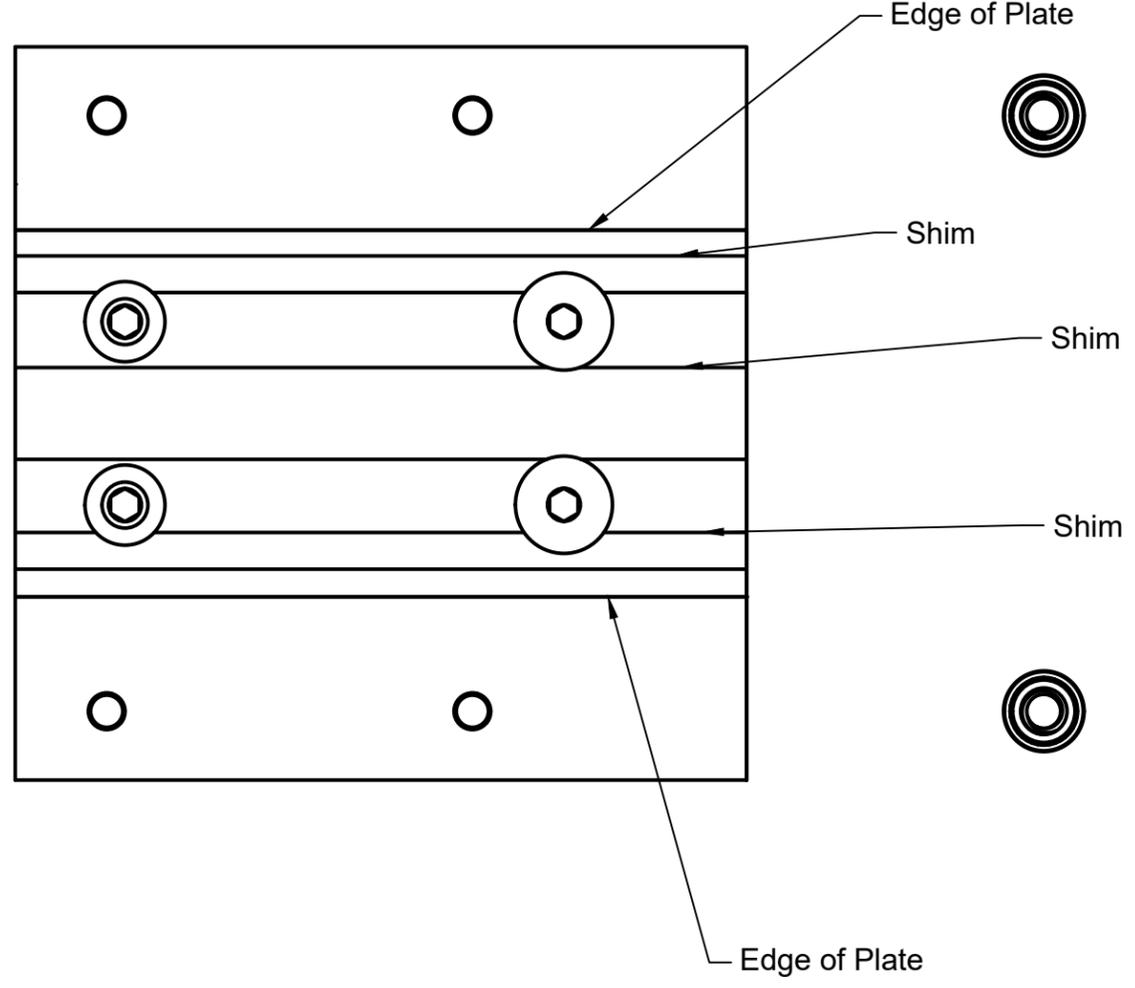
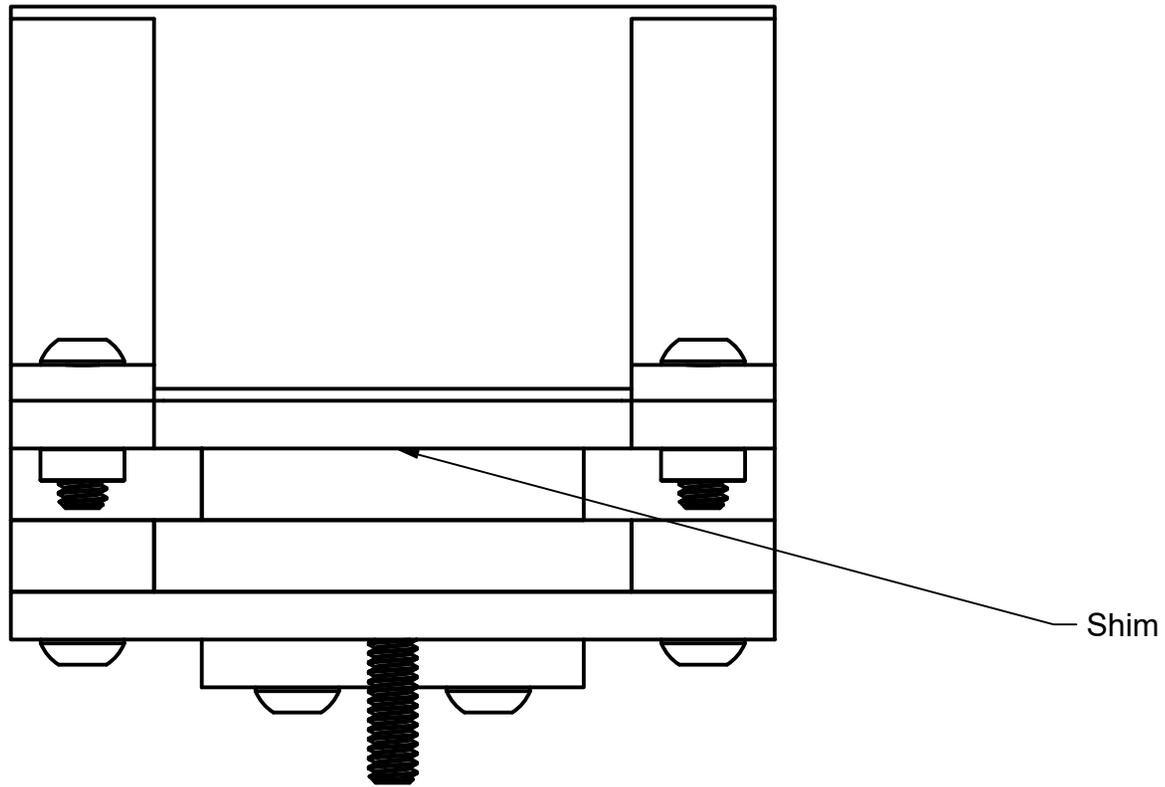


## Table of Contents

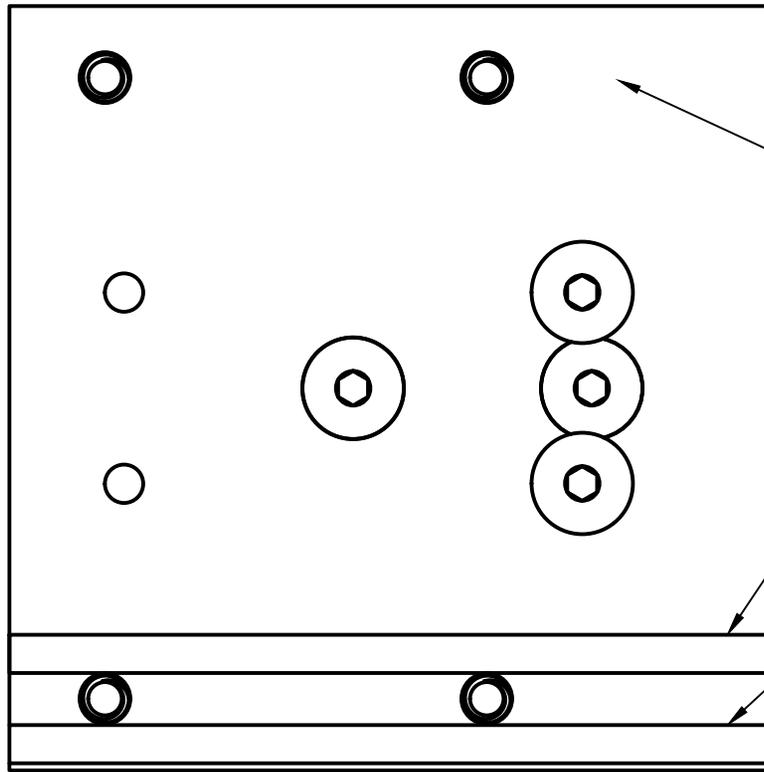
- 1) Notes
- 2) Parts List, Hardware List, Material List
- 3) Adjuster Assembly
- 4) Flat Plate Assembly
- 5) Multi Guide Pro Assembly
- 6) Slide Plate Assembly
- 7) Throat Assembly
- 8) Adjuster Fixed Angle Sht 1
- 9) Adjuster Fixed Angle Sht 2
- 10) Adjuster Slide Angle Sht 1
- 11) Adjuster Slide Angle Sht 2
- 12) Fixed Angle Sht 1
- 13) Fixed Angle Sht 2
- 14) Fixed Plate Lower Sht 1
- 15) Fixed Plate Lower Sht 2
- 16) Fixed Plate Lower Sht 3
- 17) Fixed Plate Lower Sht 4
- 18) Fixed Plate Middle Sht 1
- 19) Fixed Plate Middle Sht 2
- 20) Fixed Plate Upper Sht 1
- 21) Fixed Plate Upper sht 2
- 22) Slide Angle Sht 1
- 23) Slide Angle Sht 2
- 24) Slide Angle Spacer Sht 1
- 25) Slide Angle Spacer Sht 2
- 26) Slide Plate Lower Sht 1
- 27) Slide Plate Lower Sht 2
- 28) Slide Plate Middle Sht 1
- 29) Slide Plate Middle Sht 2
- 30) Slide Plate Upper Sht 1
- 31) Slide Plate Upper Sht 2
- 32) Slide Plate Upper Sht 3
- 33) Slide Plate Upper Sht 4
- 34) Contact Information



