INSTALLATION INSTRUCTIONS

Effective date: August 15, 2025

Supersedes: All Previous

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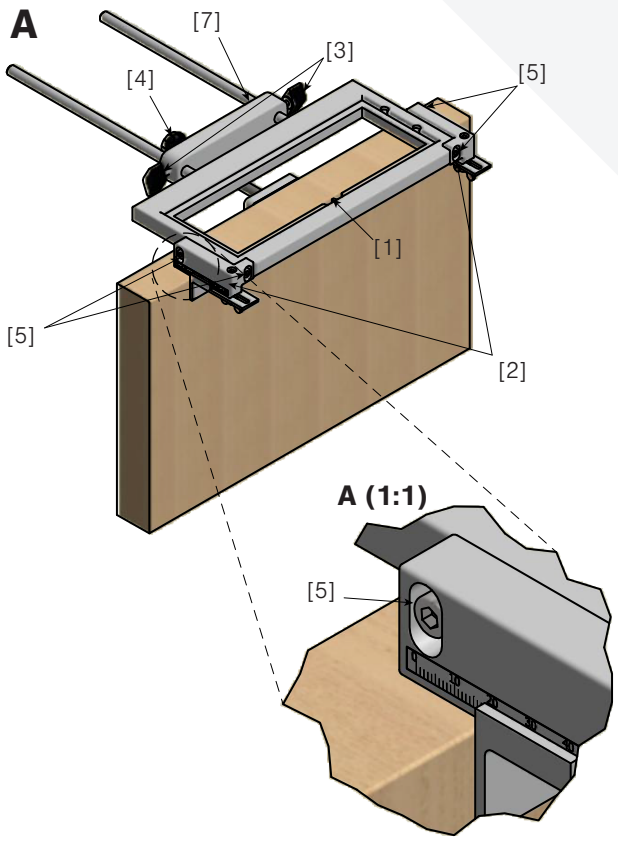
MILLING INSTRUCTION – UNIVERSAL MILLING JIG

The Universal Milling Jig allows you to prep doors for McKinney concealed hinges, including models MK1821A, MK4001A, MK80, MK80A, MK80SS, MK100, MK130+8, MK150, MK200.



ONE SET OF UMJ INCLUDES:

- 1 x Aluminium Universal Jig
- 2 x Steel Plates for Milling MK1821A Preps
- 2 x Steel Plates for Milling MK4001A Preps
- 2 x Steel Plates for Milling MK80, MK80A & MK80SS Preps
- 2 x Steel Plates for Milling MK100 Preps
- 2 x Steel Plates for Milling MK130+8 Preps
- 2 x Steel Plates for Milling MK150 Preps
- 2 x Steel Plates for Milling MK200 Preps

INSTALLATION:

1. Measure and Mark Hinge Locations

Mark the distance where each hinge will be placed.

1a. Position the Jig (View A)

Align the middle of Jig [1] with the marked midpoint of the hinge prep.

1b. Set Blocking Angles [2]

Adjust to the recommended distance for your hinge type. Reference the plates to match the hinge shape.

1c. Secure the Template

Slide plate [7] to the guide position, then lock it by tightening nuts [3].

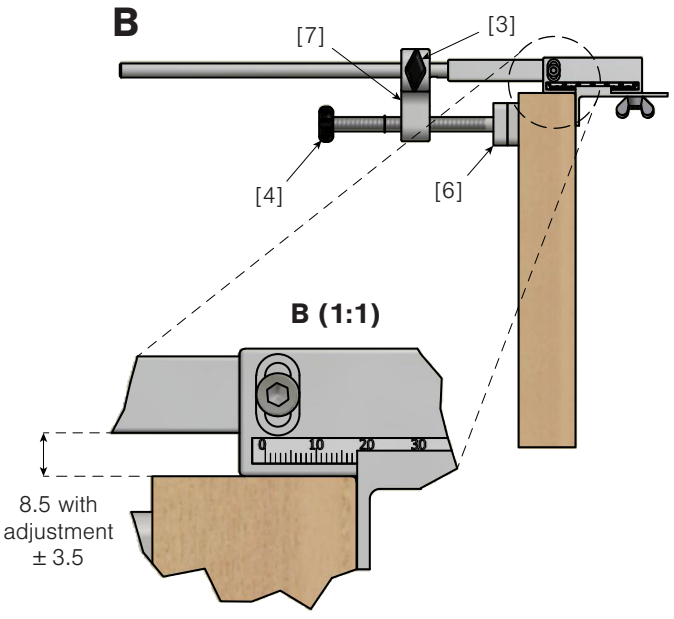
1d. Clamp the Stop [6]

Manually tighten screw [4] until the jig is firmly secured to the door or frame.

