Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference. 23h

WARRIOR™

DOVETAIL JIG



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Email our technical support at: productsupport@harborfreight.com

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When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-888-866-5797 as soon as possible.

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Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein.
Tools required for assembly and service may not be included.

⚠WARNING

**Read this material before using this product.
Failure to do so can result in serious injury.
SAVE THIS MANUAL.**

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WARRIOR™

IMPORTANT SAFETY INFORMATION

General Safety Warnings and Precautions

1. KEEP WORK AREA CLEAN AND DRY. Cluttered, damp, or wet work areas invite injuries.
2. KEEP CHILDREN AWAY FROM WORK AREA. Do not allow children to handle this product.
3. STORE IDLE EQUIPMENT. When not in use, tools and equipment should be stored in a dry location to inhibit rust. Always lock up tools and equipment, and keep out of reach of children.
4. DO NOT USE THIS PRODUCT IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS. Read warning labels on prescriptions to determine if your judgement or reflexes are impaired while taking drugs. If there is any doubt, do not attempt to use this product.
5. USE EYE AND BREATHING PROTECTION. Wear ANSI approved safety impact eye goggles and an ANSI approved dust mask or respirator when using this product. ANSI approved safety impact eye goggles, dust masks, and respirators are available from Harbor Freight Tools.
6. DRESS SAFELY. Do not wear loose clothing or jewelry, as they can become caught in moving parts. Wear a protective hair covering to prevent long hair from becoming caught in moving parts. If wearing a long-sleeve shirt, roll sleeves up above elbows.
7. DO NOT OVERREACH. Keep proper footing and balance at all times to prevent tripping, falling, back injury, etcetera.
8. INDUSTRIAL APPLICATIONS MUST FOLLOW OSHA REQUIREMENT.
9. STAY ALERT. Watch what you are doing at all times. Use common sense. Do not use this product when you are tired or distracted from the job at hand.
10. CHECK FOR DAMAGED PARTS. Before using this product, carefully check that it will operate properly and perform its intended function. Check for damaged parts and any other conditions that may affect the operation of this product. Replace or repair damaged or worn parts immediately.
11. MAINTAIN THIS PRODUCT WITH CARE. Keep this product clean and dry for better and safer performance.
12. USE THE RIGHT TOOL FOR THE JOB. Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. There are certain applications for which this tool was designed. It will do the job better and more safely at the rate for which it was intended. Do not modify this tool, and do not use this tool for a purpose for which it was not intended.
13. WARNING: The warnings, precautions, and instructions discussed in this manual cannot cover all possible conditions and situations that may occur. The operator must understand that common sense and caution are factors, which cannot be built into this product, but must be supplied by the operator.

Specific Product Warnings and Precautions

1. USE THE PROPER DOVETAIL BIT FOR YOUR ROUTER. For use only with Ø1/4" shank, Ø1/2" x 14° dovetail bits (sold separately). Do not use a bit larger than recommended, or damage to the Template will result.
2. MAINTAIN A SAFE WORKING ENVIRONMENT. Keep the work area well lit. Make sure there is adequate surrounding workspace. Always keep the work area free of obstructions, grease, oil, trash, and other debris.

SAVE THESE INSTRUCTIONS.

