

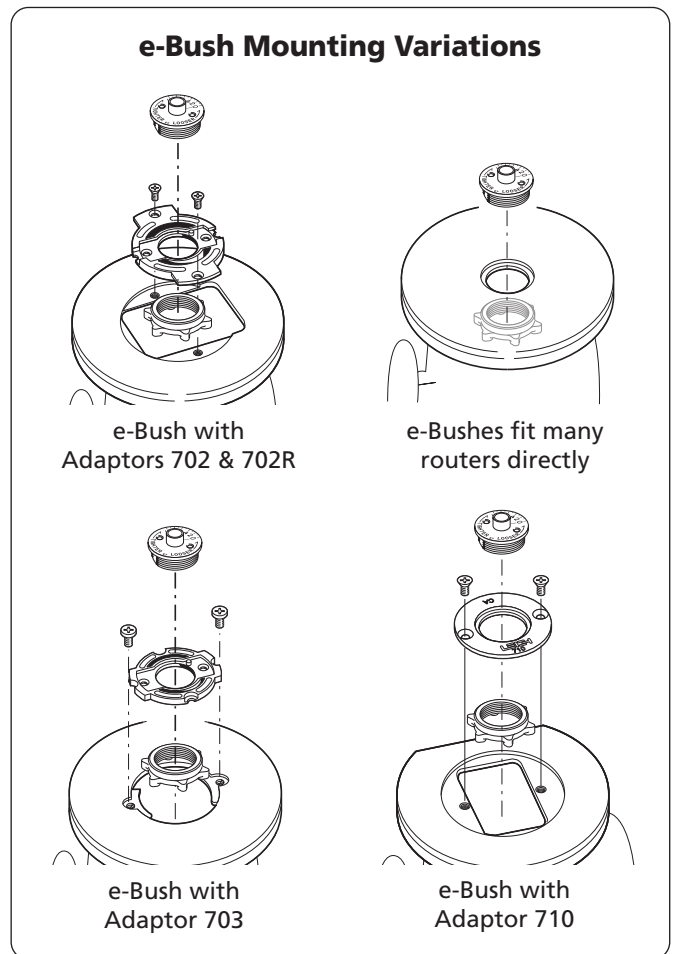
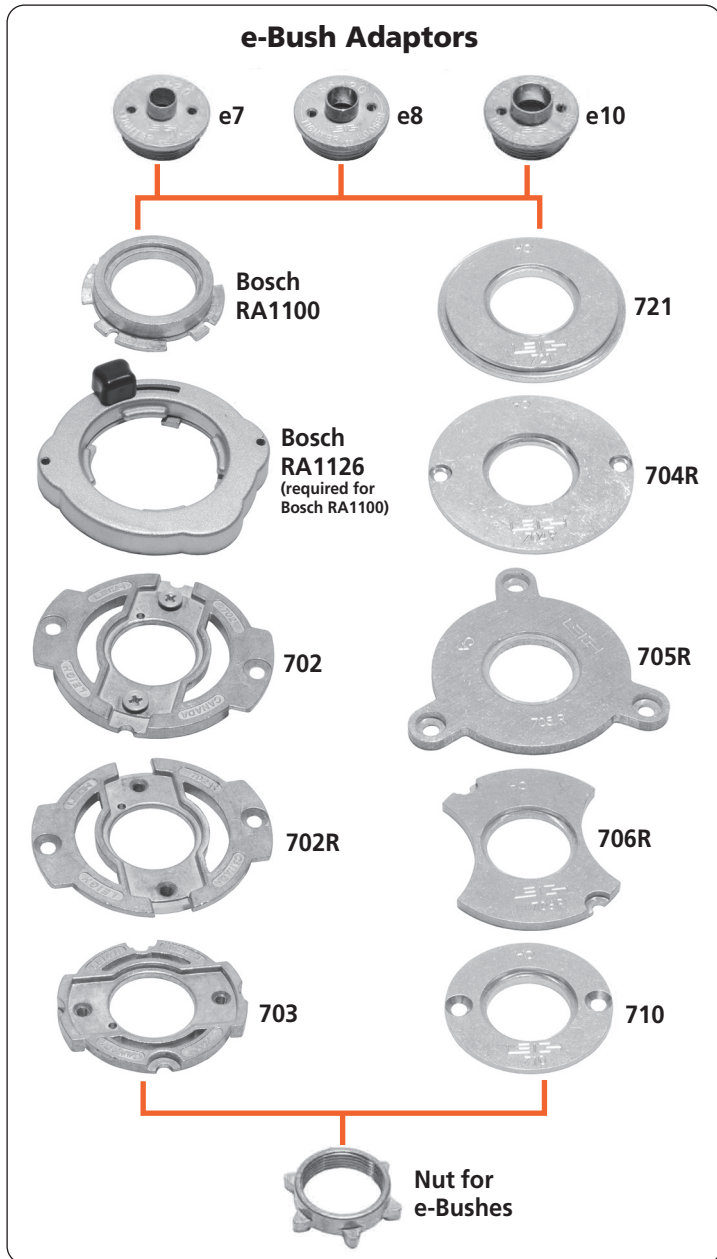
Appendix I

