

ISOLOC - Appendix I

# VGS Guidebush and Bit Selection

## VGS: The Leigh Variable Guidebush System

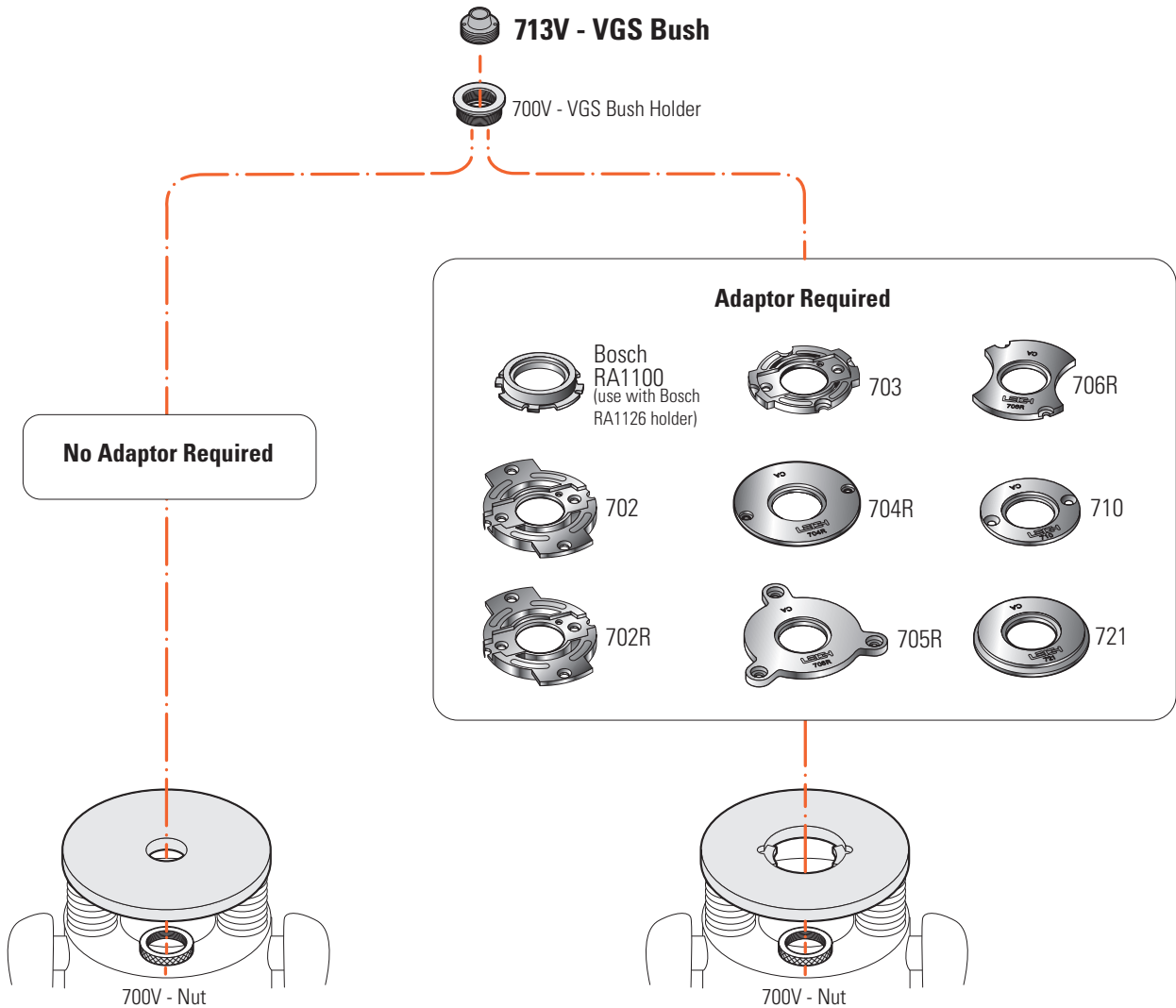
The 5-piece VGS comes with Isoloc Joint Templates, but you may need an adaptor for your router (see the next two pages for adaptor selection).



Do not use the VGS on D-series jig's dovetail fingers or the M2 as the tapered VGS bushes will not index properly on the guide fingers and guide rails.

