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
Saw jig

<table>
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<tr>
<th>ITEM</th>
<th>QTY</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Jig base</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>Clamp</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>2</td>
<td>IFI 111 - 3/8-16 UNC x 1</td>
<td>Hex Flange Screw - Regular Thread - Inch</td>
</tr>
<tr>
<td>4</td>
<td>2</td>
<td>Blade section</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Vise piece</td>
<td></td>
</tr>
</tbody>
</table>
Clamp in a vise as shown and blade is even on both sides before clamping in vise, you will be grinding to make a joint.

DETAIL A

Clamp in vise and make sure teeth are opposite.
Grind this away

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.

Before

After
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.
Clamp the Jig into a Vise and align blades as shown, loosen jig clamps and prepare for clamping.
Bring ends of blade together as shown and tighten jig clamps, be sure that there is no space in the joint.
Take time to align the blades as perfect as possible, if the joint is crooked it will fail.

This joint must straight to achieve a good bond

This surface must be very clean on both sides of the blade

DETAIL B
SCALE 1 : 1
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
After melting the flux introduce the brazing rod and melt some of it to the joint, it should flow nicely and stick to the metal.

Take care not to overheat the joint.
Smoother away excess brass bumps from top and bottom

Edge

Face

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

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<tbody>
<tr>
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Jig holder

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