



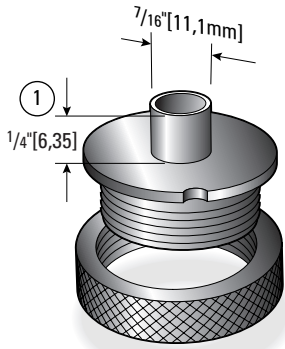
DAR APPENDIX I

Guidebush Selection

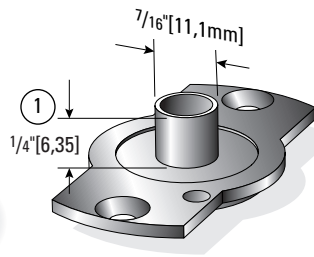


Foreword

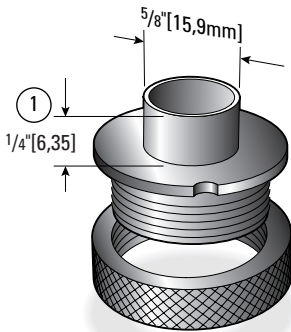
The correct guidebush is the vital link between the router and your Leigh Jig. It precisely steers the router. Where possible, always use the Leigh system **to ensure correct bush length and precise diameter for accurate results.**



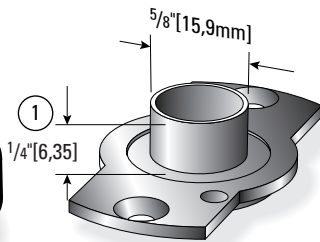
711 TP



711



716 TP



716

Guidebush Selection

Only two sizes of guidebush are used with the Leigh jig*: 7/16" [11,1mm] O.D. (outside diameter) and 5/8" [15,9mm] O.D.

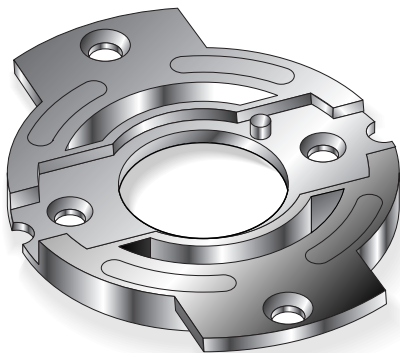
Bush barrel length ① from base of router should be 1/4 - 3/32" [6 - 7mm].

Use 7/16" [11,1mm] for all half-blind dovetailing and for through dovetailing with 1/4" [6,35mm] or 8mm shank bits: i.e., dovetail bit Nos. 50, 50-8, 60, 60-8, 70, 70-8, 75, 75-8, 80, 80-8, 101, 101-8, 120, 120-8, 128, 128-8, and straight bit Nos. 140 and 140-8.

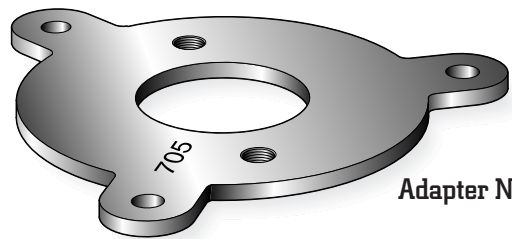
Use 5/8" [15,9mm] O.D. for large through dovetail bit combinations with 1/2" [12,7mm] shanks: i.e., bit Nos. 90, 160, 100, 150.

Here are the two types of Leigh guidebush and five Leigh adapters. Use the chart on page 145 to select the adaptor and/or guidebush required for your router.

**Except for sliding dovetails (see page 107).*



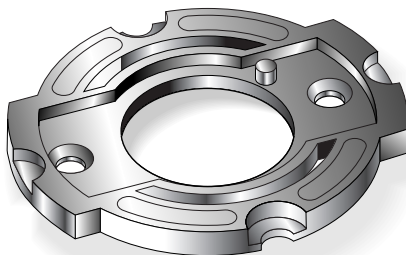
Adapter No. 702



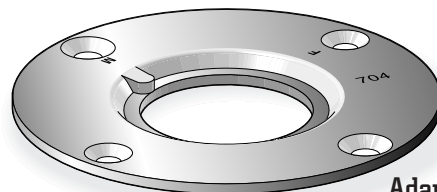
Adapter No. 705



Adapter No. 706

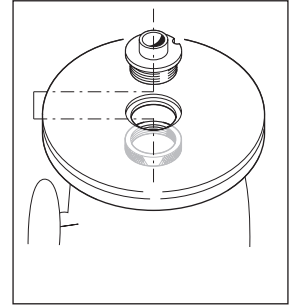


Adapter No. 703

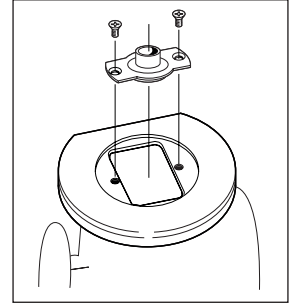


Adapter No. 704

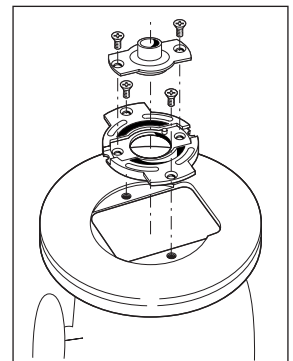
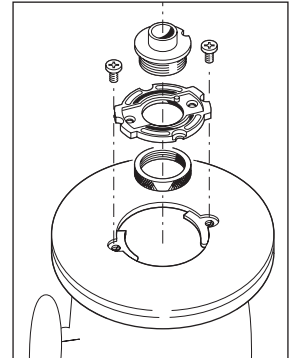
Leigh 711TP and 716TP (TP stands for Two Part) fit directly to Porter Cable and most Black & Decker routers.



Leigh 711 and 716 guidebushes fit directly to some routers using the screws that come with the router.



Leigh universal adapters fit to a wide range of plunge routers and generally accept both types of Leigh bush.



