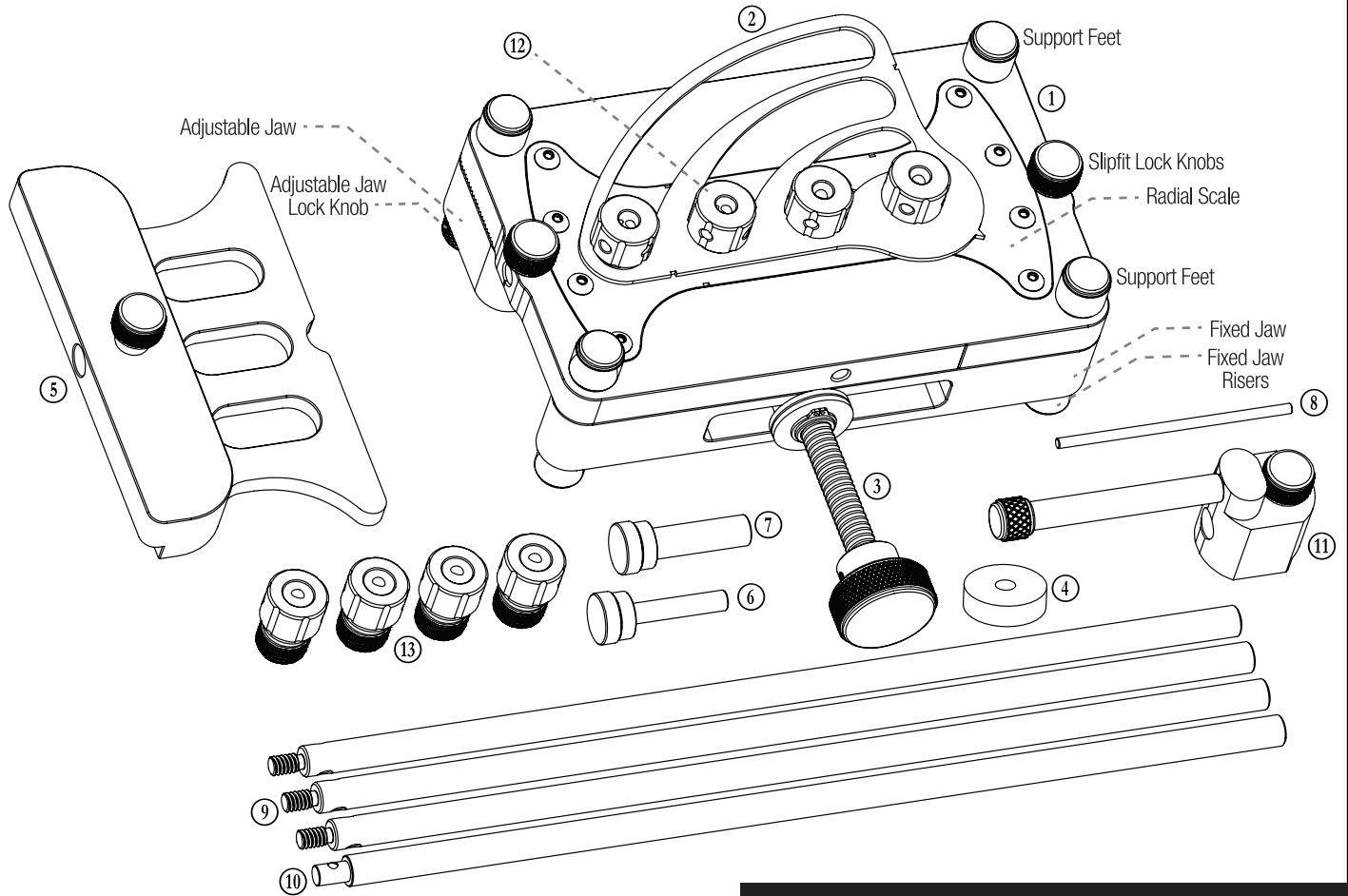


# Woodpeckers®

## ULTIMATE DOWELING JIG

### OWNER'S MANUAL



**NOTE:** there are slots in the foam in your case to add in the optional sized drill guides that are sold separately.

DIAGRAM NUMBER	(QTY) PART NAME
①	(1) Base Plate Assembly with Fixed Jaw, Adjustable Jaw & Jaw Nuts
②	(1) Cam Plate
③	(1) Clamp Assembly with Clamp Pad
④	(1) Clamping Cylinder
⑤	(1) Fence Assembly with Lock Knob
⑥	(1) Index Pin 1/4"
⑦	(1) Index Pin 3/8"
Sold Separately	(1) Index Pin 1/2"
	(1) Index Pin 5/16"
	(1) Index Pin 5mm

