


# VGS Guidebush and Cutter Selection

## VGS: The Leigh Variable Guidebush System

The 5-piece VGS is included with Isoloc joint templates but you may need an optional adaptor for your router (see next pages).

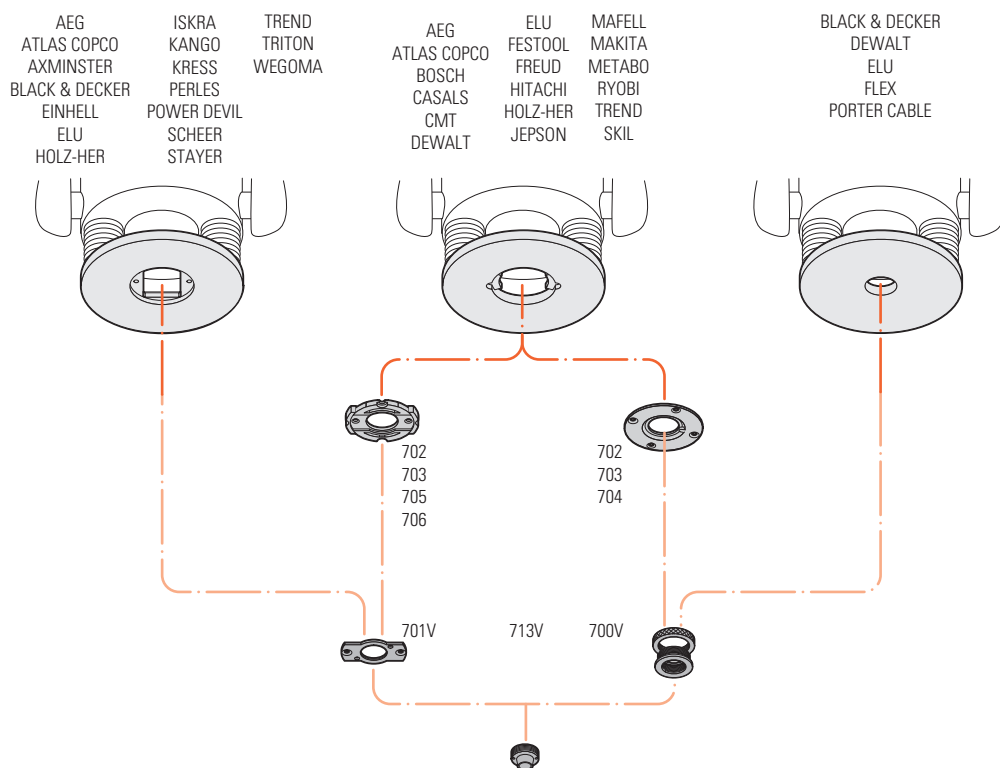
 Do not use the VGS on D Series jigs or the M2 (MMTA) as the tapered VGS bushes will not index properly on the guidefingers and guide rails.

### The Variable Guidebush System

#### The Vital Link Between Your Router and Leigh Isoloc Joint Templates

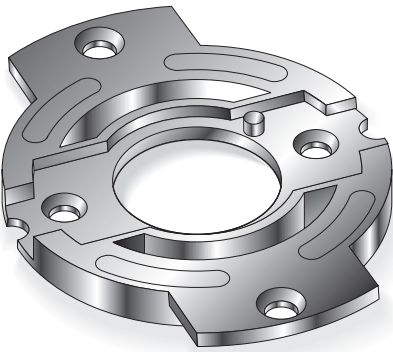
Because there is little or no standardization in the router industry, Leigh has developed a comprehensive guidebush and adaptor system to match your router to Leigh jigs and attachments. The diagram below shows how the VGS parts relate to each other and adapt to different makes and types of routers.

Do not use this diagram for part selection. See next pages.

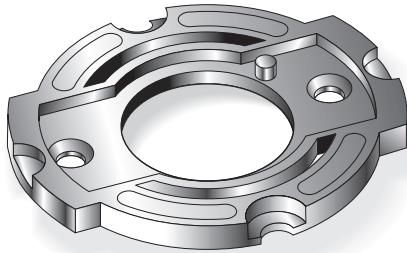


Do not use this diagram for part selection. See next pages.

