

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Jig Weldment		1
2	caster		4
3	parts tray		1
4	Axle Fixture		1
5	Neck Fixture		1
6	Rail Fixture		1
7			1
8	CB34_FRAME		1

These plans are freely available from Crime Scene Choppers, they outline the construction of our frame jig as shown in Ron Covell's new "Building a Chopper Chassis" video.

Few of the dimensions or material callouts are critical. The width of part #6, the frame rail fixture, is determined by the outside width of your lower frame rails. Typically, the inside width is 8 3/8", so the outside width is 8.375 + 2 \* the diameter of your frame tubing.

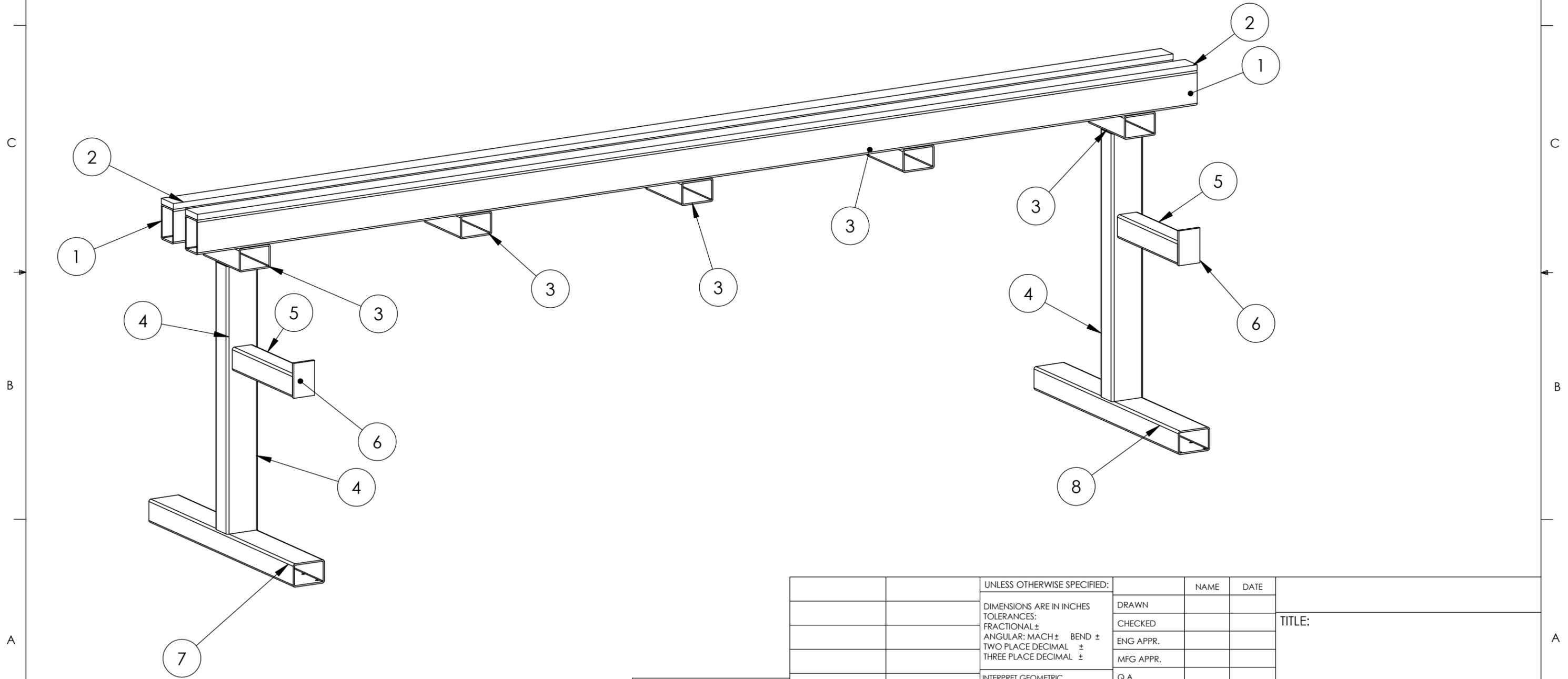
Check the alignment of your parts carefully as you work, a warped jig is worse than no jig at all!

<http://www.crimescenechoppers.com>

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		DIMENSIONS ARE IN INCHES	DRAWN		TITLE:	
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		ANGULAR: MACH ± BEND ±	MFG APPR.			
		TWO PLACE DECIMAL ±	Q.A.		SIZE DWG. NO. REV	
		THREE PLACE DECIMAL ±	COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:				SCALE: 1:10 WEIGHT: SHEET 1 OF 10
		MATERIAL				
NEXT ASSY	USED ON	FINISH				
APPLICATION		DO NOT SCALE DRAWING				

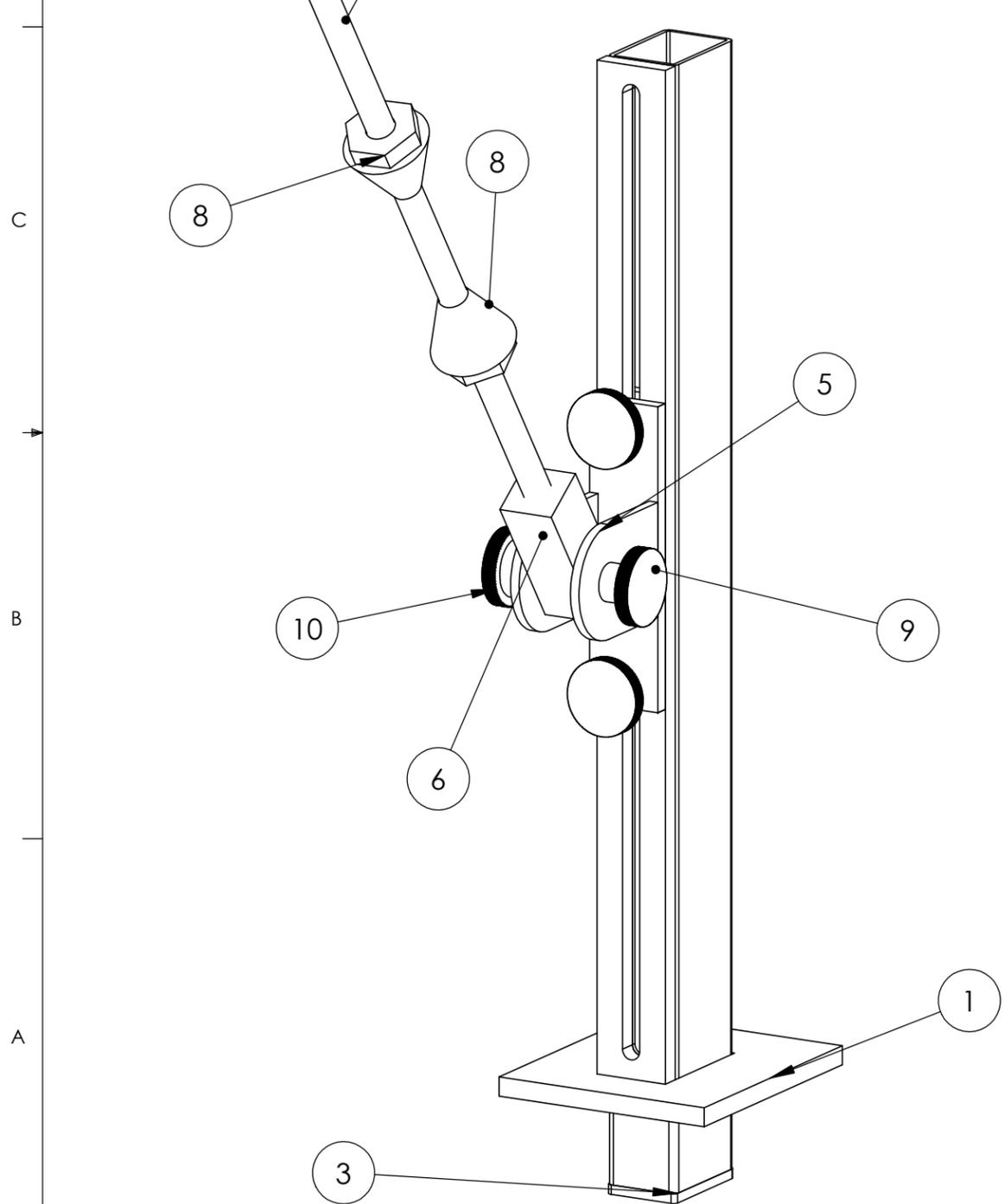
ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	2	TUBE, RECTANGULAR 3.00 X 2.00 X .13	96
2	2	BAR STOCK, RECTANGULAR .5 x 2 Flat Bar	96
3	5	TUBE, RECTANGULAR 3.00 X 2.00 X .13	6
4	2	TUBE, RECTANGULAR 3.00 X 2.00 X .13	23
5	2	TUBE, SQUARE 2.00 X 2.00 X .13	10
6	2	BAR STOCK, RECTANGULAR 0.25 x 2 flat bar	3
7	1	TUBE, RECTANGULAR 3.00 X 2.00 X .13	24
8	1	TUBE, RECTANGULAR 3.00 X 2.00 X .13	24



