



OPERATING AND MAINTENANCE INSTRUCTIONS

12" & 24" DOVETAILS FIXTURE

40-010

40-020



FEATURES

40-010

Cuts precision matching dovetails with the same accuracy found in fine furniture.

Put the stock in position and pull the handle to lock it into place.

Both pieces of stock are held at the same time to provide the necessary offset.

Handles stock up to 12" wide and from 1/2" to 1 1/4" thick.

This fixture makes the perfect dovetail joints possible.

Comes with 1/2" aluminum template (40-016).

40-020

Male and female dovetail joints are cut simultaneously, to ensure perfectly matched dovetail joints.

Side stops provided, allow repeated precise dovetail joint cutting with one initial setting.

Handles stock up to 24" wide.

SAFETY RULES

READ CAREFULLY BEFORE OPERATING THE MACHINE

1. Learn the machine's applications and limitations, as well as the specific potential hazards particular to this machine. Follow available safety instructions and safety rules carefully.
2. Keep working area clean and be sure adequate lighting is available.
3. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.
4. Keep hands well away from router bits and all moving parts. Do not clear chips and sawdust away with hands. Use a brush.
5. Make sure the router bit is moving at operation speed before cutting.
6. Do not push the router bit too hard. The router bit will perform better and be safer working at the rate for which it was designed.
7. Whenever possible use a dust collector with shaving hood to minimize health hazards.
8. Never leave the machine with the power on.
9. Keep children away. Make sure that visitors are kept at a safe distance from the work area.
10. Use recommended speed router bit, accessory, and workpiece material.
11. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
12. Be sure the router bit is securely locked in the machine.
13. Do not force the machine. It will do the job better and be safer at a rate for which it was designed.
14. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the tool again.
15. Be sure that key and adjusting wrenches have been removed before turning power on.
16. Use only accessories designed for the machine.
17. Make sure tool is properly grounded. If tool is equipped with three-prong plug, it should be plugged into a three-pole electrical receptacle. Never remove the third prong.
18. Always disconnect tool before servicing and when changing accessories such as router bits.
19. Make sure that switch is in "OFF" position before plugging in cord.
20. Hold material firmly against the table.
21. Use ONLY recommended accessories. Use of accessories NOT recommended by General International may result in a risk of injury.
22. Do not use this dovetail fixture for other than it's intended use. If used for other purposes, General International disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

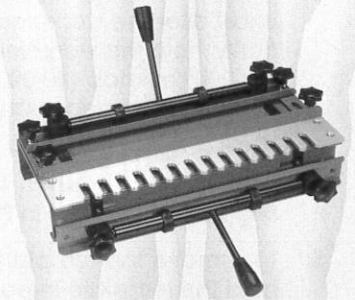
GENERAL ® INTERNATIONAL guarantee

All component parts of GENERAL INTERNATIONAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL INTERNATIONAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months from date of purchase. In order to obtain warranty, all defective parts must be returned prepaid to GENERAL INTERNATIONAL MFG. Co Ltd. Repairs made without our written authorization voids all guarantees.

DOVETAIL FIXTURE

40-010/40-020

GENERAL® INTERNATIONAL dovetail fixtures are carefully tested and inspected before shipment and if properly used will give perfect results. However, a reasonable amount of care and attention is necessary to ensure perfect performance and accurate work. It is imperative that you take a few moments to familiarize yourself with these instructions, as they will no doubt save you a lot of time and trouble.



UNPACKAGING

- Remove the contents of the shipping carton and compare with your contents list.
- Report damage if any to your local distributor.

ASSEMBLY & MOUNTING(40-010)

1. Thread the rear handle (A, Fig.1) into the clamping rod (B, Fig.1). The rear handle should be mounted with the cams (C, Fig.1) pointing up as illustrated in (Fig.1). This will allow to push the handle down from you to lock the workpiece in the fixture.
2. Thread the front handle (D, Fig.1) into the clamping rod (E, Fig.1), the front handle should be, mounted with cams (F, Fig.1) pointing down, as illustrated in (Fig.1). This will allow you to push the handle down from you to lock the workpiece in the fixture.
3. You can mount the fixture to a workbench through the two mounting holes found at the rear of the fixture. You can also mount the fixture to a piece of plywood so that it can be clamped to your workbench when needed.

