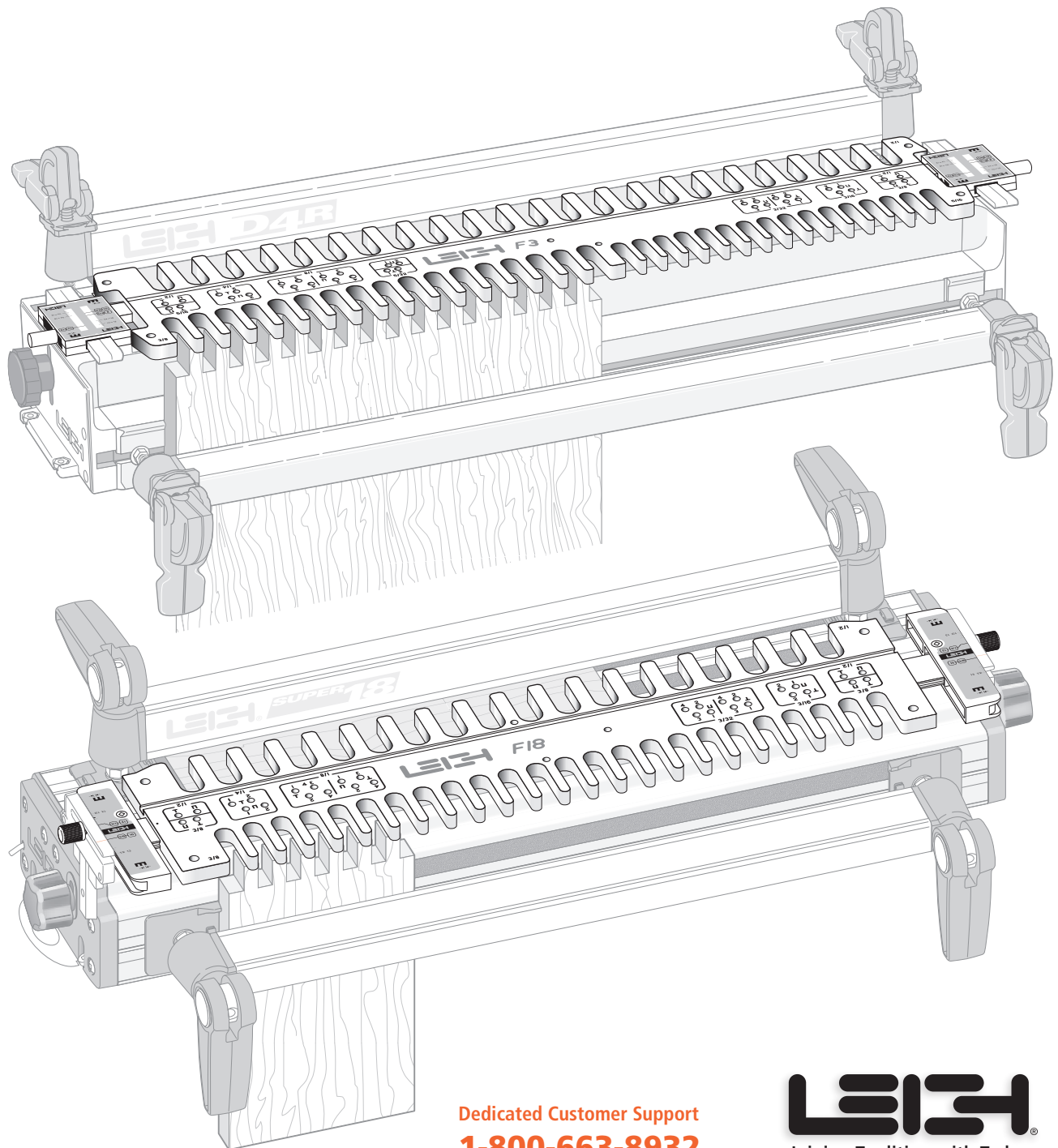


# LEIGH BOX/FINGER JOINT TEMPLATES

## User Guide

*F3, F18 and F24 Box/Finger Joint Templates  
for Use on Leigh D-Series & SuperJig Dovetail Jigs*



Dedicated Customer Support  
**1-800-663-8932**

**LEIGH**<sup>®</sup>  
Joining Tradition with Today

## Your new Leigh Finger Joint Template

You now own a superb finger jointing system. The Leigh Finger Joint template\* and adjustable e-Bush will help you rout finger or box joints with unique adjustment for precise tightness of fit.

“Finger” and “Box”: Both words are used universally to title this simple but strong joint. As the first machine-made joint, it’s old enough to be called antique, so we have been even-handed in using both terms throughout this guide.

We recommend that you first mount the template on your Leigh Jig, carefully following the instructions in the first section of the user guide. Then before you try to do any actual joinery routing, read the rest of the guide, following along with the basic functions. By all means, cut a few practice joints in scrap boards before you use the template to rout a precious hardwood workpiece.

If you have any questions that are not answered in this user guide, please call Leigh international customer support: 1-800-663-8932  
or email: [help@leighjigs.com](mailto:help@leighjigs.com).

