

# Model D4116 Doweling Jig Instruction Sheet



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## Introduction

Use the Model D4116 Doweling Jig to drill aligned and opposing dowel holes in two boards to be joined.

Included are two each of  $\frac{1}{4}$ ",  $\frac{3}{8}$ ", and  $\frac{5}{16}$ " threaded drill guides for making a pair of dowel holes at a time without having to reposition the jig. Additionally, there are  $\frac{7}{16}$ " and  $\frac{1}{2}$ " drill guides bored into the center bar.

When properly clamped, the doweling jig automatically centers the drill guides onto boards up to  $2\frac{5}{8}$ " in width.

## Identification (see Figure 1)

- A. **Threaded Holes:** Accept the threaded drill guides that can be installed as a pair or individually.
- B.  **$\frac{7}{16}$ " &  $\frac{1}{2}$ " Drill Guides:** Non-threaded holes in the middle bar that provide additional sized drill guides.
- C. **Vise Screw:** Controls the clamping pressure of the extruded aluminum vise plates.
- D.  **$\frac{1}{4}$ ",  $\frac{3}{8}$ ", &  $\frac{5}{16}$ " Drill Guides:** When installed in the threaded holes of the middle bar, provide drill guides for the drill bit.

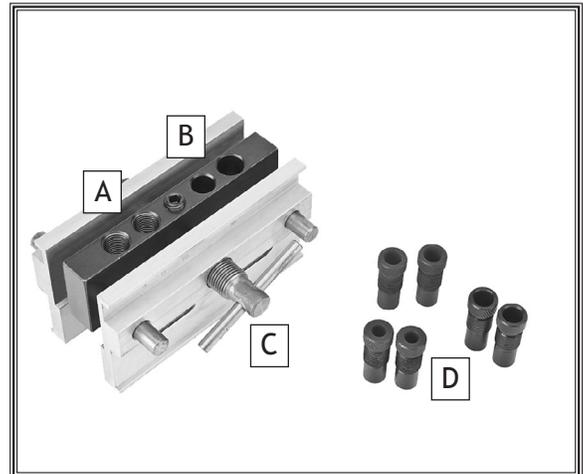


Figure 1. Model D4116 identification.

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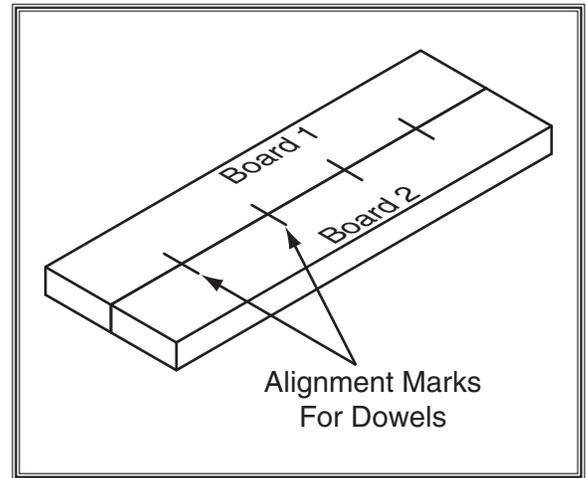
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## Operation

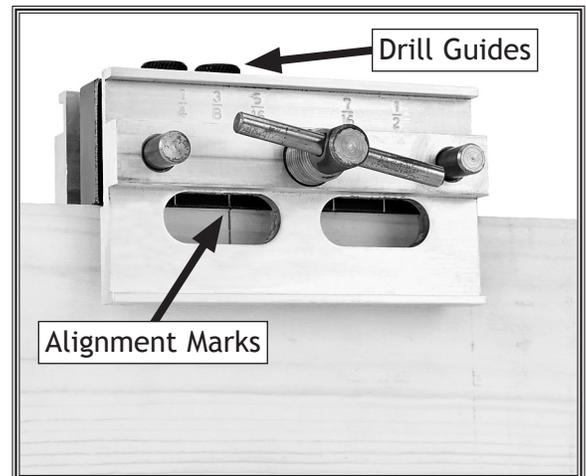
1. Align the two boards to be joined, then make marks on one side of the boards where the dowel holes will be drilled (see **Figure 2**).
2. Install the appropriate drill guides into the middle bar of the jig where applicable, or use the non-threaded drill guides of the bar.
3. Separate the boards, align the appropriate mark on the bottom of the middle bar with the mark on one of the boards (see **Figure 3**), then firmly clamp the jig to the board.
4. Insert the correct size drill bit into the drill guide and against the board, then start the drill and make a dowel hole that is the right depth for your operation.
5. Repeat **Steps 3–4** for the other board.

## Maintenance

Periodically, wipe away dust and debris from the vise screw and the threads of the drill guides, then apply a thin coat of light machine oil to ensure smooth operation of these parts.



**Figure 2.** Alignment marks on the boards for the dowel positions.



**Figure 3.** Doweling jig setup.