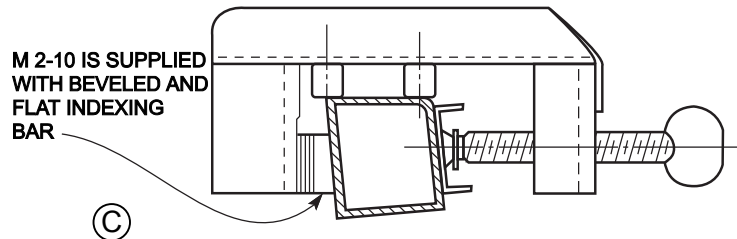
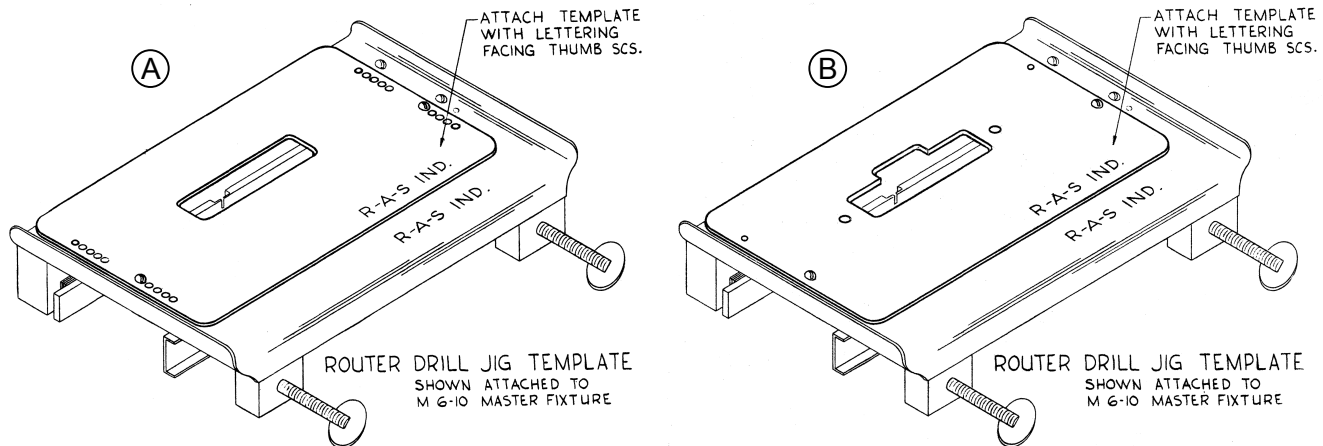


SECTION G - LOCK HARDWARE
REINFORCING PLATES - ROUTER TEMPLATES - DRILL JIGS - FIXTURES

APPLICATION	ROUTER TEMPLATE DRILL JIG OR FIXTURE	REINFORCING PLATE	PAGE
LOCK PREP	1777		G-2
LOCK PREP	1777 DJF	777 777 B	G-2A
LOCK HANDLE PREP	1777 DJH		
ADAMS RITE MAXIMUM SECURITY LOCK	1205		G-3
LOCK STRIKE	1784 A	784 A	G-4
	1784 B	784 B	G-5
LOCK STRIKE & DEAD BOLT	1784 ADSK 1784 ADSJ	784 A 784 AS	G-6
ADAMS RITE LOCK STRIKE	4501 4502		G-7
FOLGER ADAMS ELECTRIC DOOR RELEASE	310-2T 310-2DJ		G-8
ELECTRIC DOOR RELEASE	1002	002	G-9
ADAMS RITE ELECTRIC DOOR RELEASE	7500 7530		G-10
FLUSH BOLT	1781 D		G-11
FLUSH BOLT			G-11A

SEE SPECIFIC PAGE FOR FULL PART NUMBER BEFORE ORDERING

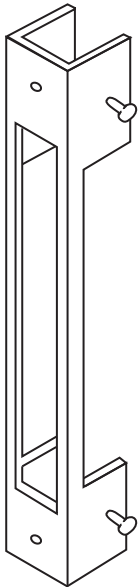
NOTE - ROUTER TEMPLATE GUIDE MUST BE USED WITH R-A-S ROUTER TEMPLATES. SEE PAGE J-5.



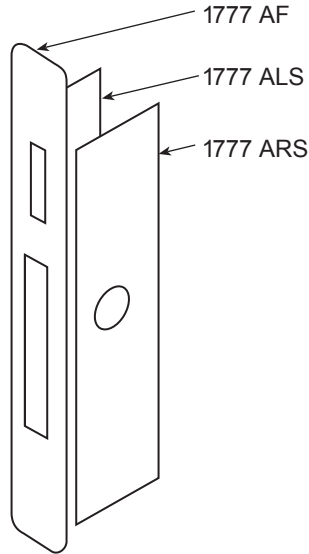
END VIEW M 2-10
NARROW & BEVEL TUBING
 NOTE - WHEN USING TWO OR MORE, USE MA 2-10. SEE PAGE B-8.

NOW! LOCK PREP IN LESS THAN 3 MIN. WHILE DOOR IS GLAZED & HUNG

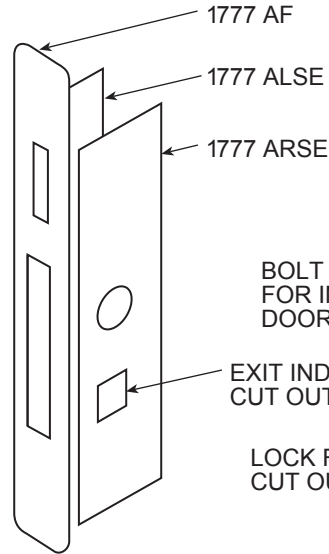
MASTER FIXTURE
 M1777



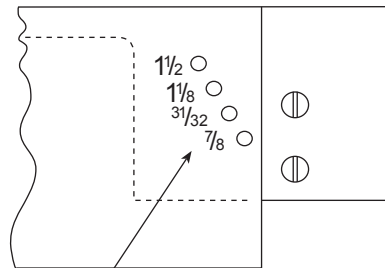
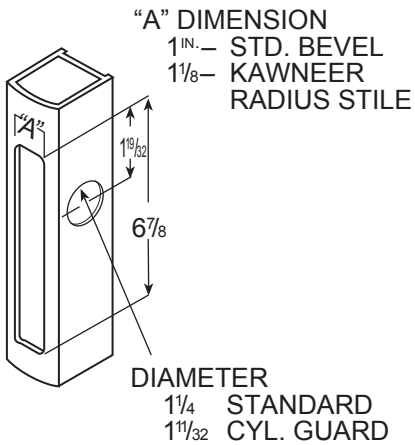
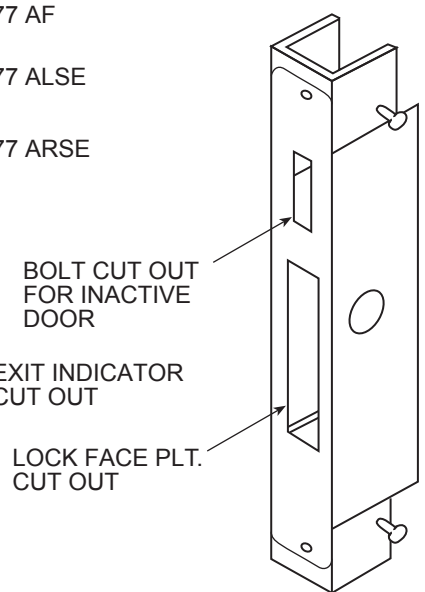
TEMPLATES



