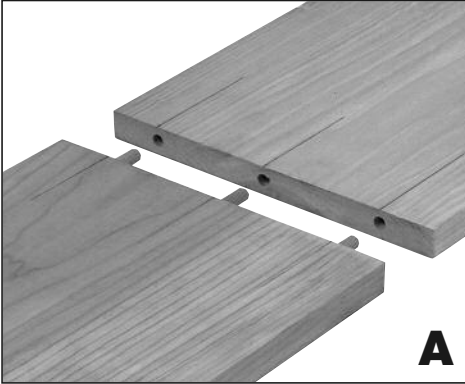




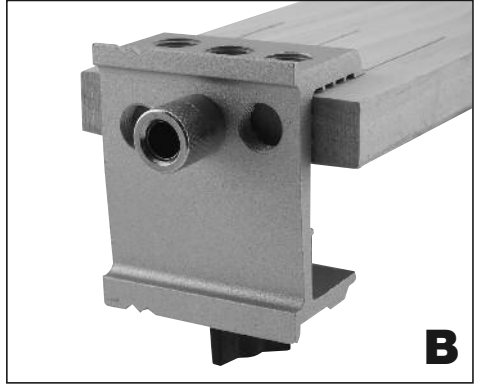
E•Z Pro™ DOWELING JIG KIT

#841
MANUAL



A

EDGE DOWELING

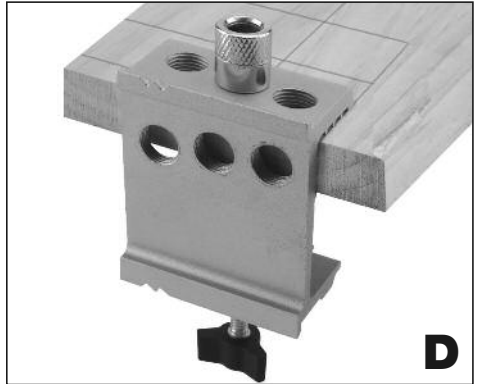


B

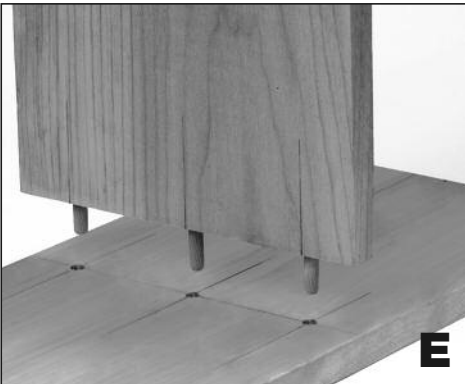


C

RIGHT ANGLE DOWELING

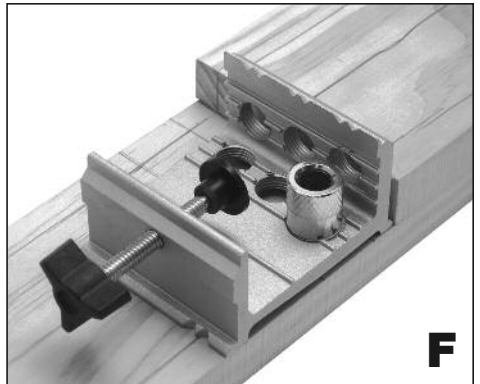


D



E

SURFACE DOWELING



F

INSTRUCTIONS:

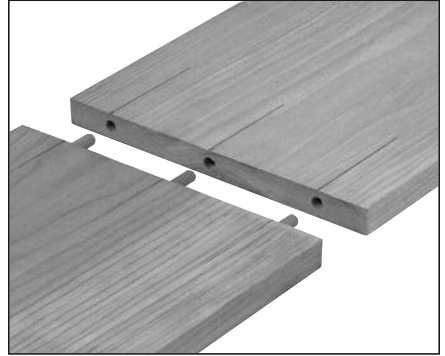
NOTE: In these instructions we will assume using 5/16" diameter dowels, nominal 3/4" thick boards and drilling with the 5/16" drill bit.

All figure references are on the front & back covers.

EDGE DOWELING:

SETTING THE COLLAR AND DRILL DEPTH FOR EDGE DOWELING

You will be drilling 3/4" deep dowel holes in each piece so the 1-1/2" dowels will be equally centered into both boards. In order to correctly position the drill collar, you need to add the thickness of the jig plus the length of the bushing (1") to the 3/4" depth. Thus, to also allow for gluing, set the collar slightly longer than 1-3/4" from the end of the drill (**Fig. G**).



