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DIRECTIONS FOR MCE-100 MORTISE CYLINDER EXTENSION DRILL GUIDE





The MCE-100 drill guide is made up of a clamp to securely hold a mortise cylinder when drilling and tapping the required mounting holes. There is also the drill guide plate (gray) and tapping plate (red), Also included is a #29 drill bit with a stop and a 8-32 tap with a handle.

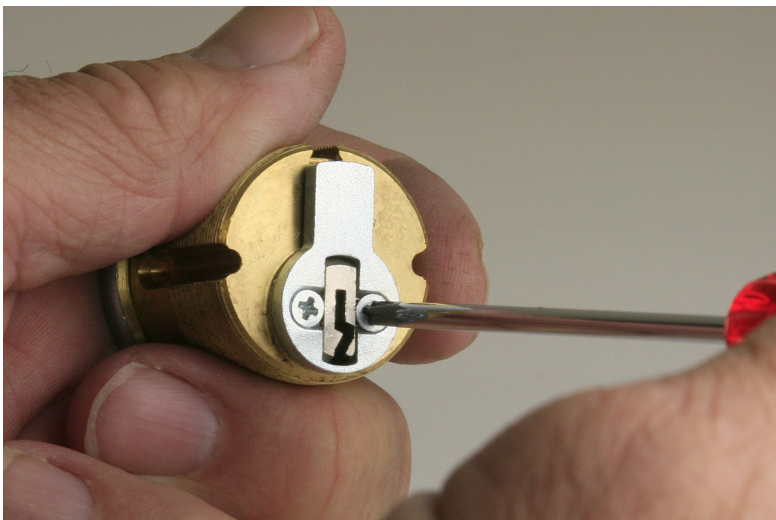




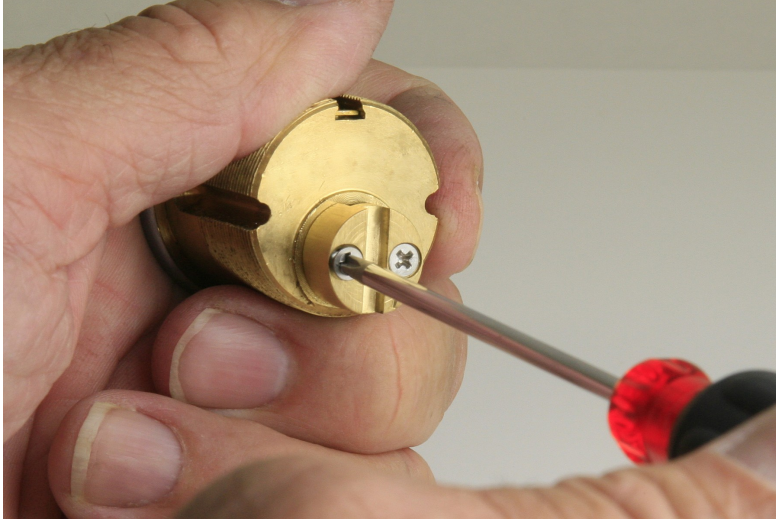
Mortise cylinder to be extended.



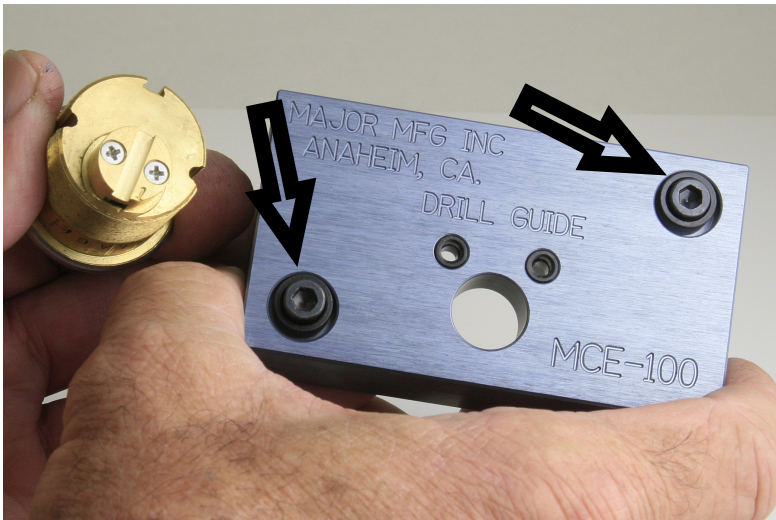
Extension kit and proper drive cam needed for the modification.



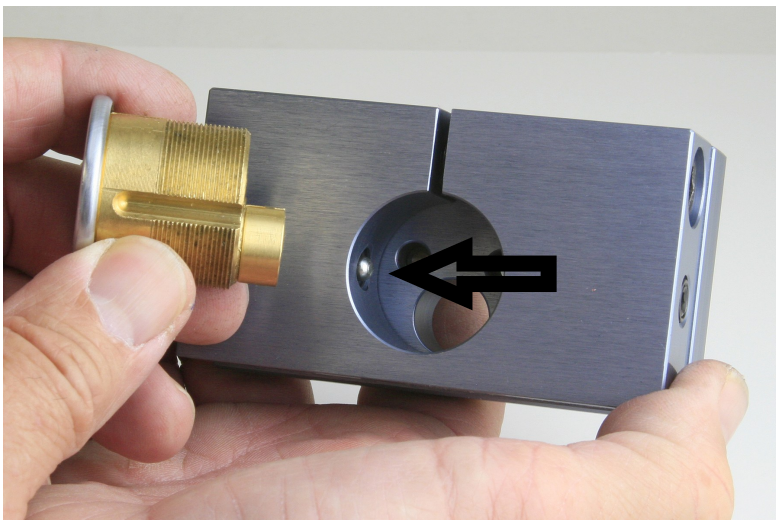
Remove the factory supplied cam from the mortise cylinder.