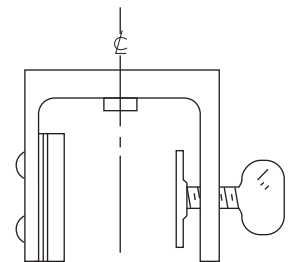
TEMPLATES



TEMPLATES
 ON M1777



CORRESPONDING HOLES
 FOR ADJUSTABLE BACKSET

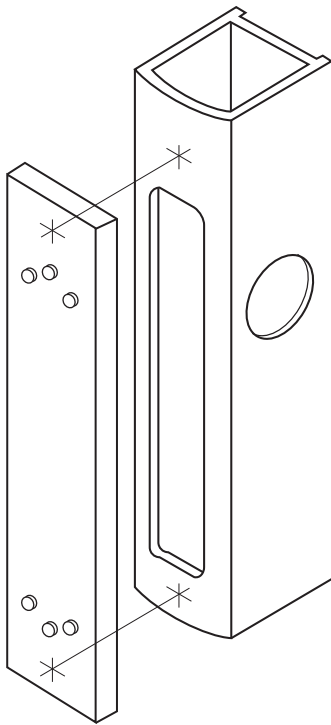


SHIMS FOR
 CENTERING TUBE

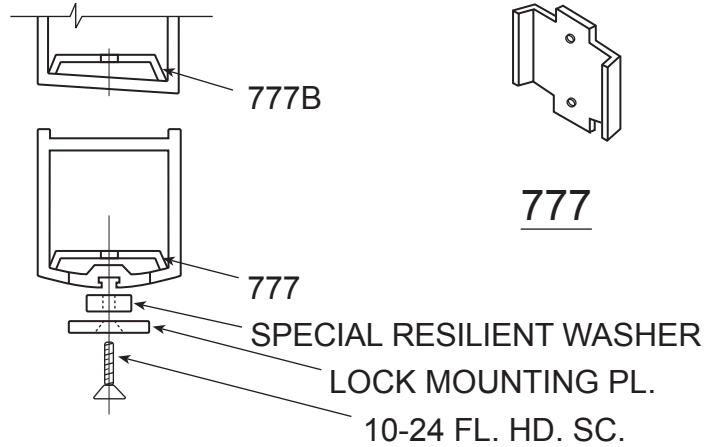
MS 1850 A
 MS 1850 - A505
 MS 1890
 4510

ORDERING INFORMATION
 FOR KAWNEER FACE PLATE ORDER 1777 AFK
 FOR TUBELITE FACE PLATE ORDER 1777 AFT
 FOR CYLINDER GUARD ORDER 1777 ALSCG & 1777 ARSCG

TEMPLATES AVAILABLE FOR VARIOUS LOCKS, LETTER-SLOTS, PANIC HARDWARE ETC.



1777 DJF



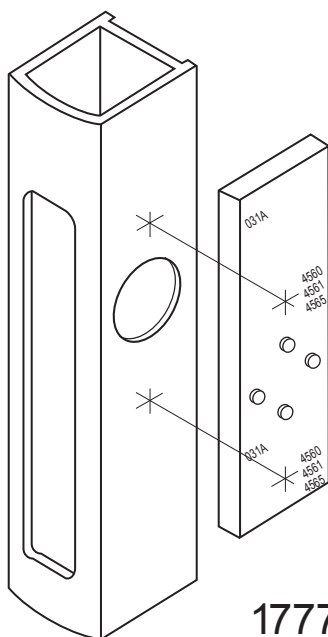
USE 1777 DJF DRILL JIG TO LOCATE & DRILL HOLES FOR R-A-S CLIP #777 OR #777B.

INSERT LOCATING PINS INTO LOCK CUT OUT (SEE PG. G-2) TO POSITION JIG ON DOOR STILE & DRILL TWO #9 HOLES AND CSK. FOR #10-24 FL. HD. SC.

AFTER INSTALLING CLIP TO DOOR STILE ATTACH LOCK TO CLIP WITH #10-24 FL. HD. SC. AND SPECIAL RESILIENT WASHER #1777 W WHICH ALLOWS FOR PROPER INSTALLATION OF FACE PLATE.

USE CLIP #777 FOR FLAT OR RADIUS DOORS
 USE CLIP #777B FOR BEVEL DOORS

NOTE – 1777 DJF CAN ALSO BE USED ON KAWNEER 1¹/₈ WIDE FACE PLATE BY MOVING LOCATING PINS TO OUTER HOLES WHICH ARE PROVIDED.



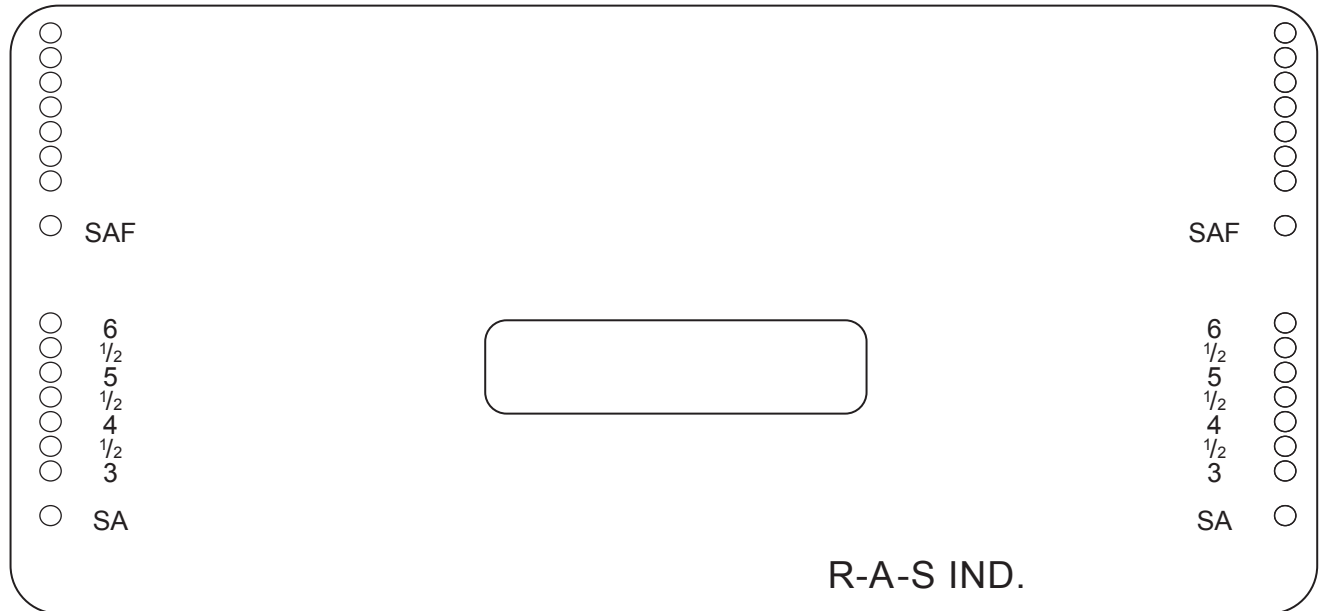
1777 DJH

USE 1777 DJH DRILL JIG TO LOCATE AND DRILL HOLES FOR ADAMS RITE LATCH HANDLES.