Fig. 1

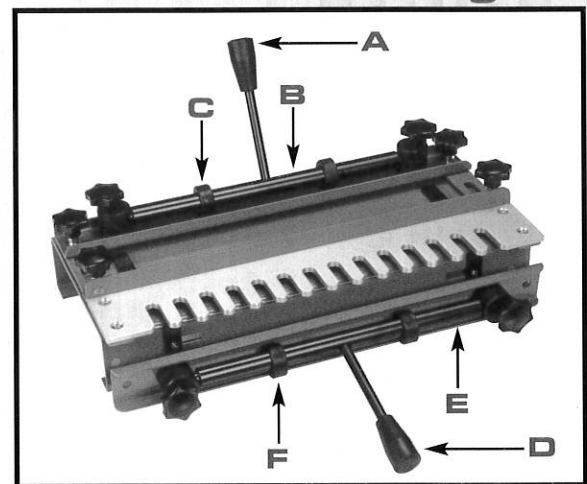
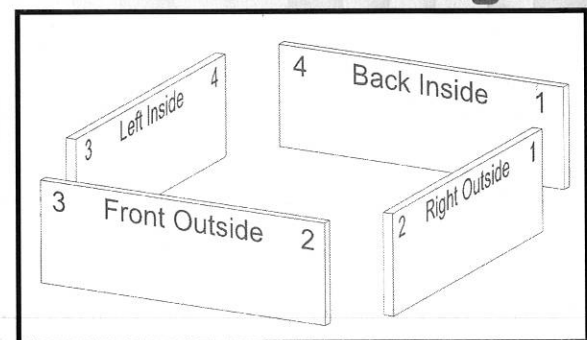


Fig. 2



OPERATION & SET-UP

The dovetail fixture comes with a 1/2" aluminum template. It should be used with a 1/2" dovetail router bit (1/4" shank, 14°), and a 7/16" guide bushing.

ALWAYS SET-UP AND PRACTICE ON A TEST PIECE

1. Lay out the work pieces and mark according to the finished position, illustrated in (Fig.2).
2. Slide the workpiece marked "Front" or "Back" (Fig.3, A) under the top clamping assembly when handle is in the up position. The side marked inside should face up.

3. Adjust the clamping pressure knobs (C, Fig.3) until the bar is just over the workpiece. The workpiece should still move freely, hold the workpiece in place by pushing the handle (40-010) or knob (40-020) away from you. Excessive force should not be necessary to clamp the workpiece.
4. Set the horizontal stop (D, Fig.3) so that the edge of the workpiece lines up in the centre of one of the template fingers as illustrated in Fig.3.
5. To remove the template unscrew the (4) four screws that hold the template in position (F, Fig.3)
6. Remove the front clamping assembly by unscrewing the two knobs (G, Fig.3).
7. Mark the workpiece 1/2" from the edge for template finger width (H, Fig.4). Adjust the vertical stop against the square (I, Fig.4).
8. Re-install the template and front clamping assembly.
9. Slide the workpiece marked "side" under the front clamping assembly when the handle (40-010) or knob (40-020) is in the release position. The side marked "inside" should face out. Match up the numbers you marked.
10. Adjust the clamping pressure knobs so that the bar(40-010) is just over the workpiece. The workpiece should still move freely. Clamp the workpiece in the place by pushing the handle (40-010) or knob (40-020) down. Excessive force should not be necessary to clamp the workpiece.
11. Set the template back from the front edge of the workpiece by Apr. 1/8" as illustrated in (Fig.5).
12. Loosen the two knobs (Fig.5, A) to position the template. Measure from the two ends of the workpiece to the template to make sure the template is parallel to the front edge of the workpiece.
13. The fence (Fig.5, B) should be set from the template finger tip according to a simple equation found in Table 1. Loosen the two knobs (C, Fig.5) to position the fence.
14. Set the router bit so it is approximately 7/8" lower than the router base. See the recommended list on page 5.
15. Rout off the front edge of the workpiece following along the template fingers. Rout out the rest of the material.
16. Remove the workpieces and verify for fit.

