



# The Leigh F1 Finger Joint Template

This template requires a Leigh 24" D-series Dovetail Jig

## FINGER JOINTS

Finger joints, also called box joints, add visually striking symmetrical design to corner assemblies. Unlike dovetails, finger joints do not interlock mechanically, but their enormous amount of glue surface can make them as strong as dovetails throughout the life of the adhesive. Leigh's versatile F1 Finger Joint Template\* is the most comprehensive and accurate jig of its kind, producing 9 sizes of square-cornered fingers from 1/16" to 1/2". The F1 can also cut square half-blind joints, and it can make beautiful rounded joints, through or half-blind, as well. Bullnose the board ends and drill a hinge pin hole and finger joints become tight, smooth-acting wooden hinges. Leigh's unique VGS guidebush system, provided with the F1, guarantee you can make every joint fit flawlessly.

\*Patented in U.S.A., Canada and Europe



The popular 19th-century finger (box) joint is easier than ever to make, thanks to Leigh. The F1 template's precision-controlled offset system lets you rout fingers one half and even one quarter of each guide comb's native size (1/4", 5/16", 3/8" & 1/2"), all with complete control of joint tightness. See joint width capacities and bit selection on page 20.



### F1 Finger Joint Template

#### Features

- Precision CNC machined aluminum alloy template
- Precisely adjustable joint fit
- 9 sizes of finger joints (1/16", 3/32", 1/8", 5/32", 3/16", 1/4", 5/16", 3/8", 1/2")
- 4 sizes of unique rounded finger joints
- 4 sizes of square half-blind corners
- 4 sizes of round/square through corner joints

#### Standard equipment

- Leigh 8-piece VGS variable fit guidebush system
- 106-page fully illustrated user guide

The F1 attaches directly to the D4 or any D-series Dovetail Jig.

**Item F1-24** 24" Finger joint template .....US \$329 .....CDN \$433

Leigh also offers a metric version of the F1:

**Item F1M** Metric Finger Joint Template (not shown) .....US \$329 .....CDN \$433

Shipping weight 8 lb.

The metric F1 Finger Joint Template is a completely separate product. It has three guide combs instead of four and uses metric-sized bits. Only order this product if you have metric bits and suitable router collets. **Leigh Industries does not stock or sell metric bits.**

Joint size and board width: 8mm x 260mm wide, 10mm x 340mm wide and 12mm x 600mm wide.



### VGS Accuracy

VGS guidebushes offer unprecedented ability to adjust joint fit. The full 8-piece VGS is included with each F1. Nominal guide sizes are 3/8", 7/16", 1/2" & 5/8". Mounting adaptors, if needed, are listed on pages 26-27.

Leigh's Variable Template Guidebush System (VGS) consists of four CNC machined tapered template guidebushes and a common holder, mounted in the router base plate. Adjusting the guides up or down with the kit's pin wrench changes the barrel's effective diameter, altering joint fit with stunning accuracy. One eighth of a turn changes the fit by a mere one thousandth of an inch (.001"). A nylon plug in the guide threads ensures smooth and secure adjustment. No other system provides such simple, accurate adjustment.





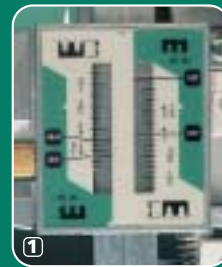
*End Table in walnut with square and rounded finger joints 26"H x 18"W x 16"D*



*Highly unusual half-blind box joints are easy to make with the F1 Finger Joint Template.*


## How To Cut Square Finger Joints

① As on all other Leigh templates, the right side of each scale indicates the joint being routed. The scales are color coded green for square fingers and gray for rounded joints. In the square finger mode, there is just one setting for each of the F1's four guide combs.



② The VGS is mounted directly on the router baseplate. In some cases, a Leigh template guidebush adaptor may be needed. Adjusting the template guidebush up or down changes the joint fit .001" for each 1/8 of a turn. A full turn alters the fit by .008"!




③ In finger-jointed corners, one board starts with a finger, the other with a socket. A template control pin positions the F1 guide combs for one or the other. Here, the icon  shows you're ready to cut a finger board.



④ Both finger and socket boards are clamped vertically in the jig. A straight or spiral upcut bit that matches the comb size does all the cutting for both pieces.



⑤ Remove the control pin, slide the guide comb sideways to the next position (the distance between finger centers) and insert the pin in the hole marked by the socket icon . The control pin positioning holes are always at the opposite end of the active portion of the comb and do not interfere with the router.



⑥ That's all it takes to change from finger board to socket board mode. Rout the second half of your joint, adjust the fit as needed with the VGS and then produce as many perfectly fitted boxes as you please.



**"Leigh Jigs are so versatile."**

—Patrick Spielman, Router Jigs and Techniques





## The Leigh F1 Finger Joint Template

This template requires a Leigh 24" D-series Dovetail Jig

### ROUNDED FINGER JOINTS

Finger joints have always been made with square-ended fingers and sockets because that's the only self-matching shape that saw blades, dados, groovers and straight bits can cut. The F1 template however, makes possible a new variety of rounded finger joint, joints which are as strong as square cut but which have their own distinctive visual impact. Thanks to the F1's rounded guide fingers and built-in adjustable router stop fence, you can produce through or half-blind round finger joints almost as easily as square, in any of the template's four guide comb sizes: 1/4", 5/16", 3/8" or 1/2".

***"The most sophisticated of the Leigh Jig attachments... the fit of this joint is cleverly achieved by an adjustable guidebush."***

*—Jeremy Broun, Good Woodworking Magazine (UK)*



*Another unique variation gives rounded fingers on one face and square fingers on the adjacent face.*



*End Table in walnut with square and rounded finger joints 26"H x 18"W x 16"D*

***"The Leigh D4 Dovetail Jig is a quality tool that I highly recommend. You'll be truly amazed at the beautiful joints you'll be able to master with ease."***

*—Robert E. Belke, Creative Woodworks & Crafts Magazine*

***"The Leigh Jig is a fabulous jig...it equals if not surpasses hand-cut joints."***

*—Good Woodworking Magazine (UK)*





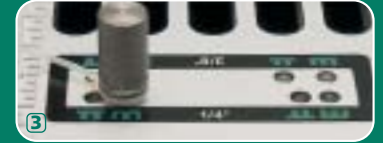



## How To Cut Rounded Finger Joints

① Configure the template for round fingers in the width of your choice and set the gray scale to the thickness of the pin board (drawer front). You'll use this one setting for finger and socket boards.



② The router stop fence controls horizontal cutting depth into the board. Measuring scales are built into the top of the template.



③ Insert the control pin at the  icon for rounded pins.



④ Clamp the pin board vertically. Set the router stop fence and rout the pins.

⑤ Remove the control pin, reposition the template to rout the socket board and reinsert the pin.



⑥ The socket board is clamped horizontally. Leaving both template scales and router stop fence in the same positions, rout the socket board.



⑦ Use the tapered VGS guide to adjust joint tightness. Turn the barrel clockwise to loosen the fit and counterclockwise make the joint tighter.



