



# 8575 Lockset Jig

*Please Read Carefully!*

Parts List:		
Part	Description	Quantity
8575	1-1/8" x 2-1/4" Lockset Jig .....	1
STP001	#8 x 3/4" Screws .....	2
WB001	3/16" Washers .....	2
BUSH002	1/4" Spacers .....	2
5503	1/2" Thumb Screws .....	2

**ASSEMBLY**

Identify and verify that you have all the parts listed. Read the instructions at least once before beginning.

Cut a wood fence approximately 3/4" thick, 1-1/4" wide and approximately 10" long to mount the Lockset Jig to the wood fence using the 3/16" Washers (**WB001**) and 3/4" Screws (**STP001**). *See fig. 1.*

Place the 1/4" Spacers (**BUSH002**) on the 1/2" Thumb Screws (**5503**) and screw them in to two of the four holes of the Lockset Jig shown. By selecting the holes for the thickness door you have (1-3/8" or 1-3/4") the jig will automatically be centered on the door. If you have a different door thickness, remove the spacers and adjust the wood fence to center the jig on the door. *See fig. 2.*

**USING THE JIG**

Mark the lockset location on the door. The Lockset Jig is 1/8" wider (1/16" on each side) than the actual lockset opening it cuts. Position the Lockset Jig so its edges are 1/16" from the lockset location marks, or make the lockset marks 1/8" further apart to correspond to the actual opening in the Lockset Jig. Clamp the Lockset Jig to the door using the wood fence and two clamps. *See fig. 1.*

Install our 8500 Hinge Bit (1/2" diameter with a 5/8" bearing), or a 1/2" bit (**13416**) and 5/8" bushing (**5030K**), in your router. If using the **8500 Hinge Bit**, make sure the bearing rides firmly on the edge of the jig before attempting any cuts. Since the cutting depth for locks is shallow (usually 1/8" or less), any router will work. Set the cutting depth of the bit, taking into account the thickness of the jig. Plunge or tilt the router bit into the approximate center of the jig, moving in a small clockwise circle as you do so to cut a relief opening.

With the router base riding firmly on the jig, move towards an edge of the jig opening. When you get to an edge, move clockwise, following the edge of the jig with the bearing or bushing until the outline has been cut. Make clean up passes to remove any remaining material.

**ACCESSORIES**

Self-centering drill bits (**PN 6505 - 5/64"**, **6507 - 7/64"**, **6509 - 9/64"**) are available to insure perfectly centered pilot holes.

A Corner Chisel (**PN 8508**) is available to square the radiused corners left by the 1/2" router bit.