INSERT LOCATING PINS INTO CYLINDER CUT OUT (SEE PG. G-2) TO POSITION JIG ON DOOR STILE.

ALIGN JIG WITH DOOR STILE AND DRILL TWO 5/32^{IN} (#21) HOLES. NOTE – JIG HAS TWO SETS OF HOLES FOR TWO DIFFERENT APPLICATIONS.

USE AS SHOWN FOR ADAMS RITE 4560, 4561 & 4565 LATCH HANDLES. ROTATE JIG 180° TO USE FOR ADAMS RITE 4160 REPLACEMENT HANDLE.



HALF SCALE PLAN VIEW

1205A ACTUAL CUT-OUT IN FRAME $2\frac{1}{32} \times 3\frac{3}{4}$
STANDARD BOLT

1205AS ACTUAL CUT-OUT IN FRAME $2\frac{1}{32} \times 2$ IN
SHORT THROW

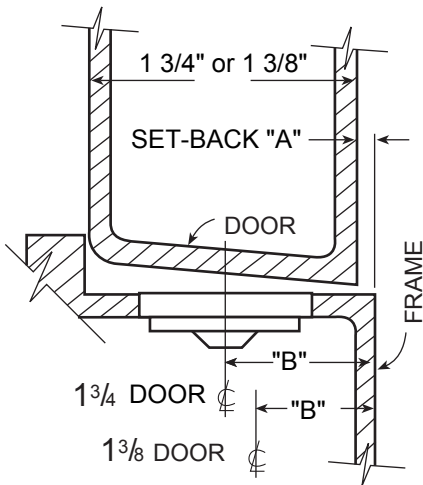
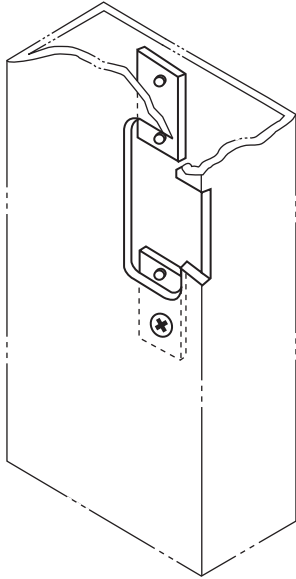
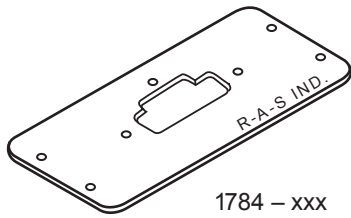
THERE ARE 9 SETS OF HOLES AT EACH END OF THE TEMPLATE FOR ATTACHING TEMPLATE TO THE MASTER FIXTURE.

EACH SET OF HOLES ALLOWS THE SAME TEMPLATE TO BE USED FOR 9 DIFFERENT APPLICATIONS.

WHEN ATTACHED TO THE HOLES MARKED "SA" THE CUT-OUT WILL BE LOCATED ON ANY SIZE TUBE FOR A DOOR $1\frac{3}{4}$ " THICK WITH $\frac{1}{8}$ " SET-BACK. "SAF" DENOTES DOOR MOUNTED FLUSH WITH FACE OF FRAME 0" SET-BACK.

NUMBERS ON LAST SET OF HOLES DENOTES THE TUBE SIZE. WHEN ATTACHED AT THESE HOLES THE CUT-OUT WILL BE IN THE CENTER OF THAT PARTICULAR SIZE TUBE.

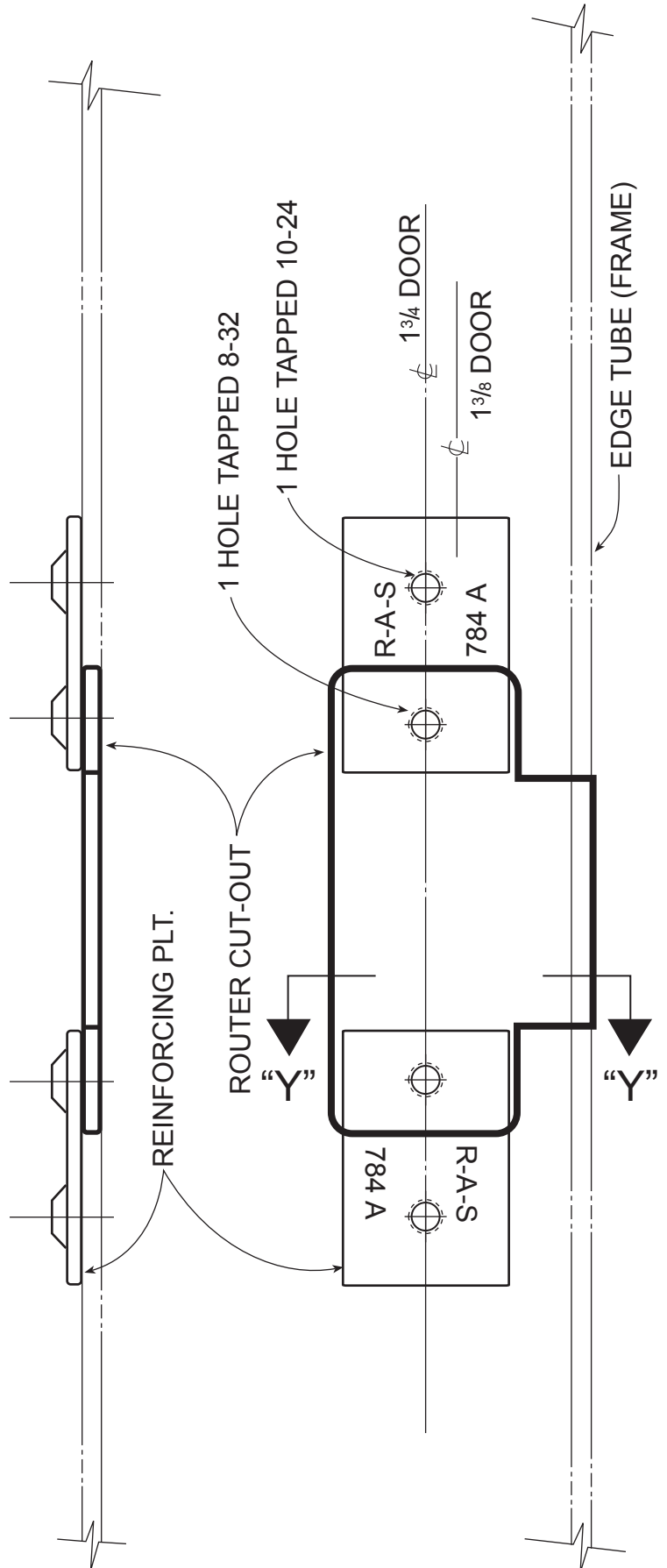
OTHER TEMPLATES ARE AVAILABLE.

