

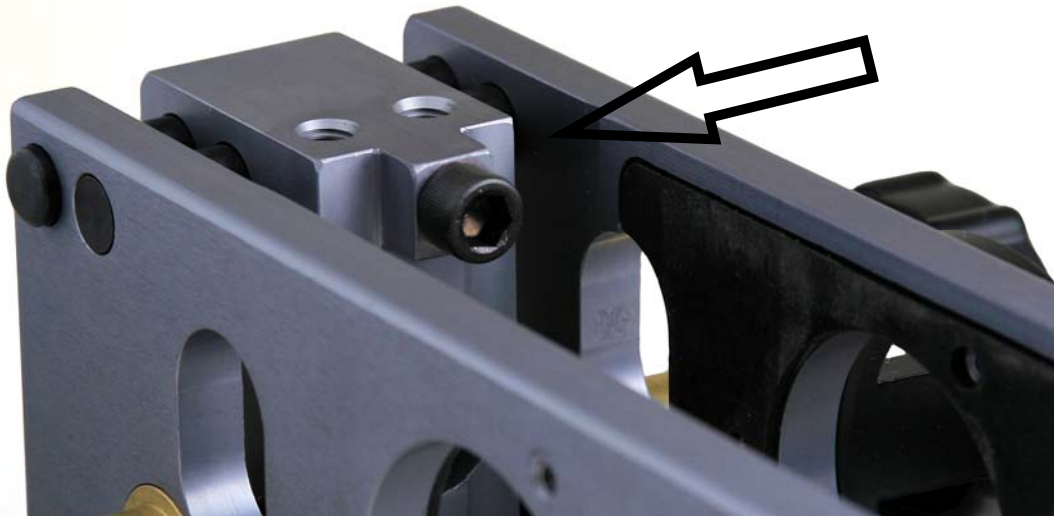


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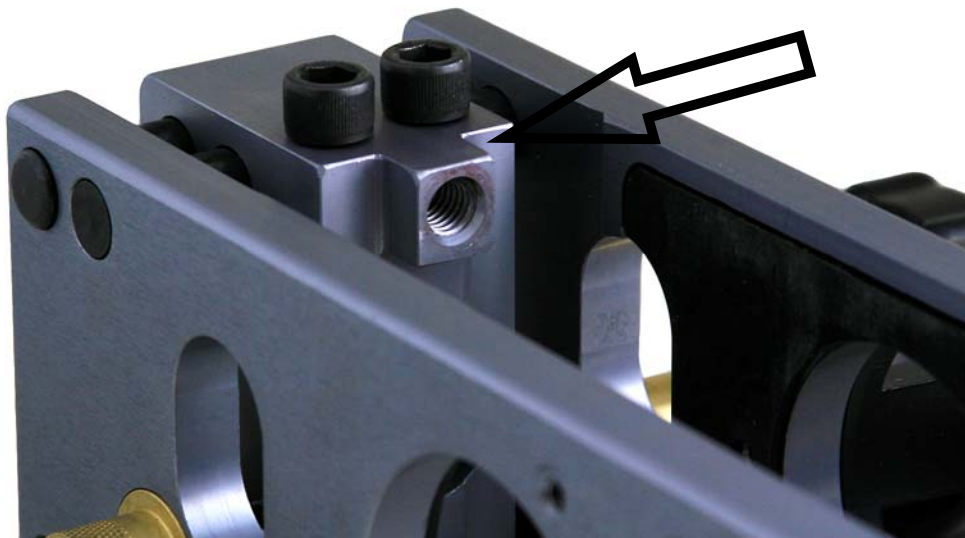
**INSTRUCTIONS  
FOR  
HIT-55  
DRILL GUIDE**