Template Guidebush System Selection Chart* (for 24" D-Series Jigs)

IMPORTANT: Check the make and model of your router in column 1. Where possible, a lways order the Leigh adaptors and template guidebushes (indicated in red), which are specially designed for use on Leigh jigs. Other adaptors and template guidebushes must be purchased from the router manufacturer's own distributor.

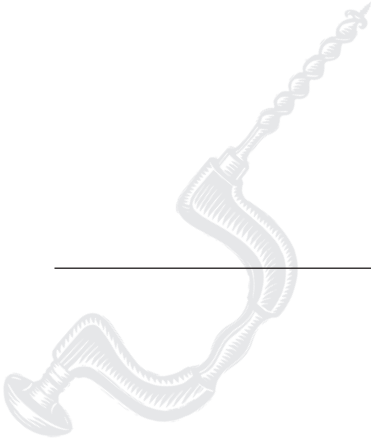
***NOTE: If your router is not listed here, visit leighjigs.com for a complete, up-to-date list of routers.**

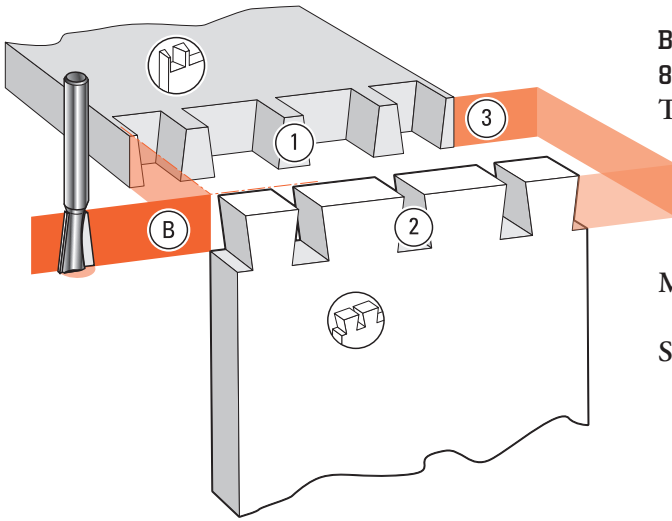
1 ROUTER MAKER	2 ROUTER MODEL	3 LEIGH OR ROUTER MAKER'S ADAPTOR NO.	4 7/16" OUTSIDE DIAMETER GUIDE BUSH NO.	5 5/8" OUTSIDE DIAMETER GUIDE BUSH NO. ▼	6 METHOD OF ATTACHMENT
AXMINSTER WHITE	AW635R	No adaptor required	711	716	Screws incl. w/router
	AW127R	Adaptor supplied w/router	711	716	Screws incl. w/router
BLACK & DECKER	All Professional, HD 1250, RP400K	No adaptor required	711TP	716TP	Threaded nut included
	6200	720673-00	711TP	716TP	2 screws req'd, 249412-20
	SR100, 7AEE, KW780 series	No adaptor required	711	716	Screws incl. w/router
BOSCH	90140, 90098, 90088	No adaptor required	82855	82854	Screws included
	90085, 90150, 90300, 90303, 90305, 91264		82859	82864	Screws included
	1600, 1601, 1602, 1603, 1604, 1606, B1350	2 610 906 290	711TP	716TP	Threaded nut included
	1613, 1613EVS, 1613AEVS, 1614, 1614EVS, 1617, 1617EVS, 1618EVS, 1619EVS, B1450	No adaptor required if using RA Template Guides	RA1107	RA1113	No screws required
	POF800ACE, POF1100ACE, GOF900ACE, GOF1200, GOF1300ACE, GOF2000CE	RA1100 required for 711TP, 716TP and VGS	711TP	716TP	Threaded nut included
	1611, 1611EVS, 1615, 1615EVS, B1550 GOF1600, GOF1700ACE	702	711 or 711TP	716 or 716TP	◆
CMT	1E	702R	711 or 711TP	716 or 716TP	◆
CRAFTSMAN (SEARS)	All non-plunge models	No adaptor required	Set of 3 bushes from Sears USA order no.25082 (stamped steel) or 25090 (plastic). Set of 3 bushes from Sears Canada order no.092-970-704		Screws incl. w/set
	135275070 Plunge Other plunge models	702	See Skil 1823 or 1835		◆
DEWALT	DW610, DW616, DW618	No adaptor required	711TP	716TP	Threaded nut included
	DW613	No adaptor required	711	716	Screws incl. w/router
	DW614, DW615, DW621 DW624, DW625 and DW626	North America Only Adaptor supplied w/router	711TP	716TP	Threaded nut included
	DW621K and DW626 outside N. America	706	711	716	◆
	DW625 Type 1, 2, 3, 5 outside N. America	702	711 or 711TP	716 or 716TP	◆
	DW625 Type 4 outside N. America, DW625EK	702R	711 or 711TP	716 or 716TP	◆
ELU	OF15, OF15E, OF97, OF97E	706	711	716	◆
	MOF68, MOF69, MOF96, MOF96E	No adaptor required	711	716	Screws incl. w/router
	MOF131, MOF177 Type 1, 2 & 3	702	711 or 711TP	716 or 716TP	◆
	MOF177 Type 4, MOF177EK	702R	711 or 711TP	716 or 716TP	◆
	2720, 2721, 3328	No adaptor required	711TP	716TP	Threaded nut included
	3303, 3304	E09600 or 761 270-00	711TP	716TP	Threaded nut included
FEIN	3337, 3338, 3339	702	711 or 711TP	716 or 716TP	◆
	RT1800	Adaptor supplied w/router	711TP	716TP	◆
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704	711TP	716TP	Threaded nut included
	OF2000, OF2000E	705	711	716	◆
	OF1400 North America Only	Adaptor supplied w/router	711TP	716TP	Threaded nut included
	OF1400 Outside North America	493566	711TP	716TP	Threaded nut included
FLEX	All	No adaptor required	711TP	716TP	Threaded nut included
FREUD	FT2000	703	711 or 711TP	716 or 716TP	◆
	FT1700	FT1100	711TP	716TP	Threaded nut included
HITACHI	TR8, TR12, FMB, M8, M12 Series	325211 or 703	711TP	716TP	Threaded nut included
	M12VC, KM12SC, KM12VC	No adaptor required	711TP	716TP	Threaded nut included
MAFELL	LO65E	702	711 or 711TP	716 or 716TP	◆
MAKITA	3600, 3606, 3608, 3612, 3612B, 3612BR 3612C N. America, 3620, 3621 3612C Europe Ok. Fit Base	703	711 or 711TP	716 or 716TP	◆
	3601B	321 493-1	711TP	716TP	Threaded nut included
	RP0910, RP1110C	706	711	716	◆
	RP0910, RP1110C	706	711	716	◆
METABO	RF1100, RF1101, RD1100, RD1101, RP1101	No adaptor required	711TP	716TP	Threaded nut included
	OF1612, OFE1812	704	711TP	716TP	Threaded nut included
MILWAUKEE	5615, 5616, 5619	49-54-1040	711TP	716TP	Threaded nut included
	5625	49-54-1026	711TP	716TP	Threaded nut included
PERLES	OF808 Series, OFE 6990	No adaptor required	711	716	Screws incl. w/router
PORTER CABLE (ROCKWELL)	All	No adaptor required or adaptor supplied w/router	711TP	716TP	Threaded nut included
POWER DEVIL	All	No adaptor required	711	716	Screws incl. w/router
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703	711 or 711TP	716 or 716TP	◆
	R600, R601, RE600, RE601	702	711 or 711TP	716 or 716TP	◆
	R160, R161, R162, R165, R170, R175, RE175, R180, R180PL, R181, R185	706	711	716	◆
SKIL	1823 or 1835	91803	711TP	716TP	Threaded nut included
	All others	No adaptor required	11592	71021	Nut 11587
	SK1810, 1815, 1820, 1825	RAS140	711TP	716TP	Threaded nut included
TREND (FELLISATI)	T5	No adaptor required	711	716	Screws incl. w/router
	T9	Adaptor supplied w/router	711	716	Screws incl. w/router
TRITON	TRA001	TGA006 or 704	711TP	716TP	Threaded nut included
	MOF001	TRA359	711TP	716TP	Threaded nut included
WEGOMA	OF850 Series	No adaptor required	711	716	Screws incl. w/router