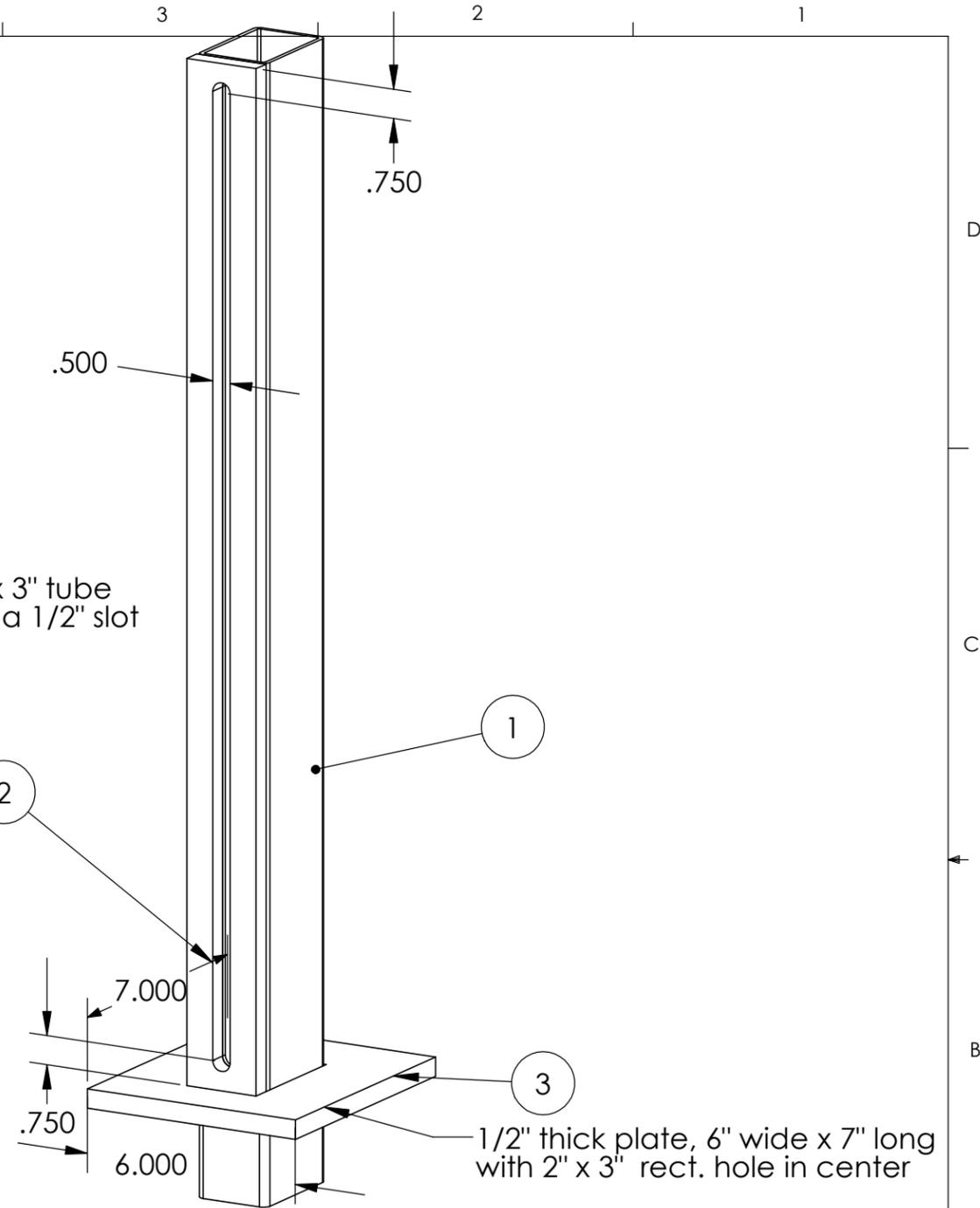
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		THREE PLACE DECIMAL ±	COMMENTS:		
		INTERPRET GEOMETRIC TOLERANCING PER:			
		MATERIAL			
		FINISH			
NEXT ASSY	USED ON				
APPLICATION		DO NOT SCALE DRAWING			
			TITLE:		
SIZE	DWG. NO.			REV	
<b>B</b>	jig				
SCALE: 1:8	WEIGHT:			SHEET 2 OF 10	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Neck Fixture		1
2	Slider Mechanism		1
3	Bolt Plate		1
4	HHNUT 0.5000-13-D-N	1/2"-13 nut welded to top of #3	1
5	Pivot Plate	1.75" x 1.75" square bar stock	2
6	Neck Pivot		1
7	all thread	3/4"-16 threaded rod	1
8	Neck Cone	45 degree cone to hold steering neck	2
9	DKA-13	Reid Tool	1
10	SDKA-13	Reid Tool	1



Stitch weld 2" x .5" flat bar to 2" x 3" tube then set up in mill and machine a 1/2" slot for the length of the tube.