Specifications

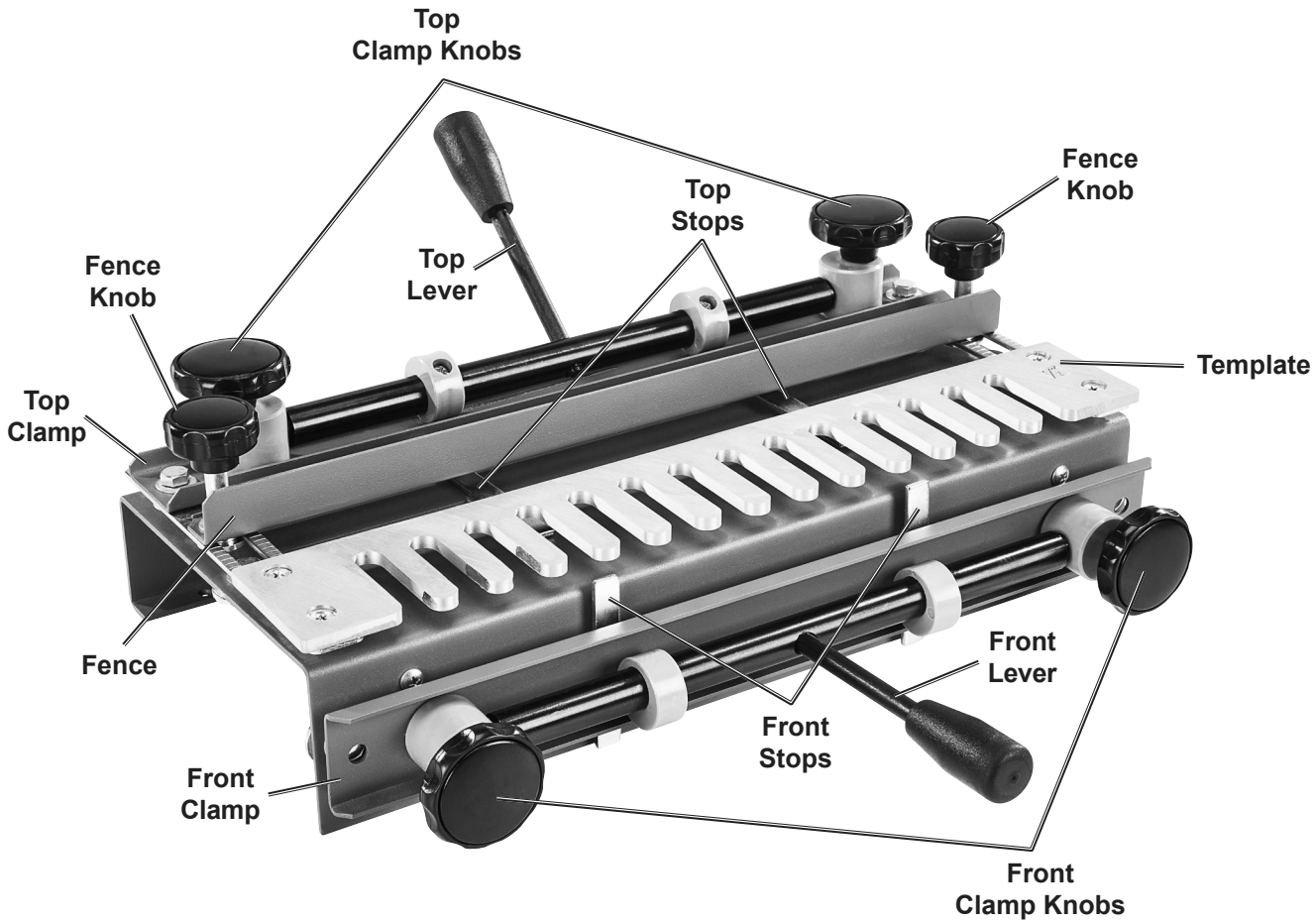
Dovetail Jig Style	1/2" Half-Blind Joints
Workpiece Capacity	1-1/4" Thick and 10" Wide
Router Requirements	1/4" Collet, 7" max Base, 7/16" Template Guide (sold separately)
Router Dovetail Bit	Ø1/4" Shank, Ø1/2" x 14° (sold separately)

Setup - Before Use:

Read the ENTIRE IMPORTANT SAFETY INFORMATION section at the beginning of this document including all text under subheadings therein before set up or use of this product.

Note: For additional information regarding the parts listed in the following pages, refer to the Assembly Diagram near the end of this manual.

Functions



Template - Pattern for cutting dovetails

Fence - Router guide

Fence Knobs - Hold Fence in place

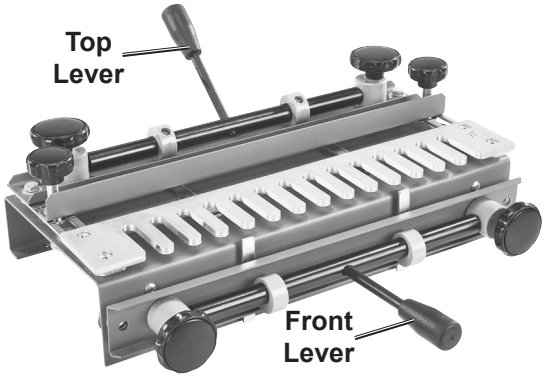
Levers - Hold workpieces in place

Clamp Knobs - Adjust Clamp pressure

Stops - Align workpieces to Template

Assembly

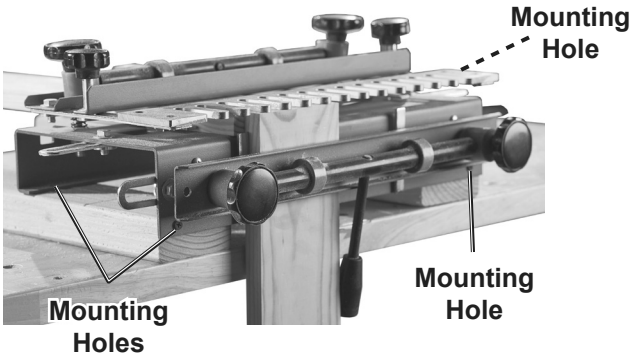
Thread Levers into Rods.



