

# 400 SERIES ASSEMBLY INSTRUCTIONS

There are 4 basic 400 series locks:

404X (Passage Hinge)  
403X (Passage Slide)  
404X (Privacy Hinge)  
403X (Privacy Slide)  
(X is the bolt size)

The initial assembly for all 400 series locks is the same, and will be discussed first.

The basic lock consists of a Base and a Lid from a 100 series lock that have been punched out with a special die to accept the Kwik-Set handle mechanism. The first thing to do is to mount the Cylinder in the Base. For the Passage locks, you must use a Dummy Cylinder. For the Privacy locks use either a KD (Keyed Different) or KA (Keyed Alike) Cylinder, whichever the customer desires. These are mounted with a Cylinder Nut Ring, tightened slightly more than hand tight.

The next step is to install the proper size and type Bolt, either slide or hinge. If this is the final installation, make sure that the Bolt is facing in the proper direction. There are two directions to be concerned about. For both the Slide and the Hinge Bolt, determine whether the gate will open to the left or right, and for the Hinge Bolt, make sure the Bolt faces properly for the in or out operation.

Then place the 105 Diamond Cam in the proper spot (see the installation photos on the website). The Spring should be installed next, again using the photos on the website for the proper positioning. Note that the Spring positioning is different for the hinge and slide configurations. A small dab of grease on the shaft of the Diamond Cam is a good idea at this point. This completes the assembly of the Lock Base, and it is now awaiting the addition of the Kwik-Set hardware.

The Kwik-Set portions of the 400 series locks are of two types, Privacy and Passage. The basic Kwik-Set handle assembly comes in two parts. The differences are that the Passage handles are both smooth. The Privacy handles have a thumb turn handle on the inside, and a blind rivet installed on the outside handle to prevent unauthorized access.

One side of the Kwik-Set assembly has the activation shaft and two mounting posts. In all cases, the Multilock Booster Ring is mounted to this side, with the grooved side of the Booster Ring nestled into the Kwik-Set hardware. (see website installation photos).

At this point you should install the portion of the Kwik-Set hardware with the mounted Booster Ring into the base of the Multilock, holding it in place by hand. The Kwik-Set handle should be facing the opposite side of the lock from the exposed bolt.

For all locks in this series, you must now install the grey PVC Spacer on the activator shaft prior to installing the half moon cam (see installation photos). This is not a tight fit. Next, install the Half-moon Cam over the actuator shaft, with the arm portion pointed toward the exposed end of the bolt. This will assist in assuring proper positioning of the cam during use. The exact positioning of the Halfmoon Cam in respect to the Diamond Cam is critical. For Hinge Locks, it may help to depress the bolt to the retracted position while positioning the Halfmoon Cam. You should test the lock for proper operation at this point while hand holding it. (Again, the photos show this well.)

There are two different length Halfmoon Cams, according to which type lock is being assembled. The shortest size fits all Slide Locks. The longer one fits all the Hinge Locks. It is essential that the correct length cam be used, or the lock will not function properly. The proper length cam will be supplied with your order. Once again, a small dab of grease where the Halfmoon Cam hits the Diamond Cam will make the lock operate more smoothly.

Now install the lock Lid, and hold it in place by hand along with the Kwik-Set handles. The lock should activate properly. If not, check closely the positioning of the Halfmoon Cam with the Diamond Cam. If it is installed correctly, tighten the screws on the the Kwik-Set assembly, and then the lid/base assembly. Do not over tighten the Kwik-Set screws, or the lock may bind.