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		Multi guide Pro		
		TITLE		
		Shim Page 3		
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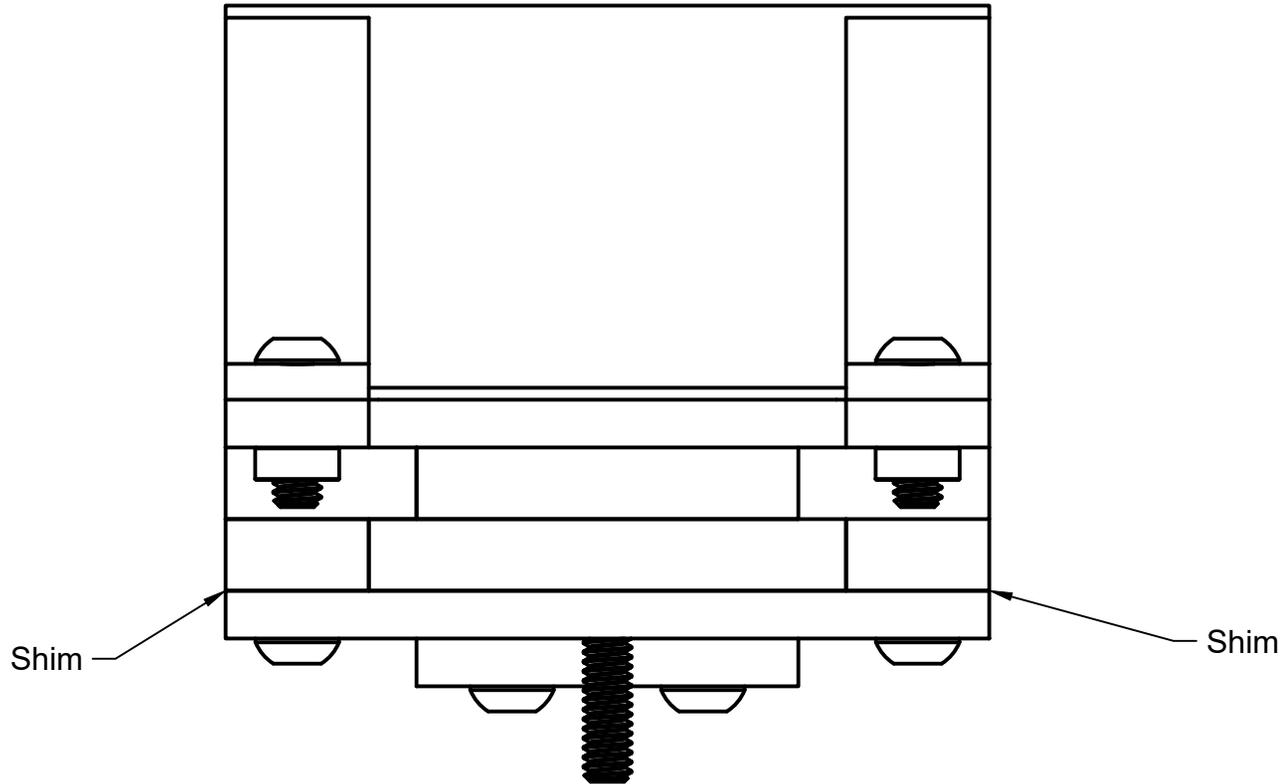


Repeat shim installation on this side same as side shown below

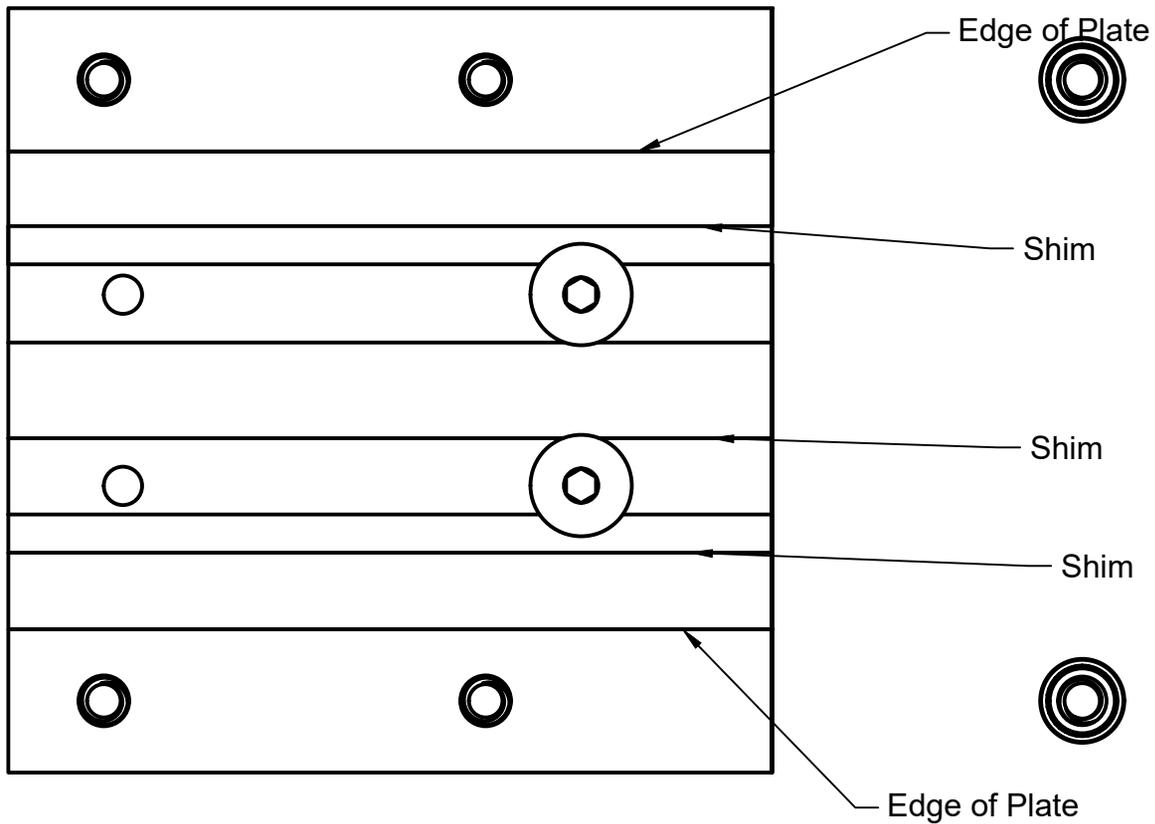
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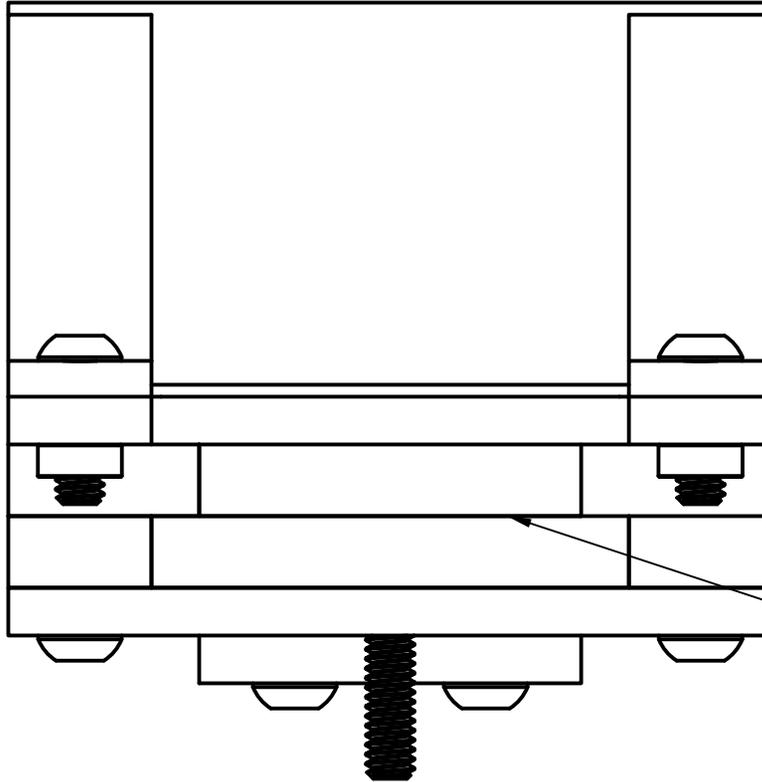
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		Multi Guide Pro		
		TITLE		
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Install shim material between these two plates

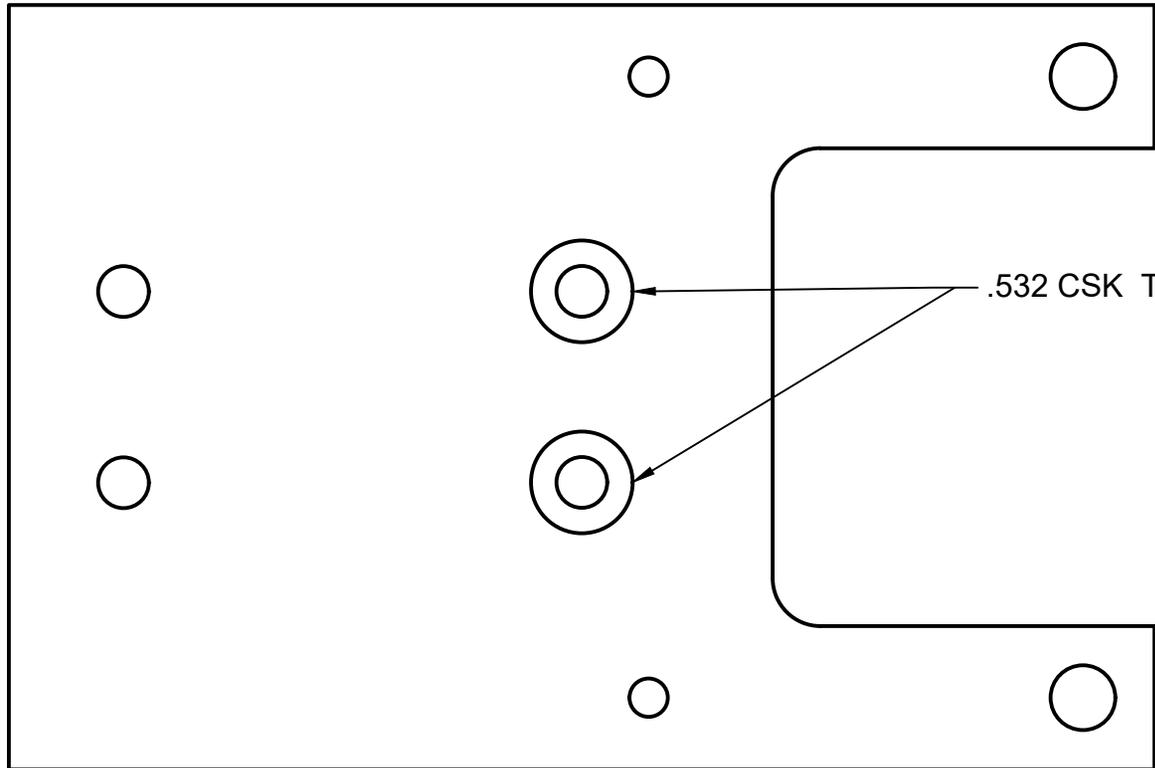
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Contact information

[www.belnapcustomknives.com](http://www.belnapcustomknives.com)

