

LEIGH  USER GUIDE

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# Isoloc™ Joint Templates



**Your New Leigh Isoloc™ Joint Template**

You now own an incredible jointing system which will help you create strong and beautiful decorative joints never before available.

The Leigh Isoloc\* (equal locking) Templates (I1A, I1B and I1C) and Variable Guidebush System (VGS)\* are used on our 24" D Series jig base. They will enable you to rout uniquely beautiful half-blind corner joints, end-on-end, and even through-interlocking joints; with flexible VGS adjustment for precise joint fit.

Unlike other Leigh jigs, the Isoloc joint templates have dual inch and metric settings and may be used with either 5/16" or 8mm diameter cutters. Only one variable guidebush (No. 713V; included) is required.

**This manual is common to all Leigh Isoloc joint templates, and almost all illustrations show only the I1A template with "Key" and "Mirror Key" joint patterns. The joint icons are identical on all templates and all Isoloc templates work in exactly the same way.**

We recommend that you first mount the Isoloc templates on your D Series Leigh Dovetail Jig (it fits to D1258-24, D1258R-24, D3-24 and D4 jigs and Jig Body) carefully following the instructions in the first section of the manual. Then read the rest of the manual, following along with the basic functions, before you try to do any actual joinery routing. By all means, cut a few practice joints in scrap boards before you use the Isoloc template to rout a precious hardwood workpiece.

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

\*Leigh Isoloc joints, Isoloc templates, and Variable Guidebush System are protected by U.S., Canadian, and European patents.

\*\*See [Appendix IV – Customer Support](#)

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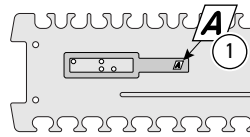
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### How to Read the Symbols

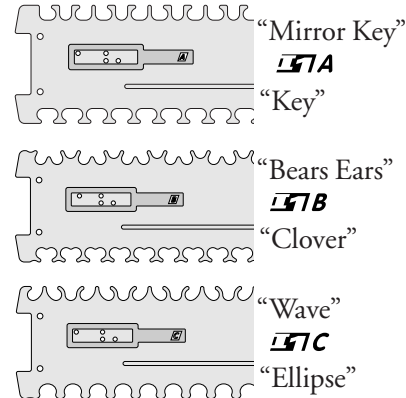
To help you understand the instructions and illustrations in this manual, we have used a number of international symbols, plus a few special ones of our own. They are all explained below. You needn't worry about memorizing these symbols now, because they are repeated quite frequently in the manual, and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

### Glossary of Symbols

There are three templates in the **57** Series (1997). Each template has two Isoloc joint patterns for a total of six available joint shapes. Each template is identified by letter; A, B, or C ①, and each joint pattern is named in texts for reference, as below:



Only the **57A** "Key" template pattern is used in this manual. Procedures for all other joints are similar.



### Scale Icons



The scales all feature the same icon which (this way up) indicates the active scale.

### Template Icons



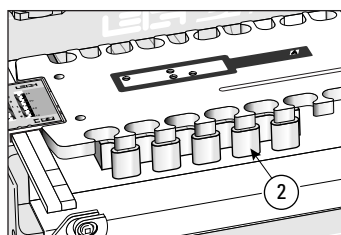
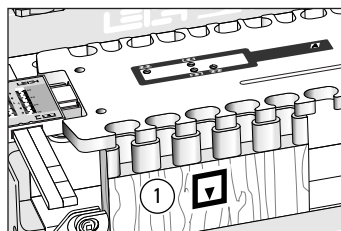
Indicates the template position for vertical pin boards.





Indicates the template position for horizontal socket boards.

### Isoloc Joint Terminology

It's a new joint with a new name, but we thought we would keep the joint part terminology simple. It is similar to typical dovetail terminology and should be easy to remember. Straight parts, cut in line with the grain are "pins" ①. Curved parts, cut across the grain are "sockets" ②.



### Which Way Round Should the Board Go?

Most joinery done on the Leigh  templates is for casework (i.e., boxes, drawers, and so on) so in nearly all the illustrations we have indicated which side of the board faces you when it is in the jig, e.g., in this illustration, the inside face  of the board faces away from the jig. Note: On all Isoloc joint boards except end-on-end joints, the inside of the board faces away from the jig body.



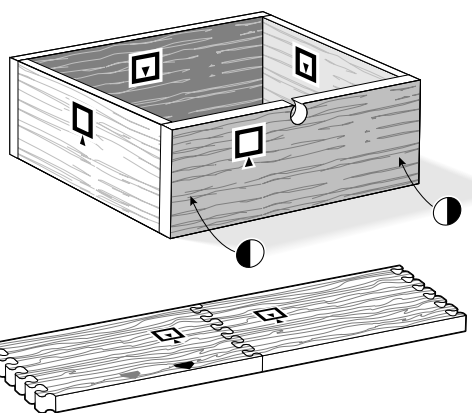
This indicates the side of the board that will face outward on the finished project.



This indicates the side of the board that will face inward on the finished project.



This indicates a side that can face either inward or outward on the finished project.



The following symbols indicate:



Left side of item (drawer, box, case, etc.)



Right side of item



Top of item



Bottom of item



This edge against side stop



This edge against side stop



Sawcut allowance



Caution: use special care

①②③ Reference in text



Diameter



Centreline of board or layout



Equals



Does not equal



Approximately



Less than or equal to



Greater than or equal to