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

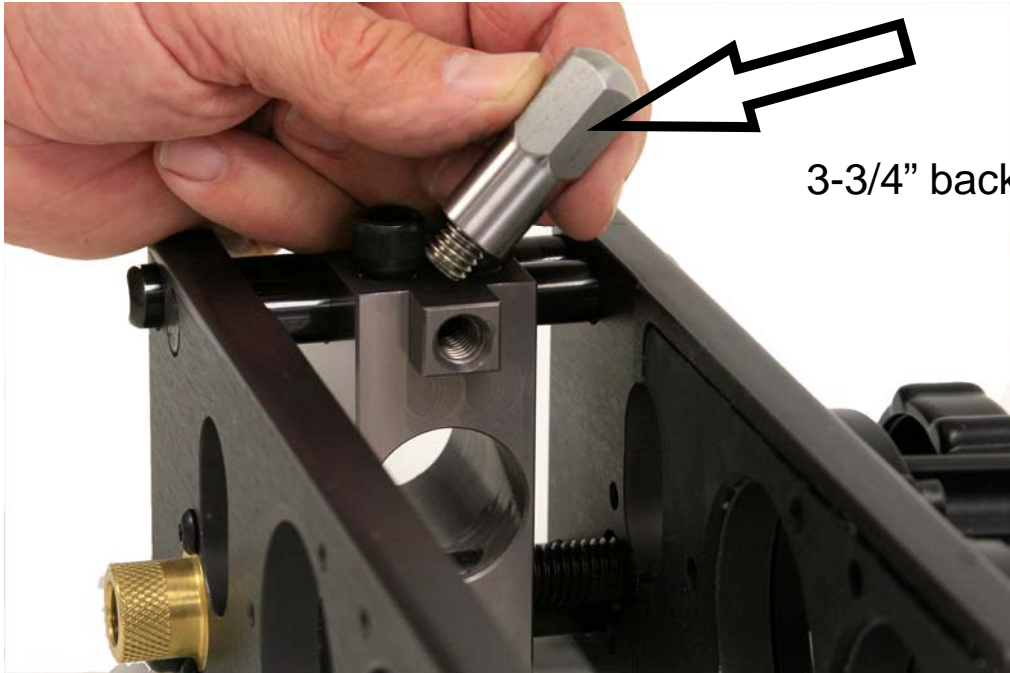
# To adjust for 2-3/8", 2-3/4" & 5" backsets



To adjust for 2-3/8" and 5" backset locks, install the backset studs as shown in picture. Make sure studs are fully threaded in.



To adjust for 2-3/4" backset locks, store the backset studs as shown in picture.



3-3/4" backset stud

Backset stud shown for use with 3-3/4" backset locks.