Wooden hinges (knuckle joints) are an easy variation on standard finger joints.

*“The name Leigh and the term Dovetail Jig are almost synonymous thanks to the reputation established by this Canadian Machine.”*

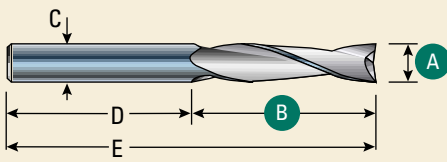
—Traditional Woodworking Magazine (UK)



# How to Select the Right Bits for Finger Joints

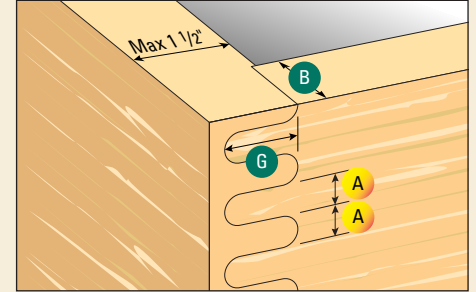
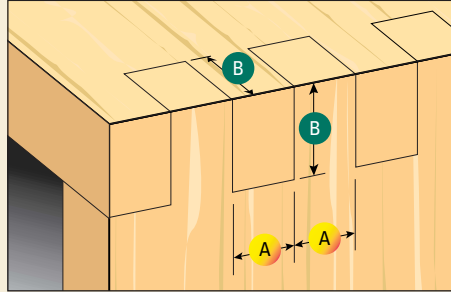
All finger joints are cut with straight bits and Leigh Industries offers two variants; a two flute spiral upcut in High Speed Steel and a Solid Carbide version. The spiral upcut design cuts cleaner, faster, leaves a smoother finish and dramatically reduces tearout. Although both produce excellent results, the solid carbide versions

are stiffer and they hold a keen edge longer than the HSS. The performance of less expensive HSS bits is comparable to Solid Carbide but they loose their edge more quickly. Choose the bit that best suits your needs and budget.



A is the bit diameter which matches the width of fingers or sockets.

B is the cutting depth or board thickness, whichever is less.



FINGER JOINT BIT SELECTION								PRICE			
LEIGH BIT ITEM NO.		A	B	C	E	F	G	HSS Spiral Upcut		Solid Carbide Spiral Upcut	
HSS Spiral	Solid Carbide Spiral	Bit Diameter (= Finger Size)	Cutting Depth (= Maximum Board Thickness)	Shank Diameter	Overall Length	Maximum Board Width	Max. Rounded Finger Length	US	CAN	US	CAN
162	—	1/16"	3/16"	1/4"	2"	8-7/16"	—	\$12	\$16	—	—
163	—	3/32"	3/8"	1/4"	2"	12-9/16"	—	\$12	\$16	—	—
164	164C	1/8"	3/8"	1/4"	2"	8-7/16" *	—	\$12	\$16	\$20	\$27
165	165C	5/32"	5/8"	1/4"	2"	10-1/2"	—	\$14	\$19	\$20	\$27
166	166C	3/16"	5/8"	1/4"	2-1/2"	12-9/16"	—	\$12	\$16	\$20	\$27
168	168C	1/4"	3/4"	1/4"	3"	8-7/16" *	1-1/8"	\$12	\$16	\$24	\$32
170	170C	5/16"	7/8"	8mm & 5/16"	2-3/4"	10-1/2" **	1-1/4"	\$14	\$19	\$36	\$48
173	173C	3/8"	1"	3/8"	3"	12-9/16" **	1-3/8"	\$14	\$19	\$38	\$51
180	180C	1/2"	1-1/4"	1/2"	3-1/2"	14-21/32" **	1-3/8"	\$18	\$24	\$57	\$76

Note: 162, 163 and 165 are single flute bits.

\* 1/4" and 1/8" box joints may be routed up to 14" widths on the 1/2" comb.

\*\* A simple two-step procedure allows 5/16" square finger joints to be routed to 20" width and 3/8" and 1/2" square finger joints to be routed to 24" width.

## Bit Sets for The F1 Finger Joint Template



No.1618F 11-piece bit set features two-flute HSS spiral upcut bits (162, 163 and 165 are single flute). Boxed set includes 162, 163, 164, 165, 166, 168, 170, 173, 180 and collet reducers 172-8 and 172-375.

**Item 1618F** HSS 11-piece bit set

SAVE US \$23/CDN \$34 over unit price\* .....US \$109 .....CDN \$144

No.1618C solid carbide spiral upcut bit set is for those that have to have the best! They're expensive, but they outlast the rest. The two smallest bits are not available in solid carbide so we have replaced them with two carbide-tipped straight bits. Boxed set includes 132, 133, 164C, 165C, 166C, 168C, 170C, 173C, 180C and collet reducers 172-8 and 172-375.

**Item 1618C** Solid carbide spiral upcut 11-piece bit set

SAVE US \$56/CDN \$82 over unit price\* .....US \$219 .....CDN \$289

Most 1/2" collet routers come with 1/4" collets or collet reducers, or they are commonly available. The 5/16" (8mm) and 3/8" shank sizes are not common so we have included collet reducers 172-8 and 172-375 in the sets above.

**Item 172-8** One 1/2" to 8mm collet reducer 1-1/4" long.....US \$6 .....CDN \$850

**Item 172-375** One 1/2" to 3/8" collet reducer 1-1/4" long.....US \$6 .....CDN \$850

\* and you get the box as well!



# Who Uses the Leigh D4 Dovetail Jig?

*The Leigh D4 Dovetail Jig is used by hobbyists and home craftsmen, production shops, woodworking schools and video workshops worldwide.*

Leigh Jigs are built for woodworkers who want efficient, high quality joinery. They are perfectly suited for the weekend enthusiast making one-of-a-kind pieces, the professional craftsman making limited custom runs, or the full-on production shop turning out hundreds of commercial pieces.

## Hobbyists and Craftsmen

Leigh jigs are simple to set up, easy to use, and tough enough to last through a whole career of woodworking for the fun of it. In fact, over 70% of all Leigh jigs are purchased for use in home workshops.

## Production Shops

Leigh jigs are built to the exacting standards of professional and production-line woodworking. They're fast and easy to use and designed for continuous use.

## Woodworking Schools

Many schools take a day or less to teach their students to use Leigh jigs. Others use the jig for very efficient demonstration of a variety of routed joints.

