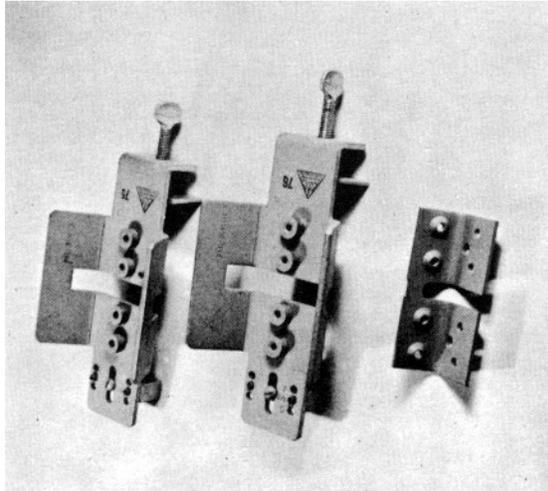


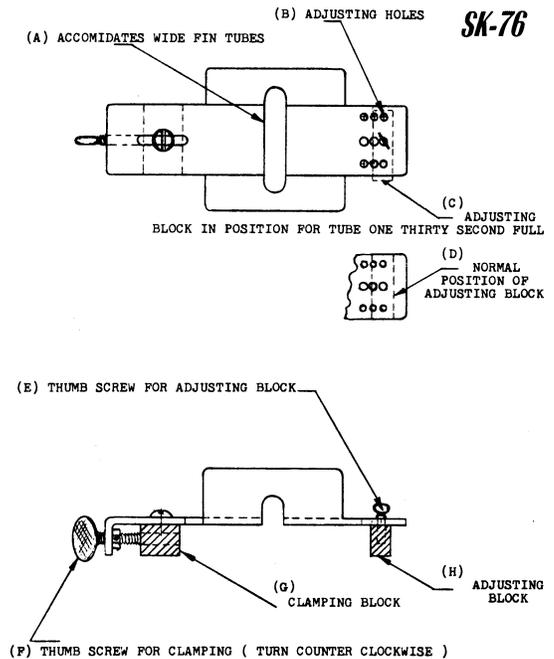
## SECTION H - BRACKETS AND DRILL JIGS

BRACKETS	DRILL JIGS	MISCELLANEOUS INFORMATION	PAGE
80	75 & 76	ADJUSTABLE JIG	H-2
80	40 & 45		H-3
80 84 84 RH 81	40 & 45 THRU 75 & 76 38 C & 39 C 38 A, 39 AR & 39 AL 10 & 15 THRU 75 & 76		H-4
36		4" DOVETAIL TUBE	H-6

NOTE - SEE SPECIFIC PAGE FOR FULL PART NUMBER BEFORE ORDERING.



R-A-S Brackets and Drill Jigs  
covered by U.S. Patents  
3046818 & 3047110.



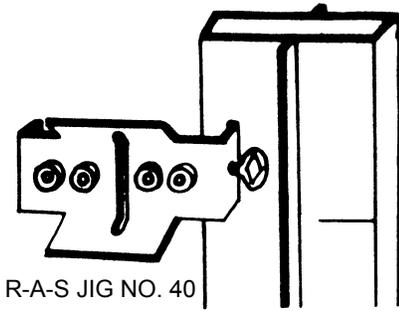
THE ADJUSTING BLOCK ( POSITION B AND C ) CAN BE REVERSED ON THE JIG. WHEN THIS IS DONE THE DRILL BUSHING HOLES WILL BE CENTERED ON A TUBE THAT IS FULL BY AS MUCH AS A THIRTY SECOND. ©1961

# NEW ADJUSTABLE DRILL JIGS

SAVE TIME, MONEY, AND ACCURACY ON STORE FRONT FABRICATION

R-A-S Industries, the originator of the patented drill-jig, and system for extrusion fabrication has now developed an all new adjustable drill jig for store front fabrication. Easily adjustable to 4", 4½", and 5" aluminum extrusions, the new R-A-S drill jig No.'s 75 and 76, and the No. 80 Bracket enable you to save time, money and accuracy with the one set of 2 drill-jigs pictured above — *eliminating the three sets (6 jigs) previously required!* The method of securing the jig to the extrusion gives up to 800% more gripping power. The gripping pad is reversible giving a plus or minus of 1/32" to take care of the difference in extrusion tolerances. The new jigs are formed from 3/16" steel with case hardened drilling holes clearly marked for drilling size. One set of the new adjustable drill-jigs is approximately 1/3 the cost of the three sets previously required.

