

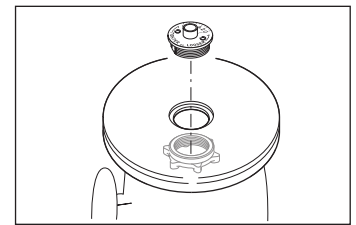
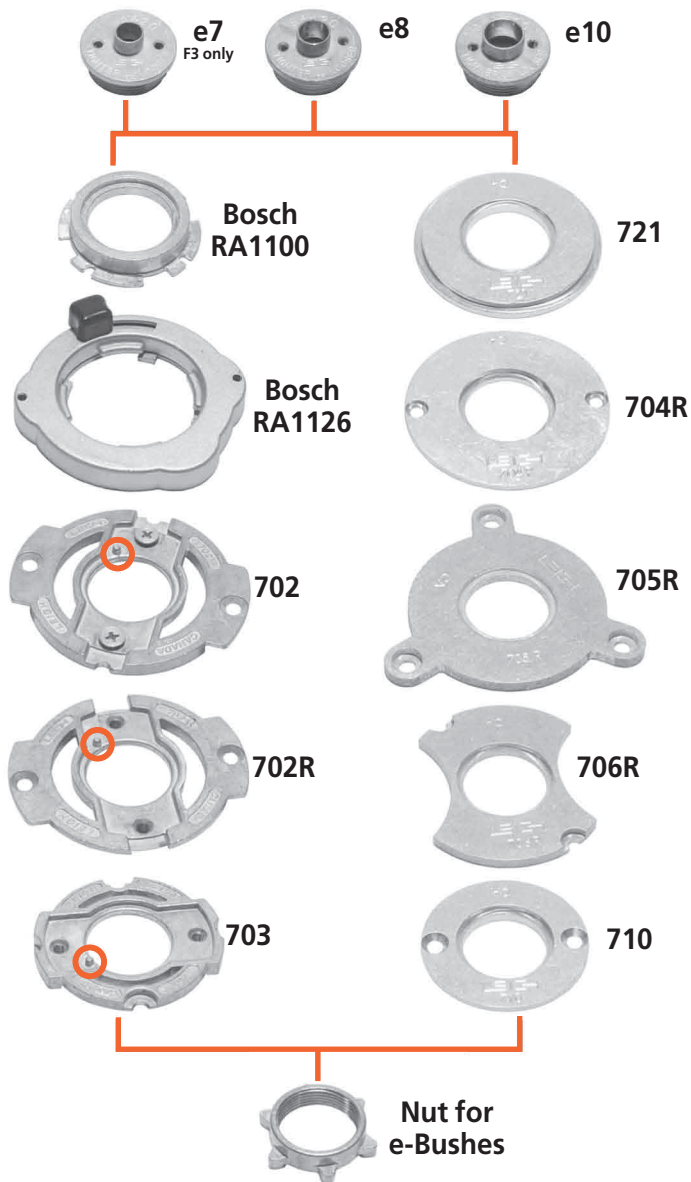
## Appendix I

# Attaching the Leigh e-Bush to the Router

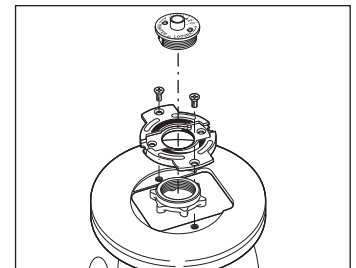
## e-Bush and Guide Adapters

The Leigh e-Bush fits directly to most popular router models such as Porter Cable, Black & Decker, and Dewalt. Many other makes, e.g. Bosch, Fein, Festool, Milwaukee etc., either offer or come complete with base adapters that accept the e-Bush. In addition Leigh offers the nine adapters below to allow the use of over one hundred other router models new and old.

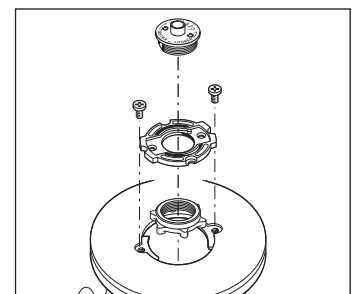
**For the complete listing of routers, see page 28.**



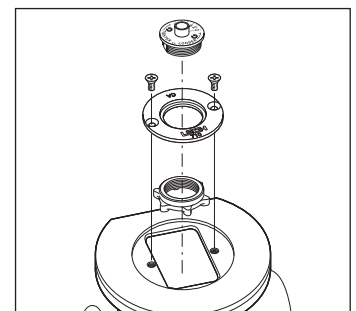
The eBuses fit directly to many routers.