## New Yankee Workshop

Many have seen Norm Abram use the Leigh dovetail jig on this popular woodworking program. In fact, the Leigh Jig has been featured in more than 20 shows. Here are a few of his comments:

*"...a sophisticated dovetail jig..."*

*"...my dovetailing fixture...allows me to make just about any dovetail layout I want.."*

*"If you follow the directions that come with these dovetail fixtures you will be able to dovetail one, or a hundred drawers—perfect every time."*

*—Norm Abram, New Yankee Workshop*



### A Simple Starter Piece

*This tool box is a perfect starter piece for the novice. In poplar with a pecan finish. 6"H x 22"W x 9"D*



### For Pros and Hobbyists Alike

*Even hobbyists can make this beauty. In douglas fir. 18"H x 30"W x 17"D*



### Small Professional Production Shop

*Workers doing production-line woodworking*



### Production Run of Storage Boxes

*Production run in cherry incorporating exotic veneered tops. Featuring 5/32" finger joints. 4"H x 9"W x 5"D*



### Conover Workshops

*Instructor oversees student's progress.*



### Mark's Tool School

*Students learn to rout "Leigh" dovetails.*







## The Leigh M2 Attachment

*This attachment requires a Leigh 24" D-series jig  
and a 1/2" collet plunge router*

### MULTIPLE MORTISE AND TENONS

The layout and cutting of multiple mortise and tenon joints demands such a high level of time-consuming care and craftsmanship that these striking joints are usually found only in the most sophisticated hand-made furniture. Leigh's M2, Multiple Mortise and Tenon Attachment however, brings this challenging joint within easy reach of any woodworker who owns a D4 Dovetail Jig and a plunge router with 1/2" collet. The M2's adjustable guide fingers let you cut multiple mortise and tenon joints in virtually any layout you like, in stock up to 24" wide. Mortises and tenons can be cut in sizes from delicate 5/16" x 5/8" to muscular 1-1/2" x 2-1/2".

The M2 brings you two additional unique capabilities as well. Multiple mortise & tenon joints are closely related to finger joints and the M2 can be used as a custom finger joint jig for producing large scale, variably spaced finger joints from 5/8" wide on up, in stock up to 1-1/8" thick. The M2 guide fingers can also be used to produce extra-large variably spaced half-blind dovetails with tails up to 1-1/4" deep.



### M2 Attachment

#### Features

- Mortises and tenons in sizes from 5/16" x 5/8" to 1-1/2" x 2-1/2"
- Choice of three corner radii: 5/32", 1/4", or square (with chiseling)
- 74-page fully illustrated user guide
- Supplied with 1/2" HSS spiral upcut bit (Leigh No.180)

**Item M2-24** 24" Multiple Mortise  
and Tenon Attachment

**\$239** **\$315**  
US ..... CDN

**Item M2M-24** 24" Multiple Mortise

and Tenon Attachment with metric scales ..... **US \$239** ..... **CDN \$315**

Shipping weight 10 lb.



*Wall-mounted Bookshelf with Drawer in birdseye maple and  
maple with cocobolo wedges. Featuring square wedged  
mortise and tenons. 16"H x 32"W x 9"D*




*Variations of multiple mortise and tenons.*



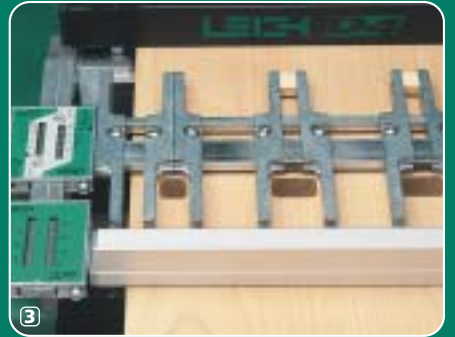


## How to Cut Multiple Mortise and Tenons

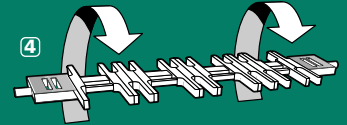
① Mount the M2 template on your D4 jig in mortise mode . Color-coded scales for 1/2" or 5/16" bits gives you precise control of mortise width.




② Upcut spiral bits are your best choice for routing mortises and tenons cleanly. Use a 5/16" bit with 7/16" o.d. template guidebush, or a 1/2" bit (provided) with a 5/8" o.d. guide.



③ Adjust the fingers to the multiple mortise and tenon layout you've designed. The template guidebush steers your router against the fingers through three sides of the mortise. An adjustable fence, the *mortise beam*, guides your router base as you cut the fourth side. Set your depth of cut for either blind or through mortising.



④ Remove the mortise beam and flip the finger assembly over into tenon mode .



⑤ While the finger layout establishes the width of your tenons, the scales determine their thickness.

⑥ Routing square-cornered tenons is very quick and straightforward. Rounding their corners is a simple two-step process, aided here by using shop-made wooden bridges between finger ends.



Square tenons are even quicker to rout than rounded.



A sharp corner chisel makes short work of squaring mortises.

**“Repeatable accuracy... you can rout joints in minutes that would otherwise take hours by hand. (M2) Performance ★★★★★”**

—Better Homes & Gardens Wood Magazine







## The Leigh M2 Attachment

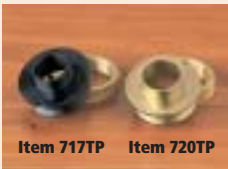
This attachment requires a Leigh 24" D-series Dovetail Jig

### JUMBO JOINTS

As if it weren't enough for the M2 to produce fine multiple mortise and tenon joints, it goes two steps further, cutting extraordinary variably spaced finger joints and oversize half-blind dovetails. Finger joints are almost always made with identical finger and socket sizes, but since fingers are basically multiple tenons and sockets are simply series of mortises, Leigh's M2 is a finger joint jig right out of the box. The M2 makes fingers 5/8" or wider, symmetrical or variably spaced just like Leigh dovetails. The M2 handles stock as thick as 1-1/2".

Straight, adjustable guide fingers are what you use to make half-blind dovetails with the D4 jig's standard dovetail finger assembly. Straight, adjustable fingers are what you get on the M2 attachment, so yes, it's a half-blind dovetail jig too. Using either of the two largest dovetail bits for the D4, 11/16" (No.90) and 13/16" (No.100) and a custom-made template guidebush for each bit, you can cut jumbo half-blind dovetails in stock up to 1-1/2" thick. The 11/16" No.90 dovetail bit works with template guidebush No.717TP to cut half-blinds 1" deep, the 13/16" No.100 works with guide No.720TP to cut 1-1/4" deep. These special guides must be paired with their respective bits to cut dovetails on the M2. The M2

User Guide includes instructions for both jumbo finger joints and jumbo half-blinds.



- Item 717TP** .673" (17.1mm) Template Guidebush (for No.90 bit) .....US \$13 .....CDN \$18  
**Item 720TP** .756" (19.2mm) Template Guidebush (for No.100 bit) .....US \$13 .....CDN \$18



### Jumbo Finger Joints

In 1 1/8" and 1 3/8" cherry. Small tray made with 1/16" finger joints using the F1.