Attaching the Leigh e-Bush to the Router

e-Bush and Guide Adaptors

The Leigh e-Bush fits directly to most popular router models such as Porter Cable, Black & Decker, and Dewalt. Many other makes, e.g. Bosch, Fein, Festool, Milwaukee etc., either offer or come complete with base adaptors that accept the e-Bush. In addition Leigh offers the nine adaptors below to allow the use of over one hundred other router models new and old.

See list of routers on the next page.



e-Bush Adaptor Selection

Your router may need an adaptor to mount the guide bushing. Find out with this chart.

See www.leighjigs.com for the complete list of routers.

DIRECTIONS

- A.** Locate name of router maker in Column 1.
- B.** Locate router model in Column 2. If your router is not listed visit leighjigs.com for a complete, up-to-date list of routers.
- C.** Locate adaptor required for your router in Column 3.
 - Order Leigh adaptors (part no's in red) in Column 3 from Leigh.
 - Order Bosch adaptors RA1100 and RA1126 in Column 3 from Leigh or your Bosch dealer.
 - Order all other adaptors in Column 3 from the router manufacturer's dealer.
- D.** Guide bushings in Columns 4, 5 and 6 fit all adaptors listed and may be ordered if required. Note the following:
 - ◆ 7/16" (e7, 711TP) guide bushings are supplied with all Leigh dovetail jigs. Order only if you require a replacement.
 - 1/2" (e8) guide bushing is used on the F3 Finger Joint Template only.
 - ▲ 5/8" (e10, 716TP) guide bushings are used with 1/2" shank router bits on D4R Pro, D4R, D4, D3 & D1258(R) jigs. Order only if using 1/2" shank router bits.
 - MAFELL – Rework adaptor slightly.

Adaptor Mounting Screws

Screws are included with router.

Adaptors for Router Tables

Leigh guide bushings and e-Bushes are based on the industry standard 1-3/8" 2-piece design. Most router tables have adaptors that accept these standard guide bushings. If your router table does not have a suitable adaptor, please check with the router table manufacturer.

Guide Bushings

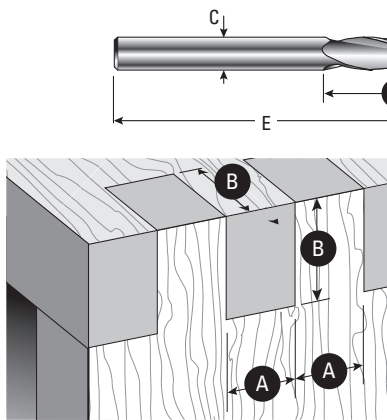
You can only use e7, e8, and e10 guide bushings with the F3 Template, and e8 and e10 bushings with the F18 and F24 Templates.

