



Start by cutting 2 strips to fit into your table saw slots. Should be a snug fit but not tight. The thickness of the strips should be less than the depth of the table saw slot. You want the board of the jig in contact with the saw surface.



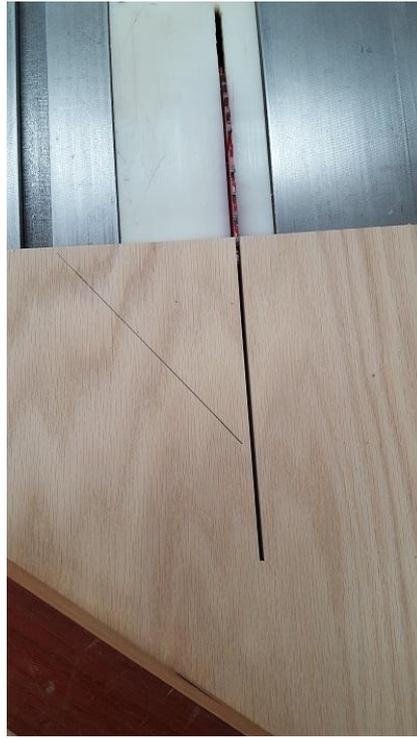
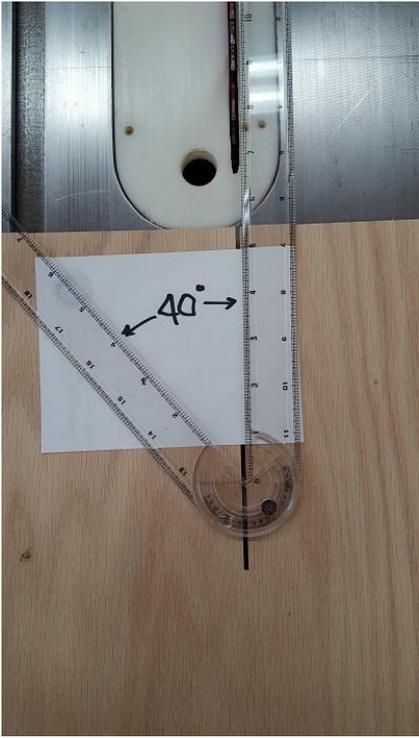
Lay thin spacers into the slots. Coins will work. You want the strips to be proud of the table surface.



Cut a board approx 18" square. Spread glue on the strips. Lay your board on the strips and weight down until the glue sets. I lined the strips up with the edge of the table and the board against the rip fence. You don't have to do that, its just the anal engineer in me.



After the glue sets turn upside down and screw the runners into the board.



Cut approx half way through the board.

Determine the angle you want to use for your knot design. I prefer between 35 to 40 degrees.

Draw a pencil line representing that angled line.

Place a board (fence) along the line and attach it to the jig. If you intend to make your knots at the same angle every time this board can be permanently mounted with glue and screws.

The fence should be taller than any pen blank you are going to use.



Roughly determine where you will place the pen blank and install clamps to the fence. Be sure screws are not in line with the blade. **Do not use this jig without clamps.**

Put a stop block in place and install clamp. Note the shape of the stop block. This design prevents saw dust from interfering with the placement of the blank. I prefer to hold the stop block with a clamp in case I want to change the placement of the knot.



My clamping fixture is a piece of construction lumber with packing tape to prevent the glue from sticking.

Apply glue to both halves of the cut blank. Insert decorative piece and clamp.

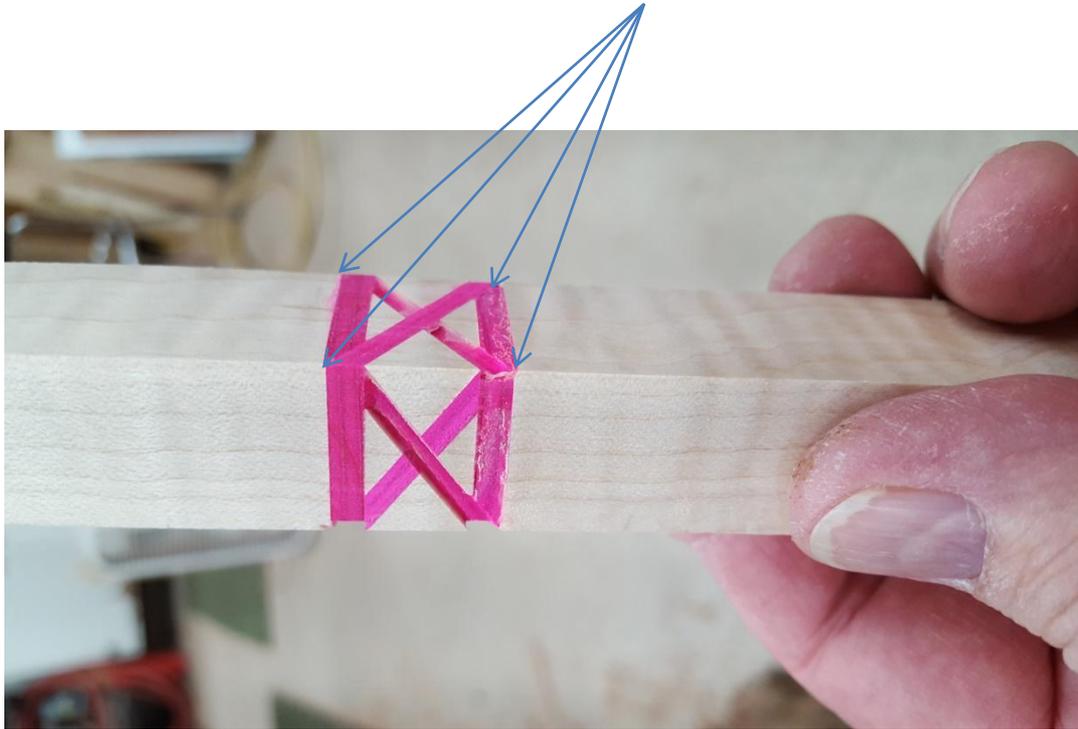
When clamping apply downward pressure to the blank and clamp **lightly**. Clamp both halves. Third clamp is directly over the decorative piece. Last clamp draws the blank together. Light clamping helps keep everything in line.

The next day I clean up the blank on the belt sander. You don't want any bumps sticking up. Don't be too aggressive sanding.

Repeat cutting and gluing on every side of the blank.

**Important: the thickness of the decorative insert must be the same as the width your saw blade.**

If you've done things correctly all the corners will match all around the blank.



If they don't match your knot will be lopsided.

