

Patent No. 568456  
No. 8,864,188

**Precision™**  
**PLS24PRO-XHD**  
**EXTRA HEAVY DUTY**  
**CONCEALED MAGNETIC CATCH**

# INSTALLATION GUIDE



**WARNING** use extreme caution when handling magnets as the attractant forces are very powerful and if allowed to snap together violently small sharp chips can be thrown off.

SmartBore™ drilling template

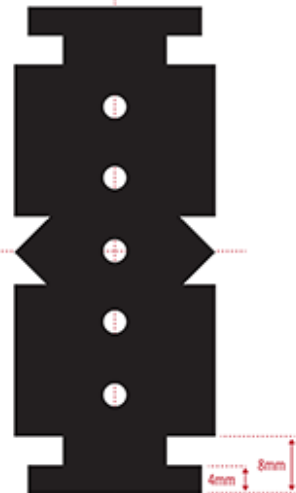
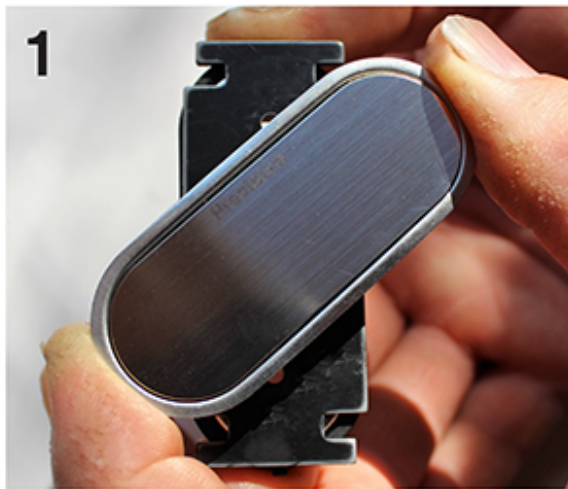
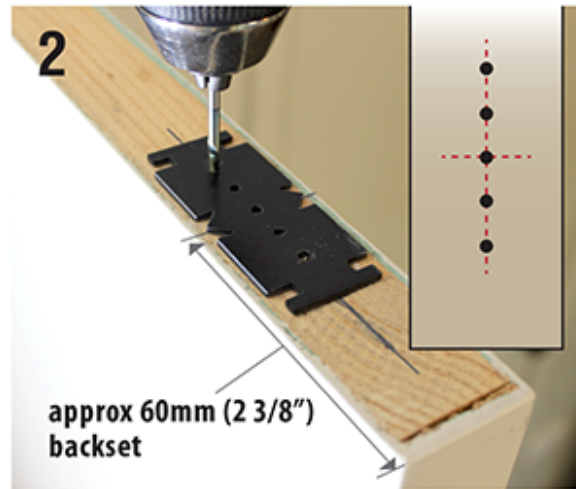


