

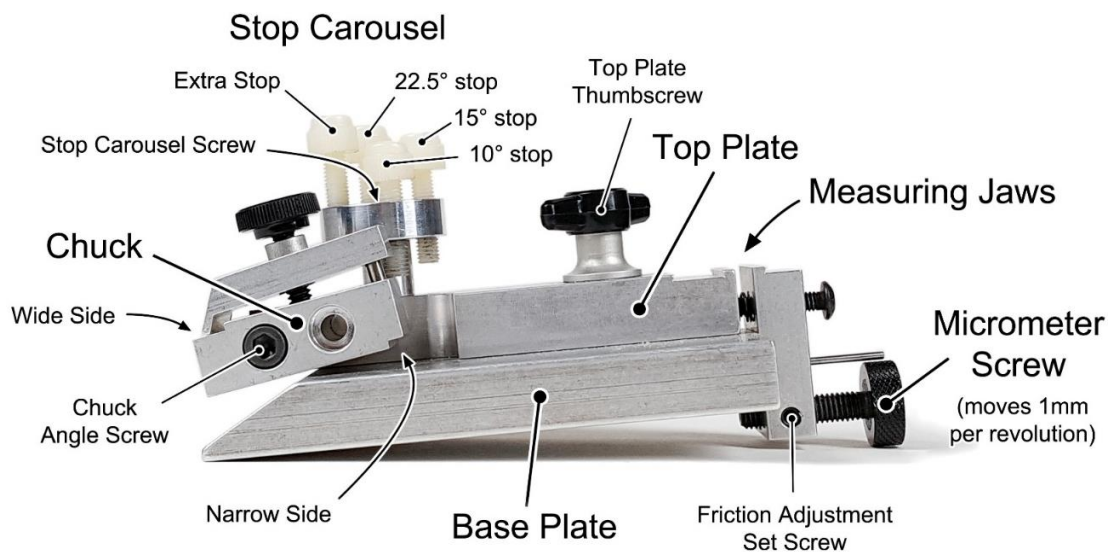
Fitting a New Frog Slide with the Alberti Frog Slide Fixture

1 PREP

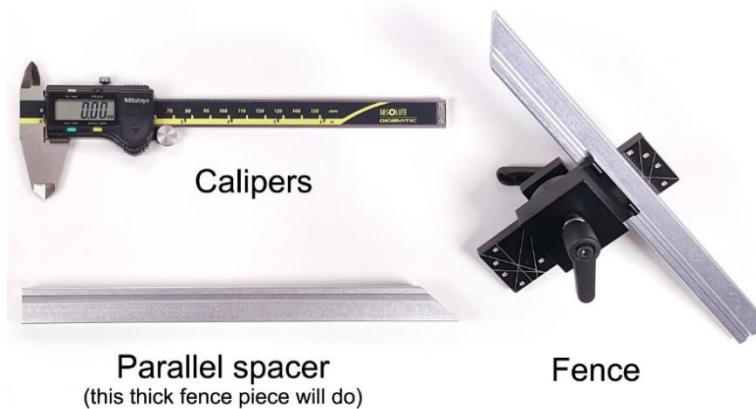
1.1 IMPORTANT NOTES

- Always clamp the slide **pearl side up**
- When sanding the slide's taper, its **wooden protrusion** and the **throat of the frog** must be **facing the same direction**

1.2 ANATOMY OF THE FIXTURE



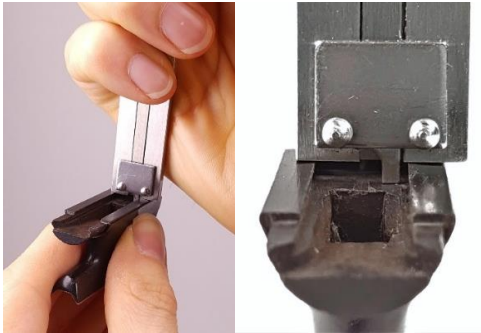
1.3 OTHER EQUIPMENT



2 SLIDE THICKNESS

2.1 MEASURE DOVETAIL DEPTH

Measure depth of **slide dovetail** in **frog** with the end of a **caliper**. Check it in **all four corners** and the **middle** of the **frog**.



2.2 SAND SLIDE THICKNESS

Sand the **wooden backing** on the **pearl slide** to conform to the **frog** by checking with **calipers** and leaving the **thickness** slightly greater than the **dovetail depth**.