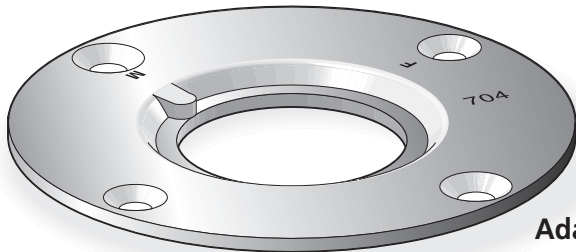
Optional Adaptors, if required (702R not shown):



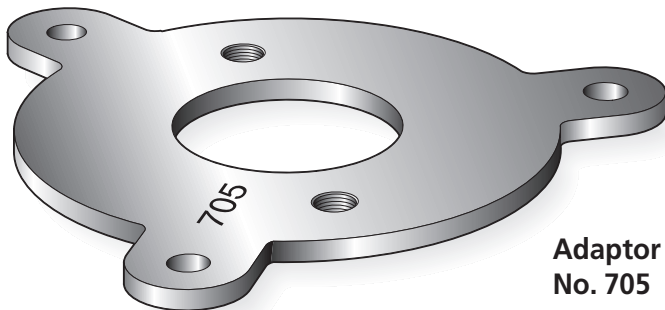
**Adaptor  
No. 702**



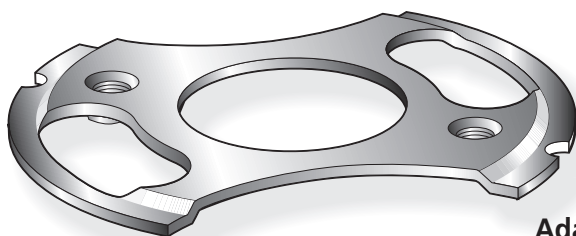
**Adaptor  
No. 703**



**Adaptor  
No. 704**



**Adaptor  
No. 705**

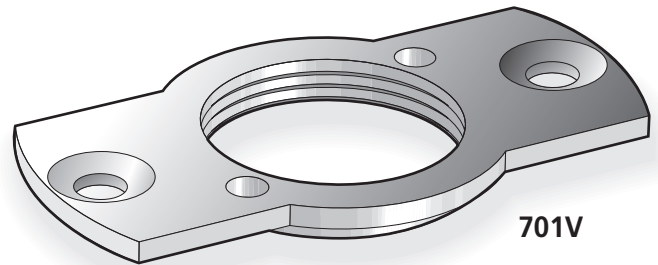


**Adaptor  
No. 706**

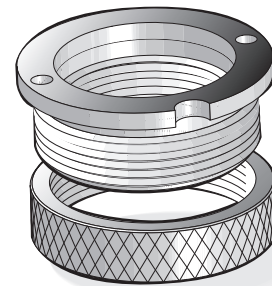
## How to Select Router Adaptors for the Leigh Isoloc Templates and Variable Guidebush System

1. Go to Selection Chart on the facing page.
2. Find the make and model of your router from columns 1 and 2.
3. See which standard variable guidebush holder works with your router in column 4. **This holder is included with your Isoloc template.**
4. Select the optional Adaptor Plate for your router (if required) from column 3. *NA means not available for those model routers. Leigh does not stock router manufacturers' adaptors.*

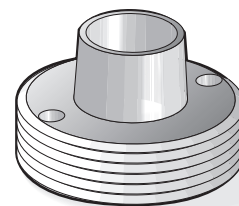
*These accessories are included with the Isoloc template.*



**701V**



**700V**



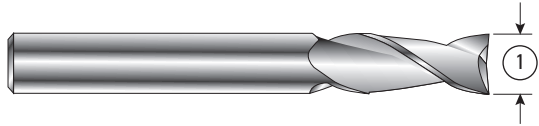
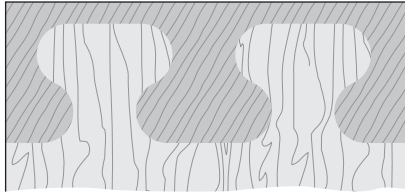
**713V**

Find the make and model of your router in columns 1 and 2. See which Leigh holder works with your router in column 4. Select the correct adaptor plate for your router (if required) from column 3. Leigh adaptors are in red. Other adaptors must be purchased from the router manufacturers distributor. Note: The VGS holders and bush are included with your **LS7**.