PREPARING YOUR WORK PIECE

1. Draw location lines on the face of your work piece where the dowel holes are to be drilled. Extend these lines at least 2 inches in from the edge (**Fig. H**).
2. Select the drill bushing that fits the dowel size you intend to use, and screw it into the long side of the E•Z Pro Dowel Jig, using the hole that centers on the thickness of the stock you are using (**Fig. I**).
3. Secure your work piece and attach the E•Z Pro Dowel Jig to the edge centering the 2" registration line in the appropriate "V" pointer as shown in (**Fig. J**).
4. Keeping the bushing in the same position re-align jig and drill holes for each dowel position. Insert dowels, assemble dry to check for fit.

Apply glue to dowel pins or drilled holes for a permanent joint. Once assembled, wipe away excess glue.

RIGHT ANGLE (CORNER) DOWELING:

SETTING THE COLLAR AND DRILL DEPTH FOR RIGHT ANGLE DOWELING

For the edge piece, you will be drilling a 1" deep hole and/or the surface piece you will be drilling a 1/2" deep hole to accommodate the 1-1/2" dowels.

Therefore, in order to correctly position the drill collar, you need to add the thickness of the jig plus the length of the bushing (1") to the respective depths before drilling (2" and 1-1/2").



PREPARING YOUR WORK PIECE

Marking the pieces: Lay the 2 pieces to be joined on a flat surface and mark the drill hole locations across each board (**Fig. H**). This will be the INSIDE of the joint.

For the edge doweled part:

1. Mark the board and select the appropriate bushing following the edge doweling instructions (1) and (2) above.
2. Set the appropriate collar depth for edge drilling (2").
3. Drill your edge holes as above (**Fig. B**).

For the surface doweled part:

1. Move the drill bushing to the corresponding location on the top of the E•Z Pro Dowel Jig (Fig. D).
2. Secure your work piece accordingly; clamp the jig with the appropriate “V” pointer on the location line (Fig. J).
3. Set your corresponding collar depth (1-1/2") and drill holes for each dowel position. Insert dowels and assemble dry to check for fit.

Apply glue to dowel pins or drilled holes for a permanent joint. Once assembled, wipe away excess glue.

SURFACE DOWELING:

NOTE: *Surface doweling is the same as right angle (corner) doweling, except you are not on the edge.*

SETTING THE COLLAR AND DRILL DEPTH FOR SURFACE DOWELING

The collar settings and the drill depths will be the same as for right angle doweling.

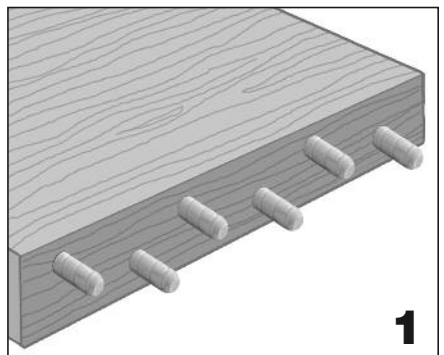
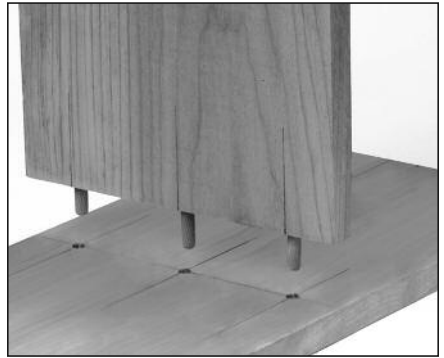
PREPARING YOUR WORK PIECE

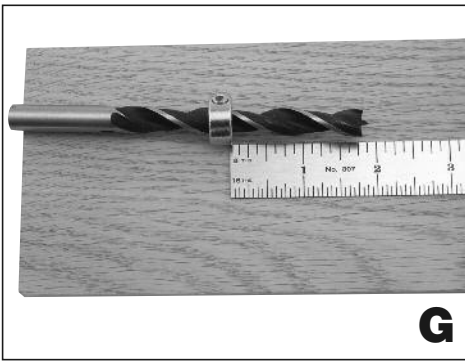
1. In the case of bookcases or cabinets, prepare the end of the shelf or partition as in EDGE DOWELING (Fig's A & B). Attach jig as in edge drilling (Fig. I) and drill holes.
2. On your vertical riser, mark a horizontal line across the full surface where the dowels will be located (Fig. H). If not already marked, you can transfer the center locations from the prepared edge to that horizontal line (Fig. K). Extend your marks at least 3-1/2" down the face to make it visible for alignment to the bottom “V” pointer when the jig is positioned.
3. Mark the jig locating line 15/16" above and parallel to your doweling line (Fig. K). Align your edge board on this line on the surface of your work piece and clamp both pieces (Fig. L).
4. Place the Doweling Jig on its back with the thumbscrew toward you, and screw the desired size drill bushing into the right hand, inside hole (Fig. F). (*Note: this is the only bushing hole to be used when surface doweling.*)
5. With the jig still on its back, slide its top edge to the clamped edge piece (Fig. F), or to the marked line (Fig. K). Align the registration points on both ends of the jig with the extended location lines, hold or clamp the jig firmly and drill your dowel hole.