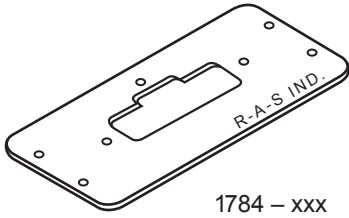


SECTION Y-Y

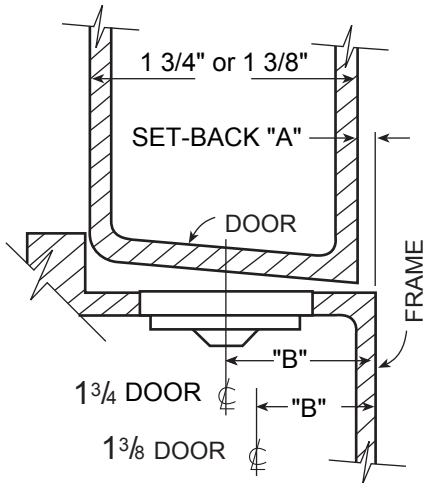
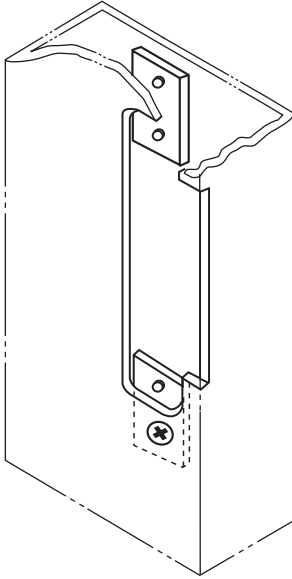
ROUTER DRILL JIG TEMPLATE	DOOR THICKNESS	SET-BACK "A"	"B"
1784AJ	1 3/8	1/8	13/16
1784AK	1 3/4	1/8	1
1784AJF	1 3/8	FLUSH	11/16
1784AKF	1 3/4	FLUSH	7/8