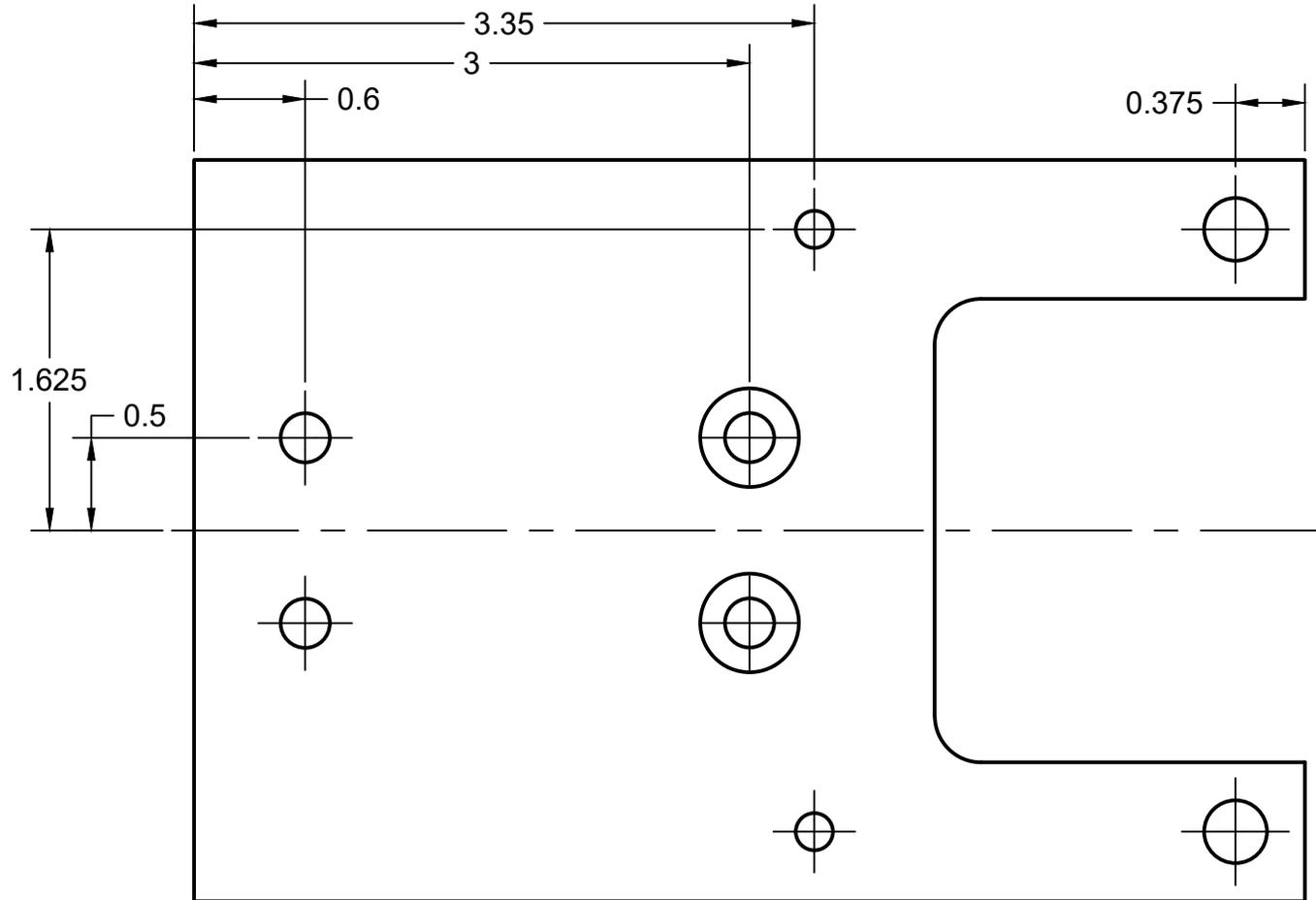
[www.facebook.com/belnapcustomknives](https://www.facebook.com/belnapcustomknives)