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

◆ Guidebush mounting screws are provided with adaptor and adaptor mounting screws are provided with router.
 ▼ 5/8" O.D. guidebushes are used only with 1/2" shank router bits. ■ MAFELL - Rework the adaptor slightly.
 Note: Ideal barrel depth is 1/4" to 9/32" (6mm to 8mm) below the router base. Other manufacturers' guidebushes may require careful cutting to length. All Leigh bushes have 5/16" long barrels.

Bit Selection





Bit Selection for Through Dovetails

8° Dovetail Bit for Tails

The pins ①

must fit into the sockets ②. So the dovetail bit's depth of cut **B** must be equal to or a little greater than the pinboard thickness ③.

Measure

the pinboard thickness ③.

Select

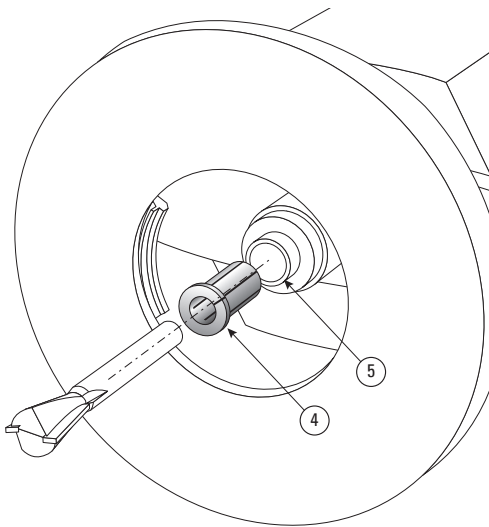
A dovetail bit with the appropriate depth of cut **B** from the following pages (bits must be 8° for through dovetails).

Straight Bit for Pins

The matching straight bit for routing the pinboard is listed next to the dovetail bit.

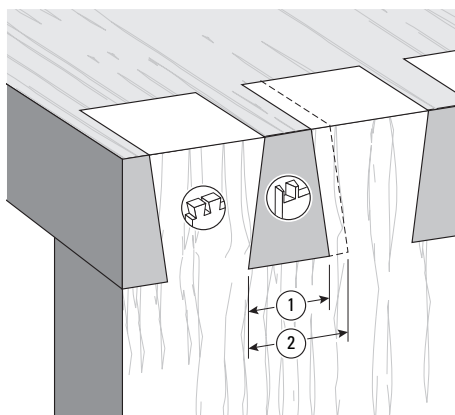
Guidebush

All 8mm shank through-dovetail bits listed in this appendix work with the $\frac{7}{16}$ " O.D. Guidebush that is supplied with your Leigh jig. The optional $\frac{5}{8}$ " O.D. Guidebush is used with $\frac{1}{2}$ " shank bits. No other guidebushes can be used for through dovetails.



Shank Selection


All Leigh Dovetail jigs are shipped with one 8mm shank through-dovetail bit, one 8mm shank through-dovetail straight bit, and a $\frac{1}{2}$ " to 8mm collet reducer. The reducer ④ simply slides into the $\frac{1}{2}$ " collet ⑤ of your router and the 8mm shank bit is inserted into the collet reducer. The collet is tightened as normal. The collet reducer is not required with $\frac{1}{2}$ " shank bits.



