

Pinned Bridge Drilling Jig Instructions

What's included:

- Jig body
- Fence
- Thick steel drill plate

Features:

- Can be used with a handheld drill or drill press
- Accurate and repeatable
- Fence saves settings for use on multiple bridges
- Thick steel drill plate helps keep bit straight
- Spacings: 2 1/8", 2 5/32", 2 3/16", 2 1/4" 2 5/16", 2 3/8"
- Spacings are equidistant on center

How to use:

To begin, you'll need to first install the drill plate in the jig. It's made to a very tight tolerance and has to be put in perfectly straight or it will bind. DO NOT FORCE IT! It'll go in easily once everything is perfectly aligned.

I prefer to drill for bridge pins after the bridge has been slotted since I use that as a reference point. To begin, you'll need to mark the bridge pin row on center. So for instance, I want the center of my pins to be a half an inch from the nearest edge of the saddle slot on center. You'll also need to mark the center of the bridge.

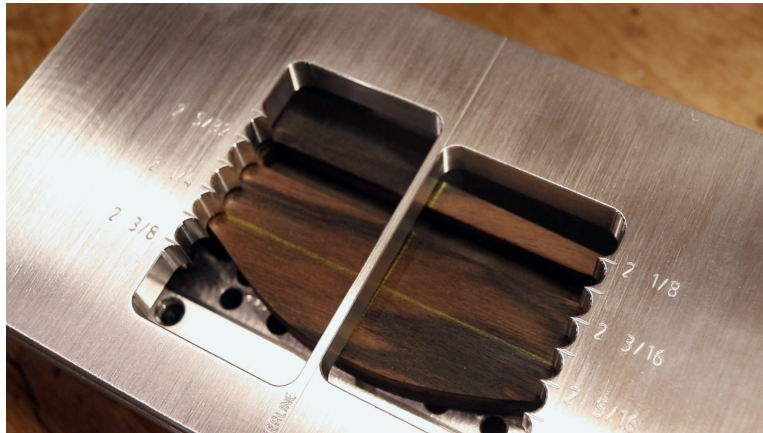


The jig is intended to be used prior to thicknessing and shaping the bridge. This helps with clamping and minimizes the effects of any chipping from the drill exiting the blank.

Now that the bridge has been marked, it's time to locate it in the jig. Flip the jig upside down and place the bridge in the jig body so you can see your pencil marks. There are a set of

points on the underside of the jig that correspond to the drill plate. Each is marked with the appropriate spacing. Be careful handling the jig around these points. THEY'RE SHARP!

There is a vertical strip of aluminum between the points. Look at it carefully. One side is labeled as the centerline. Align your bridge such that the line for your pin row location lines up with the points for your desired spacing and the intersection of your two lines is at the centerline position then lock it down with the lock knobs on the drill plate.



The knobs will mark the underside of the bridge. This is another reason to use the jig prior to final thickening and shaping. If you plan on doing more than one bridge with these settings, now is the time to set the fence. Slide it up against your bridge and lock it down using the two screws on the face of the jig to save your settings.



Now that your bridge is aligned and clamped in place, you're ready to drill. I prefer to use a drill press for this step. Make sure your drill bit is sharp and that you are using the correct set of holes for your desired spacing. When drilling, I like to set a depth stop on my drill press and slow down when I'm approaching final depth to minimize blow out.



That's all there is to it. Drill all your holes and you're done. Or swap out another bridge and you're ready to drill again.

***More of a visual learner? Check out the video tutorial on the [ELEVATE](http://ElevateLutherie.com) site.
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