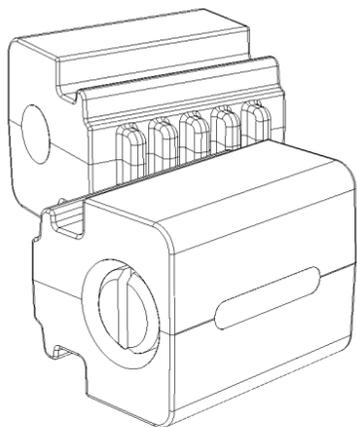


AKEDA®
INDEX STRIP ADJUSTER
Fits Imperial and Metric
C-Series Jigs

**INSTRUCTIONS
FOR INSTALLATION
AND OPERATION**



AKEDA P/N 3460

PREPARING TO INSTALL THE INDEX STRIP ADJUSTER

On some jigs the Index Strip is kinked to hold it in place with friction. This installation is relatively easy.

On other jigs the Index Strip is crimped in place at the L.H. end of the jig. This installation requires special care and attention. Follow the step-by-step instructions carefully.

You'll need a pair of needle nose pliers, a small screwdriver and needle files.

1. Prepare the Adjuster Blocks

The Index Strip Adjuster consists of two joined pairs of Blocks, each pair connected by a "bridge". One of each pair is a "four-tab" Adjuster Block for North American Imperial jigs with 1/8" pitch Index Strips. The other is a "five-tab" Adjuster Block for Metric jigs with 2.5mm pitch Index Strips.

Break apart both pairs of Adjusters. Remove the "bridge" that remains connected to one of the Blocks by bending it to and fro' with the pliers. Discard the "bridge" and file off any flash remaining on the Adjuster Blocks.

Select either the 5-tab metric pair, or the 4-tab imperial pair, and set the others aside in case you need them in the future.

2. Remove the Rear Guide Rail

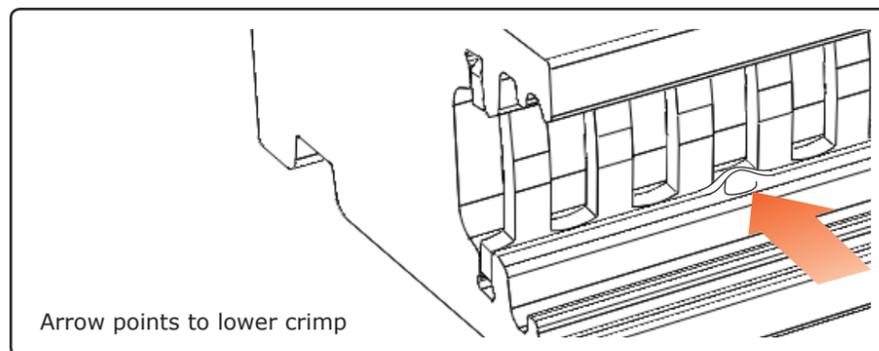
Remove all the guide fingers from the jig. Remove the two rear guide rail mounting screws and lift the guide rail out of the jig.

3. How To Free A Kinked Index Strip

If the Index Strip is held in place with a "kink", it will slide easily. DO NOT REMOVE THE INDEX STRIP FROM ITS CHANNEL. Slide it to the left so you can get at the kink, and carefully straighten out it out.

4. How To Free A Crimped Index Strip

Freeing a crimped Index Strip requires a little skill and patience.



Arrow points to lower crimp

Use a round needle file from the front, and a flat needle file from the end to carefully file away the crimp material. Use short strokes, and be careful not to damage the section of the guide rail where the guide fingers are installed.

When you've removed most of the lower and upper crimps, try tapping the Index Strip to the right hand end with a small block of hardwood, or try pulling it with needle nosed pliers from the right. Once past the crimp, it will slide easily. DO NOT REMOVE THE INDEX STRIP FROM ITS CHANNEL.

If it won't slide easily, file away more of the crimp material. Use a flat needle file from the front and end to remove the rest of the crimp material. Make sure you remove the material that was formed over into the Index Strip channel. Use a small brush to clear out all the aluminum filings.