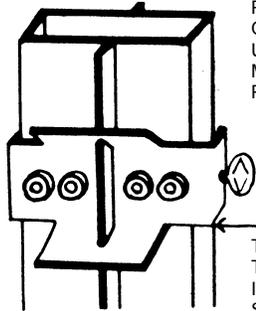
**R-A-S MANUFACTURES DRILL JIGS AND BRACKETS  
FOR ALL TYPES OF ALUMINUM EXTRUSIONS**



R-A-S JIG NO. 40

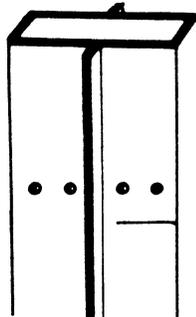
FOR HORIZONTAL BUTT JOINT INTO A VERTICAL TUBE

MEASURE UP THE VERTICAL TUBE TO WHERE THE BOTTOM OF THE HORIZONTAL TUBE WILL BUTT IT AND DRAW A LINE.



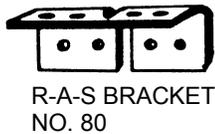
PLACE THE R-A-S NO. 40 JIG ON THE VERTICAL TUBE. SLIDE UP UNTIL BOTTOM OF THE JIG MATCHES UP WITH THE LINE PREVIOUSLY DRAWN.

TIGHTEN THE THUMB SCREW ON THE END OF THE JIG. (THE JIG IS REVERSIBLE SO THAT THE THUMB SCREW CAN BE USED ON THE LEFT OR THE RIGHT).

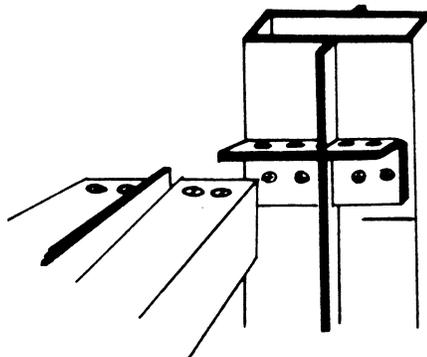


USING THE BUSHINGS AS GUIDES, DRILL FOUR HOLES FOR NO. 10 SELF-TAPPING ROUND HEAD SCREWS.

PLACE THE R-A-S NO. 80 BRACKET SO THAT THE CLEARANCE HOLES LINE UP WITH THE HOLES DRILLED AND FASTEN WITH THE NO. 10 SELF-TAPPING SCREWS.

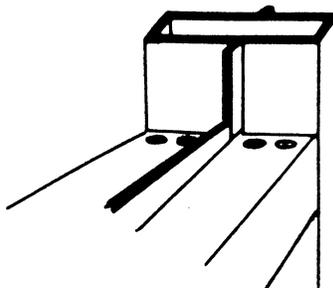


R-A-S BRACKET NO. 80



FOR HORIZONTAL TUBE ATTACHMENT, SEE INSTRUCTIONS UNDER USE OF THE R-A-S JIG NO. 45

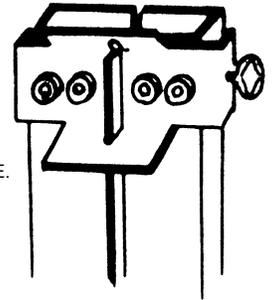
COMPLETED HORIZONTAL BUTT JOINT INTO A VERTICAL TUBE.



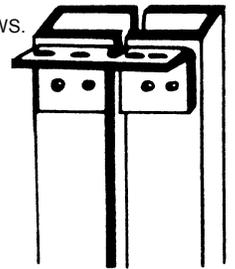
WHERE VERTICAL TUBES BUTT INTO HORIZONTALS, REVERSE THE PROCEDURE.

FOR A HEADER JOINT INTO A VERTICAL TUBE

SLIDE THE R-A-S JIG NO. 40 TO THE TOP OF THE VERTICAL TUBE. LINE UP JIG WITH TOP OF TUBE. HOLD SECURELY IN PLACE.



TIGHTEN THE THUMB SCREW ON THE END OF THE JIG AND DRILL FOUR HOLES FOR NO. 10 SELF-TAPPING ROUND HEAD SCREWS.