For support contacts in your country of purchase see Appendix IV – Customer Support.

\* US Patent No. 5,711,356

Canadian Patent No. 2,146,834

European Patent No. 0698458

### LEIGH FINGER (BOX) JOINT SIZES

Inch Templates	Full Size (Inches)			Half Size (Inches)			Quarter Size (Inches)		Half-Blind (Inches)			Double Sizes (Inches)		
	<b>F3</b>	5/16	3/8	1/2	5/32	3/16	1/4	3/32	1/8	5/16	3/8	1/2	5/8	3/4
<b>F18</b>		3/8	1/2		3/16	1/4	3/32	1/8		3/8	1/2		3/4	1
<b>F24</b>		3/8	1/2		3/16	1/4	3/32	1/8		3/8	1/2		3/4	1
Metric Templates	Full Size (mm)			Half Size (mm)			Quarter Size (mm)		Half-Blind (mm)			Double Sizes (mm)		
	<b>F3M</b>	8	10	12	4		6	2		8	10	12	16	20
<b>F18M</b>		10	12		5	6		3		10	12		20	24
<b>F24M</b>		10	12		5	6		3		10	12		20	24

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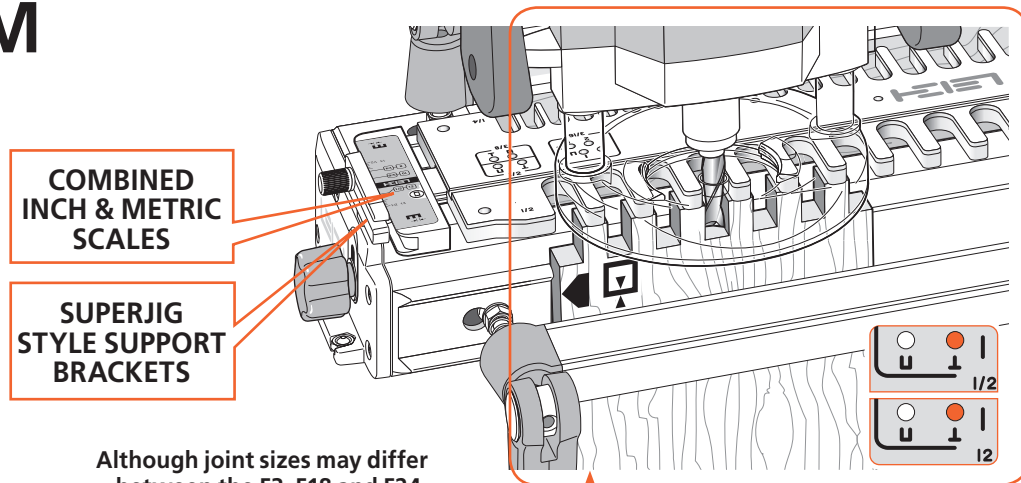
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**Are there operational differences between the F3 and F18/24?**

No. While the F18 and F24 are illustrated for most of the procedures in this guide, the differences between the F3 and the F18/24 do not affect the operational instructions. Movements and settings

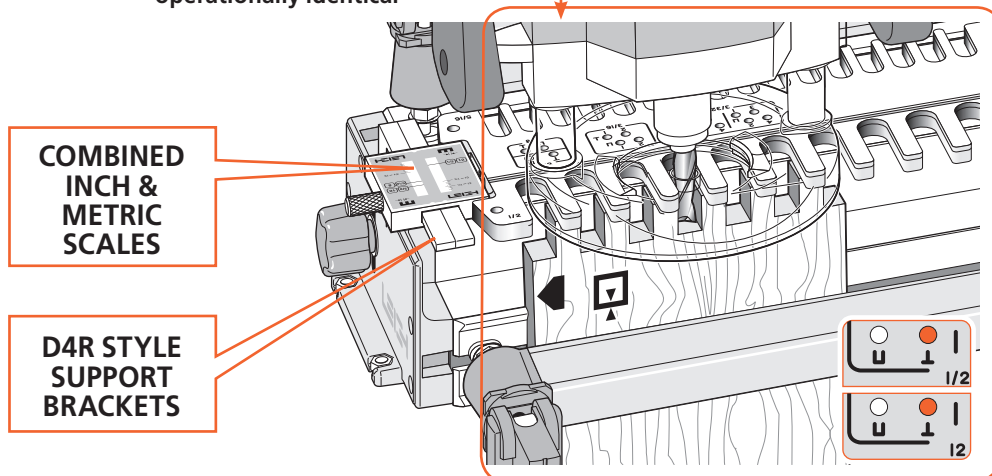
illustrated in each step are identical whether performed on the F3/F3M, F18/24, or F18M/24M. Icon types for template pin positions are the same on all templates.

