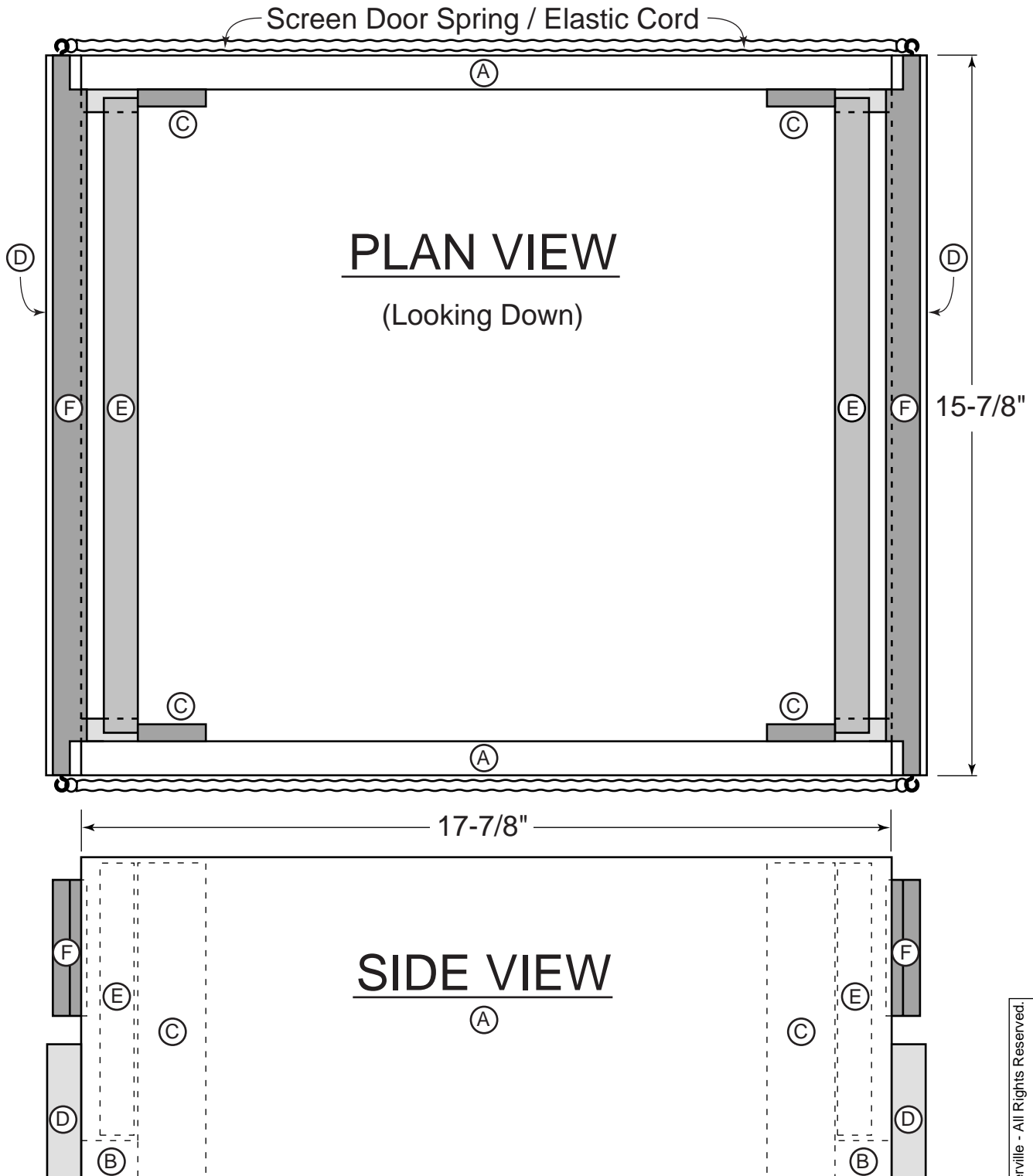


# 10-FRAME ASSEMBLY JIG

## CONSTRUCTION DETAILS FOR 3/4" THICK LUMBER



### FOR 9" FRAMES

- (A) Side panels are 17-7/8" x 7-1/8" x 3/4"
- (B) Bottom spacers are 1-1/4" x 7/8" x 1/2"
- (C) Side spacers are 1-1/2" x 7" x 3/8"
- (D) Front & rear panels are 15-7/8" x 3" x 3/4"
- (E) Inner supports are 14" x 6" x 3/4"
- (F) End supports are 15-7/8" x 3" x 3/4" with a 3/8" x 3/4" rabbet on both ends.

