

LEIGH D4 DOVETAIL JIG SYSTEM



Joining Tradition With Today

2005



“This jig sure makes it easy.”

— Norm Abram, New Yankee Workshop

The Leigh D4 Dovetail Jig



The Best There Is

Welcome to the world's most versatile dovetail jig. The Leigh D4 is so easy to use that producing beautifully fitted Through, Half-blind or Sliding dovetail joints becomes the simplest part of your work, freeing you to concentrate on pleasing design and efficient execution. The D4's adjustable guide fingers mean you are never compelled to dimension your work to suit the jig. Go ahead and plan your project just as if you were going to cut the joints by hand then set up the jig to fit the work. You are never limited to repetitive, clearly machine-made joints. In fact, the only obvious difference between Leigh dovetails and custom hand joinery is Leigh's consistently flawless fit. The jig works with any router you own, using just two standard sizes of template guidebushes or Leigh's template guidebush adaptor system. The D4 can handle stock up to 24" wide and 1-1/2" thick. Five optional finger assemblies expand the D4's capabilities to include Finger (box) joints, Isoloc hybrid dovetail joints, Multiple Mortise and Tenon joints, jumbo Half-blind dovetails and variably spaced large Finger joints. There is no other dovetail jig that does so much, so easily and so well.



The heart of the Leigh jig is the adjustable finger assembly. Arrange the infinitely adjustable guide fingers in the desired layout; the same layout for pins and tails. A template guidebush mounted in the base of your router precisely follows the guide fingers producing perfectly matched pins and tails for Through and Half-blind dovetails.

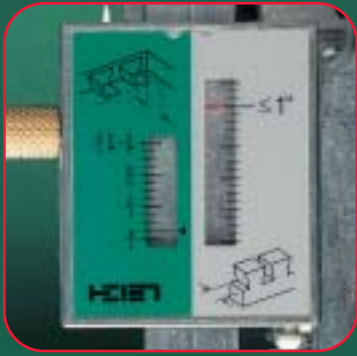


The Leigh D4 jig comes with four patented Leigh Cam-Action Speed-Clamps made from high tech glass-filled nylon for years of trouble free service. Easily adjustable for different board thicknesses, these rugged clamps provide amazing holding power for stock up to 1-1/2" thick.

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Precision scales on the finger assembly allow very accurate adjustment for perfect fitting dovetails and scale settings are easily recorded for future use. Icons on the scales clearly indicate the jig mode in use. Scales are available in inch or metric measure.



Sliding Dovetails are easy with the Leigh D4. Simply snap the crosscut bar in the Tail end of the fingers and make crosscuts in vertically and horizontally mounted boards. Great for cross grain joints!



The 168 page User Guide will take you through the D4's amazing capabilities with clear, beautifully illustrated, easy to follow, step-by-step instructions. No product you own comes with a better manual. Making dovetails has never been easier.



The 50-minute instructional video will quickly show you how easily you will create a wide variety of extraordinary joints with amazing accuracy.





The Leigh D4 Dovetail Jig

For through, half-blind and sliding dovetails

THROUGH DOVETAILS

A CLOSER LOOK

Making strong, beautiful through dovetails on Leigh's D4 Dovetail Jig is so easy that your biggest challenge may be remembering to use other kinds of joints. Whether you're making a delicate jewelry box with sides just 1/4" thick, an heirloom blanket chest in 3/4" hardwood or a contemporary dining room buffet in 1-1/8" exotic timber, the D4 lets you design aesthetically pleasing joints that suit both the scale and function of the work. Leigh stocks 7 sizes of 8° dovetail bits and corresponding straight bits (see page 10) to handle stock from 1/8" to 1-1/4" thick, on boards from 1" to 24" wide. You will need just two template guidebushes, 7/16" o.d. and 5/8" o.d., to work with every bit available. We offer two piece screw on style guides that fit many routers directly, as well as an adaptor system to fit virtually every router on the market (see pages 26-27.)

US Patent no.4,428,408 CDN Patent no.1,205,362 EURO Patent no. E0077143



D4 Dovetail Jig

Features

- Fully adjustable spacing of pins and tails
- Through dovetails 1/8" to 1-1/4" thick
- Half-blind dovetails up to 1-1/2" thick
- Sliding dovetails up to 1-1/2" thick
- Stock width from 1" to 24"
- Precise measurement scales

Standard equipment

- 1/2", 8° dovetail bit (Leigh No.80)
- 5/16" straight bit (Leigh No.140)
- Adjustable cam-action speed clamps
- Crosscut/sliding dovetail guide bar
- No.2 square driver and assembly wrench
- 168-page fully illustrated user guide
- 50-minute instructional video

Note: You will require at least one template guidebush for your router. See pages 26-27. You may also require additional bits. See Pages 10-11.

