

PHILIP KUBICKI

Neck Mtg Insert Nut Installation

***By using these instructions instead of having us do the installation, you are assuming all risk for any damage that occurs to the neck while installing the inserts despite following these instructions.

Marking the locations of the neck mounting holes:

1. Place neck in the neck slot of the body.
2. Put a 1/4" (.25") brad point drill through each of the body's neck mounting holes and tap with a wood piece or soft headed hammer, just hard enough to mark the neck.

Drilling the neck mounting holes:

3. Place a letter N (.302") drill with 135 degree chamfer in a drill press and set the drill stop so the depth of the drill hole will be no more than 5/8" (0.625") to the tip of the drill. If you don't have an N drill, a 5/16" (.3125") drill will also work.
4. *It is critical that the insert holes are drilled perpendicular to the face of the heel.* Center one of the holes to be drilled directly under the drill. Place the heel face on a block of wood measuring 2 1/4" long x 3/4" wide x 1 1/2" tall, that has its edges rounded over. Rounding the edges is to prevent it from denting the heel face when clamped. You will also need to shim the neck up at around the 12th fret so the heel is level. Adding two blocks along the edges of the heel will help prevent the neck from moving. Use clamps or other hold down method to secure the neck. Drill the 4 marked mounting holes.
5. Countersink the holes with a ball end grinder to just break the hole edge.

Installing the insert nuts: (Do Not Try Use the Insert Slot and a Slotted Screw Driver to Install)

6. Unplug the drill press.
7. Cut off the head of a 1/4-20 x 2" bolt (same thread as the insert nut) and install it in the drill press chuck.
8. Spin two nuts onto the bolt. Thread the insert onto the bolt until it is flush with the bottom. Turn the first jam nut so it is against the insert. Turn the second jam nut so it is against the first and tighten them together using two wrenches. *Note:* At least one of the wrenches needs to be thinner than the nut for later removal.
9. Center one of the neck holes directly under the insert and clamp the neck down with the heel face on the riser block. As with the drill hole, the insert nuts must also be installed perpendicular to the heel face. You cannot rely on the drill hole to guide the insert. Applying downward pressure on the drill press arm, advance the insert into the hole until it just contacts. Turn the chuck slowly, by hand, while continuing to apply downward pressure on the drill press arm, so that the insert screws into the wood. Keep turning the chuck until the insert is fully inserted.
10. Back off the nut using a wrench and reverse the spin of the chuck so the bolt spins out. If the insert is not perfectly flush with the wood, use a mill file to file it flush. Do not use a slotted screw driver as it may break the insert.