### The Vital Link Between Your Router and Leigh Isoloc Joint Templates

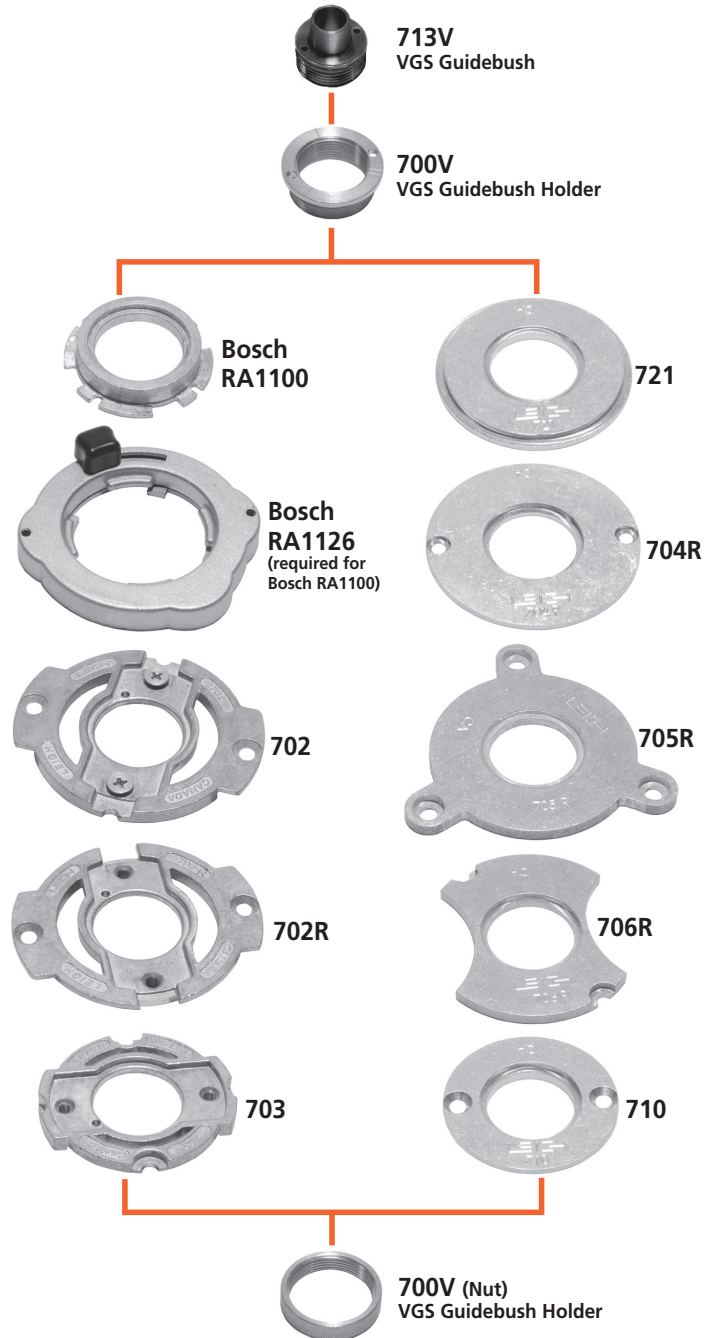
Because there is little or no standardization in the router industry, Leigh has developed a comprehensive guidebush and adaptor system to match your router to Leigh jigs and attachments. The diagram below shows how the VGS parts relate to each other and how they adapt to a router. **There are many adaptor-to-router mounting options. See the complete selection of guide bushing adaptors on the next page.** For a list of routers see the VGS Guidebush Adaptor Selection chart on page 47.



**NOTE: Do not use this diagram for part selection. See following pages.**

The Leigh VGS guidebush/holder 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 VGS bush. In addition Leigh offers the nine adaptors below to allow the use of over one hundred other router models, new and old. For a complete list of routers, see the VGS Guidebush Adaptor Selection chart on the opposite page.

### VGS Guidebush Adaptors



## VGS Guidebush Adaptor Selection

In order to fit your Leigh VGS holder to your router, you may need an adaptor. Find out in the chart below.