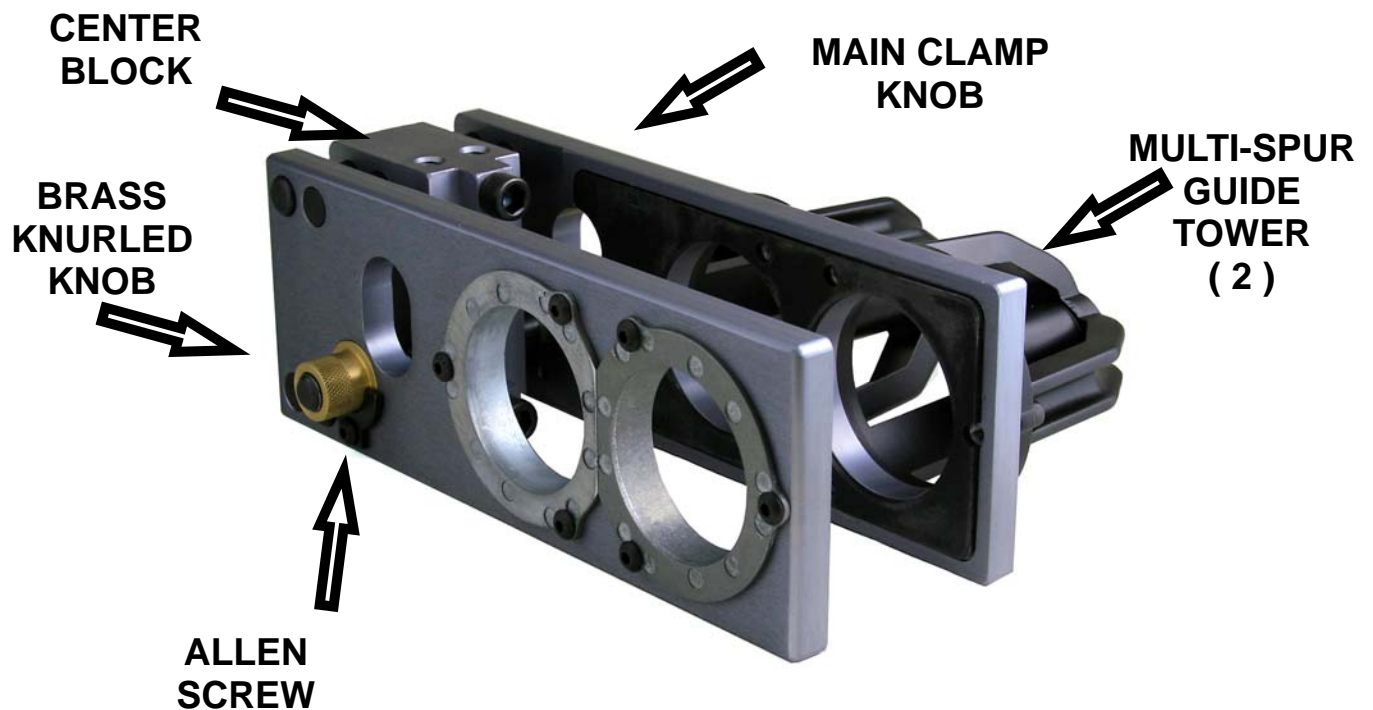


HIT-55 drill guide with both 3-3/4" backset studs installed.

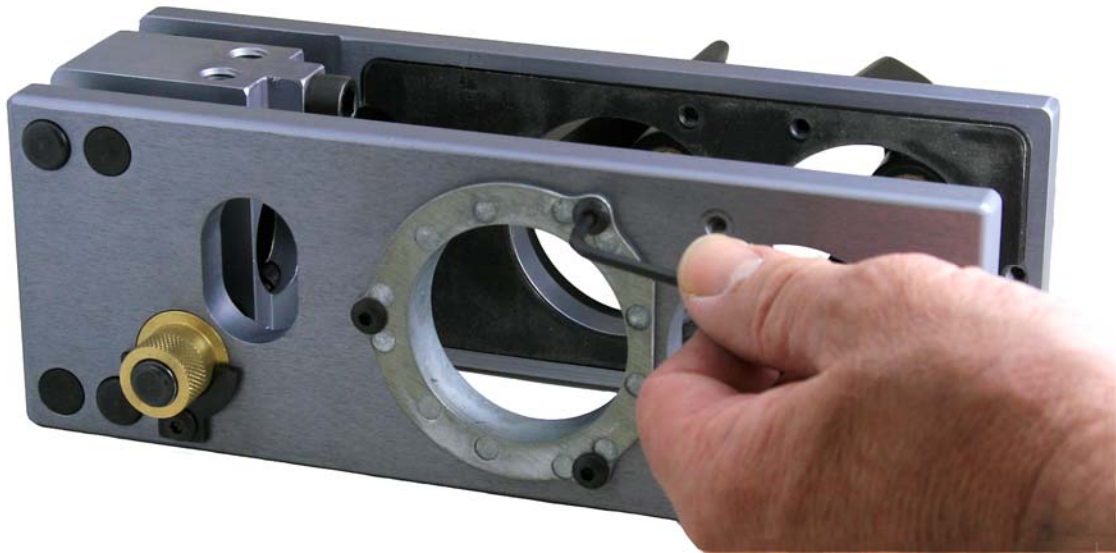


There are three drill guides supplied with the HIT-55 for use when drilling the edge bore, they are held in with an allen screw. Choose from a 7/8", 1" or the brass guide for use with our spade type or multi-spur bit.

