

Directions for MDLT-1 “Pit Bull” steel door tool. Always wear eye and ear protection when using power tools.

Drill holes in steel door for lock installation. Steel doors should be drilled with a 2-3/4” backset. The “Pit Bull” will require a 2-1/8” crossbore to allow the draw die to be inserted into the door. We are using our HIT-44 Drill Master in the picture with a hole saw to drill crossbore and latch holes.



The draw die is placed inside door with the “ears” toward the folded side of the door. The opposite side of the door has a seam that is welded.



Draw die being placed inside door. Use care with this step, don't drop die inside door. There is a 8-32 tapped hole on the back of the draw die - use to attach a wire or lanyard for peace of mind. (not supplied) Lube the threads of the draw bolt with bearing grease prior to installing the Pit Bull fixture in door. Failure to properly lube bolt may damage the Pit Bull tool.



Center the forming die over the latch hole. Pencil mark on door edge shows center of latch hole, the forming die has an alignment mark to locate the center of the die. Make sure set screws in form die are backed off inside die. They must not protrude at this time.



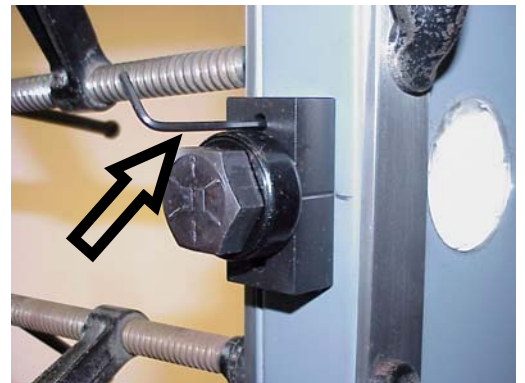
The use of the two steel bars (supplied) and C clamps (not supplied) will help prevent door distortion when forming latch pocket. Clamp one on the inside and outside edge of door as shown.



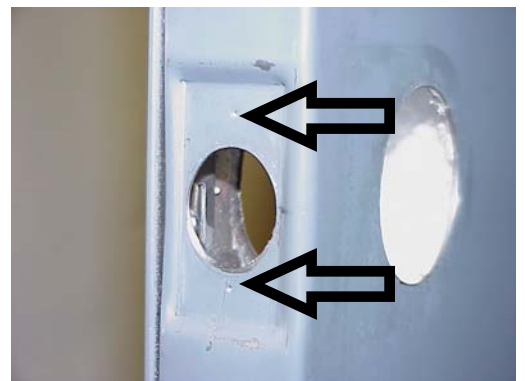
Use an 1-1/8" box end wrench or socket to tighten bolt. This works better than an adjustable wrench. Tighten until the forming die bottoms out on the draw die inside the door.



Use the supplied hex key and tighten the top and bottom set screws in the forming die. This will locate the latch mounting screws.



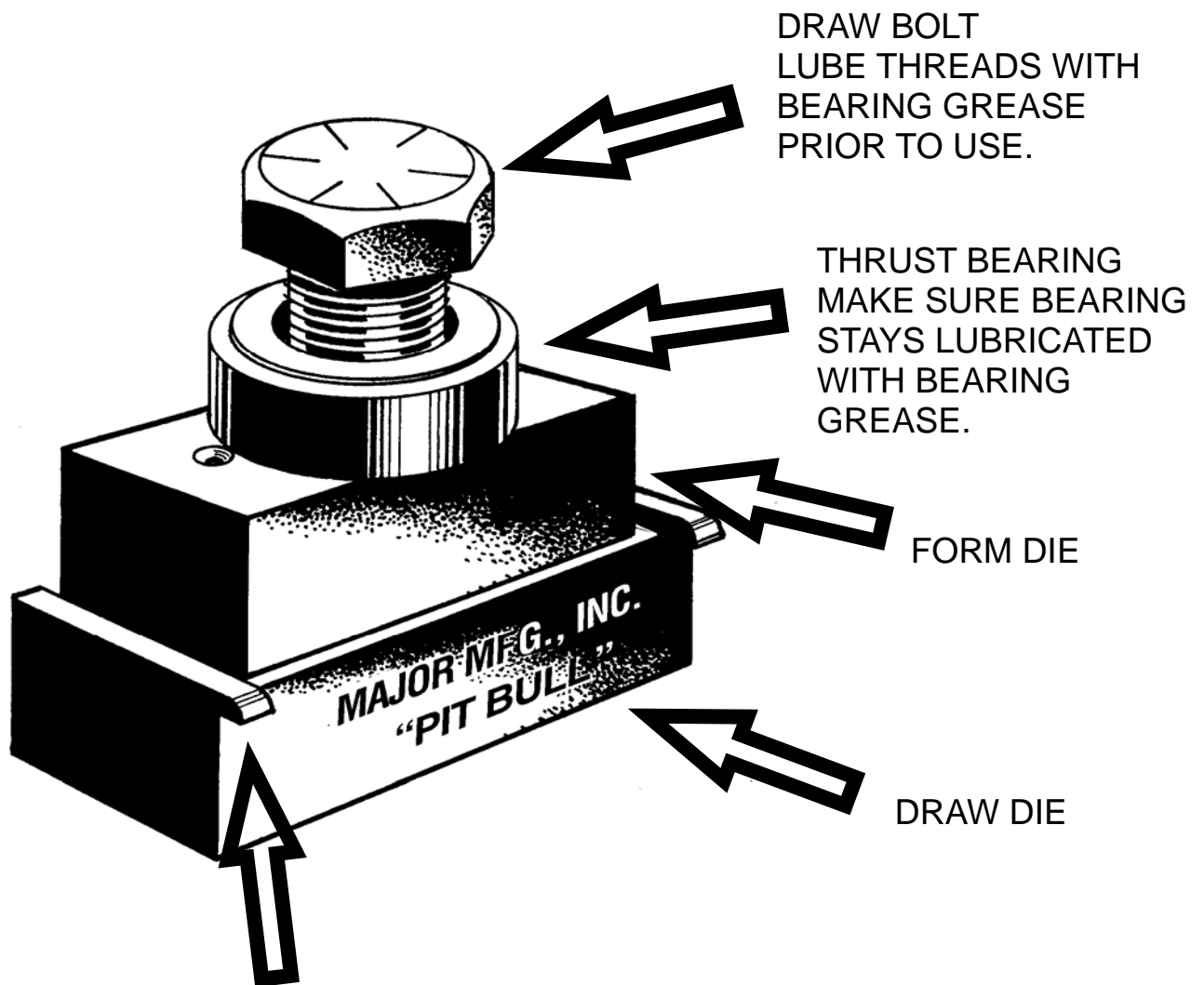
Completed latch face pocket. Drill the two marks left by the set screws with a #29 drill and tap 8-32.



Install lock and latch.



NOTE: FAILURE TO LUBE DRAW BOLT PRIOR TO USE MAY CAUSE THREADS TO BIND, SEIZE AND / OR STRIP OUT. USE A GOOD QUALITY BEARING GREASE. WD-40 OR SPRAY LUBES ARE NOT AN ADEQUATE LUBE OR REPLACEMENT FOR BEARING GREASE.



DRAW BOLT
LUBE THREADS WITH
BEARING GREASE
PRIOR TO USE.

THRUST BEARING
MAKE SURE BEARING
STAYS LUBRICATED
WITH BEARING
GREASE.

FORM DIE

DRAW DIE

PIT BULL "EARS"
WHEN IN USE, MAKE SURE THESE
LOCATE TOWARD THE FOLDED SIDE
OF THE DOOR, NOT THE SIDE WITH
THE WELDED SEAM.