1 ROUTER MAKER	2 ROUTER MODEL	3 (optional) LEIGH OR ROUTER MAKER'S ADAPTOR NO.	4 (included) LEIGH VGS HOLDER
AEG	OFE 710 in plunge base	No adaptor required	701V
	OFSE 2000	703	
ATLAS COPCO	OFSE 710 in Plunge Base, OFE 1000	No adaptor required	701V
	OFSE 2000	703	
AXMINSTER WHITE	AW635R	No adaptor required	701V
	AW127R	Adaptor supplied w/router	
BLACK & DECKER	All Professional HD 1250, RP400K	No adaptor required	700V
	6200	720673-00	
	SR100, 7AEE, KW780 Series	No adaptor required	
BOSCH	90140, 90098, 90088	No adaptor available	700V
	90085, 90150, 90300, 90303, 90305, 91264		
	1600, 1601, 1602, 1603, 1604, 1606, B1350	2 610 906 290	
	1613, 1613EVS, 1613AEVS, 1614, 1614EVS, 1614EVS, 1617, 1617EVS, 1618EVS, 1619EVS, B1450, POF800ACE, GOF900ACE, GOF1300ACE, GOF2000CE	RA1100	
	1611, 1611 EVS, 1615, 1615 EVS, B1550, GOF1600, GOF1700 ACE	702	
		703	
CASALS	FT750, FT1000E, FT2000E	703	701V
CMT	1E	702R	701V
CRAFTSMAN (SEARS)	All non-plunge models	No adaptor required	NA
	135275070 Plunge	See Skil 1823 or 1835	See Skil 1823 or 1835
	Other plunge models	702	701V
DEWALT	DW610, DW616, DW618	No adaptor required	700V
	DW 613	No adaptor required	701V
	DW614, DW615, DW618, DW621, DW624, DW625, DW626	North America only; Adaptor supplied w/router	700V
	DW621K & DW626 Outside North America	706	701V
	DW625 Type 1, 2 and 3 Outside North America	702	
	DW625 Type 4, Outside North America, DW625EK	702R	
EINHELL	EOF850SP, OF-G 1100E	No adaptor required	701V
ELU	2720, 2721, 3328	No adaptor required	700V
	3303, 3304	E09600 or 761 270-00	
	3337, 3338, 3339, MOF131, MOF177, Type 1,2 and 3	702	
	MOF68, MOF69, MOF96, MOF96E	No adaptor required	
	OF15, OF15E, OF97, OF97E	706	
	MOF 177 Type 4, MOF177EK	702R	
FEIN	RT1800	Adaptor supplied w/router	700V
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704	700V
	OF2000, OF2000E	705	701V
FLEX	ALL MODELS	No Adaptor required	700V
FREUD	FT2000	703	701V
HITACHI	TR8, TR12, FMB, MB, M12 Series	703	701V
HOLZ-HER	2355, 2356	No adaptor required	701V
	2365	702	
ISKRA	MR808A Series	No adaptor required	701V
JEPSON	7412	703	701V
KANGO	OF808	No adaptor required	701V
KRESS	OF690 IE Series	No adaptor required	701V
MAFELL	LO65E	702 ■	701V
MAKITA	3601B	321 493-1	700V
	RF1100, RF1101, RD1100, RD1101, RP1101	No adaptor required	701V
	RP0910, RP1110C	706	
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N. America, 3620, 3621	703	
	3612C Europe Qk. Fit Base	Contact your National Leigh distributor	
METABO	OF1612, OFE1812	704	700V
MILWAUKEE	5615, 5619	49-54-1040	700V
	5625	Adaptor supplied w/router	
PERLES	OF808 Series, OFE6990	No adaptor required	701V
PORTER CABLE (ROCKWELL)	All	No adaptor req'd, or supplied w/router	700V
POWER DEVIL	All	No adaptor required	701V
RYOBI	R30, R50, R150, R151, R155, RE155, R500, R501, R502	703	701V
	R600, R601, RE600, RE601	702	
	R160, R161, R162, R165, R170, R175, RE175, R180, R180PL, R185	706	
SCHEER	HM9, HM14, HM14-12, HM18, HM18-E	No adaptor required ●	701V
SKIL	1823 or 1835	91803	700V
	All others	See Bosch Distributor	NA
STANLEY	All	No adaptor available	NA
STAYER	PR50 Series	No adaptor required	701V
TREND (Fellisati)	T5	No adaptor required	701V
	T9	Adaptor supplied w/router	
TRITON	TRC001	TGA002	700V
WEGOMA	OF850 Series	No adaptor required	701V