1e. Adjust Jig Height (if needed)

You can adjust the distance between the profile surface and jig support from 0–7 mm (View B).

- Loosen locking screws [5] with a 4 mm Allen key.
- Adjust height as needed.
- Retighten screws [5].



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2. Position the Plate [8]

Use the plate with the larger prep hole (View C) for milling the first, shallower prep.

2b. Select the Correct Tools

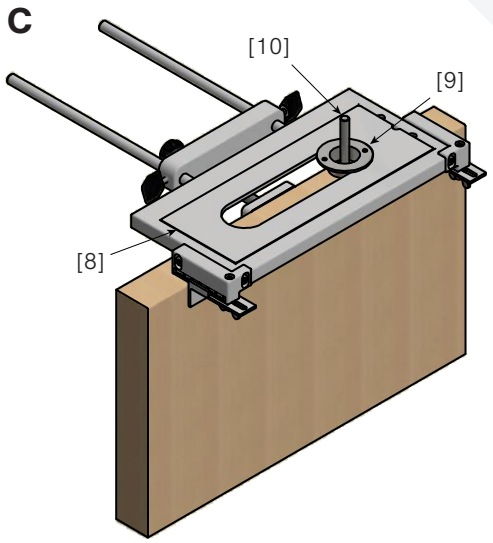
Attach a Ø30 copying ring [9] and a Ø16 self-drilling slotting cutter [10] with a minimum working length of 30 mm.

2c. Mill the Prep

Guide the sleeve through the milled hole in the plate to achieve the correct shape.

2d. Complete One Full Turn

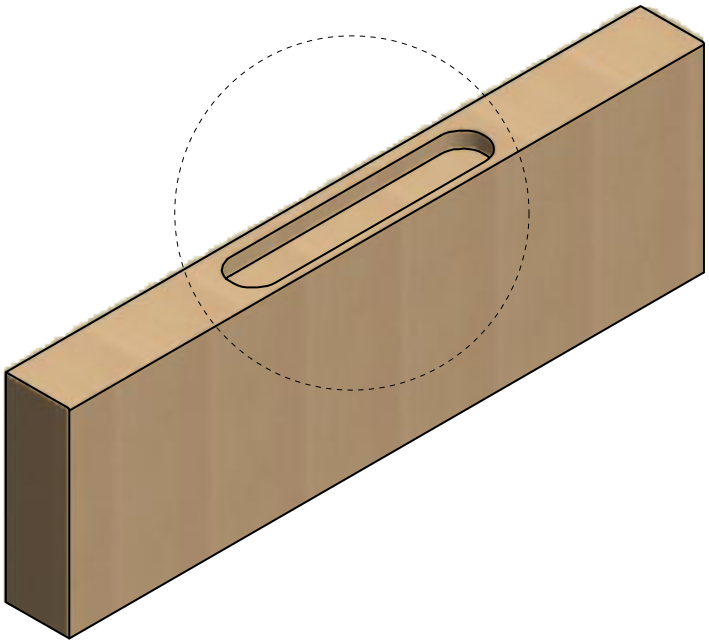
Make a single pass along the prep hole in the plate to finish it.



WARNING: Set the depth for the first prep on the milling machine after the cutter makes contact with the surface of the door or frame.

NOTE: The copying ring and self-drilling slotting cutter are **not** included with the jig.

After this stage of milling prep should look like this:



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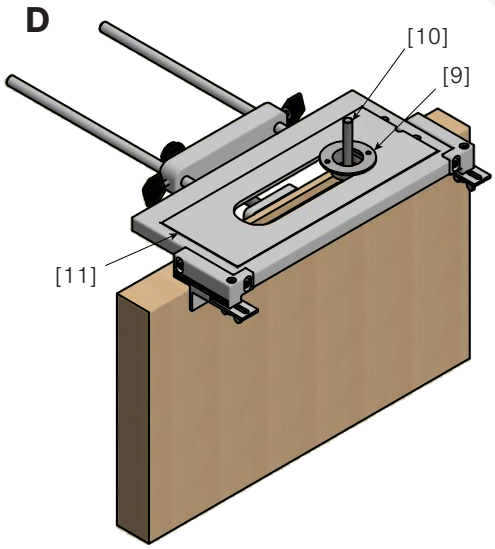
3. Position the Plate [11]

Use the plate with the smaller prep hole (see illustration) for milling the second, deeper prep.