OTHER SET-BACKS AVAILABLE





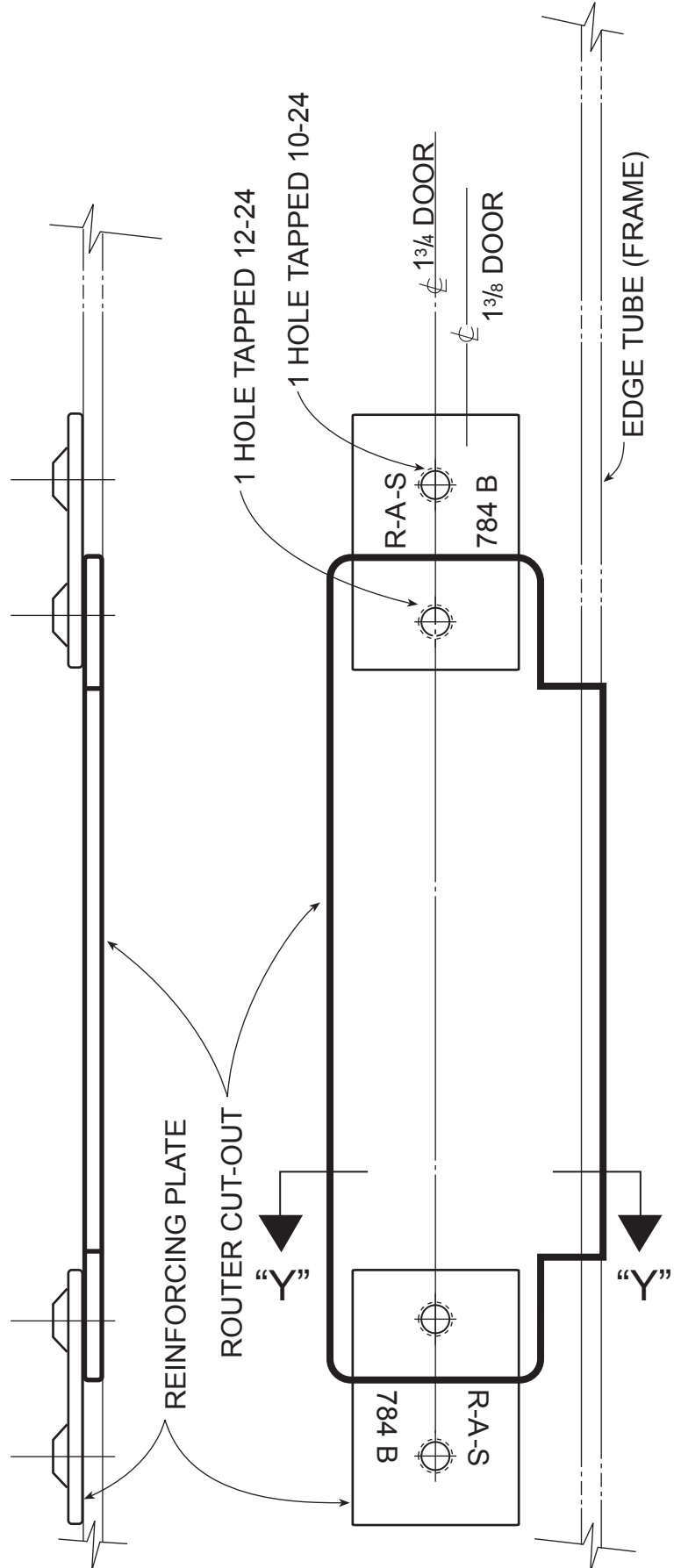
1784 - xxx



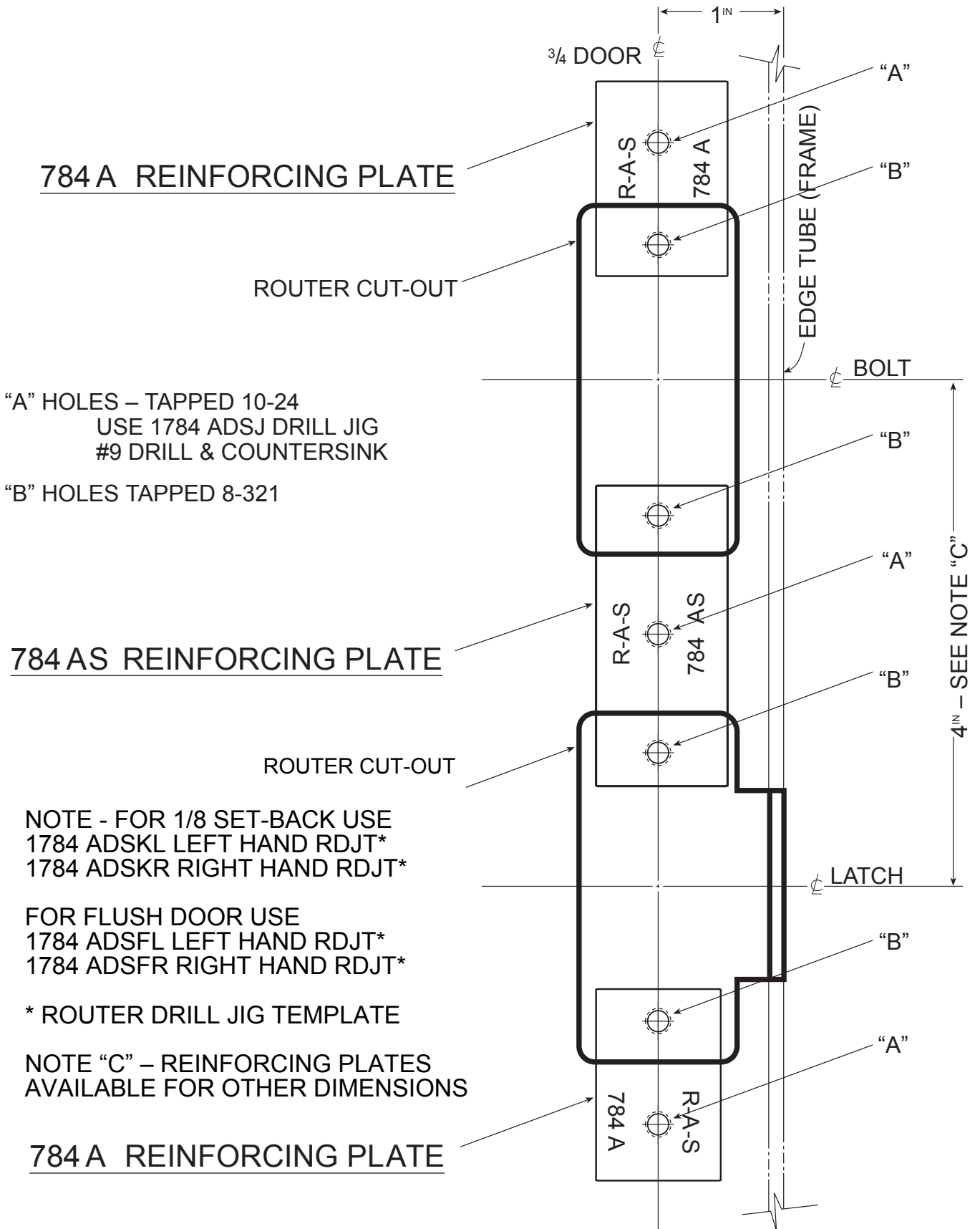
SECTION Y-Y

ROUTER DRILL JIG TEMPLATE	DOOR THICKNESS	SET-BACK "A"	"B"