See [www.leighjigs.com](http://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](http://leighjigs.com) for a complete, up-to-date list of routers.

**C.** Locate adaptor required for your router in Column 3.

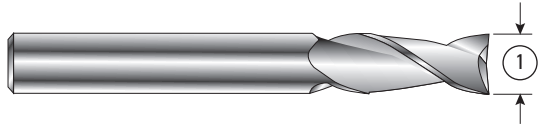
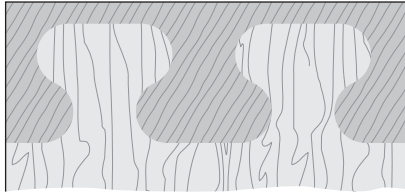
- Order Leigh adaptors (part no's in red) in Column 3 from Leigh.
- Order Bosch adaptors RA1100 and RA1126 in Column 3 from Leigh or your Bosch dealer.
- Order all other adaptors in Column 3 from the router manufacturer's dealer.

**Note:** Adaptor mounting screws are included with router.

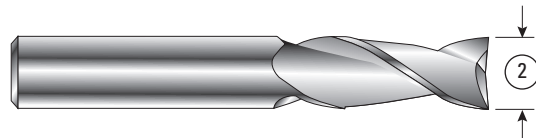
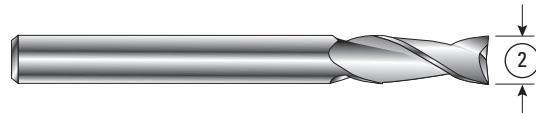
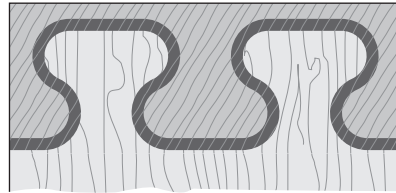
■ MAFELL – Rework adaptor slightly.

1 ROUTER MAKER	2 ROUTER MODEL	3 ROUTER ADAPTOR
AEG	OFE 710 in plunge base	Not Required
	OFSE 2000	703
	RT1350E	706R
BLACK & DECKER	All Professional, HD1250, RP400K,7614	Not Required
	6200	720673-00
	SR100, 7AEE, KW780 series, KW 800, KW850	710
BOSCH	1600, 90085, 90088, 90098, 90140, 90150, 90300, 90303, 90305, 91264	Aftermarket base plate required
	1601, 1602, 1603, 1604, 1606, B1350	RA1110
	North American ROUTERS PRODUCED AFTER mid-2010: 1613EVS, 1613AEVS, 1617, 1617EVS, 1618, 1618EVS, 1619EVS, MR23EVS, MRC23EVS, MRF23EVS, MRP23EVS	RA1126 quick change adaptor and RA1100 bushing adaptor required
	North American ROUTERS PRODUCED BEFORE mid-2010 and others available worldwide that include the RA1126 adaptor: 1613, 1613EVS, 1613AEVS, 1614, 1614EVS, 1617EVS, 1618EVS, 1619EVS, B1450, GOF900, GOF900CE, GOF900ACE, GOF1200, GOF1300CE, GOF1300ACE, GOF1600CE, GOF2000CE, GMF1400, GMF1600CE, POF800ACE, POF1100AE, POF1200AE, POF1400ACE	RA1100
	1611, 1611EVS, 1615, 1615EVS, B1550, GOF1600, GOF1700ACE	702
CRAFTSMAN (SEARS)	All non-plunge models	Aftermarket base plate required
	135275070 Plunge	See Skil 1823 or 1835
	Other plunge models	702
	MD11 Plunge & Fixed Base, MD9.5 Fixed Base	Not Required
DEWALT	DW610, DW616, DW618	Not Required
	DW613, DW615(UK)	710
	DW614, DW615, DW621, DW624, DW625, DW626	N. America Only, Supplied w/router
	DW621K & DW626 outside N. America	706R
	DW625 Type 1,2,3,5 outside N. America	702
	DW624 & DW625 Type 4 outside N.America, DW625EK	702R
ELU	OF15, OF15E, OF97, OF97E	706R
	MOF68, MOF69, MOF96, MOF96E	710
	MOF131, MOF177 Type 1, 2, & 3	702
	MOF177 Type 4, MOF177EK	702R
	2720, 2721, 3328	Not Required
	3303, 3304	E09600 or 761 270-00
	3337, 3338, 3339	702
FEIN	RT1800	Supplied w/router
FESTOOL	OF1E , OF2E , OF650 , OF900E , OF1000 , OF1010E	704R
	OF2000, OF2000E	705R
	OF1400 and OF2200 North America Only	Supplied w/router
	OF1400 Outside North America	493566
	OF2200 Outside North America	494627 O-Ring may be required to keep bushing centered
FREUD	FT700(2), FT2000, FT2200, FT3000	721
HITACHI	TR8, TR12, FM8, M8, M12 Series	325211 OR 703
	M12VC, KM12SC, KM12VC	Not Required
	M12SA2, M12V2	325224
MAFELL	LO65E	702 ■
MAKITA	M363, MRP090, RP1800, RP1801, RP2301, RP2301FC, 3612C Europe Qk Fit Base	721
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N.America, 3620, 3621, RP0900, RP900K	703
	3601B	321 493-1
	RP0910, RP1110C	706R
	RF1100, RF1101, RD1100, RD1101, RP1101	Not Required
MASTERCRAFT	Please contact Leigh for assistance	
METABO	OF1612, OFE1812 (for all others, please contact Leigh for assistance)	704R
MILWAUKEE	5615, 5616, 5619	49-54-1040
	5625	49-54-1026
	5670	Not Required
PERLES	OF808 Series, OFE6990	710
PORTER CABLE (ROCKWELL)	All	Not Required or Supplied w/router
RIDGID	R2930 (for all others, please contact Leigh for assistance)	704R
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703
	R600, R601, RE600, RE601	702
	R160, R161, R162, R163K, R165, R170, R175, RE175, R180, R180PL, R181, R185, ERT1150	706R
SKIL	1823 or 1835	91803
	SK1810, 1815, 1820, 1825	RAS140
	All others	Aftermarket base plate required
TREND	T3, T4, T5, T9, T10, T11—UniBase required	710
TRITON	TRC001	TGA006 or 704R
	JOF001, MOF001, TRA001	Accessory Kit (includes adaptor) TGA001 or TGA150
WEGOMA	OF850 Series	710

