



F2, F1600 APPENDIX I

Variable Guidebush Selection

VGS:

The Leigh Variable Guidebush System

The VGS is included with the F Finger Joint Templates, but you may need an optional adaptor for your router (see next pages).

Do not use the VGS on D Series dovetail jigs or the M2(MMTA) as the tapered VGS bushes will not index properly on the guidefingers and guide rails.

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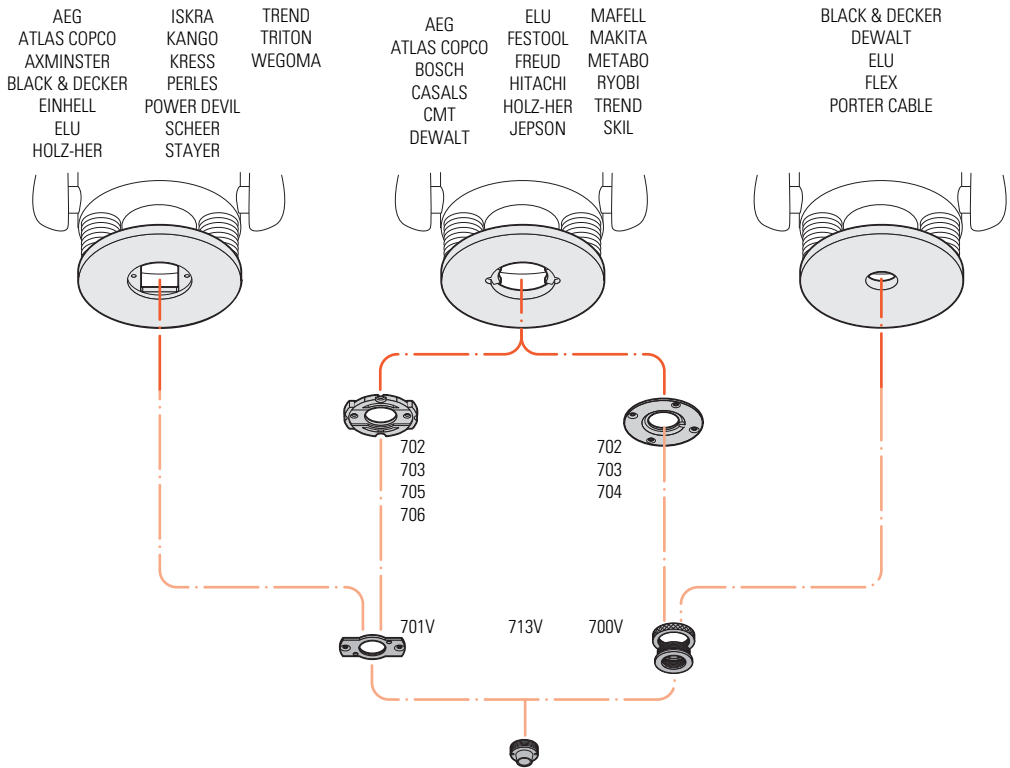
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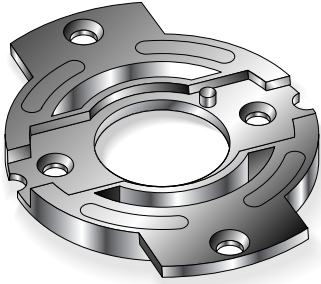
The Variable Guidebush System

The Vital Link Between Your Router and the Leigh F Template

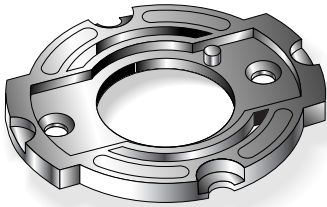
Because there is little or no standardization in the router industry, Leigh has developed a comprehensive guidebush and adaptor system to match your router to Leigh jigs and attachments. The diagram below shows how the VGS parts relate to each other and to different makes and types of routers.

Do not use this diagram for part selection. See pages 75-76.