Mounting

CAUTION! TO PREVENT INJURY OR PROPERTY DAMAGE: Mount the Jig on a flat, level, sturdy, surface capable of supporting the weight of Jig, workpieces, and tools.

1. Position Jig on front edge of mounting surface.
2. Using Jig as a template, mark and drill four holes in mounting surface. Secure Jig with appropriate hardware (not included).



Preparing Workpieces

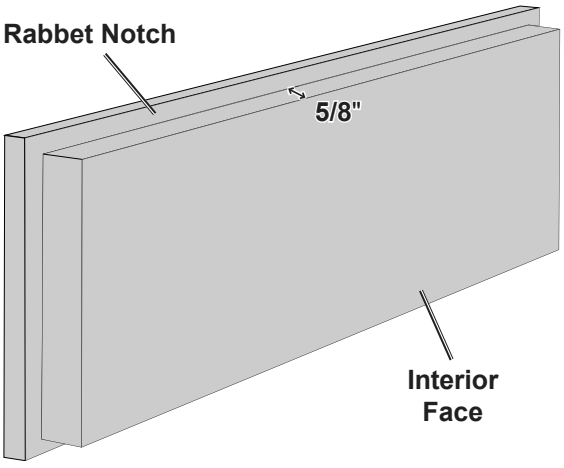
Note: Prepare two identical sets of workpieces. Use scrap material for one set for test cutting.

1. Cut front and back workpieces minimum 5/8" thick and 1" increments wide.
2. Cut Side workpieces minimum 3/8" thick and 1" increments wide.

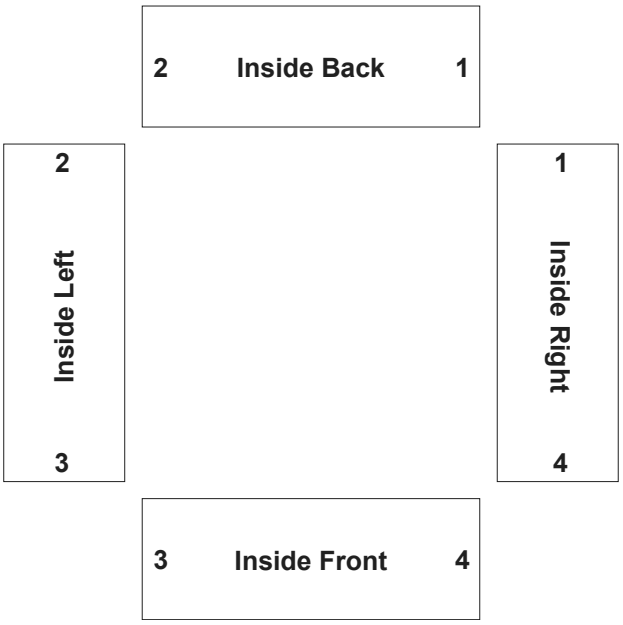
Note: Difference in thickness between front, back and sides must be 1/4" or less.

3. Verify all workpiece edges are flat, even and square.

Note: If using rabbeted front, interior face must be minimum 5/8" thick.

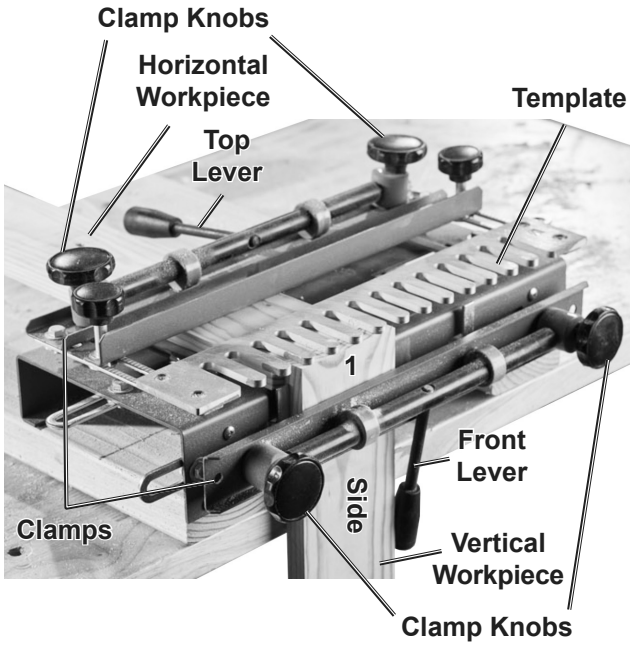


4. Mark inside of workpieces with names and numbers.



Setting Clamp Pressure

1. Open Levers (shown closed).
2. Loosen Clamp Knobs.
3. With markings facing out, mount side workpiece vertically, flush against Template. Tighten Clamp Knobs until Clamp just touches workpiece.
4. Close Front Lever.
5. With markings facing out and matching number next to vertical workpiece, mount front or back workpiece horizontally under Template and flush against vertical workpiece. Tighten Clamp Knobs until Clamp just touches workpiece.
6. Close Top Lever.
7. Check workpieces and Template for flexing or raising. Adjust Clamp Knobs as necessary until workpieces are flat.



