

Item no. D4RKIT

Make Single Pass Half-Blind Dovetails and Finger (Box) Joints on Your Earlier Model Leigh Dovetail Jig

Your D4R, D4, D3, D1258R or D1258 Dovetail Jig can be upgraded with two great features. This upgrade (D4RKIT), **along with your modified or new set of guide fingers***, will allow you to rout single pass half-blind dovetails in five depths and rout two sizes of finger (box) joints, 3/8" and 3/4", with precise adjustment for fit. The following parts are included in the upgrade kit:

- 1 Single Pass Half-Blind Dovetail Spacer
- 2 Finger (Box) Joint Spacer
- 3 Single Pass Half-Blind Nylon Stop Rod
- 4 e7 Elliptical Guide Bushing
- 5 Pin Wrench for e7 Guide Bushing
- 6 D4R Pro User Guide (which includes the instructions for each of these joints)



*In addition to the parts shown above, you will need to modify the tail end of each guide finger as described on the following pages. *Note: No modification is required for finger (box) joints.* **If you would prefer a "new" set of D4R Pro fingers, see "D4R Pro Guide Finger Set" at www.leighjigs.com/jig-upgrades/ for details.**

Guide Finger Modification

In order to produce single pass half-blind dovetails on your Leigh dovetail jig, a $9/64$ " hole must be drilled in the tail end of each guide finger at a specific location. Although fingers may be marked and drilled free hand, we recommend using a shop-made drilling jig similar to the drawing on the following page, and your drill press, to ensure holes are drilled at the same location in every guide finger.

D4R/D4 (see drawing on next page)

1. Remove the guide finger assembly from the jig, and remove the scales and all fingers from the finger bar.
2. Use a flat board approximately 10" x 6" as a base.
3. Mount a cross piece (A), 4" long by $3/4$ " x $1/2$ " approximately 2 $1/2$ " from one end of board.
4. Mount the first perpendicular piece (B), 5" x $3/4$ " x $1/4$ " approximately on crosspiece (A).
5. Place a finger firmly against the first horizontal piece.
6. Mount the second perpendicular piece (C) firmly against the finger and secure in place.
7. Make a spacer block (D), $7/32$ " x 1" x $7/16$ ".
8. Using a left hand finger, mark layout lines on the flat surface of the tail end of the finger as indicated.
i.e. $11/64$ " from the screw face of the finger and $29/32$ " from the end of the finger.

NOTE: All fingers are identified with an "L" (Left hand) or an "R" (Right hand) cast in to the tail end of the finger.

9. Place the left finger in the drilling jig as indicated and mount drilling jig on drill press table.
10. Center the drill bit on the layout marks and secure the drilling jig to the table with clamps. **Tighten clamps securely.**
11. Drill all left hand fingers.
12. Before drilling the right hand fingers, place the spacer block in the drilling jig as indicated. This block is necessary to prevent the right hand fingers from bending down when drilling.
13. Drill all right hand fingers.
14. Replace all fingers on the finger bar and refer to Chapter 1, Figures 1-8 and 1-9 of your User Guide, when reattaching the scales.

D3, D1258R & D1258

D3 and earlier jig owners may use the same drilling procedure as noted above, however your guide fingers are solid (not cored out).

IMPORTANT NOTE: D4, D3, D1258R & D1258

Shop-Made Spacers Required

The spacers provided with this kit cannot be used to offset the boards from the side stop. Therefore shop-made spacers are required to offset the tail board for single pass half-blind dovetails, and the socket board for $3/8$ " and $3/4$ " finger (box) joints. They are easily made from scrap $1/4$ " plywood, solid wood or pressboard.

The single pass half-blind dovetail offset spacer must be 5 $1/2$ " long by 0.544" wide by $1/4$ " thick.

Tip: Cut spacer to $35/64$ ". You may need to sand lightly to specification.

The finger (box) joint offset spacer must be 5 $1/2$ " long by 0.386" wide by $1/4$ " thick.

Tip: Cut spacer to $25/64$ ". You may need to sand lightly to specification.