DIAGRAM NUMBER	(QTY) PART NAME
⑧	(1) Tommy Bar
⑨	(3) Threaded Extension Rod
⑩	(1) Slipfit Extension Rod
⑪	(1) Bar Stop Assembly with Pin and Lock Knob
⑫	(4) Drill Guides, 1/4"
Sold Separately	(4) Drill Guides 3/8"
	(4) Drill Guides 1/2"
	(4) Drill Guides 5/16"
	(4) Drill Guides 5mm



Scan the QR code above to watch the video or visit [woodpeck.com](http://woodpeck.com) under the video tab towards the bottom of the product page.

If you think you're missing anything, email us at [mailroom@woodpeck.com](mailto:mailroom@woodpeck.com). You can also call us at 800-752-0725 from 9:00 a.m. to 4:00 p.m. EST Monday - Friday.

## I. HOW TO REMOVE & INSTALL DRILL GUIDE BUSHINGS

1. Select which Drill Guide (1/4" ⑫ or 3/8" ⑬) you would like to use.
2. To remove the Drill Guides, insert the Tommy Bar ⑧ into the hole of the Drill Guide and use it as leverage to loosen and remove the installed Drill Guide.
3. Replace the removed Drill Guide with your desired Drill Guide.
4. Continue down the line of Drill Guides removing and replacing them one-at-a-time.
5. Snug up all (4) Drill Guides using the Tommy Bar.

## II. HOW TO SET THE SPACING OF THE DRILL GUIDES

1. Loosen the four installed Drill Guides to allow the Cam Plate ② to rotate and slide the Drill Guides along the top of the Base Plate ①.
2. Set desired work spacing of Drill Guides (from their centers) by rotating the Cam Plate. **FIGURE 1.**
3. Use the Radial Scale (on the top of the Base Plate **FIGURE 1-A**.) or the Base Scale (on the underside of the Base Plate **FIGURE 2-A**.) to determine the desired spacing.
4. Tighten the (4) Drill Guides with the Tommy Bar to lock in the Cam Plate position. *The consecutive in-line spacing range of the Drill Guides is 3/4" to 1-1/4".*

## III. SET THE ADJUSTABLE JAW FOR DIFFERENT STOCK THICKNESS WITH CENTERED OR OFFSET HOLES

1. The Adjustable Jaw is capable of 1/32" incremental adjustment by flipping or rotating it. To change the position of the Adjustable Jaw, first loosen and remove the two Adjustable Jaw Lock Knobs. Then, choose one of the four positions below.

