

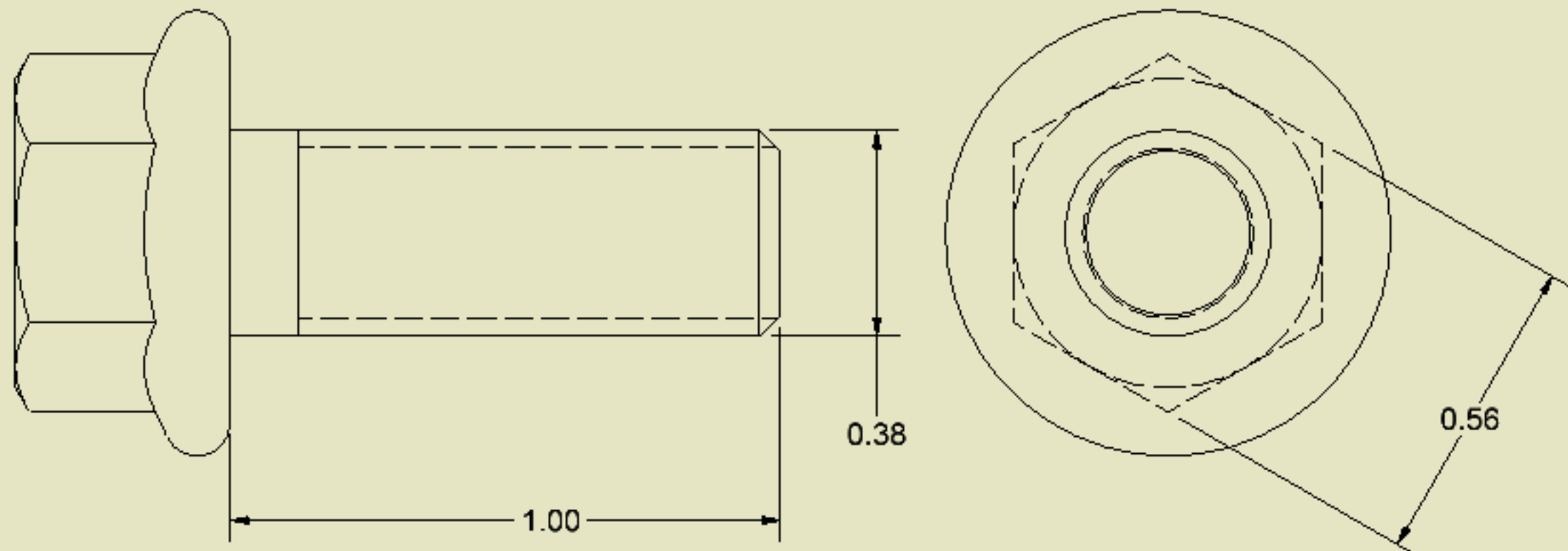
A

- 1 Threaded hole or bolt and nut combination
- 2 Weld to base of Jig, this is used to hold the jig in a vise
- 3 Machine groove to the thickness of the blades you work with
- 4 Clamp shape is not critical, however you should follow the basic shape when machining
- 5 Bolt should be flange type head

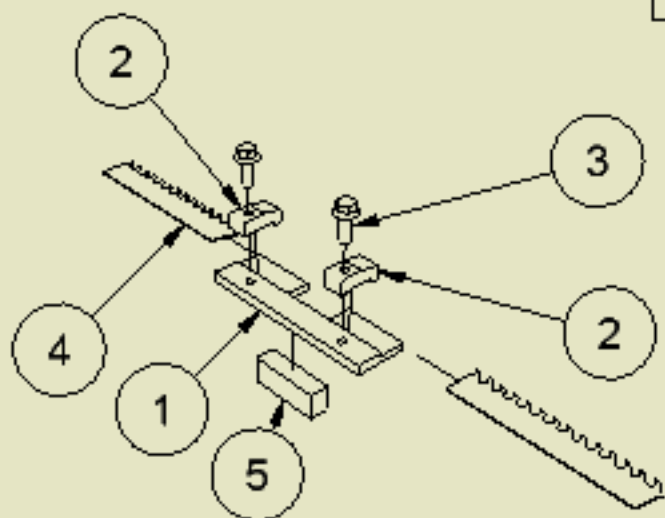
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Assembly details

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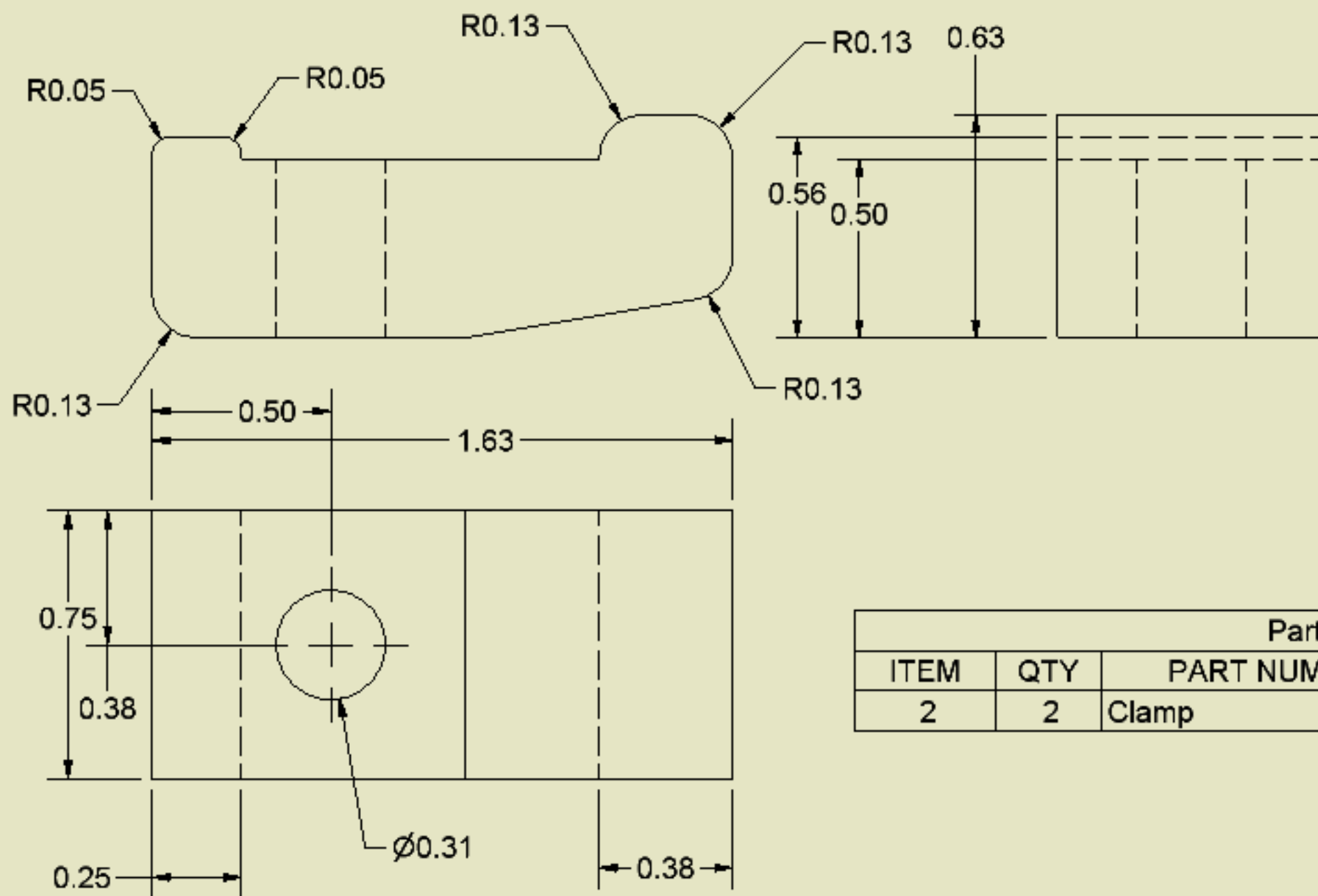
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
3	2	IFI 111 - 3/8-16 UNC x 1	Hex Flange Screw - Regular Thread - Inch
1	1	Jig base	



