

Variable M&T Drilling Jig Instructions

What's included:

- Solid aluminum body
- Indexable stainless steel drill guides- (1) 1/4", (1) 3/8"

Features:

- Jig body compatible with 3/4" or 7/8" mortise and tenon joints (choose size)
- Indexable drill guides allow repeatable precision with a handheld drill
- Works for both screw-in type inserts and barrel nut type inserts.

Recommended Specs:

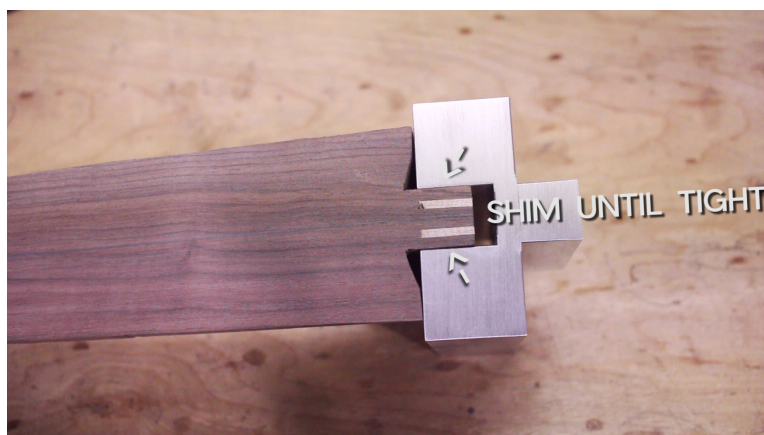
- Instrument M&T Specs: 3/4" or 7/8" wide maximum x 3" long minimum x 3/4" deep

How to use:

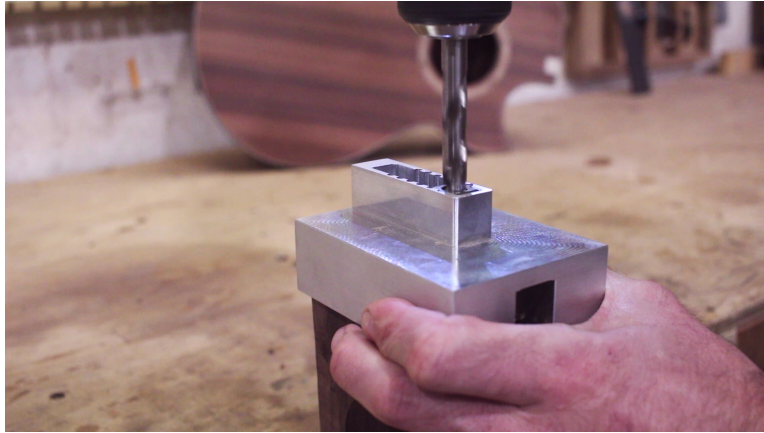
The Variable M&T Drilling Jig is intended for use on instruments with a $\frac{3}{4}$ " wide or $\frac{7}{8}$ " wide mortise and tenon. To use the jig, first decide which positions you'll be using to drill. The guides are made to be a tight fit, so make sure they are perfectly vertical when inserting them into the jig. Removing drill guides is made easier with the use of a common L shaped allen wrench.

I like to start with the tenon after the neck has been fitted to the body. If you glue down the fingerboard, simply butt the jig against the underside of the fingerboard. If you build with a 100% bolted system, position the jig so that it's flush to the top of the neck stock prior to attaching the fingerboard and adding the fingerboard extension support.

If your tenon is undersized, it's recommended that you add shims equally to both sides until it's snug in the jig.



If you use insert style hardware use the end face of the jig with the $\frac{3}{8}$ " guide to drill the tenon for hardware. If you use cross grain style inserts, first use the side face of the jig and a 10mm guide (sold separately) to drill for hardware, then use the end face and a $\frac{1}{4}$ " guide to drill your clearance holes.



Now on to the body. If your mortise is oversized, add shims as mentioned before. To drill the mortise, flush the jig to the top of the instrument where the jig meets the sides. This is especially important to note if you don't build flat tops. Using the $\frac{1}{4}$ " guide, drill through the neck block. A long clamp applied with light pressure is a good way to hold the jig in place while drilling.



Now that both the mortise and tenon have been drilled, attach your hardware to the tenon and assemble the instrument to check alignment.

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