1 ROUTER MAKER	2 ROUTER MODEL	3 ROUTER ADAPTOR	4 ~7/16" OD BUSHING ◆	5 ~1/2" OD BUSHING ●	6 ~5/8" OD BUSHING ▲
BLACK & DECKER	All Professional, HD1250, RP400K,7614	Not Required	e7	e8	e10
	6200	720673-00	e7	e8	e10
	SR100, 7AEE, KW780 series, KW 800, KW850	710	e7	e8	e10
BOSCH	90140, 90088, 90098, 90085, 90150, 90300, 90303, 90305, 91264	Aftermarket base plate required	82855	NA	82854
	1600, 1601, 1602, 1603, 1604, 1606, B1350	2 610 906 290	82859	NA	82864
	ROUTERS PRODUCED AFTER mid 2010: 1613AEVS, 1617EVS, 1618EVS, and MR23EVS series, in N.America require Bosch adaptors RA1100 & RA1126. GOF1600CE in Europe requires RA1100 only.	RA1100 Adaptor and RA1126 Quick Change Adaptor required	e7	e8	e10
	ROUTERS PRODUCED BEFORE mid 2010: 1613AEVS, 1614EVS, 1617EVS, 1618EVS, 1619EVS POF800ACE, POF1400ACE, POF1100AE, POF1200AE, GOF1200, GOF900ACE, GOF1300ACE, GOF900CE, GOF2000CE, GMF1400, B1450	RA1100	e7	e8	e10
1611, 1611EVS, 1615, 1615EVS, B1550, GOF1600, GOF1700ACE	702	e7	e8	e10	
CMT	1E	702R	e7	e8	e10
CRAFTSMAN (SEARS)	All non-plunge models	Aftermarket base plate required	Order 5-piece set from Sears USA 0925973, or 3-piece set from Sears Canada 0900970704		
	135275070 Plunge		See Skil 1823 or 1835		
	Other plunge models	702	e7	e8	e10
DEWALT	MD11 Plunge & Fixed Base. MD9.5 Fixed Base	Not Required	e7	e8	e10
	DW610, DW616, DW618	Not Required	e7	e8	e10
	DW613, DW615(UK)	710	e7	e8	e10
	DW614, DW615, DW621, DW624, DW625, DW626	N. America Only, Supplied w/router	e7	e8	e10
	DW621K & DW626 outside N. America	706R	e7	e8	e10
	DW625 Type 1,2,3,5 outside N. America	702	e7	e8	e10
	DW624 & DW625 Type 4 outside N.America, DW625EK	702R	e7	e8	e10
ELU	OF15, OF15E, OF97, OF97E	706R	e7	e8	e10
	MOF68, MOF69, MOF96, MOF96E	710	e7	e8	e10
	MOF131, MOF177 Type 1,2, & 3	702	e7	e8	e10
	MOF177 Type 4, MOF177EK	702R	e7	e8	e10
	2720, 2721, 3328	Not Required	e7	e8	e10
	3303, 3304	E09600 or 761 270-00	e7	e8	e10
	3337, 3338, 3339	702	e7	e8	e10
FEIN	RT1800	Supplied w/router	e7	e8	e10
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704R	e7	e8	e10
	OF2000, OF2000E	705R	e7	e8	e10
	OF1400 and OF2200 North America Only	Supplied w/router	e7	e8	e10
	OF1400 Outside North America	493566	e7	e8	e10
	OF2200 Outside North America	494627 O-Ring may be required to keep bushing centered	e7	e8	e10
FREUD	FT700(2), FT2000, FT2200, FT3000	721	e7	e8	e10
HITACHI	TR8, TR12, FM8, M8, M12 Series	325211 OR 703	e7	e8	e10
	M12VC, KM12SC, KM12VC	Not Required	e7	e8	e10
	M12SA2, M12V2	325224	e7	e8	e10
MAFELL	LO65E	702 ■	e7	e8	e10
MAKITA	RP1801, RP2301, 3612C Europe Qk Fit Base	721	e7	e8	e10
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N. America, 3620, 3621, RP900K	703	e7	e8	e10
	3601B	321 493-1	e7	e8	e10
	RP0910, RP1110C	706R	e7	e8	e10
	RF1100, RF1101, RD1100, RD1101, RP1101	Not Required	e7	e8	e10
METABO	OF1612, OFE1812	704R	e7	e8	e10
MILWAUKEE	5615, 5616, 5619	49-54-1040	e7	e8	e10
	5625	49-54-1026	e7	e8	e10
	5670	Not Required	e7	e8	e10
PERLES	OF808 Series, OFE6990	710	e7	e8	e10
PORTER CABLE (ROCKWELL)	All	Not Required or Supplied w/router	e7	e8	e10
RIDGID	R2930	704R	e7	e8	e10
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703	e7	e8	e10
	R600, R601, RE600, RE601	702	e7	e8	e10
	R160, R161, R162, R163K, R165, R170, R175, RE175, R180, R180PL, R181, R185, ERT1150	706R	e7	e8	e10
SKIL	1823 or 1835	91803	e7	e8	e10
	SK1810, 1815, 1820, 1825	RAS140	e7	e8	e10
	All others	Aftermarket base plate required	11592		71021
TREND	T3, T4, T5, T9, T10, T11 – UniBase required	710	e7	e8	e10
TRITON	TRC001, TRA001	TGA006 or 704R	e7	e8	e10
	MOF001	TRA359	e7	e8	e10
WEGOMA	OF850 Series	710	e7	e8	e10