## ISOLOC JOINT BIT SELECTION

**Plain Joints: Half-Blind or Through**

For plain joints without inlay, use only a single straight bit; either Leigh No.170 or 170C,  $\frac{5}{16}$ " diameter or 8mm diameter ①. The 0.0025" [0.0635mm] diameter difference is easily "adjusted out" with the Leigh VGS.

**Inlaid Joints**

Inlay joints require two straight bits ②: For  $\frac{1}{16}$ " wide inlays, use:  $\frac{1}{4}$ " diameter (Leigh 168 or 168C), and  $\frac{3}{8}$ " diameter (Leigh 173 or 173C).

For 2mm wide inlays use 6mm and 10mm diameter.

*Note: For narrower inlays of  $\frac{1}{32}$ " or 1mm, see Step 8-15.*

## ISOLOC - Appendix II

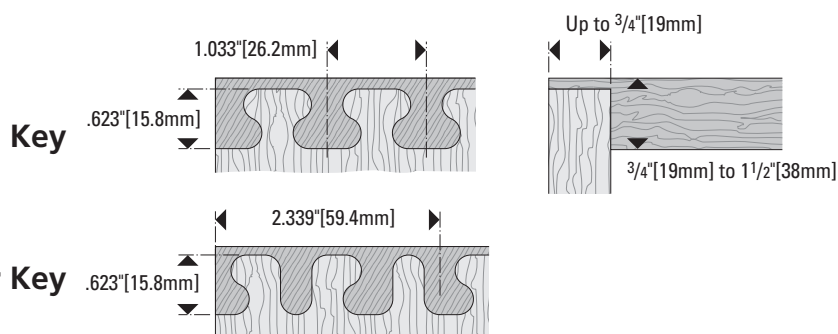
# Joint Specifications

### Isoloc Joint Specifications

These drawings show the precise Isoloc joint specifications. Pin boards may be up to 1½" [38mm] thick on the 24" D type jig, and 1" thick on the D1600 and Superjigs. Socket boards have a maximum practical thickness of ¾" to 1", depending on wood species. Routing thicker socket boards with a ⅝" [8mm] bit is not practical, even using progressive depth routing. For maximum board widths, see Chapter 5.

