

METRIC CONVERSION ADDENDUM

INCRA JIG FENCE POSITIONER

General

The Incra Jig Precision Fence Positioner shipped in this package is equipped with a Metric Scale and includes Metric Sawtoothed Positioning racks along with Metric Joinery Templates. While the manual and the instructional DVD still include references to the original imperial scaled version, the necessary conversions are really quite simple. For the most part, just multiplying the imperial scale reference (in inches) by 25.4 will give you the metric value (in mm) that you need to proceed.

In the Joinery Applications section of the manual and DVD, the following important changes need to be noted.

Box Joints (Metric Users Only)

The Box Joint Template provided will require a 10mm bit, rather than the 3/8" straight bit described in the owner's manual and DVD. (See the reverse side of this sheet for a correct joint diagram).

Centering

When setting the initial fence position for centering the Incra Jig as described on page 8 figs. 30 & 30A, set the Incra Jig to 75mm on the scale.

Dovetails (Metric Users Only)

The Dovetail Joint Template provided will still use a 12.7mm (1/2") - 14 degree dovetail bit, or for an increased depth of cut you can use the optional 12.7mm (1/2") - 10 degree dovetail bit. (See the reverse side of this sheet for a correct joint diagram).

Setting the Depth of Cut for Dovetails

It is important when making the test cuts for establishing the final depth of cut as described on page 7, fig 26 to make the required cuts at a spacing of 22mm apart.

Centering

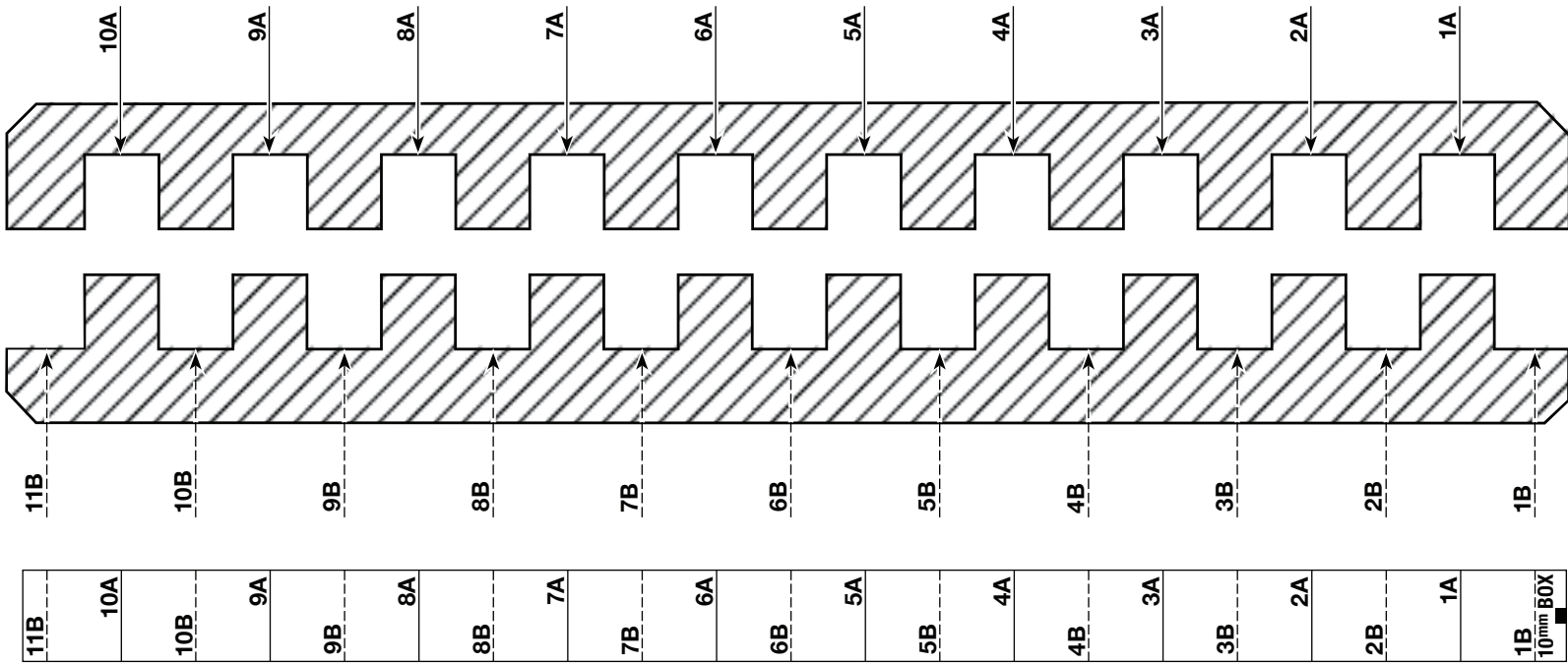
When setting the initial fence position for centering the Incra Jig as described on page 8 figs. 30 & 30A, set the Incra Jig to 75mm on the scale.