Appendix II

Bit Selection and Joint Specification

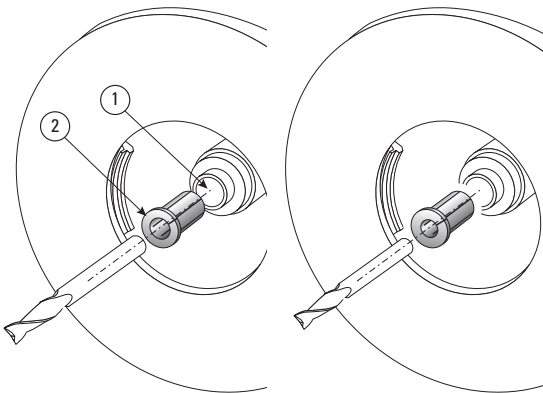
Bit Selection and Joint Specification



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.

“A” is the bit 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 bit 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.

BIT SELECTION & JOINT SPECIFICATIONS

F18 and F24

LEIGH Bit Item No.		Solid Carbide Spiral	A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
Carbide Tipped	HSS Spiral					
163	163	—	3/32"	3/8"	1/4"	2"
134	164	164C	1/8"	3/8"	1/4"	2 5/8"
136	166	166C	3/16"	5/8"	1/4"	2 7/8"
138	168	168C	1/4"	3/4"	1/4"	3"
143	173	173C	3/8"	1"	3/8"	3"
160	180	180C	1/2"	1"	1/2"	3 1/2"

F18M and F24M

A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
3	12	8	70
5	19	8	70
6	19	8	70
10	25	8	75
12	25	8	75

Leigh does not stock metric sized bits. Please contact your national distributor for Leigh.

F3

LEIGH Bit Item No.		Solid Carbide Spiral	A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
Carbide Tipped	HSS Spiral					
163	163	—	3/32"	3/8"	1/4"	2"
134	164	164C	1/8"	3/8"	1/4"	2 5/8"
135	165	165C	5/32"	5/8"	1/4"	2 7/8"
136	166	166C	3/16"	5/8"	1/4"	2 7/8"
138	168	168C	1/4"	3/4"	1/4"	3"
140-8	170	170C	5/16"	7/8"	8mm & 5/16"	2 3/4"
143	173	173C	3/8"	1"	3/8"	3"
160	180	180C	1/2"	1 1/4"	1/2"	3 1/2"

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

F3M

A Bit Dia. Finger Size	B Cutting Depth Range up to Max. Board Thickness	C Shank Diameter	E Overall Length
2	10	8	70
4	15	8	70
6	19	8	70
8	22	8	70
10	25	8	75
12	32	8	75

Leigh does not stock metric sized bits. Please contact your national distributor for Leigh.

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

Appendix III

Template Parts

See parts list and drawing on the following pages.

When ordering parts, please quote the template model (inch or metric), serial number, part number, part description and quantity required.

For quick reference, record your template's serial number here.

When ordering parts, please quote the template model (inch or metric), serial number, part number, part description and quantity required.