Item D4-24 24" Leigh Dovetail Jig with 1/4" shank bitsUS \$449CDN \$595

Leigh also offers the following D4 jigs with alternate shank selection and/or metric scales:

Item D4-24B 24" Leigh Dovetail Jig with 8 mm shank bits. See page 10 for shank selectionUS \$449CDN \$595

Item D4-24M 24" Leigh Dovetail Jig with metric scales and 1/4" shank bitsUS \$449CDN \$595

Item D4-24M/8 24" Leigh Dovetail Jig with 8 mm shank bits & metric scales. See page 10 for shank selectionUS \$449CDN \$595

Above items shipping weight 27 lb.






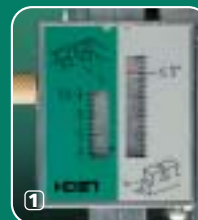
Rocking Cradle in lace wood with single angle, decorative cogged dovetails.
22"H x 24"W x 35"D



The Leigh Dovetail Jig can join pins and tails of different thickness up to 1-1/4".

How to Cut Through Dovetails

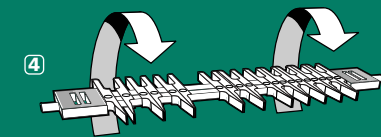
① Position the finger assembly in the Through dovetail Tail mode . Icons identify joint type. The readable scale area is always on the right, colour coded grey for Through and green for Half-blind. There is just one scale setting to rout your Through tails.




② Using a template guidebush with a dovetail bit, the template guidebush steers the router along the guide fingers, ensuring precise, accurate routing of the Through dovetail sockets. All bits with 1/4" or 8mm shanks work within a 7/16" o.d. template guidebush. Bits with 1/2" shanks require a 5/8" o.d. guide.




③ Individually adjustable guide fingers let you quickly set up custom layouts to suit your work. You can create any joint layout you want — the guide finger spacing is infinitely variable. Now rout all the tail boards.



④ Flipping the finger assembly front to back switches the mode from Tails to Pins .



⑤ Adjust the pin scales  to make a precise, recordable and repeatable setting for each bit combination. The pins will fit the sockets perfectly, joint after joint.

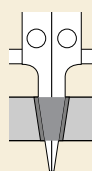
⑥ Install the matching straight bit in your router. The template guidebush follows the angled guide finger surfaces to cut perfectly mating pins.



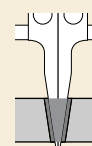
⑦ As you can see there's just one setup of the guide fingers, so perfect pin and socket alignment is guaranteed, no matter what joint layout you've chosen. That's all there is to it...perfect Through dovetails!

A Perfect Fit

Adjusting through dovetail joint tightness is very straightforward.



Towards You is Larger
In Through dovetail Pin mode, moving the finger assembly towards you lets you cut slightly larger pins, making the joint fit tighter.



Away is Smaller
Moving the finger assembly away from you lets you cut slightly smaller pins, making the joint fit looser.

"I was amazed that this jig...could make so many joints... in any pattern you like..." —Fine Woodworking Magazine





The Leigh D4 Dovetail Jig

For through, half-blind and sliding dovetails

HALF-BLIND DOVETAILS

A CLOSER LOOK

Half-blind dovetails are used to make strong corner joints that are invisible from the pin side, such as drawer fronts, leaving the figure of the wood and the design of your furniture uninterrupted by exposed end grain. The variable spacing of the D4's guide fingers allows you to create sound, classic joints regardless of stock width, with half-pins at each edge; mechanically much stronger than half-tails and therefore the traditional design of choice. Flush or rabbeted half-blind joints are equally straightforward. Leigh's selection of five half-blind dovetail bits from 8° to 18°, allows you to produce pins and tails properly sized to suit the thickness of the pinboard.



The Leigh Jig is so accurate, durable and easy to use that it is just as well suited for cutting a single custom-designed joint as it is for producing a whole chest of drawers or thousands of identical dovetails in a commercial millwork shop.

"Since the Leigh will cut both through and half-blind dovetails of any desired pin spacing, my hand-cut dovetails could effectively be emulated. Once together, the two methods could not be differentiated except that the ones cut by the Leigh were perfect while mine had flaws. It is hard to match the music on a compact disk with a live performance."

—Ernie Conover, Woodworker Magazine

"...the Leigh is the only jig that will make variably spaced half-blind dovetails...if you're a cabinetmaker looking for the most versatile dovetail jig on the market, this is it."