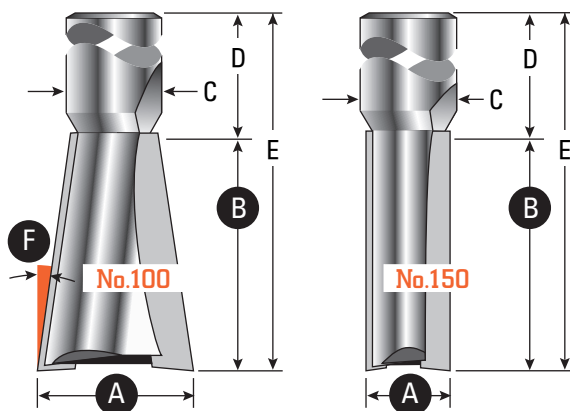
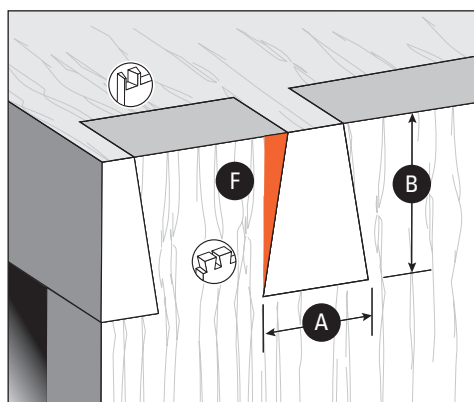
You will note that some of the dovetail bits' depths of cut overlap. For example:
 No.80-8 bit (B): $\frac{1}{2}$ " - $\frac{13}{16}$ " [12 - 20mm]
 No.90 bit (B): $\frac{5}{8}$ " - 1" [16 - 26mm]

This means that boards between $\frac{5}{8}$ " and $\frac{13}{16}$ " [16 - 20mm] thick can be joined using either the No.80-8 & 140-8 combination or the No.90 & 160-8 combination.

The two bit combinations will produce slightly different-looking joints because the No.80-8 bit can cut a narrower pin socket ① than the No.90 bit ②.

 Do not attempt to rout dovetails at less than the minimum depth of cut specified.

Leigh Through Dovetail Bits

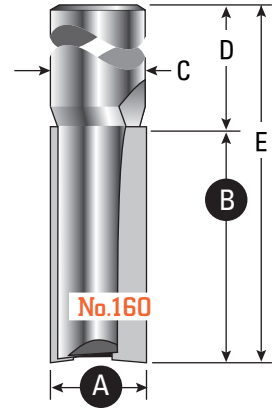
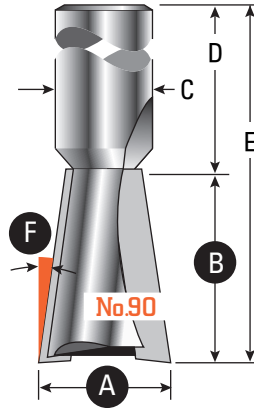
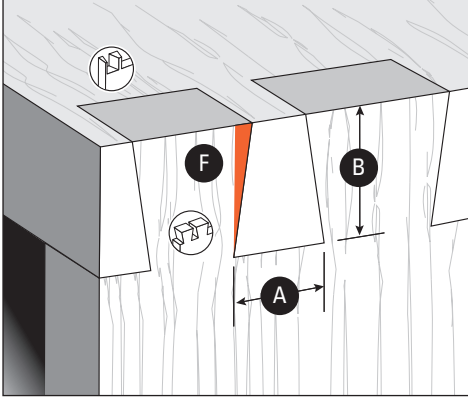


Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 100	13/16" [20,6]	1" to 1-1/4" [26,0 - 32,0]	1/2" [12,7]	1-3/4" [45,0]	3" [76,0]	8°	5/8" [15,9]
No. 150	7/16" [11,1]	up to 1-1/4" [32,0]	1/2" [12,7]	1-3/4" [45,0]	3" [76,0]	-	5/8" [15,9]

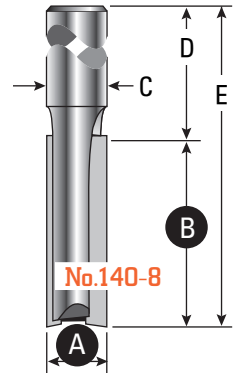
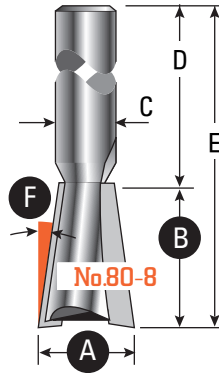
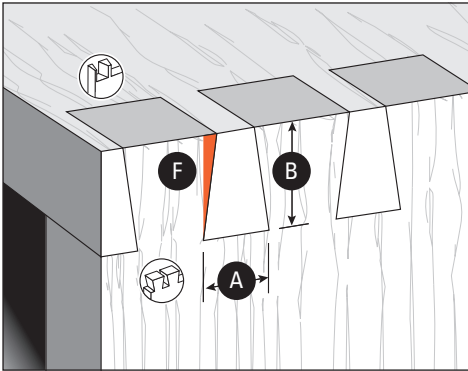
Numbers in brackets are millimetres

Appendix II **D4R** User Guide

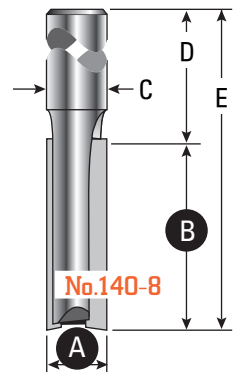
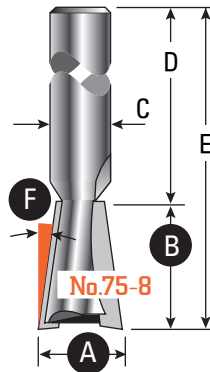
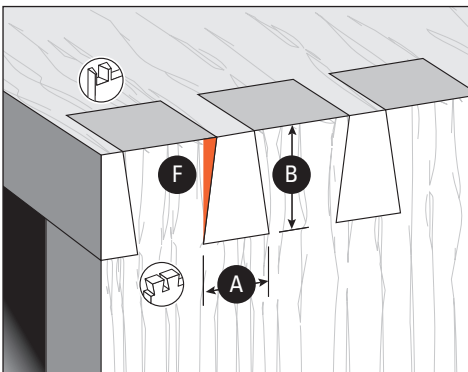
Leigh Through Dovetail Bits



Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 90	11/16" [17,5]	5/8" to 1" [16,0-26,0]	12,7mm (or 1/2")	1-3/4" [45,0]	2-3/4" [70,0]	8°	5/8"[15,9]
No. 160	1/2" [12,7]	up to 1-1/4" [32,0]	12,7mm (or 1/2")	1-3/4" [45,0]	3" [76,0]	-	5/8"[15,9]



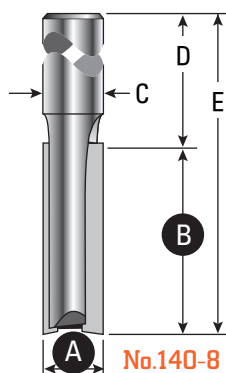
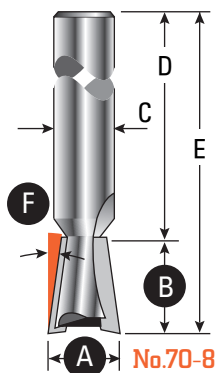
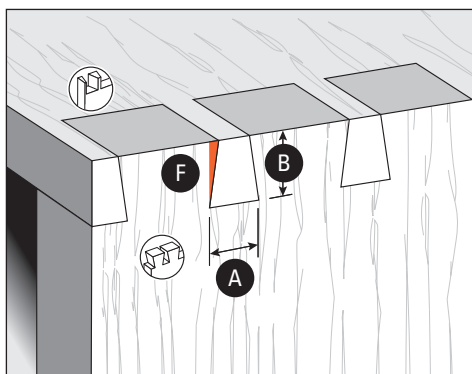
Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 80-8	1/2" [12,7]	1/2" to 13/16" [13,0-20,6]	8mm (or 1/4")	1-3/4" [45,0]	2-9/16" [65,0]	8°	7/16"[11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"[11,1]



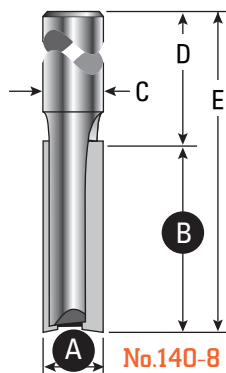
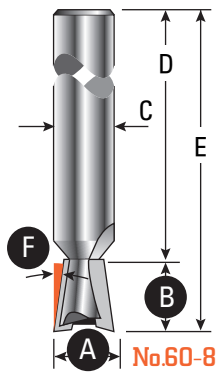
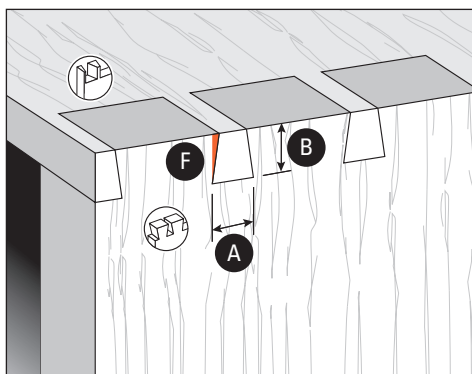
Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 75-8	7/16" [11,1]	3/8" to 5/8" [9,5-16,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/8" [60,0]	8°	7/16"[11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"[11,1]

Numbers in brackets are millimetres

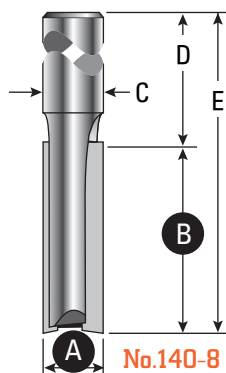
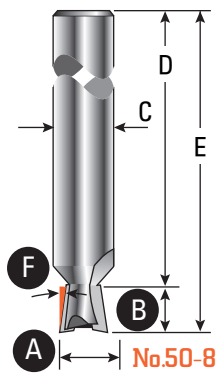
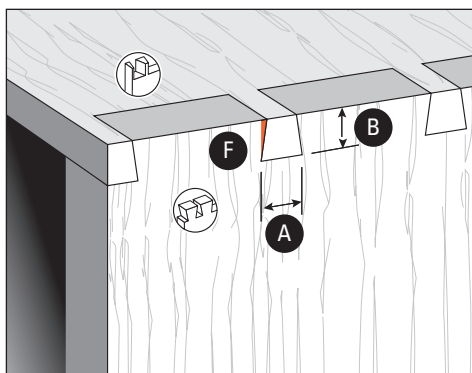
* No.80-8 and No.140-8 bits come standard with the Leigh Jig



Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 70-8	3/8" [9,5]	1/4" to 1/2" [6,0-13,0]	8mm (or 1/4")	1-3/4" [45,0]	2-1/4" [57,0]	8°	7/16"[11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"[11,1]



Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 60-8	5/16" [7,9]	up to 3/8" [9,5]	8mm (or 1/4")	1-3/4" [45,0]	2-1/8" [54,0]	8°	7/16"[11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"[11,1]

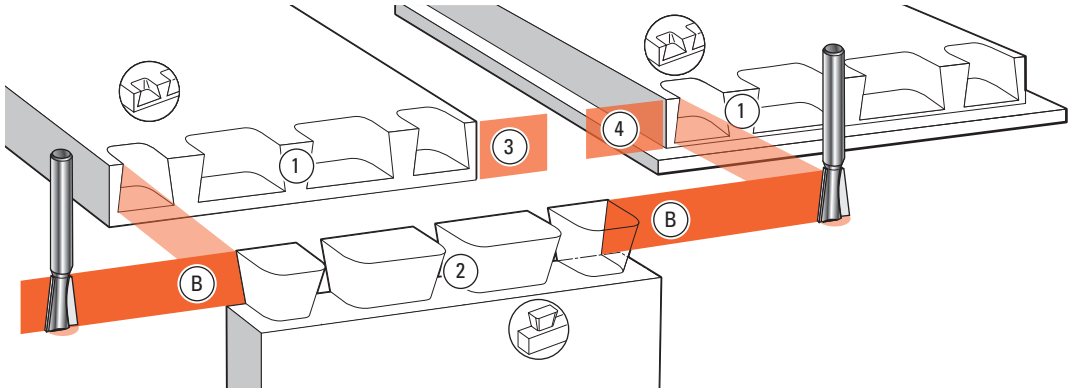


Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 50-8	1/4" [6,35]	up to 1/4" [6,35]	8mm (or 1/4")	1-3/4" [45,0]	2" [50,0]	8°	7/16"[11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm (or 1/4")	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"[11,1]