F18, F18M, F24, F24M

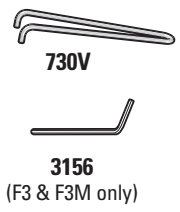
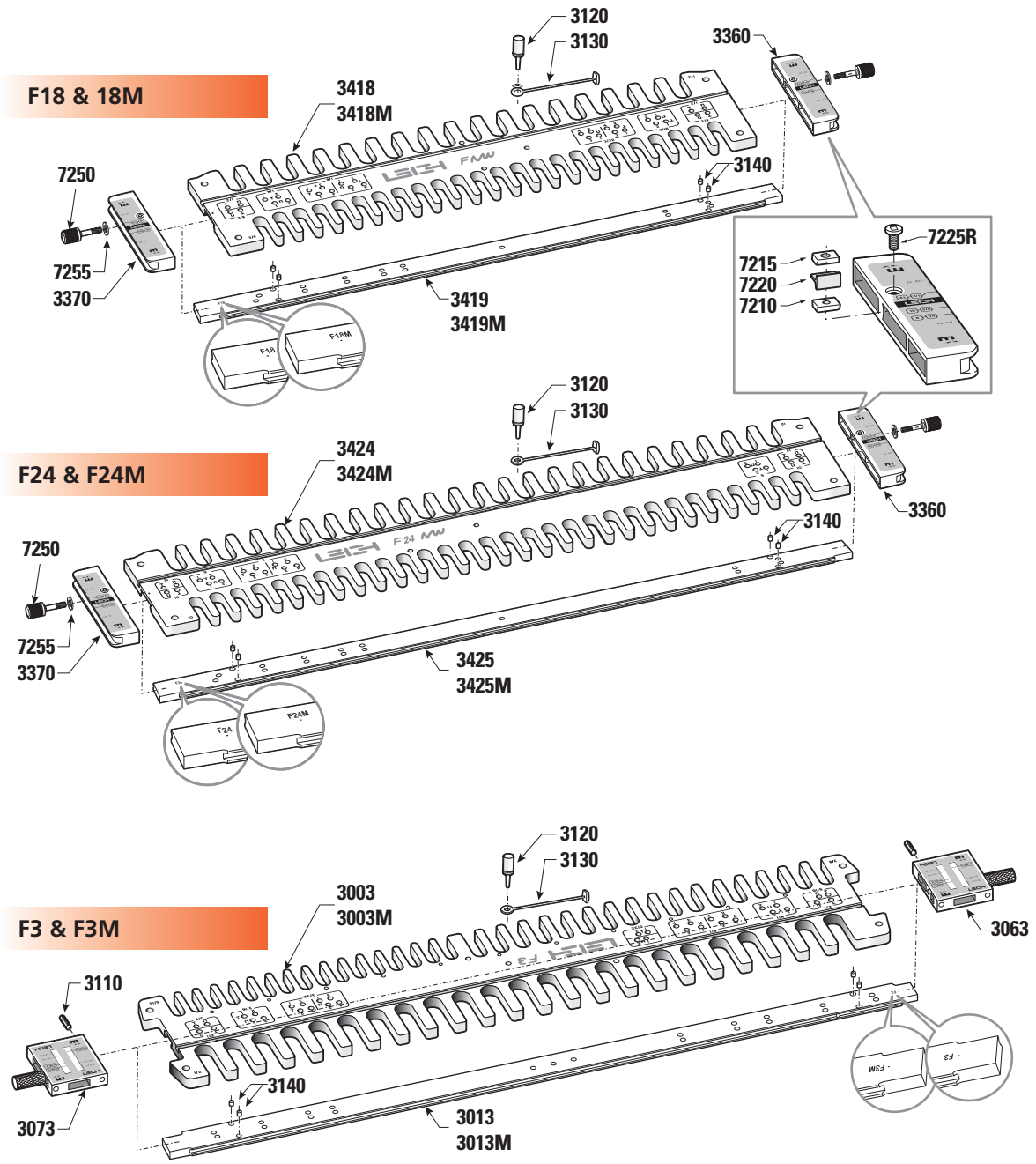
PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
3418	1	F18 "Inch" Template
3418M	1	F18 "Metric" Template
3424	1	F24 "Inch" Template
3424M	1	F24 "Metric" Template
3419	1	F18 "Inch" Template Bar with glides (3140)
3419M	1	F18 "Metric" Template Bar with glides (3140)
3425	1	F24 "Inch" Template Bar with glides (3140)
3425M	1	F24 "Metric" Template Bar with glides (3140)
3360	1	RH Scale Assembly (RH in $\frac{3}{8}$ " & 10mm mode)
3370	1	LH Scale Assembly (LH in $\frac{3}{8}$ " & 10mm mode)
7210	2	Scale Nut
7215	2	Scale Washer
7220	2	Scale Wedge
7225R	2	Scale Lock Screw #8-32
7250	2	Scale Thumbscrew
7255	2	Nylon Flat Washer $\frac{13}{64}$ " x $\frac{7}{16}$ " x .062"

F3, F3M

PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
3003	1	F3 "Inch" Template
3003M	1	F3M "Metric" Template
3013	1	F3 "Inch" Template Bar with Glides (3140)
3013M	1	F3 "Metric" Template Bar with Glides (3140)
3063	1	F3/F3M RH Scale Assembly (RH in $\frac{1}{2}$ " & 12mm mode)
3073	1	F3/F3M LH Scale Assembly (LH in $\frac{1}{2}$ " & 12mm mode)
e7	1	$\frac{7}{16}$ " e-Bush and nut
3156	1	Allen Wrench for Set Screws
3110	2	Scale Lock Set Screws