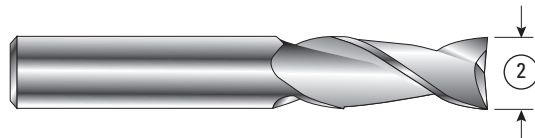
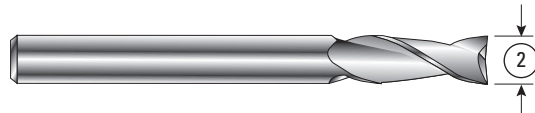
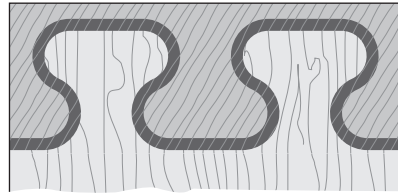
■ MAFELL – Rework the adaptor slightly. ● SCHEER – Rework the router base slightly.

## ISOLOC JOINT BIT SELECTION

**Plain Joints; Half-Blind or Through**

For plain joints without inlay, this is really easy. Use only a single straight bit; either Leigh No.170 or 170C,  $\frac{5}{16}$ " diameter or 8mm diameter ①.

The 0.0025" [0.0635mm] diameter difference is easily "adjusted out" with the Leigh VGS.

**Inlaid Joints**

Inlay joints require two straight bits ②: For  $\frac{1}{16}$ " wide inlays, use:

$\frac{1}{4}$ " diameter (Leigh 168 or 168C),  
and  $\frac{3}{8}$ " diameter (Leigh 173 or 173C).

For 2mm wide inlays, use:  
6mm and 8mm diameter.

*Note: For narrower inlays of  $\frac{1}{32}$ " or 1mm, see 8-15.*

## ISOLOC - Appendix II

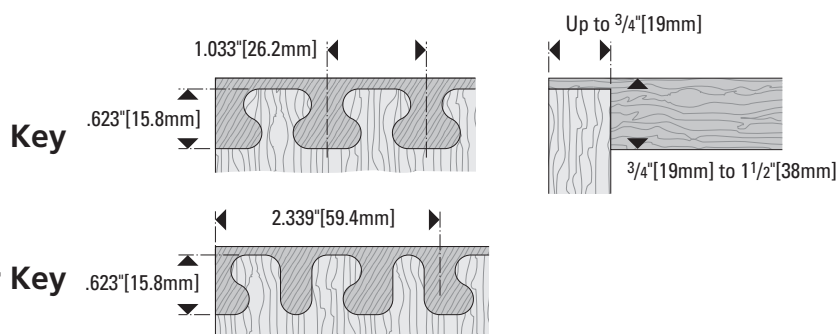
# Joint Specifications

### Isoloc Joint Specifications

These drawings show the precise Isoloc joint specifications. Pin boards may be up to 1½" [38mm] thick on the 24" D type jig, and 1" thick on the D1600 and Superjigs. Socket boards have a maximum practical thickness of ¾" to 1", depending on wood species. Routing thicker socket boards with a ⅝" [8mm] bit is not practical, even using progressive depth routing. For maximum board widths, see Chapter 5.

