

D1600 USER GUIDE

Leigh Dovetail Jig



Your New Leigh Dovetail Jig

Congratulations! You now own a most useful and versatile dovetailing tool. The Leigh D1600 Dovetail Jig will help you cut an infinite variety of joints, and all of its major functions are described in detail in this manual. A very helpful DVD is also included, but the manual is essential reading.

We recommend that you first assemble and mount the jig, carefully following the instructions in the first section of the manual. Then read the rest of the manual, following along with the basic functions and principles of operation, before you try to do any actual joinery routing. By all means, cut a few practice joints in scrap boards before you use the jig to rout a precious hardwood work piece!

If you have any questions that are not answered in the manual, please call the Leigh customer support line*.

But remember: “If at first you don’t succeed, read the instructions!”

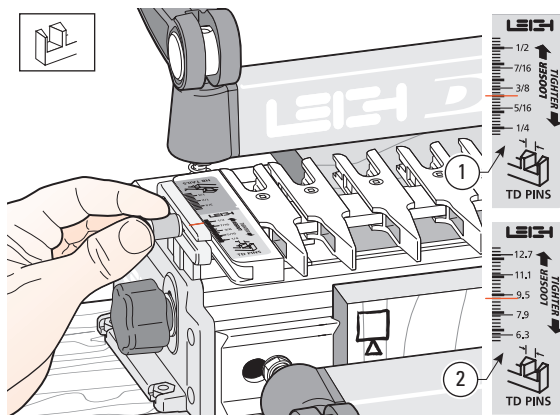
*See Appendix IV – Customer Support

Important! Inches and Millimetres

Leigh makes the D1600 jig in two models; inch and metric. The two models are identical except for scales. Text and illustrations in this Leigh English-language user guide indicate dimensions in both inches and millimetres, with “inches” first, followed by “millimetres” in square brackets.

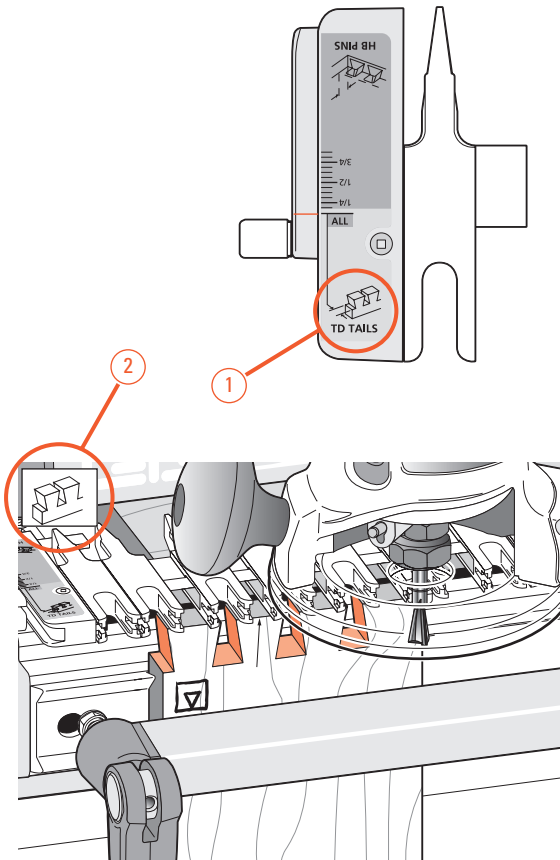
Example: $\frac{3}{4}$ " x $5\frac{1}{2}$ " x 8" [20 x 140 x 200mm]

Do not be concerned if the inch/millimetre equivalents are not exact. Just use the dimensions which apply to your jig.



Where finger assembly scales overlay an illustration, the “inches” scale ① will be at the top, the “millimetres” scale ② will be at the bottom. Only the front “active” half of the scales are illustrated. For clarity, setting positions are indicated with a red line in the manual only. **On the jig, the lines are black.**

Glossary of Symbols.....	iv
Chapter 1 – Jig Assembly, Mounting, and Using The Clamps	1
Chapter 2 – Adjusting the Finger Assembly	11
Chapter 3 – How Routers with Guidebushes Work	15
Chapter 4 – Operation Concepts and Basic Jig Functions	17
Chapter 5 – Using Your Jig Safely	27
Chapter 6 – Wood Preparation	31
Chapter 7 – Router Preparation.....	33
Chapter 8 – Through Dovetail Procedures	37
Chapter 9 – Half-Blind Dovetail Procedures	51
Chapter 10 – Rabbeted Half-Blind Dovetails	65
Chapter 11 – Asymmetric Dovetails	69
Chapter 12 – Sliding Dovetail Procedures	75
Chapter 13 – Quick Reference – Through Dovetails	85
Chapter 14 – Quick Reference – Half-Blind Dovetails.....	89
Chapter 15 – Hints and Tips.....	93
Appendix I – Guidebush Selection	101
Appendix II – Cutter Selection.....	105
Appendix III – Jig Parts List	113
Appendix IV – Customer Support	117

