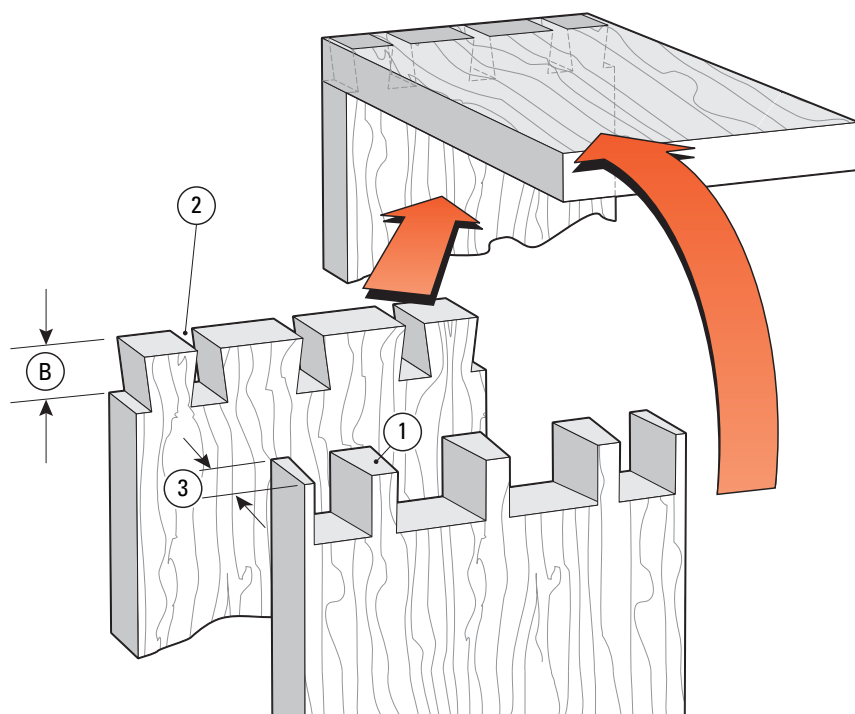


D1600 APPENDIX II
Cutter Selection





Cutter Selection for Through Dovetails

8° Dovetail Cutter for Tails

The pins ① must fit into the sockets ②. So the dovetail cutter's depth of cut ⑥ must be equal to or a little greater than the pinboard thickness ③.

Measure the pinboard thickness ③ and select the dovetail cutter with the correct depth of cut ⑥ from the following pages (cutters must be 8° for through dovetails).

Straight Cutter for Pins

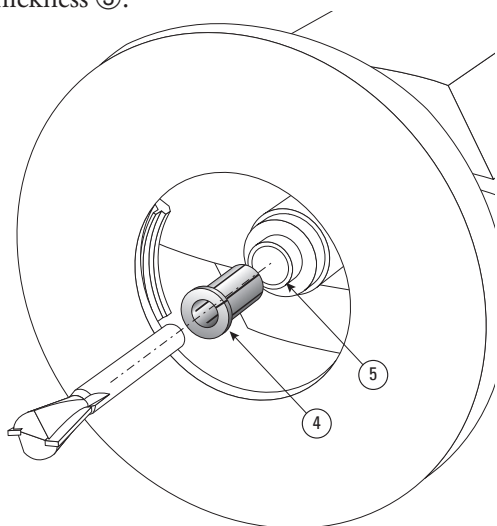
The matching straight cutter is listed just below the dovetail cutters. The $\frac{5}{16}$ " diameter No. 140-8, 8mm shank is the only straight cutter you need with the D1600. The $\frac{1}{4}$ " shank No. 140 is also available.