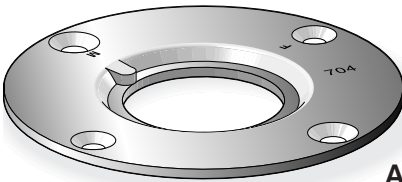




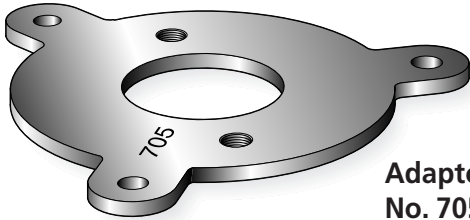
Adaptor No. 702



Adaptor No. 703



Adaptor No. 704



Adaptor No. 705

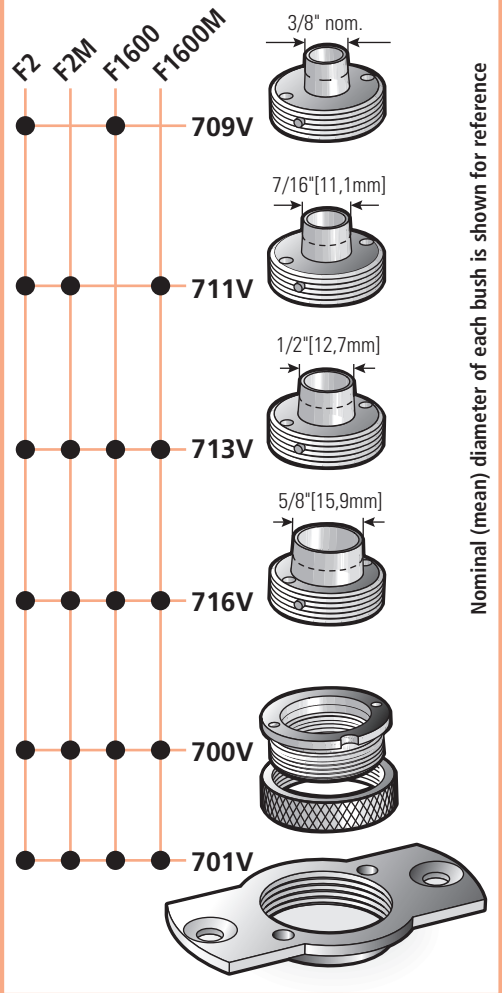


Adaptor No. 706

How to Select the Adaptor for the Leigh F Template and Variable Guidebush System

1. Go to the Selection Chart on the facing page.
2. Find the make and model of your router from columns 1 and 2.
3. See which standard variable guidebush holder works with your router in column 4. **This holder is included with your F2.**
4. Select the Adaptor for your router (if required) from column 3. *NA means not available for those model routers. Leigh does not stock router manufacturers' adaptors.*

ACCESSORIES INCLUDED WITH TEMPLATES



Find the make and model of your router in columns 1 and 2. See which Leigh holder works with your router in column 4. Select the correct adaptor plate for your router (if required) from column 3. *Leigh adaptors are in red.* Other adaptors must be purchased from the router manufacturers distributor. The VGS holders are included with your F Template.