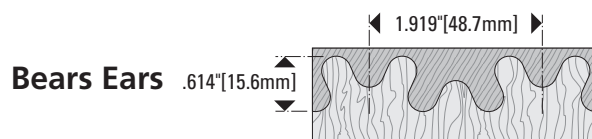
Inlay strips are generally ⅛" or 2mm thick, but it's easy to achieve ⅜" or 1mm (see 8-15).

**I1A**  
**I1600A**  
**I24A**



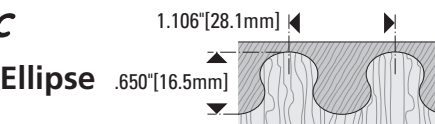
**I1B**  
**I1600B**  
**I18B**  
**I24B**

**Clover**

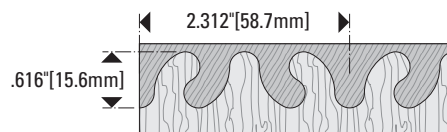


**I1C**  
**I1600C**

**Ellipse**



**Wave**



## Isoloc Joint Identification and Design Reference

	PLAIN JOINT (actual size)	INLAY			
		1/16"	1/32"	2mm	1mm
<b>I1A</b> <b>I1600A</b> <b>I24A</b>  Key					
Mirror Key					
<b>I1B</b> <b>I1600B</b> <b>I18B</b> <b>I24B</b>  Clover					
Bears Ears					
<b>I1C</b> <b>I1600C</b>  Ellipse					
Wave					

Inlay strips are generally 1/16" or 2mm thick, but it's easy to achieve 1/32" or 1mm (see 8-15).

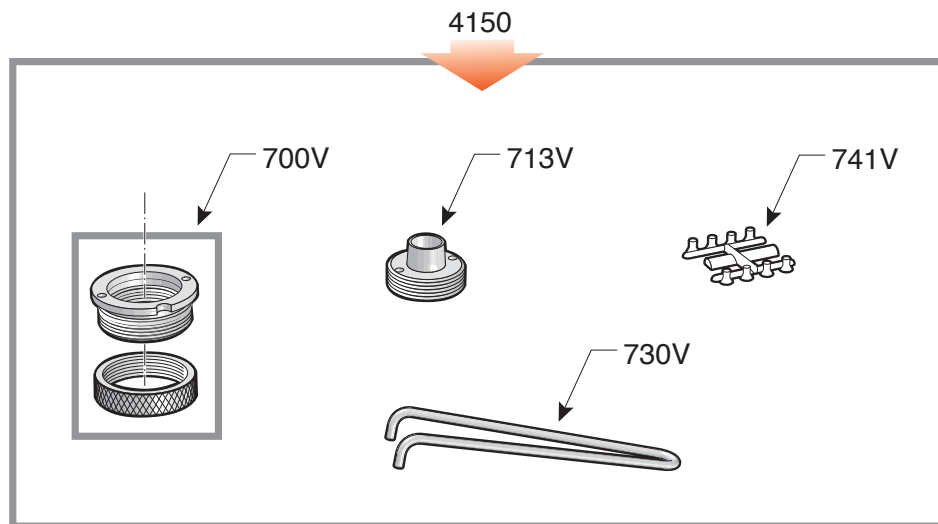
## ISOLOC - Appendix III

# Template Parts List

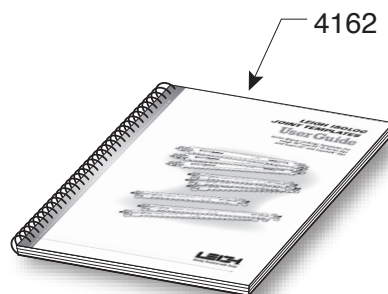
### Parts List for VGS Package supplied with all Isoloc Templates

When ordering parts, please quote the number (A, or B, or C) that matches your template; its serial number, the part numbers required, and part descriptions.