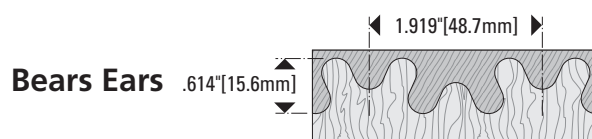
Inlay strips are generally ⅛" or 2mm thick, but it's easy to achieve ⅜" or 1mm (see 8-15).

**I1A**  
**I1600A**  
**I24A**



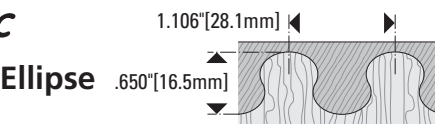
**I1B**  
**I1600B**  
**I18B**  
**I24B**

**Clover**

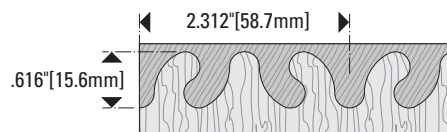


**I1C**  
**I1600C**

**Ellipse**



**Wave**



## Isoloc Joint Identification and Design Reference

	PLAIN JOINT (actual size)	INLAY			
		1/16"	1/32"	2mm	1mm
<b>I1A</b> <b>I1600A</b> <b>I24A</b>  Key					
Mirror Key					
<b>I1B</b> <b>I1600B</b> <b>I18B</b> <b>I24B</b>  Clover					
Bears Ears					
<b>I1C</b> <b>I1600C</b>  Ellipse					
Wave					

Inlay strips are generally 1/16" or 2mm thick, but it's easy to achieve 1/32" or 1mm (see 8-15).

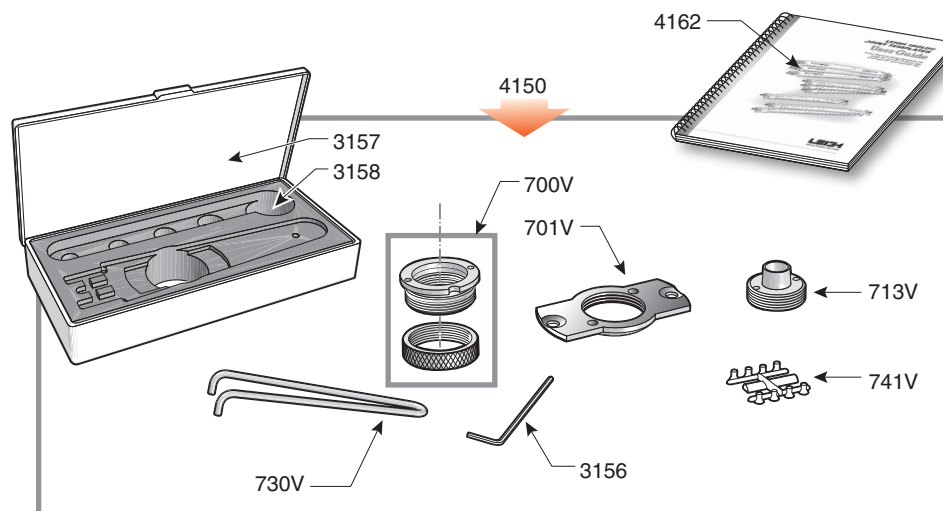
## ISOLOC - Appendix III

# Template Parts List

### Parts List for VGS Package supplied with all Isoloc Templates

When ordering parts, please quote the number (A, or B, or C) that matches your template; its serial number, the part numbers required, and part descriptions.

