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**INSTRUCTIONS FOR  
INSTALLING  
INTERNATIONAL FB-1202  
FLUSH BOLTS ON ALUMINUM DOORS  
WITH THE HIT-45FB1 TEMPLATE**

**WHEN USING POWER TOOLS  
ALWAYS WEAR  
EYE AND EAR PROTECTION!!**



These are the most important tools that you will use in this installation.

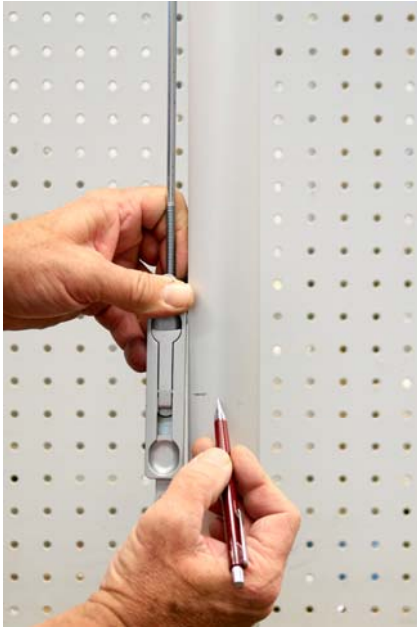
## **Always use eye and ear protection!!**



Your router needs to be equipped with a 3/8" outside diameter template guide mounted in its base. Failure to use a template guide will cause the opening being routed to be too large and will damage your HIT-45 template.

***See our catalog or web site for a list of available router template guides.***

Install a 1/4" diameter aluminum cutting router bit ( our part # HIT-45RB4 ) into the router collet and secure tightly. Adjust the router bit so it will route about through the door channel.



Determine the location of the flush bolt being installed. Make sure you mark the center of the opening and have the bolt in the retracted position so you have enough throw when it is installed.



With the HIT-45FB1 template attached to your HIT-45 clamp, center the template over the center line from the above step.



Drill a 3/8" or larger starting hole for the router bit in the center of the template hole to be routed. In the picture we are using a step drill bit.



We recommend the area to be routed be lubricated with a cutting lube. We use a product called Tapmatic Edge Cream made by the LPS Company. You can find this product at industrial hardware stores or machine shop supplies. This is also a handy product to use for other drilling or tapping chores.



Place the router bit in the starting hole and with firm control of the router follow the HIT-45 template and feed the router slowly in a **CLOCKWISE DIRECTION. DO NOT BACK UP IN THE CUT IF YOU THINK YOU MISSED AN AREA.** Make sure the base of the router is held flat on the routing template. When completed with the cut, turn the router off and wait for the bit to come to a complete stop before removing it from the template. Failure to do so may cause damage to the door, your HIT-45 template or injury to yourself. After making the first pass, brush away the chips and make a second clean up pass.



With the Clamp still attached to the door, drill the mounting holes for the flush bolt with a 5/32" drill bit.



Clean the area of left over cutting lube and chips. Use a machinist scraper or an aluminum cutting file and deburr all of the openings.



Counter sink the two mounting holes to fit the screws supplied with the flush bolt.

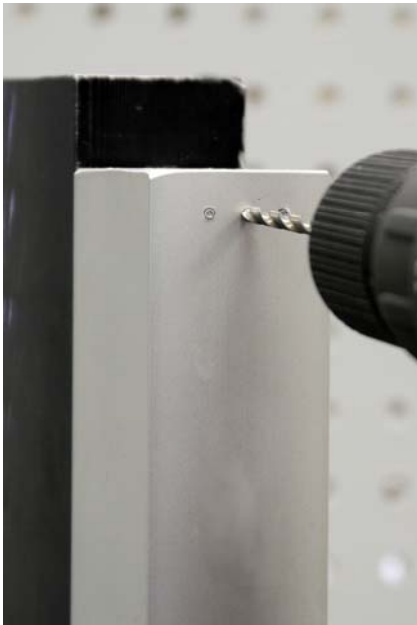


Completed flush bolt prep.



Mark the location for the guide bracket. You can use the factory supplied plastic guide, or upgrade to our steel bracket (LMB-06 square hole or LMB-07 hex Hole).

After marking the holes center punch for a starting point.



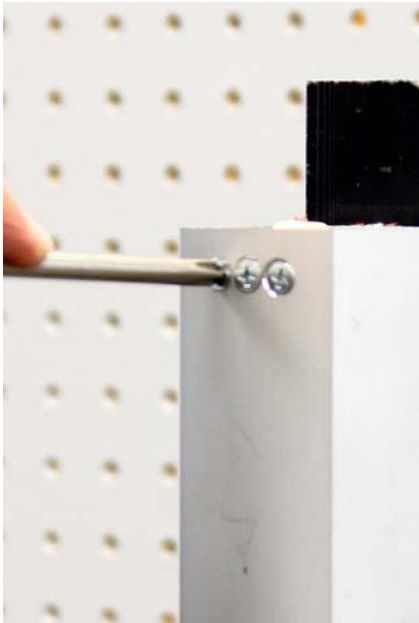
Drill all three marks with a 5/32" drill bit and counter sink for the flat head screws when complete.



Rod guide holes drilled and counter sunk.



Install flush bolt into opening and secure with the factory supplied screws. Don't forget to adjust rod height prior to installing.



Install rod guide and fasten in place.



There you have it, a completed installation.

That's all there is to it!