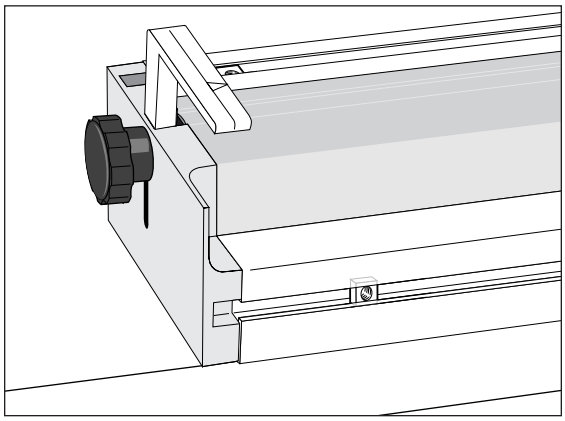
INFORMATION ONLY

INSTALLATION INSTRUCTIONS

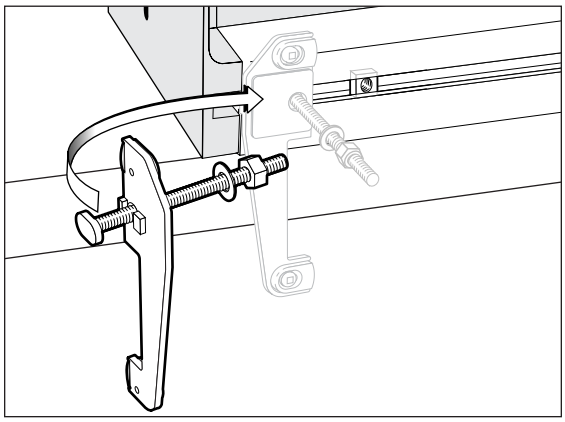
Leigh D4 Sidestops

Fits D3, D1258R, and D1258 model jigs

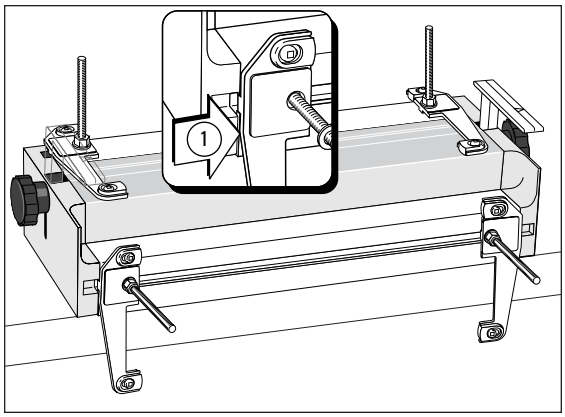
Joining Tradition with Today



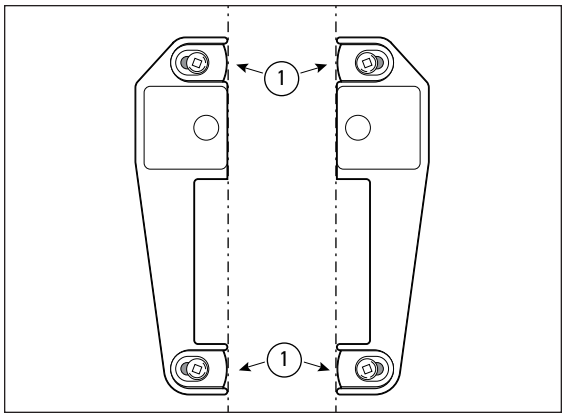
1 Remove the finger assembly, cam clamps or clamp knobs, clamp bars, side stops and bolt assemblies. Reassemble the T-bolts, nuts and washers with the new stops as shown.



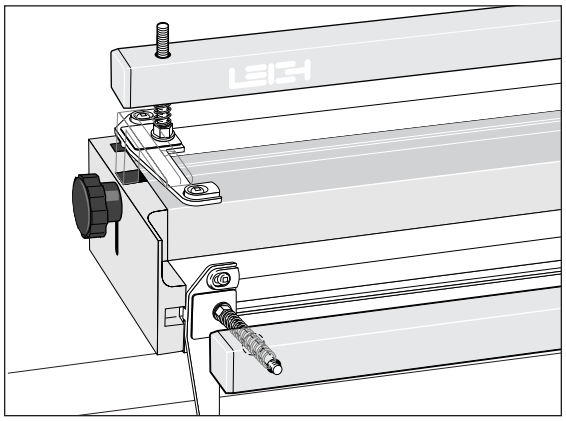
2 Insert two T-bolt/sidestop sub-assemblies into each of the two main extrusions. Make sure the side stop, washer, and nut are in the correct order as illustrated, with the locating lugs engaging in the extrusion slot. Note: The lugs will be tight to enter the extrusion slot, but the nut will force the lugs in. See step 3 before tightening.



