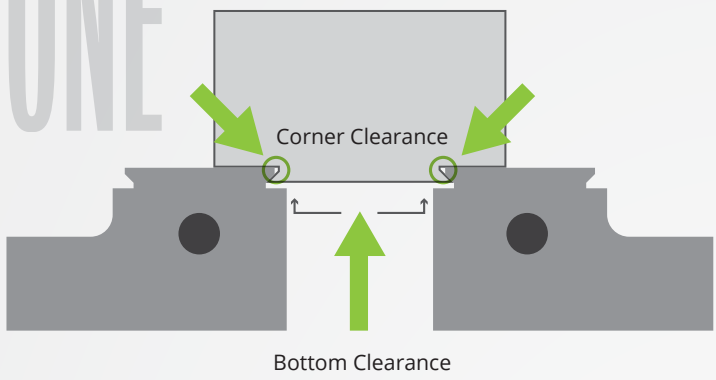


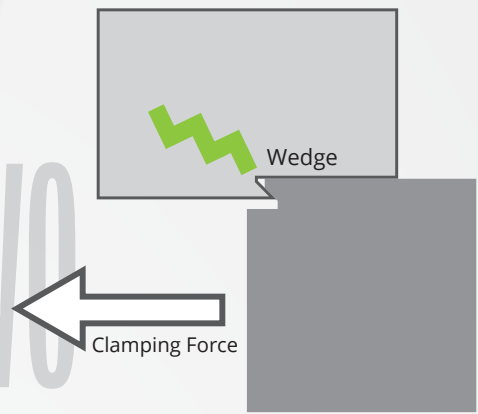
# PROPER DOVETAIL USAGE

ONE



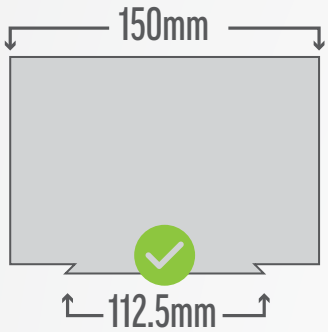
**1.** Material should rest on top of the jaw/fixture and on the 45° face.

TWO



**2.** Proper dovetails act as a wedge trying to split the material in the corners.

Material is only clamped once or twice and therefore is resistant to fracturing.

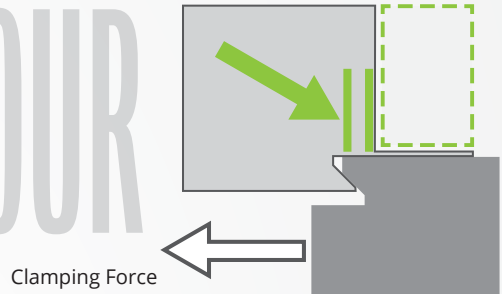


THREE

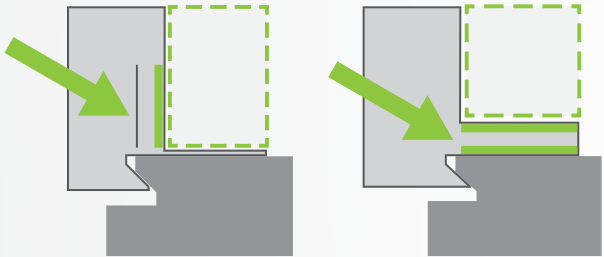
**3.** The recommended dovetail width should not be less than 75% of the width of the stock.

This is a general ratio, not a rule. If in doubt, use 75% of the stock width.

FOUR



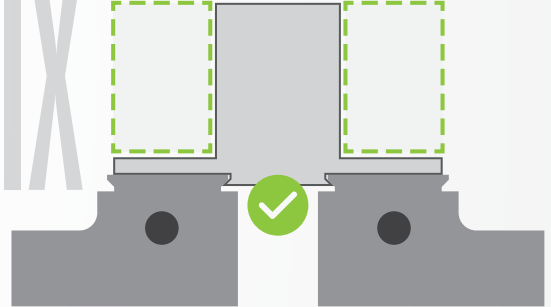
**4.** Dovetail width should be narrow enough to support the part after material is removed.



**5.** If more support is needed, decrease dovetail width or increase tab thickness.

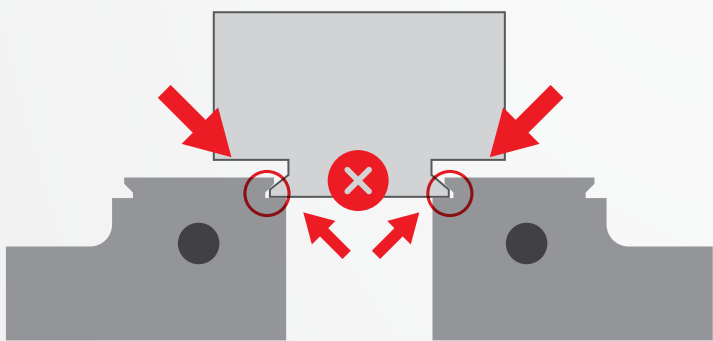
FIVE

SIX



**6.** For narrow parts, position the dovetail as close as possible to the finished parts center of mass.

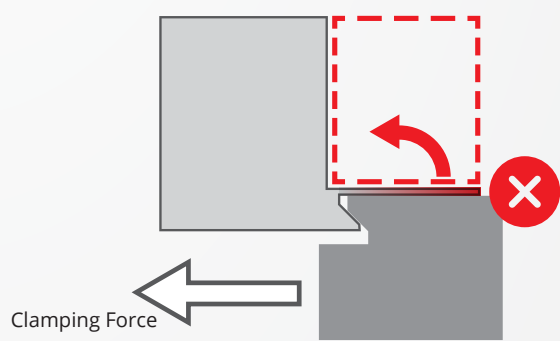
## COMMON MISTAKES



### **Dovetail Too Deep**

Clamping with a dovetail should never cause the material to locate on the bottom step of the jaw and on the 45° face.

Locating on the bottom step causes the material to become a wedge trying to split the jaw. **This can break the jaw!**



### **Finished Part Unsupported**

A thin tab and/or insufficient material on the top locating surface will allow the part to move during machining.

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[www.HaasTooling.com](http://www.HaasTooling.com)