Numbers in brackets are millimetres

* No.80-8 and No.140-8 bits come standard with the Leigh Jig

Half-Blind Dovetails



About Bit Selection for Half-Blind Dovetails

Bits: Both parts of a half-blind dovetail are cut with the same dovetail bit, and at the same cutting depth **B**. Dimension **B** is the bit's specified cutting depth and cannot be varied except for fine tuning joint fit.

Flush Drawers: The dovetail bit's working depth of cut **B** must be at least $\frac{1}{8}$ " [2mm] less than the pinboard thickness **3**.

Rabbetted Drawers: The dovetail bit's working depth of cut **B** must be slightly (about $\frac{1}{16}$ " [1mm]) less than the rabbet depth **4**.

Drawer Sides (tailboard): Minimum thickness is $\frac{1}{4}$ " [6mm]. **Thickness does not affect bit selection.**

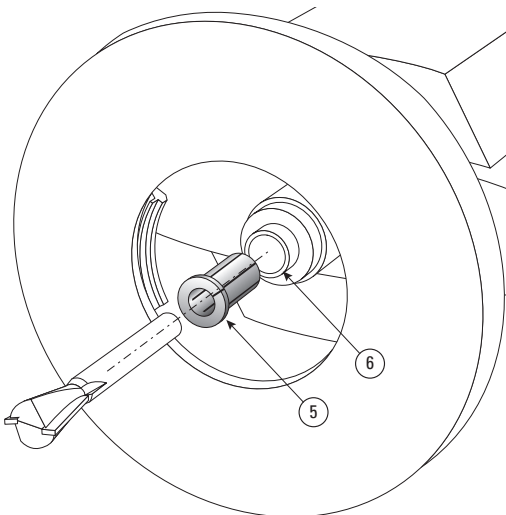
Selecting the Bit

Measure:

- Drawer front thickness
(minimum $\frac{1}{2}$ " [12mm]) **3**
- or rabbet depth
(minimum $\frac{3}{8}$ " [9,5mm]) **4**

Select:

A bit with the appropriate depth of cut **B** from the following pages.



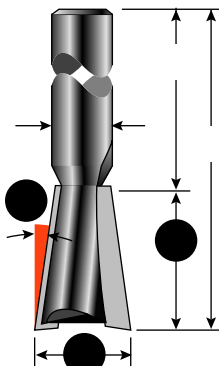
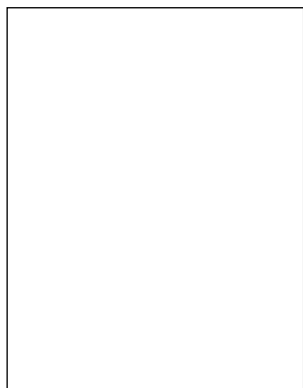
Guidebush

All half-blind dovetail bits listed in this appendix work with the $\frac{7}{16}$ " O.D. Guidebush that is supplied with your Leigh jig. No other guidebush can be used for half-blind dovetails.

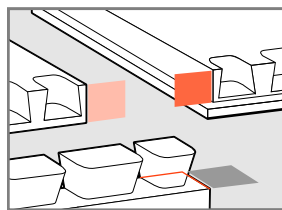
Shank Selection

All Leigh Dovetail jigs are shipped with two 8mm shank half-blind dovetail bits, and one $\frac{1}{2}$ " to 8mm collet reducer. The reducer **5** simply slides into the $\frac{1}{2}$ " collet **6** of your router and the 8mm shank bit is inserted into the collet reducer. The collet is tightened as normal. The collet reducer is not required with $\frac{1}{2}$ " shank bits.

Leigh Half-Blind Dovetail Bits

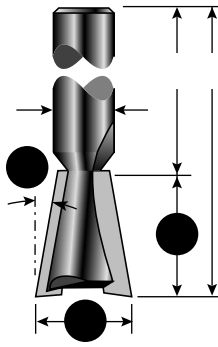
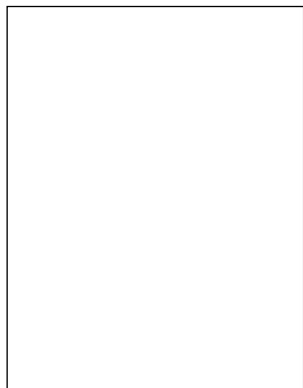


No.80-8*

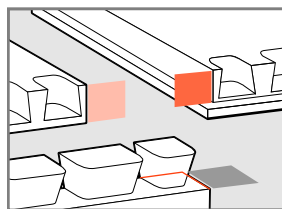


Pinboard Flush Drawer Front	Pinboard Rabbetted Drawer Front	Tailboard Drawer Side
Min Thickness 7/8" [22mm]	Min Rabbett Depth 13/16" [20,5mm]	Min Thickness 1/4" [6,5mm]

Bits	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
*No. 80-8	1/2" [12,7]	~3/4" [19]	8mm (or 1/4")	1-3/4" [44,0]	2-9/16" [65,0]	8-	7/16" [11,1]

