

**INSTRUCTIONS**  
**RIGHT ANGLE JIG WELD PLAN**  
**90 DEGREE JIG**

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**MATERIALS REQUIRED:**

(20 IN) 2X2X1/4" Angle Steel

(10 IN) 2X1/4" Flat Bar Steel

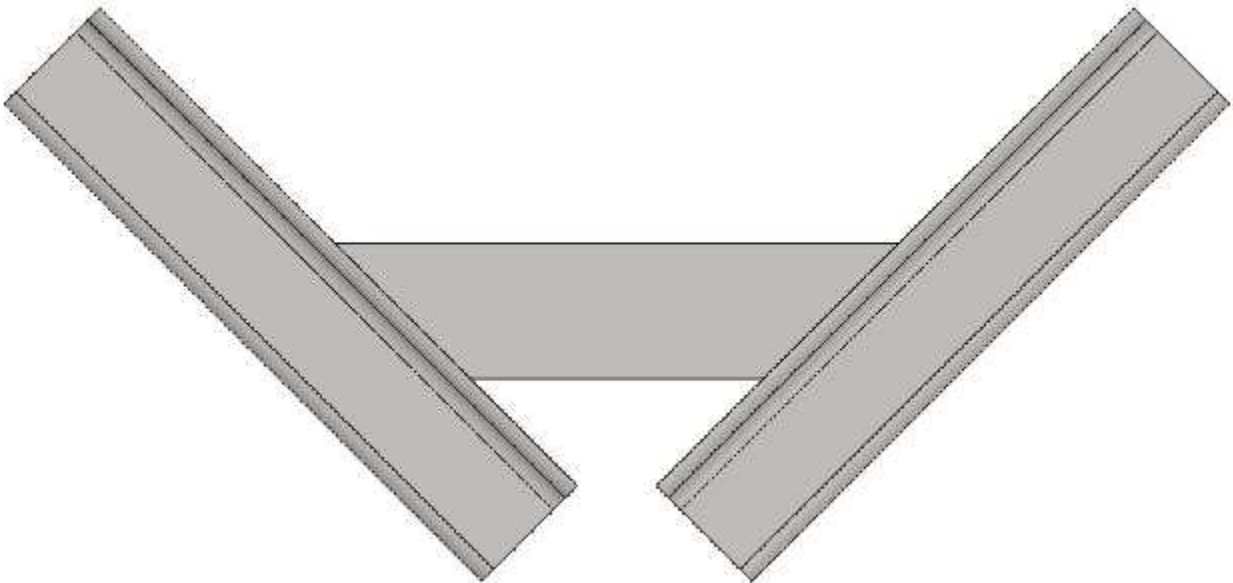
**INSTRUCTIONS:**

**Step 1**

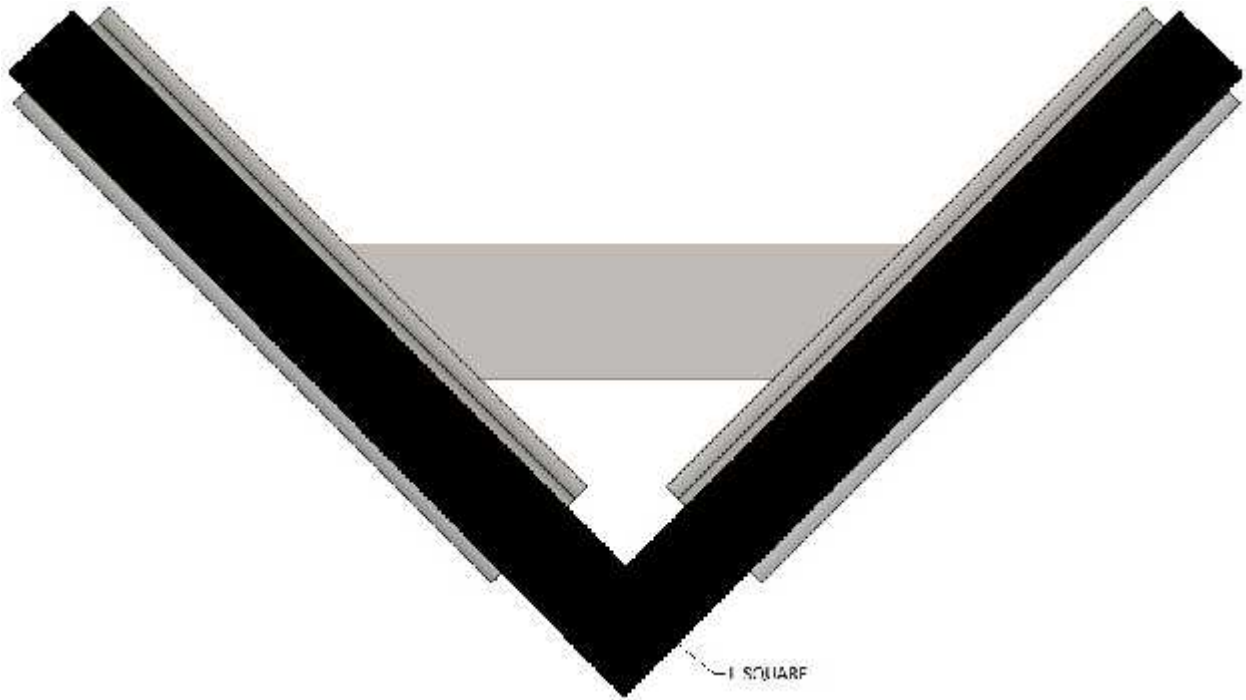
Cut two pieces of angle steel and one piece of flat bar according to their attached drawing CUT SHEET.