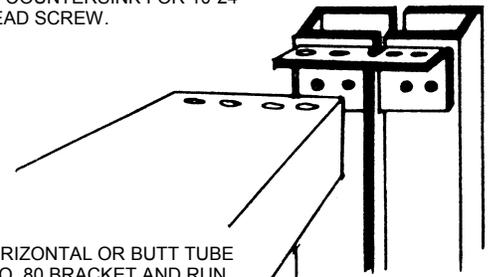
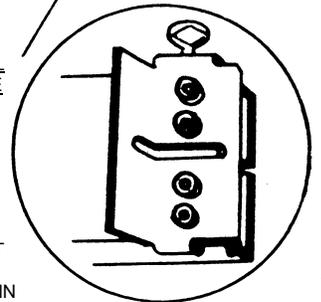
PLACE R-A-S BRACKET NO. 80 SO THAT THE CLEARANCE HOLES LINE UP WITH THE HOLES DRILLED AND FASTEN WITH SELF-TAPPING SCREWS.



R-A-S JIG NO. 45

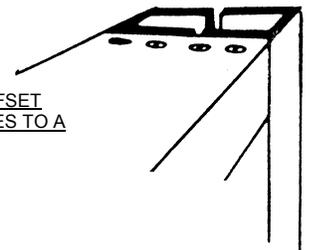
TO ATTACH THE HORIZONTAL OR BUTT TUBE -- USE OF THE R-A-S NO. 45 JIG.

PLACE THE R-A-S JIG NO. 45 ON THE END OF THE HORIZONTAL TUBE AND SEAT SECURELY. TIGHTEN THUMB SCREW (SEE HEAD ON VIEW IN CIRCLE). USING BUSHINGS AS GUIDES, DRILL WITH #9 DRILL -- REMOVE JIG AND COUNTERSINK FOR 10-24 FLAT HEAD SCREW.



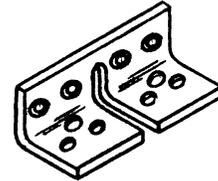
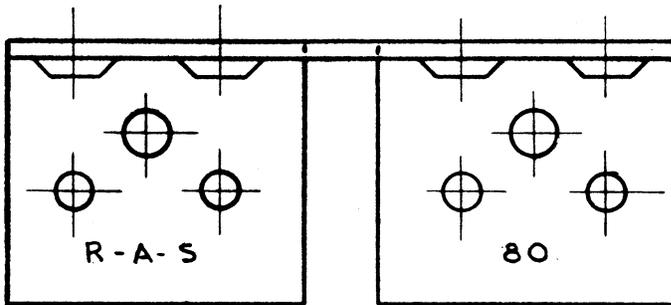
SLIP HORIZONTAL OR BUTT TUBE OVER NO. 80 BRACKET AND RUN 10-24 FLAT HEAD SCREWS HOME THROUGH THE TAPPED HOLES.

NOTE: THE DRILL JIG IS OFFSET ENOUGH TO DRAW UP TUBES TO A HAIRLINE JOINT.



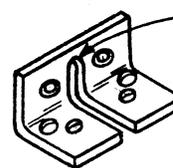
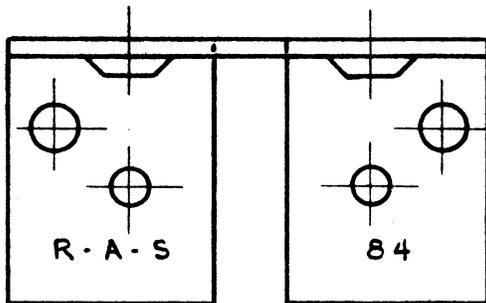
NOTE: THE USE OF THE R-A-S JIGS AND BRACKETS PROVIDE A MORE ECONOMICAL MEANS OF CONSTRUCTION.

BRACKETS AND JIGS COVERED BY U.S. PATENTS 3046818 & 3047110,  
 ALSO CANADIAN PATENTS 665838 & 679198.



#80 BRACKET FOR USE ON 4 TO 5" PLAIN OR FIN TYPE TUBE.

