

M2 – CHAPTER 1

Assembly and Mounting

Make Sure You Have All The Parts!

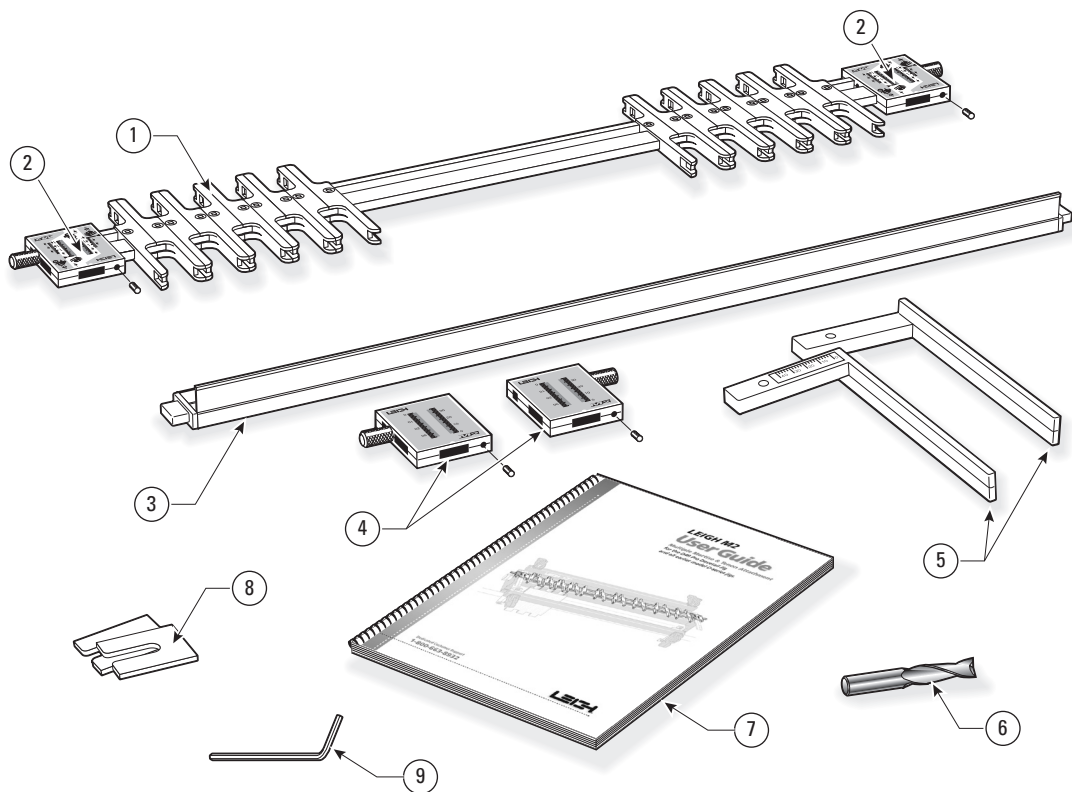
Before you start to assemble your Leigh M2, check to make sure you have received all the required parts.

The carton contains:

1. 1 finger assembly on two bars
(10 pairs of fingers)
2. 2 scale assemblies for guidefingers
3. 1 fence assembly complete with two end plugs
4. 2 scale assemblies for fence
5. 2 support brackets*
6. 1 standard cutter, 1/2" [12,7mm] spiral upcut
7. 1 Leigh M2 user guide
8. 2 side stop extensions
9. 5/64" hex key (2mm may also work)

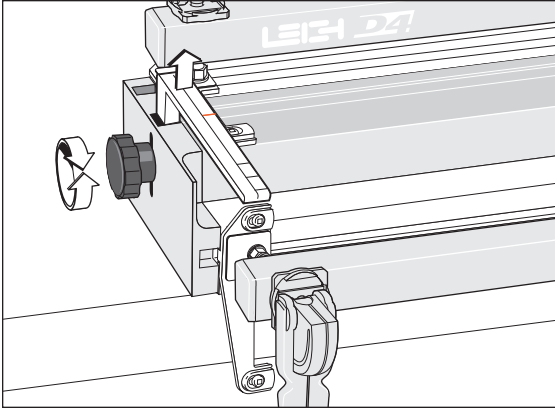
If any of these items are missing from your jig, please notify your supplier or Leigh Industries immediately.

*D4, D4R and D4R Pro jigs already have these brackets, so these become spares.