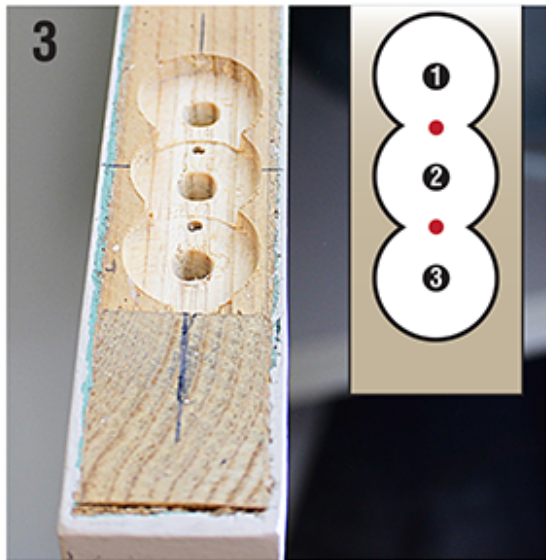
FIG 1 Drilling depth guide



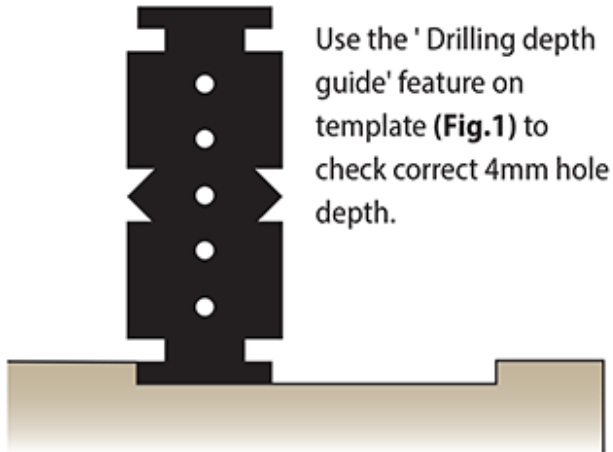
1. Remove magnetic assemblies from packaging. To separate assemblies twist apart sideways. Keep magnetic assemblies at least 1 metre apart (and away from any steel objects) until secured into door and jamb.



2. Measure and mark a centreline onto the top edge of the door. Measure and mark a backset of approx. 60mm (2 3/8") from the 'leading edge' of the door. Position the plastic **SMARTBORE DRILLING TEMPLATE** on the top of door so the templates middle hole and side alignment points are lined up over the intersecting centreline and 'backset mark'. Drill 5 x Ø3mm (1/8") pilot holes through the template into the centreline.

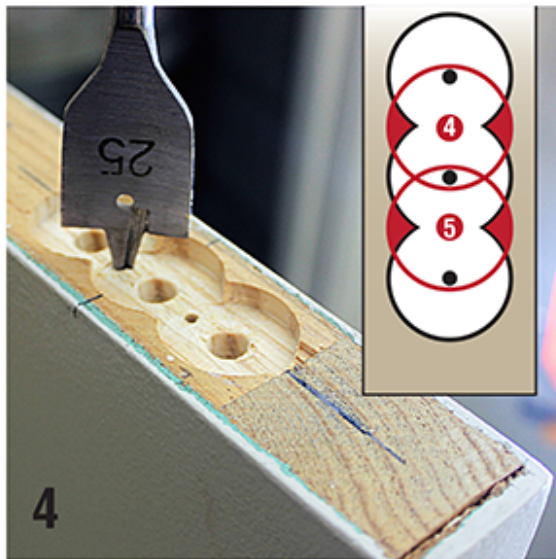


3a



Use the ' Drilling depth guide' feature on template (Fig.1) to check correct 4mm hole depth.

3. Using the 5 x  $\text{\O}3\text{mm}$  ( $1/8''$ ) pilot holes as guides ( Fig.2), bore 3 x overlapping holes ①, ②, ③ with a  $\text{\O}25\text{mm}$  ( $1''$ ) Spade bit, to a depth of approx. 4mm.

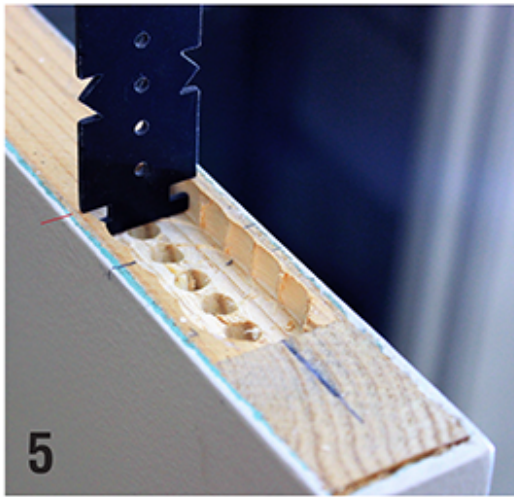


Insert the spade bit's centre guide point into pilot hole bring Power drill up to full speed before slowly and carefully boring out the remaining small **side protrusions**, to the same depth as the surrounding holes

