Thing-a-ma-JIG-40 *(for use with Adams Rite #4901)*
Thing-a-ma-JIG-60 *(for use with Adams Rite #4902)*

These innovative jigs are highly accurate and easy to use – designed to simplify the installation of Adams Rite dead-latch strikes commonly found on aluminum door frames.

Setup and positioning of these strike jigs is best accomplished using the Precision Fit 40/60 Jig Locator Plate, found at www.doorgadgets.com. A combination square may also be used to calculate the correct position.

Parts included in the kit

- Main guide plate
- Moveable guide edge
- 2 large spacer blocks
- 2 small spacer blocks
- 2 x 10-32 stainless steel mounting screws

Instructions

1. Mount the Precision Fit 40/60 Jig Locator plate onto the Universal or Modified Holder.
2. Using the Precision Fit 40/60 marking jig, locate the mounting holes for either the Thing-a-ma-JIG 40 or 60, and centre punch to mark. These holes will accurately match the mounting plate used to secure the strike.
3. Drill the holes with a 5/32” bit.
4. Thread with a 10/32” tap.
5. Screw the jig onto the frame using the stainless steel screws and spacer blocks provided. **Hand tighten: Do not use a screw drill.**
6. Use the appropriate-sized spacer blocks to keep the frame stop from interfering with the position of the jig. (e.g. if the jig needs to be set back so deeply that the frame stop is in the way, use the thicker spacer blocks.) Make sure the spacer blocks are positioned parallel to the top and bottom guide edges and do not protrude into the cutting area. (Photo 1)
7. The unique feature of this jig is the sliding guide. This guide controls the router bit and allows the user to safely cut as close to the frame edge as possible. Position the guide along the outside edge of the frame. (Photo 2).

DO NOT CUT THROUGH THE FRAME EDGE AT THIS TIME! This will be the last step after the main prep opening is cut out.

8. Approximately 3/4 inches down from the top guide edge and centered between the two vertical guide edges, drill a 3/8" hole. This is the hole from which to start the cut. Now the jig is ready to be used to guide the router.

   Notes:

   - The router must be equipped with a 3/8" guide and a 1/4" 2-flute single end mill. DO NOT USE A PLUNGE ROUTER as they are dangerous and not as accurate when used for this operation. *See recommended router style below.*
   - The cutting bit must be adjusted to go deeper into the door than the thickness of the aluminum.
   - Lubricate the area to be cut or the bit will overheat and melt the aluminum which will adhere to the bit. There are good quality paste-style cutting lubes available; however, as this is a vertical surface, standard cutting fluid will run off and not protect the bit. One recommendation is Gillette Foamy shaving cream – it stays in place and holds the cut shavings, preventing them from flying around. Fill the opening with foam. Clean up is easy with paper towels.

9. Insert the router bit into the starting hole. With a **firm grip** on the router, begin cutting in a CLOCKWISE direction. Keep the router base flat on the guide jig. When the cut is complete, turn off the router. **DO NOT REMOVE THE ROUTER UNTIL THE BIT STOPS TURNING** or it can damage the guide jig and the door, and can cause serious injury. *ALWAYS WEAR EYE AND EAR PROTECTION.*
10. Clean out the shavings and do a clean-up pass to smooth the edges.
11. To cut the outside edge of the frame, readjust the bit depth to the correct position to allow the strike to fit flush with the frame.
12. Loosen and carefully move the sliding vertical edge of the jig from the door frame just enough to allow the cutting bit to address this edge. Tighten the screws of the sliding edge guide. This will provide a solid edge along which to run the router. (Photo 3)
13. Cut in a CLOCKWISE direction as in #8 above.
14. Remove the jig and deburr all edges.
15. Drill out the threaded holes which held the jig and counter-sink to the correct depth.

16. Install the strike.

Recommended Router Style

Because it is imperative that the router not be removed from the jig before it has come to a complete stop, we recommend use of a router with an easily accessible, trigger-style on/off switch. If this is not available, a foot on/off switch which plugs into an extension cord may be used. **Do not use a plunge router!**

These installation jigs require proficiency in use of a high-speed router and should be used by qualified personnel only. General safety rules apply. Always wear eye and ear protection.

Replacement parts for these installation jigs may be purchased at www.doorgadgets.com. Please e-mail for pricing.

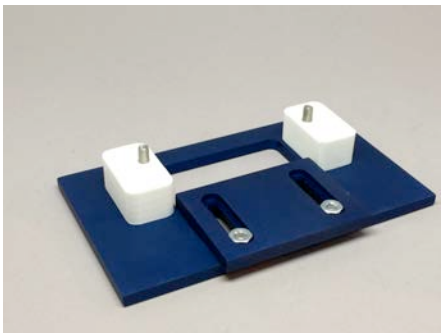

Photo 1: using spacer blocks

Photo 2

Photo 3