See the jig in action at BigIronTV on youtube

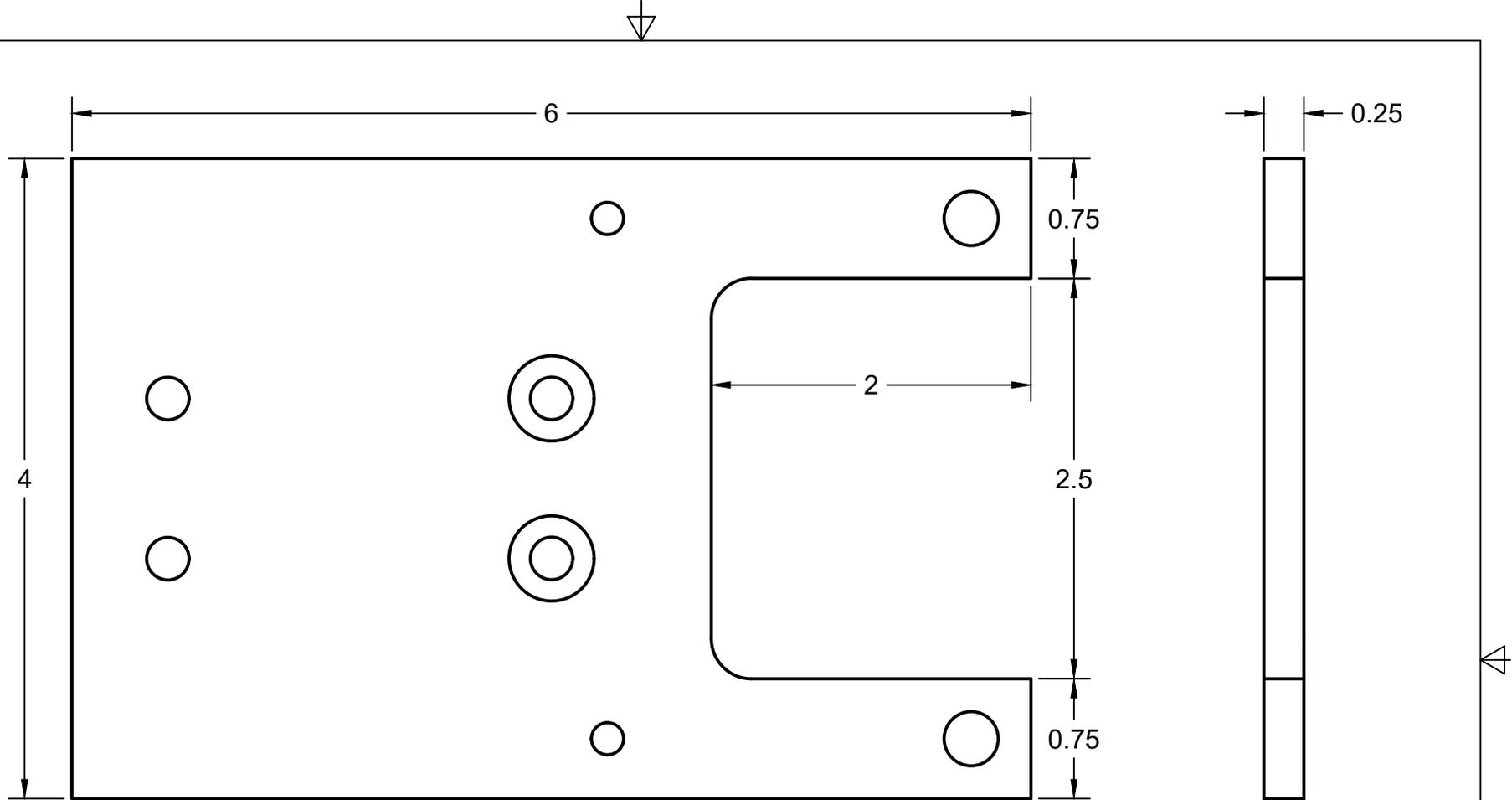


.532 CSK Top Side

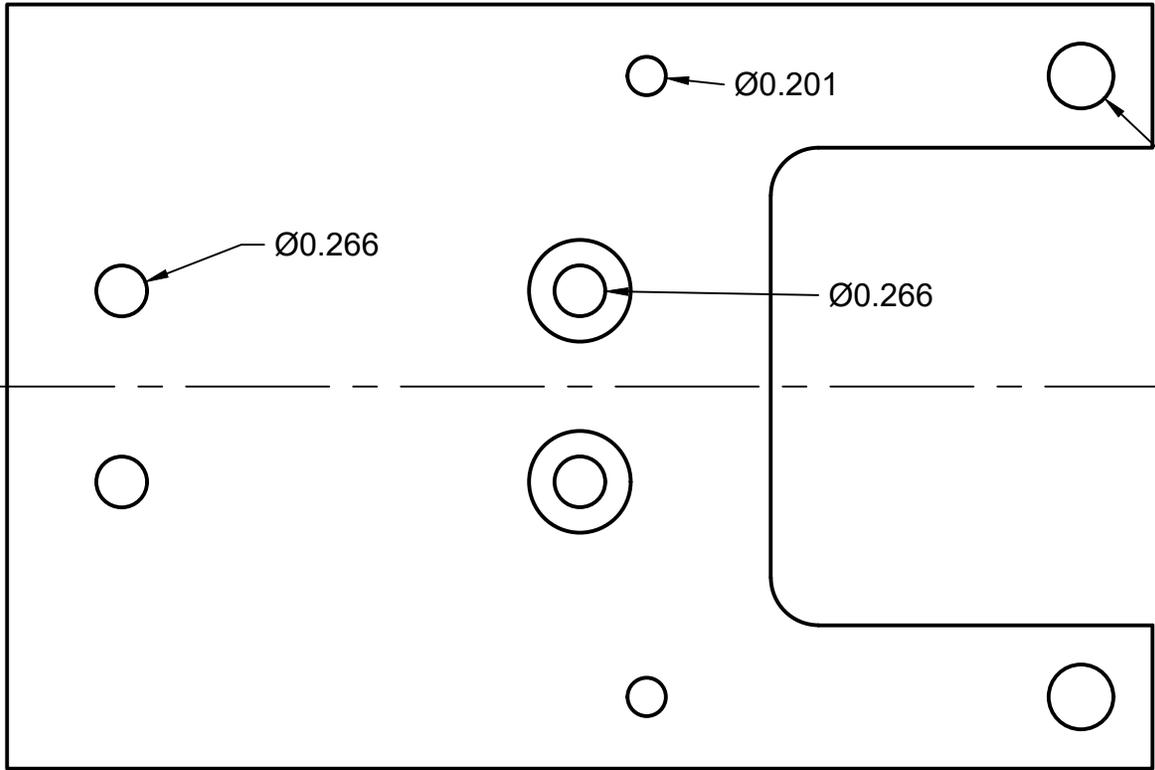
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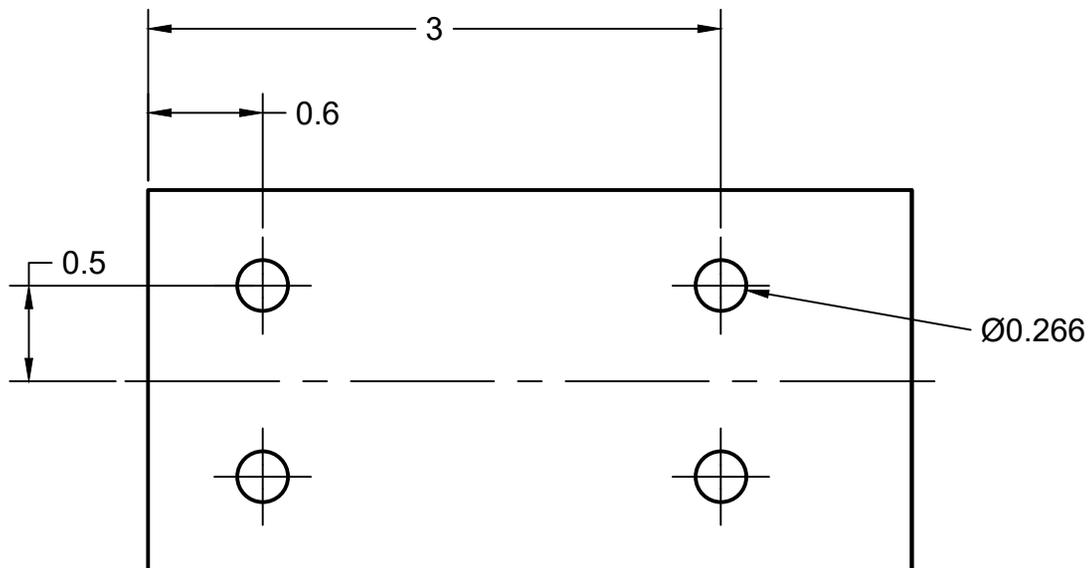
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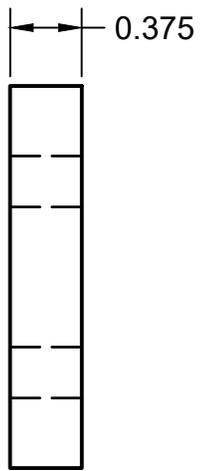
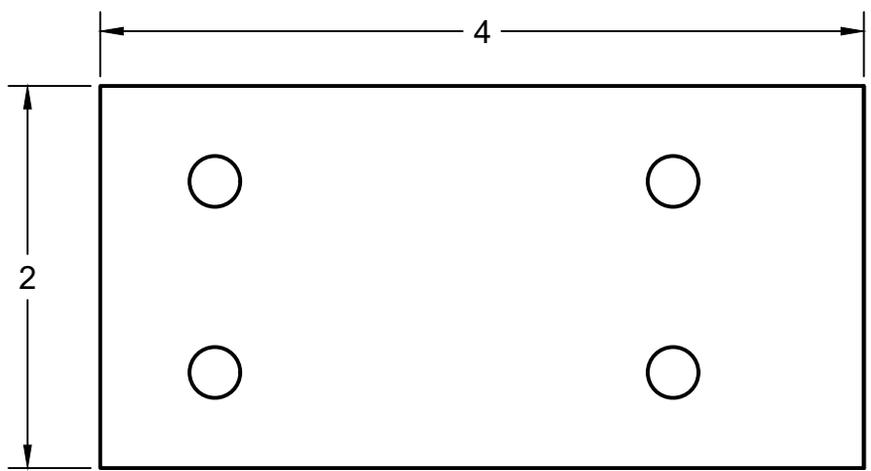
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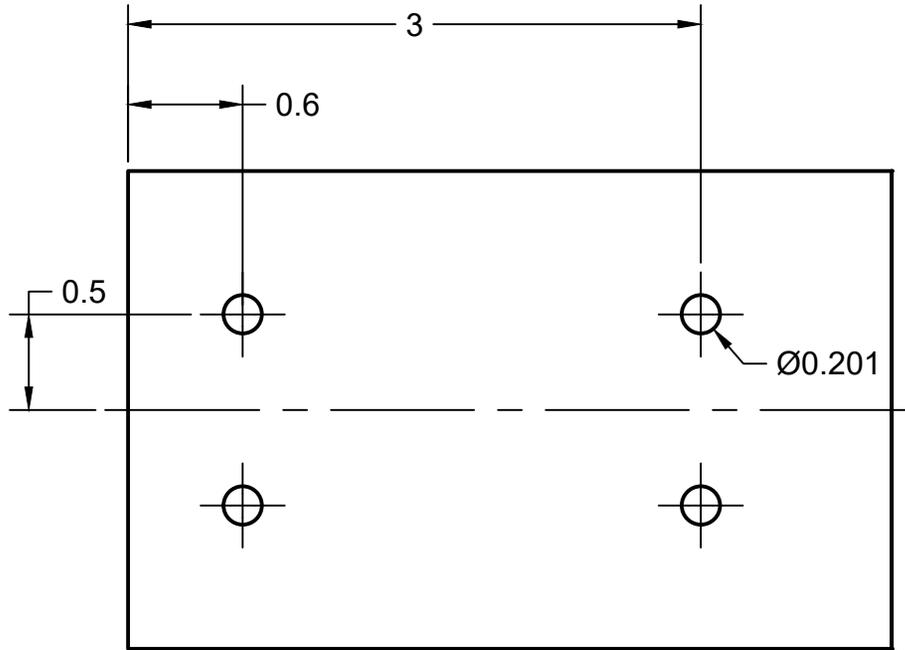
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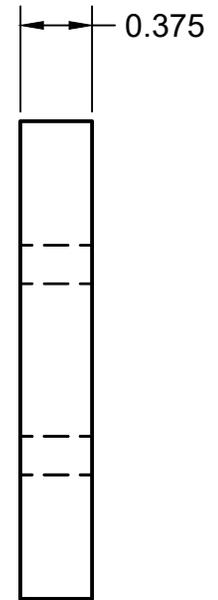
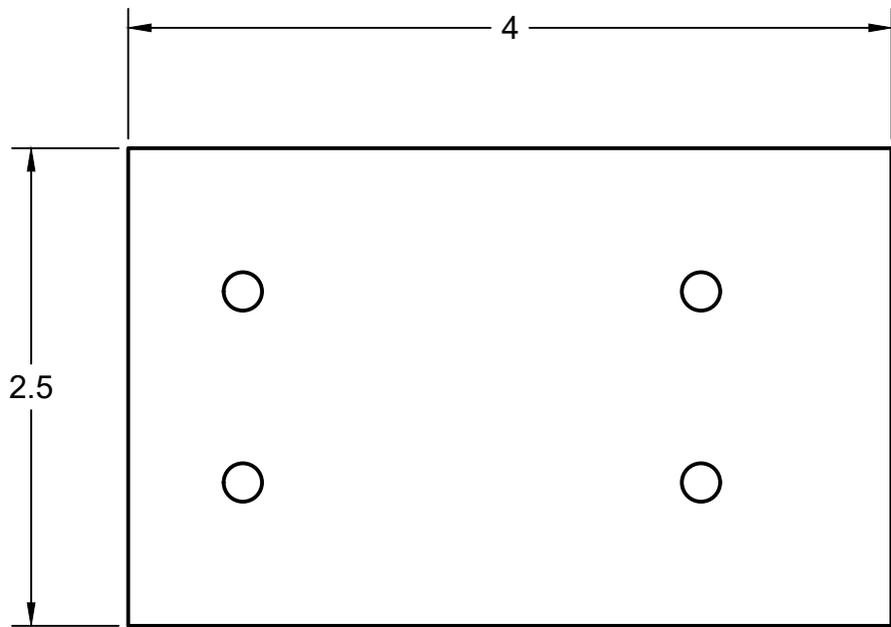
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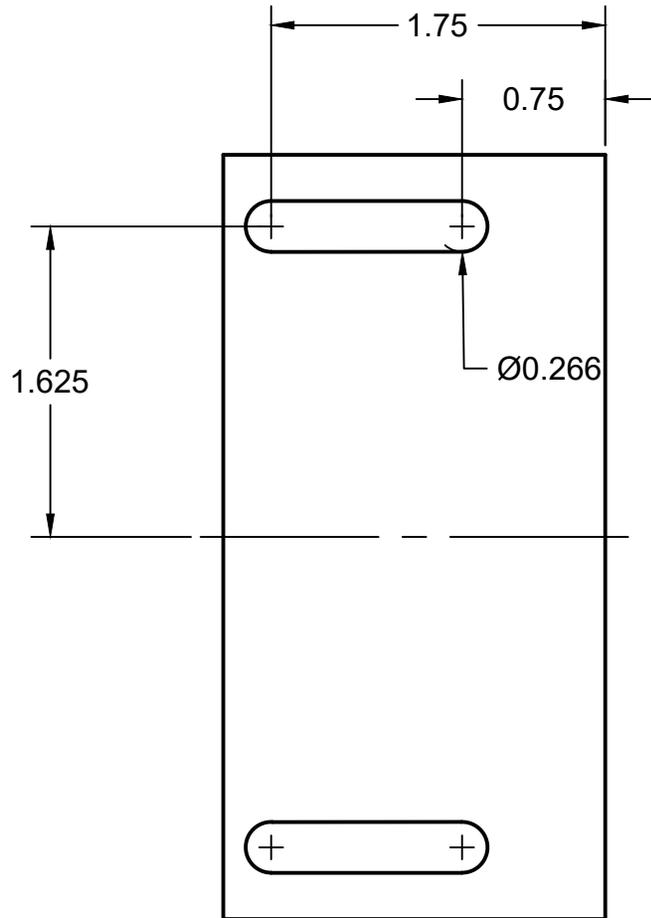
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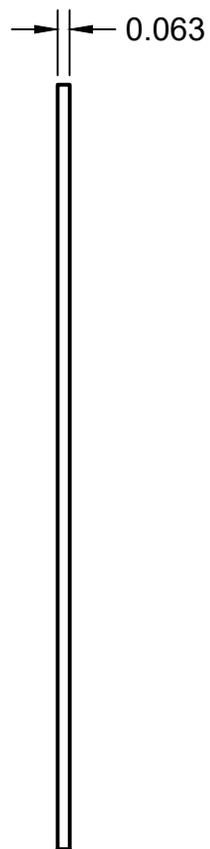
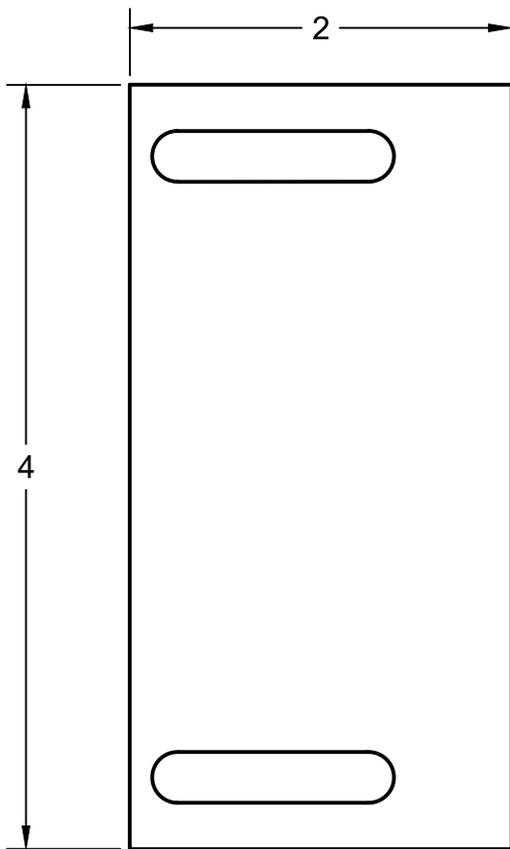
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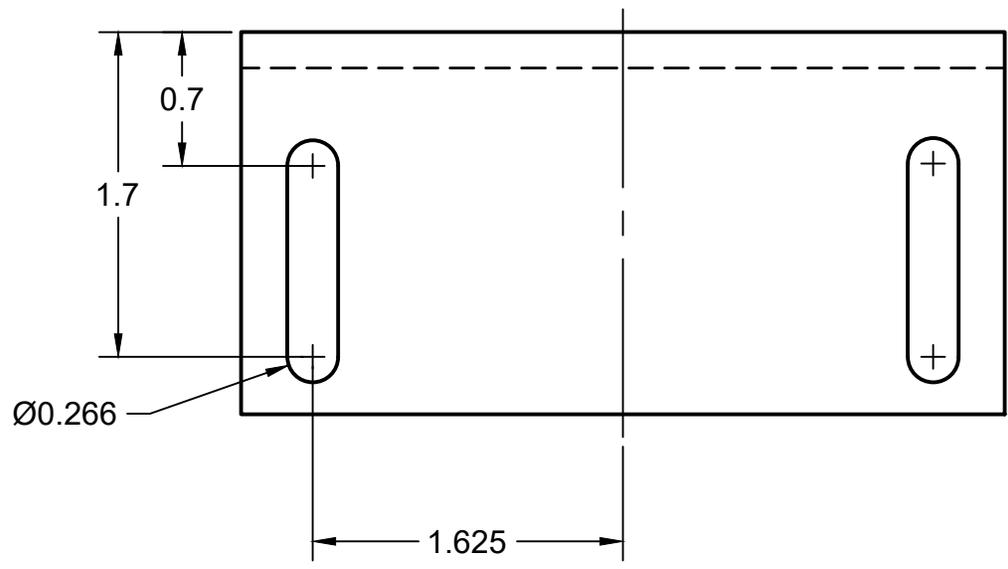
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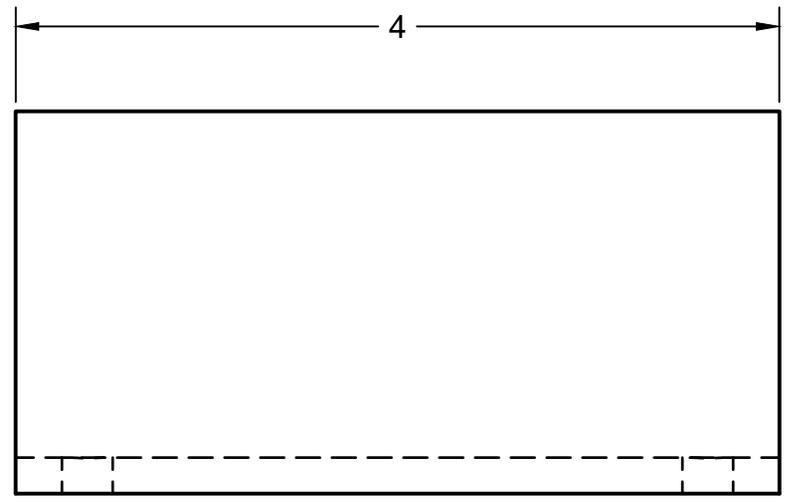
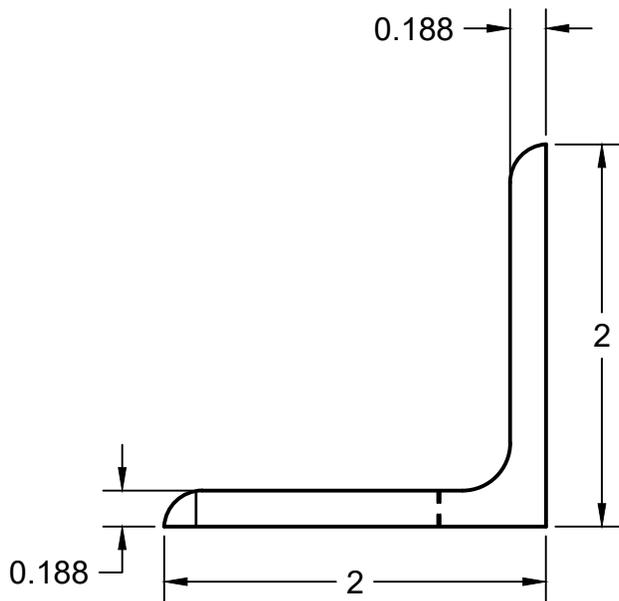
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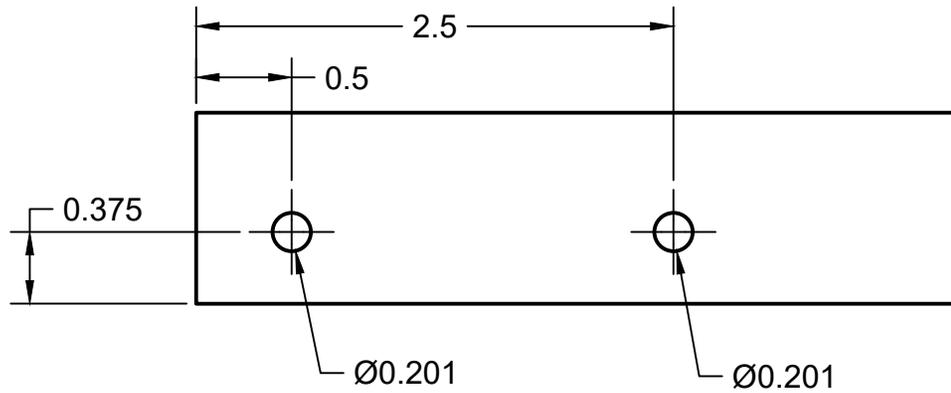
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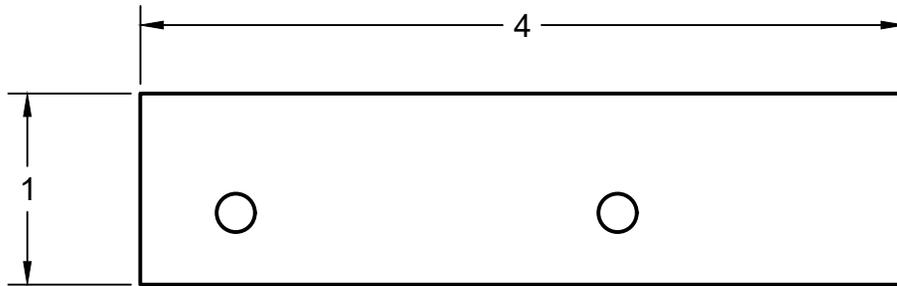
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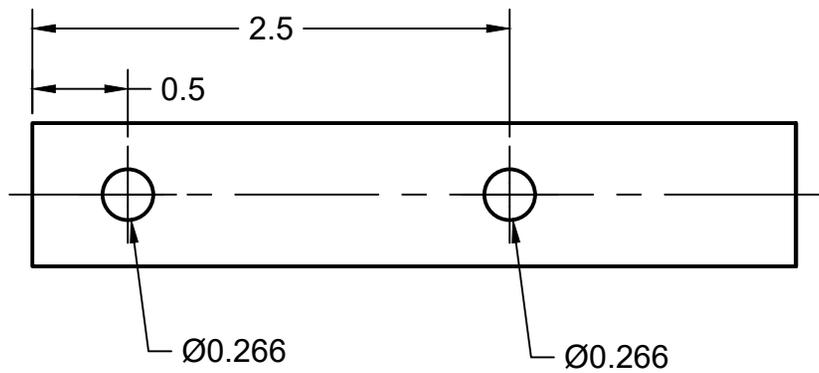
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DRAWN	Daryl Belnap	4/4/2017	SCALE 1:1	WEIGHT
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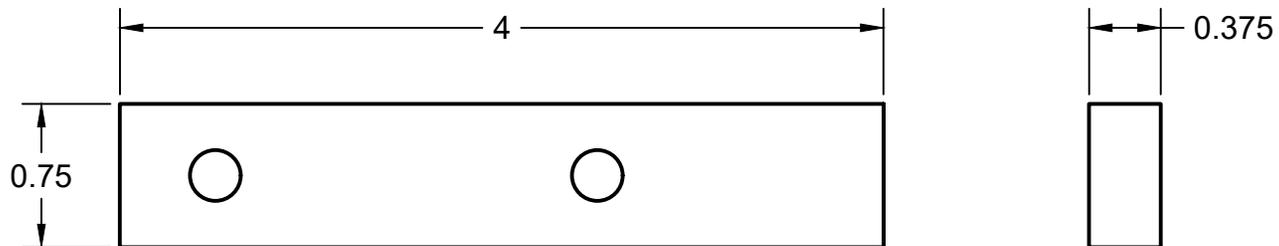
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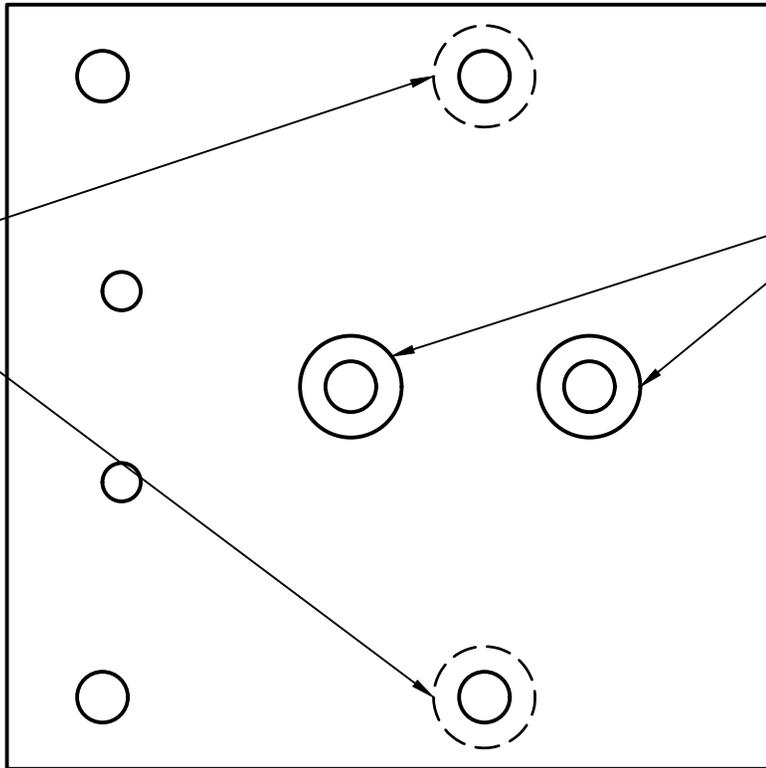
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CHECKED	A			
DRAWN	Daryl Belnap	4/4/2017	SCALE 1:1	WEIGHT
				SHEET 1/1