Fig. 3

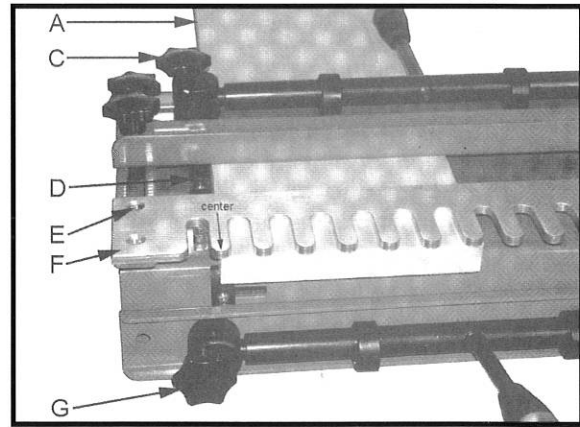


Fig. 4

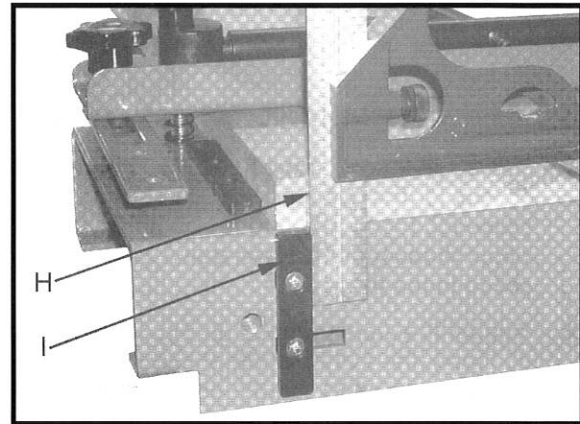


Fig. 5

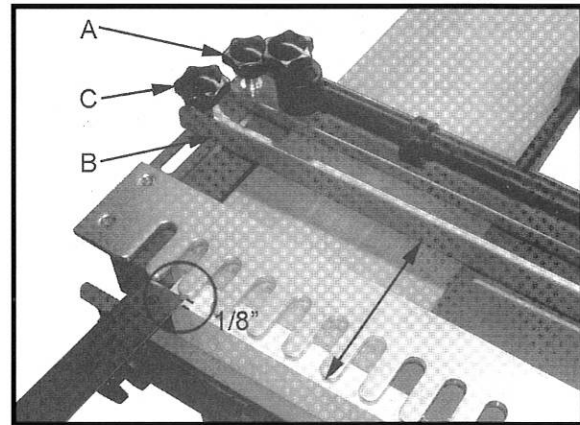


TABLE 1

EQUATION

Stock Thickness times two, plus Router Base Radius, Minus Bit Radius, equals distance from template finger to fence.

EXAMPLE

STOCK THICKNESS	ROUTER BASE RADIUS	ROUTER BIT RADIUS	DISTANCE FROM FENCE TO TEMPLATE FINGER
1/2" TIMES 2 = 1"	6" DIVIDED BY 2 = 3"	1/2" DIVIDED BY 2 = 1/4"	3 - 3/4"

FITTING & ADJUSTING

If the dovetail fit is too tight; decrease the router bit distance from router base slightly.

If the dovetail fit is too loose increase the router bit distance from the router base slightly.

If the pins on the side piece fit too deeply in the tails of the front or the back piece; then the cut is too deep. Move the fence forward the same amount the pins are exposed.

If the side piece sticks out from the front or the back piece; then the cut is too shallow. Move the fence back the same amount the sides stick out.

If the edges on the front and side piece do not match adjust the stop. The front stop must be offset from the top stop the width of the template finger at 1/2".