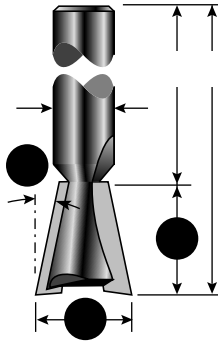
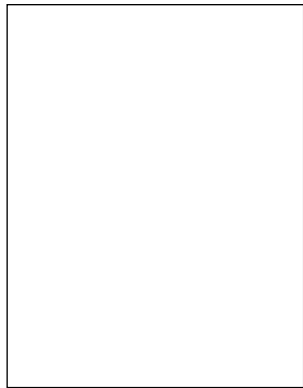


No.101-8

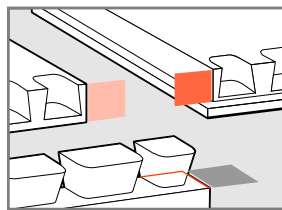


Pinboard Flush Drawer Front	Pinboard Rabbetted Drawer Front	Tailboard Drawer Side
Min Thickness 3/4" [19mm]	Min Rabbett Depth 11/16" [17,5mm]	Min Thickness 1/4" [6,5mm]

Bits	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 101-8	1/2" [12,7]	~5/8" [16]	8mm (or 1/4")	1-3/4" [44,0]	2-3/8" [60,0]	10-	7/16" [11,1]



No.112-8



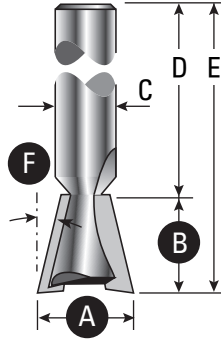
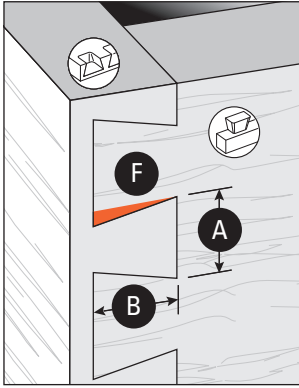
Pinboard Flush Drawer Front	Pinboard Rabbetted Drawer Front	Tailboard Drawer Side
Min Thickness 5/8" [16mm]	Min Rabbett Depth 9/16" [14,5mm]	Min Thickness 1/4" [6,5mm]

Bits	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 112-8	1/2" [12,7]	~1/2" [13,0]	8mm (or 1/4")	1-3/4" [44,0]	2-21/64" [59]	12-	7/16" [11,1]

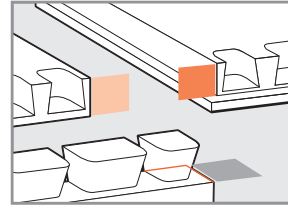
Numbers in brackets are millimetres

* Nos. 80-8 and 120-8 bits come standard with the Leigh Jig

Appendix II **D4R** User Guide

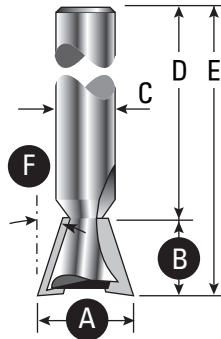
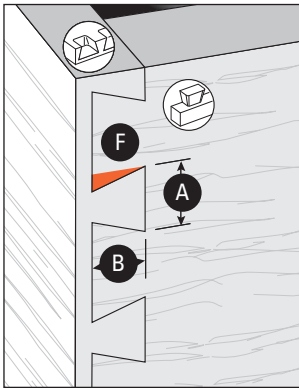


No. 120-8

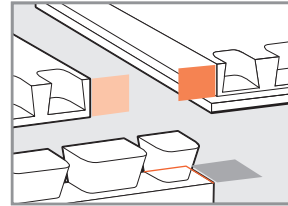


Pinboard Flush Drawer Front	Pinboard Rabbetted Drawer Front	Tailboard Drawer Side
Min Thickness 9/16" [14,5mm]	Min Rabbett Depth 1/2" [12,7mm]	Min Thickness 1/4" [6,5mm]

Bits	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 120-8	1/2" [12,7]	~7/16" [11,0]	8mm (or 1/4")	1-3/4" [44,0]	2-1/4" [57]	14°	7/16" [11,1]



No. 128-8



Pinboard Flush Drawer Front	Pinboard Rabbetted Drawer Front	Tailboard Drawer Side
Min Thickness 1/2" [12,7mm]	Min Rabbett Depth 7/16" [11mm]	Min Thickness 1/4" [6,5mm]

Bits	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 128-8	1/2" [12,7]	~3/8" [9,5]	8mm (or 1/4")	1-3/4" [44,0]	2-1/8" [54]	18°	7/16" [11,1]