1 ROUTER MAKER	2 ROUTER MODEL	3 (optional) LEIGH OR ROUTER MAKER'S ADAPTOR NO.	4 (included) LEIGH VGS HOLDER
AEG	OFE 710 in plunge base	No adaptor required	701V
	OFSE 2000	703	
ATLAS COPCO	OFSE 710 in Plunge Base, OFE 1000	No adaptor required	701V
	OFSE 2000	703	
AXMINSTER WHITE	AW635R	No adaptor required	701V
	AW127R	Adaptor supplied w/router	
BLACK & DECKER	All Professional HD 1250, RP400K	No adaptor required	700V
	6200	720673-00	
	SR100, 7AEE, KW780 Series	No adaptor required	
BOSCH	90140, 90098, 90088	No adaptor available	NA
	90085, 90150, 90300, 90303, 90305, 91264		
	1600, 1601, 1602, 1603, 1604, 1606, B1350	2 610 906 290	
	1613, 1613EVS, 1613AEVS, 1614, 1614EVS, 1614EVS,		
	1617, 1617EVS, 1618EVS, 1619EVS, B1450,	RA1100	
	POF800ACE, GOF900ACE, GOF1300ACE, GOF2000CE		
	1611, 1611 EVS, 1615, 1615 EVS, B1550, GOF1600, GOF1700 ACE	702	701V
CASALS	FT750, FT1000E, FT2000E	703	701V
CMT	1E	702R	701V
CRAFTSMAN (SEARS)	All non-plunge models	No adaptor required	NA
	135275070 Plunge	See Skil 1823 or 1835	See Skil 1823 or 1835
	Other plunge models	702	701V
DEWALT	DW610, DW616, DW618	No adaptor required	700V
	DW 613	No adaptor required	701V
	DW614, DW615, DW618, DW621, DW624, DW625, DW626	North America only; Adaptor supplied w/router	700V
	DW621K & DW626 Outside North America	706	701V
	DW625 Type 1, 2 and 3 Outside North America	702	
	DW625 Type 4, Outside North America, DW625EK	702R	
EINHELL	EOF850SP, OF-G 1100E	No adaptor required	701V
ELU	2720, 2721, 3328	No adaptor required	700V
	3303, 3304	E09600 or 761 270-00	
	3337, 3338, 3339, MOF131, MOF177, Type 1,2 and 3	702	
	MOF68, MOF69, MOF96, MOF96E	No adaptor required	
	OF15, OF15E, OF97, OF97E	706	
	MOF 177 Type 4, MOF177EK	702R	
FEIN	RT1800	Adaptor supplied w/router	700V
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704	700V
	OF2000, OF2000E	705	701V
FLEX	ALL MODELS	No Adaptor required	700V
FREUD	F12000	703	701V
HITACHI	TR8, TR12, FM8, M8, M12 Series	703	701V
	M12VC	No adaptor required	700V
HOLZ-HER	2355, 2356	No adaptor required	701V
	2365	702	
ISKRA	MR808A Series	No adaptor required	701V
JEPSON	7412	703	701V
KANGO	OF808	No adaptor required	701V
KRESS	OF690 IE Series	No adaptor required	701V
MAFELL	LO65E	702	701V
MAKITA	3601B	321 493-1	700V
	RF1100, RF1101, RD1100, RD1101, RP1101	No adaptor required	
	RP0910, RP1110C	706	
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N. America, 3620, 3621	703	
	3612C Europe Qk. Fit Base	Contact your National Leigh distributor	
METABO	OF1612, OFE1812	704	700V
MILWAUKEE	5615, 5619	49-54-1040	700V
	5625	Adaptor supplied w/router	
PERLES	OF808 Series, OFE6990	No adaptor required	701V
PORTER CABLE (ROCKWELL)	All	No adaptor req. d, or supplied w/router	700V
POWER DEVIL	All	No adaptor required	701V
RYOBI	R30, R50, R150, R151, R155, RE155, R500, R501, R502	703	701V
	R600, R601, RE600, RE601	702	
	R160, R161, R162, R165, R170, R175, RE175, R180, R180PL, R185	706	
SCHEER	HM9, HM14, HM14-12, HM18, HM18-E	No adaptor required ●	701V
SKIL	1823 or 1835	91803	700V
	All others	See Bosch Distributor	NA
STANLEY	All	No adaptor available	NA
STAYER	PR50 Series	No adaptor required	701V
TREND (Fellisati)	T5	No adaptor required	701V
	T9	Adaptor supplied w/router	
TRITON	TRC001	TGA002	700V
WEGOMA	OF850 Series	No adaptor required	701V

■ MAFELL – Rework the adaptor slightly.

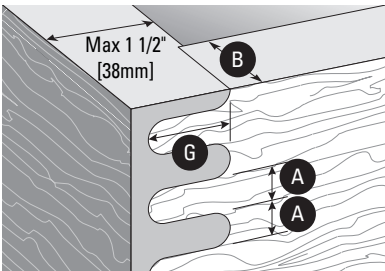
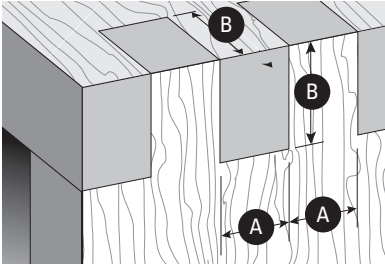
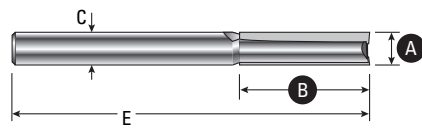
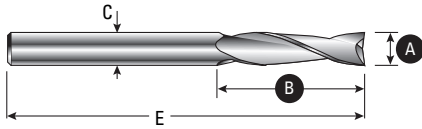
● SCHEER – Rework the router base slightly

F2, F1600 APPENDIX II

Cutter Selection and Joint Specification

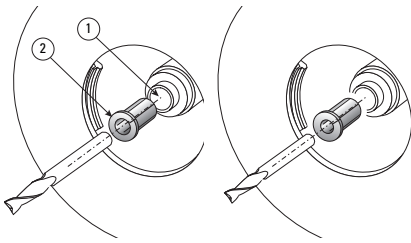


Cutter Selection and Joint Specification



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. 1/4" collet reducers come standard with most 1/2" collet routers, but **if 5/16", 8mm or 3/8" collets are not available, use one of the following:**

For all 3/8" shank bits use the Leigh No. 172-375, 1/2" to 3/8" collet reducer.

For all 5/16" and 8mm shank bits (*these are almost the same diameter*), use Leigh No. 172-8, 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"*

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*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.