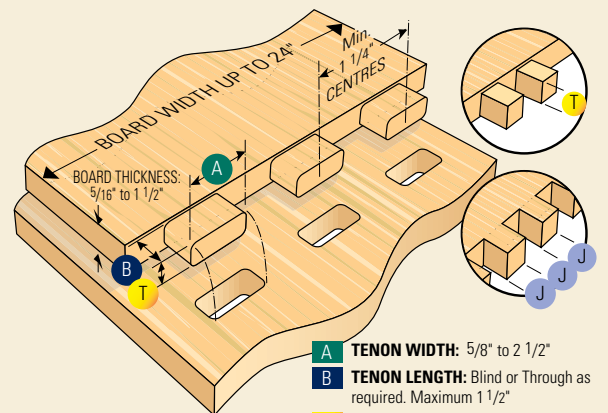
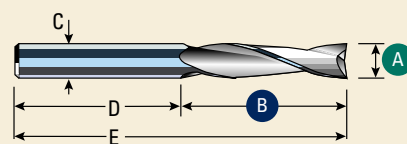


### Coffee Table or Bench

In figured bubinga. 1 1/2" thickness. 17"H x 40"W x 19"D

## How To Select The Right Bits for Multiple Mortise and Tenons

For relatively small mortise & tenon joints in boards 3/4" or thinner stock, a 5/16" spiral upcut bit (Leigh No.170 & 170C) leaves a nice, tight radius in the corners. Use it with a 1/2" to 8mm (5/16") collet reducer, No.172-8 (see page 20). For heavier joinery in boards 3/4" to 1-1/2" thick, a 1/2" bit (Leigh No.180 or 180C) cuts quickly and smoothly. Leigh sells both HSS and solid carbide spiral bits. *Note: No.180 1/2" HSS spiral bit comes standard with the M2.*



MULTIPLE MORTISE AND TENON BIT SELECTION											
LEIGH BIT ITEM NO.		A	B	C	D	E	Required	HSS		Solid Carbide	
HSS	Solid Carbide	Overall Diameter	Cutting Depth	Shank Diameter	Shank Length	Overall Length	Template Guidebush	US	CAN	US	CAN
180	180C	1/2"	1 1/2"	1/2"	2"	3 1/2"	5/8"	\$18	\$24	\$57	\$76
170	170C	5/16"	1"	5/16"	2"	3"	7/16"	\$14	\$19	\$36	\$48

- A** TENON WIDTH: 5/8" to 2 1/2"
- B** TENON LENGTH: Blind or Through as required. Maximum 1 1/2"
- T** TENON THICKNESS: 5/16" to 1 1/2"  
SQUARE TENON: 5/16" to 1 3/8"
- J** FINGER JOINTS: 5/8" and up, variable



# How to Choose a Dovetail Jig

*"Comparisons are odorous."* (*Much Ado About Nothing*) Shakespeare could joke about it, but then he wasn't in the market for a dovetail jig, was he? As you do your shopping homework, we urge you to seek from other manufacturers the same kind of clear, comprehensive information that we've presented in this catalog. Review their literature, watch their videos, and if at all possible take in a live demonstration at a woodworking show or tool store. Find out what other jig users have to say and check out the chat groups at woodmagazine.com (woodtalk), woodcentral.com, woodnet.net, and Google groups search (rec.woodworking).

## Key Points to Consider When Comparing Jigs:

### Simplicity: Design or Use?

A dovetail jig must be uncomplicated and easy to use. No other jig offers so many options however, the technically excellent design features of the Leigh D4 ensure fast, efficient, accurate and above all simple routing of each joint type and style the D4 has to offer. Design the joint, adjust the bit depth, set the scales and rout the joint! What could be more simple. Add versatility to its operational simplicity and you have the best dovetail jig on the market. The Leigh D4's design is time tested, time proven and endorsed by tens of thousands of users around the world.

### Versatility

Which would you prefer: adjusting guide fingers to fit your work or redesigning a whole piece of furniture to make its components fit your dovetail jig? At its most basic, the Leigh Jig's variable guide finger spacing lets it handle a wider range of workpiece dimensions than any other jig. Further, the jig's large capacity means you can use it to build full-size toy boxes and silver chests, not just drawers to fit within them. When a special piece of timber just begs to be shown off with a bit of fine joinery, the D4 is your jig, whether the piece is 1/8" thick or a hefty 1-1/2", just a few inches wide or a full two feet. And, as the preceding pages have shown, special functions and optional attachments let you make sliding dovetails, dovetails with decorative inlay, unique Isoloc hybrid dovetails, finger joints, multiple mortise & tenon joints and more.



### Clamping

Leigh's design excels in every detail from the smallest screw to the robust Cam Action Speed Clamps. The D4's fast and effective clamps are far more friendly than knobs, and they open wider than eccentric

clamps when released, making it considerably easier to clamp and remove your work. The clamping force generated



by these clamps is strong enough to take the cup out of a board. For each pound of pressure you exert on the clamp lever, the clamp generates at least 45 lbs of pressure on the board. So at only 20 lbs pressure on the lever you are clamping with a force over 900 lbs. And if you don't believe us, just put your big toe in there!

### User Guides That Work

Leigh's manuals are the most accurately documented and clearly illustrated guides in the business. They lead you step by step through fundamental operations, including jig and router setup, safety, stock preparation, testing, and fitting your joints. The D4 User Guide regularly earns extraordinary praise, such as "This is the best manual I have ever had with any product, not just woodworking tools, but any product I own". You can preview and download our guides and recent bulletins in the Support section of our Web site, [www.leighjigs.com](http://www.leighjigs.com).



### Adjustments for Fit and Flush

Despite their many differences, all dovetail jigs work in essentially the same way, that is, joint tightness and flushness are adjusted in the same manner. Joint tightness in half-blind dovetails and joint flushness in through dovetails are both altered by changing depth of cut, not by changing anything on the jig. Through dovetail tightness and half-blind joint flushness however, are jig adjustments, where trial and error testing is a vital part of the process. The D4's crisp, clear graduated scales make fine adjustments easy and they give you precise readings to record for future reference.

### Outstanding Service

Regardless of where you purchase your Leigh jig, you'll find our customer service is second to none. During business hours, 8 AM to 4:30 PM Pacific Time, Monday through Friday, you'll receive personal service from our business and technical staff. E-mail, fax, letters, and phone messages are answered promptly, without fail.



# What Router Do I Use?

**Can I use my router with Leigh jigs and attachments?** Most likely. We recommend a minimum of 1.5 HP (9-10 amps). A plunge router is also recommended for Isoloc templates and is a must for the M2 but is not required for the D4 and F1.

**Why does Leigh use template guidebushes instead of bearings?** Conventional guides are much more versatile than shank mounted bearings. Bearings severely limit the range of board thicknesses, joint sizes and pin and tail spacing on joinery jigs.

**Do I need to use Leigh's template guidebushes?** The router industry isn't standardized, so you may need to use Leigh's template guidebush and mounting adaptor system (GBS) to match your router to Leigh Jigs and Attachments. Note: The Leigh 711TP and 716TP are universal style template guidebushes with nuts. Many routers accept these guides directly or come with an adaptor made to fit them.

## How To Select The Right Template Guidebush and Adaptor for Your Router

For jig models D4, D3, D1258R, D1258 and the Leigh M2 Attachment

### GBS

**The GBS Universal Template Guidebush System** includes template guidebushes and mounting adaptors for the D4 Dovetail Jig and the M2 Multiple Mortise & Tenon Attachment. Use the instructions below and chart on the facing page to select the right component(s) for your router.