PART NO.		PART DESCRIPTION
4150	1	Isoloc VGS Set - Complete
700V	1	VGS Holder (2 pieces)
713V	1	VGS Bush
730V	1	Pin Wrench for VGS
741V	1	6 Nylon Thread Inserts for VGS (on tree)



PART NO.		PART DESCRIPTION
4162	1	Isoloc User Guide (for all Isoloc models)



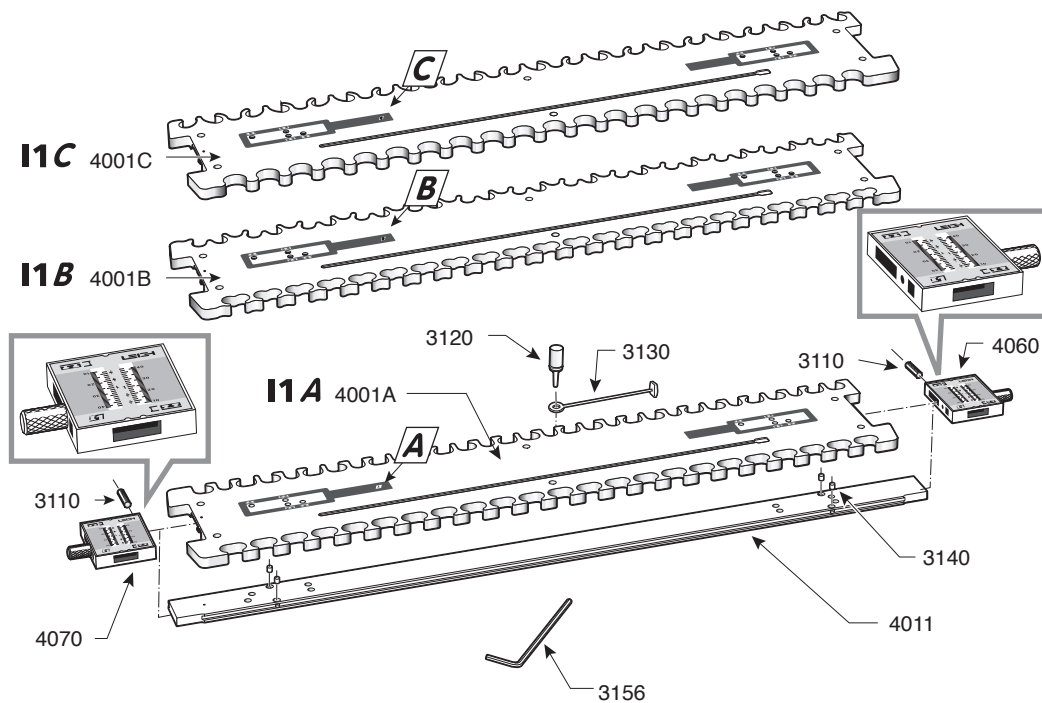
### Parts List for I1 24" Isoloc Templates

When ordering parts, please quote the number (A, B, or C) that matches your template; its serial number, the part numbers required, and part descriptions.

PART NO.	TEMPLATE DESCRIPTION
4001A	Key & Mirror Key Template "A"
4001B	Clover & Bears Ears Template "B"
4001C	Ellipse & Wave Template "C"

### I1 Parts and Sub-Assemblies:

PART NO.	QUANTITY PER TEMPLATE	PART DESCRIPTION
3110	2	Scale Bar Set Screws
3120	1	Template Pin
3130	1	Template Pin Tie
3140	4	Template Bar Glides (installed in Template Bar)
3156	1	Allen Wrench for Scale Set Screws
4011	1	Template Bar (complete with four glides)
4060	1	RH Scale Assembly (RH with 3110 screws away from you)
4070	1	LH Scale Assembly (LH with 3110 screws away from you)