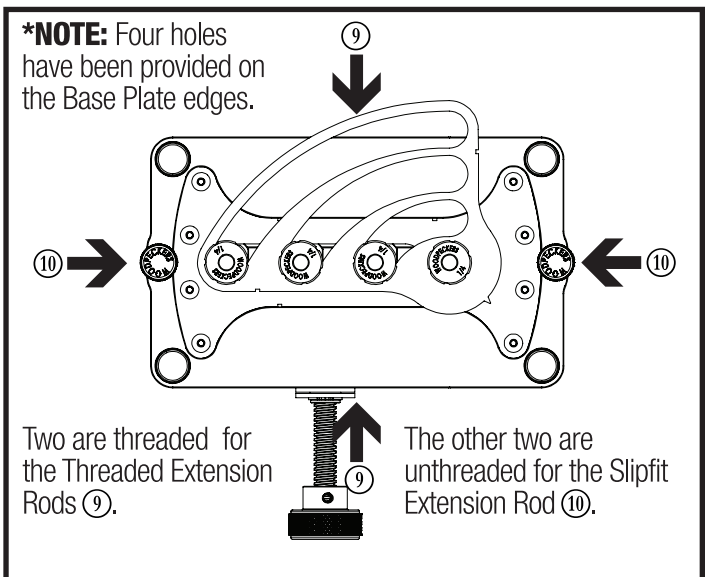
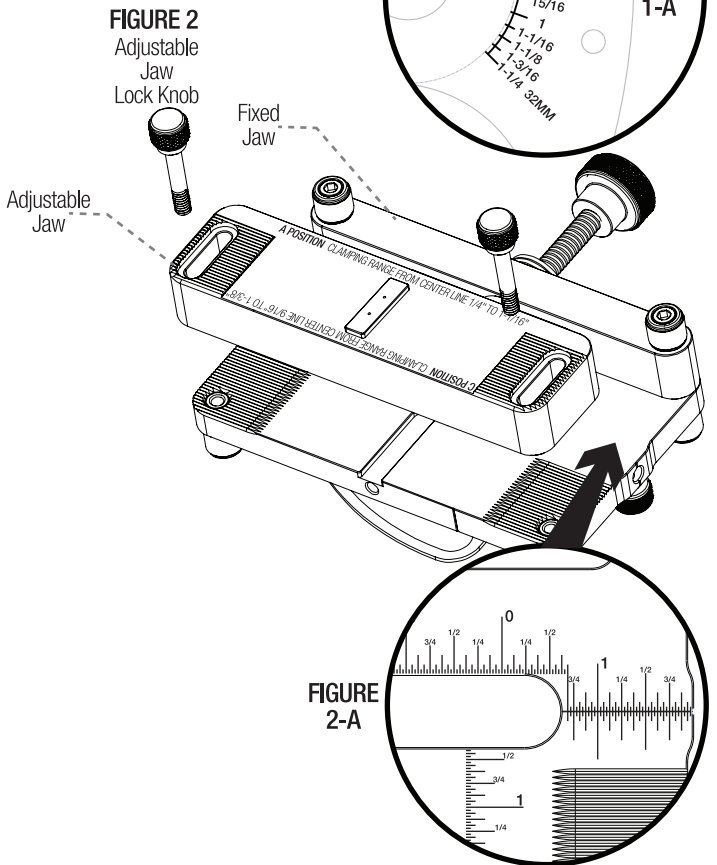
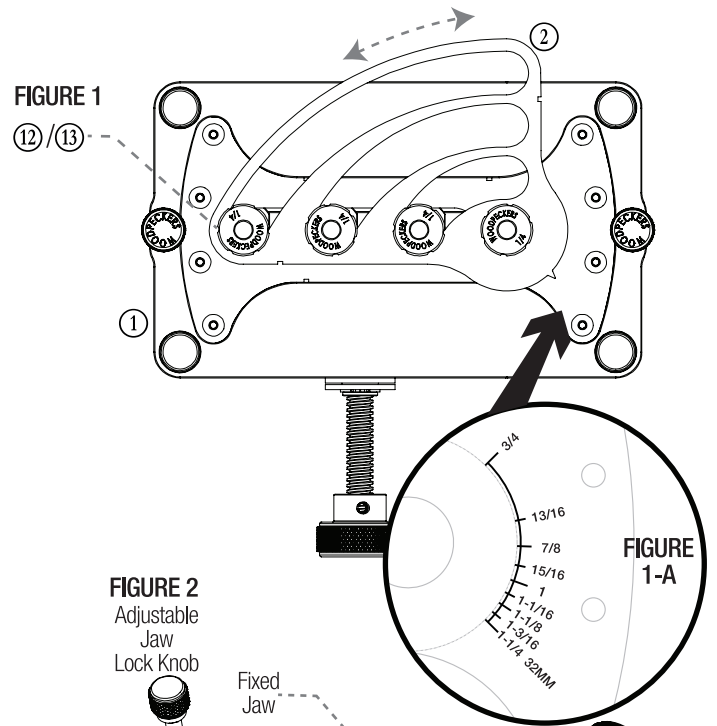
- **A POSITION** Clamping range from center line 1/4" to 1-1/16"
- **B POSITION** Clamping range from center line 7/32" to 1-1/32"
- **C POSITION** Clamping range from center line 9/16" to 1-3/8"
- **D POSITION** Clamping range from center line 19/32" to 1-13/32"

2. Set the Adjustable Jaw into the groove of the Base Plate at your desired location. *Make sure the Adjustable Jaw seats properly and doesn't have any dirt or wood chips interfering with the serrated grooves.* Tighten the Adjustable Jaw Lock Knobs firmly to secure the position of the Adjustable Jaw. **FIGURE 2.**

3. **Centered Holes** - To drill holes that are centered on the workpiece edge or end, take the stock thickness and set the Adjustable Jaw to half of that dimension from the center line of the Drill Guides. Do this by selecting the best side of Adjustable Jaw to center the workpiece on the Drill Guide centers.