—American Woodworker Magazine

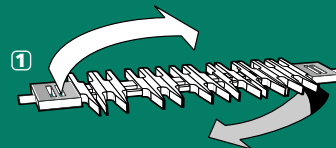






Arts and Crafts Style writing desk and chair in white oak (desk: 30"H x 45"W x 22"D, chair: 42"H x 20"W x 20"D)

How to Cut Half-blind Dovetails

① Turning the finger assembly end for end switches from Through to Half-Blind joints.



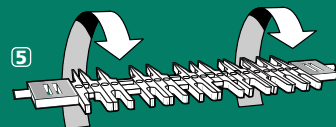
② Set the pin scale  to the drawer side (tailboard) thickness. Half-blind scales are color coded green. The readable scale area is always to the right and each scale has its own identifying icon .




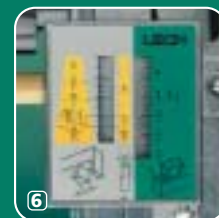
③ Use a 7/16" template guidebush with a 1/2" dovetail bit to cut both halves of the joint. Use the depth of cut to adjust joint tightness. Only Leigh offers five half-blind bits for any drawer-front thickness. See page 11 for selection.



④ Note how a scrap board clamped vertically is used to align the front edge of the pin board (drawer front) for accurate socket depth. Now rout all the half-blind pins.



⑤ After routing all pins on the drawer fronts, rotate the finger assembly to the tail mode .



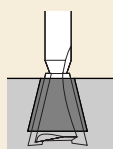
⑥ Set the  scale again to the drawer side (tailboard) thickness. Yes, it's that simple!

⑦ Now rout all the half-blind tails. Once again, perfect pin/socket alignment is guaranteed automatically, whatever the layout, because there is only one setup of the guide fingers.



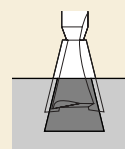
A Perfect Fit

Adjusting half-blind dovetail joint tightness is very straightforward.



Lower is Tighter

Lowering the bit cuts a narrower opening between tails and removes a little less material from the sides of the pins, making the joint tighter.



Higher is Looser

Raising the bit cuts a wider opening between tails and cuts away a little more of the pins as well, making the joint looser.





The Leigh D4 Dovetail Jig

For through, half-blind and sliding dovetails

SLIDING DOVETAILS

Sliding dovetails are used to create mechanically interlocked joints in fine furniture and shelving construction as they're stronger than dados. Unlike ordinary dados, sliding dovetail joints will hold together without being glued along the full length of the joint. This makes them ideal for wide cross-grain assemblies such as shelves in a bookcase where wood movement must be both accommodated and controlled.

The Leigh D4 Dovetail Jig comes equipped with a crosscut bar that snaps into the TAIL side of the finger assembly. The cross cut bar provides an adjustable straight guide for routing grooves in horizontal workpieces and tails in vertical workpieces up to 24" wide.



Stock thickness and load bearing stresses on the sliding dovetail joint will determine the necessary width and depth of the socket and corresponding tail. Generally, the depth of the socket should be about 1/3 of the stock thickness. A wide range of readily available dovetail bit widths and angles allow you to create precisely the right size joint for your project.

When a design calls for discreet, invisible joinery, blind stopped sliding dovetails are just as easy to cut as through joints.

You can set guide fingers to the precise position to cut the stopped tail and radius the end of the tail to mate perfectly with the undercut end of the stopped groove.



ANGLED DOVETAILS

You can use the Leigh D4 to cut angled joints just as easily as square corners. Using shop-made angled clamp jaws, you can rout obtuse joints or even compound angled corners.



SPECIAL FUNCTIONS: SHELF PIN HOLES AND NOTCHES

If you own a plunge router, you can also use the D4's guide fingers to rout parallel rows of shelf pin holes in shelving uprights or cabinet sides up to 24" wide. Then, rout notches in the shelf ends perfectly aligned to fit over the shelf pins.

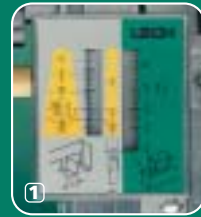




Stacking boxes in curly maple with through dovetailed partitions.
3"H x 11"W x 11"D

How to Cut Sliding Dovetails

① Set the finger assembly in half-blind Tails mode. Mark the center of the socket on the edge of the workpiece and clamp the piece horizontally. Using the graduated scales, adjust the cross cut bar to center the bit on your layout line and rout the socket.