Cutting the Rabbets for Half Blind Dovetails

When cutting the rabbets for half blind or cornerpost dovetails, as described on page 9, figs. 35 & 35A, and on page 12 figs. 46 & 46A, begin with a light "scoring pass" of 1mm, followed by several subsequent passes of 1-2mm each until reaching a final rabbet width of 5mm.

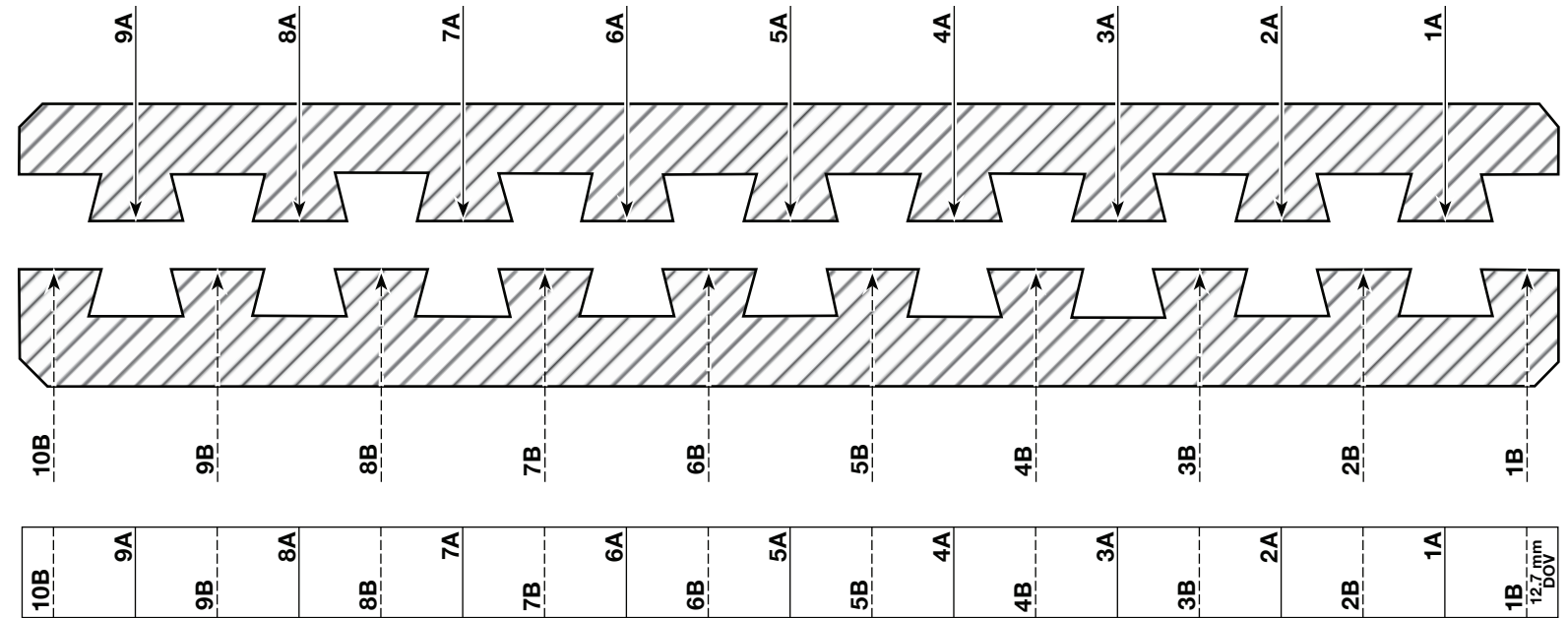
Metric Templates on Reverse

10mm Box Joint Template



SUGGESTED CENTER CUT: 6B

12.7mm (1/2") Dovetail Joint Template



SUGGESTED CENTER CUT: 5A
APPROX. RABBET WIDTH 5mm
SPACING TO SET DEPTH OF CUT: 22mm

Dovetail Depth of Cut Chart

		STOCK THICKNESS	
BIT TYPE	APPROX. DEPTH OF CUT	HALF BLIND	THROUGH
12.7mm 14° DOVETAIL	6.3mm	12.7mm	6.3mm
12.7mm 10° DOVETAIL	9.5mm	19.0mm	9.5mm