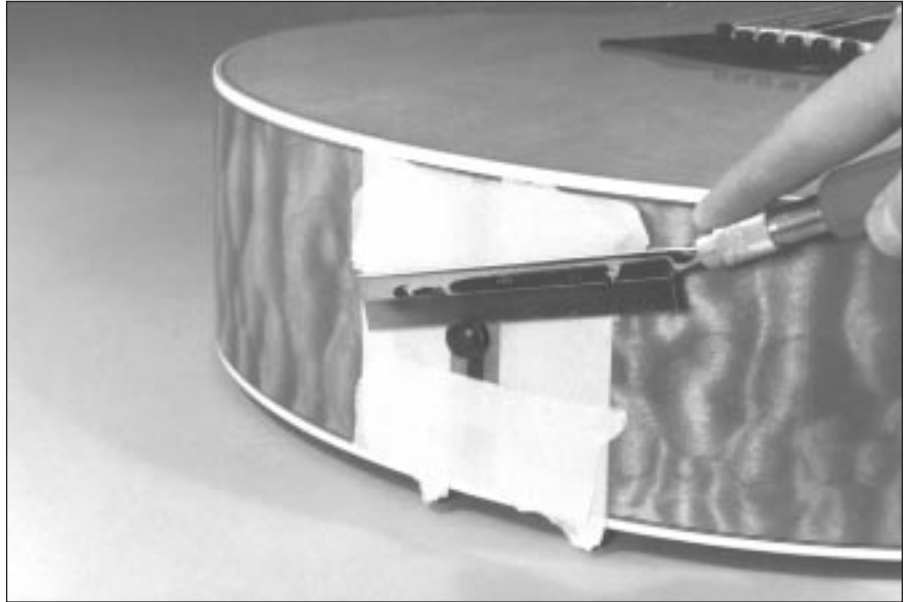


INSTALLATION OF AN END PIN JACK

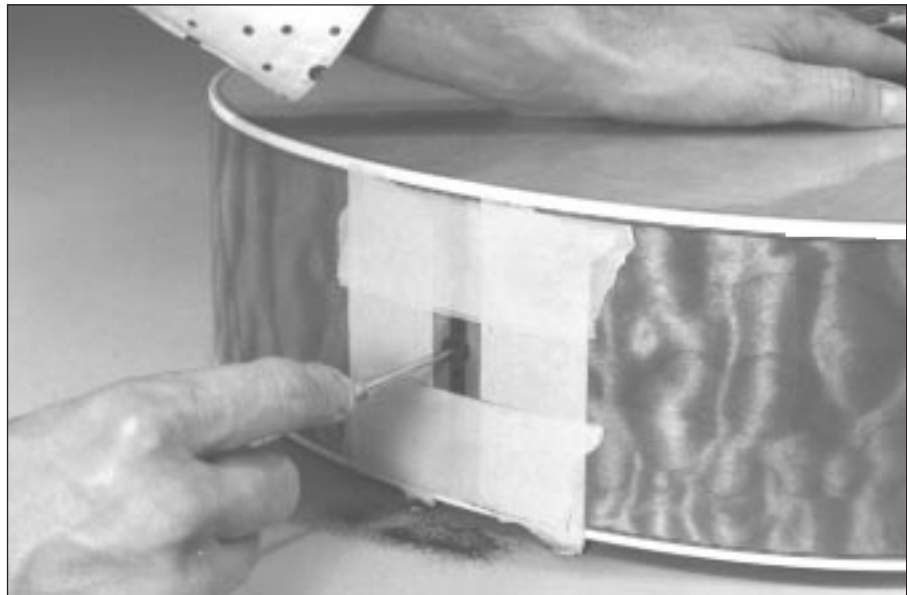
Installing an end pin jack into a guitar that already has a tapered wooden end pin requires special attention. By following the steps outlined below, you can produce a very clean hole with very little risk of damaging the guitar. If you do not feel comfortable with this procedure, it would be wise to consult your local repair person.

1. Do not remove the wooden end pin. Instead, saw it off with a fine tooth X-acto saw. Do not try to cut flush with the body or you may damage the finish. Cut about 1/16-inch away from the body. Apply masking tape around the area to protect the finish before you start.



1.

2. Use a scribe to center punch the end pin plug exactly on center. This will provide a guide for drilling the pilot hole.



2.



