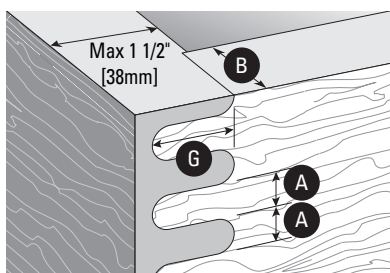
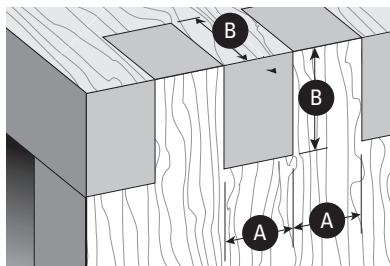
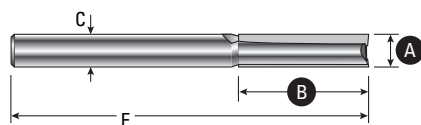
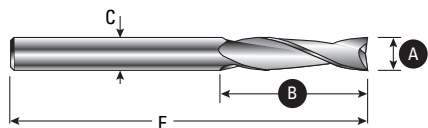


*F2, F1600 APPENDIX II*

# **Cutter Selection and Joint Specification**

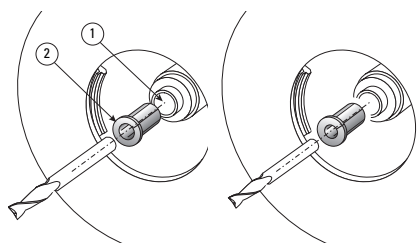


## Cutter Selection and Joint Specification



Virtually any straight router bit may be used for routing box joints or finger joints. There are two types which each have their own advantages and disadvantages. Generally, the high-speed steel (HSS) spiral upcut bits cut cleaner and have less tendency to cause tear-out. They also tend to pull the waste chips up to and around the guidebush, necessitating the occasional cleaning of the guide surfaces. Straight-flute carbide tipped bits spray the waste out horizontally, but they do not cut quite as cleanly. The smallest cutters in both categories are usually single flute straight bits.

“A” is the cutter diameter and equals the nominal size of the finger or socket. “B” is the cutting depth or board thickness, whichever is less.



Check the shank size of each cutter selected, then use the appropriate collet ① or collet reducer ②.  $\frac{1}{4}$ " collet reducers come standard with most  $\frac{1}{2}$ " collet routers, but **if  $\frac{5}{16}$ ", 8mm or  $\frac{3}{8}$ " collets are not available, use one of the following:**

For all  $\frac{3}{8}$ " shank bits use the Leigh No. 172-375,  $\frac{1}{2}$ " to  $\frac{3}{8}$ " collet reducer.

For all  $\frac{5}{16}$ " and 8mm shank bits (*these are almost the same diameter*), use Leigh No. 172-8,  $\frac{1}{2}$ " to 8mm collet reducer.

### F2 and F2M Cutter Selection and Joint Specification

Leigh does not stock metric sized cutters or reducers. Please contact your national distributor for Leigh.

#### F2 SPECIFICATIONS

LEIGH		Solid Carbide Spiral	A Cutter Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length	F Maximum Board Width	G Max. Rounded Finger Length
Cutter Item No. Carbide Tipped	HSS Spiral							
132	162	—	1/16"	3/16"	1/4"	2"	8 7/16"	—
133	163	—	3/32"	3/8"	1/4"	2"	12 9/16"	—
134	164	164C	1/8"	3/8"	1/4"	2 5/8"	8 7/16"	—
135	165	165C	5/32"	5/8"	1/4"	2 7/8"	10 1/2"	—
136	166	166C	3/16"	5/8"	1/4"	2 7/8"	12 9/16"	—
138	168	168C	1/4"	3/4"	1/4"	3"	8 7/16"	1 1/8"
140-8	170	170C	5/16"	7/8"	8mm & 5/16"	2 3/4"	10 1/2"	1 1/4"
143	173	173C	3/8"	1"	3/8"	3"	12 9/16" to 22 29/32" *	1 3/8"
160	180	180C	1/2"	1 - 1/4"	1/2"	3 1/2"	14 21/32" to 23 13/16" *	1 3/8"

\* See "www.leighjigs.com", click on support/technical bulletins/wider box joints

#### F2M SPECIFICATIONS

A Cutter Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length	F Maximum Board Width F124	G Max. Rounded Finger Length
2	6	8	60	253	—
4	12	8	70	253	—
6	19	8	70	596	—
8	22	8	75	253 to 499*	32
10	25	8	75	335 to 580*	35
12	32	8	75	596	35

Leigh does not stock metric sized cutters or reducers. Please contact your national distributor for Leigh.

\*See "www.leighjigs.com", click on support/technical bulletins/wider box joints.

## F1600 and F1600M Cutter Selection and Joint Specification

Leigh does not stock metric sized cutters or reducers. Please contact your national distributor for Leigh.

### F1600 SPECIFICATIONS

LEIGH Cutter Item No. Carbide Tipped    HSS Spiral		Solid Carbide Spiral	A Cutter Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length	F Maximum Board Width F2400
132	162	—	1/16"	3/16"	1/4"	2"	8 7/16"
133	163	—	3/32"	3/8"	1/4"	2"	12 9/16"
134	164	164C	1/8"	3/8"	1/4"	2 5/8"	8 7/16"
136	166	166C	3/16"	5/8"	1/4"	2 7/8"	12 9/16"
138	168	168C	1/4"	3/4"	1/4"	3"	8 7/16"
143	173	173C	3/8"	1"	3/8"	3"	12 9/16" to 22 29/32"*
160	180	180C	1/2"	1 - 1/4"	1/2"	3 1/2"	14 21/32" to 23 13/16"*

Leigh does not stock metric sized cutters or reducers. Please contact your national distributor for Leigh.

\*See "www.leighjigs.com", click on support/technical bulletins/wider box joints.

### F1600M SPECIFICATIONS

A Cutter Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length	F Maximum Board Width
2	6	8	60	162
4	12	8	70	162
6	19	8	70	389
8	22	8	75	162 to 300*
10	25	8	75	264 to 500*
12	32	8	75	389

Leigh does not stock metric sized cutters or reducers. Please contact your national distributor for Leigh.

\*See "www.leighjigs.com", click on support/technical bulletins/wider box joints.