## TO ADJUST CENTERING



The HIT-55 has a unique feature in the fact the centering can be adjusted. This will allow you to drill a centered latch hole in the edge of the door or one that is off centered. This is handy in case a door has an additional skin or plywood added on for re-enforcement. Just loosen the allen screw holding the brass KNURLED knob and adjust the centering until you have the hole where you want it. Tighten the allen screw and drill the latch hole. It is a good idea to re-center your drill guide after use so a door won't be mis-drilled next time. To re-center, loosen the screw holding the brass KNURLED knob. Now tighten the large main clamp knob until it bottoms the center block, tighten the brass KNURLED knob until it also bottoms on the center block and tighten the allen screw. The HIT-55 is now centered.



Using the supplied allen wrench, install the proper size break out plate/hole saw guide. Two 1-1/2" and two 2-1/8" guides are supplied. For steel door use, remove the multi-spur guide on opposite side and replace with another guide as shown in picture.

**Replacement break out plates p/n HIT-55BP2 consists of 1 each 1-1/2" and 2-1/8" plate.**



These are the most popular bits used in the HIT-55.

Top to bottom:

Spade type bit  
Major part# HIT-55B12 1" dia.  
Note: This is the only bit long enough for the 5" backset.

Multi Spur bit  
HIT-44B10 7/8" diameter  
HIT-44B14 1" diameter



Brad Point Bit  
HIT-44B11 7/8" diameter  
HITR-44B15 1" diameter





To clamp to door, simply determine the height and clamp. The HIT-55 was designed to clamp without the need to adjust a cantilever knob. Rubber lined jaws will protect the door as well as give a better non-slip grip. With the 3/8" backset adapters installed you can drill both 2-3/8" and 5" backset crossbores. (2-3/8" shown)



This picture shows the HIT-55 set up for a 5" backset.



When drilling a 5" backset crossbore, you will need to use one of the longer spade type bits. See our bit HIT-55B12.

Once you have drilled the required function holes, complete the job with our marking and locating tools to make your job faster and more professional.





Here we are using our HIT-44LM3 latch marking tool to mark the area for the faceplate. There is a 1/16" shim that is used to adjust to a 1" or 1-1/8" face. With the shims on the inside, this will mark a 1-1/8" face.



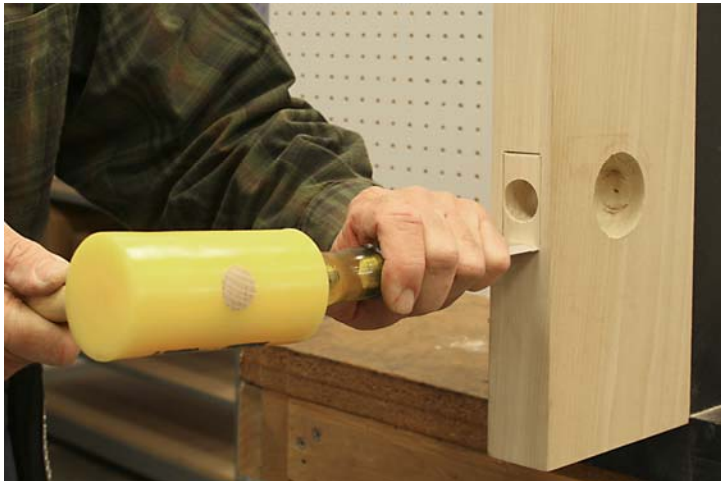
The use of a combination square will help to square the marker to the door.



Mark for the faceplate.



Use a sharp box cutter to deepen the vertical outline left by the marking tool. If you use a chisel for this step you run the risk of splitting out the side of the door.



A chisel can be used to deepen the top and bottom of the outlined area. Once everything has been outlined, chisel out the latch mortise.



Don't forget to mark the jamb for the strike plate. Shown is our HIT-44SL8 1" strike locator.

See our HIT-24 for locating a strike on a steel jamb.



Use one of our centering drills to drill for the latch screw. This will assure a centered hole and will allow you to drive in the screw with out splitting the door. Do not attempt to drive in a screw without a pilot hole.



Install the lock per the manufacturers instructions.

That's all there is to it!

Visit our web site at [www.majormfg.com](http://www.majormfg.com) to see our complete line of tools and accessories. While there, sign up for our new product releases and we will email them direct to you.