② You can use any template guidebush as long as its barrel protrudes at least 1/4" below your router's sub base. All Leigh guide barrels are 1/4" long to ensure positive contact with jig fingers and the crosscut bar. Bits having 1/4" or 8mm shank diameter require a guide bush of 7/16" o.d. or greater and bits having 1/2" shanks require a 5/8" o.d. guide bush or larger. Cutting angles of 14° or more are preferred for sliding dovetails and 1/2" shank bits offer the superior strength required for ploughing the socket in cross grain.



③ A 3/4" thick board clamped vertically assists in positioning, then provides extra support during cutting as well.



④ Clamping a tail board vertically and routing one side of the tail, then turning the board around and routing the other side, centers the tail perfectly. Adjust the finger assembly for joint fit as necessary.

"...certainly no production workshop should be without one of these and the serious home craftsman will find great joy in using it."

—John Sainsbury's Router Workshop

SPECIAL FUNCTIONS: NEEDLE PINS, END-ON-END, INLAID

Traditional English dovetail joints, cut with very narrow "needle" pins are the ultimate expression of refined hand craftsmanship. Typical dovetail jigs can't do such work, because router bits can't cut pin sockets narrower than their own 1/4" shanks. The Leigh D4's adjustable finger assembly allows very slender and delicate pins matching the old English style. The D4 can also cut strong end on end dovetails, both straight and angled, as well as very decorative inlaid through and half blind joints.



How to Select The Right Bits for

Through Dovetail Bit Selection

To match the angle cast into every guide finger, all through dovetails are cut on the D4 using 8° dovetail bits for tails and one of three straight bits for pins. The dovetail bit's working depth (carbide height) must be at least equal to or slightly greater than the thickness of your pin board (column B in the chart below). Choose the smallest dovetail bit you can (column A) to cut sockets for pins as narrow as possible for a look of hand-cut elegance. Use the template guidebush and straight bit indicated in the chart. A 1/2", 8° dovetail bit (No.80) and a 5/16" straight bit (No.140) are the workhorses used for work up to 13/16" thick. Both bits are standard equipment with the Leigh D4 jig. They are used with a 7/16" o.d. template guidebush, the choice for all bits with 1/4" or 8mm shanks.

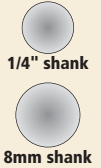
High Quality Bits

Leigh Carbide tipped router bits are among the best you can buy. Our carbide comes from Sandvik of Sweden, the world leading car-

bide manufacturer. Each bit is honed with 600 grit diamond wheels for superbly smooth, efficient cutting. Shanks are all 1-3/4" long to handle the thickness of the finger assembly. All Leigh bits are manufactured to ISO 9002 standards.

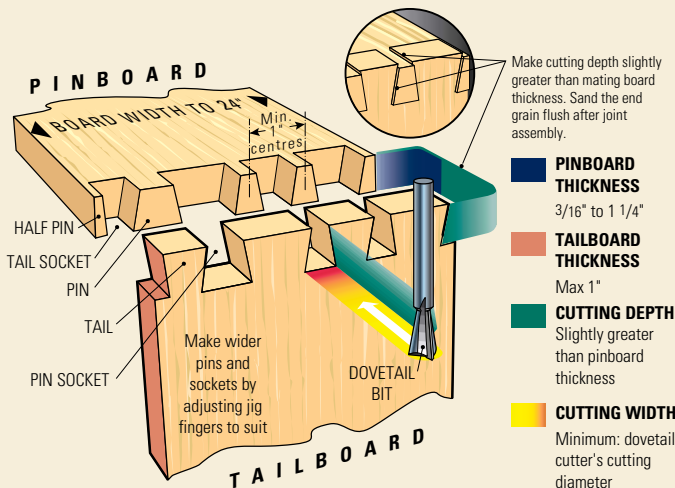
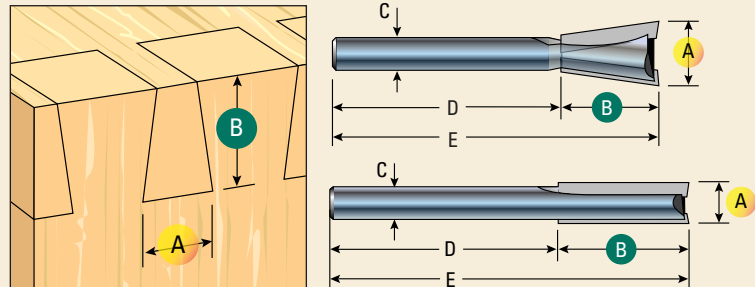
Shank Selection

Leigh highly recommends the use of bits with 8mm shanks (designated by -8 appended to Leigh bit numbers) in place of ordinary 1/4" shanks. The 8mm shanks, which have become the norm outside North America, fit easily within the inside diameter of 7/16" o.d. template guidebushes. They are considerably stronger and stiffer than 1/4" shanks, allowing smoother cuts and faster feed rates with a better margin of safety. Bosch and Porter-Cable offer inexpensive 8mm collets to fit their routers. Other routers with 1/2" collets, will accept Leigh's No.172-8 1/2" to 8mm collet reducer.