	PROJECT <b>2" x 72" Sander</b>			
	TITLE <b>Fixed Plate Middle</b>			
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CHECKED	A			
DRAWN	Daryl Belnap	4/4/2017	SCALE 1:1	WEIGHT
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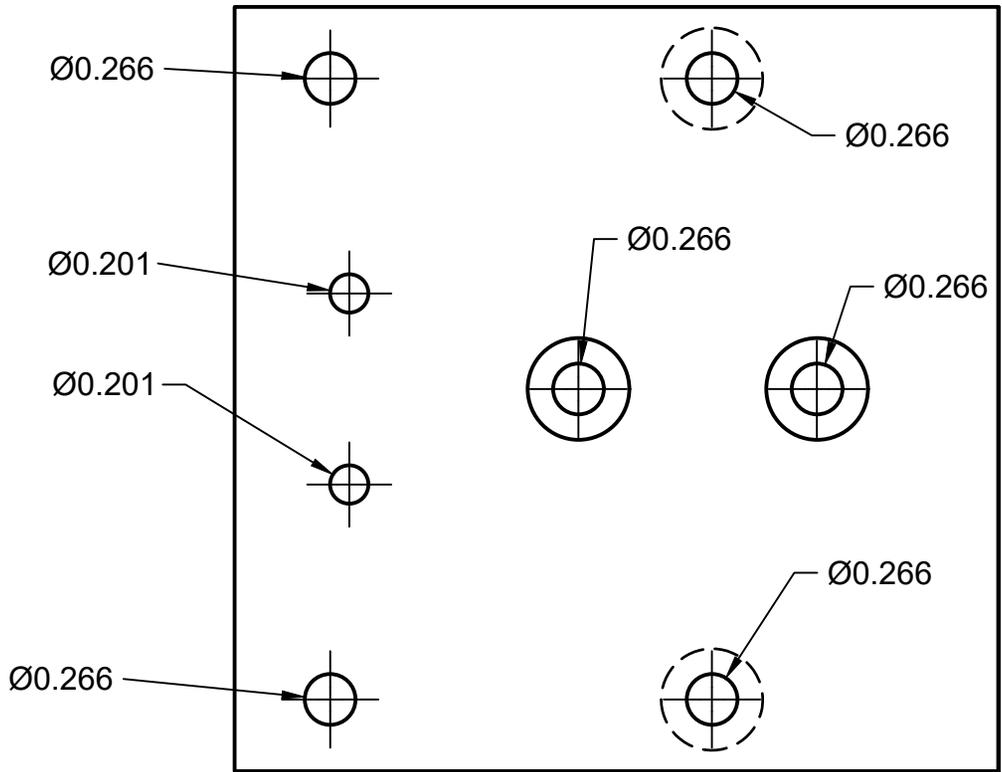
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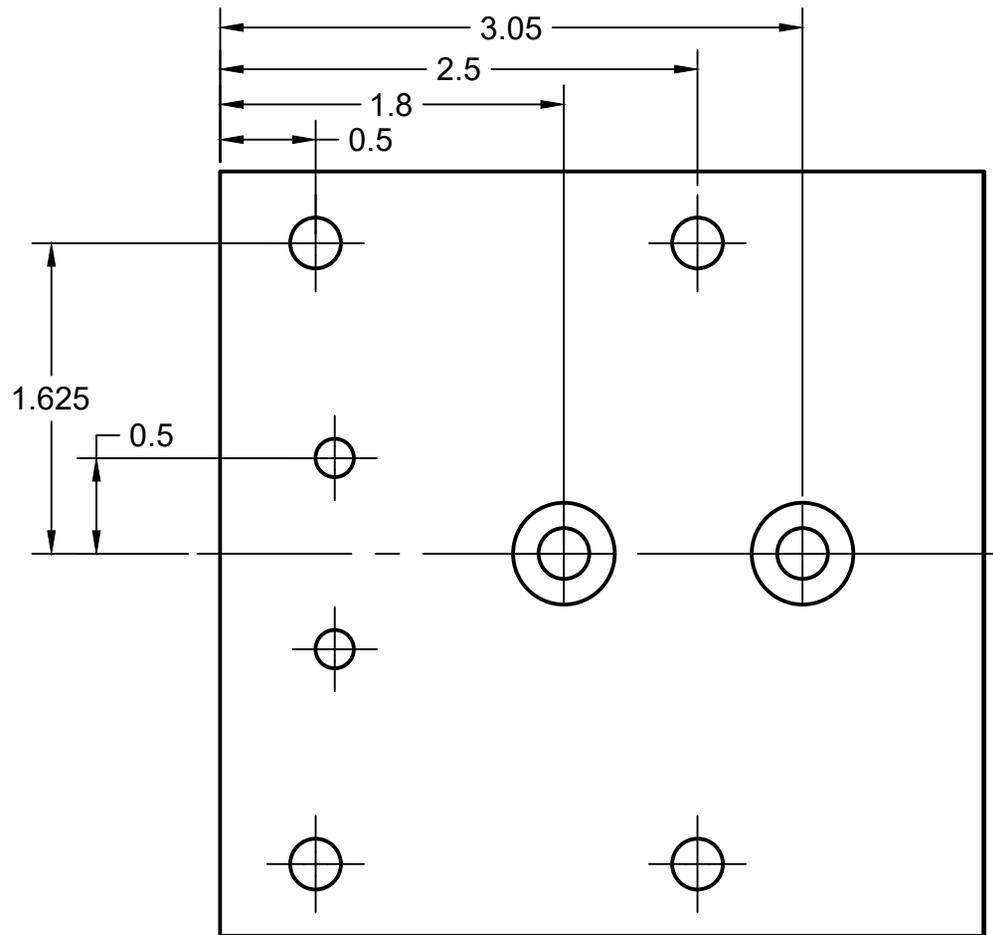
.532 CSK Bottom Side