PART NO.		TEMPLATE DESCRIPTION
3156	1	Allen Wrench for Scale Set Screws (not required with I1600)
3157	1	Isoloc VGS Box
3158	1	Isoloc VGS Box Liner
4150	1	Isoloc VGS Set complete
4162	1	Isoloc User Guide (covers all Isoloc models)
700V	1	VGS Holder (2 pieces)
701V	1	VGS Holder
713V	1	VGS Bush
730V	1	Pin Wrench for VGS
741V	1	6 Nylon Thread Inserts for VGS (on tree)



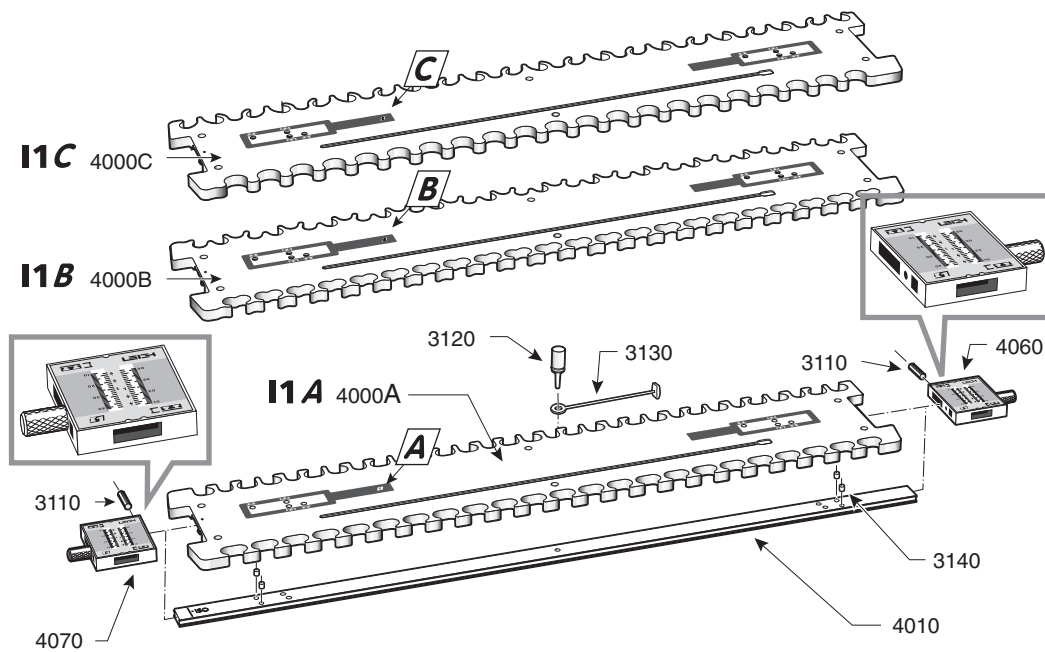
### Parts List for I1 24" Isoloc Templates

When ordering parts, please quote the number (A, B, or C) that matches your template; its serial number, the part numbers required, and part descriptions.

PART NO.	TEMPLATE DESCRIPTION
4000A	Key & Mirror Key Template "A"
4000B	Clover & Bears Ears Template "B"
4000C	Ellipse & Wave Template "C"

### I1 Parts and Sub-Assemblies:

PART NO.	QUANTITY PER TEMPLATE	PART DESCRIPTION
3110	2	Scale Bar Set Screws
3120	1	Template Pin
3130	1	Template Pin Tie
3140	4	Template Bar Glides (installed in Template Bar)
4010	1	Template Bar (complete with four glides)
4060	1	RH Scale Assembly (RH with 3110 screws away from you)
4070	1	LH Scale Assembly (LH with 3110 screws away from you)