Adjusting Stops

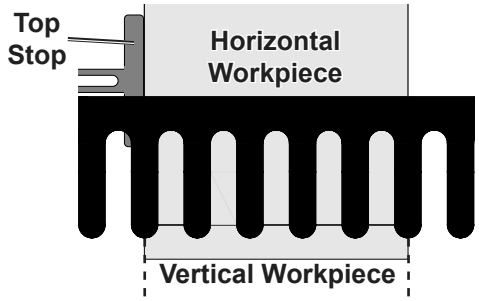
Note: These instructions are for processing one set of joints. Two sets may be processed using all four Stops, if combined width of workpieces is less than 10".

Standard Front and Back

1. Loosen Top Stop Bolt with 12mm wrench (sold separately).



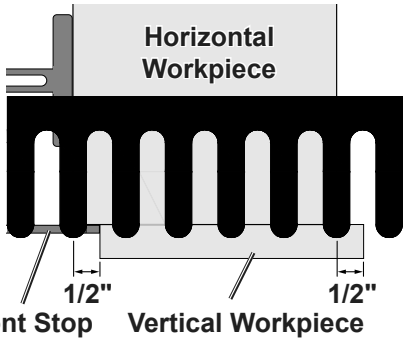
2. Open Top Lever and center horizontal (front/back) workpiece under Template fingers and flush against vertical workpiece.
3. Close Top Lever.
4. Slide Top Stop against workpiece and tighten Stop Bolt; do not overtighten.



5. Loosen Front Stop Bolt.



6. Measure 1/2" to right from right edge of horizontal workpiece and mark rear edge of template. Open Front Lever and align right edge of vertical (side) workpiece to mark on template, keeping it flush to Template and horizontal workpiece.
7. Close Front Lever.
8. Slide Front Stop against workpiece and tighten Stop Bolt; do not overtighten.



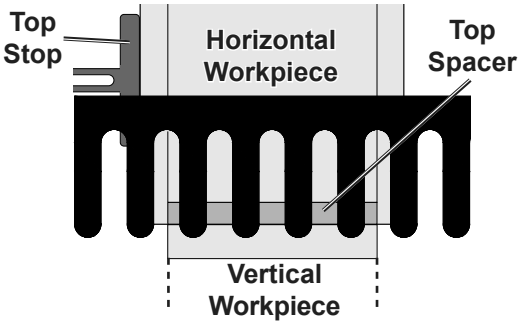
9. Verify vertical workpiece is flush against horizontal workpiece and Template.

Rabbeted Front and Standard Back

1. Loosen Top Stop Bolt.



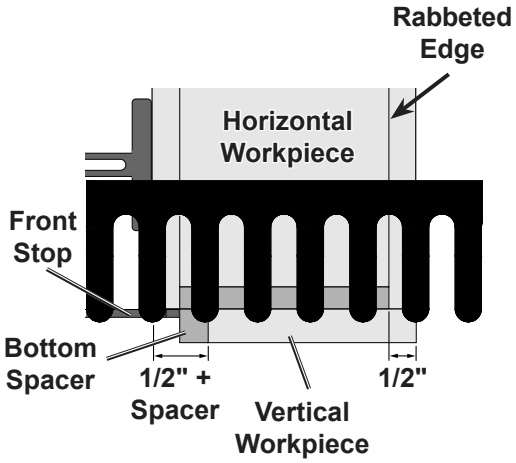
2. Open Top Lever and center horizontal (front/back) workpiece under Template and flush against vertical workpiece.
3. Close Top Lever.
4. Slide Top Stop against workpiece and tighten Stop Bolt; do not overtighten.
5. Cut top spacer for horizontal workpiece the same width as side rabbet notch and insert behind vertical workpiece.



6. Loosen Front Stop Bolt.



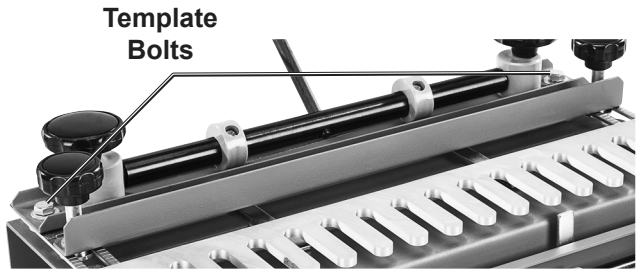
7. Cut bottom spacer for vertical workpiece the same width as top rabbet notch.
8. Measure 1/2" to right from right rabbeted edge of horizontal workpiece and mark rear edge of template.
9. Open Front Lever and insert bottom spacer between vertical (side) workpiece and Front Stop, keeping it flush to vertical workpiece.
10. Move spacer and vertical workpiece to the right, aligning edge to mark on template, keeping them flush to Template and horizontal workpiece.
11. Close Front Lever.
12. Slide Front Stop against bottom spacer and tighten Stop Bolt; do not overtighten.