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INSTALLATION OF AN END PIN JACK (continued from page 1)

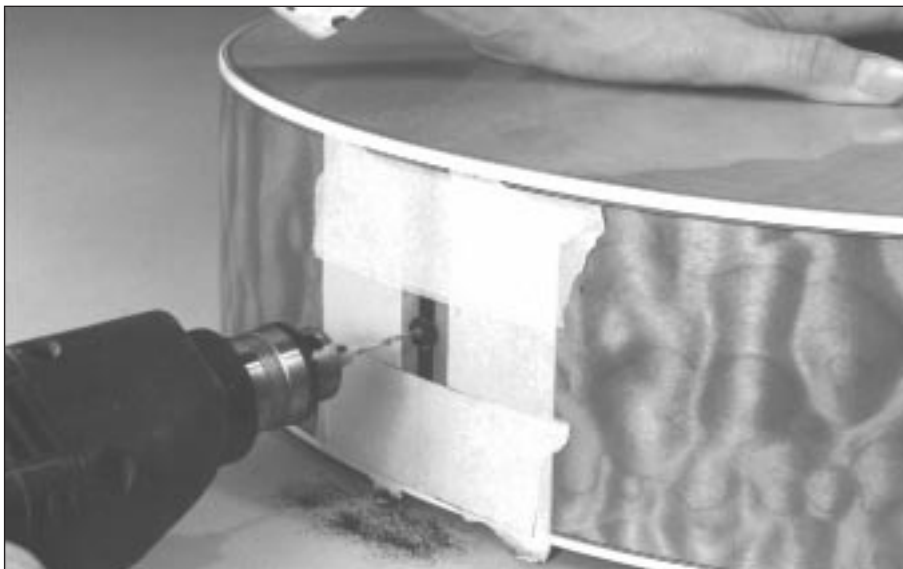
3. Drill a pilot hole with a 1/8" drill straight with the center line of the top and square with the sides.

4. Place a spade bit in the pilot hole (we use a 1/2-inch bit with the edges ground down to 15/32-inch). Drill the hole, keeping square to the body at all times. Ease up on the feed pressure a little as the drill breaks through the other side.

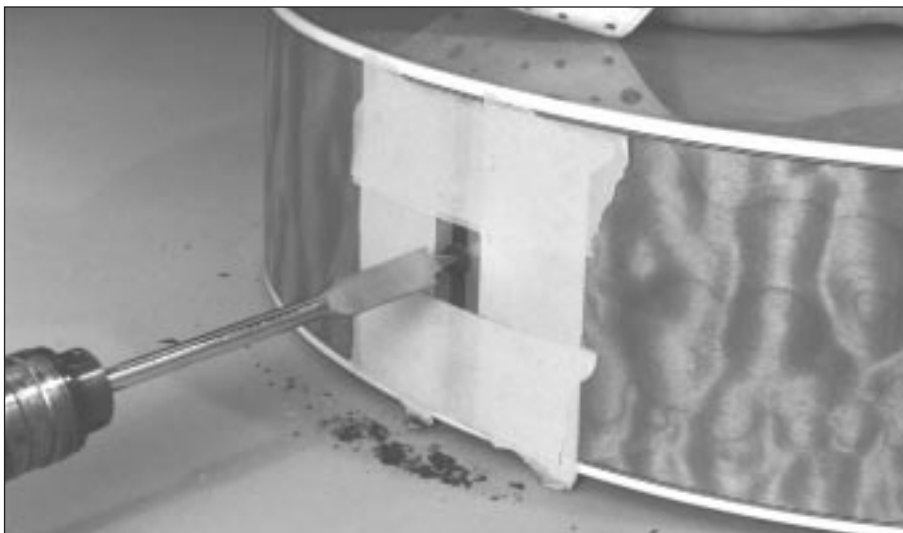
A 1/2-inch Forstner bit from your local hardware store may also be used with good results.

**IMPORTANT!
PUSH THE DRILL ALL THE WAY THROUGH AND LET IT COME TO A COMPLETE STOP BEFORE RETRACTING IT OUT OF THE HOLE.**

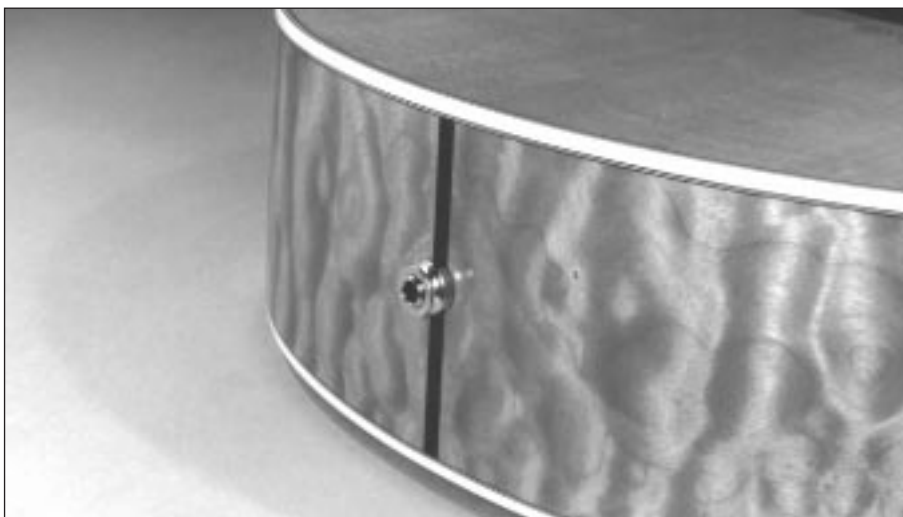
5. Remove debris from the hole and the inside of the guitar. Install the end pin jack.



3.



4.



5.



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