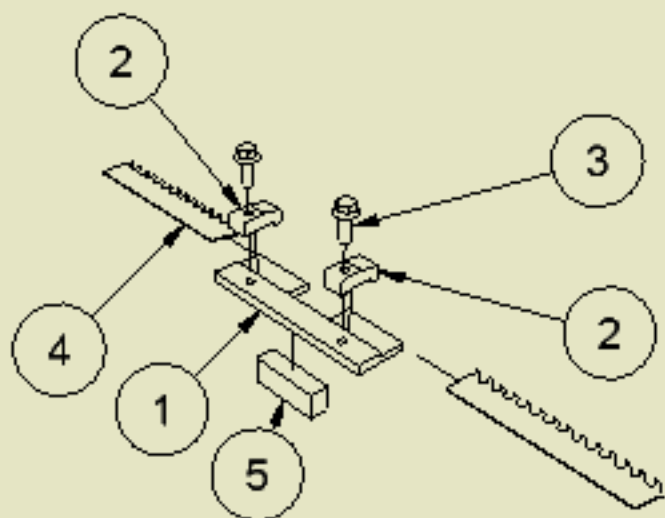
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Bolt

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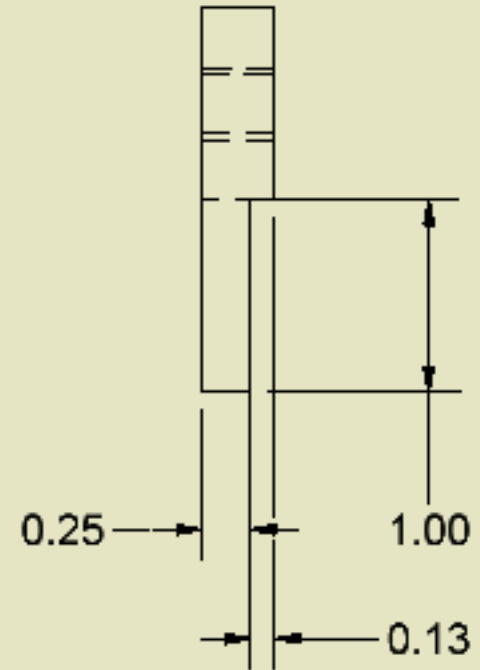
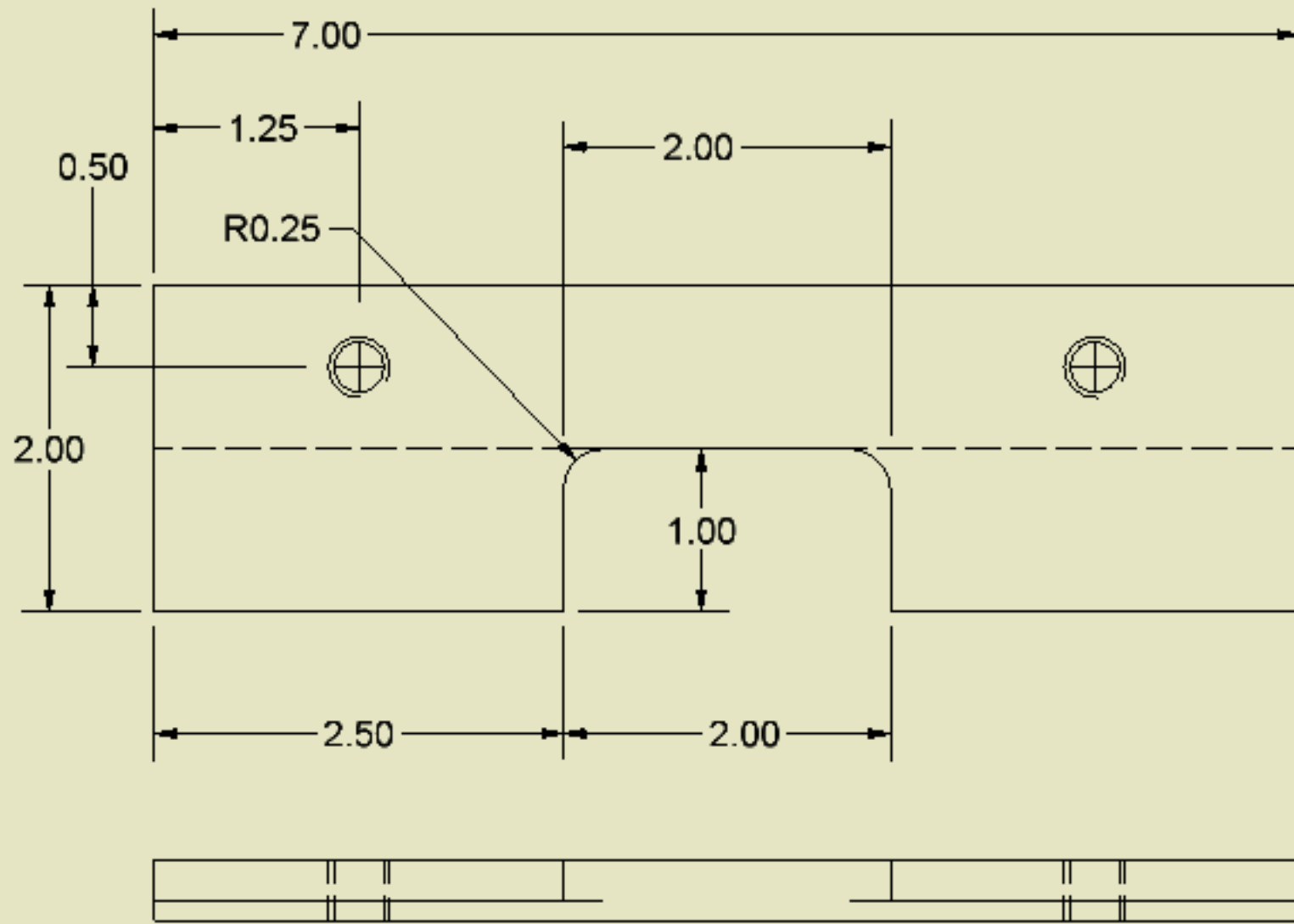
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
2	2	Clamp	