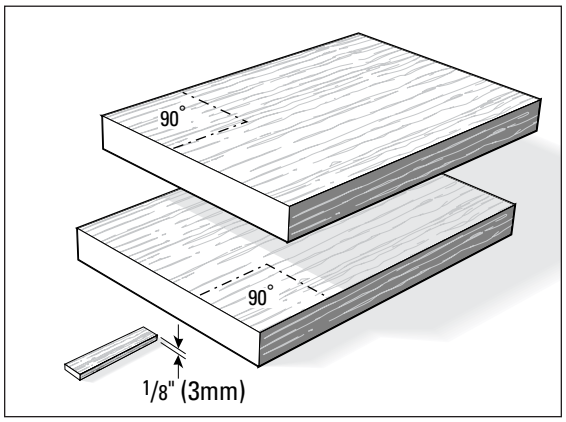
3 Position the side stops with the outer edge of the **casting** flush with the ends of the extrusion ①. Firmly tighten the nuts until the side stops are seated.



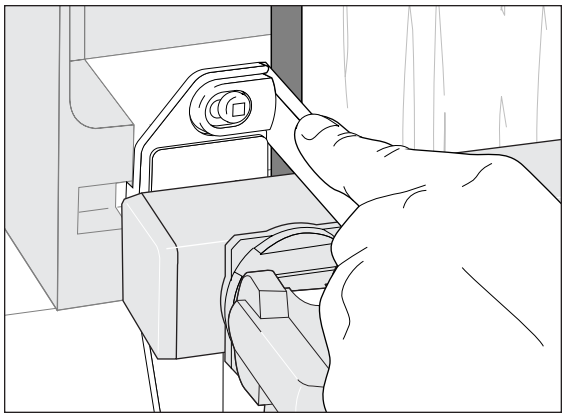
4 Note that the adjustable bumpers ① are factory set in the retracted position, which is set back from the main body of the sidestop. This is for setup alignment purposes. If yours are not in this position, make sure that they are before proceeding. Remount the finger assembly with support brackets in fully raised position.



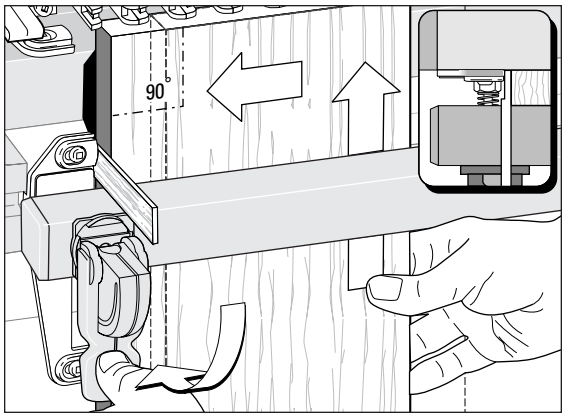
5 Place four springs and two clamp bars on the T-bolts. The large holes in the clamp bars go right over the springs. Make sure the clamp bars move freely on the T-bolts. The Leigh logo or decal should be on the rear (upper) clamp bar facing you.



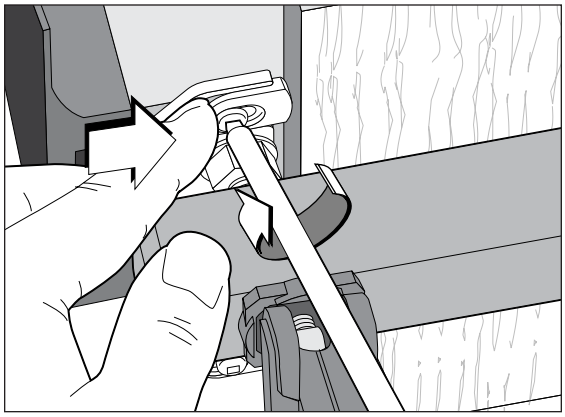
6 Now you will need two pieces of - say, 1" x 6" (¾" x 5½") by say, 10 inches long. Both pieces need to have square ends for setting the side stops. You will also need a short length of lath between 1/10" and ⅛" (3mm) thick.



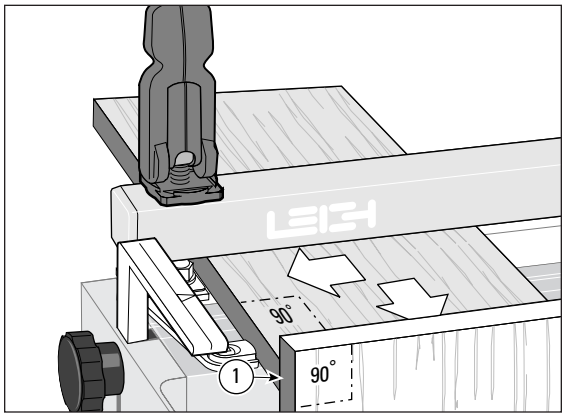
7 To set the sidestop bumpers, adjust the clamps to receive the two square boards. Use the end of the lath to position one of the 90° test boards away from the front left hand sidestop casting. Make sure the top end edge of the board is touching flush under the guide fingers.