3a. Select the Correct Tools

Attach a Ø30 copying ring [9] and a Ø16 self-drilling slotting cutter [10] with a minimum working length of 30 mm.

3b. Mill the Socket

Guide the sleeve through the milled hole in the plate to form the correct shape.

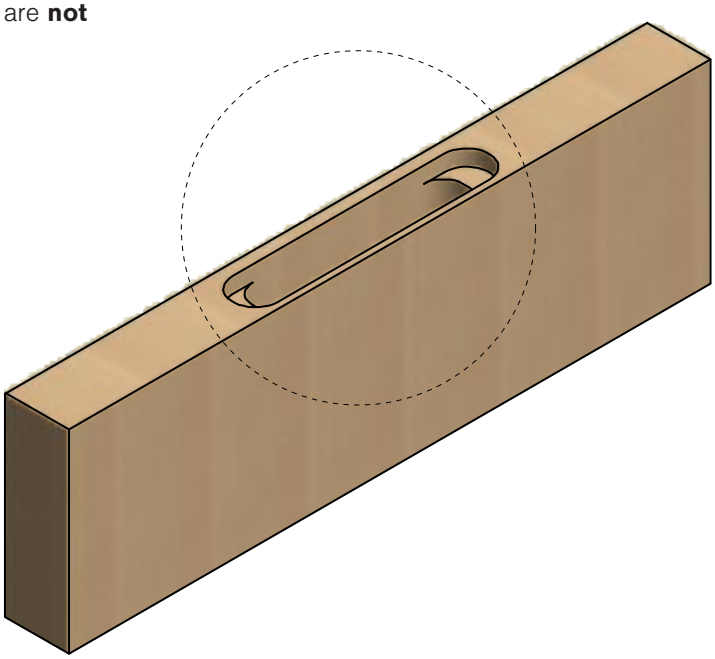
3c. Complete One Full Turn

Make a single pass along the prep hole in the plate to finish it.

WARNING: Adjust the milling machine to increase the slot depth to the required value.

NOTE: The copying ring and self-drilling slotting cutter are **not** included with the jig.

After this stage of milling prep should look like this:



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4. Remove the jig

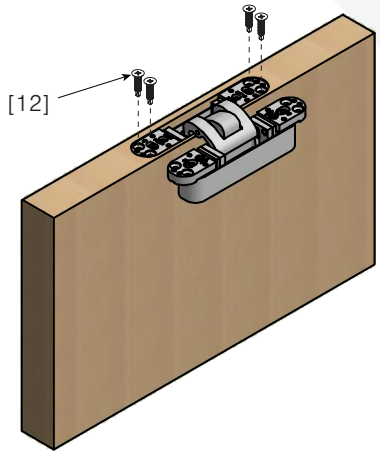
Take the jig off the door or frame.

4a. Position the hinge

Place the hinge into the prep.

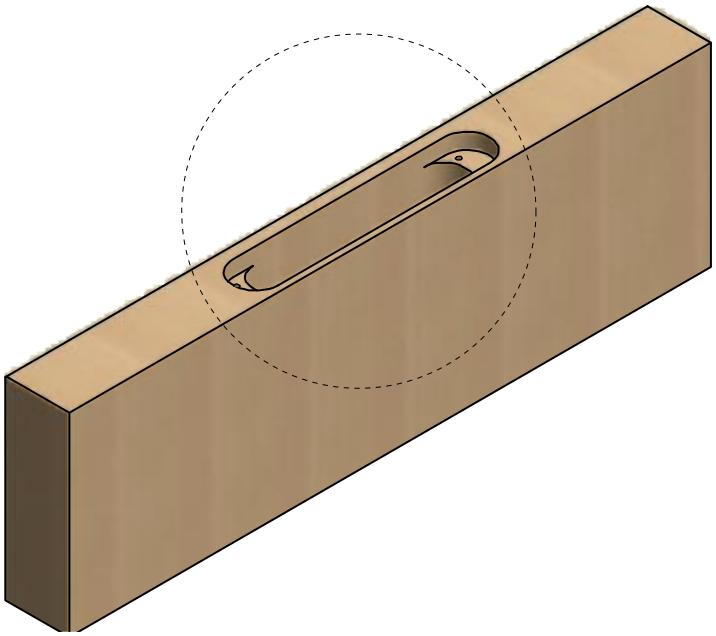
4b. Drill the holes

Using the hinge as a template, drill Ø4 holes (or another size depending on the profile material) to the required screw depth for screws [12].



NOTE: Drill Ø4 or other is not part of the JIG.

Finished prep for hinge in door or frame:



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