**F18/F18M**



Although joint sizes may differ between the F3, F18 and F24, everything in these frames is operationally identical

**F3/F3M**

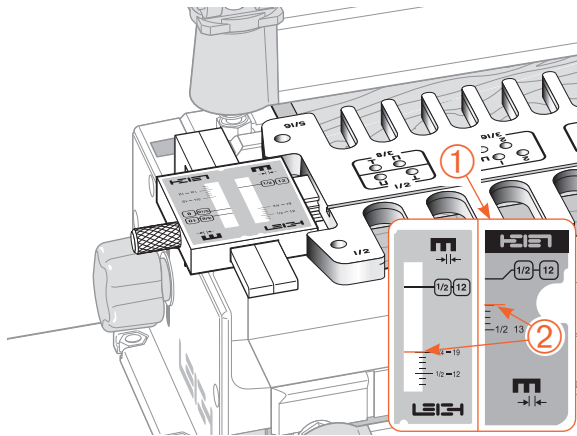


### Important: Inches and Millimeters

Because Leigh makes F3, F18 and F24 Templates in inch and metric models, measurements in this user guide are shown in both inches and millimeters. Dimensions are indicated with "inches" first, followed by "millimeters" in square parentheses.

Example:  $\frac{1}{2}$ " [12mm], or  $\frac{3}{4}$ " x  $5\frac{1}{2}$ " x 8" [20x140x200mm].

Do not be concerned if the inch/millimeter equivalents are not always exact. Just use the dimensions which apply to your jig.



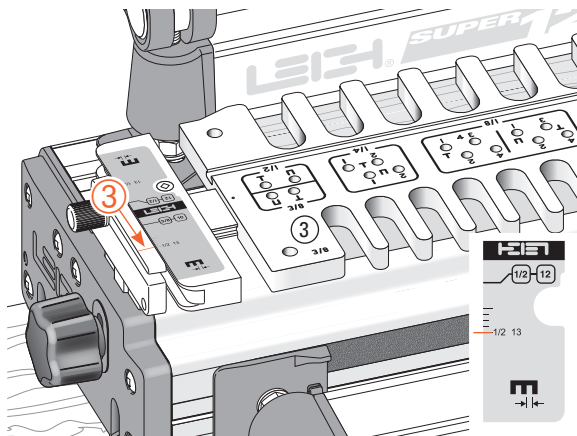
### Reading the Settings Illustrations

The F Template scales have dual markings for inch and metric.

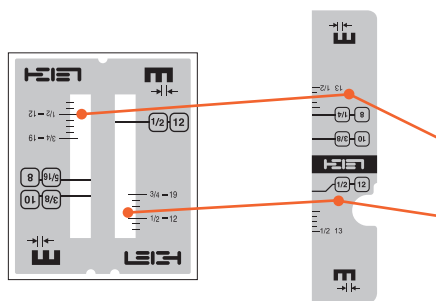
*Note: The scales on some templates may indicate a  $\frac{1}{4}$ " [6mm] size. This comb size is only available on F1600 Templates.*

The template scales are illustrated in a panel overlaying the main illustration ① when settings are specified in an instruction. The inactive (upside down) part of the scale is not shown in the illustration.

Scale settings for instructions are shown with a red line ②.



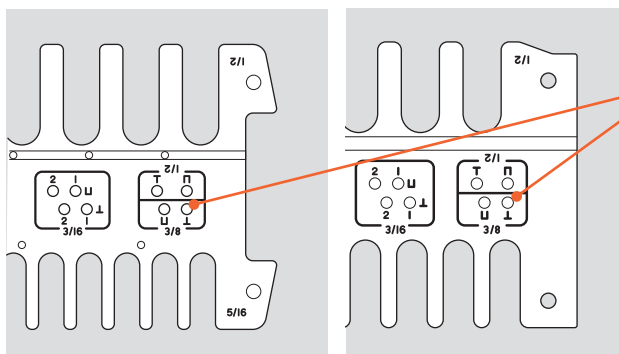
When calibration marks on the support brackets ③ are highlighted, they are illustrated in red for clarity. **On the jig, the lines are black.**



### Scale Icons

The Leigh Finger Joint Template has two modes. Position the selected comb to the front (toward you, the operator).

This places the  
Inactive scale upside down.  
and  
Active scale right side up.

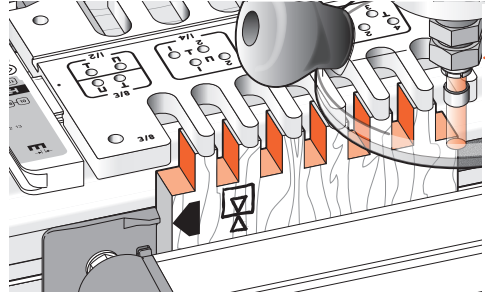



### Template Icons and Numbers (engraved)



Template positioning holes (see page 7)

## Which Way Round Should the Board Go?

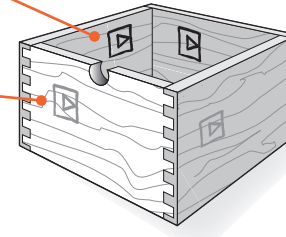
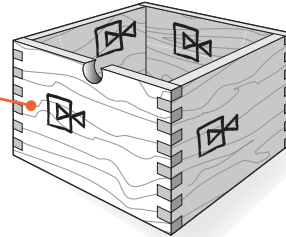
We devised these icons to indicate which side of a board faces out (toward you when it is clamped in the jig), and which faces are in or out when assembled.