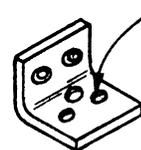
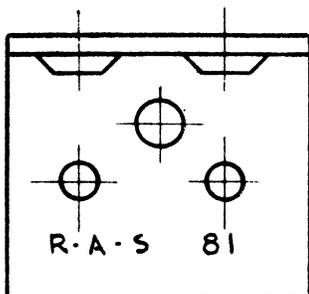
USE R-A-S DRILL JIGS # 40 & 45, 50 & 55, 60 & 65, OR 75 & 76. SEE REFERENCE CHART - PAGE H-13



FIN SLOT  
 $\frac{5}{8}$  HIGH

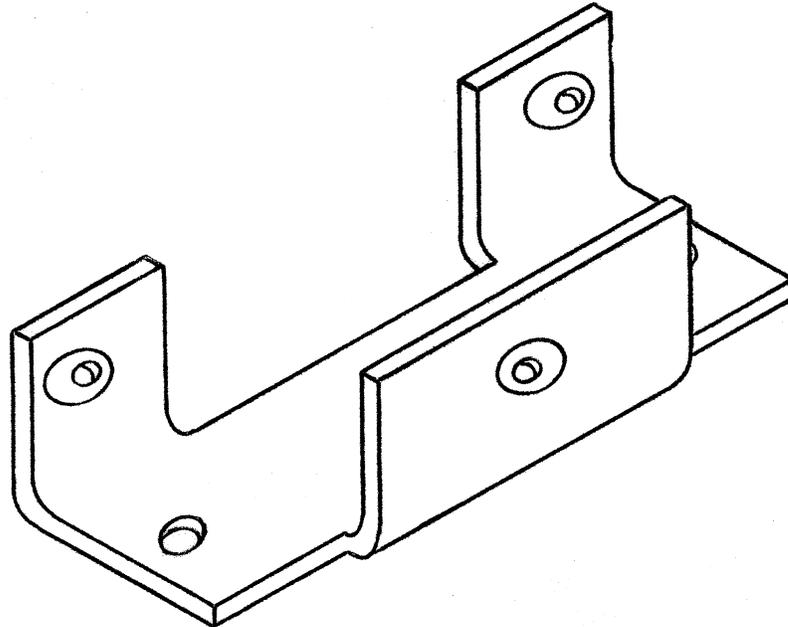
#84 BRACKET FOR USE ON 3" PLAIN OR FIN TYPE TUBE.

USE R-A-S DRILL JIGS # 38C & 39C.



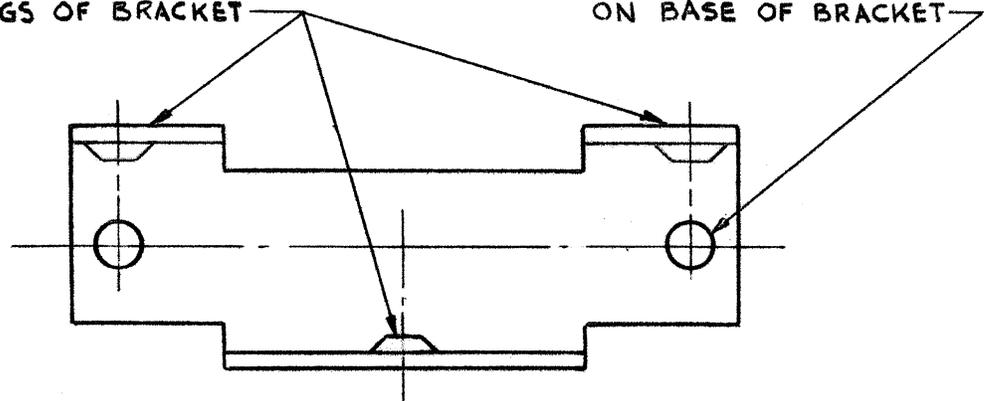
ALL CLEARANCE HOLES FOR #10 SCREW.

# 81 BRACKETS ARE FOR SPECIAL APPLICATION. USE R-A-S DRILL JIGS 40 & 45, 50 & 55, 60 & 65, 75 & 76, 10 & 15, 20 & 23 OR OTHER SPECIAL JIGS SEE REFERENCE CHART - PAGE H-13



3 HOLES DIMPLED & TAPPED  
12-24 ON LEGS OF BRACKET

2 CLEARANCE HOLES  
FOR 1/4" SCREW  
ON BASE OF BRACKET



# 36 BRACKET FOR 1/8 WALL 4" WIDE DOVETAIL TUBE  
USE R-A-S DRILL JIGS N<sup>o</sup> 30 AND 35

R-A-S Brackets and Drill Jigs covered  
by U.S. Patents 3046818 & 3047110.