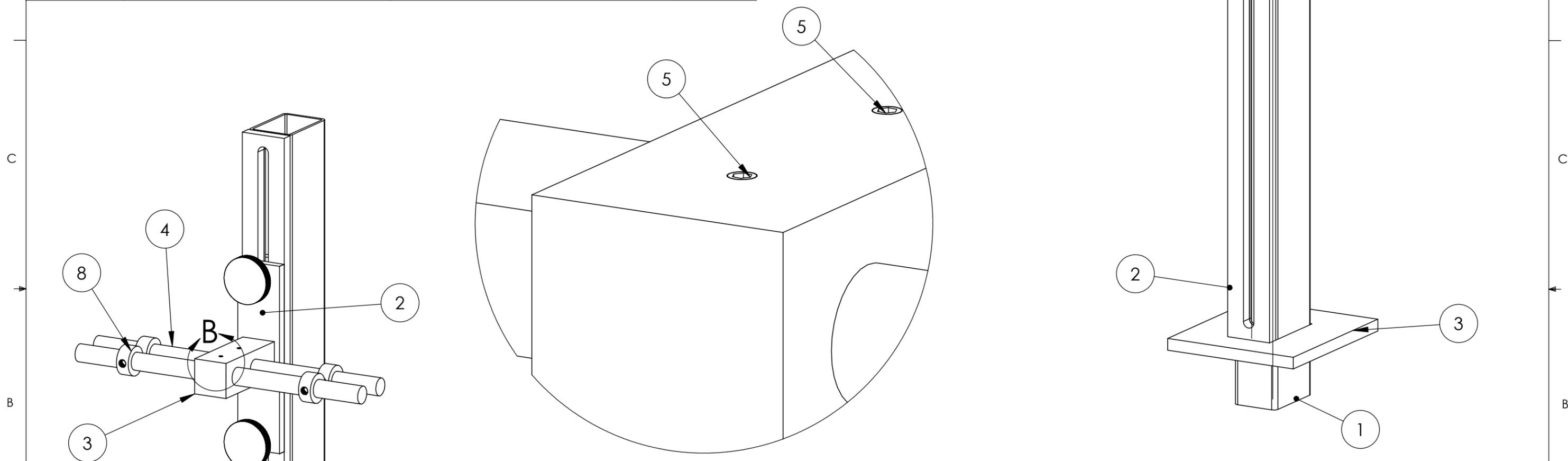
ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	1	TUBE, RECTANGULAR 2 x 3 x .125	29.5
2	1	BAR STOCK, RECTANGULAR .5 x 2 Flat Bar	26.5
3	1		

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ANGULAR: MACH ± BEND ±		MFG APPR.	
TWO PLACE DECIMAL ±		Q.A.	
THREE PLACE DECIMAL ±		COMMENTS:	
INTERPRET GEOMETRIC TOLERANCING PER:			
MATERIAL			
NEXT ASSY	USED ON	FINISH	
APPLICATION		DO NOT SCALE DRAWING	

TITLE:		SIZE	DWG. NO.	REV
		<b>B</b>	jig	
SCALE: 1:4		WEIGHT:	SHEET 3 OF 10	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Axle Fixture		1
2	Slider Mechanism		1
3	axle block		1
4	Axle		2
5	SSCONESKT 0.19-32x0.5-HX-N		2
6	Bolt Plate		1
7	HTNUT 0.5000-13-D-N	1/2"-13 nut welded to inside face of part #6	1
8	LSC-12	Reid Tool	4