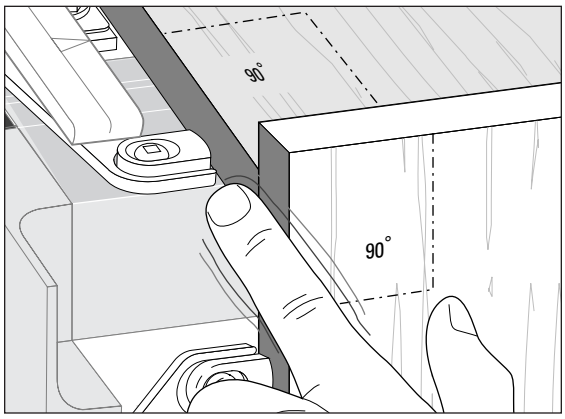
8 With the lath trapped in place, clamp the board.



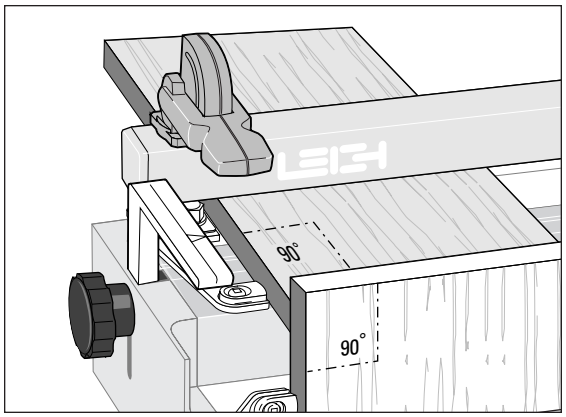
9 Remove the lath and loosen the bumper setscrews. Slide the top bumper against the board and tighten the screw firmly. Position and tighten the bottom bumper.
Leave the board in place.



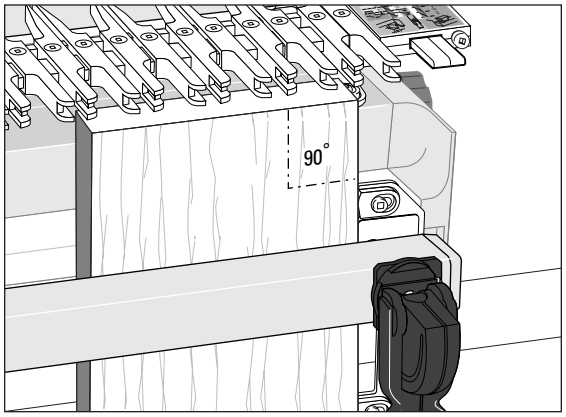
10 Remove the finger assembly. Place the second 90° test board under the rear clamp, front end edge flush against the front board. Slide the rear board side to side until the left side edges are flush ①.



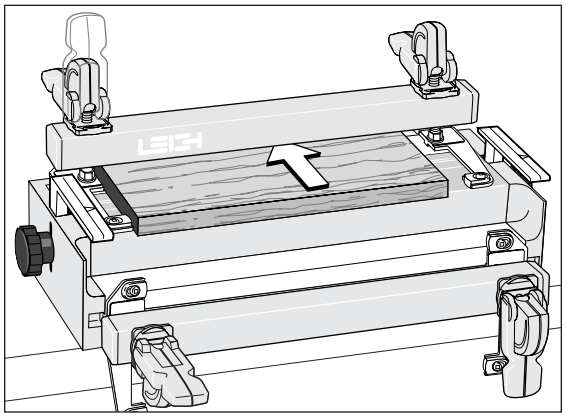
11 Check with your fingertip to make sure it is flush.



12 Clamp the rear board (if you have cam clamps, by pulling the lever forward this one time only so that the rear bumper screw is accessible). Position the bumpers against the top board and tighten the setscrews.
The left hand front and rear sidestops are now precisely aligned.



13 Remove the boards from the left side of the jig.Make sure the support brackets are still in the fully raised position. Temporarily re-install the finger assembly onto the support brackets (any mode). Repeat the sidestop bumper setting procedure with the lath, on the front right side of the jig. Then remove the finger assembly and repeat the alignment procedure for the rear right sidestop with the second board.



14 **D1258 jig owners:** Make up a spacer board to **support the finger assembly in all front-clamping vertical board modes**. The spacer board should be flat, straight and of even thickness. We suggest ¾" x 6" by approximately 11½" or 23" long, depending on your jig size. This is to keep the finger asembly above the rear side stops. **D1258R and D3 jig owners** should already have their spacer boards made.

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