4. Now Bore 2 x more 25mm ( $1''$ ) holes into remaining pilot holes ④, ⑤ to remove small **side protrusions**.

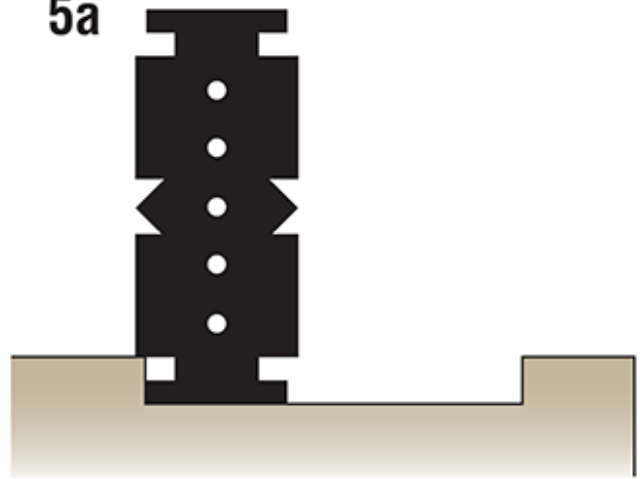


Example of all 5 x holes bored to depth of 4mm - ready for next step.



5

5a



5. Now fully repeat the previously detailed drilling sequence of steps 3. & 4. to bore out all holes to a new depth of 8mm. Use the 'Drilling depth guide' feature on template (Fig.1) to check correct 8mm hole depth (Fig.5a).

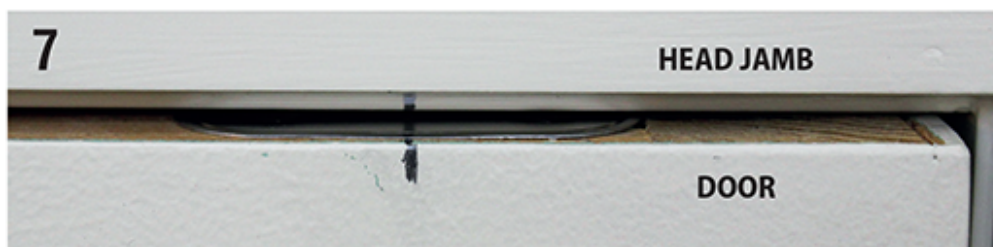
**Note: If the 25mm (1") Spade bit being used has a centre guide point of 16mm (5/8") or longer, it is possible to bore out holes to the final 8mm depth without first boring all holes to the 4mm depth.**



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6. Insert **DOOR MAGNETIC ASSEMBLY** into top of door and secure with 2 x screws provided.

**Be careful not to over tighten screws as this may cause the flanged housing cups to deform and/or cracking in timber.**



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7. Close the door, then transfer the 'backset mark' up onto the head jamb.

8. Open the door, then continue the 'backset mark' onto the underside face of the head jamb, towards the door stop strip. Measure and mark a centreline along the underside face of the head jamb, intersecting with the 'backset mark'.

Measure approx. 3-10mm (1/8" - 3/8") from the centreline towards the door stop strip and mark a new 'offset line' parallel to the centreline. Position the SmartBore drilling template on the

underside face of the head jamb so that the template's middle hole is lined up over the intersecting 'offset line' and 'backset mark'. Drill 5x  $\varnothing 3\text{mm}$  (1/8") pilot holes through the template into the 'offset line' then repeat steps 3. & 4. to create a 4mm then 8mm deep recess in the underside face of head jamb.



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9. Insert **DOOR JAMB MAGNETIC ASSEMBLY** into head jamb and secure with 2 x screws provided.