1784BJ	1 ³ / ₈	1 ¹ / ₈	13/16
1784BK	1 ³ / ₄	1 ¹ / ₈	1
1784BJF	1 ³ / ₈	FLUSH	11/16
1784BKF	1 ³ / ₄	FLUSH	7/8

OTHER SET-BACKS AVAILABLE

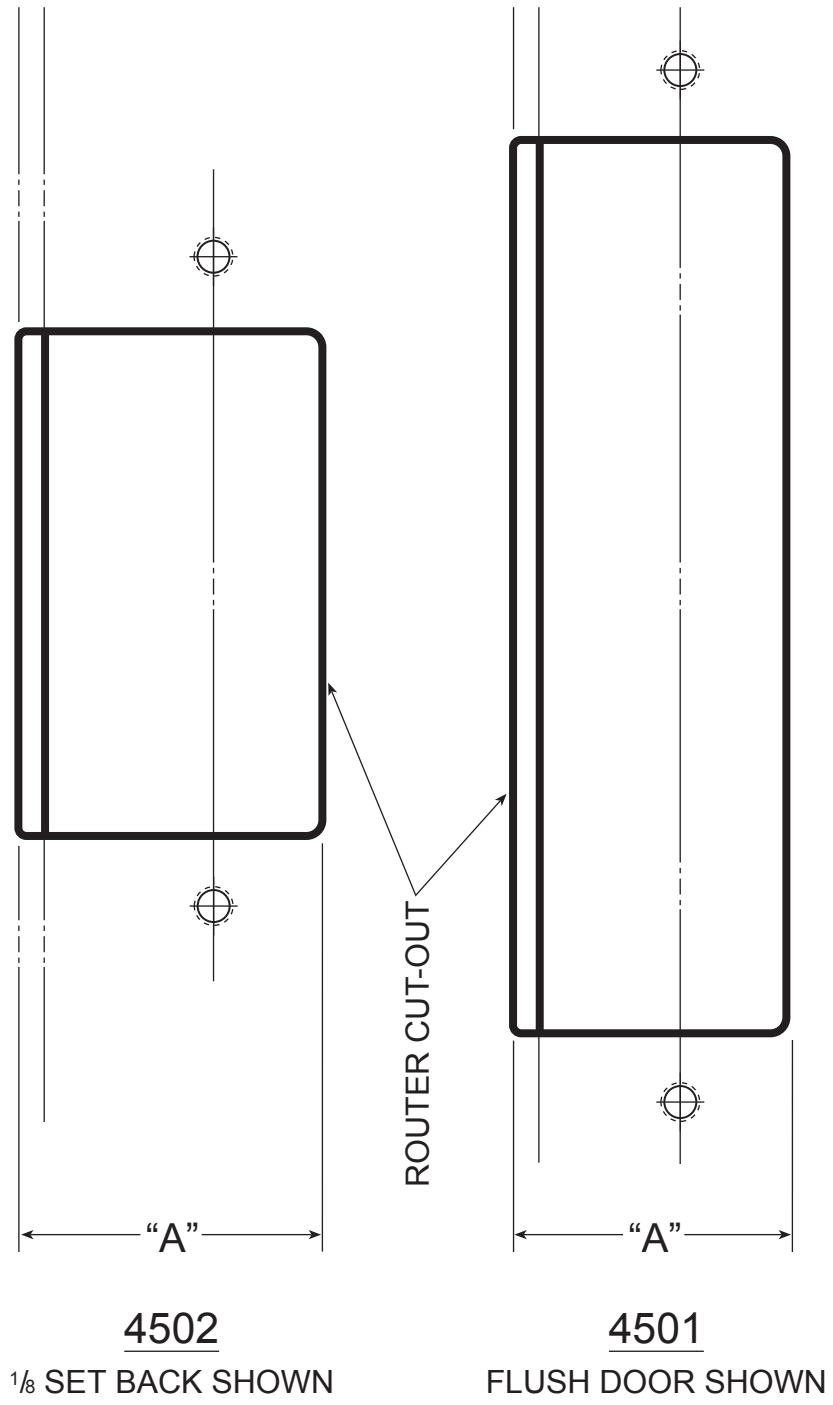
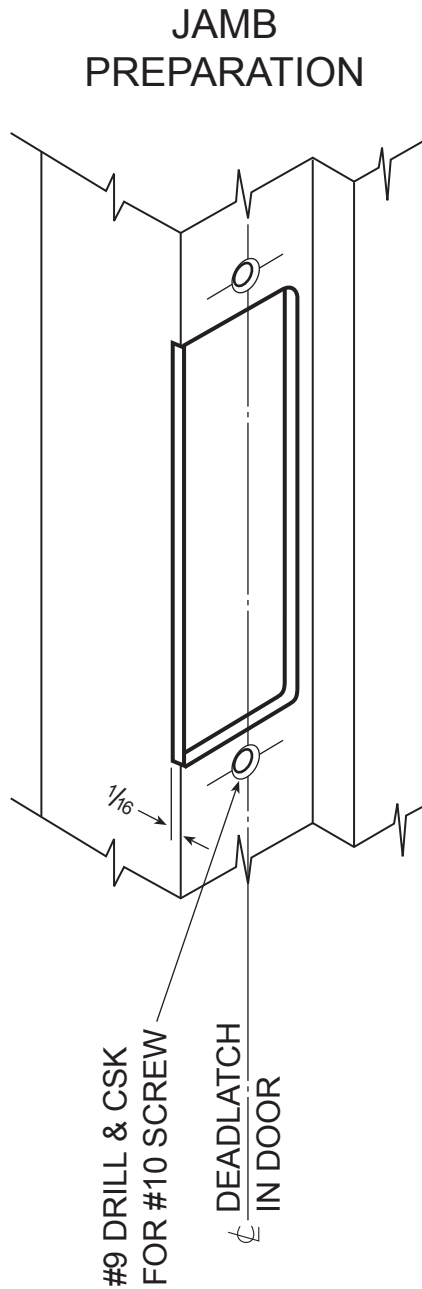