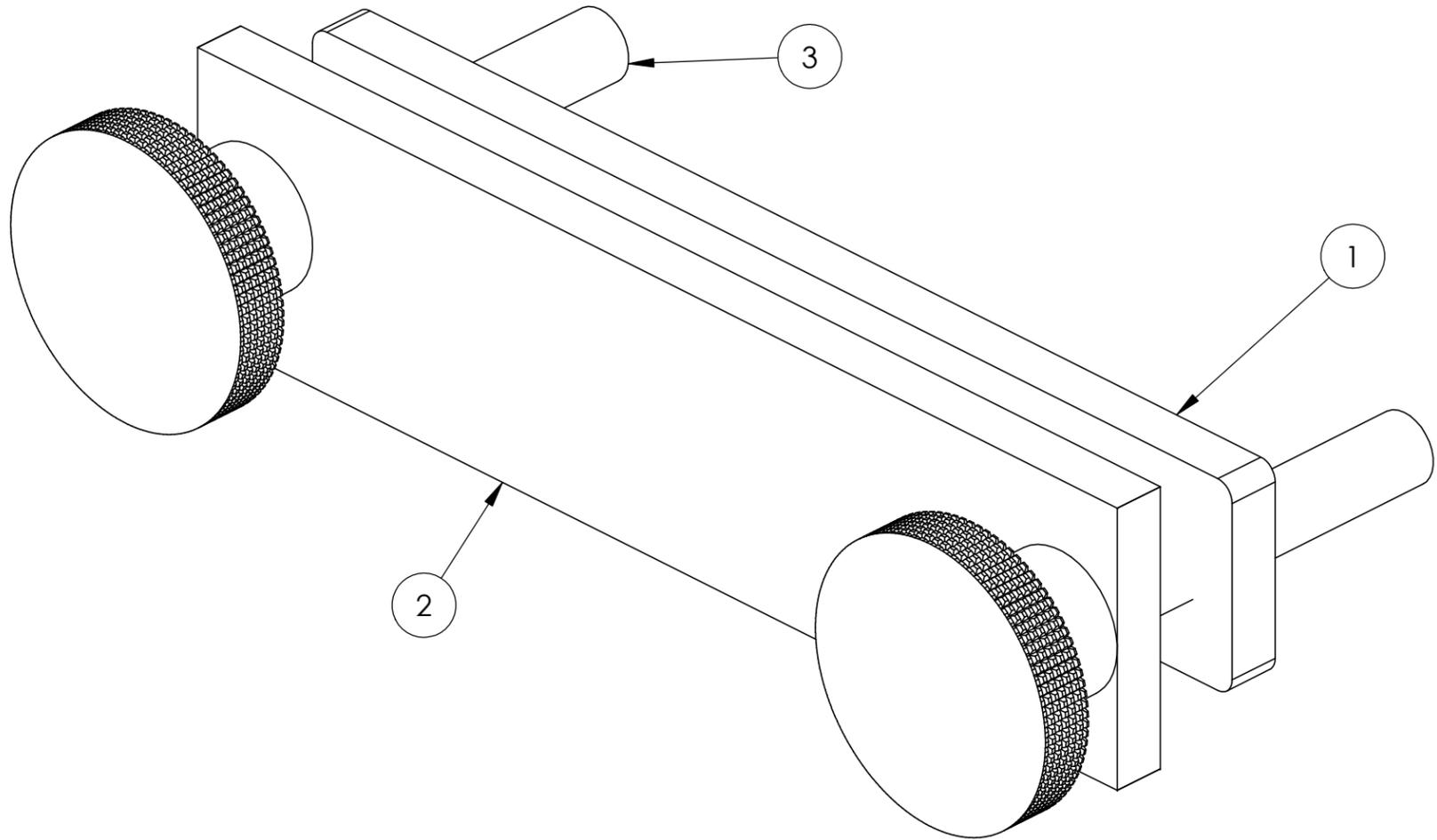
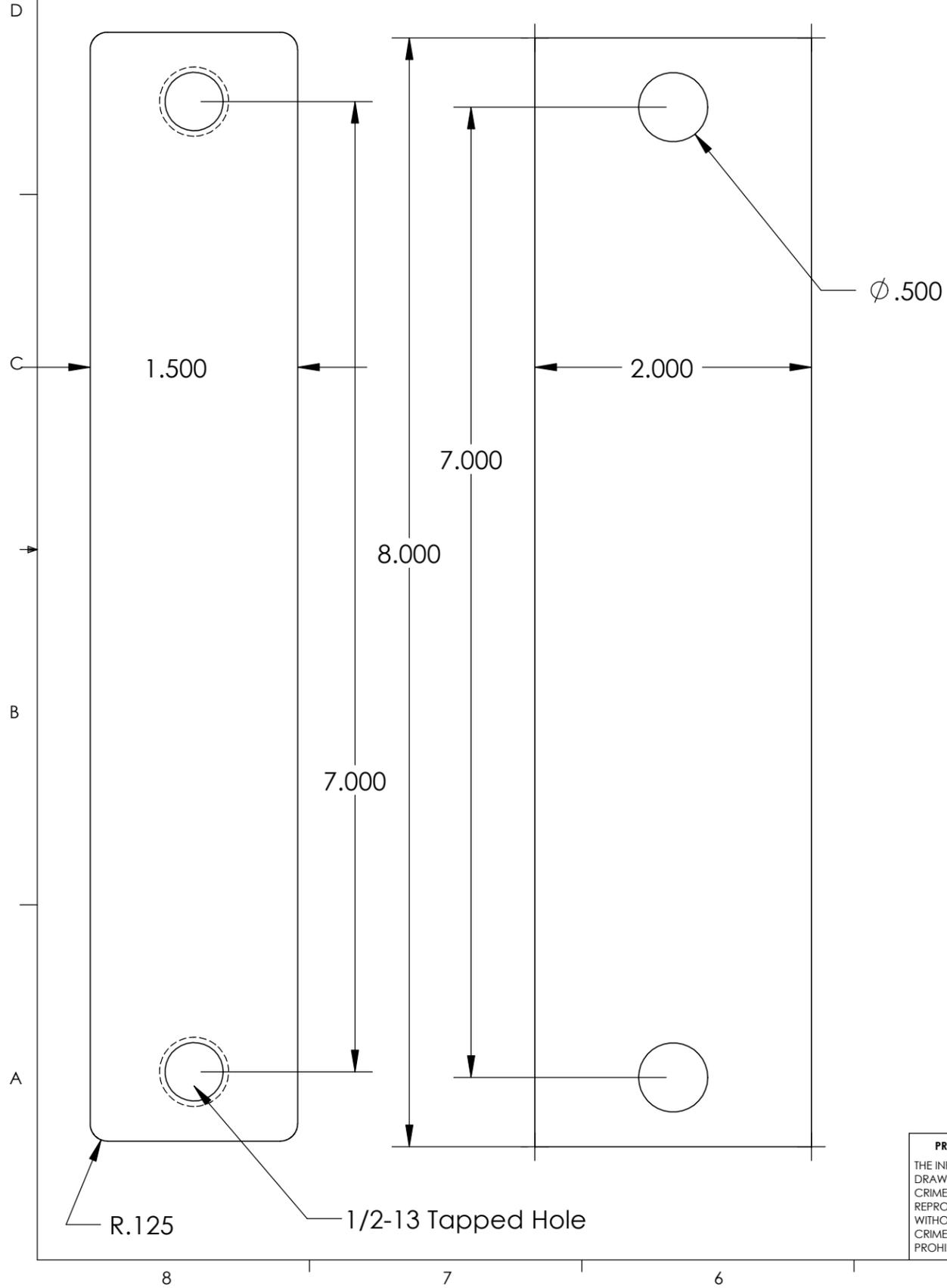
DETAIL B  
SCALE 2 : 1

ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	1	TUBE, RECTANGULAR 2 x 3 x .125	22
2	1	BAR STOCK, RECTANGULAR .5 x 2 Flat Bar	19
3	1		

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		MATERIAL		ENG APPR.	
NEXT ASSY	USED ON	FINISH		MFG APPR.	
APPLICATION		DO NOT SCALE DRAWING		Q.A.	
				COMMENTS:	
		SIZE	DWG. NO.	REV	
		<b>B</b>	jig		
		SCALE: 1:4	WEIGHT:	SHEET 4 OF 10	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Nut Plate		1
2	Slider Bolt Plate		1
3	DKA-15	Reid Tool	2



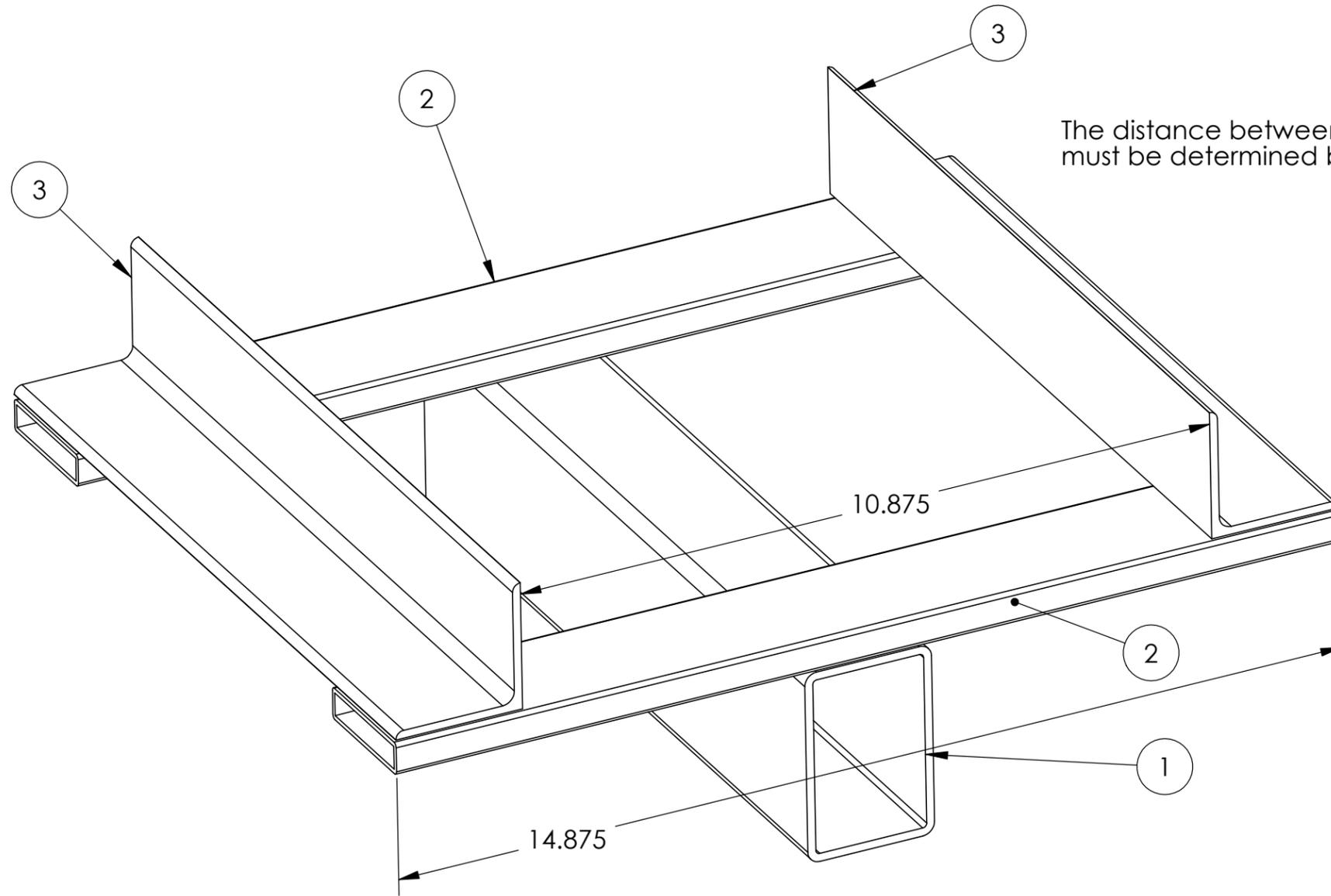
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		ANGULAR: MACH ± BEND ±	MFG APPR.	
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		THREE PLACE DECIMAL ±	COMMENTS:	
		INTERPRET GEOMETRIC TOLERANCING PER:		
		MATERIAL		
		FINISH		
NEXT ASSY	USED ON			
APPLICATION		DO NOT SCALE DRAWING		