Chapter 1 M2 User Guide

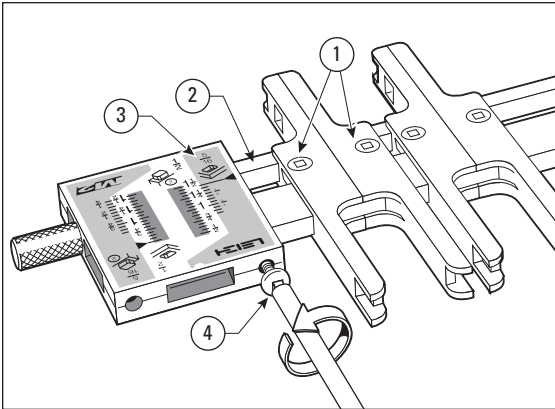
Note: Most illustrations in this guide feature the D4 model jig.




1-1

D1258, D1258R, and D3 jig owners: Replace the short support brackets with the extended M2 brackets. These are marked LH to left, RH to right. Raise to full height and tighten the knobs. Use these new extended brackets for all dovetailing or template jointing functions.

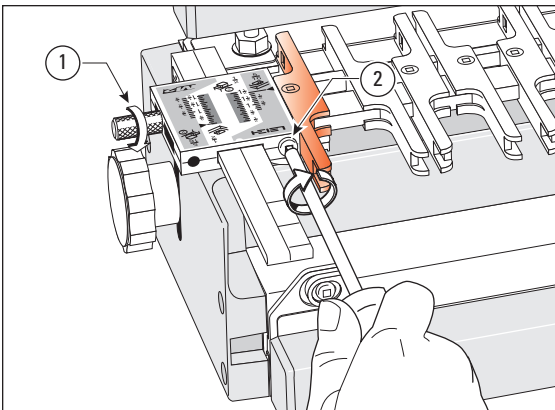
D4 and D4R jig owners: your M2 attachment may come with the extended support brackets. Put these in your “spares” box. Raise the support brackets to full height and tighten the knobs.




1-2

Place the finger assembly on a bench with finger screws ① upwards and the small square bar ② away from you, and the $\frac{5}{16}$ " [7,9mm]  mortise scale-③ to the right at both ends. Loosen the scale screws ④*.

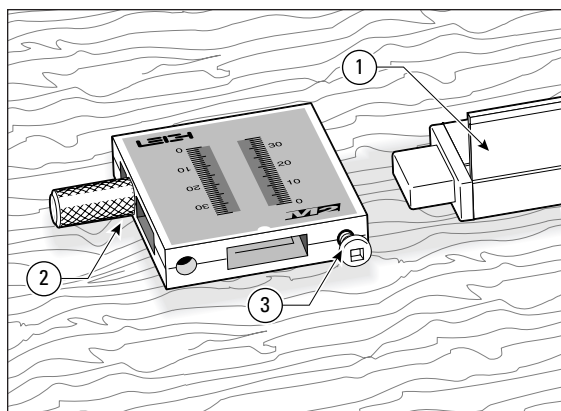
***M2 scale change:** The original flat head screws on M2 scales have been replaced with set screws and an included hex key.



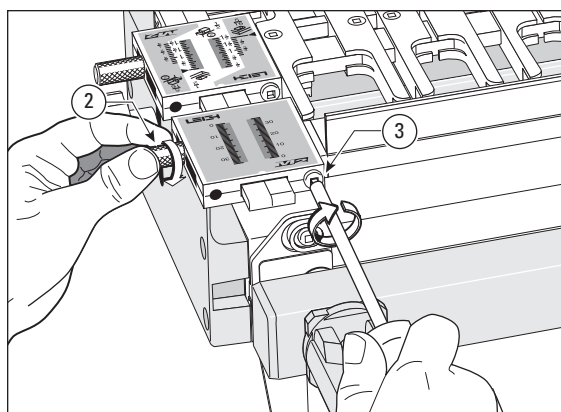
1-3

Slide complete finger assembly with *loose* scales onto support brackets. Set scales at say, $\frac{3}{4}$ " [20mm] on the $\frac{5}{16}$ " [7,9mm]  mortise scale and tighten thumb screws ①. Now tighten scale lock screws ② firmly with Leigh screwdriver. Do not over-tighten. *To ensure correct alignment, follow this same procedure whenever scales are removed from finger assembly.*

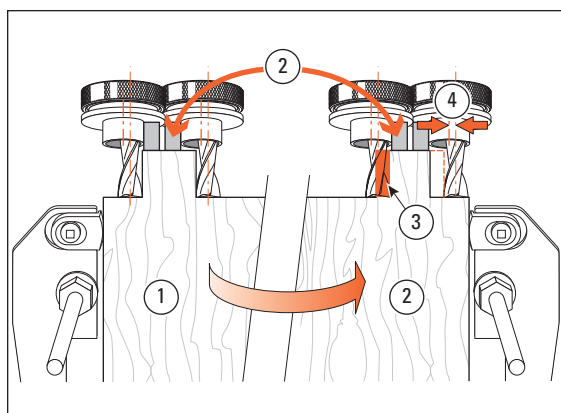
Move the outer finger on both ends out to touch the scales (shown in red).