**784 A & 784 AS
 REINFORCING PLATE
 LOCK STRIKE & DEADBOLT**



ROUTER DRILL JIG TEMPLATE

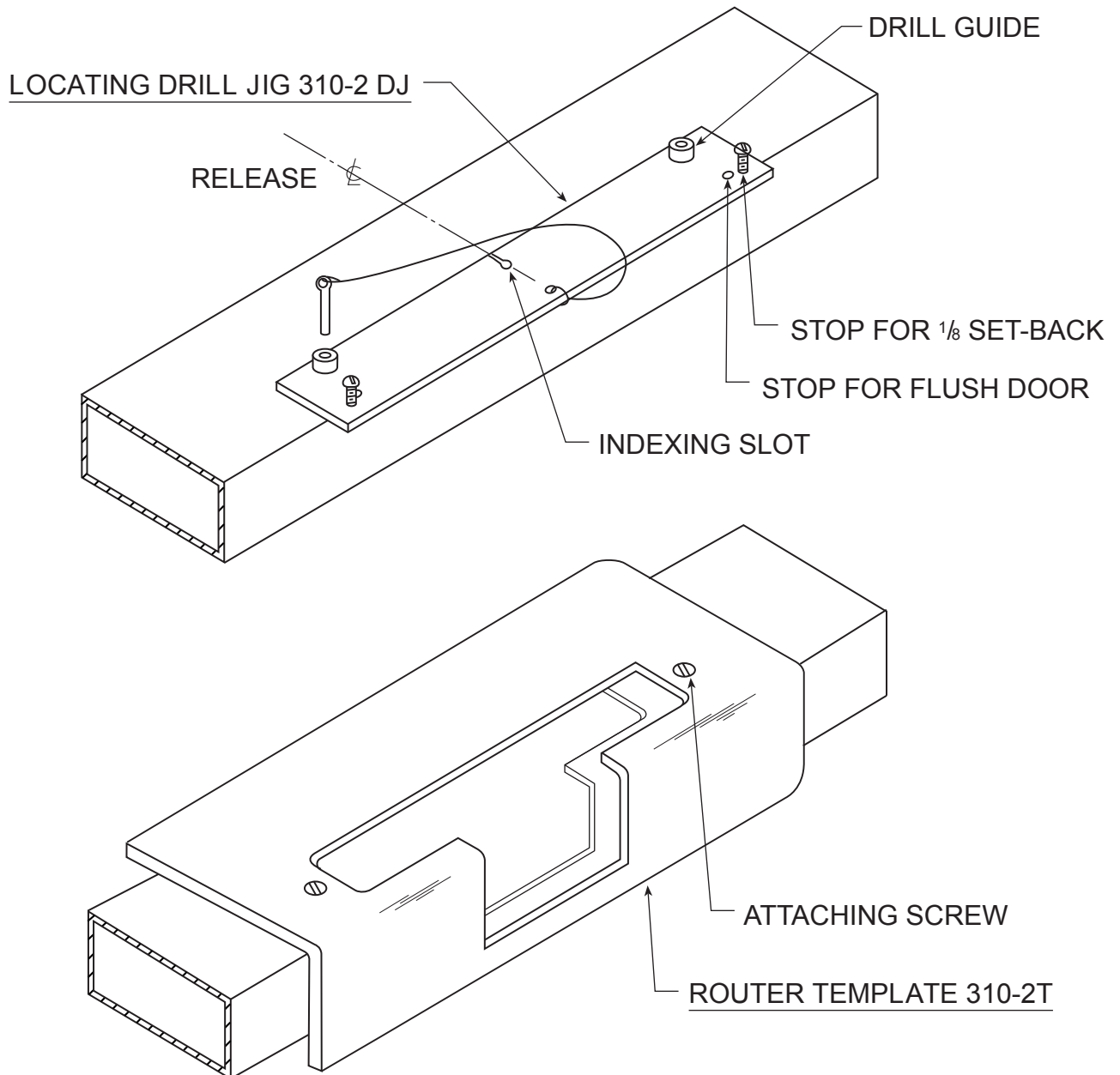
ADAMS RITE LOCK STRIKE



“A” DIMENSION IS DETERMINED BY DOOR SET BACK USE FOLLOWING
ROUTER DRILL JIG TEMPLATE

1 3/4 THK. DOOR – FLUSH OR INACTIVE – 4501F OR 4502F

1 3/4 THK. DOOR – 1/8 SET BACK – 4501 OR 4502

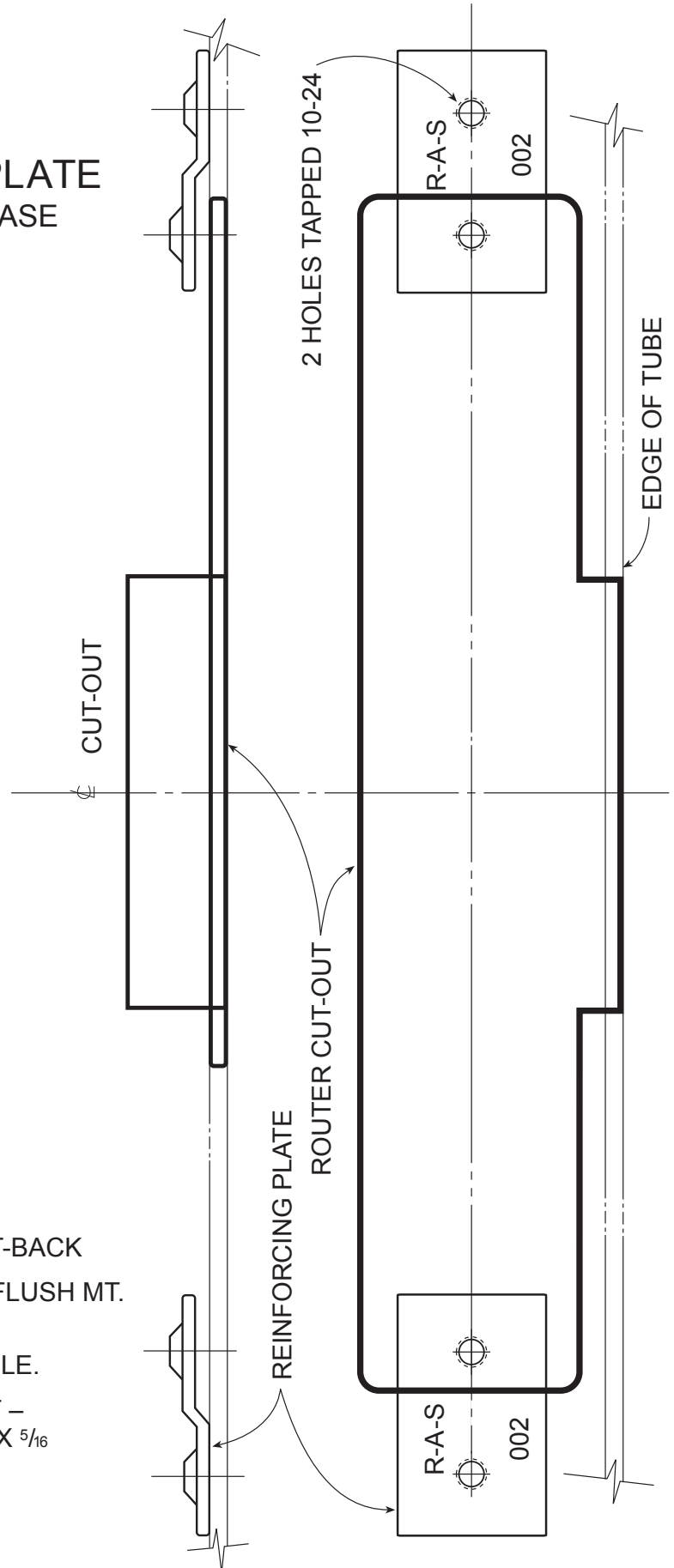
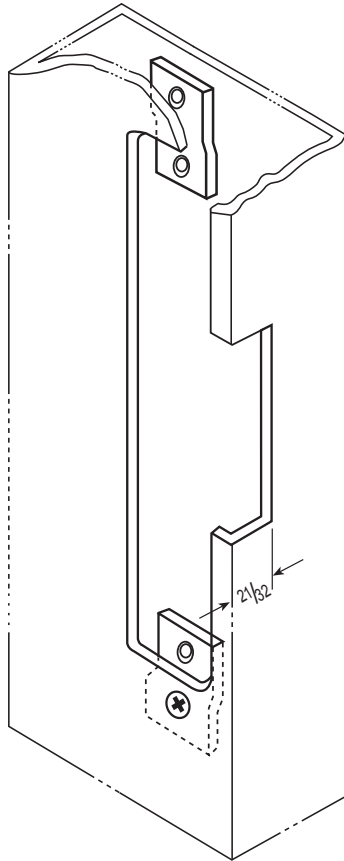


