

Your New Leigh M2 Attachment

Congratulations! You now own the world's only jig for routing multiple mortise and tenon joints; one of the most difficult joints to hand-cut is made simple with the M2.

The M2 is an optional attachment for the Leigh Dovetail Jigs: 24" [610mm] models D1258, D1258R, D3, D4, D4R and D4R Pro.

Most illustrations in this guide show the M2 mounted on the D4 jig but the instructions are identical for the D4R Pro and all earlier D-series jigs.

We recommend that you first mount the M2 on your Leigh Jig, carefully following the instructions in the first section of this user guide. Then read the rest of the user guide, following along with the basic functions and principles of operation before you try to do any actual joinery routing. By all means, cut a few practice joints in scrap boards before you use the M2 to rout a precious workpiece!

If you have any questions that are not answered in the user guide, please call the Leigh customer support line.*

*See Appendix III – Customer Support

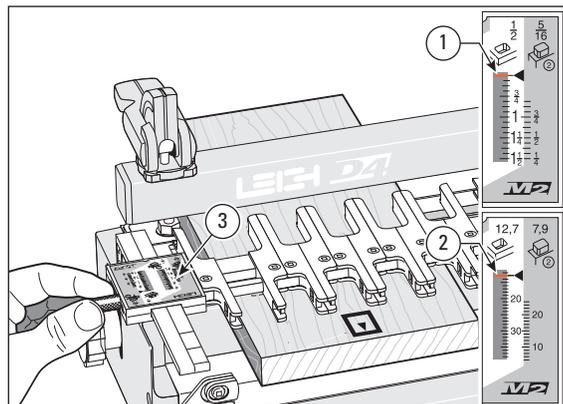
Important: Inches and Millimeters

Leigh makes the M2 attachment in two models; inch or metric. Text and illustrations in this Leigh English-language user guide indicate dimensions in both inches and millimeters. Dimensions are indicated in text and illustrations with inches first, followed by millimeters in square brackets.

Example: $\frac{3}{4}$ " x $5\frac{1}{2}$ " x 8" [20 x 140 x 200mm]

Do not be concerned if the inch/millimetre equivalents are not always exact. Just use the dimensions which apply to your jig.

Where finger assembly or template scales overlay an illustration, the inches scale ① will be at the top, the millimeters scale ② will be at the bottom. Only the right "active" half of the scales are illustrated. Setting positions are indicated in this guide with a red line. **On the jig, the lines are black.** General views of the scales ③ will usually show inch markings.



Glossary of Symbols	iv
CHAPTER 1 – Assembly and Mounting	1
CHAPTER 2 – Using Your Attachment Safely.....	7
CHAPTER 3 – Adjusting the Finger Assembly.....	13
CHAPTER 4 – How Routers with Guidebushes Work	19
CHAPTER 5 – Basic Jig Functions.....	23
CHAPTER 6 – Wood Preparation	31
CHAPTER 7 – The Multiple Mortise and Tenon Joint.....	35
CHAPTER 8 – Operations Procedures for Mortises	39
CHAPTER 9 – Operations Procedures for Tenons.....	49
CHAPTER 10 – Beyond the Basics	59
Appendix I – Guidebush and Cutter Selection	63
Appendix II – Parts List.....	69
Appendix III – Customer Support.....	73

How to Read the Symbols

To help you understand the instructions and illustrations in this user guide, we have used a number of international symbols, plus a few special ones of our own. They are all explained below. You needn't worry about memorizing these symbols now, because they are repeated quite frequently in the user guide, and you will soon get used to them.

Glossary of Symbols

The Leigh M2 Attachment can be in any one of three modes, depending on what part of the joint is being routed. Each finger assembly scale has its own mode icon, identifying that joint part. You will also find the mode icon in the top left hand corner of most illustrations, indicating which finger assembly mode to use. Sometimes a mode icon will be used to identify a board.

Mode and Scale Icons



Mortises



Tenon ① (first side of tenons)



Tenon ② (second side of tenons)