TITLE:		
SIZE	DWG. NO.	REV
<b>B</b>	jig	
SCALE: 1:1	WEIGHT:	SHEET 5 OF 10

ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	1	TUBE, RECTANGULAR 3.00 X 2.00 X .13	12
2	2	TUBE, RECTANGULAR 2.00 X .50 X .13	14.88
3	2	L 2.00 X 2.00 X .125	12

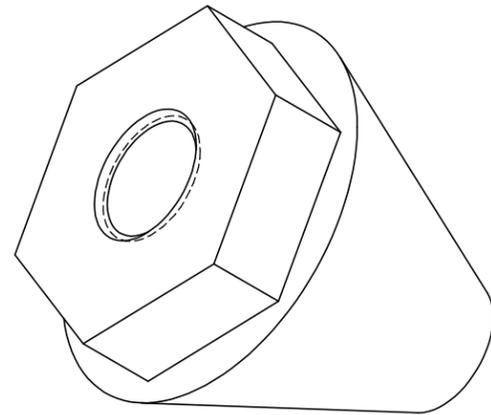
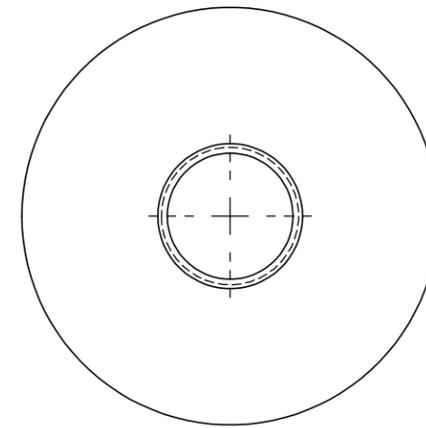
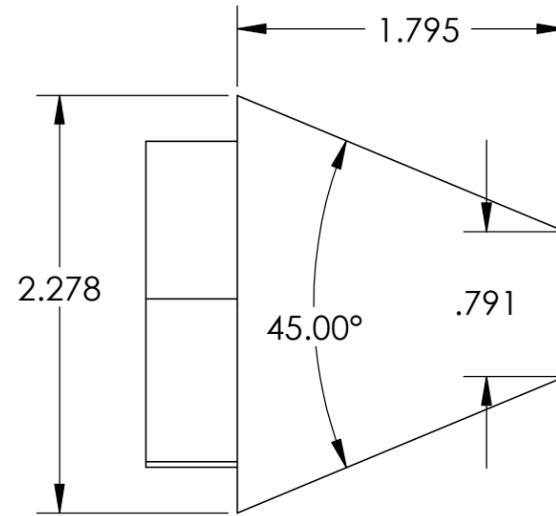
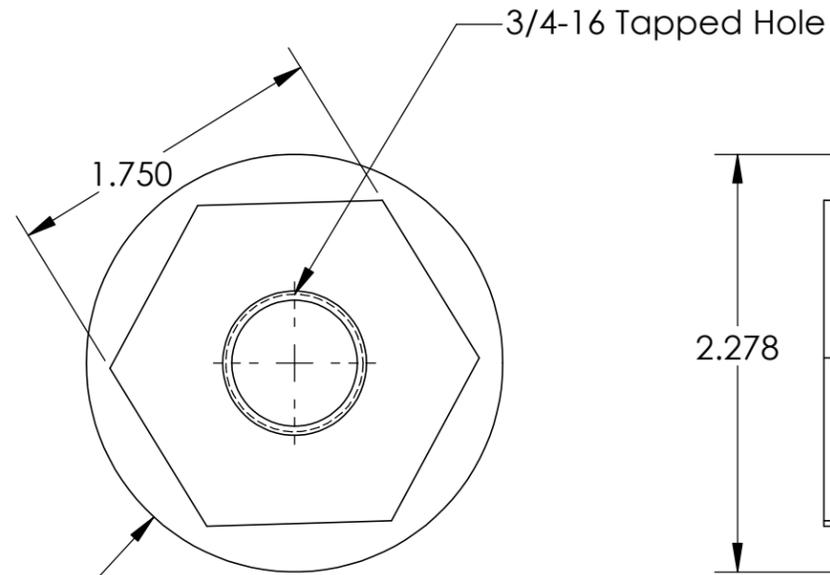
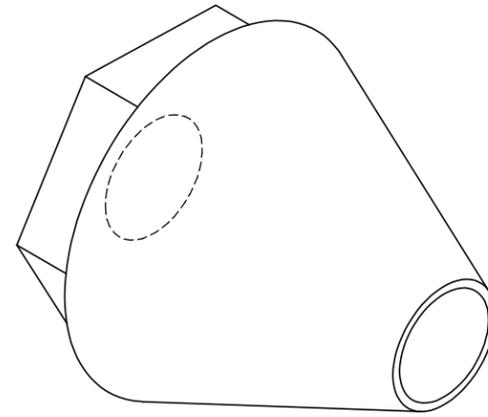


The distance between the angle iron faces (10.875 shown here) must be determined by the outside width of the bottom frame rails.