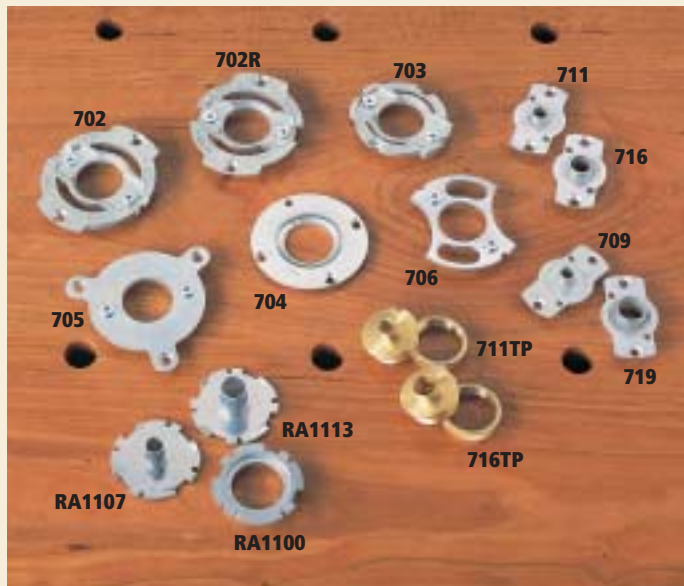
- 1 Select the bits required from pages 10, 11 or 24. On the same line as the bit specification is the size of the template guidebush required, either 7/16" or 5/8".
- 2 Go to the selection chart on the facing page and find the make and model of your router from columns 1 and 2.
- 3 Choose the adaptor for your router (if required) from column 3.
- 4 Select the 7/16" and/or the 5/8" template guidebush from columns 4 and 5.
- 5 Place your order from the section below.

For template models F1 and I1

### VGS

**The VGS Variable Template Guidebush System** is included with the F1 Finger Joint Template and the I1 Isoloc Joint Templates, but you may need an adaptor for your router (see below). *Note: The VGS guides do not work on the D4 or the M2.*

- 1 Go to the selection chart on the facing page and find the make and model of your router from columns 1 and 2.
- 2 See if the variable guide system works with your router in column 7.
- 3 Select the adaptor plate for your router (if required) from column 3.
- 4 Place your order from the section below.



The Leigh Universal Template Guidebush System (GBS) lets you mount precision Leigh template guidebushes to almost any router. Leigh template guidebushes are accurate to .002" and their deep steel or brass barrels ensure secure template routing.

<b>Item 702</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 702R</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 703</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 704</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 705</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 706</b> GBS Adaptor .....	US \$16.....	CDN \$23
<b>Item 711</b> 7/16" OD Template Guidebush .....	US \$12.....	CDN \$17
<b>Item 716</b> 5/8" OD Template Guidebush .....	US \$12.....	CDN \$17
<b>Item 711TP</b> 7/16" OD Universal Template Guidebush with Nut.....	US \$13.....	CDN \$18
<b>Item 716TP</b> 5/8" OD Universal Template Guidebush with Nut .....	US \$13.....	CDN \$18
<b>Item 709</b> 3/8" Template Guidebush or <b>Item 719</b> 3/4" Template Guidebush for general template routing, <i>not for use on Leigh Jigs</i> .....	US \$12.....	CDN \$17
<b>Bosch RA1100</b> Adaptor.....	US \$8.....	CDN \$13
<b>Bosch RA1107*</b> 7/16" Template Guidebush.....	US \$10.....	CDN \$16
<b>Bosch RA1113*</b> 5/8" Template Guidebush.....	US \$10.....	CDN \$16

\* These two Bosch bushes were not specifically designed for use on Leigh jigs and may require filing to length.





# Template Guidebush System Selection Chart

**IMPORTANT:** Check the make and model of your router in column 1. Where possible, always order the Leigh adaptors and template guidebushes (indicated in red), which are specially designed for use on Leigh jigs. Leigh also sells other manufacturer's adaptors and template guidebushes (indicated in green). All others must be purchased from the router manufacturer's own distributor.