**1-4**

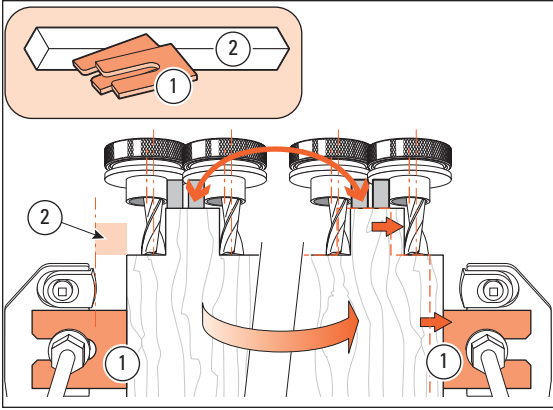
Place fence extrusion flat down on bench with fence ① upright and towards you. Slide tongue into left hand fence scale as shown, with brass thumb screw ② outward and away from you. Repeat for the right hand scale but **do not tighten fence scale lock screws ③ yet**.

**1-5**

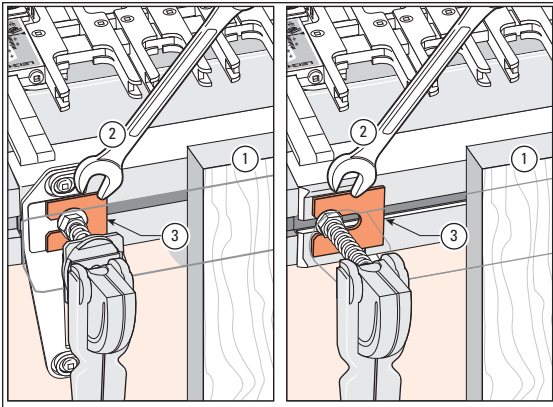
Slide complete fence assembly with loose beam scales onto support brackets. Set scales to the same reading at both ends and tighten brass thumb screws ②. Now tighten scale lock screws ③ firmly with Leigh screwdriver. Do not over-tighten. *To ensure correct alignment, follow this same procedure whenever scales are removed from fence.*

**1-6**

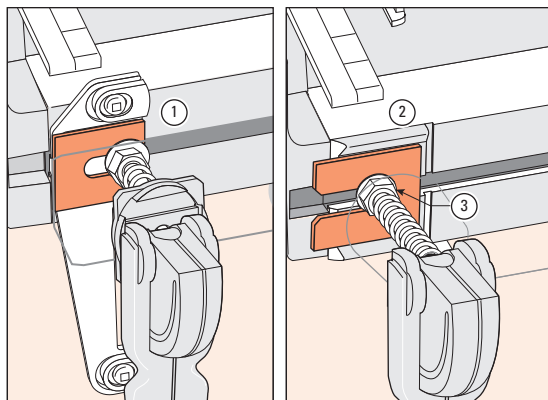
Using the M2 requires a small modification to your Leigh jig. Multiple tenons are routed in two separate stages at both ends of the jig: first on the left ① and then, with the finger assembly and tenon board flipped end-for-end, on the right ②. In this second position it is impossible to guarantee perfect indexing between the guide fingers, side stops and partly formed tenons ③. This is mainly caused by the cutter not being concentric to the guidebush ④ (greatly exaggerated in this illustration).

**1-7**

To solve this problem and correctly index the side stops, we have provided two metal sidestop extensions ①. To complete the modification, you will also need to cut a simple ½" [12mm] square by 5" [125mm] long wood "mortise block" ②. The block and extensions will allow adjustment to compensate for any cutter to guidebush eccentricity. The procedure is explained later in this guide.

**1-8**

To install the extensions, lightly clamp a board in the front clamp centre ①. This will maintain tension on the clamp bolts and keep them in position while you attach the extensions. Use a ½" [13mm] open end wrench to loosen the two front clamp bolt nuts ② sufficiently to slide the extensions beneath the washers. Lightly tighten the nuts for now ③.

**1-9**

When you're not using the jig with the M2: On the D4 and D3 jigs turn the extensions outward ①.

On the D4R and D4R Pro jig, the extensions can be retracted ②.

Always tighten the clamp nuts ③ after setting or retracting the extensions.