3 FIXTURE PREP

3.1 SQUARE THE MITER FENCE

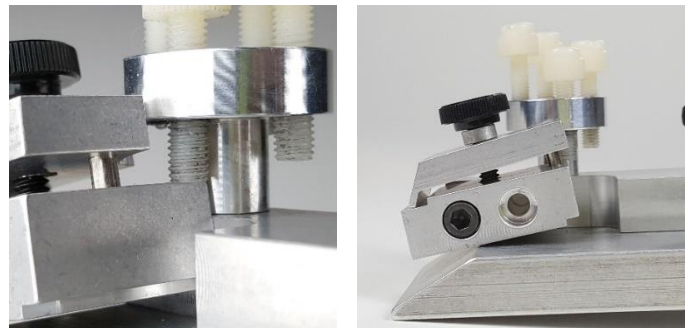
Square the **fence** with the **disk** using a **square** or the **base plate** of the **frog slide fixture** itself. Check it twice, as it must be perfectly square.

The front of the **base plate** is machined square for this purpose, but it won't be able to reach the **disk** without adjusting the **micrometer screw** almost all the way out. It's faster to put a **parallel spacer** (like the **thick fence piece**) between the **fixture** and the **disk**, as shown.



3.2 SET DOVETAIL BEVEL ANGLE (IF NEEDED)

1. Loosen the **chuck angle screw** and **stop carousel screw**
2. Position desired **stop** above corner of **chuck**
3. Tighten the **stop carousel screw**
4. Rotate the **chuck** up against the **stop**
5. Tighten the **chuck angle screw**
 - Take care that the **chuck** doesn't rotate away from the **stop** while tightening



3.3 ALIGN TOP PLATE WITH BASE PLATE

1. Loosen **top plate thumbscrew**
2. Square the **top plate** with the **base plate** by laying the **fixture** on its side on a **flat surface**
3. Tighten **thumbscrew**



4 TRUE THE FIRST EDGE

4.1 CHUCK THE SLIDE

Clamp the **slide** in the **chuck** as shown with the **pearl side up** and **wooden protrusion** to the **left**.



4.2 SAND THE FIRST EDGE

Place the **frog slide fixture** against the **fence** and true the **first edge** of the **slide** by sanding until the **entire side** has just been sanded away.



5 TRUE THE SECOND EDGE

5.1 PLACE FROG ON MEASURING JAWS

Rotate the **slide** in the **chuck** as shown, with the **wooden protrusion** to the **right** and the **pearl side up**.

Place the **frog** on the **measuring jaws** as shown.

Make sure the **wooden protrusion** of the **slide** and the **throat of the frog** are on the same side.

5.2 SAND THE SECOND EDGE

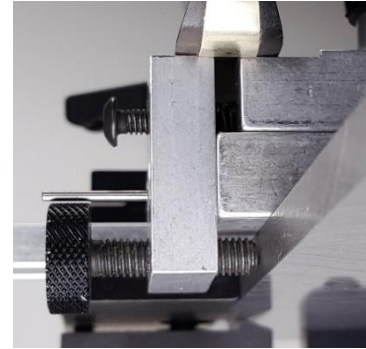
True the **second edge** like you did the first edge: with the **frog slide fixture** against the fence, sand until the **entire side** of the **slide** has just been sanded away.



5.3 SET MICROMETER SCREW

Turn the **micrometer screw** in until it touches the **table**, then **crank the sander** to make sure the **screw** is seated and the **sander** is no longer removing material.

If you have enough material on the **slide blank**, you can turn the **screw** out to **zero** and then sand until the **screw** touches the **table** again.



6 FINISH SECOND EDGE

6.1 MEASURE WIDTH OF JAWS AND SLIDE

1. Slide **frog** off **jaws**
2. Measure with **calipers** in **middle of jaws** to get an estimate of the **dovetail** width
 - a. **Warning:** If the **dovetail** is deeper than the **jaws** are **tall**, then they won't seat into the **corners** of it and this measurement will be narrower than the actual **dovetail width**. If the **dovetail** is too deep, treat this measurement as a low estimate of the **dovetail width** and fit some **scrap wood** (popsicle sticks) into the **frog** before fitting the real **slide**.
3. Remove **slide** from **chuck**
4. Measure with **calipers** in **middle of slide**



6.2 SAND OFF REMAINDER

Use the **micrometer screw** to sand off **difference in width** from **slide**, checking the **slide's** fit periodically.

The **screw** moves **1mm per revolution**.



6.3 SAND PEARL TO FINAL THICKNESS

Sand **pearl side of slide** to final thickness.