 Boards are clamped in the jig both "face in" and "face out" for alternate end cuts; e.g. all regular box joint ends are routed this way

 Inside of board. All half-blind box joints are clamped in the jig with the inside  face away from the jig toward you, the operator.


 Shaded icons are on the other side of the board.





## How to Read the Symbols


To help you understand the instructions and illustrations in this user guide, we have used a number of international symbols, plus a few special ones of our own. They are all explained below. You needn't worry about memorizing these symbols now because they are repeated frequently throughout the guide, and you will soon get used to them.

### The following symbols indicate:

 This edge against side stop

 This edge against side stop

 As above, other side of board

 Caution: use special care for this operation

①②③ Numbered References in text

$\pm$  Plus/Minus

$=$  Equals



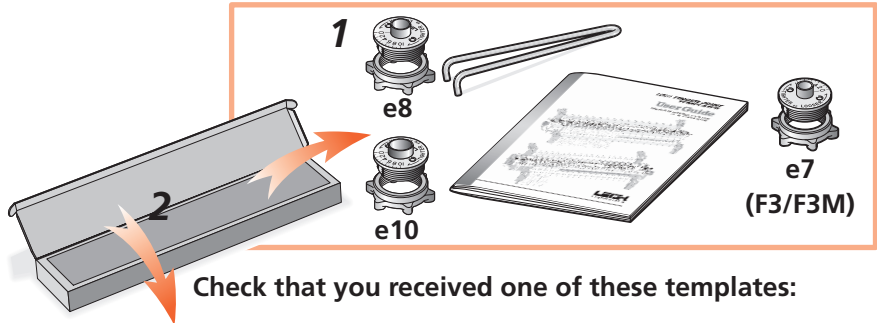
## CHAPTER 1

# Assembly, Mounting and Template Alignment

## Assembly and Mounting

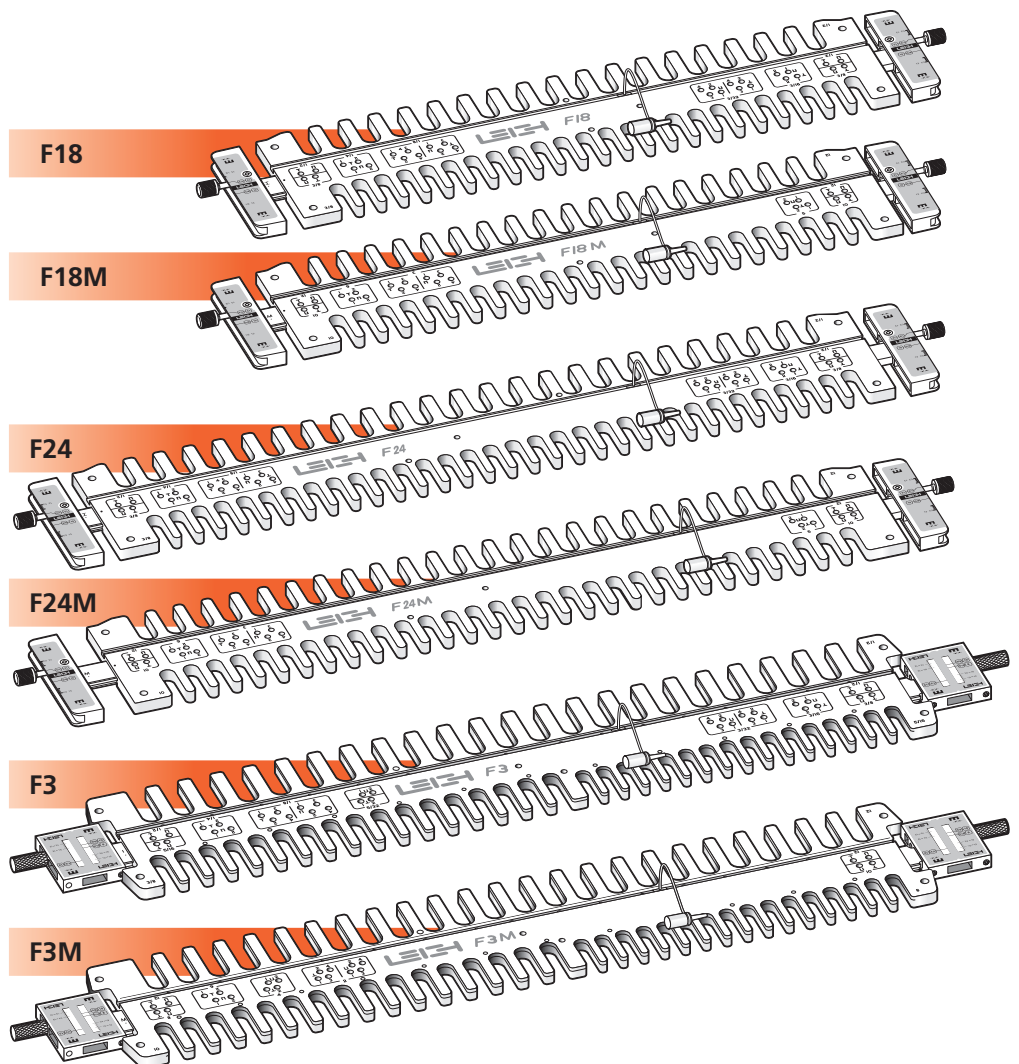
Before you begin mounting the Leigh Finger Joint Template to your Leigh Jig, make sure you have received the model ordered (Inch or Metric), and all the necessary parts.