The e-Bush with Adapter 702 & 702R.



The e-Bush with Adapter 703.



The e-Bush with Adapter 710.

Note: The small **lug** cast into the Leigh adaptors No's 702, 702R and 703 ① has to be removed to fit the e-Bush. **△** Simply drill through from the rear with a 1/8" [3,5mm] bit using all the normal metal shop safety precautions for this operation.

## e-Bush Mounting System

**NOTE: If your router is not listed here, visit leighjigs.com for a complete, up-to-date list of routers.**

### HOW TO USE THIS CHART

- A.** Locate the name of the router maker in Column A
- B.** Locate the model of the router in Column B
- C.** Locate the required adaptor for your router in Column C

- Order Leigh guide bushing adaptors, **red part numbers**, from Column C
- Order Bosch guide bushing adaptors, **black part numbers**, available from Leigh or your Bosch dealers, from Column C
- All other part numbers in black, in Column C, must be ordered from the router manufacturer's dealer

\* Leigh Adaptors 702, 702R, and 703 require a small lug to be drilled out to use the e7, e8 and e10 guide bushings. Instructions supplied with the adaptor.

■ **MAFELL** – Rework the adaptor slightly.

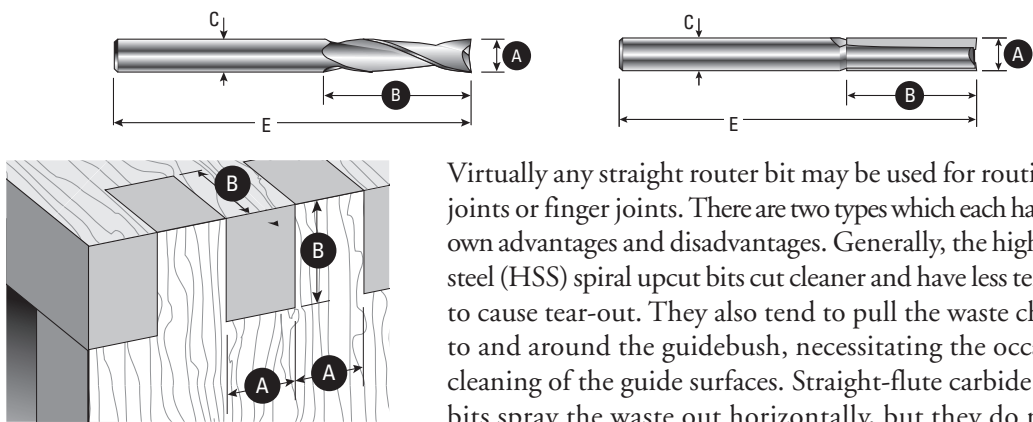
**Note:** Adaptor mounting screws are provided with router.