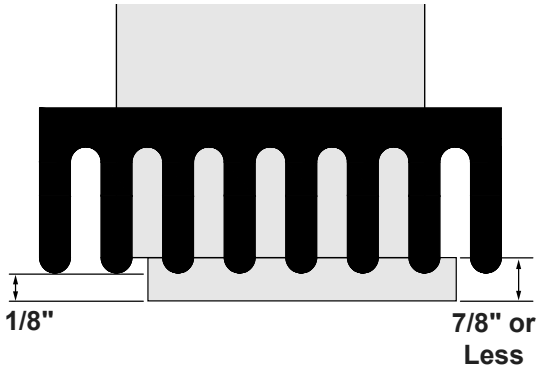
13. Verify vertical workpiece is flush against horizontal workpiece, top spacer, and Template.

Adjusting Template

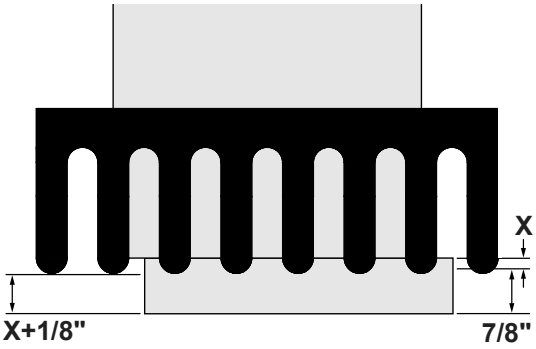
1. Slightly loosen Template Bolts with 12mm wrench.



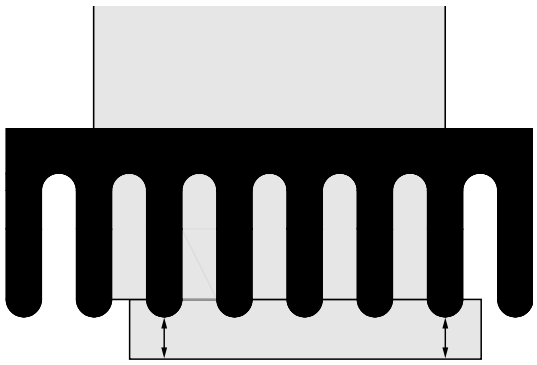
2. **Vertical workpiece less than or equal to 7/8" thick:** Slide Template so front edge is 1/8" back from workpiece edge.



3. **Vertical workpiece more than 7/8" thick:** Determine amount thickness exceeds 7/8" (**X**), and add 1/8". Set Template front edge back from vertical workpiece edge by that amount.



4. Measure at both ends of workpiece to verify Template is parallel to front edge of vertical workpiece.



5. Tighten Template Bolts , then reverify Template is parallel to front edge of vertical workpiece.

Setting Up Router

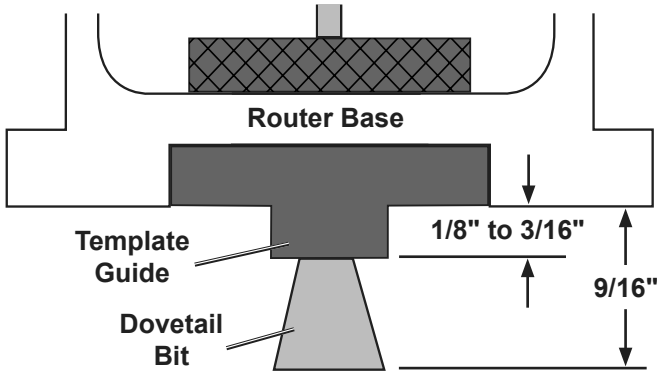
Note: Reference *Specifications* on page 3 for router base, dovetail bit and template guide requirements.

1. Refer to router manual's instructions for installing router bit and template guide.

CAUTION! TO PREVENT INJURY OR PROPERTY DAMAGE: DO NOT USE TEMPLATE GUIDE if it protrudes less than 1/8" or more than 3/16" below router base.

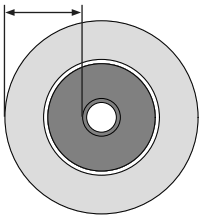
2. Using combination square (sold separately), adjust dovetail bit so it protrudes 9/16" below router base.