When you have the fixture properly adjusted, you can dovetail the actual drawer parts.

Note: Joints for the left front corner and the right rear corner of a drawer or a box are cut on the left side of the fixture. Joints for the right front corner and the left rear corner of a drawer or a box are cut on the right side of the fixture.

Note: The drawer sides should be cut to the finished height. They can be left longer and cut to the finished length later.

Note: Once the desired router bit height is established make a simple gauge block out of a hardwood to quickly get the correct setting in the future.

Note: once the stops are set properly and you have obtained the desired results use a scribe to mark the stop locations.

OPTIONAL ACCESSORIES

Optional accessories are available for your 40-010 12" and 40-020 24" Dovetail fixtures; all accessories all listed in the parts list and can be purchased through your authorized dealer. For information regarding the optional accessories please do not hesitate to communicate with General® International customer service department or your local dealer.

40-010	Dovetail Template Patron Pour Queue D'arondes	Router Bit {1/4" Shank} Mèche De Toupie {1/4" Collet}	Guide Bushing Bague	Depth of Cut Profondeur De Coupe
	5/16" (7.9MM)	1/4" (6.1) x 8°	5/16" (7.74)	5 MM
	7/16" (11.1) 1/2" (12.7) 9/16" (14.3)	1/2" (12.7) x 14°	3/8" (9.5)	12.4 MM
	7/16" 1/2" 9/16"	1/2" (12.7) x 14°	7/16" (11.1)	6.4 MM
	1/2" 9/16"	5/8" (14.4) x 14°	12 MM	9.6 MM
	1/2" 9/16"	5/8" (14.4) x 14°	1/2" (12.7)	12.4 MM

40-020	Dovetail Template Patron Pour Queue D'arondes	Router Bit {1/4" Shank} Mèche De Toupie {1/4" Collet}	Guide Bushing Bague	Depth of Cut Profondeur De Coupe
	1/4" (6.35MM)	1/4" (6.1) x 8°	5/16" (7.74)	5 MM
	1/2" (12.7)	1/2" (12.7) x 14°	3/8" (9.5)	12.4 MM
	1/2" (12.7)	1/2" (12.7) x 14°	7/16" (11.1)	6.4 MM
	1/2" (12.7)	5/8" (14.4) x 14°	12 MM	9.6 MM
	1/2" (12.7)	5/8" (14.4) x 14°	1/2" (12.7)	12.4 MM
	Box Joints Queues Droites	Straight Bit {1/4" Shank} Mèche Droite	Guide Bushing Bague	Cut Deep Profondeur De Coupe
	1/4" (6.35mm)	1/4"	5/16"	Exact Thickness of The Stock Epaisseur exacte de la pièce
	3/8" (9.5mm)	3/8"	1/2"	
	1/2" (12.7mm)	1/2"	5/8"	