1 ROUTER MAKER	2 ROUTER MODEL	3 LEIGH OR ROUTER MAKER'S ADAPTOR NO.	4 7/16" OUTSIDE DIAMETER GUIDE BUSH NO.	5 5/8" OUTSIDE DIAMETER GUIDE BUSH NO.▼	6 METHOD OF ATTACHMENT	7 WORKS WITH LEIGH VGS
AEG	OFE 710 in plunge base	No adaptor required	711	716	Screws incl. w/router	YES
	OFSE 2000	703	711	716	◆	YES
ATLAS COPCO	OFE 710 in plunge base, OFE 1000	No adaptor required	711	716	Screws incl. w/router	YES
	OFSE 2000	703	711	716	◆	YES
AXMINSTER WHITE	AW635R	No adaptor required	711	716	Screws incl. w/router	YES
	AW127R	Adaptor supplied w/router	711	716	Screws incl. w/router	YES
BLACK & DECKER	All Professional, HD 1250, RP400K	No adaptor required	711TP	716TP	Threaded nut included	YES
	6200	720673-00	711TP	716TP	2 screws req'd. 249412-20	YES
	SR100, 7AEE, KW780 series	No adaptor required	711	716	Screws incl. w/router	YES
BOSCH	90140, 90098, 90088	No adaptor required	82855	82854	Screws included	NO
	90085, 90150, 90300, 90303, 90305, 91264	No adaptor required	82859	82864	Screws included	NO
	1600, 1601, 1602, 1603, 1604, 1606, B1350	2 610 906 290	711TP	716TP	Threaded nut included	YES
	1613, 1613EVS, 1613AEVS, 1614, 1614EVS, 1617, 1617EVS, 1618EVS, 1619EVS, B1450 POF800ACE, GOF900ACE, GOF1300ACE GOF2000CE	No adaptor required (RA1100 required for VGS)	RA1107	RA1113	No screws required	YES
	1611, 1611EVS, 1615, 1615EVS, B1550 GOF1600, GOF1700ACE	702	711	716	◆	YES
	CASALS FT750, FT1000E, FT2000E	703	711	716	◆	YES
CMT	1E	702R	711	716	◆	YES
CRAFTSMAN (SEARS)	All non-plunge models	No adaptor required	Set of 3 bushes from Sears USA order no.25082 (stamped steel) or 25090 (plastic). Set of 3 bushes from Sears Canada order no.092-970-704		Screws incl. w/set	NO
	135275070 Plunge		See Skil 1823 or 1835			
	Other plunge models	702	711	716	◆	YES
DEWALT	DW610, DW616, DW618	No adaptor required	711TP	716TP	Threaded nut included	YES
	DW613	No adaptor required	711	716	Screws incl. w/router	YES
	DW614, DW615, DW621 DW624, DW625 and DW626	North America Only Adaptor supplied w/router	711TP	716TP	Threaded nut included	YES
	DW621K and DW626 outside N. America	706	711	716	◆	YES
	DW625 Type 1, 2 & 3 outside N. America	702	711	716	◆	YES
	DW625 Type 4 outside N.America, DW625EK	702R	711	716	◆	YES
EINHELL	EOF 850 SP, OF-G 1100E	No adaptor required	711	716	Screws incl. w/router	YES
	OF15, OF15E, OF97, OF97E	706	711	716	◆	YES
	MOF68, MOF69, MOF96, MOF96E	No adaptor required	711	716	Screws incl. w/router	YES
ELU	MOF131, MOF177 Type 1, 2 & 3	702	711	716	◆	YES
	MOF177 Type 4, MOF177EK	702R	711	716	◆	YES
	2720, 2721, 3328	No adaptor required	711TP	716TP	Threaded nut included	YES
	3303, 3304	E09600 or 761 270-00	711TP	716TP	Threaded nut included	YES
	3337, 3338, 3339	702	711	716	◆	YES
FEIN	RT1800	Adaptor supplied w/router	711TP	716TP	◆	YES
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704	711TP	716TP	Threaded nut included	YES
	OF2000, OF2000E	705	711	716	◆	YES
	OF1400		See Leigh Distributor			
FLEX	All	No adaptor required	711TP	716TP	Threaded nut included	YES
FREUD	FT2000	703	711	716	◆	YES
HITACHI	TR8, TR12, FM8, M8, M12 Series	703	711	716	◆	YES
HOLZ-HER	2355, 2356	No adaptor required	711	716	Screws incl. w/router	YES
	2365	702	711	716	◆	YES
ISKRA	MR808A Series	No adaptor required	711	716	Screws incl. w/router	YES
JEPSON	7412	703	711	716	◆	YES
KANGO	OF808	No adaptor required	711	716	Screws incl. w/router	YES
KRESS	OF690 IE Series	No adaptor required	711	716	Screws incl. w/router	YES
MAFELL	LO65E	702	711	716	◆	YES
MAKITA	3600, 3606, 3608, 3612, 3612B, 3612BR 3612C N. America, 3620, 3621	703	711	716	◆	YES
	3612C Europe Ok.Fit Base	Contact your National Leigh distributor				YES
	3601B	321 493-1	711TP	716TP	Threaded nut included	YES
	RP0910, RP1110C	706	711	716	◆	YES
	RF1100, RF1101, RD1100, RD1101, RP1101	No adaptor required	711TP	716TP	Threaded nut included	YES
METABO	OF1612, OFE1812	704	711TP	716TP	Threaded nut included	YES
MILWAUKEE	5615, 5616, 5619	49-54-1040	711TP	716TP	Threaded nut included	YES
	5625	Adaptor supplied w/router	711TP	716TP	Threaded nut included	YES
PERLES	OF808 Series, OFE 6990	No adaptor required	711	716	Screws incl. w/router	YES
PORTER CABLE (ROCKWELL)	All	No adaptor required or adaptor supplied w/router	711TP	716TP	Threaded nut included	YES
POWER DEVIL	All	No adaptor required	711	716	Screws incl. w/router	YES
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703	711	716	◆	YES
	R600, R601, RE600, RE601	702	711	716	◆	YES
	R160, R161, R162, R165, R170, R175, RE175, R180, R180PL, R185	706	711	716	◆	YES
SCHEER	HM9, HM14, HM14-12, HM18, HM18-E	No adaptor required ●	711	716	Screws incl. w/router	YES
	1823 or 1835	91803	711TP	716TP	Threaded nut included	YES
SKIL	All others	No adaptor required	11592	71021	Nut 11587	NO
	SK1810, 1815, 1820, 1825	RAS140	711TP	716TP	Threaded nut included	YES
STANLEY	All	See Bosch Distributor				
STAYER	PR50 Series	No adaptor required	711	716	Screws incl. w/router	YES
TREND (FELLISATI)	T5	No adaptor required	711	716	Screws incl. w/router	YES
	T9	Adaptor supplied w/router				
TRITON	TRC001	TGA002	711TP	716TP	Threaded nut included	YES
WEGOMA	OF850 Series	No adaptor required	711	716	Screws incl. w/router	YES

Note: Ideal barrel depth is 1/4" to 9/32" (6mm to 8mm) below the router base. Other manufacturers' guidebushes may require careful cutting to length. All Leigh bushes have 5/16" long barrels.  
 ◆ Guidebush mounting screws are provided with adaptor and adaptor mounting screws are provided with router.  
 ▼ 5/8" O.D. guidebushes are used only with 1/2" shank router bits. ■ MAFELL - Rework the adaptor slightly. ● SCHEER - Rework the router base slightly.



# RVA1

## The Leigh RVA1 Router Vacuum Attachment

### WORK IN A DUST-FREE ENVIRONMENT

Lathes, miter saws and routers have always been among the shop's toughest dust collection challenges. Now however, you can take your router off the list, at least for all your edge routing chores thanks to Leigh's ingenious RVA1 under-the-base dust extraction system. The RVA1 has a spring loaded roller guided dust chute that swings in horizontally beneath your router base, surrounding the bit and very effectively giving chips and dust nowhere else to go. Even a small shop vac can give you nearly 100% dust-free routing on fixtures like the Leigh D4 Dovetail Jig as well as during freehand edge routing. The RVA1 directs your vac hose vertically keeping it clear of jig parts, clamps or other nearby snag hazards. It fits vac hoses with 1-1/6" to 1-1/2" inside diameter.

#### Will It Fit My Router?

The RVA1 can be mounted on routers with edge guide rod holes through the base, either side to side or front to back. Side to side guide holes (the most common arrangement) must have minimum 5/16" (8mm) inside diameter. Front-to-back holes must have at least 1/4" i.d.. The RVA1 won't fit most routers with blind or short threaded rod holes. However, an optional short adaptor rod which fits Porter-Cable models 7529 and 8529 is available free from Leigh or your distributor.



*The RVA1 quickly attaches to your router to take the mess out of edge routing. Its adjustable height catcher is ideal for jig and fixture routing.*

### RVA1 Router Vacuum Attachment



#### Features

- Fits almost any router with edge guide holes through the base.
- Includes 90° mounting adaptor to fit front-to-back guide holes on some P-C, Bosch and Festool routers.
- Spring loaded dust chute with roller maintains contact with wood for highly efficient waste capture.
- RVA1 connector tube and included step adaptor fit hoses from 1-1/16" to 1-1/2" i.d.
- Glass-reinforced nylon and aluminum construction.
- Chute height is adjustable to fit flush under the base for edge routing, or lower to swing under templates and joinery jig fingers.

#### Item RVA1 Router Vacuum Attachment

US \$41 ..... CDN \$58



# Accessories

## Leigh User Guides



Leigh's new instructional user guides are without a doubt the finest in the tool field (or almost any field). But that's not just our opinion. See the sidebar to the right for just a few of the many compliments we've received.

**IMPORTANT!** Each Leigh jig and attachment comes complete with its own user guide, so order the following items only if you need a spare or replacement.

If you own a D1258, D1258R or D3 jig and would like to upgrade to the newer user guide, order the 168-page D4 User Guide. Excellent value!