4. **Offset Holes** - Offset holes can also be created by repositioning the Adjustable Jaw to offset the face of the workpiece to the distance desired for the hole locations.

5. The Ultimate Doweling Jig can clamp stock up to 2" thick with the



Fixed Jaw and Adjustable Jaw installed. The Clamp Pad that comes pre-installed with the Clamp Assembly (3) can be used to clamp stock that is at least 2" wide. To clamp stock less than 2" wide, remove the Clamp Pad and install the Clamping Cylinder (4) onto the Clamp Assembly. To swap the clamping fixtures, proceed as follows.

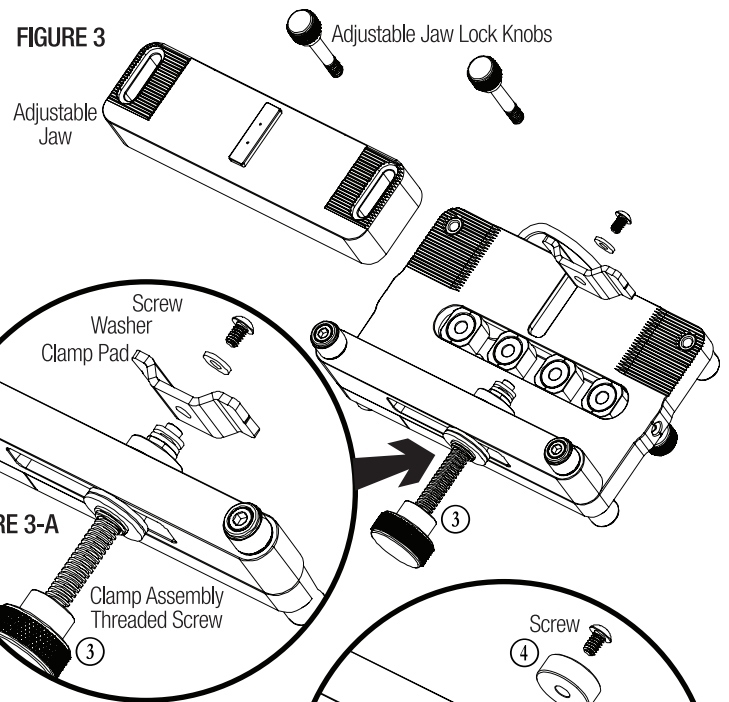
1. Remove the Adjustable Jaw Lock Knobs and remove the Adjustable Jaw. **FIGURE 3.**

2. Use an 1/8" Allen key (*not included*) to remove the Screw, Washer and Clamp Pad from the Clamp Assembly Threaded Screw. Set the Clamping Pad and Washer to the side.

3. Install the Clamping Cylinder onto the Clamp Assembly Threaded Screw with the countersunk hole facing outward. Secure the Clamping Cylinder by threading the Screw into the Clamp Assembly Threaded Screw and tighten it with an 1/8" Allen key. **FIGURE 3-B.**

4. To re-install the Clamping Pad, make sure to add the Washer between the Screw and the Clamp Pad.

**FIGURE 3-A.**



#### IV. EXTENSION ROD AND BAR STOP ASSEMBLY SETUP & USES

• The Bar Stop Assembly (11), Slipfit Extension Rod (10) and (3) Threaded Extension Rods (9) can be used together to create repeatable dowel locations for projects like face frames, or complete cabinet construction.

1. To install the Slipfit Extension Rod, loosen one of the two Slipfit Lock Knobs. Install the Slipfit Extension Rod so the indent on the end of the Slipfit Extension Rod aligns with the point of the screw on the Slipfit Lock Knob. **FIGURE 4.**

