



D4RKIT Upgrade

Leigh D4R Dovetail Jig Upgrade to New Features

Your D4R Dovetail Jig can be upgraded with two great new features. The D4RKIT Upgrade, along with new or modified fingers, will allow you to rout single pass Half-blind dovetails in five depths and you can also rout two sizes of box joints, 3/8" and 3/4", with precise adjustment for fit. The following parts are included in the Upgrade kit:

1. Single Pass Half-blind Dovetail Spacer
2. Box Joint Spacer
3. Single Pass Half-blind Nylon Stop Rod
4. e-7 Elliptical Guide Bush
5. Pin Wrench for e-7 Guide Bush
6. Revised D4R Pro User Guide



In addition to the above, you will need to modify the tail end of each guide finger as described on the following pages.

Should you not wish to modify your guide fingers, a "new" set of D4R PRO guide fingers, Leigh Part #462472, is available for \$99.00 plus shipping. (Dealers may sell for less). See www.leighjigs.com for details.

D4R/D4 Finger Modification

In order to produce Single Pass Half-blind dovetails on your D4R dovetail jig, a 9/64" hole must be drilled in the tail end of each finger at a specific location. Although fingers may be marked and drilled free hand, we recommend using a shop made drilling jig similar to the attached drawing, and your drill press, to ensure holes are drilled at the same location in every finger.

D4R/D4 Owners

1. Remove the finger assembly from the jig, remove the scales and remove all fingers from the finger bar.
2. Use a flat board approximately 10" x 6" as a base.
3. Mount a cross piece (A), 4" long by 3/4" x 1/2" approximately 2 1/2" from one end of the board.
4. Mount the first perpendicular piece (B), 5" x 3/4" x 1/4" approximately centered on cross piece (A).
5. Place a finger firmly against the first horizontal piece.
6. Mount the second perpendicular piece (C) firmly against the finger and secure in place.
7. Make a spacer block "D", 7/32" x 1" x 7/16".
8. Using a left finger, mark layout lines on the flat surface of the tail end of the finger as indicated. i.e. 11/64" down from the screw face of the finger and 29/32" from the end of the finger.

NOTE, all fingers are identified with an "L" (Left hand) or an "R" (Right hand) cast in to the tail end of the finger

9. Place the left finger in the drilling jig as indicated and mount the drilling jig on the drill press table.
10. Center the drill bit on the layout marks and secure the drilling jig to the table with clamps.
Tighten clamps securely.
11. Drill all left hand fingers.
12. Before drilling the right hand fingers, place the spacer block in the drilling jig as indicated. This block is necessary to prevent the right hand fingers from bending down when drilling.
13. Drill all right hand fingers.
14. Replace all fingers on the finger bar and refer to your User Guide, section 1-8 and 1-9 when reattaching the scales.

D4 Owners Only

D4 jig owners require shop made spacers to offset the tail board for Single Pass Half-blind dovetails, and the socket board for 3/8" and 3/4" box joints. Spacers are easily made from scrap 1/4" plywood, solid wood or pressboard.

The Single Pass Half-blind dovetail offset spacer must be 5 1/2" long by .521" wide by 1/4" thick.
(Cut spacer to 17/32" and sand lightly to specification)

The box joint offset spacer must be 5 1/2" long by .386" wide by 1/4" thick. **(Cut spacer to 25/64th and sand slightly to specification)**