INSTRUCTIONS

MARK CENTER OF ELECTRIC RELEASE ON TUBE & APPLY LOCATING DRILL JIG 310-2 DJ.
DRILL ONE HOLE AND INSTALL PIN. DRILL SECOND HOLE.
ATTACH ROUTER TEMPLATE 310-2T WITH TWO ATTACHING SCREWS.
ROUT OUT FACE AND EDGE OF TUBE IN ONE OPERATION.
REMOVE ROUTER TEMPLATE AND COUNTERSINK TWO ATTACHING HOLES FOR 10-24 SCS.
INSTALL REINFORCING PLATES 784B AND ATTACH ELECTRIC RELEASE.
NOTE – OTHER JIGS AND TEMPLATES AVAILABLE.

002 REINFORCING PLATE
 ELECTRIC DOOR RELEASE

002 REINFORCING PLATE
 ELECTRIC DOOR RELEASE
 (2-REQUIRED)



USE R-A-S ROUTER DRILL
 JIG TEMPLATE –

1002 FOR 1³/₄ DOOR & 1⁸ SET-BACK

1002F FOR 1³/₄ DOOR WITH FLUSH MT.
 OR INACTIVE

OTHER SET-BACKS AVAILABLE.

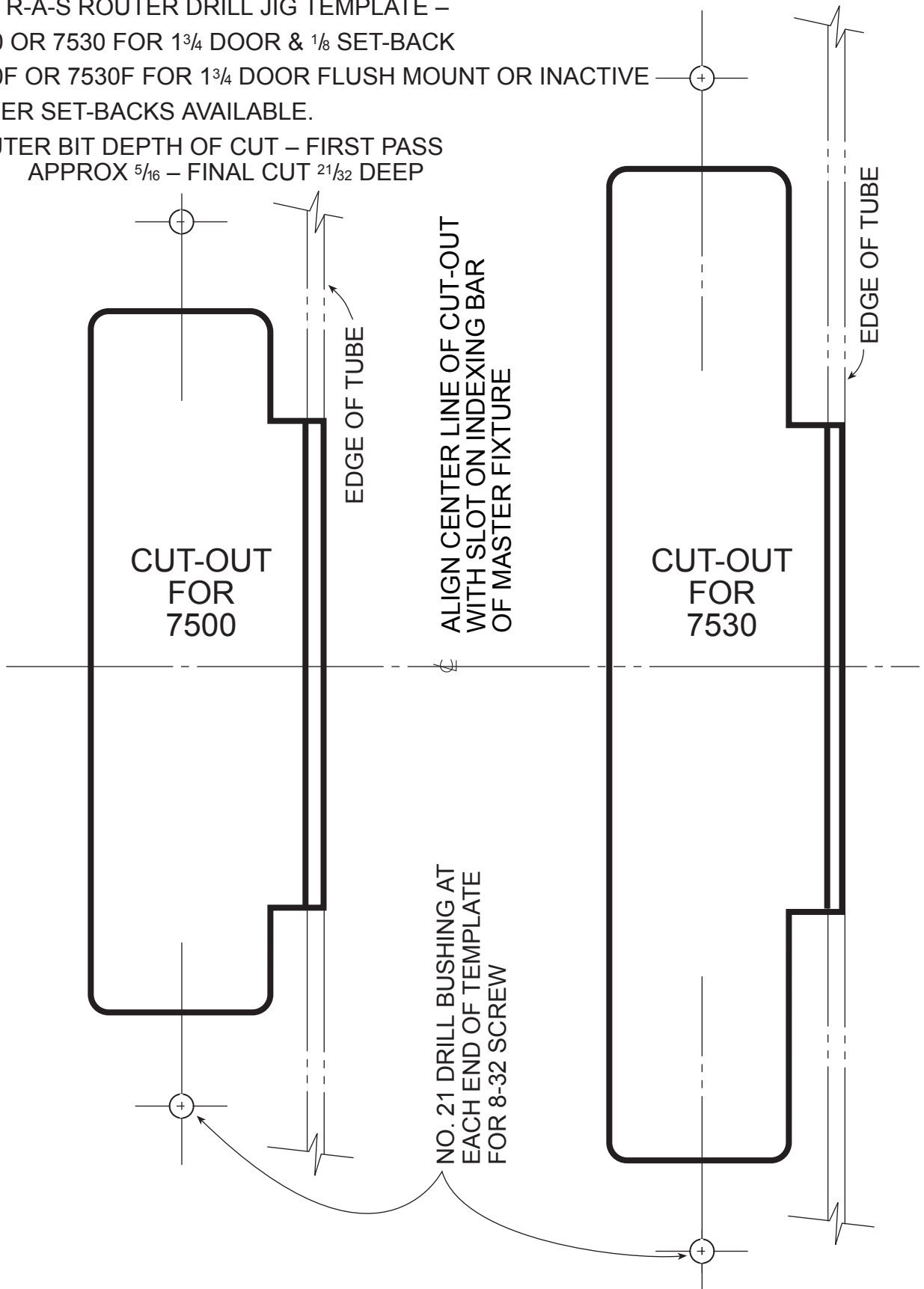
ROUTER BIT DEPTH OF CUT –
 FIRST PASS APPROX 5¹⁶
 FINAL CUT 2¹/₃₂ DEEP

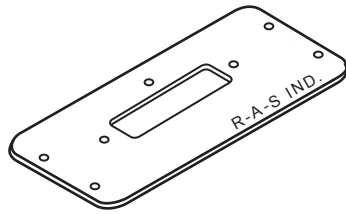
ROUTER DRILL JIG TEMPLATES

ADAMS RITE ELECTRIC DOOR RELEASE

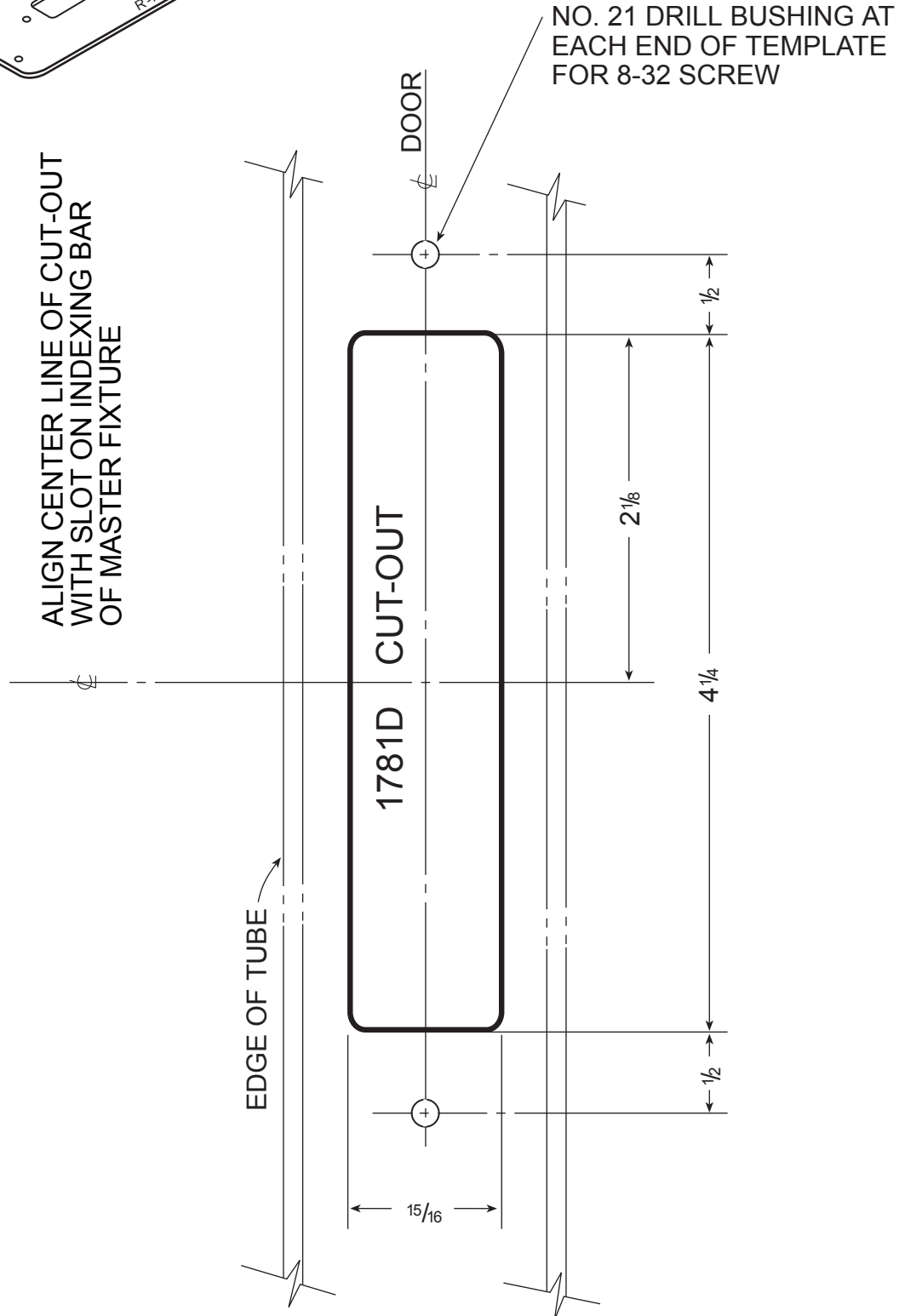
USE R-A-S ROUTER DRILL JIG TEMPLATE –
7500 OR 7530 FOR 1³/₄ DOOR & 1¹/₈ SET-BACK
7500F OR 7530F FOR 1³/₄ DOOR FLUSH MOUNT OR INACTIVE
OTHER SET-BACKS AVAILABLE.

ROUTER BIT DEPTH OF CUT – FIRST PASS
APPROX 5¹/₁₆ – FINAL CUT 2¹/₃₂ DEEP





NOTE – USE M2-10 MASTER FIXTURE



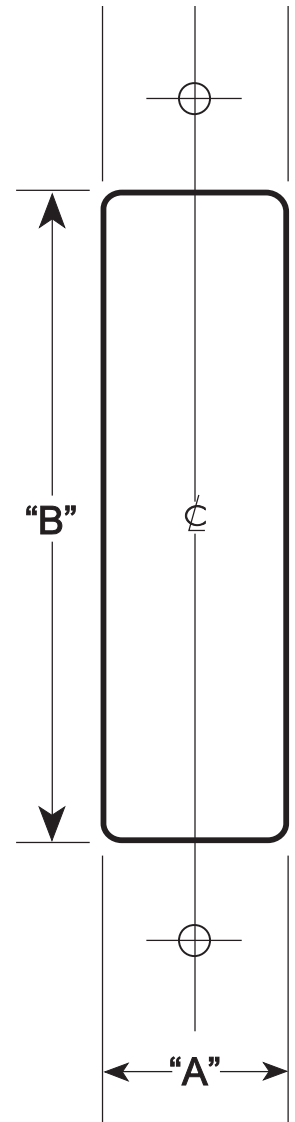
NOTE – TEMPLATES AVAILABLE FOR OTHER FLUSH BOLT CUT-OUTS, SEE PAGE G-11A.

ROUTER DRILL JIG TEMPLATES

FLUSH BOLT

Reinforcing Plates available where required.

Inventory #	Mfg Description	"A"	"B"
1781 B1	Government 86 Lock	1.250	8.000
1781 B2	Government 161 Lock	1.125	2.250
1781 B3	Government 160 Lock	1.000	2.250
1781 B4	Baldwin 8560	1.000	5.750
1781 B5	Dead Lock Strike	1.000	3.625
1781 B6	Corbin-Russwin	1.000	4.187
1781 D	Standard Flush Bolt	0.937	4.250
1781 D1	Rockwood, Glynn-Johnson	1.000	6.750
1781 D2	Dynalock 1300 Series	1.500	4.000
1781 D3	Dynalock 1300 Series	1.500	8.000
1781 D4	Rockwood (outside cut-out)	1.000	7.000
1781 D6	Rockwood	1.000	5.500
1781 D7	Sargent 7700, 8100 (same as 1781 B1)	1.250	8.000
1781 D8	Lock cut-out	1.000	3.500
1781 D9	Arcadia 4994 Door Pull	1.062	5.375
1781 D9DJ	Drill Jig for Door Pull		
1781 D11		1.000	6.375



ROUTER DRILL JIG TEMPLATES INCLUDE DRILL BUSHINGS FOR MOUNTING HOLES.

REINFORCING PLATES ARE ALSO AVAILABLE AS REQUIRED.