Item 172-8 1/2" to 8mm collet reducer, 1-1/4" long.

NOTE: Comes standard with set 5116-8.....US\$6CDN\$8⁵⁰



THROUGH DOVETAIL BIT SELECTION							PRICE	
All through dovetail bits have 8° angles. All bit shanks are 1-3/4" long.							US	CAN
Note that all carbide bit heights are slightly greater than maximum depth of cut listed.								
LEIGH BIT ITEM NO.	A Bit Diameter	B Cutting Depth	C Shank Diameter	E Overall Length	Use with Straight Bit	Template Guide o.d.		
DOVETAIL BITS								
50 or 50-8	1/4"	up to 1/4"	1/4" or 8mm	2"	5/16" (No.140)	7/16"	\$14	\$19
60 or 60-8	5/16"	up to 3/8"	1/4" or 8mm	2-1/8"	5/16" (No.140)	7/16"	\$14	\$19
70 or 70-8	3/8"	1/4" to 1/2"	1/4" or 8mm	2-1/4"	5/16" (No.140)	7/16"	\$14	\$19
75 or 75-8	7/16"	3/8" to 5/8"	1/4" or 8mm	2-3/8"	5/16" (No.140)	7/16"	\$14	\$19
80* or 80-8	1/2"	1/2" to 13/16"	1/4" or 8mm	2-9/16"	5/16" (No.140)	7/16"	\$14	\$19
90	11/16"	5/8" to 1"	1/2"	2-3/4"	1/2" (No.160)	5/8"	\$18	\$25
100	13/16"	1" to 1-1/4"	1/2"	3"	7/16" (No.150)	5/8"	\$18	\$25
STRAIGHT BITS								
140* or 140-8	5/16"	up to 1"	1/4" or 8mm	2-3/4"	—	7/16"	\$14	\$19
150	7/16"	up to 1-1/4"	1/2"	3"	—	5/8"	\$14	\$19
160	1/2"	up to 1-1/4"	1/2"	3"	—	5/8"	\$14	\$19

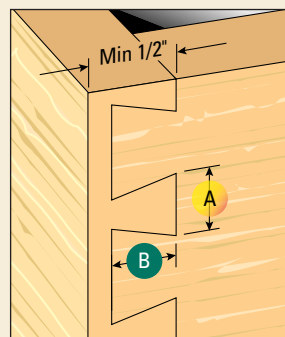
* A 1/2", 8° dovetail bit (No.80) and a 5/16" straight bit (No.140), are standard equipment with the D4 jig.



Through and Half-Blind Dovetails

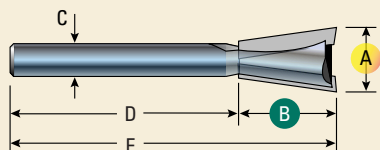
Half-Blind Dovetail Bit Selection

In half-blind joints, both pins and tails are cut with the same dovetail bit. The bit angle determines the nominal depth of cut, therefore, a bit of a given angle must cut at or very near a specific depth in order to make pins and tails fit together properly. For instance, the 1/2" 8° dovetail bit that comes with the D4 jig must cut to a depth of 3/4". You cannot use this bit to cut half-blind dovetails in pin board (drawer front) stock less than 7/8" thick. To work with 3/4" or thinner drawer fronts, choose a



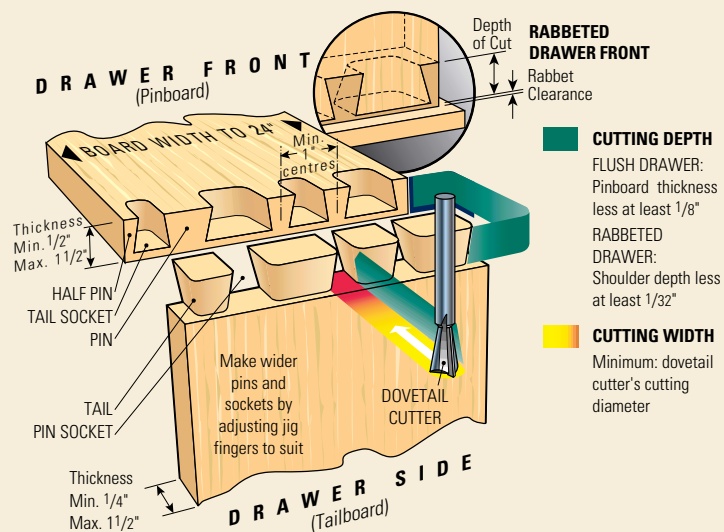
bit with a cutting depth at least 1/8" less than the thickness of the drawer front.