3. Confirm template guide and dovetail bit are secure.

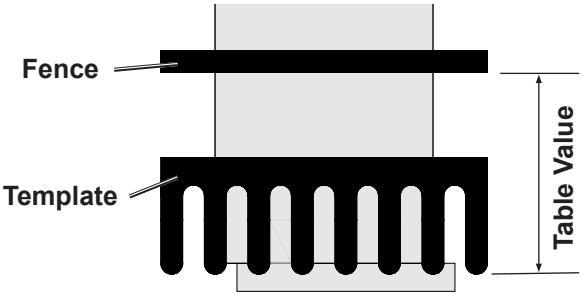


Adjusting Fence

1. Using a combination square measure distance from template guide edge to router base edge.



2. Measure vertical workpiece thickness. For rabbeted fronts, add top spacer width to workpiece thickness.
3. Look up value from *Fence Adjustment Table on page 8*.
4. Loosen Fence Knobs, set distance between Template front edge and Fence, then tighten Knobs.
5. Measure at both ends and verify Fence is parallel with Template front edge.



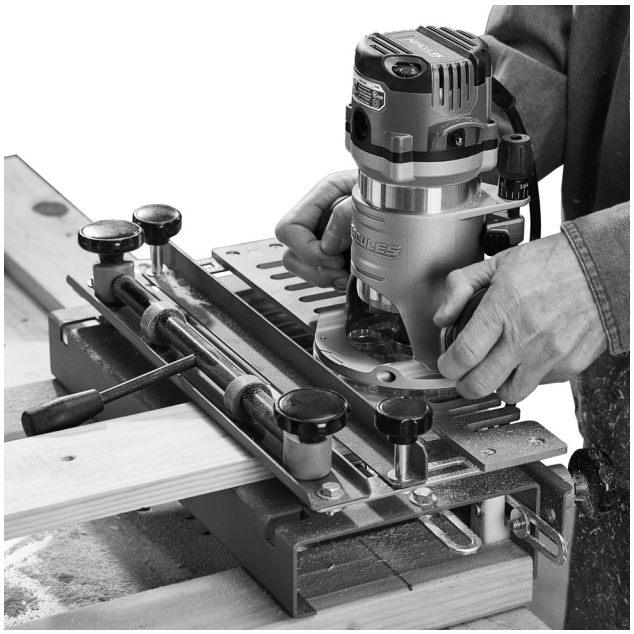
Fence Adjustment Table

Distance from Template Guide Edge to Router Base Edge in Inches	Vertical Workpiece Thickness in Inches												
	1/2	17/32	9/16	19/32	5/8	21/32	11/16	23/32	3/4	25/32	13/16	27/32	7/8
2	2-13/16	2-7/8	2-15/16	3	3-1/16	3-1/8	3-3/16	3-1/4	3-5/16	3-3/8	3-7/16	3-1/2	3-9/16
2-1/32	2-27/32	2-29/32	2-31/32	3-1/32	3-3/32	3-5/32	3-7/32	3-9/32	3-11/32	3-13/32	3-15/32	3-17/32	3-19/32
2-1/16	2-7/8	2-15/16	3	3-1/16	3-1/8	3-3/16	3-1/4	3-5/16	3-3/8	3-7/16	3-1/2	3-9/16	3-5/8
2-3/32	2-29/32	2-31/32	3-1/32	3-3/32	3-5/32	3-7/32	3-9/32	3-11/32	3-13/32	3-15/32	3-17/32	3-19/32	3-21/32
2-1/8	2-15/16	3	3-1/16	3-1/8	3-3/16	3-1/4	3-5/16	3-3/8	3-7/16	3-1/2	3-9/16	3-5/8	3-11/16
2-5/32	2-31/32	3-1/32	3-3/32	3-5/32	3-7/32	3-9/32	3-11/32	3-13/32	3-15/32	3-17/32	3-19/32	3-21/32	3-23/32
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3-3/32	3-29/32	3 -1/32	4-1/32	4-3/32	4-5/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32
3-1/8	3-15/16	4	4-1/16	4-1/8	4-3/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16
3-5/32	3-31/32	4-1/32	4-3/32	4-5/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32	4-23/32
3-3/16	4	4-1/16	4-1/8	4-3/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16	4-3/4
3-7/32	4-1/32	4-3/32	4-5/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32	4-23/32	4-25/32
3-1/4	4-1/16	4-1/8	4-3/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16	4-3/4	4-13/16
3-9/32	4-3/32	4-5/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4 -9/32	4-21/32	4-23/32	4-25/32	4-27/32
3-5/16	4-1/8	4-3/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16	4-3/4	4-13/16	4-7/8
3-11/32	4-5/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32	4-23/32	4-25/32	4-27/32	4-29/32
3-3/8	4-3/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16	4-3/4	4-3/16	4-7/8	4-15/16
3-13/32	4-7/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32	4-23/32	4-25/32	4-27/32	4-29/32	4-31/32
3-7/16	4-1/4	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4-11/16	4-3/4	4-13/16	4-7/8	4-15/16	5
3-15/32	4-9/32	4-11/32	4-13/32	4-15/32	4-17/32	4-19/32	4-21/32	4-23/32	4-25/32	4-27/32	4-29/32	4-31/32	5-1/32
3-1/2	4-5/16	4-3/8	4-7/16	4-1/2	4-9/16	4-5/8	4 -1/16	4-3/4	4-13/16	4-7/8	4-15/16	5	5-1/16

