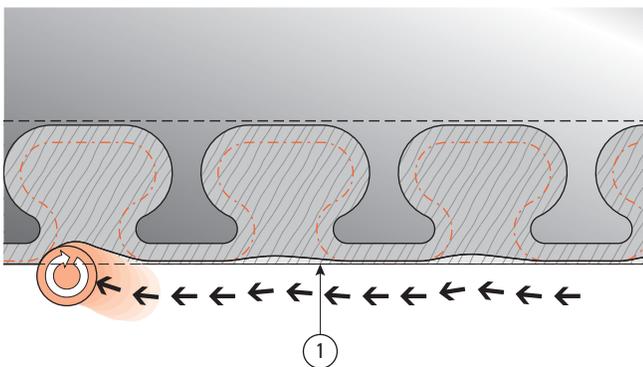
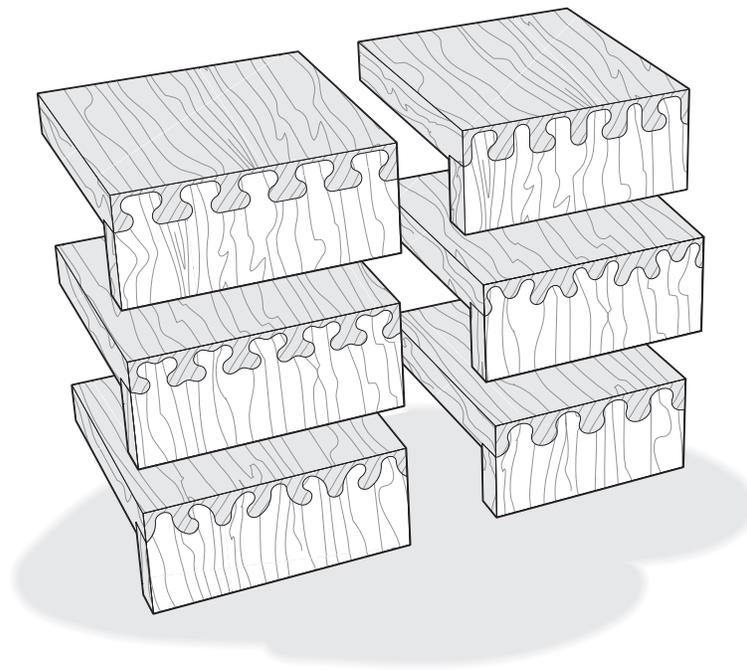


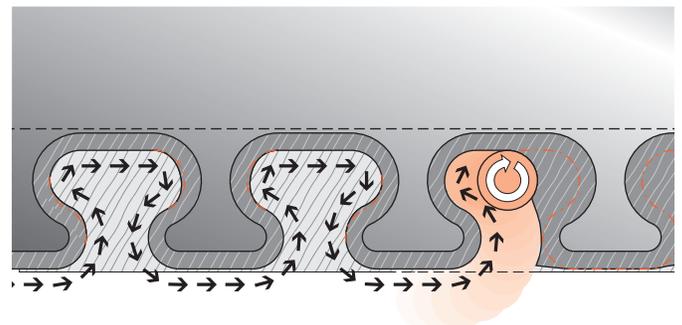
Routing Procedures Hints and Tips

Isoloc joints are unique, beautiful, and strong. They are different from routed dovetail joints and require different routing techniques, particularly the horizontal socket boards.

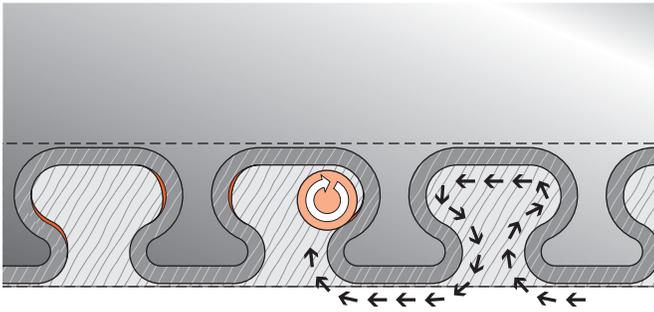
Here are some special techniques and ideas to help you get the most out of your Leigh Isoloc Template.