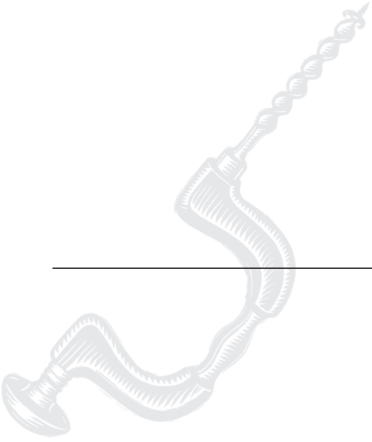
Numbers in brackets are millimetres

* Nos. 80-8 and 120-8 bits come standard with the Leigh Jig

D4R

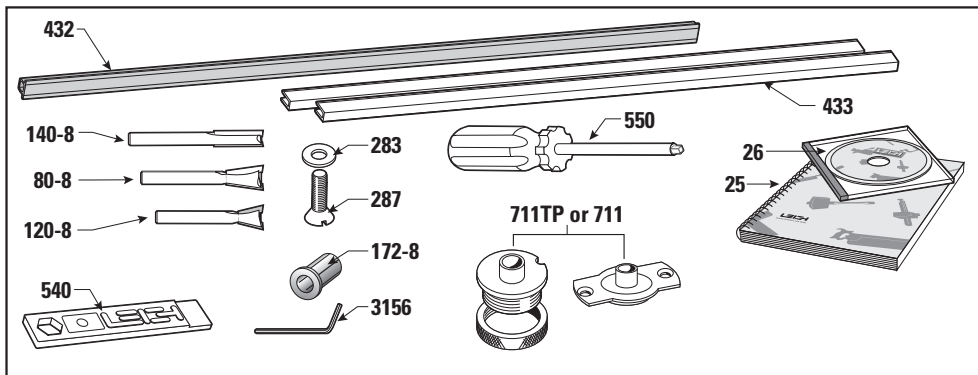
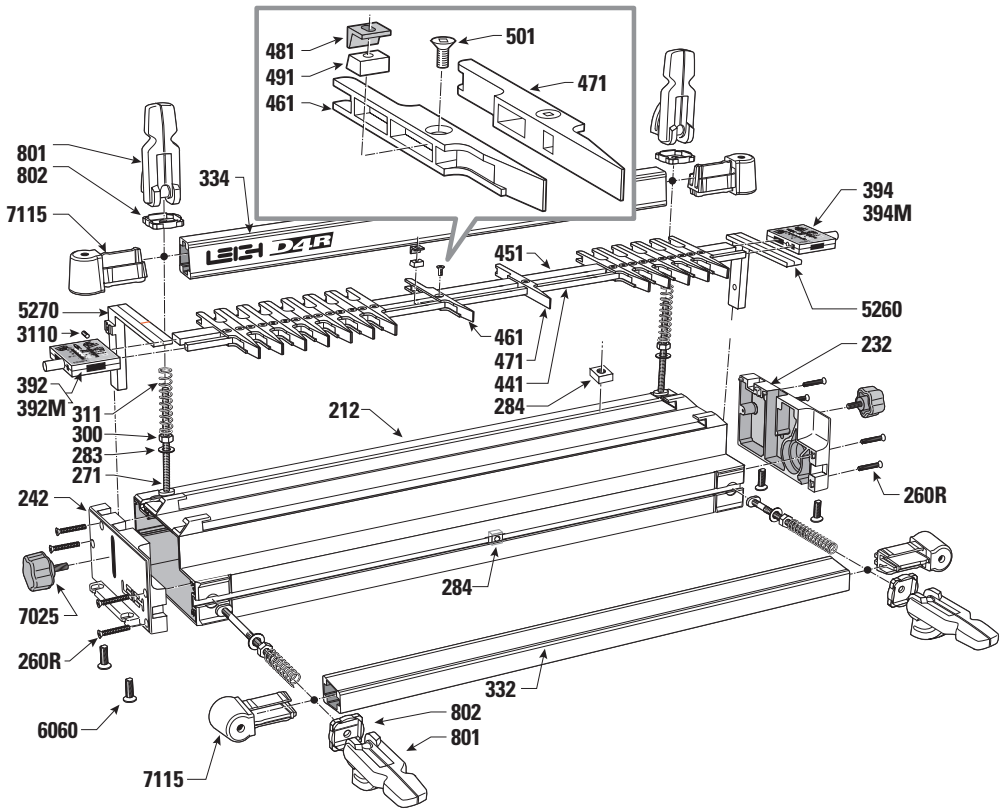
APPENDIX III

Jig Parts List



Appendix III **D4R** User Guide

PART NO.	QUANTITY		PART DESCRIPTION
	PER JIG		
25	1		User Guide D4R (English–Inch/Metric)
26	1		Instructional DVD (English - inch only)
80-8	1		Dovetail Bit, 8mm shank
120-8	1		Dovetail Bit, 8mm shank
140-8	1		Straight Bit, 8mm shank
172-8	1		1/2" to 8mm collet reducer
212	2		Body Extrusion
232	1		R.H. End-Housing
242	1		L.H. End-Housing
260R	8		End-Housing Screws
271	4		Clamp Bar T-Bolts
283	5		Flat Washers for Clamp Bolts & Accessory Screw
284	2		Accessory Attachment Square Nuts
287	1		Accessory attachment screw
300	4		Clamp Bar Bolt Nuts
311	4		Clamp Bar Springs
332	1		Front Clamp Bar (complete with End Plugs 7115)
334	1		Rear Clamp Bar (complete with End Plugs 7115) and Leigh decal
392	1		R.H. Inch Scale Assembly, complete (R.H. in H.B. Tail Mode)
or 392M	1		R.H. Metric Scale Assembly, complete (R.H. in H.B. Tail Mode)
394	1		L.H. Inch Scale Assembly, complete (L.H. in H.B. Tail Mode)
or 394M	1		L.H. Metric Scale Assembly, complete (L.H. in H.B. Tail Mode)
432	1		Cross Cut Fence
433	2		Bridge Piece extrusion
441	1		H.B. Pin Guide Rail
451	1		Finger Guide Rail
461	13		R.H. Finger complete with Wedge, Nut and Screw
471	13		L.H. Finger complete with Wedge, Nut and Screw
481	26		Finger Wedges
491	26		Finger Nuts
501	26		Finger Lock Screws
540	1		Leigh Assembly Wrench/Gauge
550	1		Finger Adjusting Screwdriver
5260	1		R.H Support Bracket
5270	1		L.H. Support Bracket
711TP	1		7/16" O.D. Template Guide with lock ring
or 711	1		7/16" O.D. Template Guide
801	4		Cam-Action Speed-Clamps complete with Step Washers 802
802	4		Speed-Clamp Step Washers
3110	2		Scale Lock Set Screws
3156	1		5/64" Hex Key (2mm may also work)
6030	4		1/4" -20 Hex nuts, jig hold-down
6060	4		1/4" -20x1 Flat head machine screws, jig hold-down
7025	2		Support Bracket Knobs
7115	4		Clamp Bar End Plug



NOTE: When ordering parts, please quote the jig model, serial number, part number, part description and quantity required. Pay particular attention to the scale measurement, inch or metric.

Manufacturer - Canada & USA

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*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!

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 Fax: (07) 3397 2785
 Ordering: 180 658 111
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 Cnr Hans Strijdom & C.R Swart Drives,
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 Fax: (011) 791-0850
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