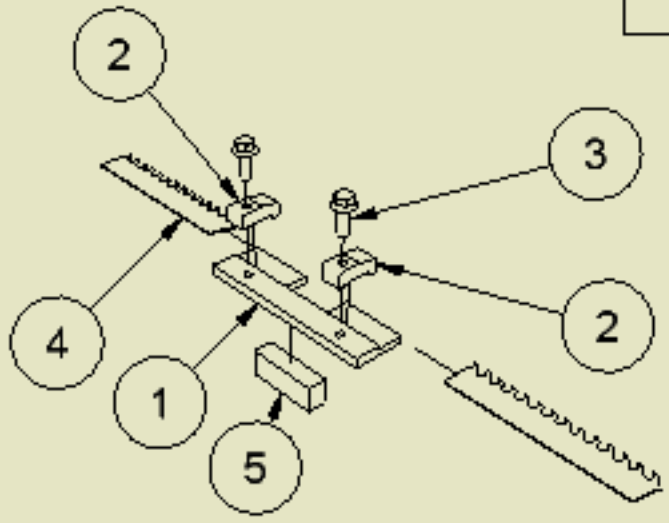
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Clamp

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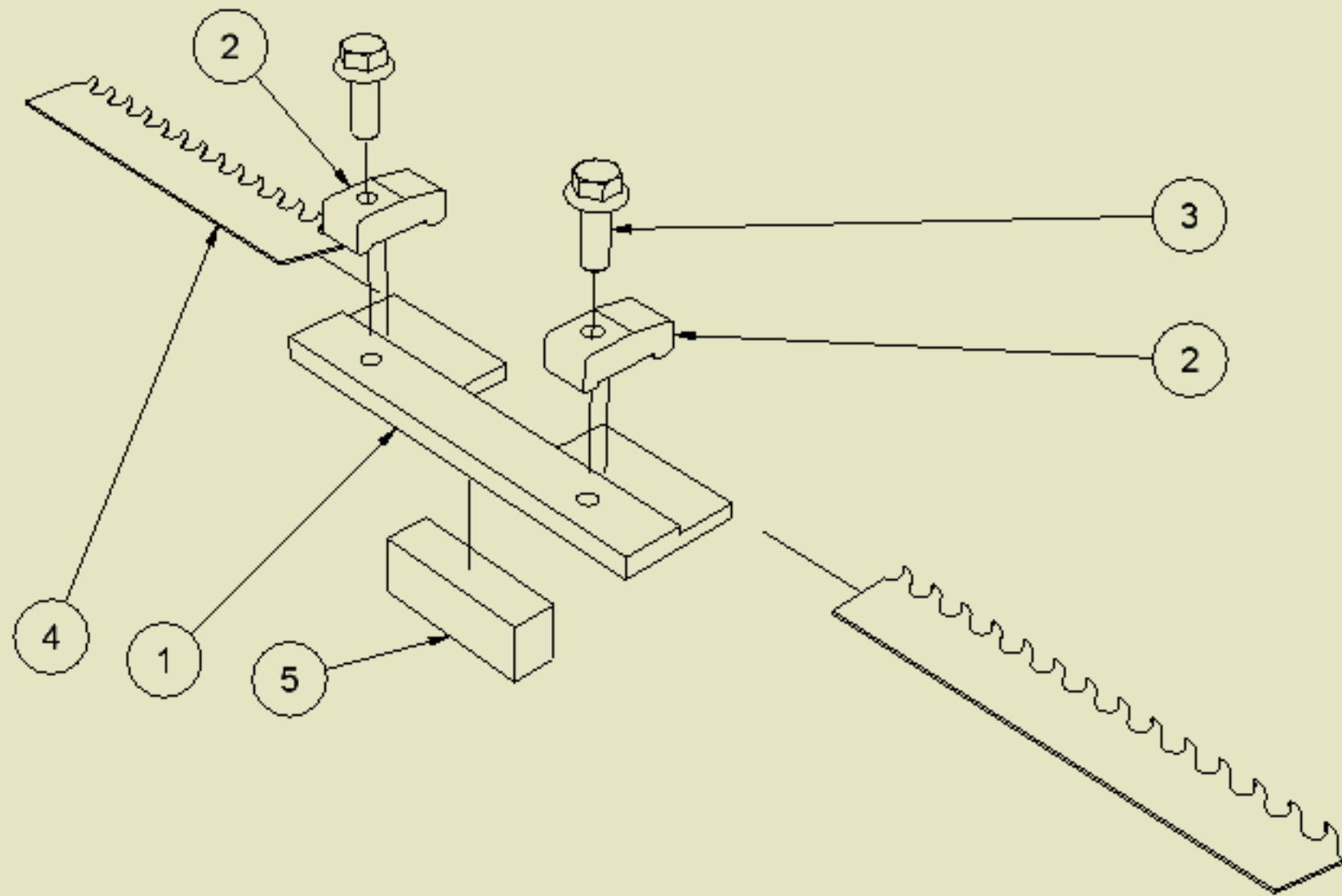
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	Jig base	



