

Guitar # _____ Type _____ Top _____ Sides _____ Ser# _____

- Joint the top halves
- Glue up top
- Tap test top
- Thickness top to .110" (.100 pre-war Adi top)
- Choose back centerpiece
- Choose which back sides will be the outside
- Joint the back halves
- Glue up back
- Thickness back to .100" (.090 pre-war)
- Glue back brace spline (vacuum press)
- Layout bridge – 25.4" (use template or neck Block w/dowels to trace location to top)
- Layout top braces
- Radius top X braces
- Notch braces if required
- Glue top braces - tape down braces, vacuum press (go bar for HHG build)
 - Pre-war: glue tone bars, finger braces, bridge plate and UTB on flat board
 - Pre-war: glue x braces 25' dish
 - Pre-war: glue neck block support brace after top is glued on
- Cut sides and thickness between .080" and .085" (.075 pre-war)
- Bend sides (see bending instructions)
- Measure and cut sides on centerlines (use frame as guideline)
- Angle both inside ends of sides (use side jig)
- Radius neck and tail blocks 30' (pencil line sand until gone)
- Locate center points of blocks (for neck use the center of the heel and square to block)
- Glue up sides and blocks in frame (line up block and side centers, check grain orientation)
- Sand top side flat (mark w/chalk sand until gone)
- Sand back side 12" radius (mark w/chalk sand until gone)
- Glue in kerfing (leave slightly proud, pre-war glue in ribbon before kerfing)
- Layout back braces on back spline
- Radius back braces 12' (pencil line sand until gone)
- Cut slots for back braces (use razor to score spline chip out and scrap clean with 1/4" chisel)
- Glue back braces – tape down, vacuum press
- Sand back 12' radius
- Sand top flat
- Sand in top slope
- Scallop tone braces w/chisel and finger plane
- Remove excess dried glue on top and back
- Measure and cut side braces (6)
- Glue and clamp side braces
- Remove excess dried glue
- Cut, nip (if necessary) and press fret wire to fingerboard
- File fret ends level to side of fingerboard
- Glue and clamp fingerboard to neck (approx. 12 clamps)

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- Scrap glue off fingerboard
- Mark top braces for trim and tuck*
- Trim w/backsaw*
- Trim top to shape on band saw*
- Glue and clamp top*
- Clean up glue squeeze out *
- Final voicing
- Measure and glue in neck block support brace
- Glue and clamp back *(same steps as above for back)
- Sand/scrape sides
- Rout binding and purfling channels
- Check channels (square and widen as necessary)
- Install bindings and purfling
- Scrap binding and purfling flush
- Sand top (100, 150, wet/dry, 150, wet/dry, 220, wet/dry, 220, wet/dry, 320)
- Spray top to seal before sanding sides and back
- Sand side and back same as in step 52
- Pore fill (SB-112) filler, let dry overnight, repeat as necessary
- Sand epoxy w/240 grit paper
- Wipe down with Naptha
- Finish spray box (Tape off neck extension location and bridge area)
- Inlay fret marker on neck (hand drill to size)
- Cut nut slot
- Make nut
- Cut out neck slot (flush rout out)
- Glue nut
- File frets (mark and level, 22 1/2°, crown, sand 320, steel wool 0000)
- Tape off Finger board, and then finish (spray or tru-oil)
- Wet sand and buff the box and neck
- Remove tape on extension & FB
- Scrap off lacquer, glue neck
- Radius bridge 25'
- Locate bridge - (place down green tape, draw extension of fret board sides, locate center line, measure and mark bridge location), drill holes in outside pin locations w/#11 bit
- Cut bridge position out of tape, remove lacquer with chisel
- Glue and clamp bridge
- Make saddle
- Ream end pin hole, fasten end pin (or install pickup)
- Install tuners – position and drill 10mm holes, insert posts, hold down w/screws, tighten nut post, retighten screws
- String and tune it up
- Play
- Have a shot of Scotch