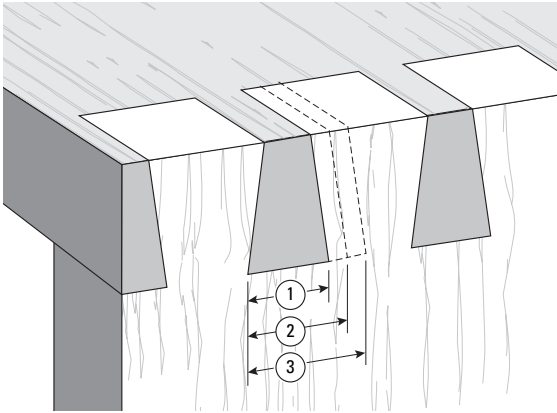
Guidebush

All through dovetails on the D1600 are routed with a $\frac{7}{16}$ " OD guidebush. See page 102.

Shank Selection

Note: If your router has an 8mm or larger collet, we highly recommend you use our 8mm shank cutters instead of $\frac{1}{4}$ " [6,35mm] shanks. For a $\frac{1}{2}$ " [12,7mm] collet you will require our $\frac{1}{2}$ " [12,7mm] to 8mm collet reducer No. 172-8. Note: This is a collet reducer ④, not a collet ⑤. It does not replace the collet, it slides directly into your $\frac{1}{2}$ " collet.





You will note that some of the dovetail cutters' depths of cut overlap. For example:
 No.80 cutter (B): 1/2" - 13/16" [12 - 20mm]
 No.70 cutter (B): 1/4" - 1/2" [6 - 12mm]

This means that 1/2" boards can be joined using either the No.80 -140 combination, the No. 75-140 combination, or the No. 70 - 140 combination.

The three cutter combinations will produce slightly different-looking joints because each dovetail cutter produces a different size pin:

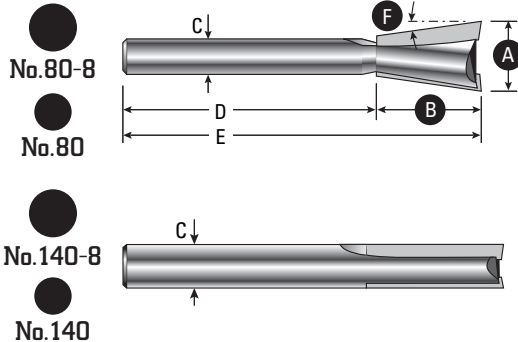
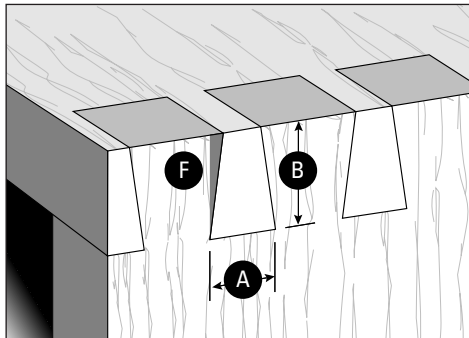
- No. 70 - 3/8" ①
- No. 75 - 7/16" ②
- No. 80 - 1/2" ③.



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

Note: Cutter and joint drawings are about 75% actual size.

Leigh Through Dovetail Cutters

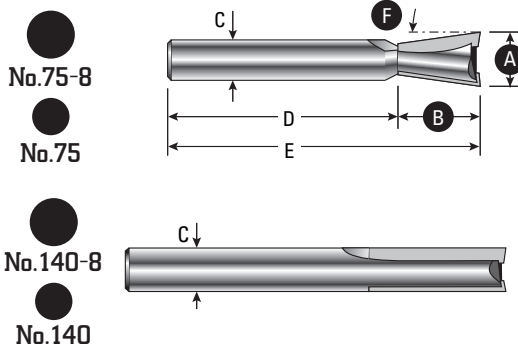
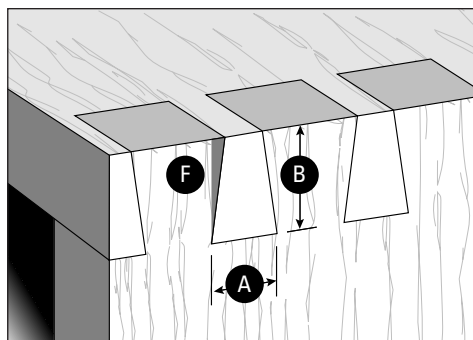