Re-align the E•Z Pro jig and drill holes for each dowel position. Insert dowels; Assemble dry to check for fit.

Apply glue to dowel pins or drilled holes for a permanent joint. Once assembled, wipe away excess glue.

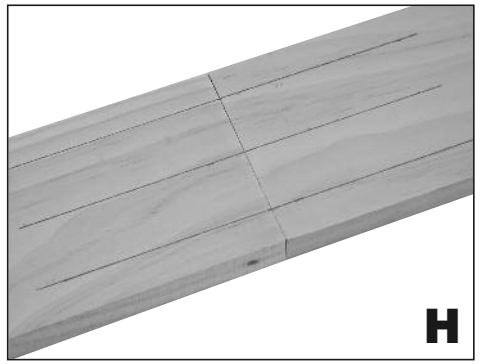
NOTE: *When doweling stock that is greater than 1 inch thick, registration may be alternated between the top and the bottom surfaces to achieve balanced doweling (Fig. 1).*





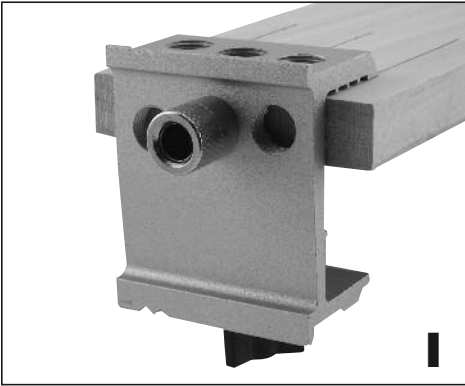
G

SETTING THE COLLAR



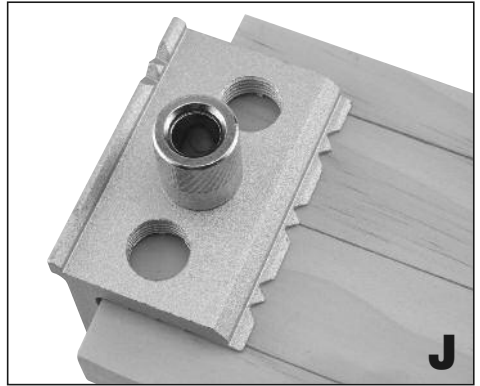
H

MARKING YOUR WORK PIECE



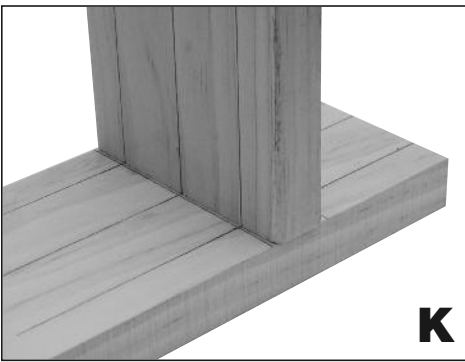
I

EDGE ALIGNMENT



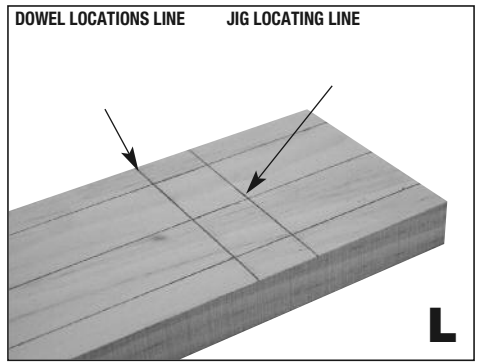
J

RIGHT ANGLE BUSHING & ALIGNMENT



K

INSIDE ANGLE TRANSFER MARKING



L

SURFACE RULE MARKING

GENERAL[®]

Specialty Tools & Instruments