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		MATERIAL		ENG APPR.	
		FINISH		MFG APPR.	
NEXT ASSY	USED ON			Q.A.	
APPLICATION		DO NOT SCALE DRAWING		COMMENTS:	
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SIZE	DWG. NO.			REV	
<b>B</b>	jig				
SCALE: 1:2		WEIGHT:		SHEET 6 OF 10	

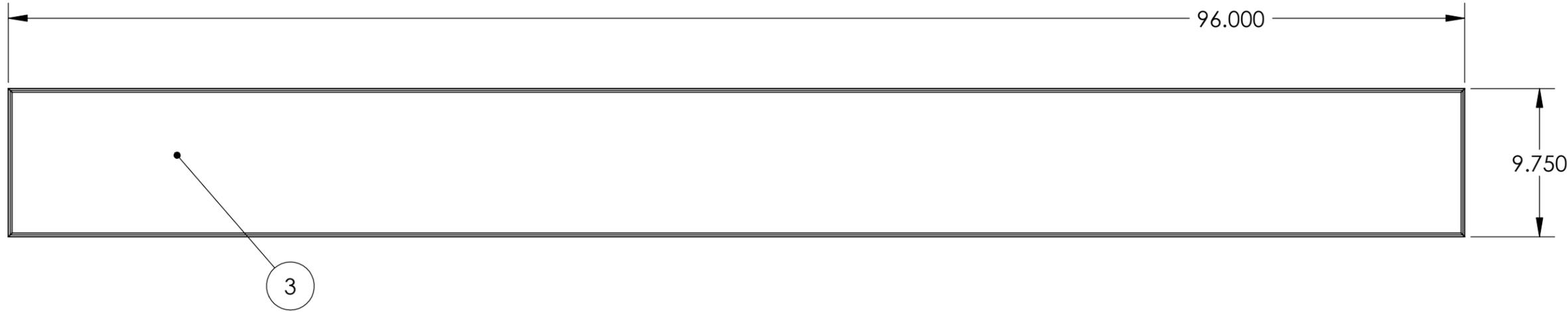
Neck Cone, make two.



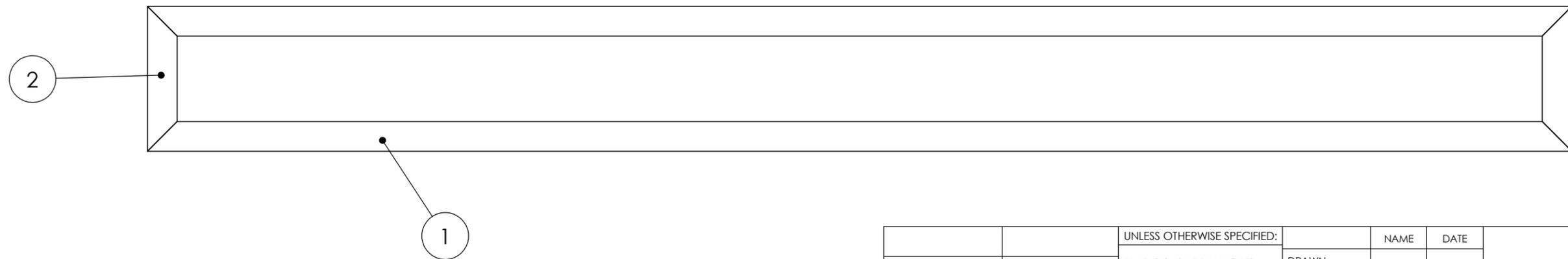
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		THREE PLACE DECIMAL ±	COMMENTS:		
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		MATERIAL			
		FINISH			
NEXT ASSY	USED ON				
APPLICATION		DO NOT SCALE DRAWING			
			TITLE:		
SIZE	DWG. NO.			REV	
<b>B</b>	jig				
SCALE: 1:1	WEIGHT:			SHEET 7 OF 10	

ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	2	L 2.00 X 2.00 X .125	96
2	2	L 2.00 X 2.00 X .125	9.75
3	1		

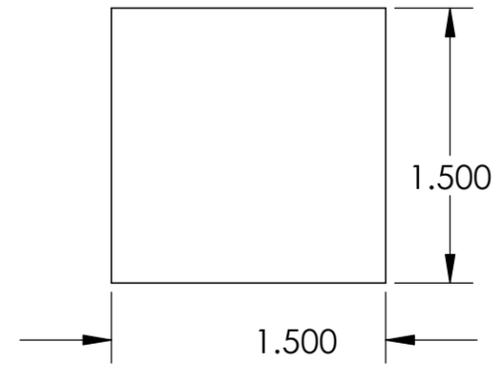
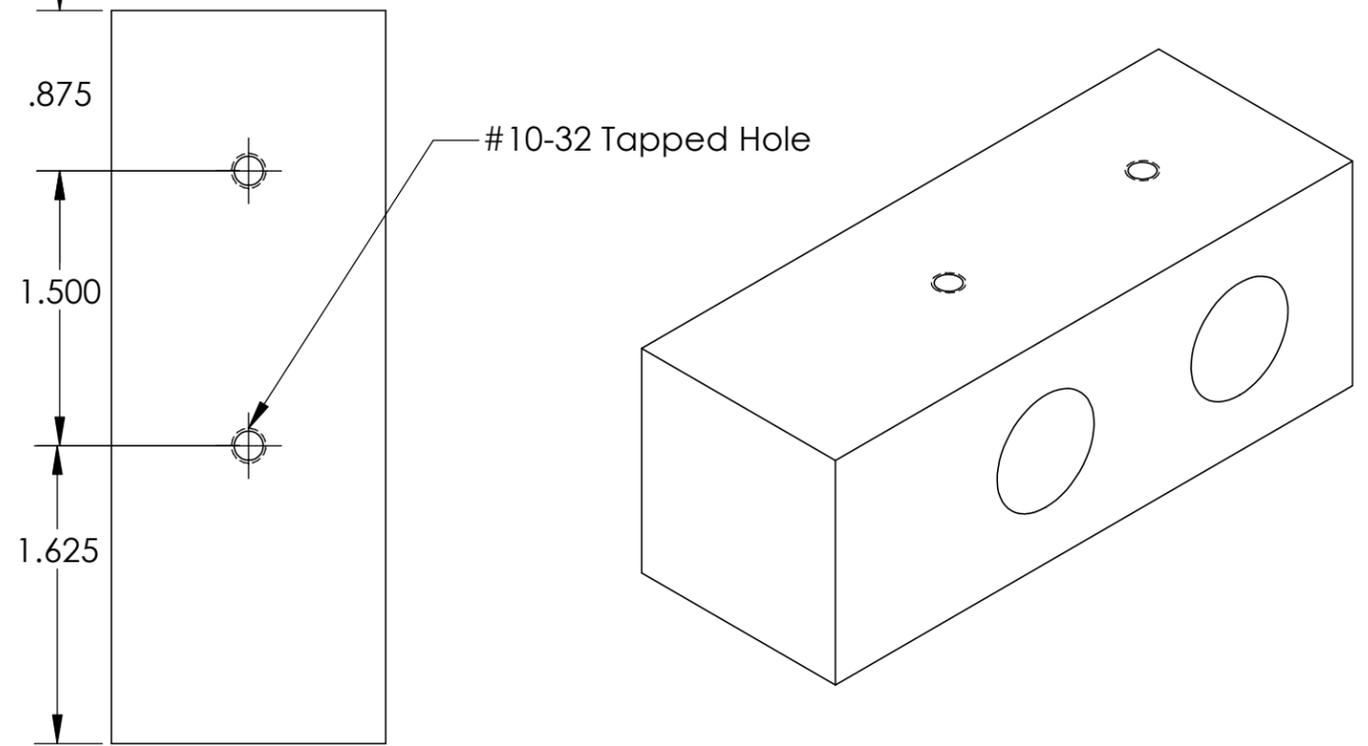