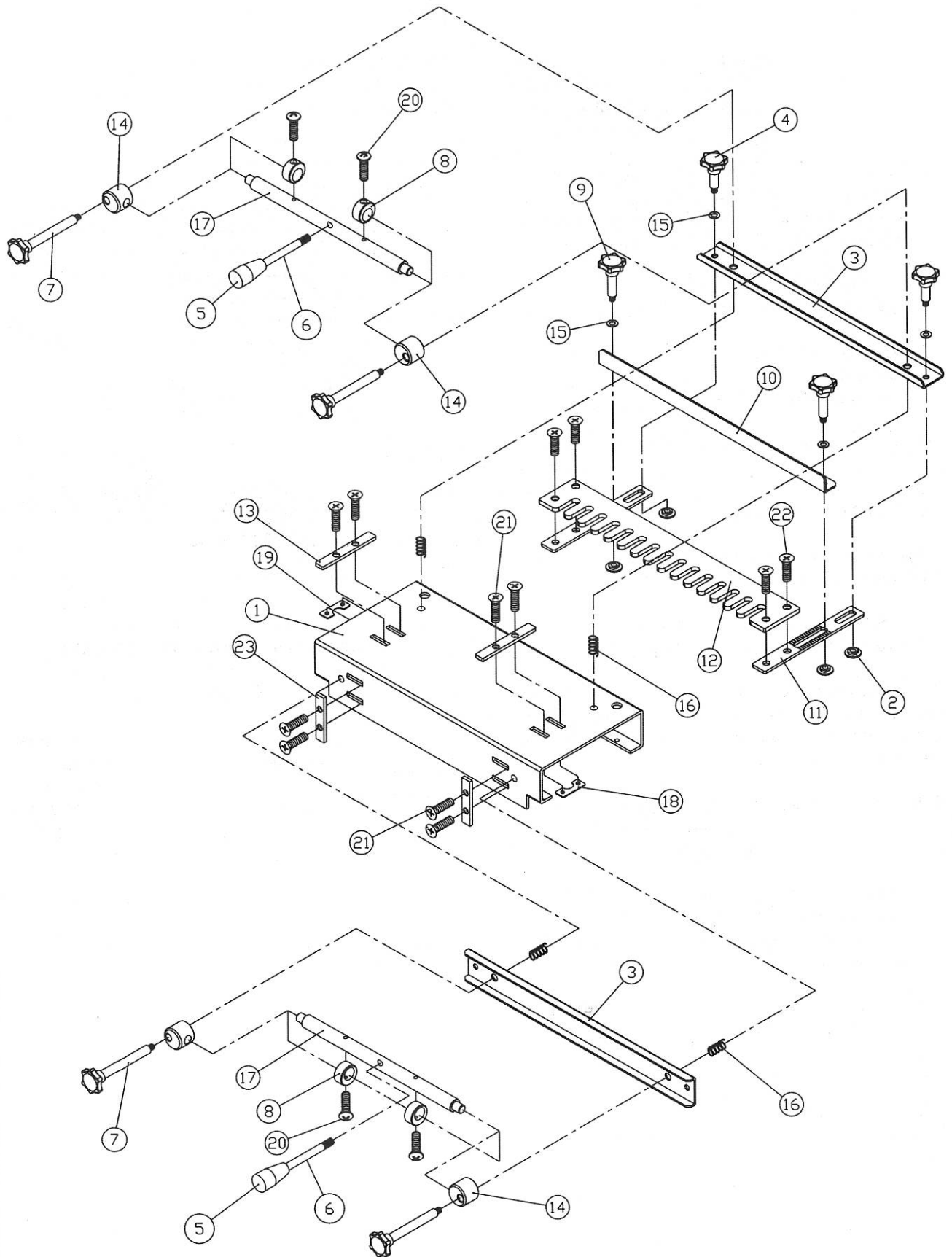
**PARTS LIST
40-010**

PART NO.	DESCRIPTION	SPECIFICATION	QTY
40010-01	BASE		1
40010-02	THREADED BUSHING		4
40010-03	BRACKET		2
40010-04	KNOB (SHORT)		2
40010-05	KNOB		2
40010-06	HANDLE		2
40010-07	KNOB		4
40010-08	ECCENTRIC WHEEL		4
40010-09	KNOB (LONG)		2
40010-10	FENCE		1
40010-11	BRACKET		2
40010-12	1/2" ALUMINUM TEMPLATE		1
40010-13	STOPS (LONG)		2
40010-14	SUPPORT		4
40010-15	FLAT WASHER		4
40010-16	SPRING		4
40010-17	ROD		2
40010-18	THREADED BRACKET (RIGHT)		2
40010-19	THREADED BRACKET (LEFT)		2
40010-20	PAN PHILLIPS MACHINE SCREW	10-24 x 3/8"	4
40010-21	FLAT PHILLIPS MACHINE SCREW	10-24 x 5/8"	8
40010-22	FLAT PHILLIPS MACHINE SCREW	1/4"-20 X 3/8"	4
40010-23	STOPS (SHORTS)		2