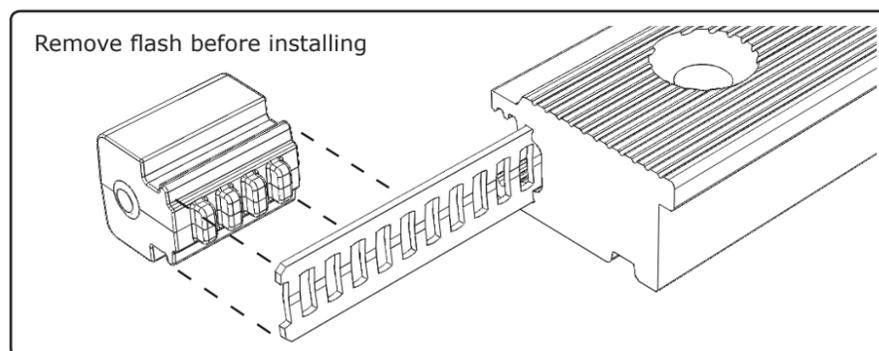
We successfully tested this procedure on a well-crimped guide rail, and it took less than five minutes from start to finish.

5. In Case You Removed The Index Strip From Its Channel

The index strip MUST ALWAYS be installed with the convex side facing outward to match the curve of the slot in the guide rail.

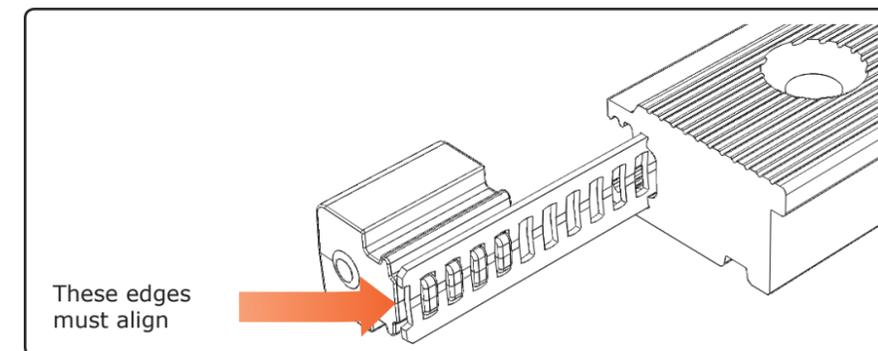
6. Installing the Index Strip Adjusters

Select the correct pair of Adjusters, and back off the set-screws so the tips are below flush.



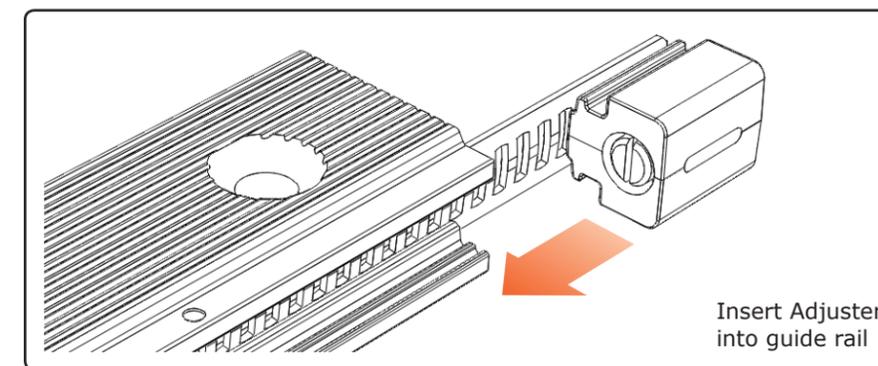
Remove flash before installing

Insert one Adjuster into the right hand end of the Index Strip so the end of the index strip lines up with the edge of the Adjuster and all the tabs are fully engaged. If there's any flash around the tabs preventing them from engaging the slots in the Index Strip, carefully remove it with a needle file. If the fit is a little tight, that's OK - it will minimize backlash. But make sure both adjusters seat fully down on the Index Strip.