For rabbeted or lipped drawers, choose a bit with a cutting depth



slightly less than the rabbet's shoulder depth.

Each of the dovetail bits below is available in a 1/4" or stronger 8mm shank.



HALF-BLIND DOVETAIL BIT SELECTION							
<i>All bits' carbide height is slightly greater than indicated cutting depth. All bit shanks are 1-3/4" long.</i>							
<i>-8 in the Leigh bit number designates bits with 8mm shanks.</i>							
LEIGH BIT ITEM NO.	A Bit Diameter	B Cutting Depth	F Angle	C Shank Diameter	Overall Length	Template Guidebush o.d.	PRICE US CAN
DOVETAIL BITS							
80* or 80-8	1/2"	3/4"	8°	1/4" or 8mm	2-9/16"	7/16"	\$14 \$19
101 or 101-8	1/2"	5/8"	10°	1/4" or 8mm	2-3/8"	7/16"	\$14 \$19
112 or 112-8	1/2"	1/2"	12°	1/4" or 8mm	2-5/16"	7/16"	\$14 \$19
120 or 120-8	1/2"	7/16"	14°	1/4" or 8mm	2-1/4"	7/16"	\$14 \$19
128 or 128-8	1/2"	3/8"	18°	1/4" or 8mm	2-1/8"	7/16"	\$14 \$19

* The 1/2" 8° No.80 bit is standard equipment with the D4 jig.

Boxed Leigh Bit Sets for the D4 Dovetail Jig

Complete sets in your choice of 1/4" or 8mm shank bits



Leigh's 14-piece No. 5116 bit set includes every 1/4" and 1/2" shank bit used with today's D4 jig and all earlier models. That's every bit shown on these two pages! The boxed set includes Leigh bit No.s 50, 60, 70, 75, 80, 90, 100, 101, 112, 120, 128, 140, 150 and 160.

Item 5116 SAVE us \$45/cdn \$66 over individual bit prices!*us\$159.....cdn\$212

No. 5116-8 16-piece bit set includes two 1/2" to 8mm collet adaptors in addition to every 8mm and 1/2" shank bit used with the D4. The extra strength and stiffness of 8mm shanks makes this bit collection ideal for high-volume professional work and for those who work in hard wood. It's our most popular set. The boxed set includes Leigh bit No.s 50-8, 60-8, 70-8, 75-8, 80-8, 90, 100, 101-8, 112-8, 120-8, 128-8, 140-8, 150 and 160.

Item 5116-8 SAVE us \$47/cdn \$70 over individual bit prices!*us\$169.....cdn\$225

* and you get the box as well!





Leigh Isoloc™ Joint Templates

These templates require a Leigh 24" D-series Dovetail Jig



SIX EXTRAORDINARY JOINT PATTERNS

It's no accident the dovetail joint has endured through centuries of hand cut joinery as the sole design for mechanically interlocked corner joints. After all, if your saw and chisel are made to cut straight lines, how can you cut dovetails any other way? It took the development of hand-held routers and the ingenuity of Leigh Industries to come up with a genuinely new hybrid dovetail design, the Isoloc* joint.

Leigh's revolutionary Isoloc joints represent the first entirely practical alternative to the traditional half-blind dovetail. With a Leigh D4 Dovetail jig and an Isoloc template, even novice woodworkers can produce strong, functional and distinctively attractive joints. Isoloc's fluid, eye-catching shapes range from original to whimsically entertaining.

Remove the D4 finger assembly and simply slide on one of the three Isoloc templates. Each template features two joint patterns, one design carefully CNC machined on each side. A single 5/16" or 8mm straight bit, preferably an upcut spiral, does all the cutting. Joint fit is easily and precisely controlled using Leigh's patented Variable Template Guidebush System (VGS), a unique adjustable 3-piece template guidebush set that can be adjusted up or down, changing the joint fit. Rotating the barrel 1/8 of a turn adjusts joint fit by a mere one thousandth of inch! The VGS, which comes standard with each Isoloc template, mounts in many router bases like an ordinary 2 piece screw on template guidebush or by using a Leigh template guidebush adaptor (see page 27).

Isoloc templates are designed primarily for half-blind joints though several of the patterns can be set up to produce through and end on end joints. Double half-blinds present another intriguing option, as illustrated in the photo gallery on page 15.