### FOR 5" & 6" FRAMES

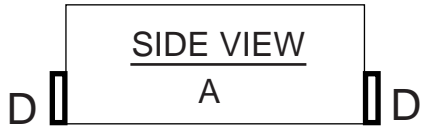
- (A) Side panels are 17-7/8" x 4-7/8" x 3/4"
- (B) Bottom spacers are 1-1/4" x 7/8" x 1/2"
- (C) Side spacers are 1-1/2" x 4-3/4" x 3/8"
- (D) Front & rear panels are 15-7/8" x 1-7/8" x 3/4"
- (E) Inner supports are 14" x 3" x 3/4"
- (F) End supports are 15-7/8" x 2-1/4" x 3/4" with a 3/8" x 3/4" rabbet on both ends.

# 10-FRAME ASSEMBLY JIG

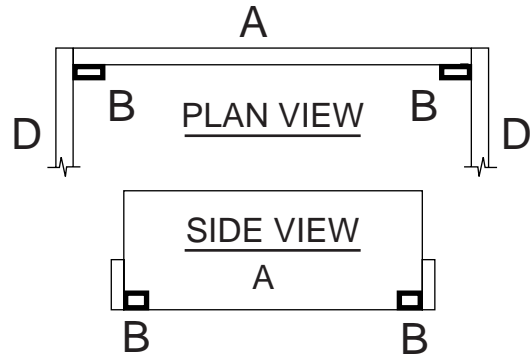
## CONSTRUCTION NOTES

After cutting all of the pieces as described, assemble the jig as follows.

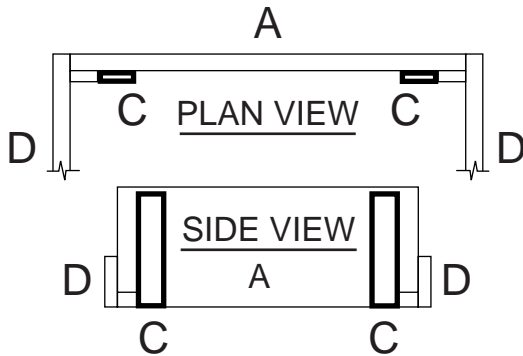
- 1) Attach (D) to the ends of the side panels (A).



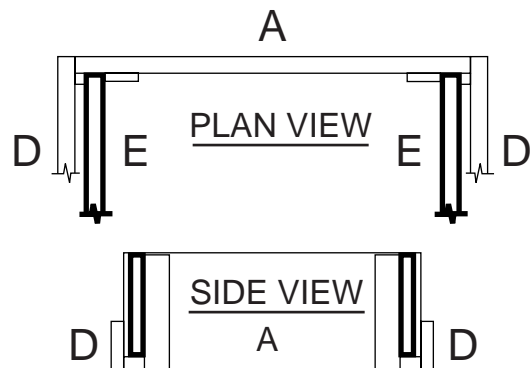
- 2) Attach the bottom spacers (B) to the inside lower edge of the side panels (A).



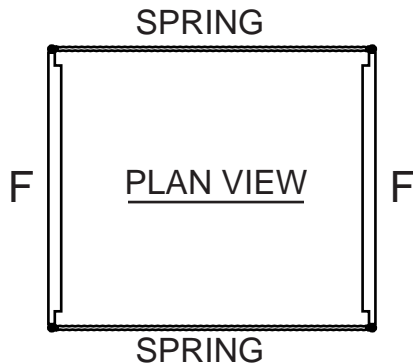
- 3) Attach the side spacers (C) next to the bottom spacers (B).



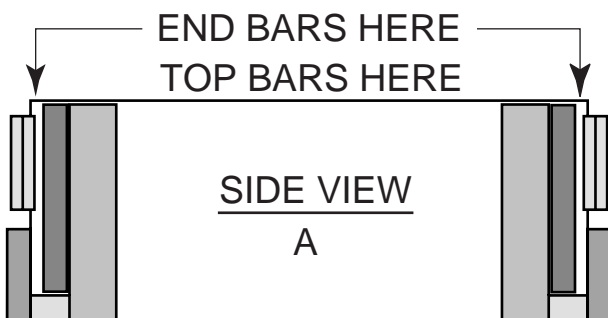
- 4) Slide the inner supports (E) into the gap between the side spacers (C) and the front and rear panels (D).  
**DO NOT ATTACH AS THIS SLIDES OUT** after the frames are assembled!



- 5) Attach two screen door springs to the sides of the end support (F).



- 6) Slide the above assembly over the jig as shown below.



Push the "END BARS" into the gap as shown.  
Attach the TOP BARS.  
Flip the jig over and attach the BOTTOM BARS.  
To remove the frames from the jig, pull up the end supports (F) and remove the inner support.  
Replace the inner supports, load up the end bars and make another perfect batch!