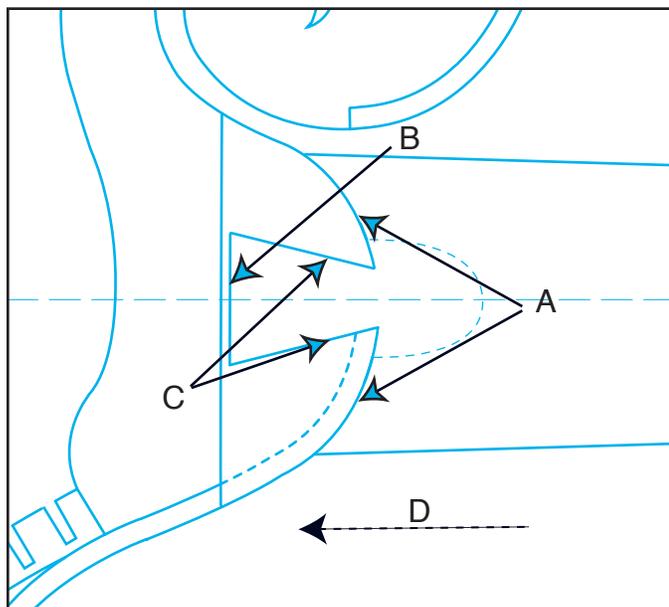


Assembly Instructions	
Dovetail neck joints	
Rev: 3/31/09	Pt# D

We prepare our dovetail joints (Service #D) with a snug fit so that you can make final adjustments when the instrument is assembled. Here are some important points to consider when doing the final fitting of dovetail joints:

**General information:**

- The final fitting should be done after the rim is fully assembled and glued to the headblock, and the soundboard is glued to the rim.
- At no time should the neck be forced into the dovetail. If the neck gets stuck in place, do not try to hammer it out. Instead, push it out the way it went in by placing two support sticks in the drill press to rest the headblock on, with space for the neck joint to come out. Place a wood dowel in the drill press chuck and slowly press on the dovetail part of the neck to gently force the neck out of the joint.
- We use a 23mm-wide non-tapered dovetail joint as used on original Gibson mandolins. (“Non-tapered” means that the joint is the same width top to bottom, so the neck can go in either from the top or bottom of the headblock.)
- If you remove too much wood from the dovetail joint, it is acceptable to use thin wood shims to build up any part of the headblock or neck to achieve a proper fit.



- You should not have to change the shape or size of the sides of the dovetail at “C” unless a major axis change is required (see below).

**Instructions for fitting the dovetail:**

- With the rim assembled, check fit the neck into the dovetail. Pay special attention to the mating surfaces of the neck, headblock, and rim at “A”. Check the fit of the gap at “B”.
- To obtain a looser fit, remove wood (sand or file) as necessary from either the headblock or the neck at “A” depending on which surface needs to be re-shaped. As you remove wood, the neck will be able to move in the direction of arrow “D” and the dovetail joint will begin to fit more easily.
- As you remove wood at “A”, check the fit at “B”. If necessary, remove wood from the neck (not the headblock) at “B”.
- Check the alignment of the neck’s axis (centerline) and rotation (across the body of the instrument; i.e., how it will align to the bridge). An adjustment in either of these two axis may require minor reshaping of the faces at “C”.



- After the dovetail is properly fitted, you can determine the proper height of the neck heel.