- Item 24** D4 User Guide .....US \$14.....CDN \$19
- Item 31** M2 User Guide .....US \$14.....CDN \$19
- Item 3160** F1 User Guide .....US \$14.....CDN \$19
- Item 4160** I1 User Guide .....US \$14.....CDN \$19

## D4 Dovetail Jig Instructional Video



See how it's done! Our great user guides may make this video redundant, but for those of you who prefer to see the movie, this 50-minute how-to video gives you step-by-step instructions on setup and use for dovetailing on the Leigh Dovetail Jig. Includes a brief view of the optional attachments. **IMPORTANT!** Each Leigh D4 Jig now comes standard with this instructional video. Only order if you require a spare or replacement, or if you have an earlier model jig.

- Item 22** Leigh D4 Instructional Video .....US \$15 .....CDN \$20

## Upgrade Your Earlier Model Jigs

### Leigh Cam-Action Speed-Clamps

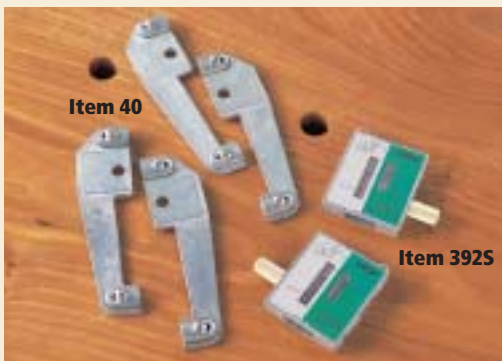


Replacing the hand-screw knobs on your older D1258 or D1258R Leigh Jig, the patented\* Leigh Cam-Action Speed-Clamps make clamping your work piece quick, precise and effortless. You can install the Leigh Cam-Action Speed-Clamp Set easily in minutes, and it immediately starts paying for itself by saving you time and effort, speeding production. Adjust the Leigh Cam-Action Speed-Clamp to a different stock thickness in seconds or use it to repeat the same clamp tension instantly, easily, and reliably.

- Item 800** 12-piece Cam-Action Speed-Clamp Set for D1258 and D1258R Jigs .....US \$35.....CDN \$49

\*U.S. Patent No. 5,156,508

### D4 Side Stops and Scales



If you have a D3, D1258R, or D1258 you can now upgrade your jig so it's basically the same as the D4.

The D4 side stops have two points of contact. These contact points are adjustable for squareness and are about five inches apart.

- Item 40** D4 Side Stop Package (set of 4) .....US \$23.....CDN \$37

The D4 scales in conjunction with the D4 User Guide have icons and color coding for each jig mode.

- Item 3925** D4 Colored Scales (set of 2) .....US \$48.....CDN \$62

## WHAT OUR CUSTOMERS AND PROFESSIONALS SAY

*"...it's terrific. The innovative use of visual symbols, the abundant and excellent illustrations, and the clear, easy-to-follow instructions make setting up and using the jig as easy as turning a page in the manual. My job would be easy if other manuals were as well written as yours. The Leigh instruction manual sets a new standard of excellence that other manufacturers will emulate. Thanks for making the use of your great jig even easier."*

– Ben Helprin, Professor of Fine Arts, Commercial Photography Program, San Jose State University

*"A big deal is made of the Leigh Jig's manual, which runs to 168 pages. It wins my "Best Manual" award. Most of the other manuals (some are cryptic instruction sheets) get the information across, but the Leigh's manual is thorough, methodical in its presentation, and clear."*

– Bill Hylton, Woodworker's Journal

*"...easy to fit, quick and easy to use. Anybody who owns one of these wonderful jigs should consider upgrading..."*

– Phil Davy

Good Woodworking Magazine (UK)

*"The instruction manual is superb, undoubtedly the best I've seen from any manufacturer."*

– Ron Fox, Traditional Woodworking Magazine (UK)

*"It is far and away the best manual I've ever encountered."*

– Herbert Morton, Glencoe Illinois





# How to Order Your Leigh Woodworking Tools

- 1 Select the jig and attachment(s) you want to order.
- 2 Select the bits required for your jig and attachment(s) from pages 10, 11, 15, 20 and 24.
- 3 Once you have selected your bits, choose your template guide-bushes from pages 26-27.

## Order Direct From Leigh

You can order Leigh jigs and accessories anytime through our toll-free customer service line, 800-663-8932, 8 AM– 4:30 PM Pacific Time, Monday through Friday, or through our secure server at [www.leighjigs.com](http://www.leighjigs.com). In

addition to taking your order, our staff will answer questions you have about Leigh products and help you get the most out of your jigs and accessories.

You can also fax your order to us at 604-464-7404, or mail it to Leigh Industries Ltd., P.O. Box 357, Port Coquitlam, B.C., Canada V3C 4K6. Especially if you order by mail, don't forget to include shipping and handling charges, and if you live in B.C. add the local sales tax on

the total. Canadian residents must add GST and NB, NF and NS residents must add HST to the total as well.

For shipping charges outside North America, call, fax or email us.

### SHIPPING AND HANDLING CHARGES

Orders up to \$25.00 .....	\$6.00
Orders from \$25.01 to \$50.00.....	\$8.00
Orders from \$50.01 to \$100.00.....	\$10.00
Orders over \$100.00 .....	\$12.00

Canadian orders sent via mail. USA (Lower 48) orders shipped via UPS Ground.  
Alaska and Hawaii orders sent via Air Mail. 2nd and Next Day Air available at extra cost.

## Order From Our Dealers

You can also buy Leigh Jigs from these better woodworking tool catalog houses and stores. Call them to order or to locate their nearest store:

### Highland Hardware (GA, USA) (1 Store)

Mail Order 1 800 241-6748  
[www.highlandhardware.com](http://www.highlandhardware.com)

### Langevin & Forest (PQ, Canada) (1 Store)

Mail Order 1 800 889 2060  
[www.langevinforest.com](http://www.langevinforest.com)

### Lee Valley Tools (Canada) (11 Stores)

Mail Order 1 800 267-8767  
[www.leevalley.com](http://www.leevalley.com)

### Lee Valley Tools (USA) (Mail Order Only)

Mail Order 1 800 871-8158  
[www.leevalley.com](http://www.leevalley.com)

### Rockler Woodworking & Hardware (USA) (35 Stores)

Mail Order 1 800 279-4441  
[www.rockler.com](http://www.rockler.com)

### The Woodsmith Store (IA, USA) (1 Store)

Mail Order 1 800 444-7002  
[www.woodsmithstore.com](http://www.woodsmithstore.com)

### Woodcraft Supply (USA) (61 Stores)

Mail Order 1 800 225-1153  
[www.woodcraft.com](http://www.woodcraft.com)

### Woodworkers Supply (USA) (3 Stores)

Mail Order 1 800 645-9292  
[www.woodworker.com](http://www.woodworker.com)



## Warranty and Satisfaction Guarantee

You can buy Leigh jigs and attachments with total confidence because they are warranted for 5 years, and even carry a 90-day customer satisfaction guarantee (if purchased directly from us, and at least a 30-day guarantee if purchased from one of our dealers).