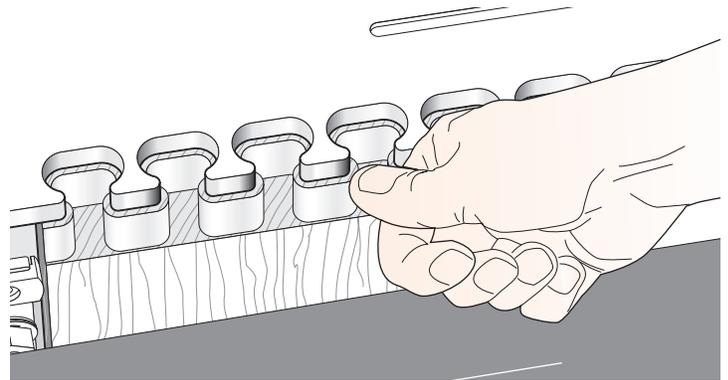
11-1 Routing Techniques for Pins The vertical pin boards are the easiest to rout and require little in the way of special technique. **⚠**For the first light cut, move the router from right to left, across the face. **Make sure you control the router firmly, because it is driven in this direction by the bit rotation.** This “back” or “climb” routing leaves a very clean shoulder in the side grain ①.



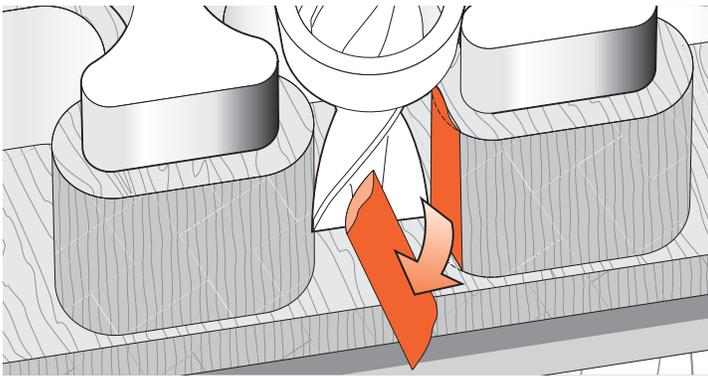
11-2 Now rout left to right, following the template contours to rout out the pins. Keep the feed rate up; routing too slowly will cause the bit to over-heat. Remember, you will be coming back for a cleanup cut.



11-3 Go back from right to left to make a final cleaning cut and to ensure no tiny parts have been missed.

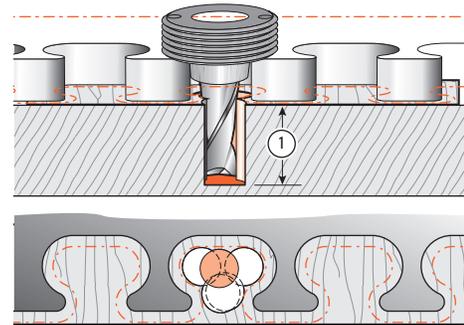


11-4 Before removing the board, examine the routed pins to ensure a clean cut.



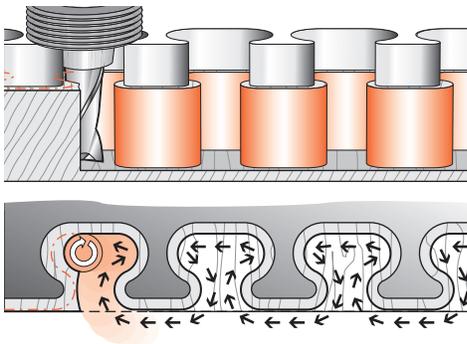
11-5 Routing Techniques for Sockets

While there is no “exiting” of the bit to cause tear-out, the combination of horizontal and end grain in horizontal socket boards can present its own problems. Much depends on the wood species. The most vulnerable part when routing is shown here.

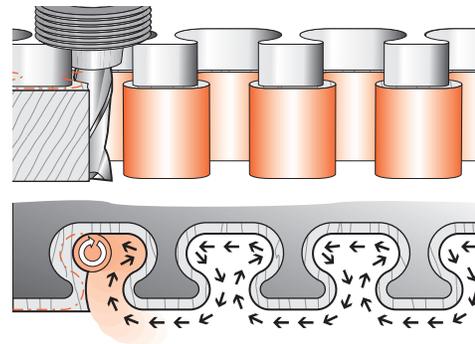


11-6 The quickest solution in troublesome wood is to plunge two to four times in each opening to 90% of board thickness only ①.