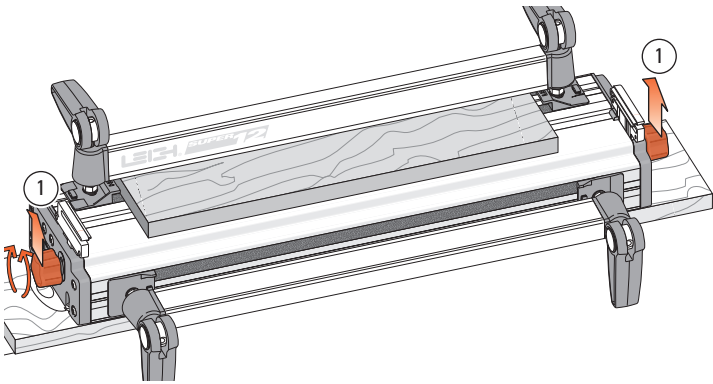
1. 1 e7-Bush incl nut (F3 only)
  - 1 e8-Bush incl nut
  - 1 e10-Bush incl nut
  - 1 Pin Wrench
  - 1 User Guide
2. 1 Template “inch” assembly,  
or:
  - 1 Template “metric” assembly



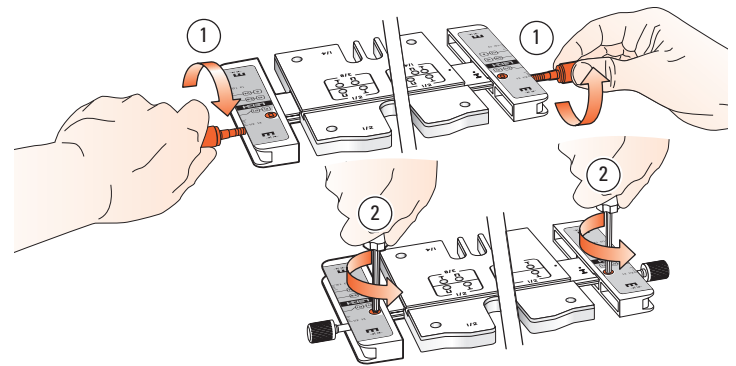
*If any of these items are missing, please notify your supplier or Leigh Industries immediately.*

Except for the scale thumbscrews (packed in a bag attached to the template), your Leigh F-Template comes fully assembled and requires only mounting and indexing to your Leigh jig. **This procedure is critical to the accuracy of the finished joinery**, so please follow the mounting instructions carefully.

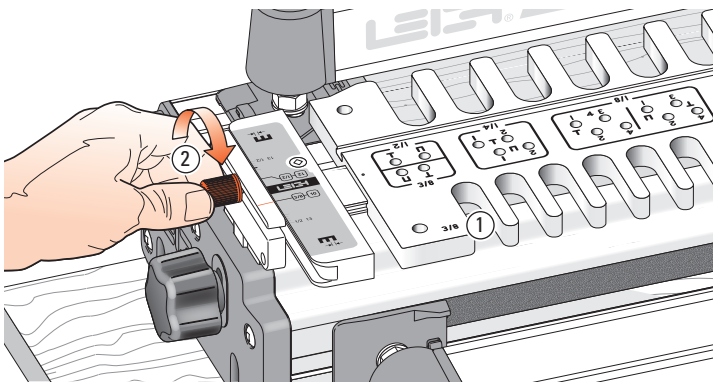




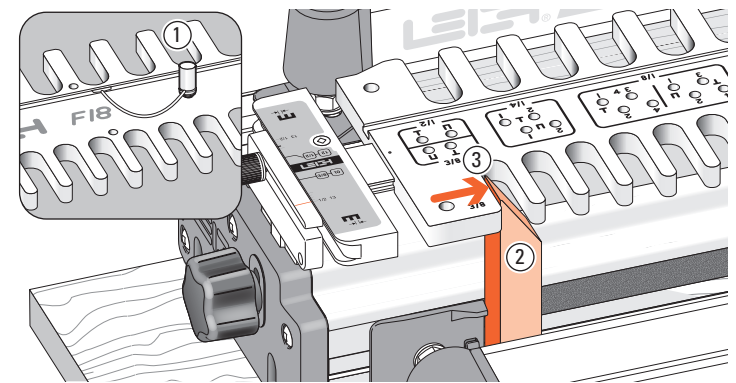
**1-1 Super18 & Super24 Jig Owners** D-Series jig owners go straight to 1-6. Raise both end support brackets and tighten the support bracket knobs ①.