Parts Tray, build from 2" x 2" x 1/8" angle, fill bottom with expanded metal

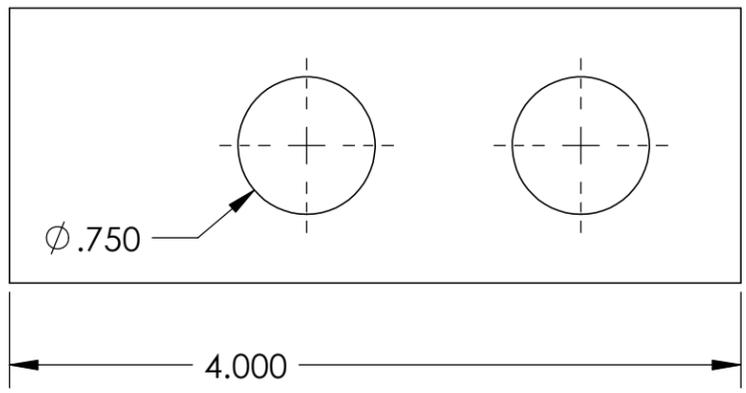


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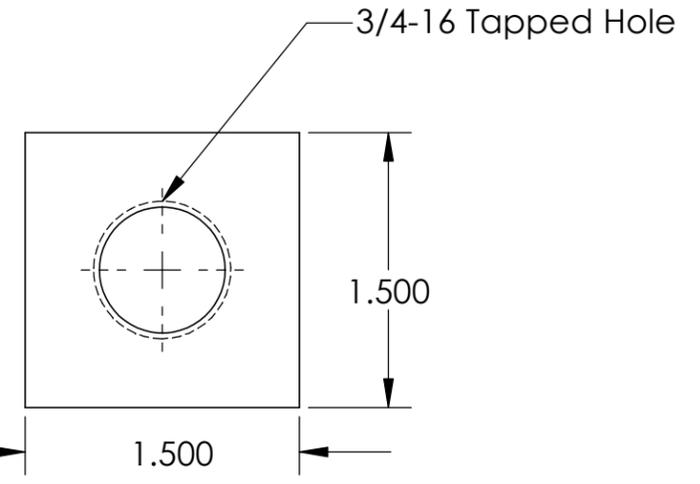
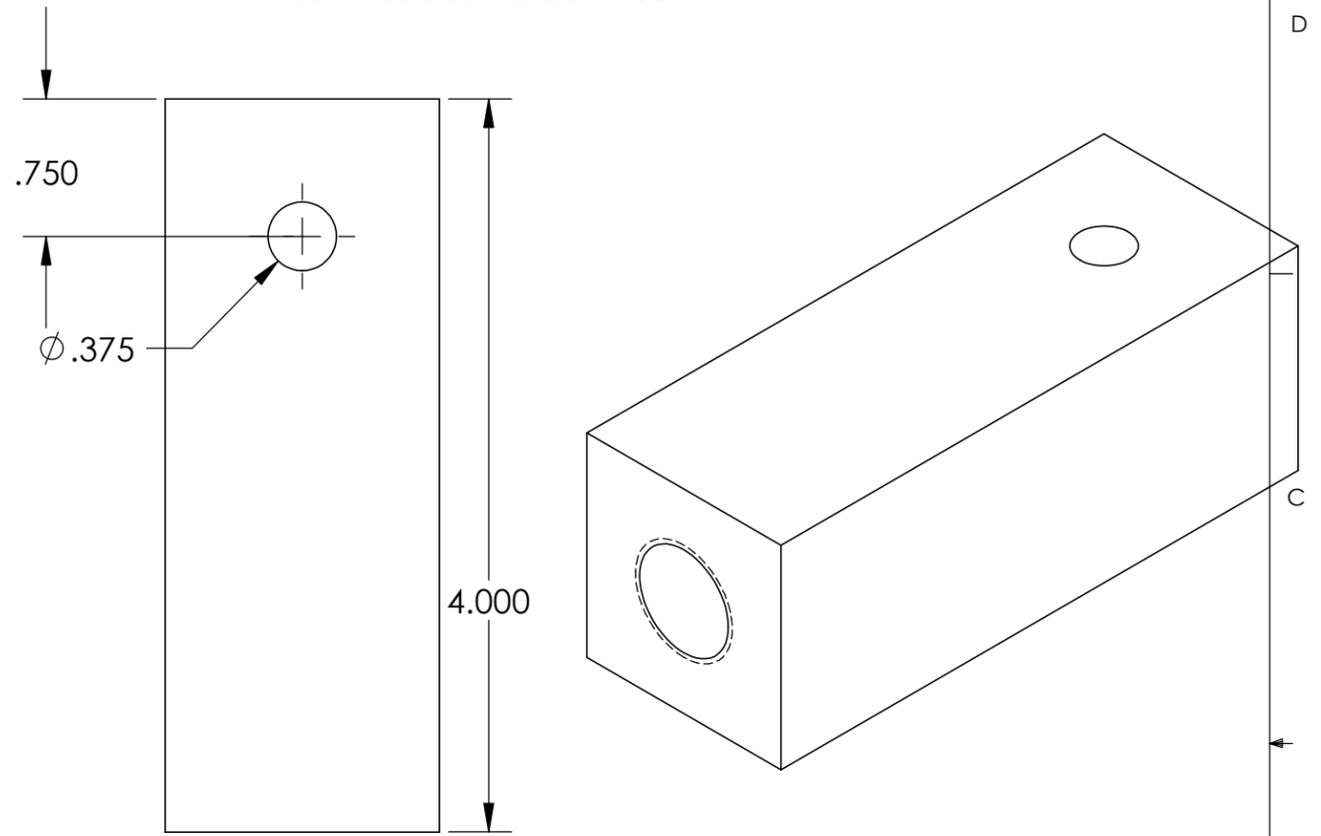
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		TWO PLACE DECIMAL ±	Q.A.		
		THREE PLACE DECIMAL ±	COMMENTS:		
		INTERPRET GEOMETRIC TOLERANCING PER:			
		MATERIAL			
		FINISH			
NEXT ASSY	USED ON				
APPLICATION		DO NOT SCALE DRAWING			
			SIZE	DWG. NO.	REV
			<b>B</b>	jig	
			SCALE: 1:8	WEIGHT:	SHEET 8 OF 10