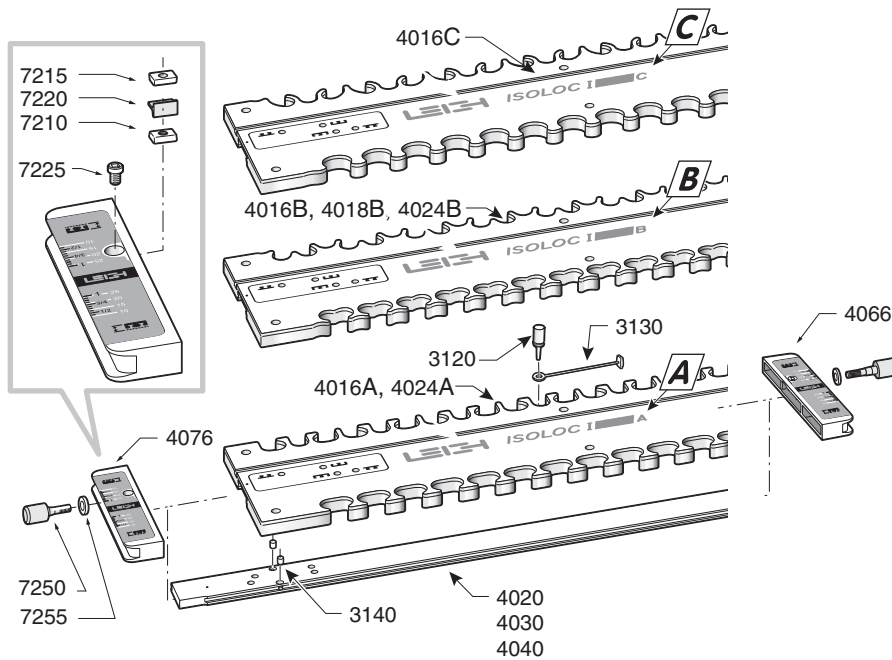


### I1600, I18, I24 Isoloc Templates

When ordering parts, please quote the number and letter (A, B, or C) of your template; its serial number, the part numbers required, and part descriptions.

PART NO.	TEMPLATE DESCRIPTION	PART NO.	TEMPLATE DESCRIPTION
4016A	Key & Mirror Key Template "A"	4018B	Clover & Bears Ears Template "B"
4016B	Clover & Bears Ears Template "B"	4024A	Key & Mirror Key Template "A"
4016C	Ellipse & Wave Template "C"	4024B	Clover & Bears Ears Template "B"

PART NO.	QUANTITY PER TEMPLATE	PART DESCRIPTION
4020	1	16" Template Bar complete with four glides
4030	1	18" Template Bar complete with four glides
4040	1	24" Template Bar complete with four glides
4066	1	RH Scale Assembly
7250	2	Scale Thumb Screws
7255	2	Nylon Washers
4076	1	LH Scale Assembly
3110	2	Scale Bar Set Screws
3120	1	Template Pin
3130	1	Template Pin Tie
3140	4	Template Bar Glides (installed in Template Bar)





## 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

#### TEL/FAX

**Customer Service and Technical Support**  
800-663-8932 (Canada/USA)  
604-464-2700 (Tel.)  
604-464-7404 (Fax.)

#### EMAIL/WEB

**Customer Service**  
leigh@leighjigs.com  
**Technical Support**  
help@leighjigs.com  
**Website**  
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 N. America) or to your national distributor. –**Thanks!**

#### MAILING ADDRESS

Leigh Industries Ltd.  
P.O. Box 357  
Port Coquitlam, B.C.  
Canada V3C 4K6

#### LOCATION

Leigh Industries Ltd.  
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Port Coquitlam, B.C.  
Canada V3C 6M9

### Distributors

#### AUSTRALIA & NEW ZEALAND

Carba-Tec Pty. Ltd.  
128 Ingleston Rd., Wakerley, Qld., 4154  
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Tel: (07) 3390 5888  
Fax: (07) 3890 5280  
Order: 180 658 111  
Email: orders@carbatec.com.au  
Web: www.carbatec.com.au

#### CHINA

Harvey Industries Co., Ltd.  
68-10 Suyuan Avenue  
Jiangning District Nanjing 211100, China  
Tel: (0)86 5792 8869 / 5792 8021  
Fax: (0)86 5792 8826  
Email: caozhi@harvey.cn  
Website: www.harveyworks.cn

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Fax: 08031 68221  
Email: hacker.rosenheim@t-online.de  
Web: www.leigh.de

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Fax: 82 (0) 31-765-5602  
Email: smgi@paran.com  
Web: www.htools.co.kr

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