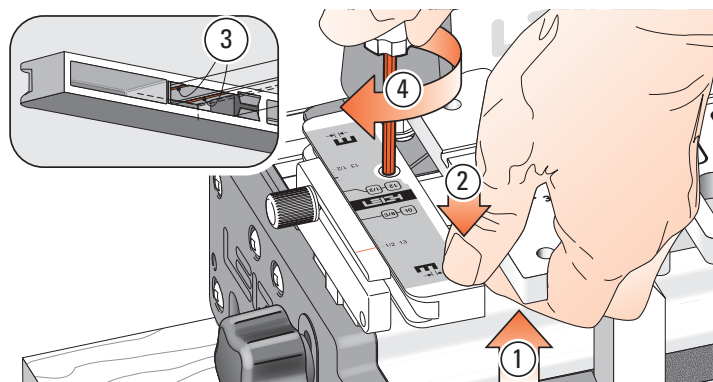
**1-2** Install the two thumbscrews a few turns into the scales ①. Loosen the scale lock screw ② at both ends (by one turn only).



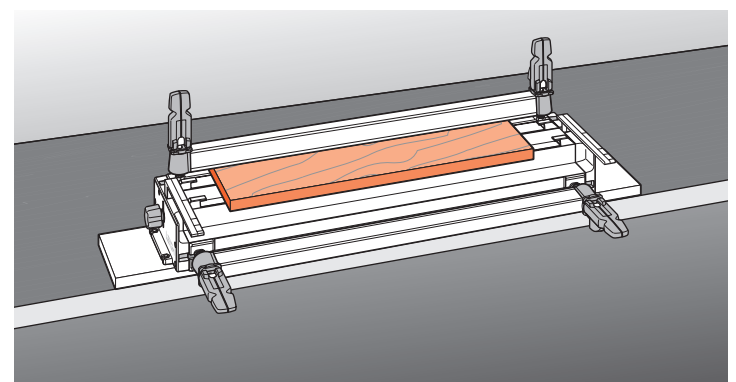
**1-3** Slide the template onto the support brackets, with the  $\frac{3}{8}$ " [10mm] comb toward you ① and set on the  $\frac{3}{8}$ " [10mm] setting. Tighten both thumbscrews ②. Do not lower the assembly onto the finger support board.



**1-4** Align the template so that its centre hole aligns with the hole in the bar and firmly insert the template pin ①. Angle trim the end of a straight block and clamp it tight against the left stop; the top protruding into the last  $\frac{3}{8}$ " [10mm] opening ②. Move the combined assembly to the right until the left side of the opening touches the block ③. Taking care to not move the template assembly...

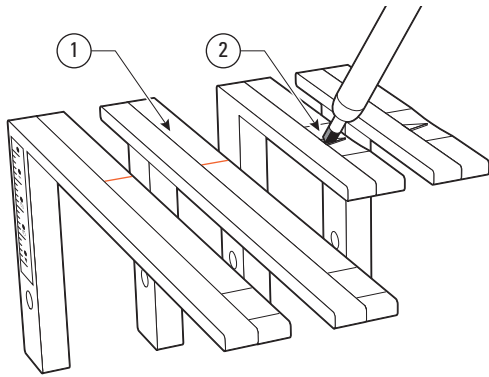


**1-5** ...pull up on the template bar ① while pushing down on the scale ② to ensure the bar is touching the two registration pads ③ inside the scale. Maintain pressure and tighten the scale lock-screw ④. Repeat at the other end. Remove the block and your template is ready to use. To maintain correct template alignment, follow this procedure whenever you remove the scales from the finger assembly.

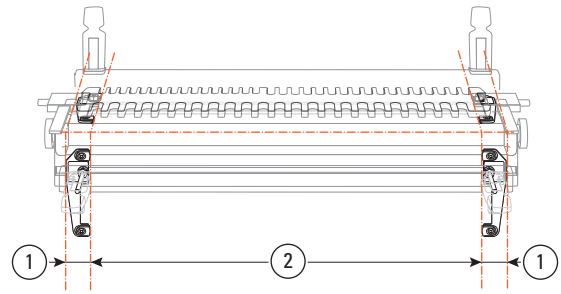


### 1-6 Mounting F3/F3M to D-Series Jigs

Procedure is the same for Inch and Metric 24" templates. Make sure your jig is mounted as per its User Guide, and the spacer board is clamped into position.



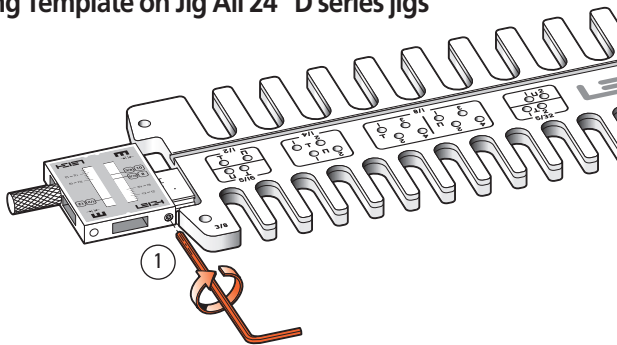
**1-7 D1258, D1258R and D3 jig owners:** If you already own the Leigh Mortise and Tenon Attachment, fit its extended support brackets ① and use for all finger joint and dovetail procedures. If not, mark the arrow pointers on the standard support brackets ② with a dark felt pen. Some D4 and D4R Jig owners already have extended brackets. Late model D4R brackets are shorter.