OPTIONAL ACCESSORIES

	ITEM#	DESCRIPTION
ALUMINUM DOVETAIL TEMPLATE	40-012	5/16" Aluminum Dovetail Template
	40-014	7/16" Aluminum Dovetail Template
	40-016	1/2" Aluminum Dovetail Template
	40-018	9/16" Aluminum Dovetail Template
BAKELITE DOVETAIL TEMPLATE	40-015	7/16" Bakelite Dovetail Template
	40-017	1/2" Bakelite Dovetail Template
	40-019	9/16" Bakelite Dovetail Template

NOTES

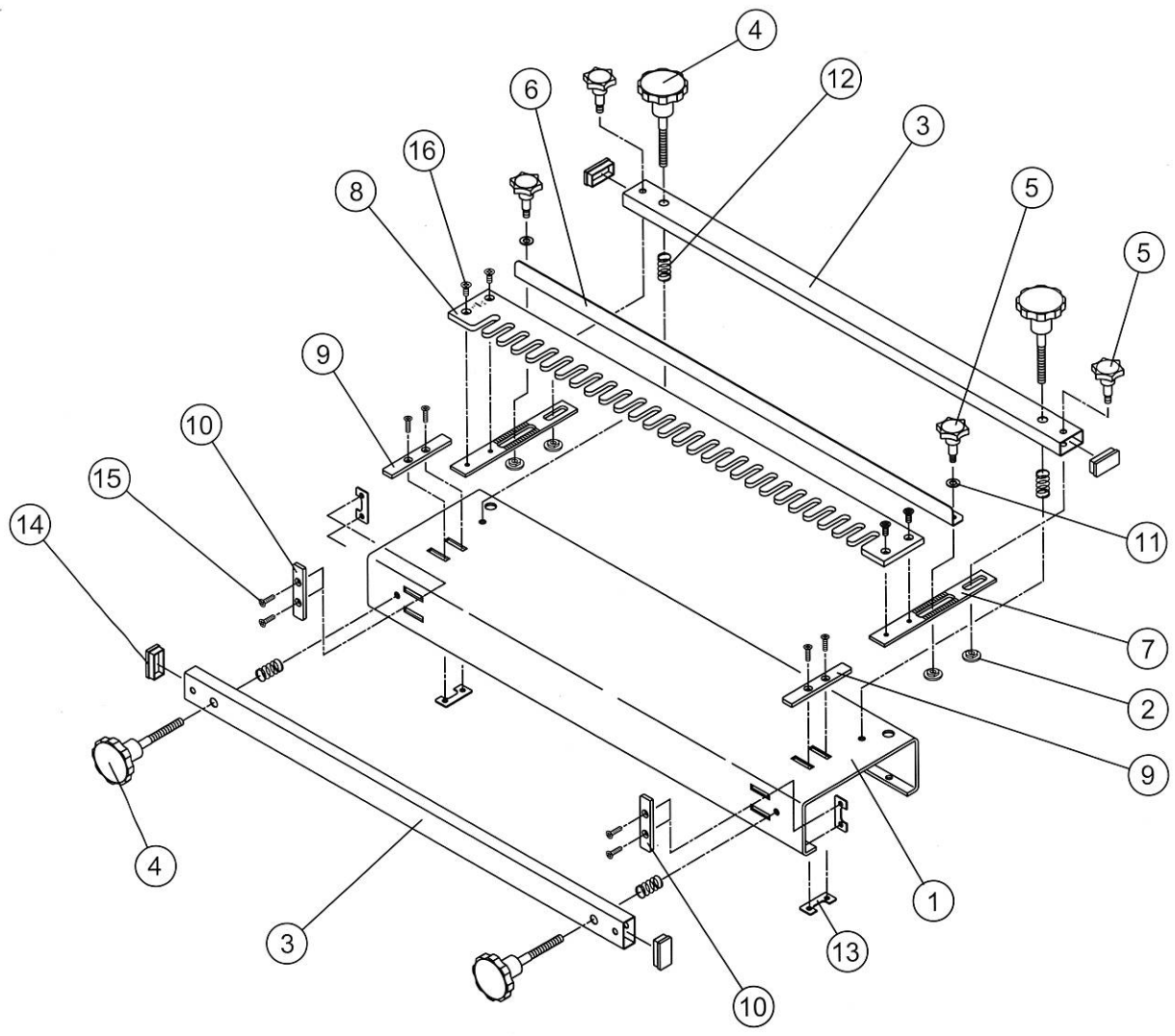


**PARTS LIST
40-020**

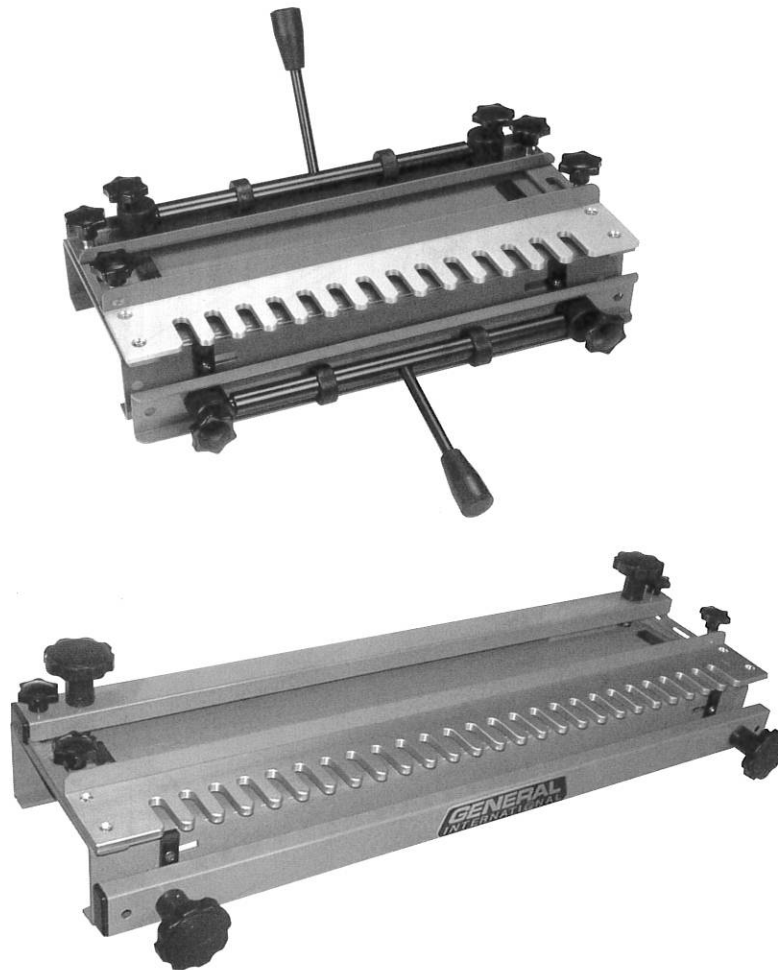
PART NO.	DESCRIPTION	QTY	
40020-01	BASE	1	
40020-02	THREADED BUSHIN	4	
40020-03	CLAMP BRACKET	2	
40020-04	CLAMP KNOB	4	
40020-05	KNOB	4	
40020-06	FENCE	1	
40020-07	BRACKET	2	
40020-08	1/2" HALF BLIND DOVETAIL	1	
40020-09	STOPS (LONG)	2	
40020-10	STOPS (SHORTS)	2	
40020-11	FLAT WASHER	2	
40020-12	SPRING	4	
40020-13	THREADED BRACKET	4	
40020-14	CAP	4	
40020-15	FLAT PHILLIPS MACHINE SCREW	10-24*5/8"	8
40020-16	FLAT PHILLIPS MACHINE SCREW	1/4"-20*3/8"	4

OPTIONAL ACCESSORIES	
ITEM#	DESCRIPTION
40-021	1/4" Half-blind template
40-022	1/2" Half-blind template
40-026	1/4" Box joint template
40-027	3/8" Box joint template
40-028	1/2" Box joint template

NOTES



40-010 / 40-020



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IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.