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Jig base

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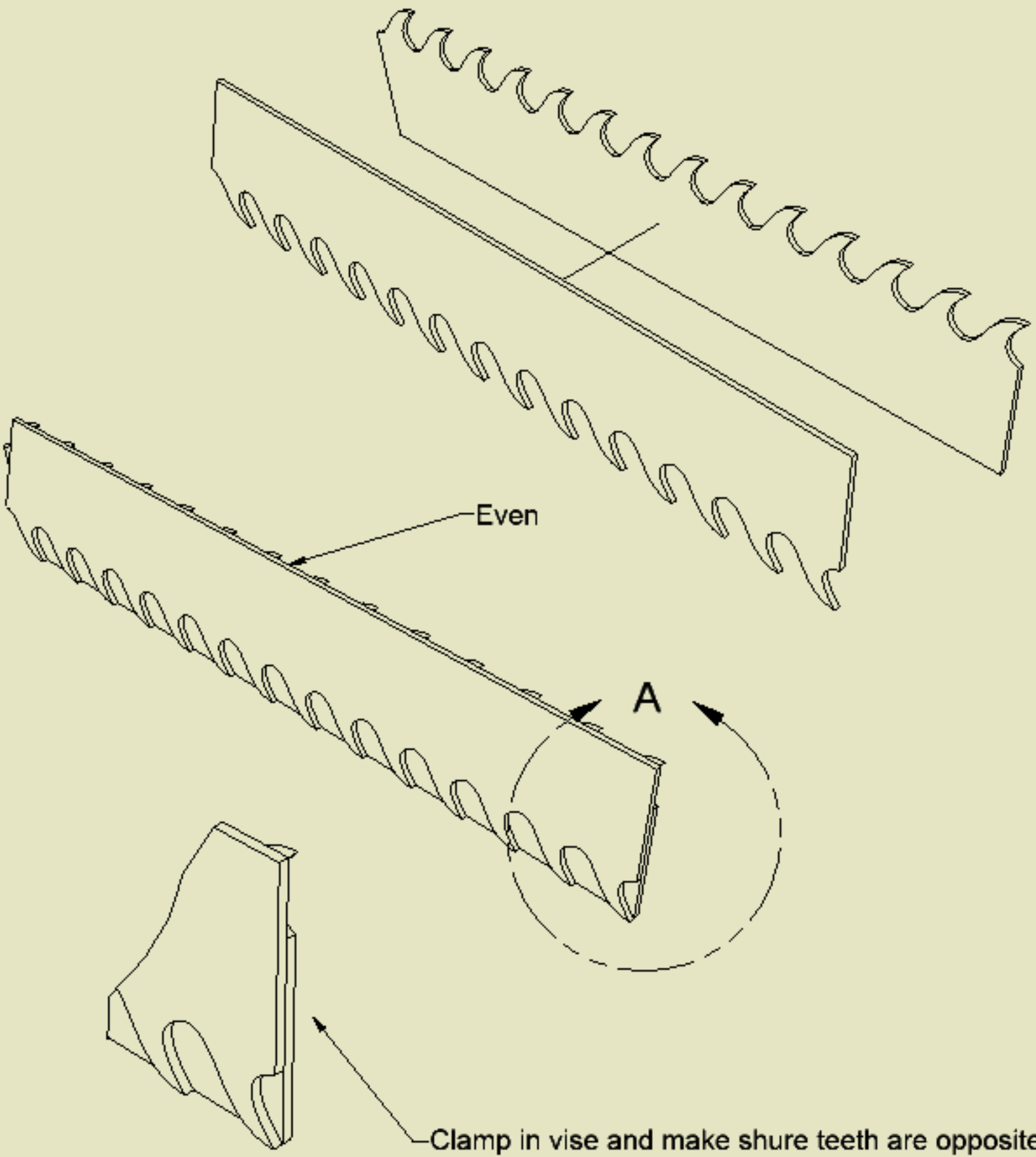


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	Jig base	
2	2	Clamp	
3	2	IFI 111 - 3/8-16 UNC x 1	Hex Flange Screw - Regular Thread - Inch
4	2	Blade section	
5	1	Vise piece	

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Saw jig

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Clamp in a vise as shown
make shure teeth are opposite
and blade is even on both sides
before clamping in vise, you will
be grinding to make a joint

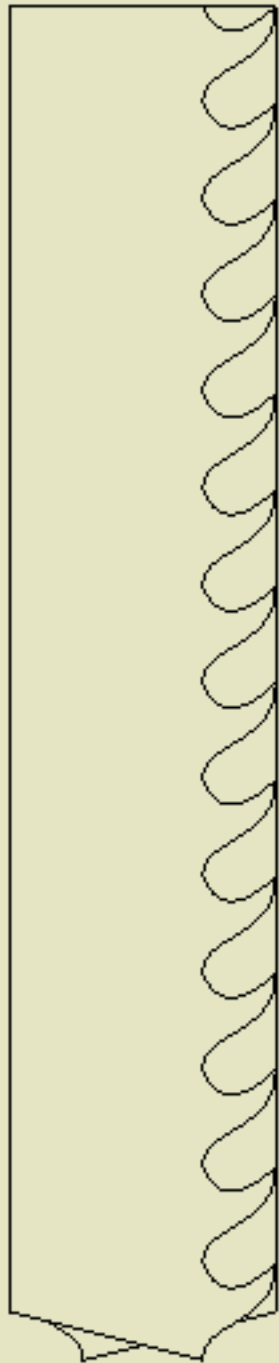
DETAIL A

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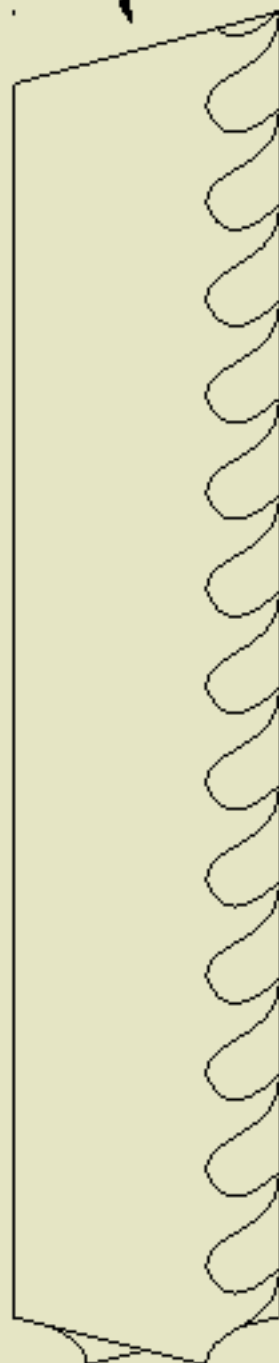
Step 1

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Grind this away



Before



After

Remove the steel shown,
this will become your joint,
the angle does not have
to be exact