The name Isoloc was coined from two words: Iso from the Greek word isos, meaning equal, and loc, an abbreviation of lock.

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



The VGS comes standard with each I1 Template.



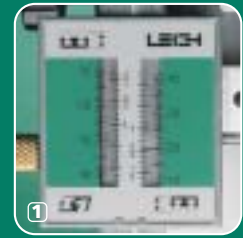
*Toy Chest in Douglas fir with Isoloc Bears
Ears pattern. 18"H x 30"W x 17"D*







How To Cut Isoloc Joints

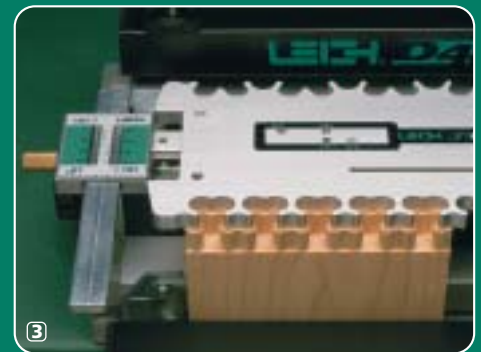
① Isoloc templates are equipped with graduated scales very similar to those on the D4 dovetail finger assembly. The scales are graduated in inch and metric measurements. Setting the scale to the thickness of the pinboard is the only setup required for routing both pins and tails.




② A stainless steel control pin positions the template on its guide bar. To mill pins, insert the control at the Pins joint icon . (Note how half pins at the icon's edges distinguish it from the Tails icon .) There are matching icons and position holes at each end of the template, so you can always place the pin out of the way of your router.



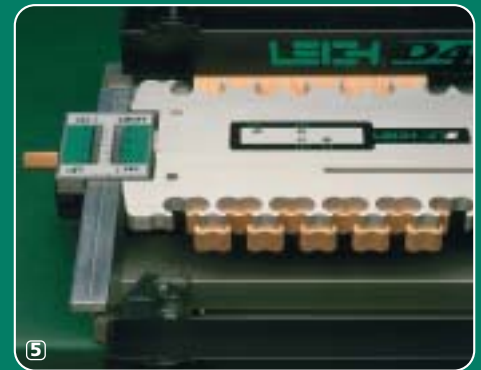
③ Install the nominal 1/2" VGS template guidebush in your router base and use a 5/16" or 8mm straight or spiral bit to mill the pins. Set the depth of cut to the thickness of your tail board, and rout your pin boards.



④ Pull the control pin, slide the template sideways on its guide bar to its offset position and insert the pin in the hole at the Tails icon . The icon's open edges identify it as Tails or socket mode.



⑤ Mount the tail board horizontally setting the end flush with the front of the jig. Rout the tails and make adjustments as required for a perfect fit. Remember, with the Variable Template Guidebush System, you can adjust joint fit in increments of .001".



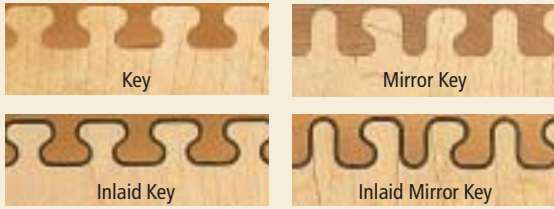
"This jig sure makes it easy."

—Norm Abram, New Yankee Workshop



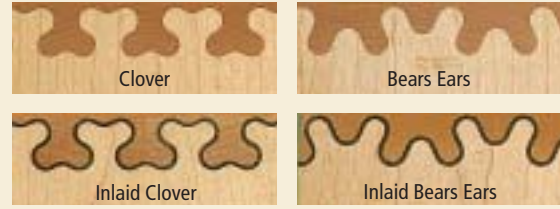
Leigh Isoloc™ Joint Templates

I1A Isoloc Joint Template



Key and Mirror Key joint patterns.
Maximum stock width: Key: 23-3/4" Mirror Key: 22-3/4"

I1B Isoloc Joint Template



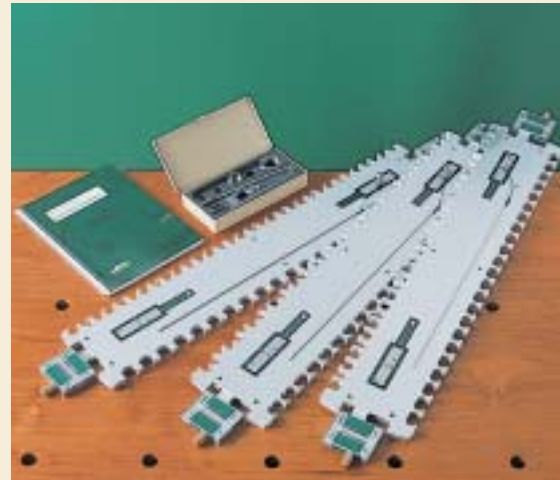
Clover and Bears Ears joint patterns
Maximum stock width: Clover: 23-3/4" Bears Ears: 22-1/4"