1 ROUTER MAKER	2 ROUTER MODEL	3 LEIGH OR ROUTER MAKER'S ADAPTOR NO.
AXMINSTER WHITE	AW635R	710
	AW127R	710
BLACK & DECKER	All Professional, HD1250, RP400K,7614	No adaptor required
	6200	720673-00
BOSCH	SR100, 7AEE, KW780 series, KW850	710
	90140, 90088, 90098	No adaptor required
	90085, 90150, 90300, 90303, 90305, 91264	2 610 906 290
	1600, 1601, 1602, 1603, 1604, 1606, B1350	RA1100 Template Adaptor and REA1126 Quick Change Adaptor required
	<b>ROUTERS PRODUCED AFTER mid 2010:</b> 1613AEVS, 1617EVS, 1618EVS, and MR23EVS series, sold in North America require Bosch adaptors RA1100 and RA1126	
BOSCH	<b>ROUTERS PRODUCED BEFORE mid 2010:</b> 1613AEVS, 1617EVS, 1618EVS, 1619EVS	RA1100
	POF800ACE, POF1400ACE, POF1100AE, POF1200AE, GOF900ACE, GOF1300ACE, GOF900CE, GOF2000CE	RA1100
	GOF1200, GMF1400, B1450, 1614/EVS, 1611, 1611EVS, 1615, 1615EVS, B1550, GOF1600, GOF1700ACE	702*
CMT	1E	702R*
CRAFTSMAN (SEARS)	All non-plunge models	No adaptor required
	135275070 Plunge	See Skil 1823 or 1835
	Other plunge models	702*
DEWALT	DW610, DW616, DW618	No adaptor required
	DW613, DW615(UK)	710
	DW614, DW615, DW621, DW624, DW625, DW626	North America Only, Adaptor supplied w/router
	DW621K & DW626 outside N. America	706R
	DW625 Type 1,2,3,5 outside N. America	702*
	DW624 & DW625 Type 4 outside N.America, DW625EK	702R*
ELU	OF15, OF15E, OF97, OF97E	706R*
	MOF68, MOF69, MOF96, MOF96E	710
	MOF131, MOF177 Type 1, 2, & 3	702*
	MOF177 Type 4, MOF177EK	702R*
	2720, 2721, 3328	No adaptor required
	3303, 3304	E09600 or 761 270-00
FEIN	3337, 3338, 3339	702*
	RT1800	Adaptor supplied w/router
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704R
	OF2000, OF2000E	705R
	OF1400 and OF2200 North America Only	Adaptor supplied w/router
	OF1400 Outside North America	493566
FLEX	OF2200 Outside North America	494627 O-Ring required to keep guidebush centered
	All	No adaptor required
FREUD	FT700(2), FT2000, FT2200, FT3000	721
HITACHI	TR8, TR12, FM8, M8, M12 Series	325211 OR 703
	M12VC, KM12SC, KM12VC	No adaptor required
	M12SA2, M12V2	325224
MAFELL	LO65E	■ 702*
	RP1801, RP2301	721
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N. America, 3620, 3621, RP900K	703
	3612C Europe Qk Fit Base	721
	3601B	321 493-1
	RP0910, RP1110C	706R
	RF1100, RF1101, RD1100, RD1101, RP1101	No adaptor required
METABO	OF1612, OFE1812	704R
MILWAUKEE	5615, 5616, 5619	49-54-1040
	5625	49-54-1026
	5670	No adaptor required
PERLES	OF808 Series, OFE6990	710
PORTER CABLE (ROCKWELL)	All	No adaptor required or adaptor supplied w/router
POWER DEVIL	All	710
RIDGID	R2930	704R
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703*
	R600, R601, RE600, RE601	702*
	R160, R161, R162, R163K, R165, R170, R175, RE175, R180, R180PL, R181, R185, ERT1150	706R
	1823 or 1835	91803
SKIL	All others	No adaptor required
	SK1810, 1815, 1820, 1825	RAS140
TREND	T3, T4	710
	T5, T9	710
	T10, T11 - UniBase required	710
TRITON	TRC001, TRA001	TGA006 or 704R
	MOF001	TRA359
WEGOMA	OF850 Series	710

## Appendix II

# Bit Selection and Joint Specification

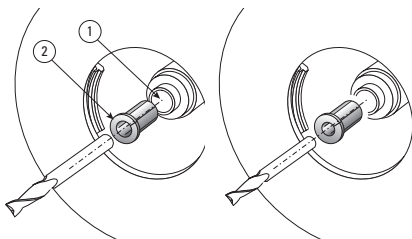
## Bit Selection and Joint Specification



Virtually any straight router bit may be used for routing box joints or finger joints. There are two types which each have their own advantages and disadvantages. Generally, the high-speed steel (HSS) spiral upcut bits cut cleaner and have less tendency to cause tear-out. They also tend to pull the waste chips up to and around the guidebush, necessitating the occasional cleaning of the guide surfaces. Straight-flute carbide tipped bits spray the waste out horizontally, but they do not cut quite as cleanly.

“A” is the bit diameter and equals the nominal size of the finger or socket.

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



Check the shank size of each bit selected, then use the appropriate collet ① or collet reducer ②. 1/4" collet reducers come standard with most 1/2" collet routers, but **if 5/16", 8mm or 3/8" collets are not available, use one of the following:**

For all 3/8" shank bits use the Leigh No. 172-375, 1/2" to 3/8" collet reducer.

For all 5/16" and 8mm shank bits (*these are almost the same diameter*), use Leigh No. 172-8, 1/2" to 8mm collet reducer.