Clean and straight grinding
is important for a strong joint

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Step 2

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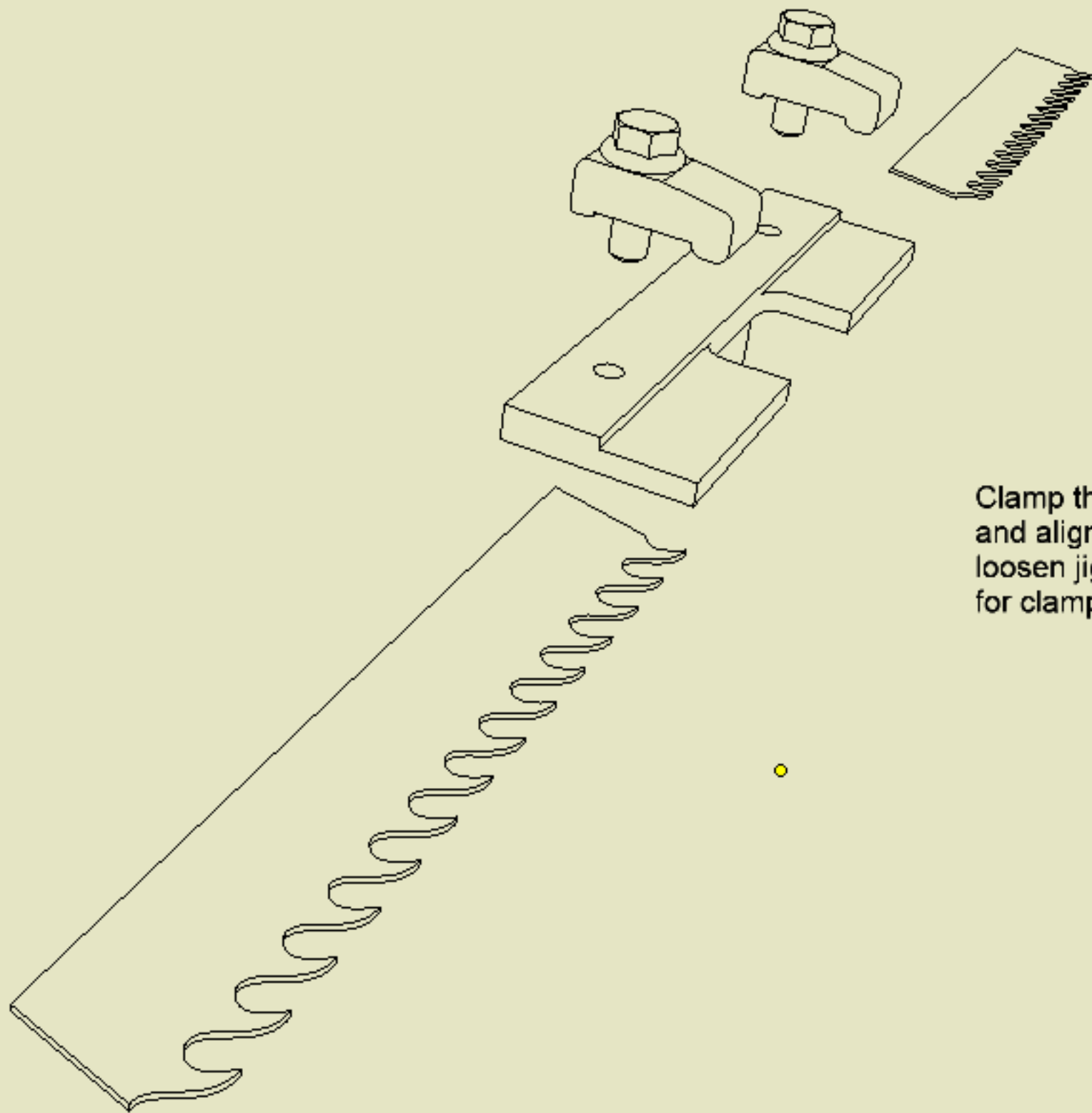


Once the grinding is done remove from vise and you will have a joint that looks similar to this, this is where the weld will be made.

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Step 3

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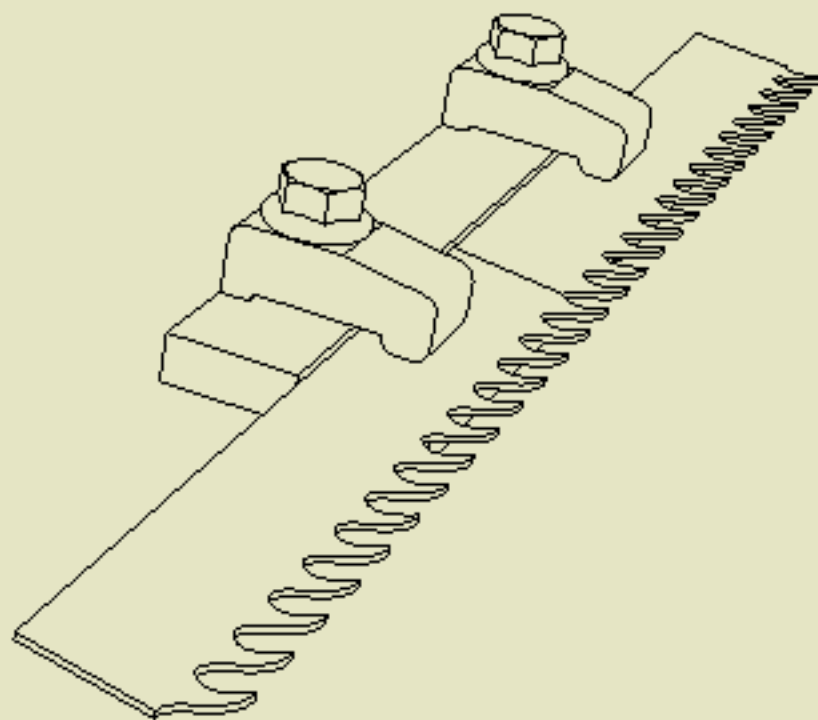


Clamp the Jig into a Vise
and align blades as shown,
loosen jig clamps and prepare
for clamping.