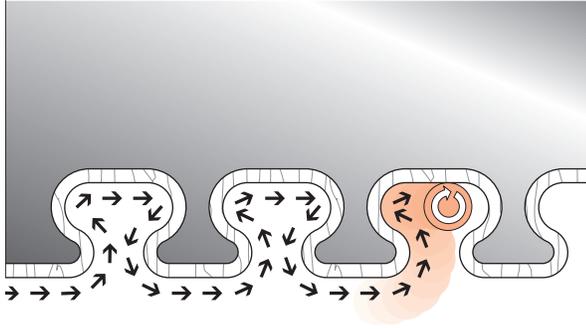
Note: Any slight “breakout” in the first 90% of cut will be buried in the finished joint, and will not be visible on the outside.



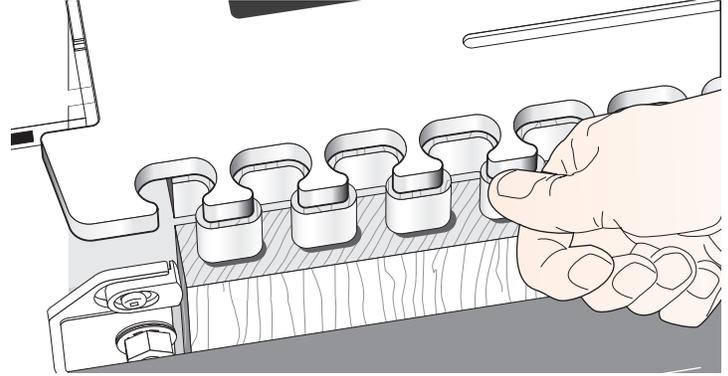
11-7 Now rout right to left, following the template contours, the bit still set at 90% depth. *Note: In thicker socket boards and hardwoods, rout in several passes at progressively deeper cuts.*



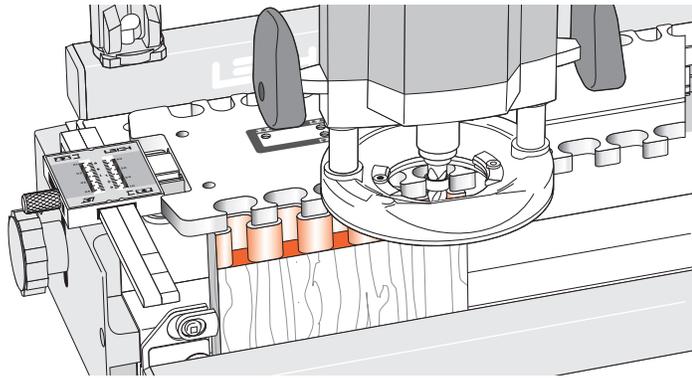
11-8 Now rout right to left again at full through.



11-9 Finish up left to right at full through.



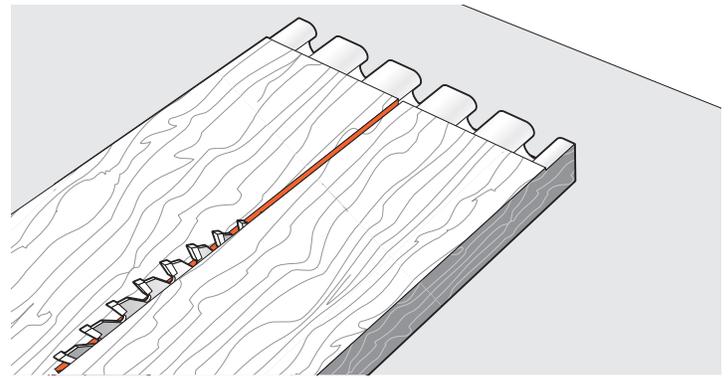
11-10 Before removing the board, examine the routed sockets to ensure a clean cut.



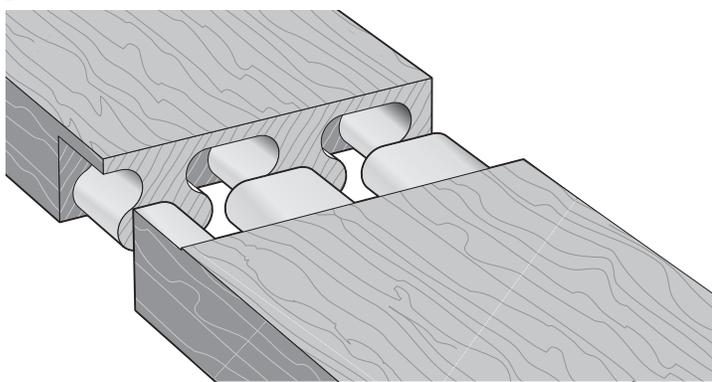
11-11 Quick-Fit Test

Rather than rout two test pieces, here is a quick way to get 99% of the way there.