.532 CSK Top Side

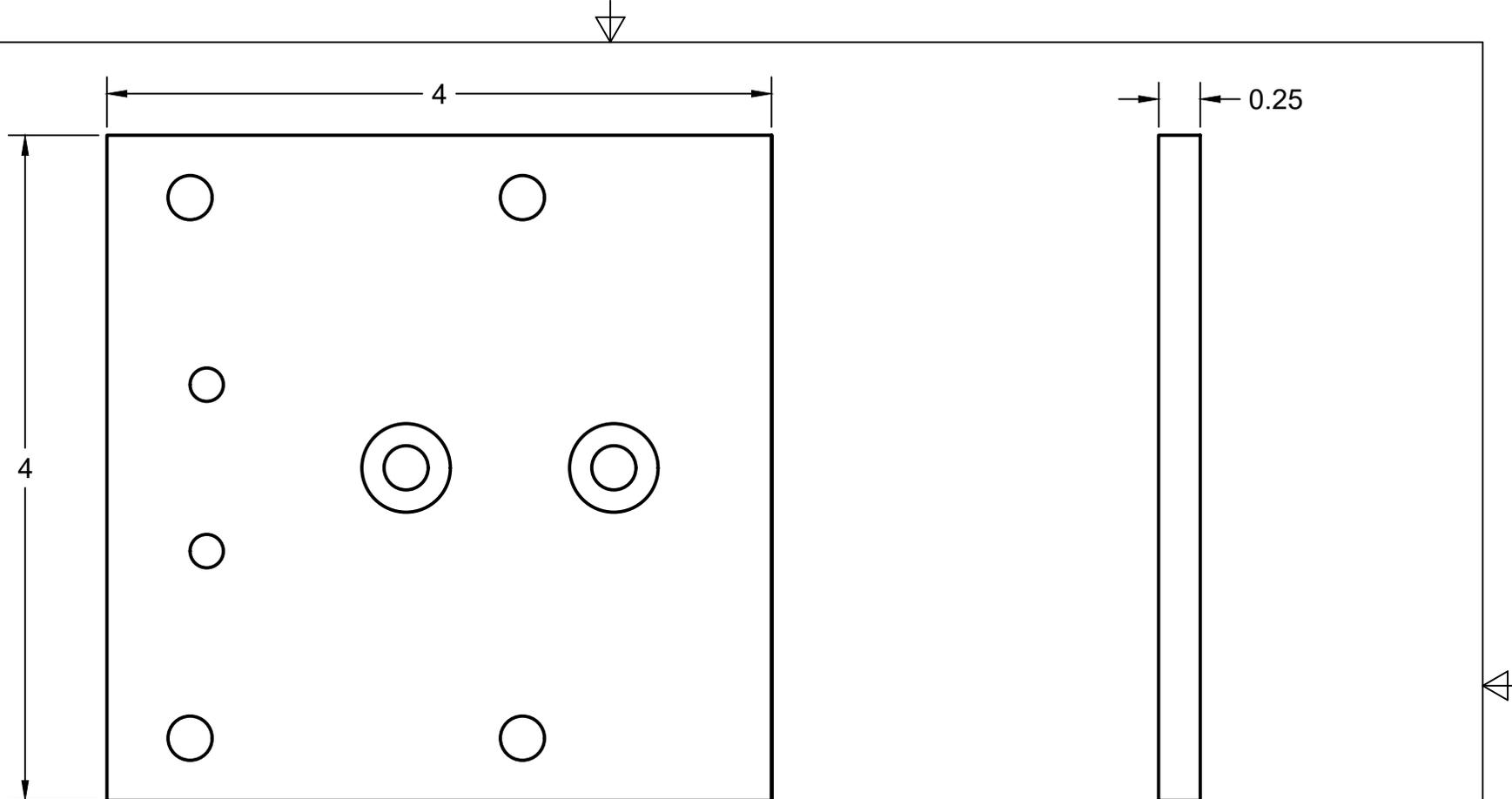
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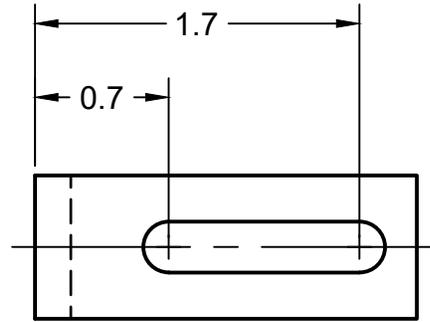
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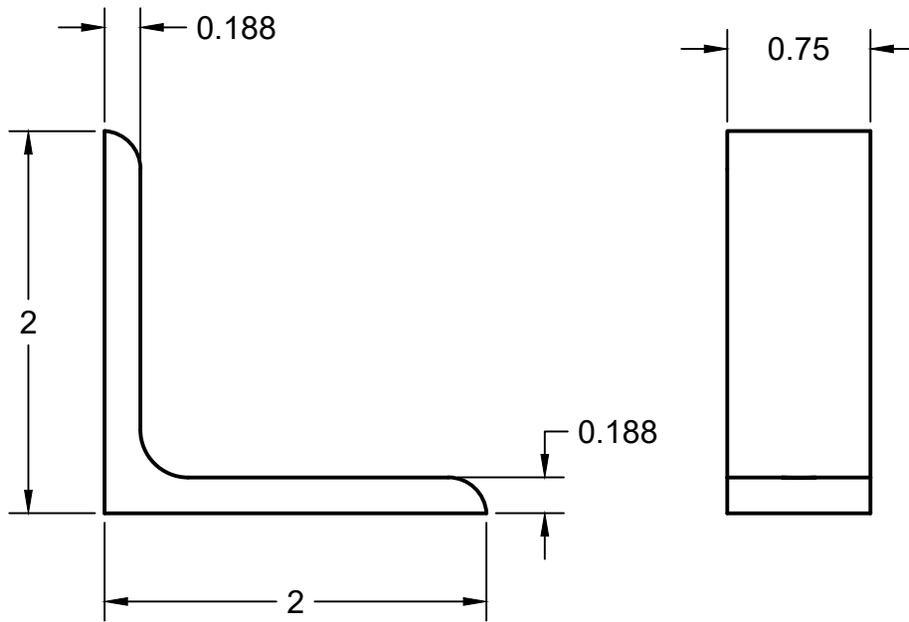
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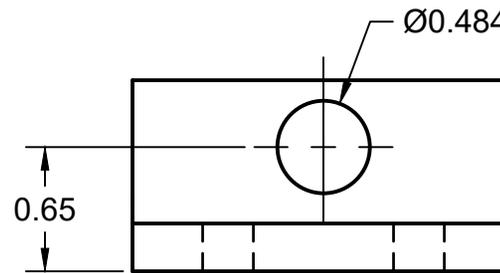
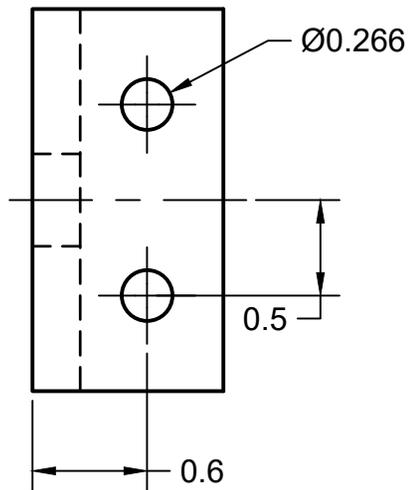
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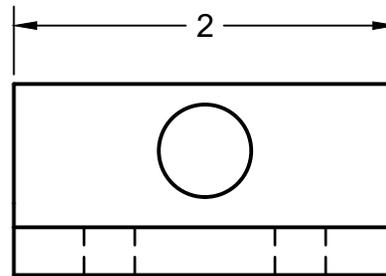
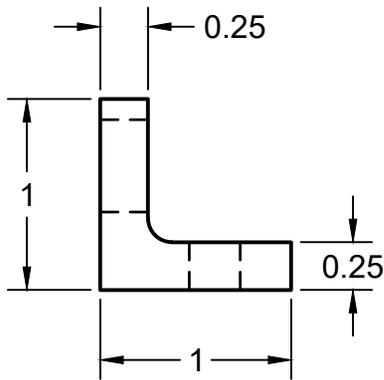
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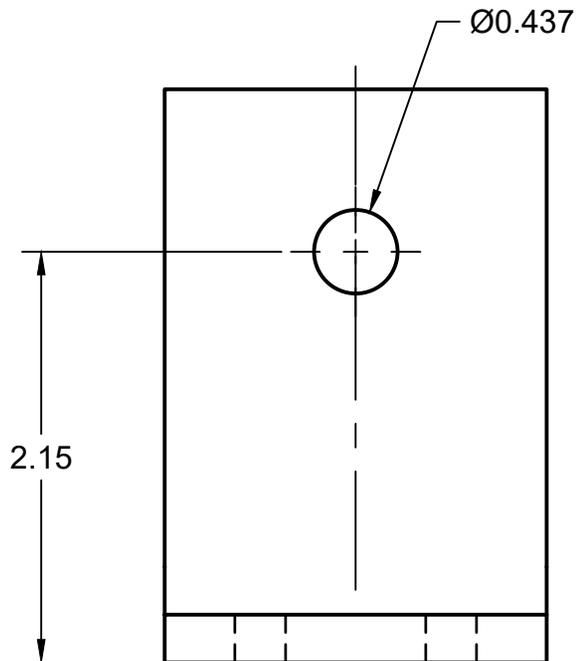
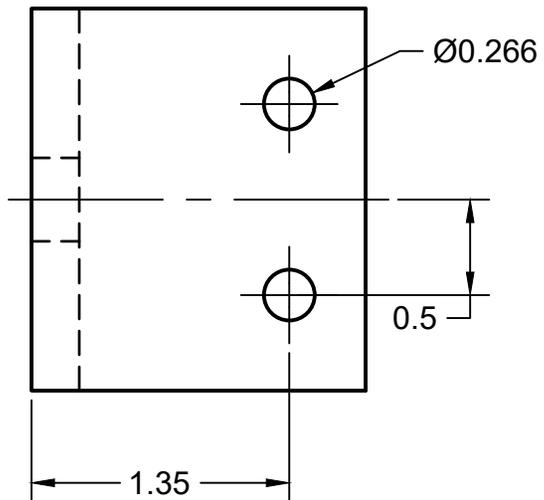
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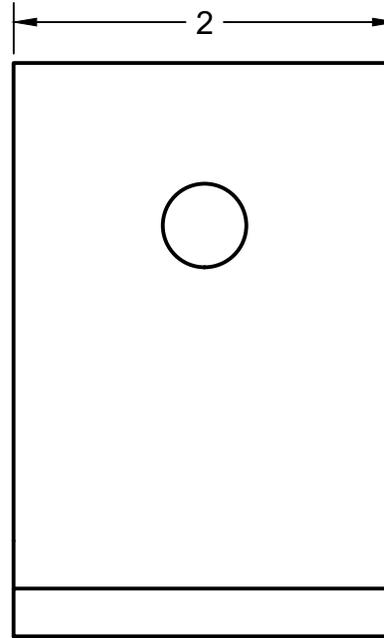
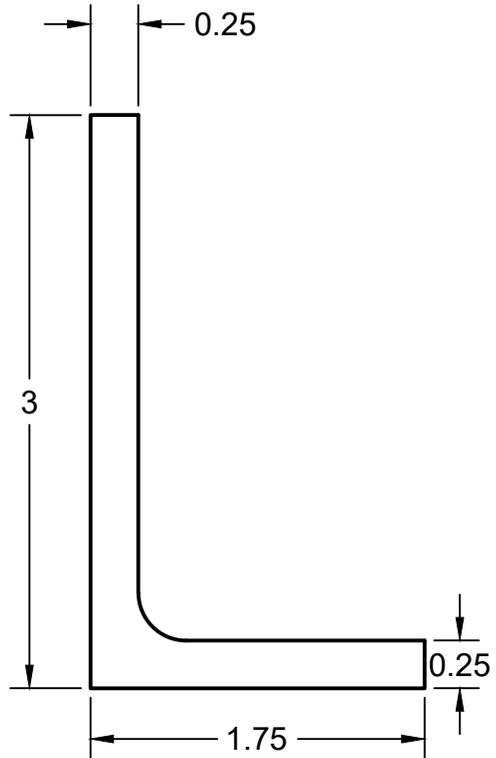
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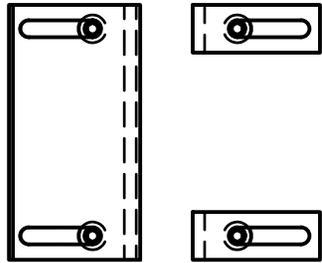
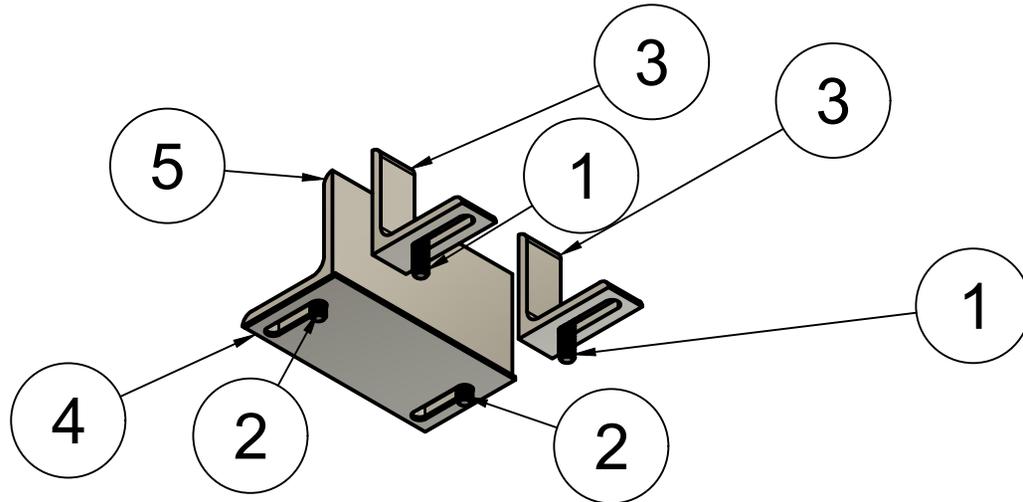
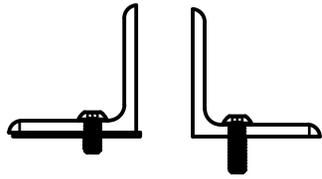
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		PROJECT		
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		TITLE		
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APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/4/2017	SCALE 1:1	WEIGHT
			SHEET 1/1	