These edges must align

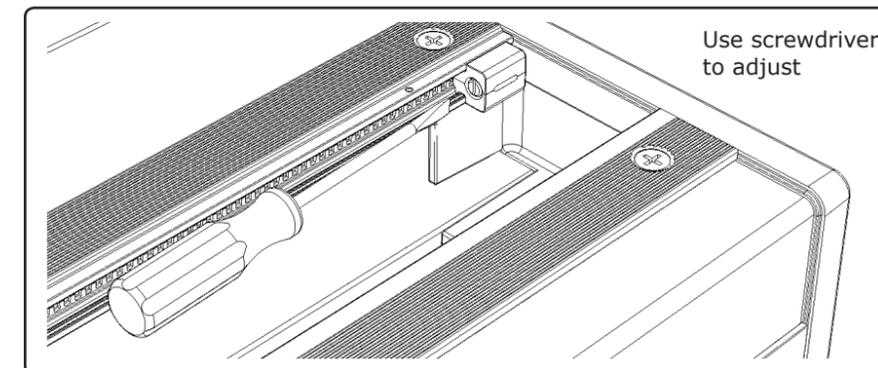
Holding the Adjuster in place, carefully push the Index Strip back into the guide rail until the Index Strip and Adjuster are fully inside the guide rail. The Adjuster needs to be accurately aligned, so work it from side to side until it slides in. Push on the Adjuster until the index strip protrudes a couple of inches at the opposite end.



Insert Adjuster into guide rail

Install the second Adjuster in the same way. This Adjuster must also be flush with the left hand end of the Index Strip. Slide the Index Strip and second Adjuster back in the guide rail.

Reinstall the guide rail in the jig. When doing this, ALWAYS tighten the left hand guide rail screw first.



Use screwdriver to adjust

Make sure the left hand Adjuster set-screw is fully backed off. Turn the right hand Index Strip Adjuster screw clockwise to "shunt" the Index Strip left and back to the "normal" position. IMPORTANT! Use the screws simply to take up

slack and gently shunt the Index Strip left or right. Over-tightening either screw will cause damage.

Now check the gap between the Adjuster and the right hand end plate when the Index Strip is in the "normal" position. If the Adjusters are correctly installed, the left hand Adjuster will be resting against the left hand end plate with the set-screw backed off, and the gap at the right hand end will measure 1/8".

THE "NORMAL" POSITION FOR THE INDEX STRIP

The Index Strip is preset at the factory flush left. This is the "normal" position. In this position the Index Strip slots are centered, relative to the side fences in the jig, to within a few thousandths of an inch. It means a guide finger will align with the dimple in the guide rail. It also means you'll get the same size half pin at both ends of the jig. This position suits work pieces with 1/8" width increments, regardless of which end of the jig you work from.

USING THE INDEX STRIP ADJUSTER

ALWAYS remove the guide fingers before attempting to adjust the Index Strip. The friction between the guide fingers and the guide rail prevent any movement, so if the guide fingers are left in place, you will damage the Index Strip slots or the guide finger tabs.

ALWAYS back off the opposite screw first to avoid "compressing" the Index Strip and causing damage.

NEVER over-tighten the set-screws. Use the set-screws to "shunt" the Index Strip to and fro'. Once you have completed an adjustment by shunting with one screw, take up the slack with the screw in the opposite Adjuster.

One full turn of the M5 screw will move the Index Strip 1/32" (.031") or 0.8mm, so four full turns will move the index strip one full increment of pitch, 1/8".

Position the Index Strip by measurement or by eye. Clamp an accurately prepared work piece in the jig, and use a pair of tail guides as gauges to find the position of the Index Strip relative to your work piece.

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U.S. Patent No. 6,032,706
Other US, Canadian, and international patents awarded
Printed in Taiwan R.O.C.
Index Strip Adjuster Instruction Sheet P/N 81113

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