2. Tighten the Slipfit Lock Knob in place to secure the Slipfit Extension Rod.

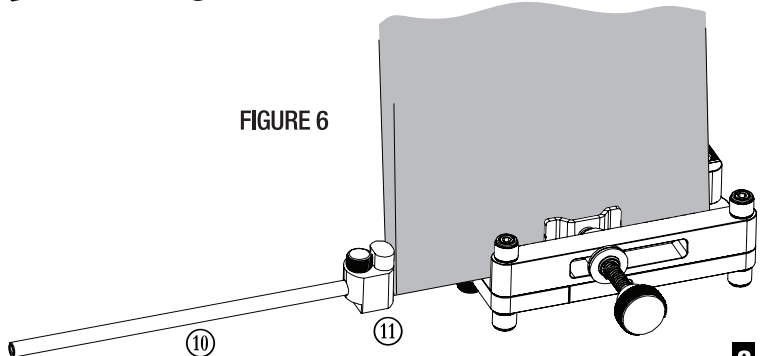
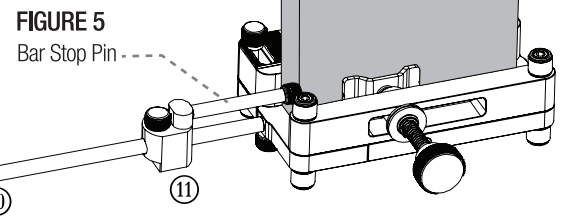
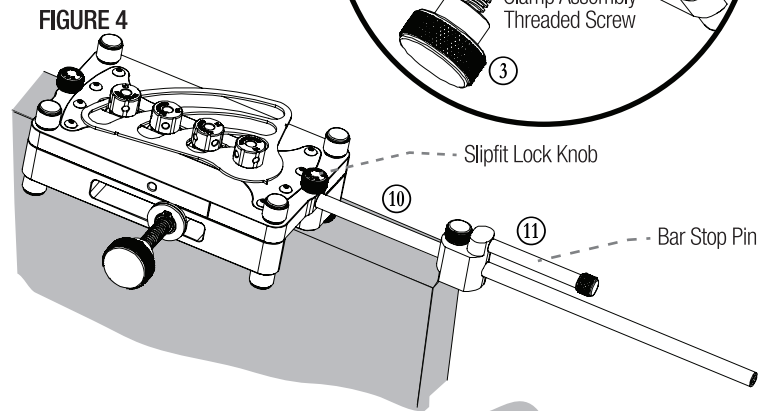
3. To extend even further, the (3) Threaded Extension Rods can thread together and into the end of the Slipfit Extension Rod for extension up to 48".

• The Bar Stop Assembly slides onto the Threaded Extension Rods or the Slipfit Extension Rod and can be used in three different positions.

1. **With the Bar Stop Pin** - which reaches over the Base Plate and can align with the Scales. **FIGURE 5.**

2. **Without the Bar Stop Pin** - using the flat of the Bar Stop against the workpiece. **FIGURE 6.**

3. Reversed to use the notched cut for flush support on the corner of a workpiece. The last position is used for face drilling and can be set on the edge of a large board or sheet material; this sets the distance and prevents the Extension Rods from sagging. **FIGURE 4.**



## V. EDGE GUIDE SET UP & USES

• **Dowel Joinery** - Using the Edge Guide (5), you can use dowel joinery on the face of wide stock and plywood. Remove the Adjustable Jaw, attach one or more Threaded Extension Rods to the Base Plate, then slide the Edge Guide onto the Threaded Extension Rod. Now you're set to use dowels to join parts that were virtually impossible before.

• **Repeatable Holes** - And the Edge Guide can also be used to drill a series of accurately spaced, repeatable holes in casework parts like bookshelf sides for shelf supports. This task is easily accomplished using the Index Pins (6) or (7). Just insert the Index Pin that corresponds with your Drill Guide and insert it into the first Drill Guide (1/4" (12) or 3/8" (13)) to index from the last hole drilled.

• **Edge Guide Positions** - There are two positions for the Edge Guide:

1. With the extended edge, which reaches under the Base Plate when the Fixed Jaw is removed. **FIGURE 7.**
2. Reversed to use the notched cut for flush support on the edge of the workpiece. *The second position prevents the Threaded Extension Rods from sagging.* Attach one or more of the Threaded Extension Rods into threaded holes at the ends or side of the Base Plate Assembly, **FIGURE 8.**