Cutters	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
*No. 80-8	1/2" [12,7]	1/2" to 13/16" [13,0-20,6]	8mm or 1/4"	1-3/4" [45,0]	2-9/16" [65,0]	8°	7/16" [11,1]
*No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm or 1/4"	1-3/4" [45,0]	2-3/4"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

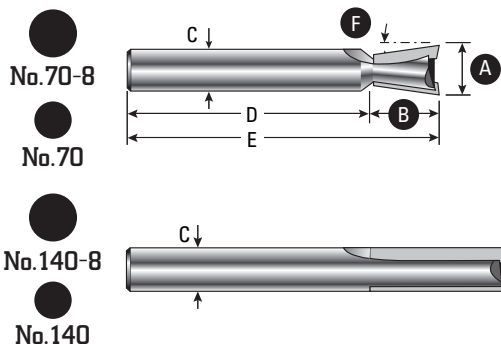
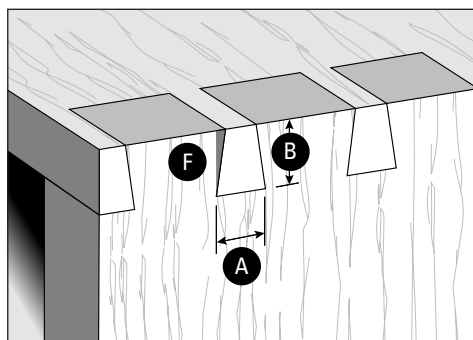
Numbers in brackets are millimetres
 No.80-8 and No.140-8 cutters come standard with the Leigh D1600 Jig

Note: Cutter and joint drawings are about 75% actual size.

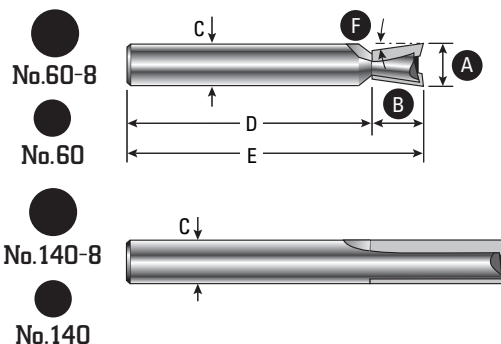
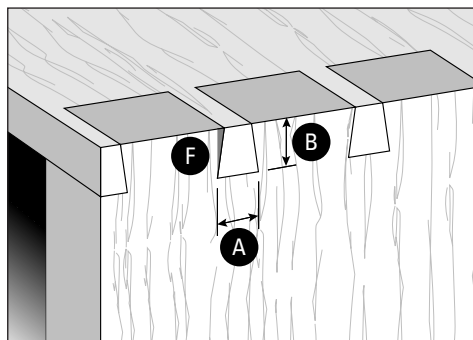
Leigh Through Dovetail Cutters



Cutters	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]



Cutters	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]

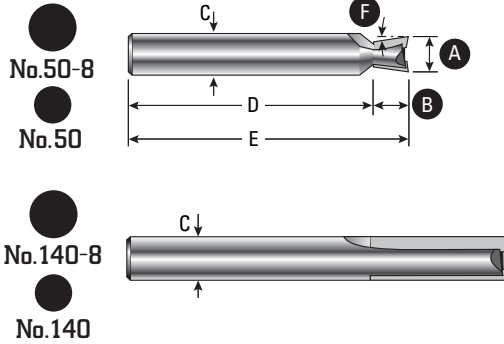
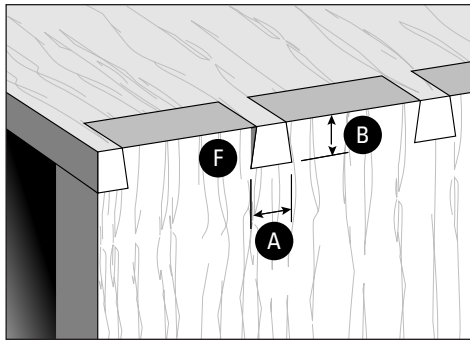