**Axle Block**



**Neck Pivot Block**



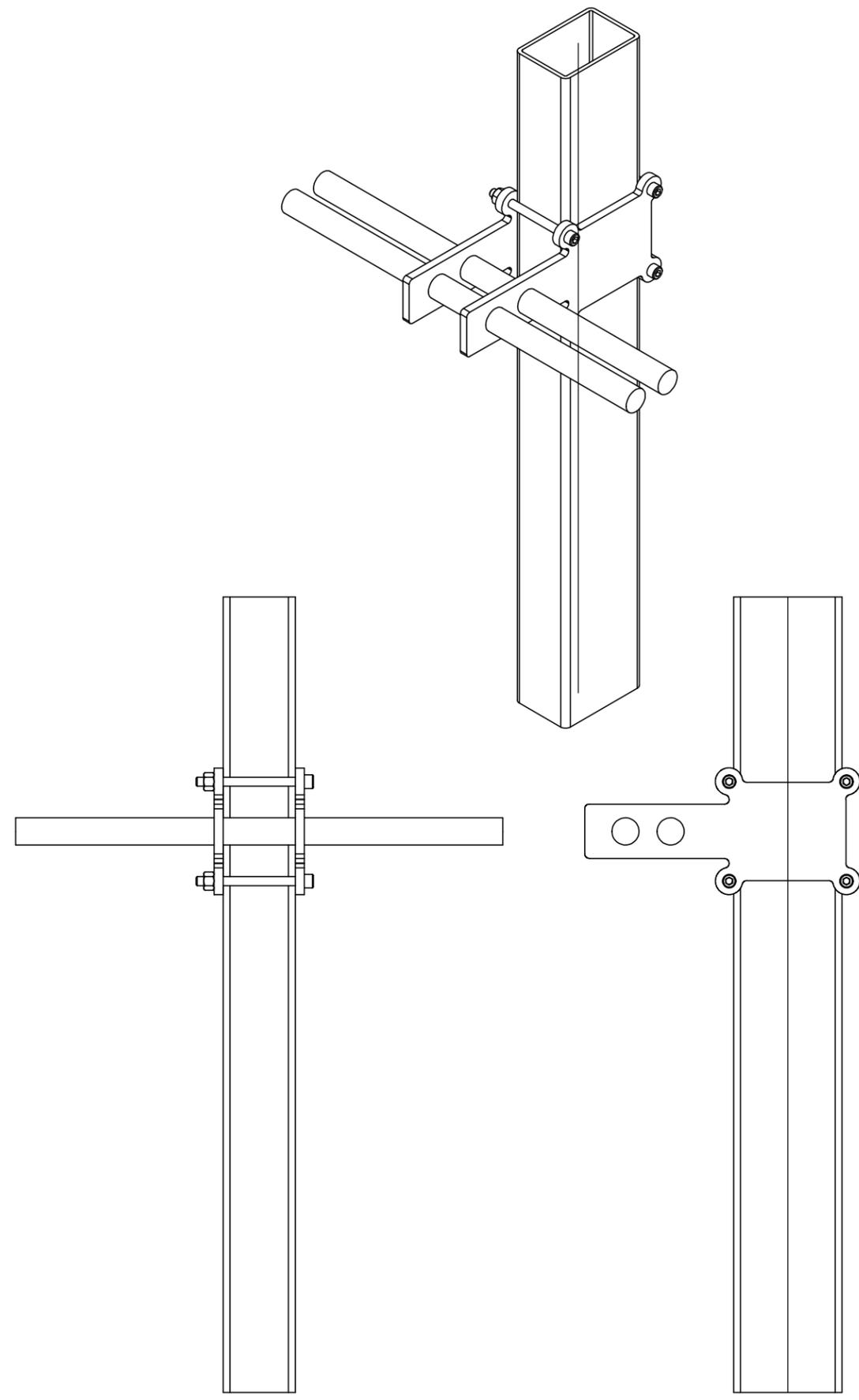
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NEXT ASSY	USED ON	FINISH		MFG APPR.	
APPLICATION		DO NOT SCALE DRAWING		Q.A.	
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		<b>B</b>	jig		
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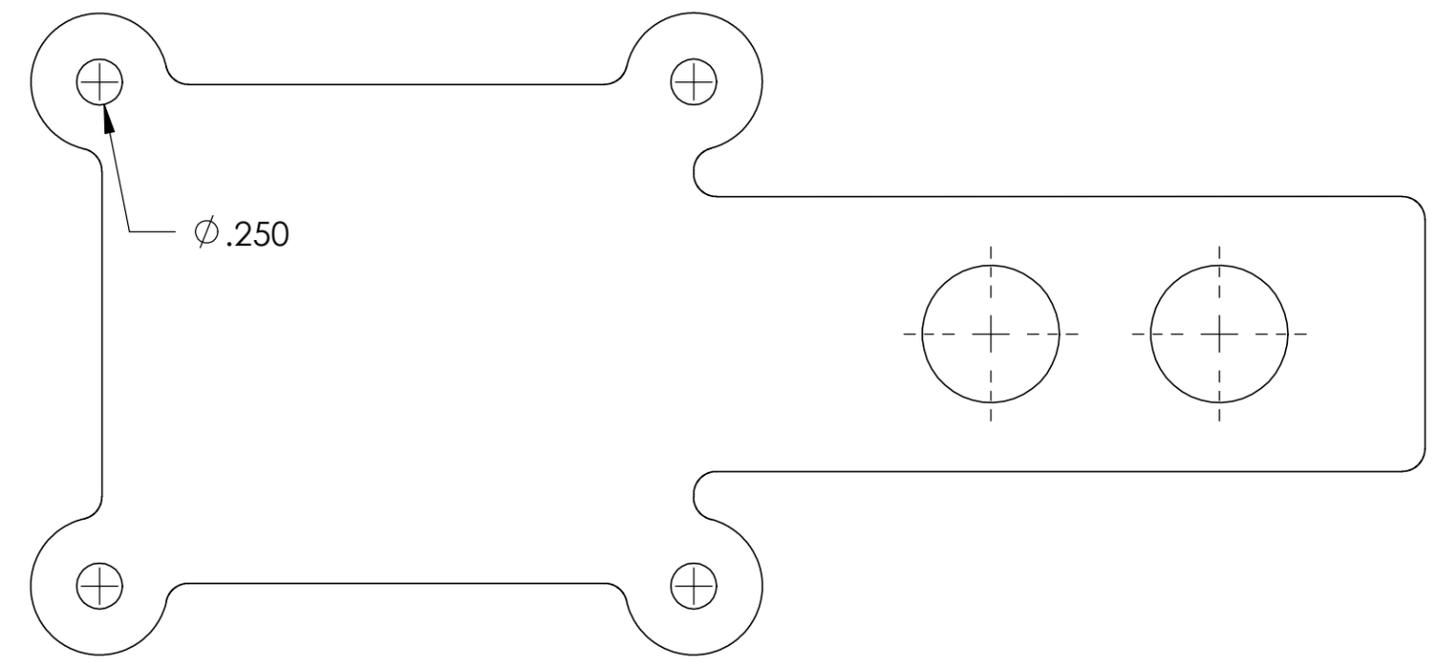
8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



This page shows an alternative approach to making the slider mechanism in the event you don't have access to a mill to cut the slots in the vertical components. This axle adjuster plate clamps to the 2" x 3" tube with four 1/4" bolts. The plate is shown full scale.



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		THREE PLACE DECIMAL $\pm$	COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:				SIZE
		MATERIAL				DWG. NO.
		FINISH				<b>B</b>
NEXT ASSY	USED ON					jig
		DO NOT SCALE DRAWING				REV
APPLICATION						SCALE: 1:4
						WEIGHT:
						SHEET 10 OF 10

8 7 6 5 4 3 2 1