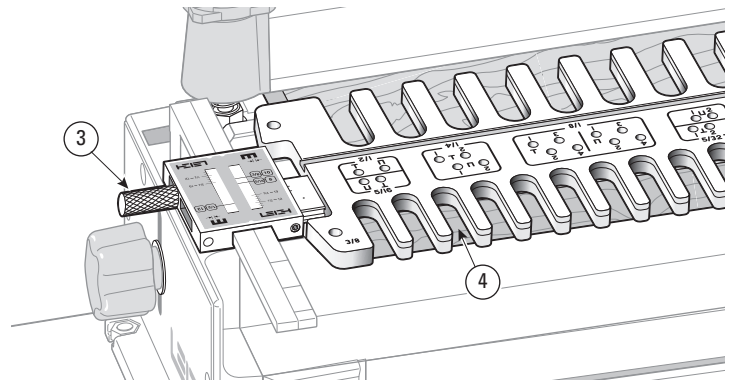
**1-8** Before installing the F3/F3M on any 24" D series jig with adjustable side stops, set and index the stops **according to the jig's user guide**. Are the stops 1½" [38mm] in from each end of the jig body extrusion ① and 24¼" [613mm] apart ②? If not, do it now.

*D4R jigs have fixed side stops.*

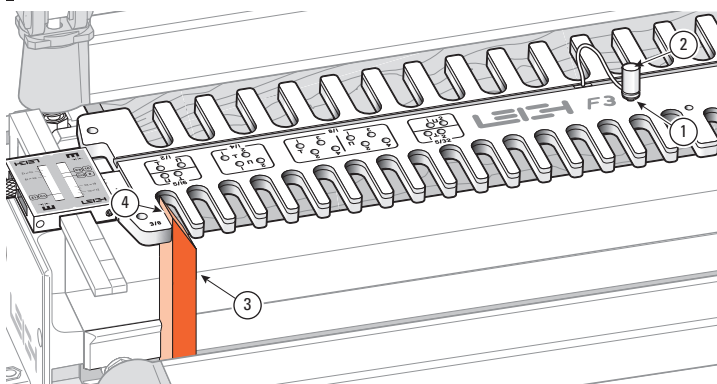
**Centering Template on Jig All 24" D series jigs**



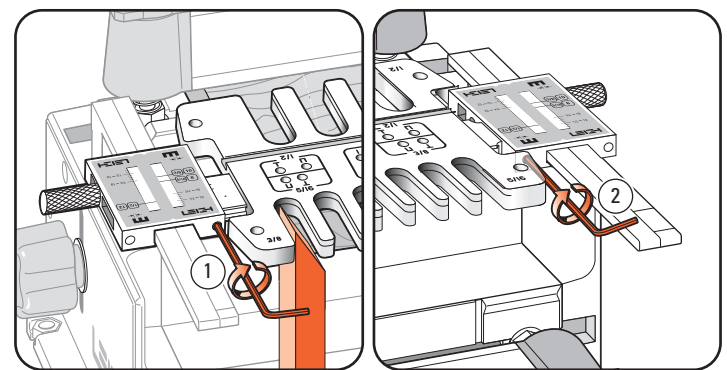
**1-9** Loosen the scale bar set screw ①, at each end of the template.



**1-10** Slide the template assembly onto the jig support brackets with the ⅜" & ⅝" [10 & 8 mm] combs toward you and lower it gently onto the jig's spacer board ④. Make sure the scale reading is the same on both scales, then tighten the thumb screws ③.



**1-11 Centering the F3** Align the template so that its centre hole ① aligns with the hole in the bar. Insert the template pin ② with a gentle twist to seat it. Angle trim the end of a straight block; clamp tight against the left stop and into the first opening ③. Move the combined assembly so the left side of the opening touches the block ④. Taking care to not move the template assembly...



**1-12** ...tighten both scale set screws ① and ②. Remove the block and your Leigh F3 is ready to use. ■

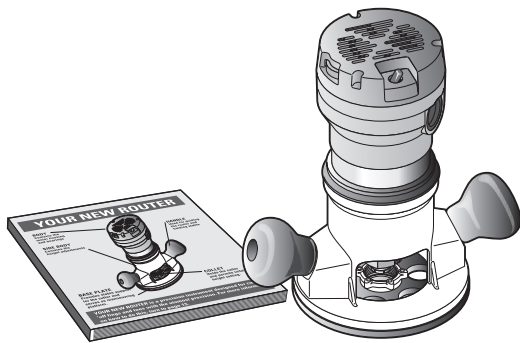


## CHAPTER 2

## Using Your Template Safely

**Safety is not optional.**

Read and follow the recommendations in this chapter.