Rout one scrap pin board, at least four pins wide.

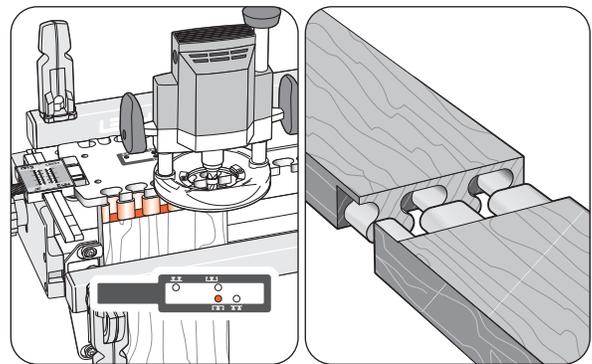


11-12 Saw the board in half.

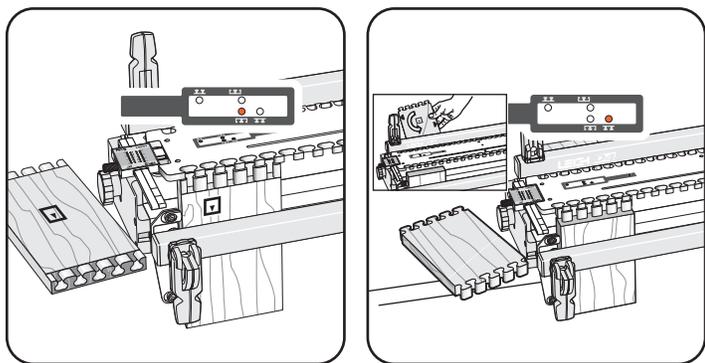


11-13

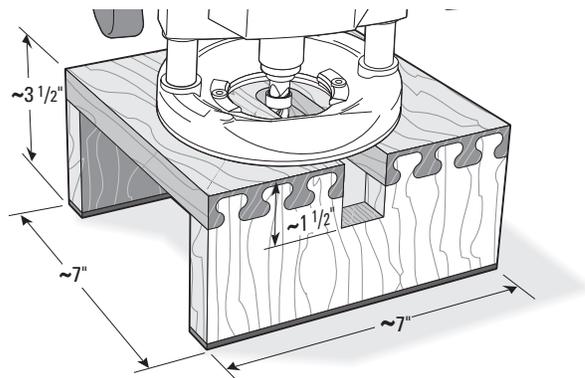
Try the boards end-on-end for fit.
If too loose, lower the bush.
If too tight, raise the bush.



11-14 Rout and test again.

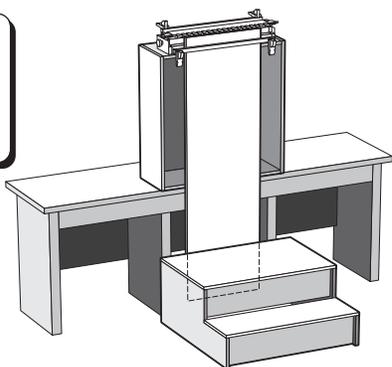


11-15 Once you have a good fit, rout a complete pin and socket joint, using the same species wood as for the workpieces, to test for final fit.



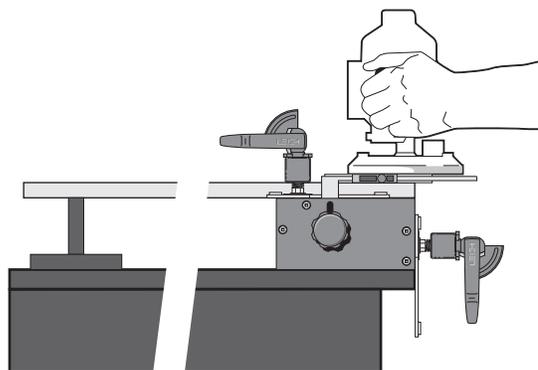
11-16 Router Stand

If you do not already have one, make up a small router stand as illustrated, to mount the router securely on the bench when not in use.



11-17 Routing Long Vertical Boards

To rout long vertical boards, you may need to build a jig stand to mount on your bench. Make the stand and bench height combination sufficient to accept the board length you have in mind. Bolt the stand securely to the bench. Make a stable platform to stand on as illustrated. Portable steps are too unstable.



11-18 Routing Long Horizontal Boards

When placing long horizontal boards in the rear clamp, make sure the rear end of the board is supported to prevent unnecessary racking of the jig. ■