FIGURE 7

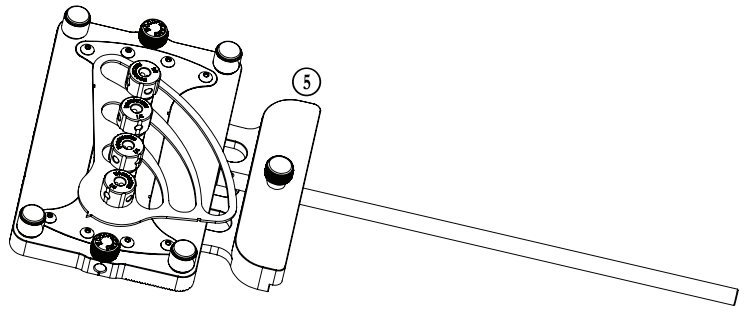
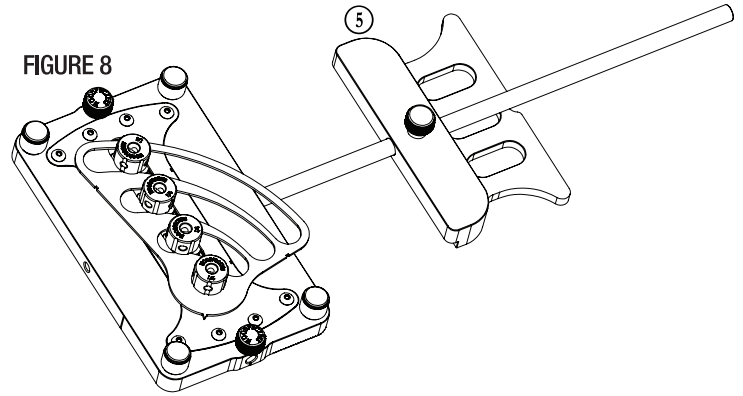


FIGURE 8



## VI. SET UP FOR FACE DRILLING & LINE BORING

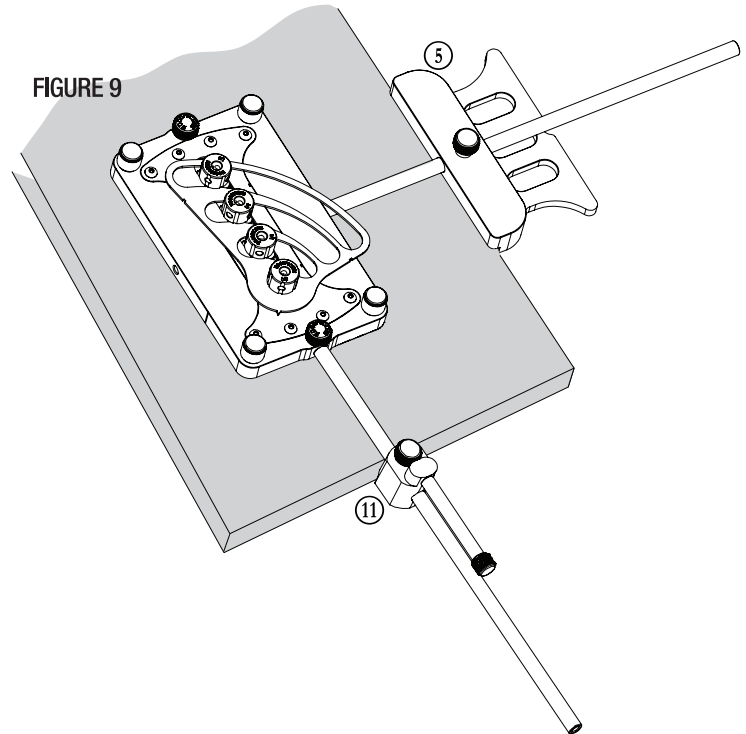
• **Setup for Face Drilling:**

1. Remove both the Adjustable and the Fixed Jaws.
2. Attach one or more of the Threaded Extension Rods into threaded holes at the ends or side of the Base Plate Assembly.
3. Slide the Edge Guide onto the Threaded Extension Rods and secure it at the desired distance from the workpiece edge.
4. Add the Threaded Extension Rod and the Bar Stop Assembly to either end of the jig for two-axis positioning. **FIGURE 9.**

• **Setup to Drill a Series of Accurately Spaced, In-line Repeatable Holes:**

1. Use the Edge Guide to drill a set of holes at a distance from the workpiece edge.
2. Insert the Index Pin in the first Drill Guide to index from the last hole drilled and drill next set of holes.
3. Continue drilling evenly spaced sets of holes as needed.

FIGURE 9



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