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Step 4

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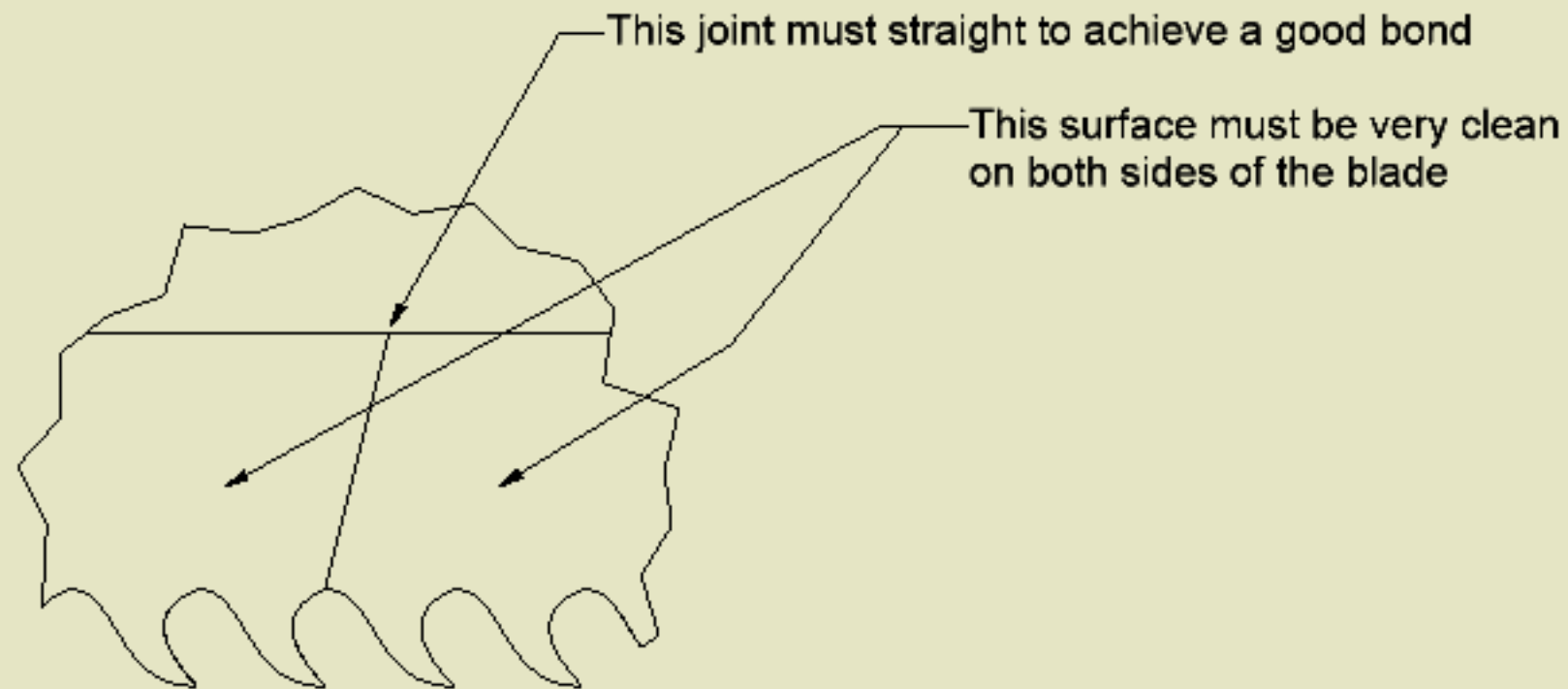
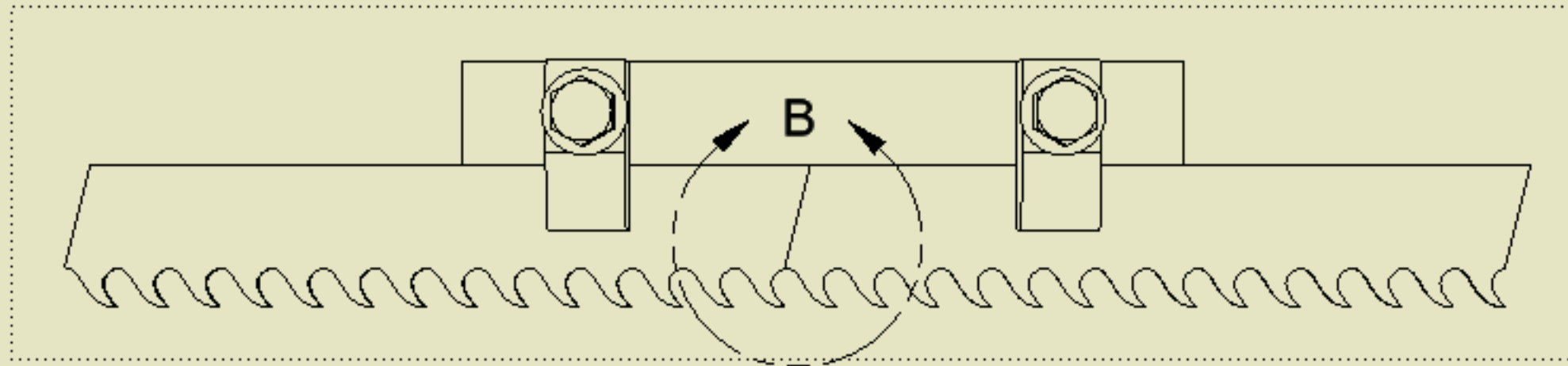
Bring ends of blade together as shown and tighten jig clamps, be shure that there is no space in the joint.

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Step 5

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Take time to align the blades as perfect as possible, if the joint is crooked it will fail.