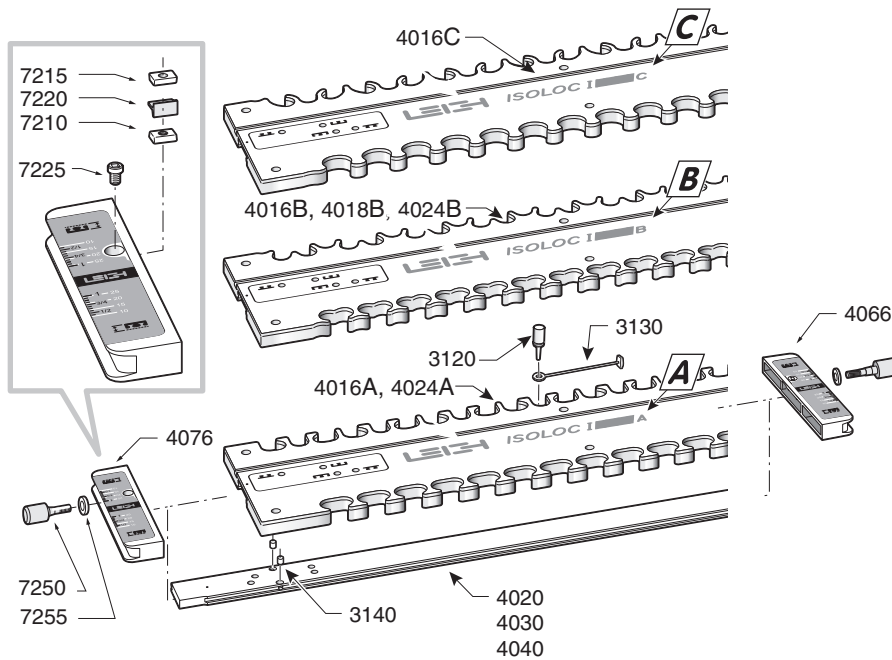


### I1600, I18, I24 Isoloc Templates

When ordering parts, please quote the number and letter (A, B, or C) of your template; its serial number, the part numbers required, and part descriptions.

PART NO.	TEMPLATE DESCRIPTION	PART NO.	TEMPLATE DESCRIPTION
4016A	Key & Mirror Key Template "A"	4018B	Clover & Bears Ears Template "B"
4016B	Clover & Bears Ears Template "B"	4024A	Key & Mirror Key Template "A"
4016C	Ellipse & Wave Template "C"	4024B	Clover & Bears Ears Template "B"

PART NO.	QUANTITY PER TEMPLATE	PART DESCRIPTION
4020	1	16" Template Bar complete with four glides
4030	1	18" Template Bar complete with four glides
4040	1	24" Template Bar complete with four glides
4066	1	RH Scale Assembly
7250	2	Scale Thumb Screws
7255	2	Nylon Washers
4076	1	LH Scale Assembly
3110	2	Scale Bar Set Screws
3120	1	Template Pin
3130	1	Template Pin Tie
3140	4	Template Bar Glides (installed in Template Bar)





## 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 Isoloc Templates will be enjoyable, rewarding and most of all, trouble free. We hope 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 our distributor in your country by any of the means listed below.

### Canada & 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  
\*E-mail: leigh@leighjigs.com  
Website: 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 & New Zealand

**Carba-Tec Pty. Ltd.**  
40 Harries Rd, Coorparoo, Qld., 4151  
Tel: (07) 3397 2577  
Fax: (07) 3397 2785  
Ordering: 1 800 658 111  
Email: orders@carbatec.com.au

**Mik International**  
27 Magill Road, Stepney, SA 5069  
Australia  
Tel: 08 8363 4666  
Fax: 08 8362 3444  
Email: inquiries@mik.com.au  
Web: www.mik.com.au

#### France

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

#### Germany, Austria & Switzerland

**Hacker GMBH**  
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Deutschland  
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Fax: 08031 68221  
Web: www.leigh.de

#### Italy

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20019 Settimo Milanese (MI) Italy  
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Fax: 0039 02 33500527  
Email: info@ferrarimacchine.com  
or info@leigh.it  
Web: www.ferrarimacchine.com  
or www.leigh.it

#### Japan

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Shizuoka City, Japan 424-0002  
Tel: 81-054-367-6511  
Fax: 81-054-367-6515  
Email: craft@off.co.jp  
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#### Korea

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Web: www.woodworking-academy.com

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Web: www.aurus.no

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Fax: (011) 791-0850  
Email: info@hardwarecentre.co.za  
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#### Sweden

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Web: www.toolbox.se

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*Manufacturers of Precision  
Woodworking Tools*

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