		PROJECT		
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		TITLE		
		Adjuster Fixed Angle		
APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/4/2017	SCALE 1:1	WEIGHT
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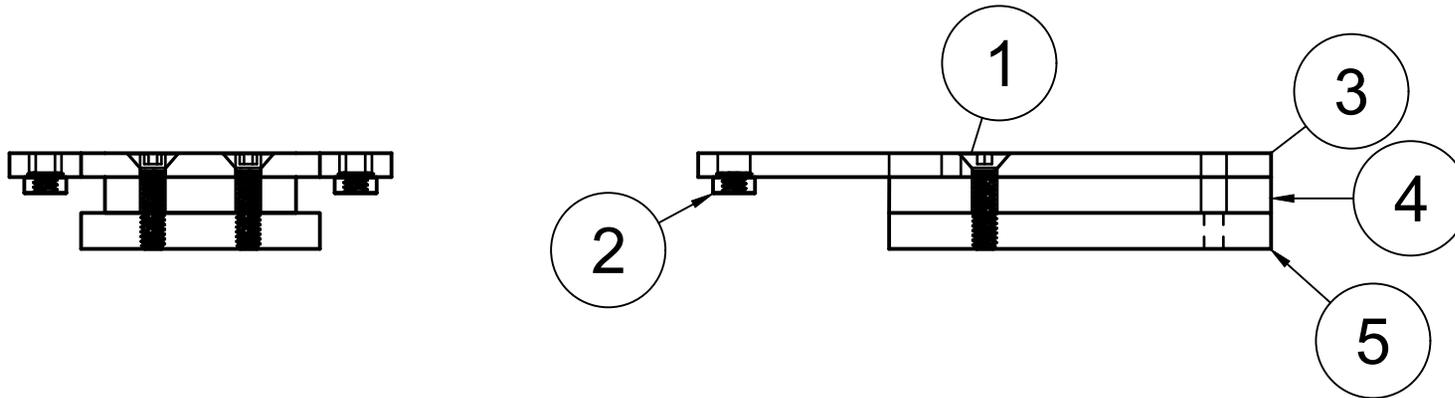


5	1	SLIDE ANGLE	3/16 ALUMINUM ANGLE	ALUMINUM
4	1	SLIDE ANGLE SPACER -9 (1)	1/16 STAINLESS STEEL	STAINLESS STEEL AISI 304
3	2	FIXED ANGLE	3/16 ALUMINUM ANGLE	ALUMINUM
2	2	91255A537 1/4-20 X 1/2 BUTTON HEAD		STEEL
1	2	91255A540 1/4-20 X 3/4 BUTTON HEAD		STEEL
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL

PARTS LIST

	PROJECT	2" x 72" Sander		
	TITLE	Multi Guide Pro Throat Assembly		

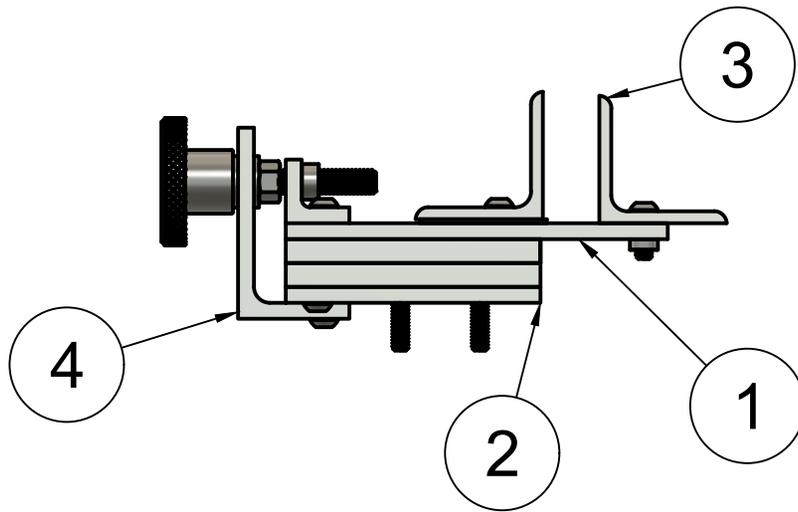
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CHECKED	A			
DRAWN	Daryl Belnap	4/5/2017	SCALE 1:3	WEIGHT
			SHEET 1/1	



5	1	SLIDE PLATE LOWER -10	1/4 PLATE	ALUMINUM
4	1	SLIDE PLATE MIDDLE -11	1/4 ALUMINUM	ALUMINUM
3	1	SLIDE PLATE UPPER		ALUMINUM
2	2	95185A199 1/4-20 PRESS-IN NUT		STEEL
1	2	91253A542 1/4-20 X 1 CSK HEAD		STEEL
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL

PARTS LIST

		PROJECT <b>2" x 72" Sander</b>		
		TITLE <b>Multi Guide Pro Slide Plate Assembly</b>		
APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/5/2017	SCALE 1:2	WEIGHT
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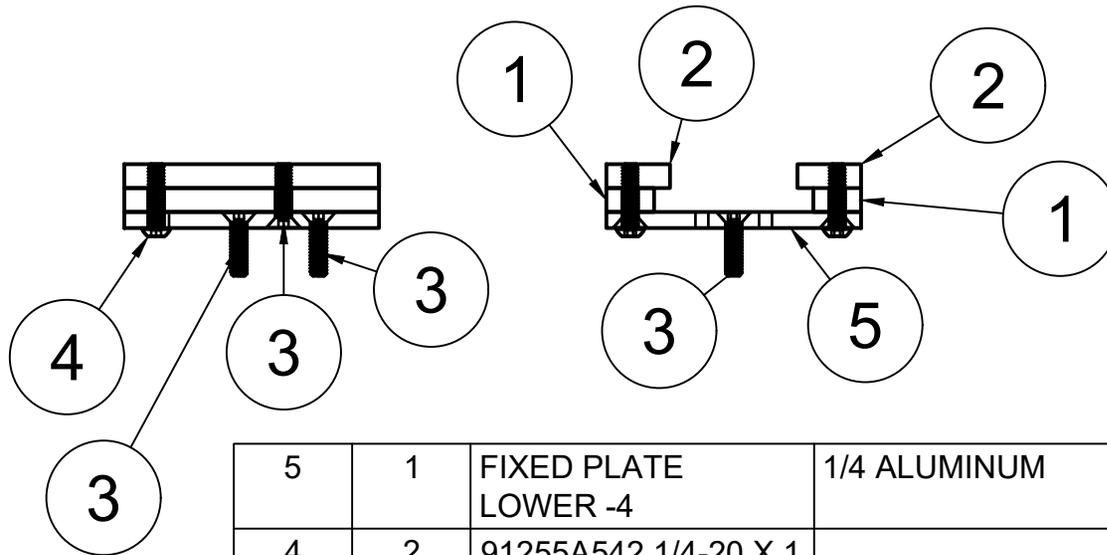


4	1	ADJUSTER ASSEMBLY		
3	1	THROAT ASSEMBLY		
2	1	FIXED PLATE ASSEMBLY		
1	1	SLIDE PLATE ASSEMBLY		
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL

PARTS LIST

	PROJECT	2" x 72" Sander		
	TITLE	Multi Guide Pro		

APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/5/2017	SCALE 1:3	WEIGHT
			SHEET 1/1	

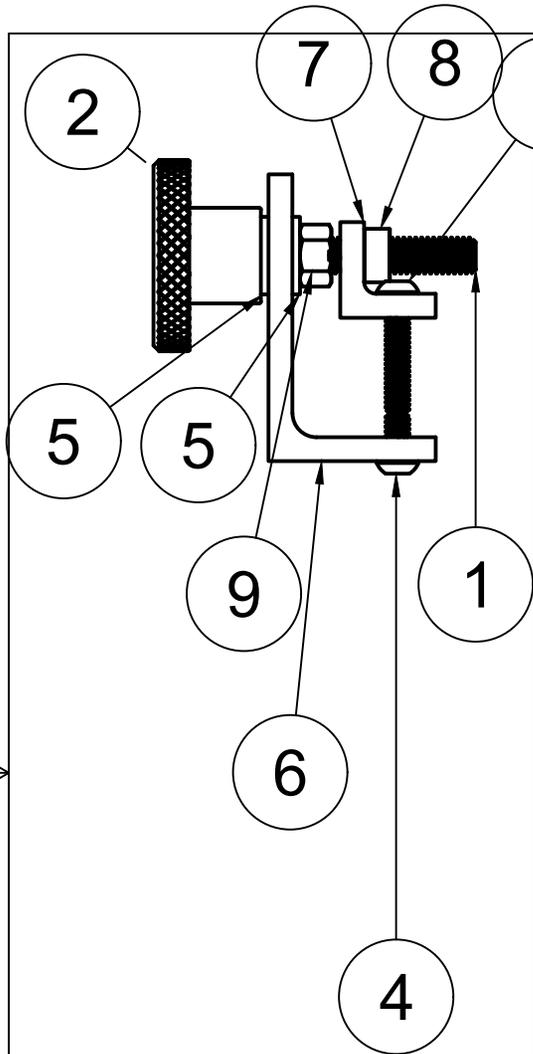


5	1	FIXED PLATE LOWER -4	1/4 ALUMINUM	ALUMINUM
4	2	91255A542 1/4-20 X 1 BUTTON HEAD		STEEL
3	4	91253A542 1/4-20 X 1 CSK HEAD		STEEL
2	2	FIXED PLATE UPPER	1/4 ALUMINUM	ALUMINUM
1	2	FIXED PLATE MIDDLE	1/4 ALUMINUM	ALUMINUM
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL

PARTS LIST

	PROJECT	<b>2" x 72" Sander</b>		
	TITLE	<b>Multi Guide Pro Fixed Plate Assembly</b>		

APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/5/2017	SCALE 1:3	WEIGHT
			SHEET 1/1	



9	1	92501A031 3/8 LOCK NUT		STEEL
8	1	95185A330 3/8-16 PRESS-IN NUT		STEEL
7	1	ADJUSTER SLIDE ANGLE -2	1/4 ALUMINUM ANGLE	ALUMINUM
6	1	ADJUSTER FIXED ANGLE	1/4 ALUMINUM ANGLE	ALUMINUM
5	2	98023A031 3/8 WASHER GRADE 8		STEEL
4	2	91255A537 1/4-20 X 1/2 BUTTON HEAD		STEEL
3	2	91255A544 1/4-20 X 1/4 BUTTON HEAD		STEEL
2	1	6121K27 ADJUSTER KNOB		STEEL
1	1	90322A116 3/8-16 X 3 THREADED ROD		STEEL
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL

PARTS LIST

PROJECT		<b>2" x 72" Sander</b>		
TITLE		<b>Multi Guide Pro Adjuster Assembly</b>		
APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	A			
DRAWN	Daryl Belnap	4/5/2017	SCALE 1:2	WEIGHT
			SHEET 1/1	

## Parts List

- 1) 1 Ea. Adjuster Fixed Angle
- 2) 1 Ea. Adjuster Slide Angle
- 3) 2 Ea. Fixed Angle
- 4) 1 Ea. Fixed Plate Lower
- 5) 2 Ea. Fixed Plate Middle
- 6) 2 Ea. Fixed Plate Upper
- 7) 1 Ea. Slide Angle
- 8) 1 Ea. Slide Angle Spacer
- 9) 1 Ea. Slide Plate Lower
- 10) 1 Ea. Slide Plate Middle
- 11) 1 Ea. Slide Plate Upper

## Hardware List

- 1) 6 Ea. 91253A542 ¼-20 x 1 CSK Head Bolt
- 2) 2 Ea. 95185A199 ¼-20 Press-In Nut
- 3) 2 Ea. 91255A542 ¼-20 x 1 Button Head Bolt
- 4) 4 Ea. 91255A537 ¼-20 x ½ Button Head Bolt
- 5) 2 Ea. 91255A540 ¼-20 x ¾ Button Head Bolt
- 6) 2 Ea. 91255A544 ¼-20 x 1 ¼ Button Head Bolt
- 7) 1 Ea. 6121K27 Steel Knob with 3/8" Threaded Hole
- 8) 1 Ea. 90322A166 3/8-16 x 3 Threaded Rod Grade 8
- 9) 1 Ea. 92501A031 Distorted Head Lock Nut Grade 8 (I tried nylon lock nuts and they did not hold well and began to loosen over time). The distorted head nuts hold very well.
- 10) 1 Ea. 95185A330 3/8-16 Press-In Nut
- 11) 2 Ea. 98023A031 3/8 Washer Grade 8

## Material List

- 1) 8.5" of ¾ x 3/8 aluminum bar. Used to make the two Fixed Plate Middle parts.
- 2) 8.5" of 1 x ¾ aluminum bar. Used to make the two Fixed Plate Upper parts.
- 3) 10.5" of ¼ x 4 aluminum bar. Used to make the Slide Plate Upper and the Fixed Plate Lower parts.
- 4) 6" of 3/16 x 2 x 2 aluminum angle. Used to make the two Fixed Angles and the Slide Angle Parts.
- 5) 4.5" of 3/8 x 2 aluminum bar. Used to make the Slide Plate Middle part.
- 6) 4.5" of 3/8 x 2.5 aluminum bar. Used to make the Slide Plate Lower part.
- 7) 2.5" of ¼ x 1 x 1 aluminum angle. Used to make the Adjuster Slide Angle part.
- 8) 2.5" of ¼ x 3 x 3 aluminum angle. Used to make the Adjuster Fixed Angle part.
- 9) 4" x 2" x 1/16" stainless steel. Used to make the Slide Angle Spacer part.

## Notes

- 1) .201" is same as a #7 drill bit
- 2) All holes identified with .201 are to be tapped to ¼-20 threads
- 3) Non-threaded holes are marked as .266" but may be drill to larger diameter if needed to get the parts to line up during assembly. It is suggested that the parts be drilled as a stacked up assembly as much as possible to get holes to line up better than drilling each part on its own.
- 4) The large .484" hole in the Adjuster Slide Angle is a 31/64 drill bit.
- 5) The 3/8 Press-In Nut is very tight in the .484" hole and must be pounded or pressed into position. I made it tight on purpose because this nut is in a push/pull and did not want it to get loose or pop out.
- 6) .339" is the same as an "R" drill bit. These are not very common in hardware stores. A 21/64" bit might also work but the insert will have to be pounded in like the 3/8 nut was. It might be possible to use an 11/32" bit as well which would only require minor tapping to seat the insert.
- 7) The mounting system you use for the jig is also important that it is sturdy and will be able to hold the jig square to the platen during grinding operations. If you need a mount feel free to contact me to discuss suitable options.
- 8) For the jig to deliver accurate bevels on each side of the blank it will need to be installed so it is square horizontally, and vertically with the platen face.
- 9) If you intend to use the jig for hollow grinding then your mounting system must allow the jig to be positioned low enough that the top of the Slide Angle Spacer is in line with the center of the contact wheel hub.
- 10) In order to get your jig to slide correctly you will likely need to shim it. I have not addressed shimming in detail because your materials will vary from those that I am using. I suggest getting a variety pack of shim stock from the local hardware store and use trial and error until you get the jig to slide smoothly without being slopping and loose. I typically install shims between the Slide Plate Middle and the Slide Plate Lower. I do this using three ¼" wide shim strips. One installed between the bolts on one outside the bolts on each side. I do this after the bolts are installed and just slip them in from the end. Make sure they don't slip out to the side and get pinched by the other plates and bind up the slide. Also I have installed shims between the Fixed Plate Lower and the Fixed Plate Middle. I do this by sliding a piece of shim in from the end until it hits the bolt. Then tighten the bolts and break off the shim that is sticking out the ends. Of course if you feel inclined to do so you can spend the time to fabricate shims that match the hole patterns and install them that way.
- 11) Add a tiny amount of Lock Tite to the bolt threads to prevent them getting loose from the vibrations of the sanding belt against the blank. Do not apply Lock Tite to the two ¼-20 x ½ bolts on the Slide Angle or the two ¼-20 x ¾ bolts on the fixed angles because these are loosened when you need to make adjustments for different blank widths.
- 12) PRIOR to drilling. Mark the plates so that you will know which position they belong in. If you drill them then some of them get moved around prior to assembly it can be a head ache trying figure out which position they were in.