I1C Isoloc Joint Template



Ellipse and Wave joint patterns
Maximum stock width: Ellipse: 23-1/4" Wave: 22-1/4"

I1 Isoloc Templates 3-pack



Get all three Isoloc templates, a VGS and a user guide.
SAVE us\$138 or CDN \$182 over separate purchase.

Isoloc Joint Templates

Features

- Precision CNC machined aluminum alloy template
- Scales include inch and metric measurement
- Fully adjustable joint tightness with the VGS
- Templates attach directly to the D4 or any D-series 24" Dovetail Jig

Standard equipment

- Leigh 5-piece VGS Variable Template Guidebush System (with nominal 1/2" o.d. guide)
- 94-page fully illustrated dual measurement user guide

Item I1A Isoloc Joint Template

Item I1B Isoloc Joint Template

Item I1C Isoloc Joint Template

.....EACH **US \$269****CDN \$357**

Shipping weight 7 lbs. each

Item I13 Isoloc Templates A, B & C

.....**US \$669****CDN \$889**

Shipping weight 21 lbs.

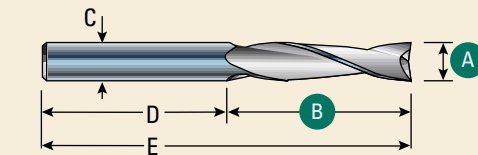


Fancy Isoloc Joints Are Just as Easy



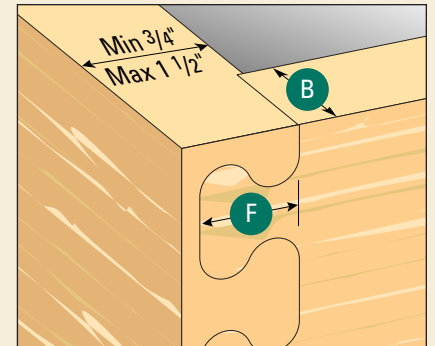
How to Select the Right Bits for Isoloc Joints

To cut Isoloc joints you need only a 5/16" or 8mm router bit. For best results use solid carbide spiral upcut bits. Solid carbide's great rigidity and excellent edge retention, together with spiral bits superbly clean cutting, gives you the best performance possible with your Isoloc template. A plunge router is recommended as it's preferable to rout the horizontal socket boards in mutiple passes. The depth stops on plunge routers make this



process safe, efficient and precise.

To cut inlaid Isoloc joints you need additional 1/4" and 3/8" bits. Check the shank sizes and order the appropriate collets or collet reducers.



ISOLOC JOINT BIT SELECTION							PRICE			
LEIGH BIT ITEM NO.		A	B	C	D	E	HSS Spiral Upcut		Solid Carbide Spiral Upcut	
HSS	Solid Carbide	Bit Diameter	Cutting Depth	Shank Diameter	Shank Length	Overall Length	US	CAN	US	CAN
168	168C	1/4"	up to 1"	1/4"	1 7/8"	3"	\$12	\$16	\$24	\$32
170	170C	5/16"	up to 1"	5/16"	1 7/8"	3"	\$14	\$19	\$36	\$48
173	173C	3/8"	up to 1"	3/8"	1 7/8"	3"	\$14	\$19	\$38	\$51

Bit Sets for Isoloc Joint Templates



- Item 16171C* Set of three solid carbide spiral upcut bitsUS \$84CDN \$112
- Item 16171* Set of three HSS spiral upcut bitsUS \$36CDN \$48

Note: Leigh does not sell 1/4" collet reducers as they're standard with most 1/2" collet routers, but for 5/16" or 8mm shanks use our 172-8 1/2" to 8mm collet reducer and for 3/8" shanks use our 172-375 1/2" to 3/8" collet reducer.

- Item 172-8 One 1/2" to 8mm collet reducer 1-1/4" long. NOTE: Comes standard with sets 5116-8, 1618F, 1316F and 1618CUS \$6CDN \$8⁵⁰

- Item 172-375 One 1/2" to 3/8" collet reducer 1-1/4" long. NOTE: Comes standard with sets 1316F, 1618C, and 1618F (see page 20)US \$6CDN \$8⁵⁰

*Included in F1 bit sets on p.20.