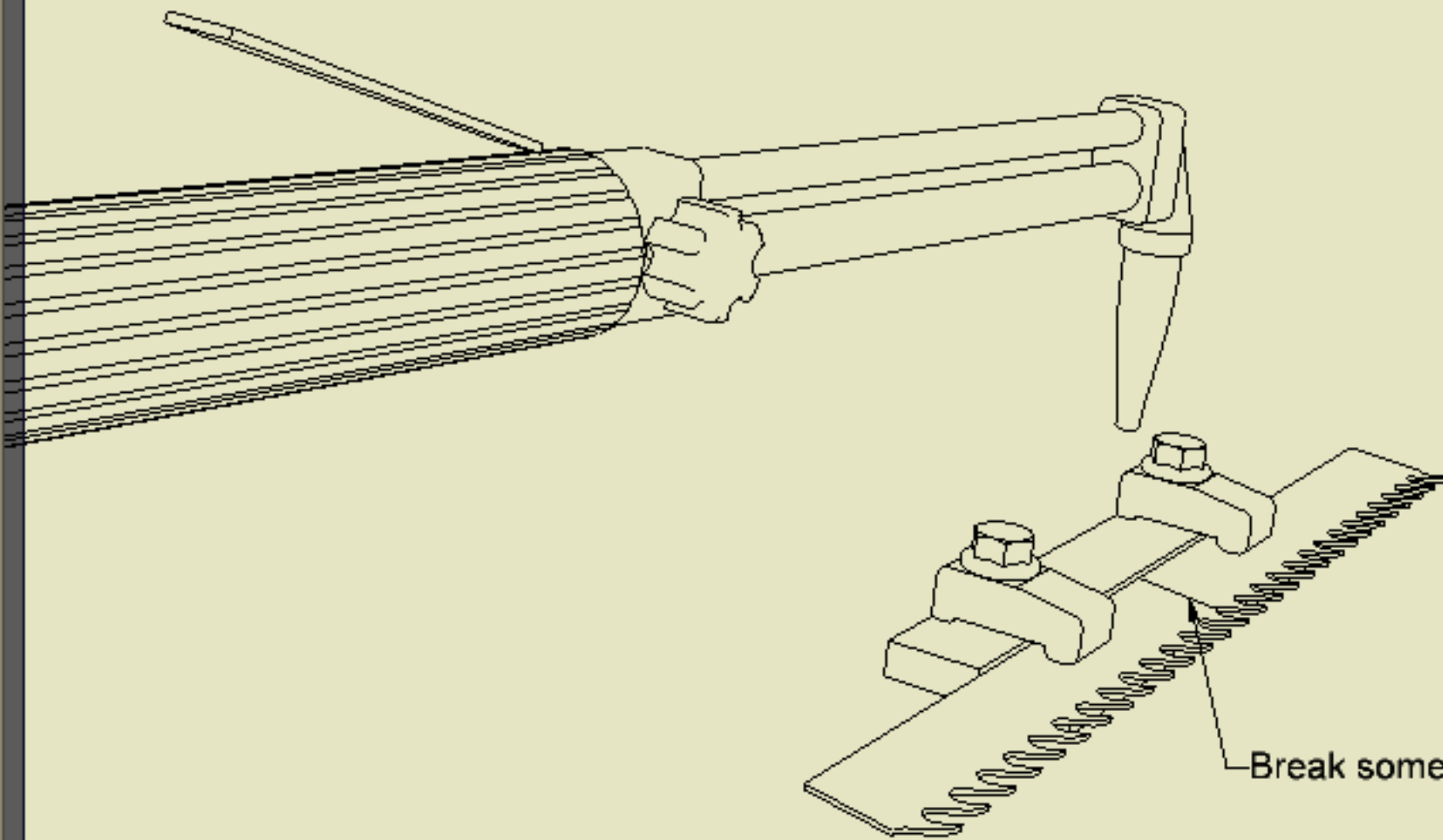


DETAIL B
SCALE 1 : 1

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Step 6

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You will need an oxygen acetylene torch or a mapp torch and some brazing rod, you can get these at any welding supply store.

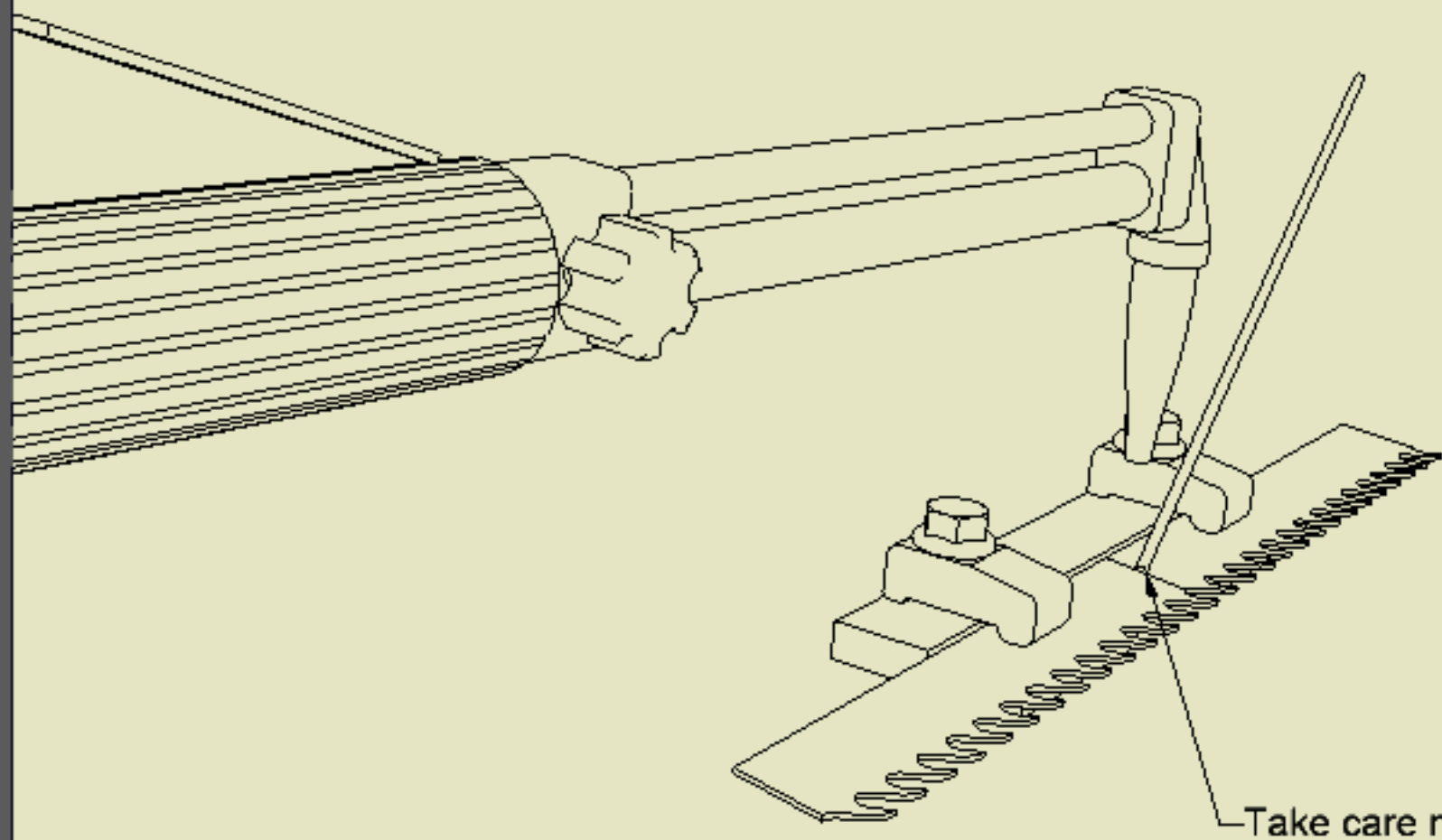
Break some of the coating off the brazing rod onto the joint, heat the joint and melt the flux into the joint.