Operating Instructions

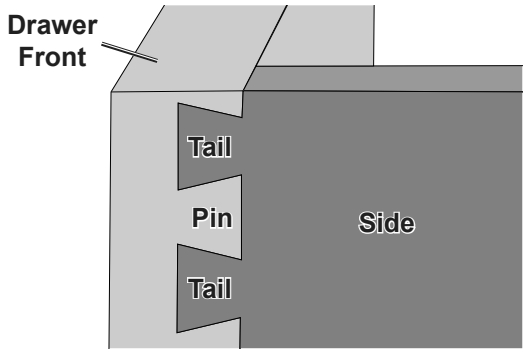
Read the ENTIRE IMPORTANT SAFETY INFORMATION section at the beginning of this manual including all text under subheadings therein before set up or use of this product.

1. Plug router into 120VAC grounded outlet.
2. Place router on Template; confirm router bit is not contacting workpieces.
3. Test cut on scrap workpieces and make adjustments according to *Troubleshooting* on page 10.
4. Turn on router; let it come up to speed.
5. Making multiple passes, remove material from in front of Template, then remove material inside Template fingers until router contacts Fence.

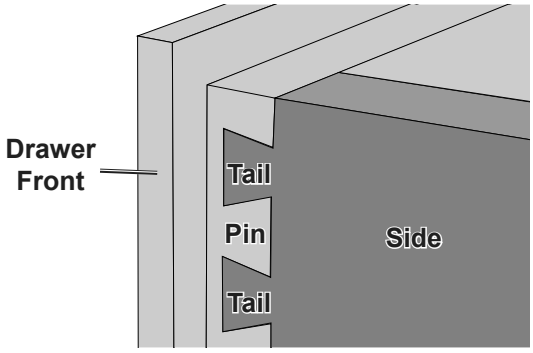


6. When finished, turn off and unplug router.
7. Sand off rough edges that may interfere with joint fit. A hammer and wood block may be required to assemble workpieces together.

Note: When assembled correctly, half-blind joints will be flush to each other on all outside surfaces.



Standard Front



Rabbet Front

8. Continue cutting and assembling vertical and horizontal workpieces until all cuts are finished.

Maintenance and Servicing

Procedures not specifically explained in this manual must be performed only by a qualified technician.

1. **BEFORE EACH USE,** inspect the general condition of the tool. Check for:
   - loose hardware,
   - misalignment or binding of moving parts,
   - cracked or broken parts,
   - any other condition that may affect its safe operation.
2. **AFTER USE,** wipe external surfaces of the tool with clean cloth.

Troubleshooting

Problem	Possible Causes	Likely Solutions
Rough edges/splintering/ tear outs when router bit exits workpiece.	1. Forcing tool to work too fast. 2. Cutting across grain of wood.	1. Allow tool to work at its own rate. 2. Scribe a line on vertical workpiece at same distance down router bit is cutting, or back up workpiece with a scrap piece, or slow router when exiting wood.
Pins on side piece fit too deep in tails of front/back piece.	Distance between edge of vertical workpiece and Fence is set too deep.	Adjust Fence forward by same amount that pins are exposed. See *Adjusting Fence on page 8*.
Pins on side piece protrudes from tails of front/back piece.	Distance between edge of vertical workpiece and Fence is set too narrow.	Adjust Fence back by same amount that tails protrude out. See *Adjusting Fence on page 8*.
Side and front/back piece edges are not aligned.	Stops are not set correctly.	Measure offset amount of workpieces and adjust Front Stops accordingly. Front Stops must be offset from top Stops by exact 1/2". Confirm front Stops remain square to horizontal workpiece.
Fit too tight/loose.	Depth of router bit needs adjustment.	**Fit to tight:** Lower bit slightly (1/64" - 1/32"). **Fit to loose:** Raise bit slightly (1/64" - 1/32").
Side workpiece fits excessively/protrudes at one edge and not the other.	1. Workpiece edges are not parallel with Template front edge. 2. Fence is not parallel with Template front edge. 3. Template is not parallel with workpiece edges.	1. Clamp workpieces parallel to each other and tight against Stops. 2. Adjust Fence parallel to front edge of Template fingers. 3. Adjust Template parallel to front edges of workpieces.