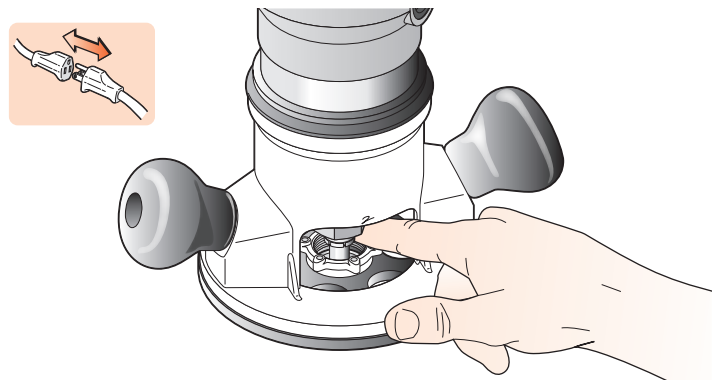
**2-1** Read the owner's manual that came with your router. It is essential to understand the router manufacturer's instructions completely.



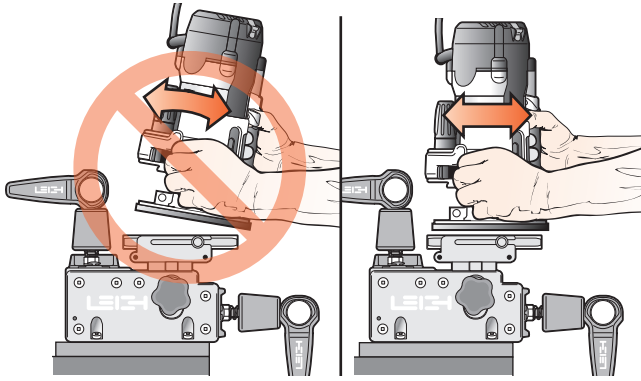
**2-2** Always wear approved safety glasses. Protect yourself from harmful dust with a face mask. Always wear hearing protection. For complete comfort and convenience, get yourself a Leigh VRS (Vacuum Router Support) to match your jig model.



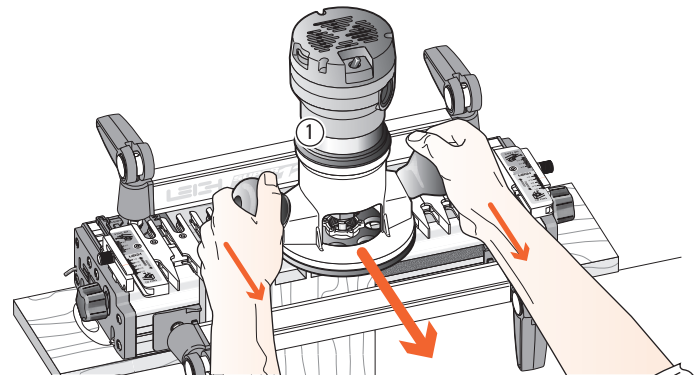
**2-3**  Never drink alcohol or take medications that may cause drowsiness when you will be operating a router.



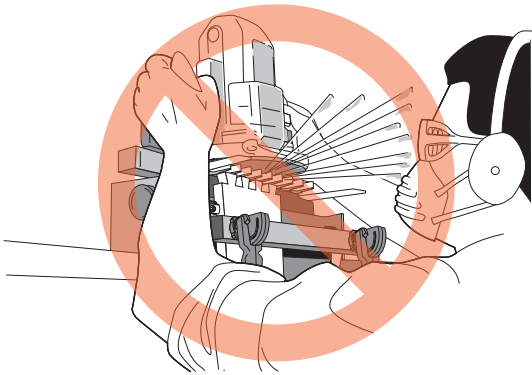
**2-4** Always disconnect the power source from the router when fitting bits or guidebushes, or making adjustments. Before connecting the router to the power source, make sure the bit and collet revolve freely in all the areas you plan to rout, and the bit does not touch the guidebush or jig.



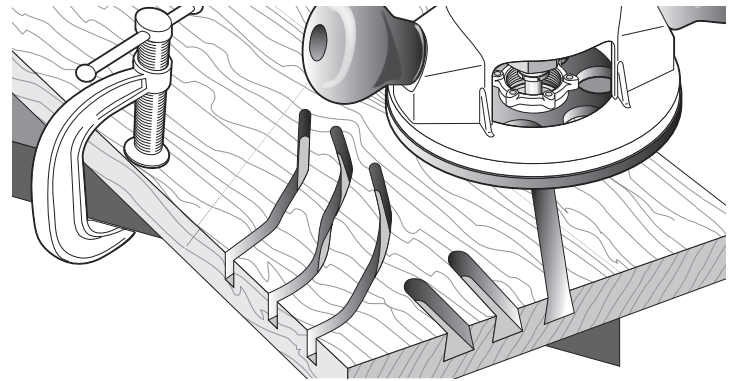
**2-5** Do not tilt the router on the jig.  
Keep the router flat on the jig assembly.  
*Note: The optional Leigh VRS attachment prevents router tilting.*



**2-6** If you insist on removing the router from the jig while it is still revolving, always pull it straight off the jig horizontally, and do not raise or lower the router until it is completely clear of the jig.



**2-7** Do not rout at face level.



**2-8** If you have never used your router before, be sure to follow the router manufacturer's instructions for its use. Make plenty of simple open-face practice cuts *without a guidebush* before you try to use the router on the Leigh jig. You must, of course, always use a guidebush when routing on the Leigh Jig. ■