Break some coating off the brazing rod and place on this joint

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Step 7

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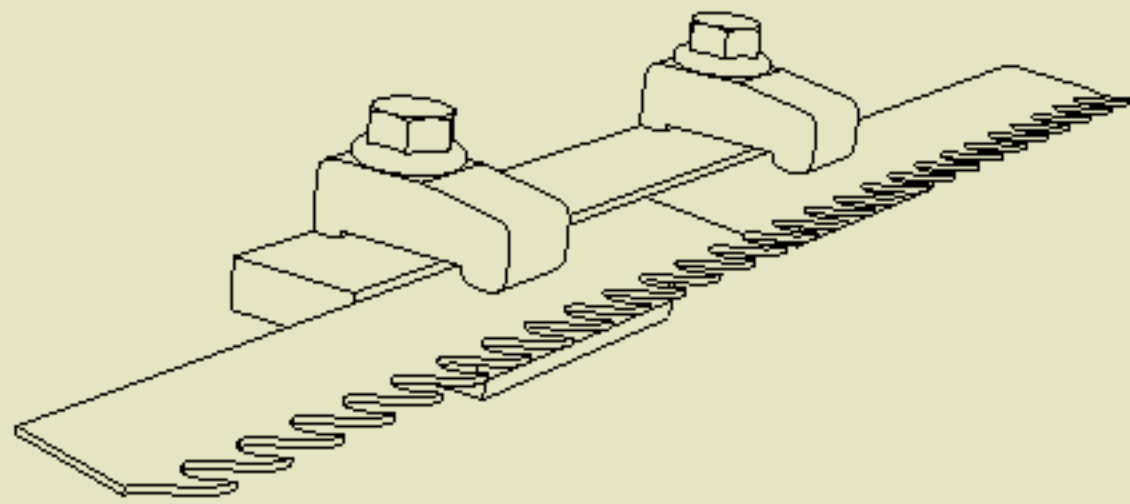
After melting the flux introduce the brazing rod and melt some of it the joint, it should flow nicely and stick to the metal.

Take care not to over heat the joint

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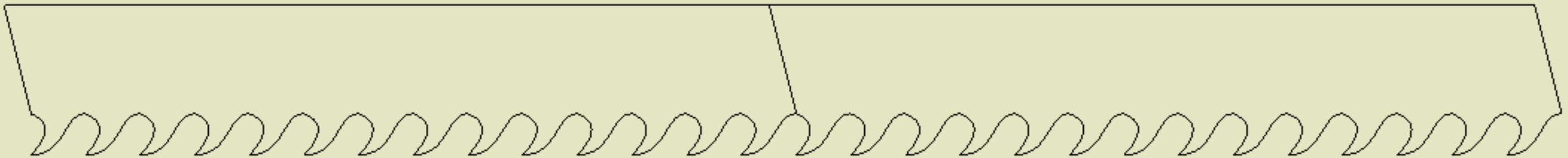
Step 8

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Smoothe away excess brass bumps from top and bottom

Edge



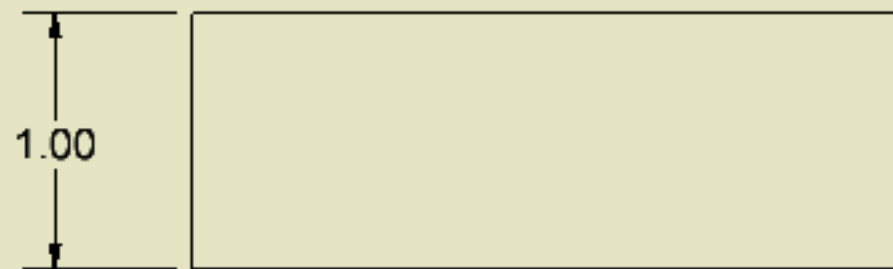
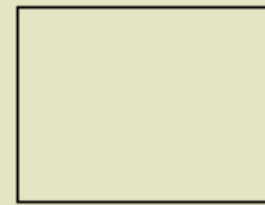
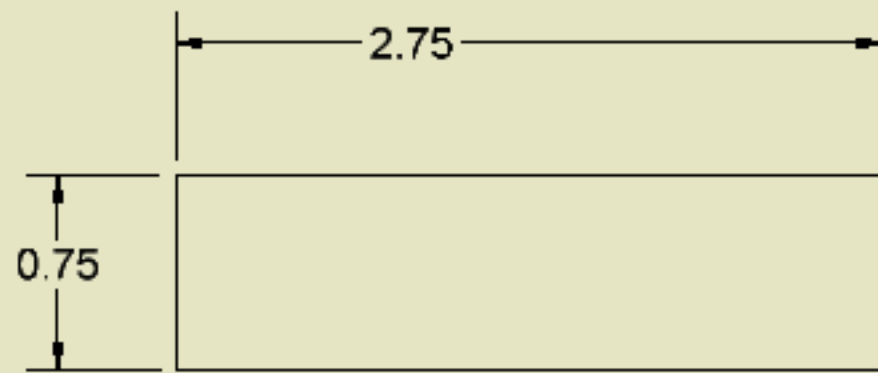
Face

After cooling remove from Jig and smooth joint out with a grinder.

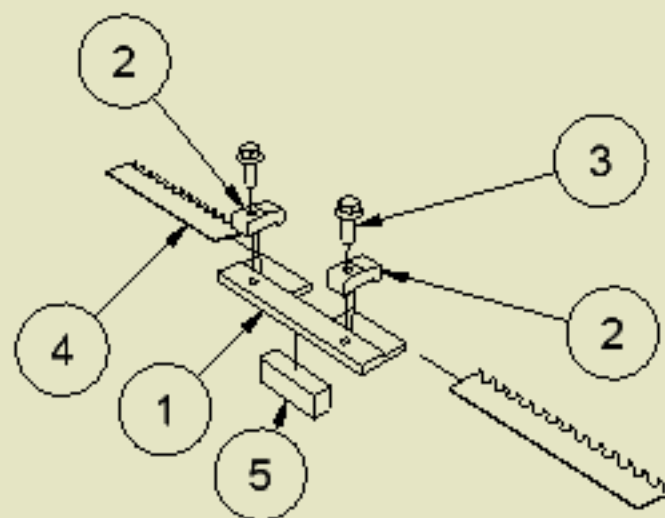
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Step 9

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Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1		Vise piece



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Jig holder

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