Cutters	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 60-8	5/16" [7,9]	up to 3/8" [9,5]	8mm or 1/4"	1-3/4" [45,0]	2-1/8" [54,0]	8°	7/16" [11,1]
No. 140-8	5/16" [7,9]	up to 1" [26,0]	8mm or 1/4"	1-3/4" [45,0]	2-3/4" [70,0]	-	7/16"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

Numbers in brackets are millimetres

* No. 80-8 and No. 140-8 cutters come standard with the Leigh D1600 Jig

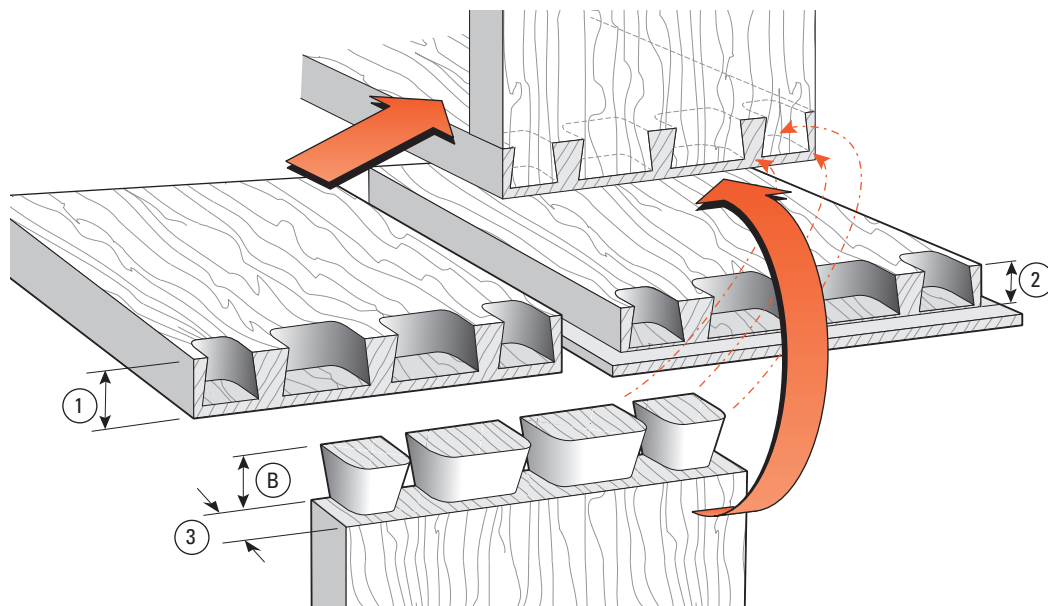
Note: Cutter and joint drawings are about 75% actual size.



Cutters	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

Half-Blind Dovetails



Cutter Selection for Half-Blind Dovetails

Both parts of a half-blind dovetail are cut with the same dovetail cutter. The dovetail cutter's working depth of cut **B** must be less than the pinboard thickness **1** for flush drawers by at least $\frac{1}{8}$ " [2mm], and slightly less than the rabbet depth **2** for rabbeted drawer fronts. Minimum pin board (drawer front) thickness is $\frac{1}{2}$ " [12mm].

Drawer side thickness **3** does not affect cutter selection.

Note: **B** is the nominal working depth for half-blind dovetails, not the maximum depth. **B** must not be varied, except for minor adjustments for joint fit. See page 53.