## BIT SELECTION &amp; JOINT SPECIFICATIONS

## F18 and F24

LEIGH Bit Item No.		Solid Carbide Spiral	A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
Carbide Tipped	HSS Spiral					
163	163	—	3/32"	3/8"	1/4"	2"
134	164	164C	1/8"	3/8"	1/4"	2 5/8"
136	166	166C	3/16"	5/8"	1/4"	2 7/8"
138	168	168C	1/4"	3/4"	1/4"	3"
143	173	173C	3/8"	1"	3/8"	3"
160	180	180C	1/2"	1"	1/2"	3 1/2"

## F18M and F24M

A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
3	12	8	70
5	19	8	70
6	19	8	70
10	25	8	75
12	25	8	75

Leigh does not stock metric sized bits. Please contact your national distributor for Leigh.

## F3

LEIGH Bit Item No.		Solid Carbide Spiral	A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
Carbide Tipped	HSS Spiral					
163	163	—	3/32"	3/8"	1/4"	2"
134	164	164C	1/8"	3/8"	1/4"	2 5/8"
135	165	165C	5/32"	5/8"	1/4"	2 7/8"
136	166	166C	3/16"	5/8"	1/4"	2 7/8"
138	168	168C	1/4"	3/4"	1/4"	3"
140-8	170	170C	5/16"	7/8"	8mm & 5/16"	2 3/4"
143	173	173C	3/8"	1"	3/8"	3"
160	180	180C	1/2"	1 1/4"	1/2"	3 1/2"

See "[www.leighjigs.com](http://www.leighjigs.com)", click on support/technical bulletins/wider box joints

## F3M

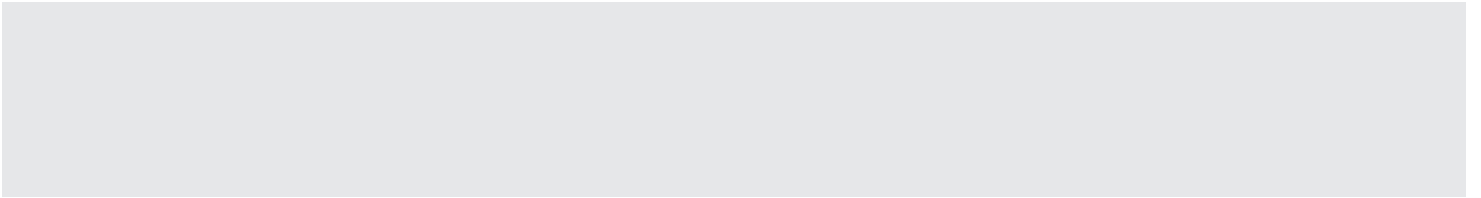
A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
2	10	8	70
4	15	8	70
6	19	8	70
8	22	8	70
10	25	8	75
12	32	8	75

Leigh does not stock metric sized bits. Please contact your national distributor for Leigh.

See "[www.leighjigs.com](http://www.leighjigs.com)", click on support/technical bulletins/wider box joints

*Appendix III*

**Template Parts List**



For quick reference, record your template's serial number here.

## PARTS

To order parts, please quote Template model (inch or metric), serial no., part no., part description and quantity required.

### F18, F18M, F24, F24M

PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
3418	1	F18 "Inch" Template
3418M	1	F18 "Metric" Template
3424	1	F24 "Inch" Template
3424M	1	F24 "Metric" Template
3419	1	F18 "Inch" Template Bar with glides (3140)
3419M	1	F18 "Metric" Template Bar with glides (3140)
3425	1	F24 "Inch" Template Bar with glides (3140)
3425M	1	F24 "Metric" Template Bar with glides (3140)
3360	1	RH Scale Assembly (RH in $\frac{3}{8}$ " & 10mm mode)
3370	1	LH Scale Assembly (LH in $\frac{3}{8}$ " & 10mm mode)
7210	2	Scale Nut
7215	2	Scale Washer
7220	2	Scale Wedge
7225	2	Scale Lock Screw #8-32
7250	2	Scale Thumbscrew
7255	2	Nylon Flat Washer $\frac{13}{64}$ " x $\frac{7}{16}$ " x .062"