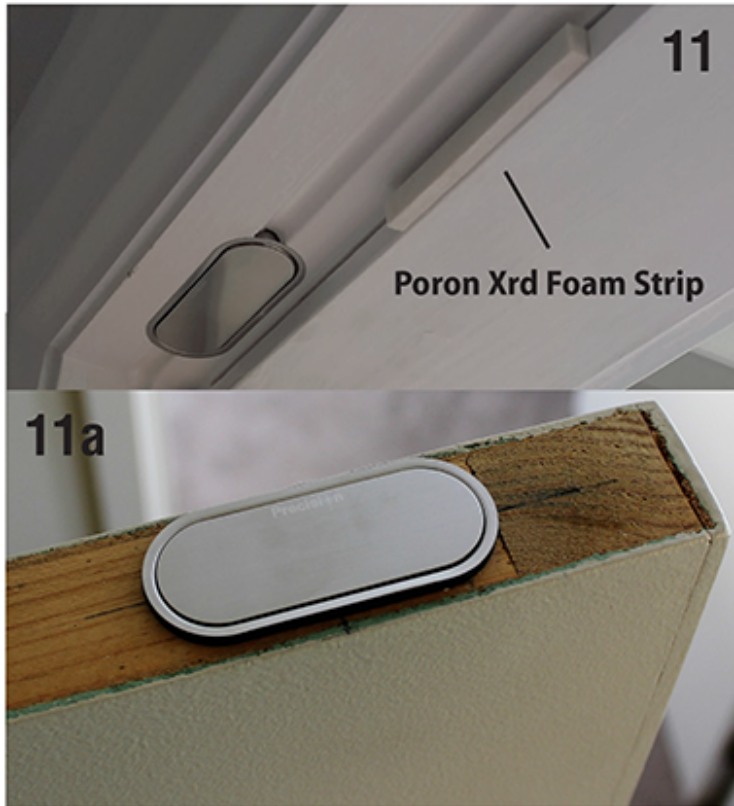
**Be careful not to over tighten screws as this may cause the flanged housing cups to deform and/or cracking in timber.**

10. Close the door to test the magnetic holding strength. **Magnetic holding strength can be greatly increased by decreasing the 'air gap' between the two MAGNETIC ASSEMBLIES.**

If more magnetic holding strength is required, measure the gap between the top of the door and the head jamb to determine how many **POWER ADJUSTMENT SPACER RINGS** should be added (under the **DOOR MAGNETIC ASSEMBLY**) to bring it closer to the **HEAD JAMB MAGNETIC ASSEMBLY**. Remove the **DOOR MAGNETIC ASSEMBLY** from the top of door, turn the assembly over and fit (1-4x) **POWER ADJUSTMENT SPACER RINGS** onto the assembly, under the flanged lip of the housing cup as shown.

**Spacer ring thicknesses range from 0.5mm-3mm (1/64" to 1/8")** Refit the **DOOR MAGNETIC ASSEMBLY** into the top of door, test operation and repeat procedure if more holding strength is required.

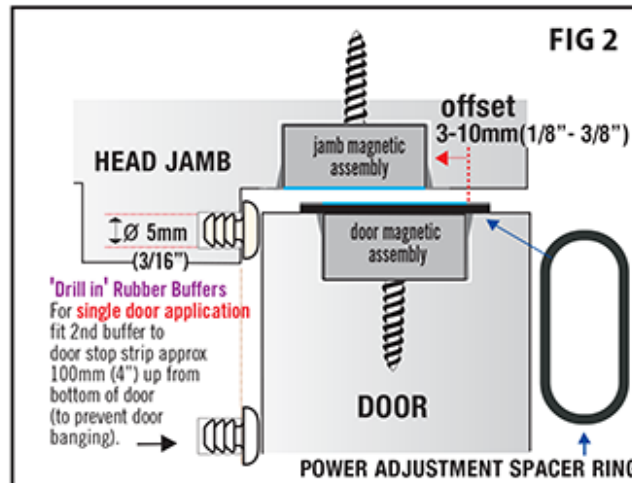




11. Once the desired magnetic holding strength has been achieved, affix the **SELF ADHESIVE S/STEEL COVERPLATES** to the magnetic face(s) of the **ASSEMBLIES** as shown, to protect the magnets from corrosion and for a more attractive 'concealed fix' finish. (11, 11a). Press firmly over the entire surface of the coverplate to ensure maximum adhesion. Remove clear plastic protective film from surface.

**Note: make sure metal faces of the assemblies are free from dust /oil etc before affixing coverplates, to insure maximum adhesion strength.**

12. Fit the rubber door buffer(s) into the door stop strip, to reduce impact noise and 'bounce' when closing the door. (FIG 2)



When the door is closed the **DOOR JAMB ASSEMBLY** must be offset from the **DOOR MAGNETIC ASSEMBLY** (towards the door stop strip) to function correctly.

**Note: to further reduce impact noise and bouncing effect when shutting door (especially when fitting the PLS24PRO-XHD to a double door set), fit PORON Xrd foam pad(s) to the door stop strip as required. (See 11)**

**Sold separately in 10 - pack. (PF10PK)**