COMMON TO ALL F-TEMPLATES

PART NUMBER	QUANTITY PER TEMPLATE	PART DESCRIPTION
e8	1	$\frac{1}{2}$ " e-Bush and nut
e10	1	$\frac{5}{8}$ " e-Bush and nut
3120	1	Template Pin with Tie (3130)
3130	1	Template Pin Tie
3140	4	Template Bar Glides
3470	1	User Guide, combined inch & metric
730V	1	Pin Wrench



Appendix IV

Customer Support

Our Commitment to You Leigh Industries takes pride in its commitment to providing excellence in customer service and support. This user guide is designed to provide you with the answers to any questions you have. However, if you require assistance, please feel free to contact our technical support staff or a distributor listed below.

Manufacturer: Canada/USA

LEIGH INDUSTRIES LTD. (est. 1981)
P.O. Box 357
1615 Industrial Ave.
Port Coquitlam, B.C.
Canada, V3C 4K6

Toll Free: 800-663-8932
Phone: 604-464-2700
Fax: 604 464-7404
Customer Service: leigh@leighjigs.com
Tech Support: help@leighjigs.com
Web Site: www.leighjigs.com

NOTE: Email can be useful, but technical queries usually raise queries from us. A phone call is the quickest and most convenient way to get queries answered; either directly to Leigh (toll-free in North America) or to your national distributor. –*Thanks!*

Distributors

AUSTRALIA & NEW ZEALAND

Carba-Tec Pty. Ltd.
128 Ingleston Rd., Wakerley, Qld., 4154
Australia
Tel: (07) 3397 2577
Fax: (07) 3397 2785
Order: 180 658 111
Email: orders@carbatec.com.au
Web: www.carbatec.com.au

FRANCE

Ets Bordet
23 Rue Traversiere
93556 Montreuil Cedex, France
Tel: 01 48 58 28 39
Fax: 01 48 58 48 58
Email: info@bordet.fr
Web: www.bordet.fr/pages/

GERMANY, AUSTRIA & SWITZERLAND

Hacker GMBH
Holzbearbeitungsmaschinen
Traberhofstraße 103 D-83026 Rosenheim,
Deutschland
Tel: 08031 269650
Fax: 08031 68221
Email: hacker.rosenheim@t-online.de
Web: www.leigh.de

ITALY

Ferrari Macchine Legno SRL
Via Gallarata 74/76/78
20019 Settimo M.se (MI) Italy
Tel: 39 02 335 010 95
Fax: 39 02 335 005 27
Email: info@ferrarimacchine.com
Web: www.ferrarimacchine.com

JAPAN

Off Corporation Inc.
323-1 Yanbara, Shimizu-ku, Shizuoka-shi
Shizuoka-ken, Japan 424-0002
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Fax: 81-054-367-6515
Email: info@off.co.jp
Web: www.off.co.jp

KOREA

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Neung Pyung-Ri, Opo-Eup, Kwangju-Si,
Kyunggi-do, Korea
Tel: 82 (0) 70-8252-0988
Fax: 82 (0) 31-765-5602
Email: smgi@paran.com
Web: www.htools.co.kr

NORWAY

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Stoelsmyrvn. 103
5542 Karmsund, Norway
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Email: info@aurus.no
Web: www.aurus.no

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Email: info@leighjigs.ru (Russia)
Email: info@leighjigs.com.ua (Ukraine)
Web: www.leighjigs.ru (Russia)
Web: www.leighjigs.ua (Ukraine)

SOUTH AFRICA

Hardware Centre Group
Post: PO Box 4059, 2125
Randburg, South Africa
Tel: (011) 791-0844/46
Fax: (011) 791-0850
Email: info@hardwarecentre.co.za
Web: www.hardwarecentre.co.za

SWEDEN

Toolbox Sweden AB
Bruksgatan 3, S-597 30
Atvidaberg, Sweden
Tel: 46 120 854 50
Fax: 46 120 854 69
Email: info@toolbox.se
Web: www.toolbox.se

UNITED KINGDOM & IRELAND

BriMarc Tools & Machinery
Unit 10a Weycroft Avenue
Axminster, Devon
EX13 5PH England
Tel: 0300 100 1008
Fax: 0300 100 1009
Email: email@brimarc.com
Web: www.brimarc.com