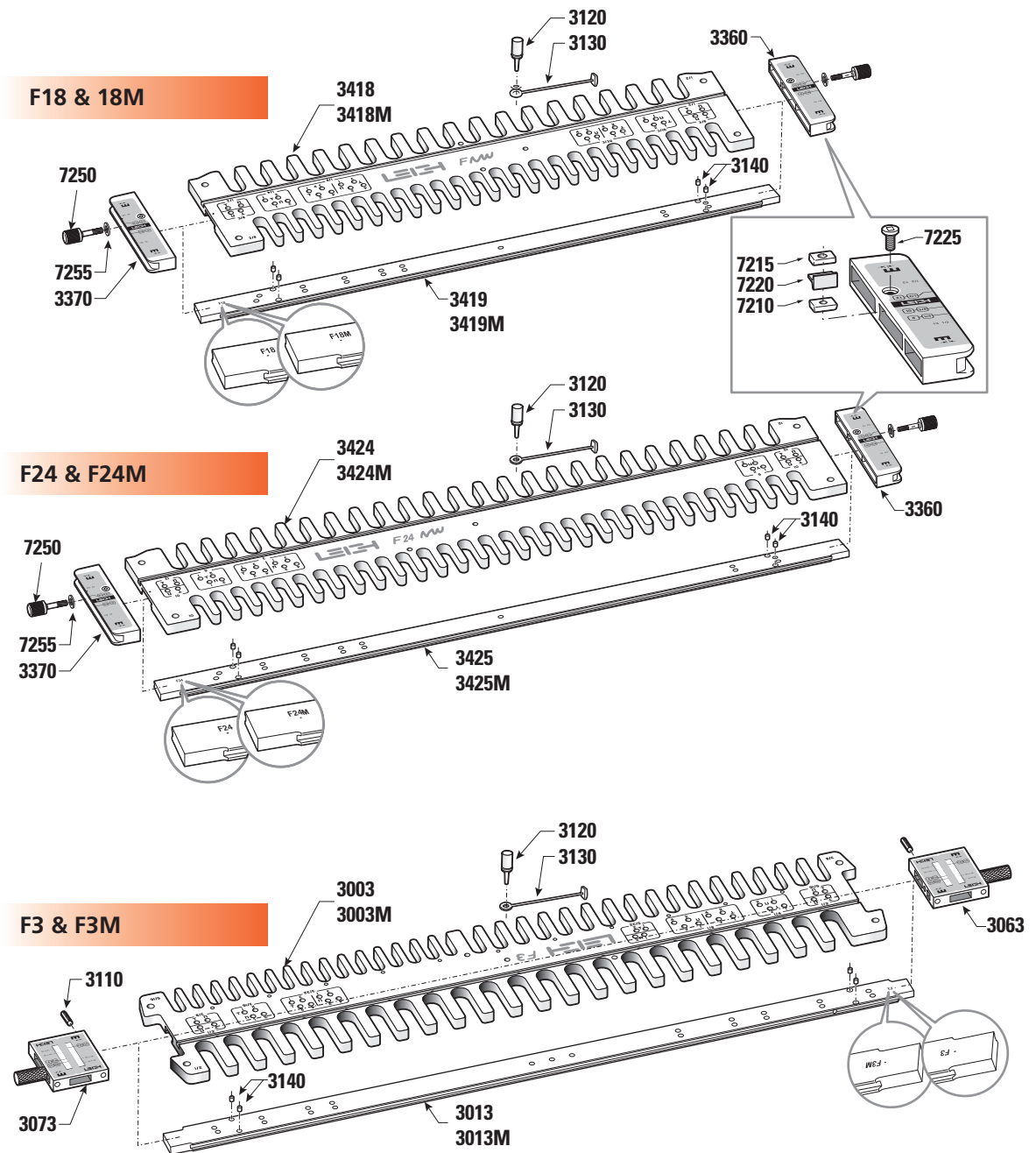
### F3, F3M

PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
3003	1	F3 "Inch" Template
3003M	1	F3M "Metric" Template
3013	1	F3 "Inch" Template Bar with Glides (3140)
3013M	1	F3 "Metric" Template Bar with Glides (3140)
3063	1	F3/F3M RH Scale Assembly (RH in $\frac{1}{2}$ " & 12mm mode)
3073	1	F3/F3M LH Scale Assembly (LH in $\frac{1}{2}$ " & 12mm mode)
e7	1	$\frac{7}{16}$ " e-Bush and nut
3156	1	Allen Wrench for Set Screws
3110	2	Scale Lock Set Screws

### COMMON TO ALL F-TEMPLATES

PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
e8	1	$\frac{1}{2}$ " e-Bush and nut
e10	1	$\frac{5}{8}$ " e-Bush and nut
3120	1	Template Pin with Tie (3130)
3130	1	Template Pin Tie
3140	4	Template Bar Glides
3470	1	User Guide, combined inch & metric
730V	1	Pin Wrench

**F18, F18M, F24, F24M PARTS ILLUSTRATIONS**



**e7 & Nut**  
only with  
F3 & F3M



**e8 & Nut**  
with all  
templates



**e10 & Nut**  
with all  
templates



**3471**



## Appendix IV

## Customer Support

## Our Commitment to You

At Leigh Industries we take pride in our commitment to provide excellence in customer service and support. We hope your use of the Leigh F Templates will be enjoyable, rewarding, and most of all, trouble free. We trust that this User Guide will provide you with the answers to any questions you may have.