Install the proper drive cam in place of the lock cam. Use the screws provided, the original screws will be too short.



Install the drill guide plate (gray plate) on the cylinder clamp. Do not tighten the mounting screws (see arrows) at this time. The drive cam must be installed at this time, it is used to center the mounting holes.



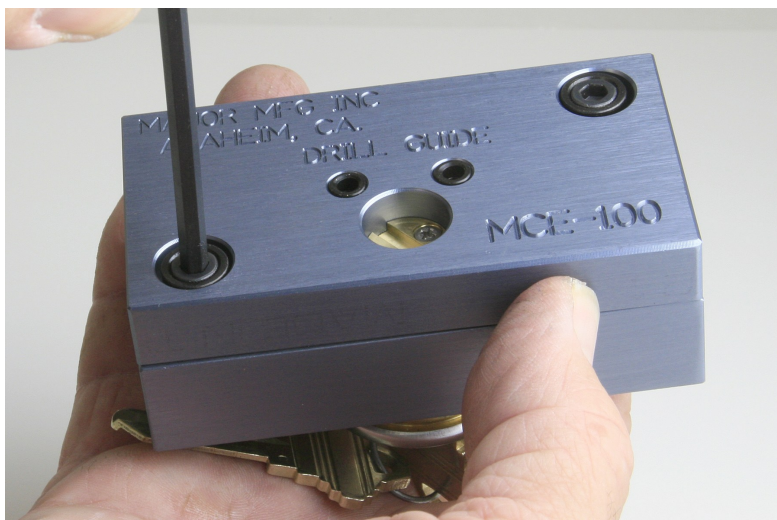
There are two ball bearing detents inside the cylinder clamp. One on each side of the clamp, the detents will center the mortise in the clamp.



Make sure the mortise cylinder bottoms on the drill guide, then pull back about 1/32".



Rotate the key and make sure the cylinder rotates freely in the guide. This will insure that everything will be aligned when drilling.



Once the cylinder rotates freely in the drill guide, tighten the two cap screws. After the guide has been tightened, check to make sure the cylinder still turns free, if not re-adjust. This step is important to insure a good working modification,



Tighten the mortise cylinder in the clamp unit, check one last time that the cylinder rotates freely.



Drill both holes with a #29 drill bit. Adjust the stop on the drill bit so the hole is drilled to a depth of about 3/4". (adjust the stop so it is 1-1/4" above the tip of the drill bit.) This will allow plenty of room to tap to the depth needed without bottoming out.



Remove the drill guide from the cylinder clamp. Do not remove the mortise cylinder at this time.



Install the tap guide on the clamp. The cap screws should be loose to allow the guide to float. This will allow the guide to self-align.



Be sure to lube the tap with a cutting oil prior to tapping holes.



With the use of the red tap guide, tap the first hole. Back the tap out frequently to clear the chips from the hole.



Loosen the cap screw on the cylinder vise and remove the mortise cylinder.



These are the finished mounting holes for the extension unit.



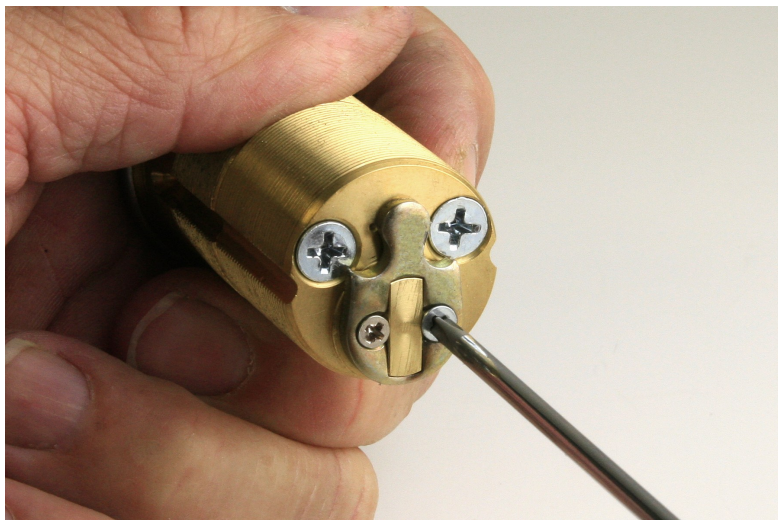
Set the plug extender on the drive cam.



The plug extension will just set on the drive cam, it is captured by the housing when installed. Put the housing over the extension and make sure the plug extension mates with the drive cam. See arrow.



Use the supplied 8-32 screws to attach the extension unit to the mortise cylinder. A drop or two of removable Loctite could be used on the threads.



The mortise extension unit is designed to accept a Kaba Ilco brand cam. The use of other brands of cylinder cams may not fit correctly and cause a problem with proper operation.

That's all there is to it!



The following drive cams are available.
Proper cam screws are included with
drive cam

MCE-D1
AMERICAN
KABA ILCO
LSDA
MARKS
SCHLAGE
U.S. LOCK
USCAN

MCE-D2
SCHLAGE PRIMUS
DISCONTINUED

MCE-D3
MEDECO

MCE-D4
ARROW LOCK
SARGENT

MCE-D5-1
CORBIN/RUSSWIN

CORBIN/RUSSWIN
I/C HOUSING

MCE-D6
GMS-IC CORE

MCE-D7
GMS-STD.

MCE-D7A
ABLOY PROTEC

MCE-D8
YALE
YALE RC HOUSING

MCE-D9
ASSA
ASSA RC HOUSING

MCE-D10
SCHLAGE LG FORMAT
I/C HOUSING

**Standard mortise
cylinder with extension.**



**Small format GMS
housing with extension.**

