

Dog-Hole Bushing

15J79.03
15J79.05

These hardened steel bushings ensure that dog holes are drilled at exactly 90° with repeated accuracy. They come in two sizes, suitable for drilling either 3/4" or 20mm diameter dog holes.

Making a Drilling Jig

You can make a simple jig from a block of softwood, 1 1/2" or 38mm thick, as shown in **Figure 1**. Add a fence if you are planning to drill a row of holes.

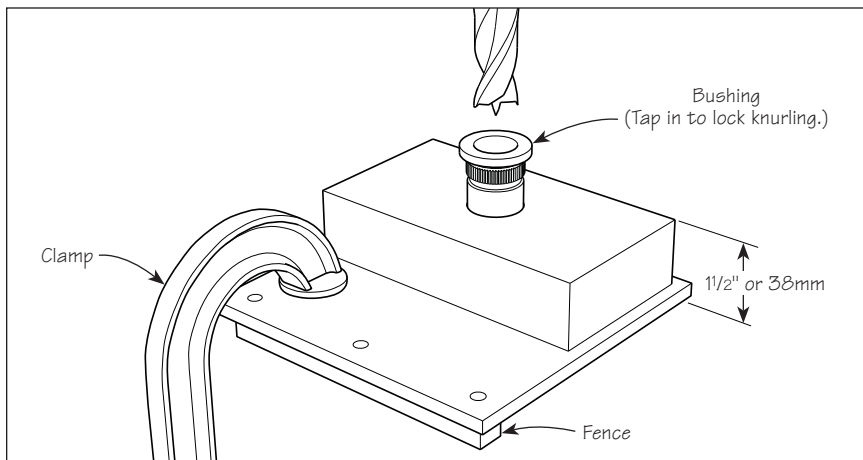


Figure 1: Example of a user-made jig.

Carefully drill a perpendicular hole through the jig using an appropriately sized drill bit (1" for the 3/4" bushing; 25mm for the 20mm bushing) mounted in a drill press.

Tap the bushing into the hole with a mallet rather than a steel hammer; a steel hammer could mushroom the head, preventing the drill bit from spinning freely. The bushing stem is sized to fit through the hole, and the knurling is designed to press into and grip the sides. No glue is needed.

Using the Jig

Place the jig at the desired location and clamp in place. Insert an appropriately sized (3/4" or 20mm) brad-point drill bit into the bushing and drill as many dog holes as needed.

Tip: Be sure to withdraw the bit frequently to clear the wood chips from the flutes.