### ORDER BY:



#### Phone or Fax

**800-663-8932** 24 Hr Toll-free line

Fax 604-464-7404



**Online** [www.leighjigs.com](http://www.leighjigs.com)



#### Mail

Leigh Industries Ltd., P.O. Box 357,  
Port Coquitlam, BC Canada V3C 4K6



Prices in effect through August 2005. Leigh Industries reserves the right to change prices and specifications without prior notice. E & OE





## See The Leigh Jig in Action

### VISIT OUR BOOTH AT A WOODWORKING SHOW IN YOUR AREA

We will be demonstrating our jigs and attachments across the USA this season at the woodworking shows listed below.

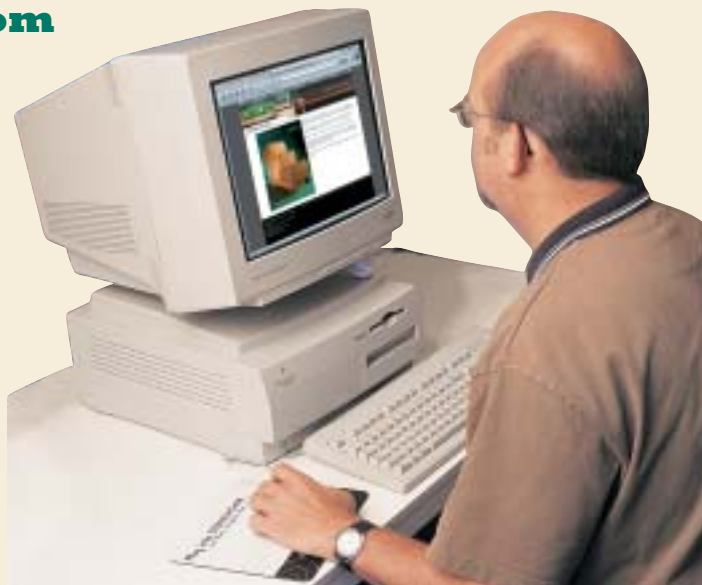
**THE WOODWORKING SHOWS** [www.thewoodworkingshows.com](http://www.thewoodworkingshows.com) • Oct.10-12, 2004 Chicago (Villa Park), IL • Oct.15-17, 2004 Minneapolis, MN • Oct.22-24, 2004 Portland, OR • Oct.29-31, 2004 San Mateo, CA • Nov.5-7, 2004 Costa Mesa, CA • Nov. 19-21, 2004 Denver, CO • Dec.3-5, 2004 Detroit, MI • Dec.10-12, 2004 Dallas/Ft. Worth, TX • Dec.17-19, 2004 Edison, NJ • Jan.7-9, 2005 Baltimore (Timonium), MD • Jan.14-16, 2005 Columbus, OH • Jan.21-23, 2005 Indianapolis, IN • Jan.28-30, 2005 Atlanta (College Park), GA • Feb.4-6, 2005 Chicago (Rosemont), IL • Feb.11-13, 2005 St. Louis, IL • Feb.18-20, 2005 Chantilly, VA • Feb.25-27, 2005 Milwaukee, WI • Mar.4-6, 2005 Kansas City, KS • Mar.11-13, 2005 Orlando, FL • Apr.1-3, 2005 Houston, TX • Apr.8-10, 2005 Seattle/Tacoma, WA • Apr.15-17, 2005 Sacramento, CA • Apr.29-May 1, 2005 Pomona, CA

**AWFS WOODWORKING MACHINERY & FURNITURE SUPPLY FAIR** [www.woodworkingfair.org](http://www.woodworkingfair.org) • July27-30, 2005 Las Vegas, NV

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

### VISIT US ON THE WEB

Check out our Web site for the latest technical bulletins, show listings and information on the latest Leigh products. It's quick and easy to download lots of useful info—even this catalog too! Bookmark us for future updates and share the Leigh experience with your woodworking friends at [www.leighjigs.com](http://www.leighjigs.com).



### MANUFACTURER CANADA AND USA

Leigh Industries Ltd. (EST. 1981)  
P.O. Box 357  
1615 Industrial Avenue  
Port Coquitlam, BC Canada  
V3C 4K6  
Phone: 604-464-2700  
Fax: 604-464-7404  
Toll Free: 800-663-8932  
Email: [leigh@leighjigs.com](mailto:leigh@leighjigs.com)  
Web: [www.leighjigs.com](http://www.leighjigs.com)

### DISTRIBUTORS

#### AUSTRALIA & NEW ZEALAND

Mik International  
27 Magill Road, Stepney SA 5069  
Australia  
Phone: 08 8363 4666  
Fax: 08 8362 3444  
Email: [inquiries@mik.com.au](mailto:inquiries@mik.com.au)  
Web: [www.mik.com.au](http://www.mik.com.au)

#### GERMANY, AUSTRIA & SWITZERLAND

Hacker GMBH  
Holzbearbeitungsmaschinen  
Traberhofstrasse 103  
D-83026 Rosenheim  
Bavaria, Germany  
Phone: 08031 269650  
Fax: 08031 68221  
Web: [www.leigh.de](http://www.leigh.de)

#### ISRAEL

Duet Wood Art  
P.O. Box 1829  
Pardes Hana 37000, Israel  
Phone: 972-52-3608453  
Fax: 972-4-6272637  
Email: [leigh@leighjigs.co.il](mailto:leigh@leighjigs.co.il)  
Web: [www.leighjigs.co.il](http://www.leighjigs.co.il)

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Via Gallarata 74/76/78  
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Italy  
Phone: 0039 02 33501095  
Fax: 0039 02 33500527  
Email: [info@ferrarimacchine.com](mailto:info@ferrarimacchine.com)  
or [info@leigh.it](mailto:info@leigh.it)  
Web: [www.ferrarimacchine.com](http://www.ferrarimacchine.com)  
or [www.leigh.it](http://www.leigh.it)

#### SOUTH AFRICA

Hardware Centre Group  
P.O. Box 4059  
Randburg 2125  
Johannesburg, South Africa  
Phone: (011) 791-0844/46  
Fax: (011) 791-0850  
Email: [info@hardwarecentre.co.za](mailto:info@hardwarecentre.co.za)  
Web: [www.hardwarecentre.co.za](http://www.hardwarecentre.co.za)

#### SWEDEN

Toolbox Sweden AB  
Horla Heden 1  
SE 441 93 Alingsås, Sweden  
Phone: 46-322-670440  
Fax: 46-322-670449  
Email: [info@toolboxsweden.se](mailto:info@toolboxsweden.se)  
Web: [www.toolboxsweden.se](http://www.toolboxsweden.se)

#### UNITED KINGDOM & IRELAND

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Nick Lowe House  
20A Harriott Drive  
Heathcote Industrial Estate  
Warwick CV34 6TJ  
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Fax: 01926 884444  
Freephone: 0800 893183  
Email: [sales@brimarc.com](mailto:sales@brimarc.com)  
Web: [www.brimarc.com](http://www.brimarc.com)

Front cover photo:  
Tansu Chest in teak with Isoloc Ellipse joinery.  
18"H x 24"W x 10"D

**LEIGH**  
Joining Tradition With Today