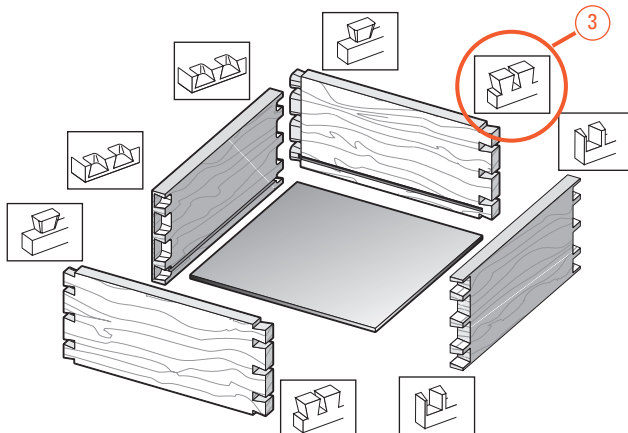


Glossary of Symbols

To help you understand the instructions and illustrations in this manual, we have used a number of international symbols, plus a few special ones of our own. They are all explained below. **You needn't worry about memorizing these symbols now**, because they are repeated quite frequently in the manual, and you will soon get used to them.

The Leigh jig's guidefinger assembly can be in any one of four joint modes, depending on what type of joint and which part of the joint you are cutting. Each finger assembly scale has its own mode icon ①, identifying that joint part. You will also find the joint mode icon in the top left corner of most illustrations ②, indicating which finger assembly mode to use.

Sometimes a joint mode icon will be used to identify a board ③.



These are the four joint mode icons:



TD Tails
(tails for through dovetail joints)



TD Pins
(pins for through dovetail joints)



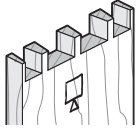
HB Tails
(tails for half-blind dovetail joints)





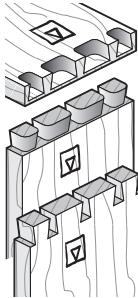
HB Pins
(pins for half-blind dovetail joints)



Which Way Round Should the Board Go?

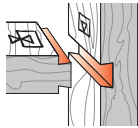
As virtually all dovetail joinery is used to make boxes, drawers and chests etc., we devised these simple (and hopefully intuitive) icons to indicate which side of a board faces inwards or outwards on the finished "box", and which side of the board faces outward (toward you, the operator), when it is clamped in the jig.







 This icon  indicates the "outside" of a board. All through dovetail pin boards are mounted in the jig with this "outside" face away from the jig (toward you, the operator).

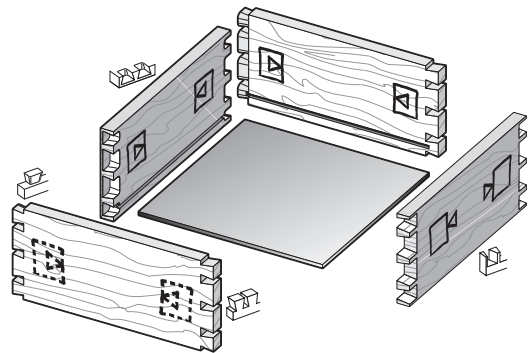
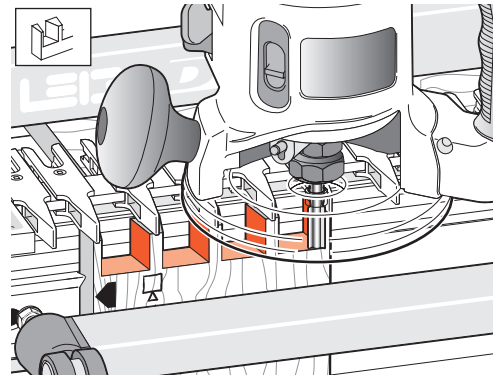


 This icon  indicates the "inside" of a board. All half-blind pin and half-blind tail boards, and through dovetail tail boards, are mounted in the jig with the "inside" face away from the jig toward you, the operator.



 This icon  indicates boards that are mounted both ways e.g. sliding dovetails.

 Dotted line icons  indicate the "other" side of the board in the illustrations.



The following symbols indicate:



This edge against sidestop



This edge against sidestop



Sawcut allowance



Caution: use special care for this operation

①②③ Numbered References in text



Centreline of board or layout



Equals



Does not equal



Approximately