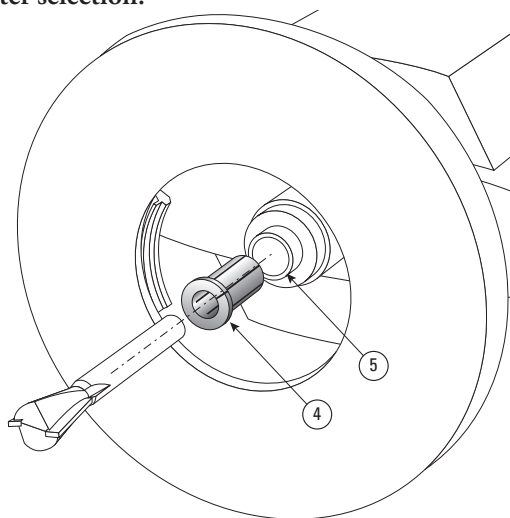
Measure the drawer front thickness (minimum $\frac{1}{2}$ " [12mm]) **1** or rabbet depth (minimum $\frac{7}{16}$ " [11,1mm]) **2** and select the cutter with the appropriate depth of cut **B** from one of the five cutters on the following pages.

Guidebush

All half-blind dovetails on the D1600 are routed with a $\frac{7}{16}$ " OD guidebush. See page 102.

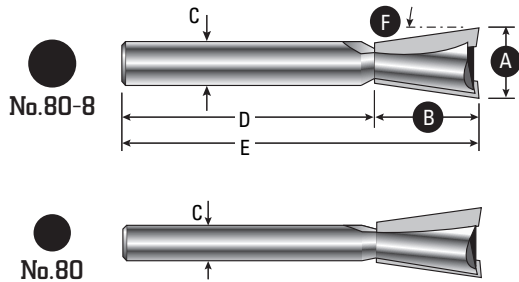
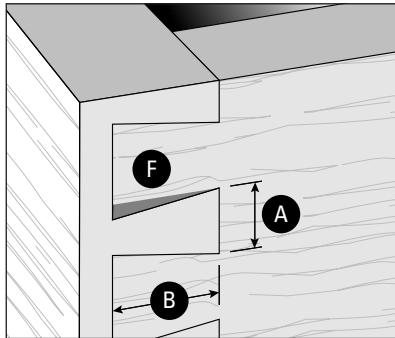
Shank Selection

Note: If your router has an 8mm or larger collet, we highly recommend you use our 8mm shank cutters instead of $\frac{1}{4}$ " [6,35mm] shanks. For a $\frac{1}{2}$ " [12,7mm] collet you will require our $\frac{1}{2}$ " [12,7mm] to 8mm collet reducer No. 172-8. **Note:** This is a collet reducer **4**, not a collet **5**. It does not replace the collet, it slides directly into your $\frac{1}{2}$ " collet.

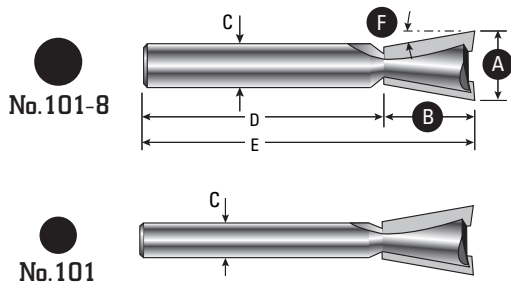
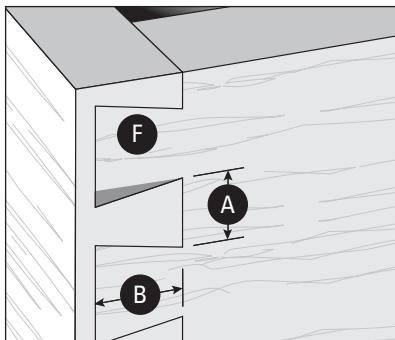


Note: Cutter and joint drawings are about 75% actual size.