**Step 2**

Gather parts and lay them out on the welding surface. Position them according to drawing 90 DEGREE JIG. Use a 90 degree L-square to clamp the pieces in place as shown below. Tack weld pieces in place. Check alignments and complete the welds.

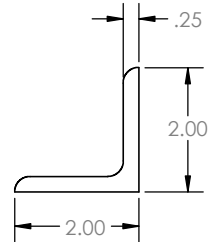
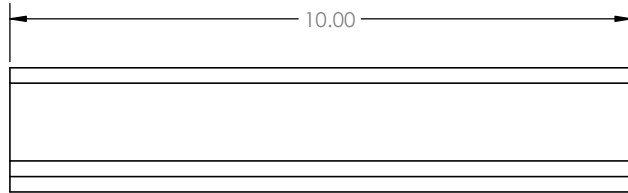


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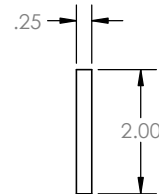
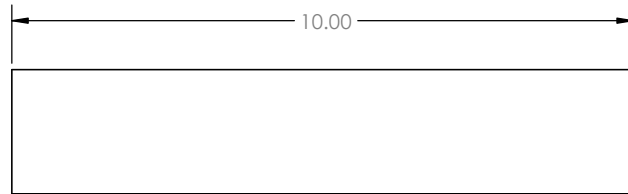


Jig can be used for welding pieces of various sizes together. If extremely large or extremely small stock needs to be welded at a 90 degree angle, this basic format can be used to make a customized jig.

2X2X0.25X10" ANGLE STEEL QTY:2



2X0.25X10" FLAT ANGLE STEEL QTY:1

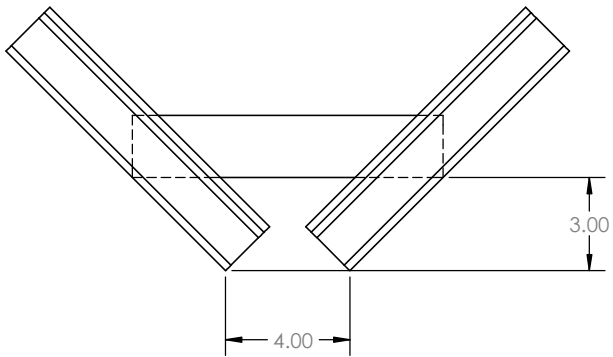
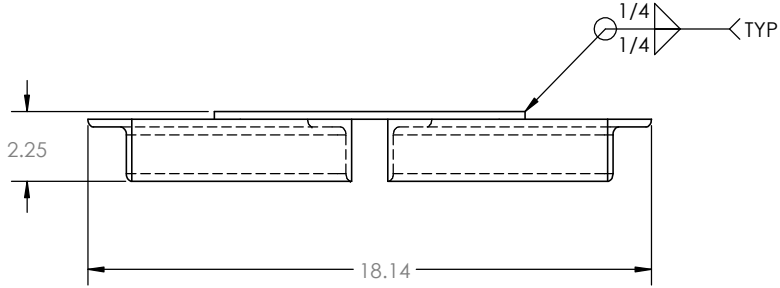


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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES		DRAWN	JJK	7/6/14	TITLE:  <b>90 DEGREE JIG CUT SHEET</b>
		TOLERANCES:		CHECKED			
		FRACTIONAL ±		ENG APPR.			
		ANGULAR: MACH ± BEND ±		MFG APPR.			
		TWO PLACE DECIMAL ±		Q.A.			
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL					SIZE
NEXT ASSY		USED ON					DWG. NO.
		FINISH					2X2X0.25X10 ANGLE
		APPLICATION					REV
		DO NOT SCALE DRAWING					1.0
				SCALE: 1:2		WEIGHT:	SHEET 1 OF 1

8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2.000X0.250X10.00 FLAT BAR		1
2	2X2X0.25X10 ANGLE		2



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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: <b>90 DEGREE WELDING JIG</b>	
		DIMENSIONS ARE IN INCHES		DRAWN	JJK		7/6/14
		TOLERANCES:		CHECKED			
		FRACTIONAL ±		ENG APPR.			
		ANGULAR: MACH ± BEND ±		MFG APPR.			
		TWO PLACE DECIMAL ±		Q.A.			
		THREE PLACE DECIMAL ±		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL				SIZE <b>B</b>	
		FINISH				DWG. NO. <b>90 DEGREE JIG</b>	
NEXT ASSY	USED ON					REV <b>1.0</b>	
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:4	
						WEIGHT: 7 LBS	
						SHEET 1 OF 1	

8 7 6 5 4 3 2 1