If this is not the case, please feel free to contact our technical support staff or a distributor listed in this section.

## Canada &amp; USA - Manufacturer

Leigh Industries Ltd. (EST. 1981)  
P.O. Box 357,  
1615 Industrial Ave.,  
Port Coquitlam, B.C.,  
Canada, V3C 4K6

Toll Free: 1-800-663-8932  
Telephone: 604-464-2700  
Facsimile: 604 464-7404  
Customer Service: leigh@leighjigs.com  
Tech Support: help@leighjigs.com  
\*Web: www.leighjigs.com

\*Email can be useful, but technical queries usually raise queries from us. So the telephone (if possible) is a much quicker and more convenient way to get those queries answered; either directly to Leigh (toll-free in North America) or to your national distributor. ...Thanks!

## Distributors

## Australia &amp; New Zealand

**Carba-Tec Pty. Ltd.**  
40 Harries Rd, Coorparoo, Qld., 4151  
Tel: (07) 3397 2577  
Fax: (07) 3397 2785  
Ordering: 180 658 111  
email: orders@carbatec.com.au

## France

**Ets Bordet**  
23 Rue Traversiere  
93556 Montreuil Cedex  
France  
Tel: 01 48 58 28 39  
Fax: 01 48 58 48 58  
Email: info@bordet.fr  
Web: www.bordet.fr/pages/

## Germany, Austria &amp; Switzerland

**Hacker GMBH**  
Holzbearbeitungsmaschinen  
Traberhofstraße 103 D-83026  
Rosenheim, Deutschland  
Tel: 08031 269650  
Fax: 08031 68221  
Email: hacker.rosenheim@t-online.de  
Web: www.leigh.de

## Italy

**Ferrari Macchine Legno SRL**  
Via Gallarata 74/76/78  
20019 Settimo M.se (MI)  
Italy  
Tel: 39 02 335 010 95  
Fax: 39 02 335 005 27  
Email: info@ferrarimacchine.com  
Web: www.ferrarimacchine.com

## Japan

**Off Corporation Inc.**  
323-1 Yanbara, Shimizu-ku, Shizuoka-shi  
Shizuoka-ken, Japan 424-0002  
Tel: 81-054-367-6511  
Fax: 81-054-367-6515  
Email: info@off.co.jp  
Web: www.off.co.jp

## Korea

**Leigh Korea**  
1st Floor, Yongyu Building, 25-3,  
Neung Pyung-Ri  
Opo-Eup, Kwangju-Si, Kyunggi-do  
Korea  
Tel: 82 (0) 70-8252-0988  
Fax: 82 (0) 31-765-5602  
Email: smgi@paran.com  
Web: www.htools.co.kr

## Norway

**Aurus**  
Stoelsmyravn. 103  
5542 Karmsund  
Norway  
Tel: +47 992 71 932  
Fax: 47 52 91 001  
Email: info@aurus.no  
Web: www.aurus.no

## Russia

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Nikitskij Boulevard 12  
Moscow, 119019  
Russia  
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Email: info@leighjigs.ru (Russia)  
Email: info@leighjigs.com.ua (Ukraine)  
Web: www.leighjigs.ru (Russia)  
Web: www.leighjigs.ua (Ukraine)

## South Africa

**Hardware Centre Group**  
Post: PO Box 4059, 2125  
Randburg, South Africa  
Tel: (011) 791-0844/46  
Fax: (011) 791-0850  
Email: info@hardwarecentre.co.za  
Web: www.hardwarecentre.co.za

## Sweden

**Toolbox Sweden AB**  
Bruksgatan 3  
S-597 30  
Atvidaberg, Sweden  
Tel: 46 120 854 50  
Fax: 46 120 854 69  
Email: info@toolbox.se  
Web: www.toolbox.se

## United Kingdom &amp; Ireland

**BriMarc Tools & Machinery**  
Unit 10a Weycroft Avenue  
Axminster  
Devon  
EX13 5PH  
England  
Tel: 0300 100 1008  
Fax: 0300 100 1009  
Email: email@brimarc.com  
Web: www.brimarc.com

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Joining Tradition with Today



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