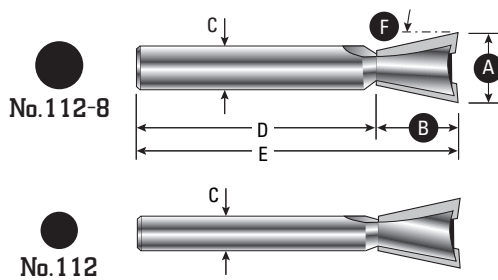
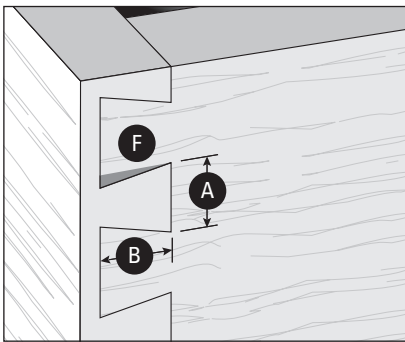
Leigh Half-Blind Dovetail Cutters



Cutters	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" [45,0]	2-9/16" [65,0]	8°	7/16" [11,1]



Cutters	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" [16,0]	8mm or 1/4"	1-3/4" [45,0]	2-3/8" [60,0]	10°	7/16" [11,1]

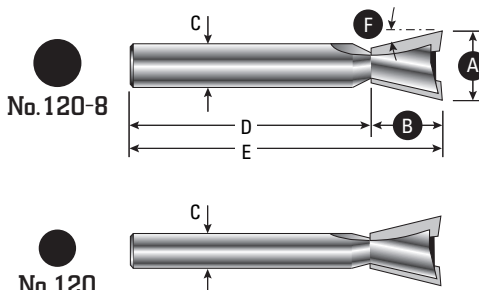
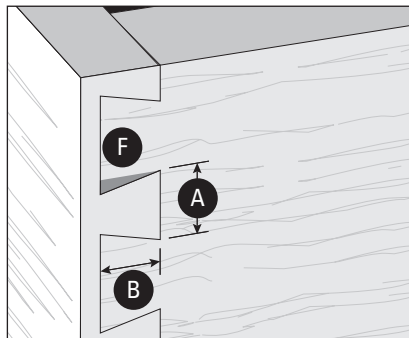


Cutters	A Overall Diameter	B Working Depth	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 112-8	1/2" [12,7]	~1/2" [13,0]	8mm or 1/4"	1-3/4" [44,0]	2-21/64" [59]	12°	7/16" [11,1]

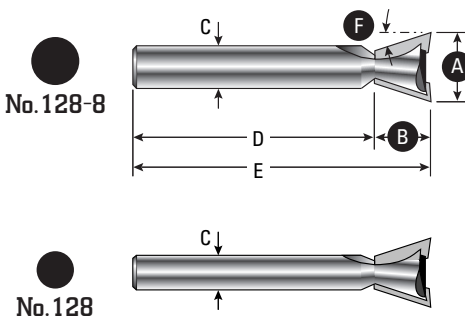
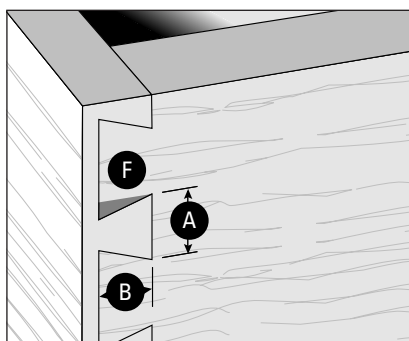
Numbers in brackets are millimetres

* No.80-8 cutter comes standard with the Leigh Jig

Note: Cutter and joint drawings are about 75% actual size.



Cutters	Overall Diameter	Working Depth	Shank Diameters	Shank Length	Overall Length	F Angle	Guidebush Diameter
No. 120-8	1/2" [12,7]	~7/16" [11,0]	8mm or 1/4"	1-3/4" [45,0]	2-1/4" [57]	14°	7/16"[11,1]



Cutters	Overall Diameter	Working Depth	Shank Diameters	Shank Length	Overall Length	F Angle	Guidebush Diameter
No. 128-8	1/2" [12,7]	~3/8" [9,5]	8mm or 1/4"	1-3/4" [45,0]	2-1/8" [54,0]	18°	7/16"[11,1]

Numbers in brackets are millimetres

No. 80-8 cutter comes standard with the Leigh Jig