Follow all safety precautions whenever diagnosing or servicing the tool.

Record Product's Serial Number Here:_____

Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts. Reference UPC 193175485205.

PLEASE READ THE FOLLOWING CAREFULLY

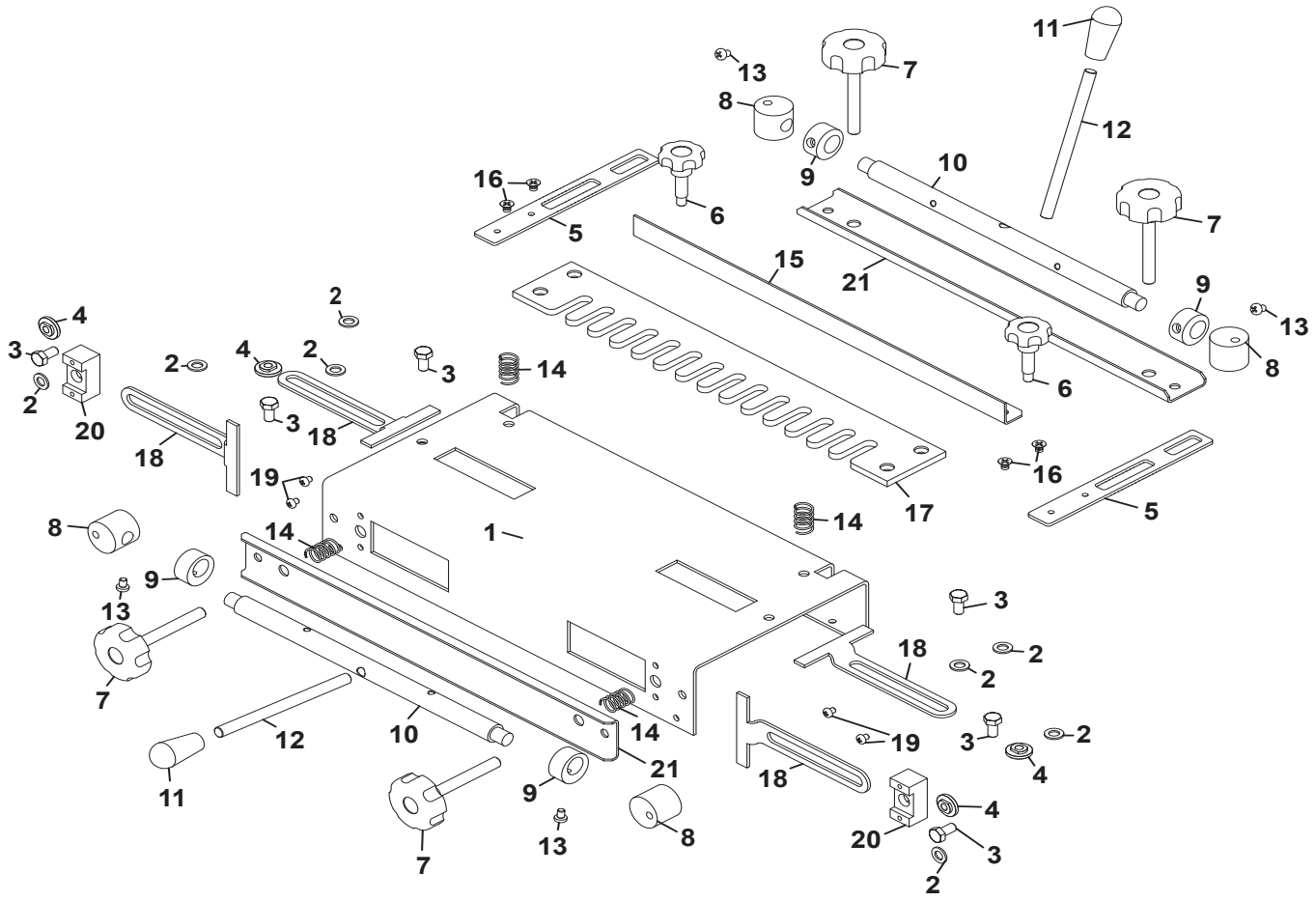
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Parts List

Part	Description	Qty
1	Base	1
2	Washer M8	8
3	Bolt M8x16	6
4	Nut M8	4
5	Side Brace	2
6	Fence Knob	2
7	Clamp Knob	4
8	Eccentric Bushing	4
9	Eccentric Cam	4
10	Rod	2
11	Lever Knob	2

Part	Description	Qty
12	Lever Rod	2
13	Set Screw M5x12	4
14	Spring	4
15	Fence	1
16	Screw M6x10	4
17	1/2" Template	1
18	Stop	4
19	Screw M5x16	4
20	Support	2
21	Clamp	2

Assembly Diagram



Limited 90 Day Warranty

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

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