

## Box Joints

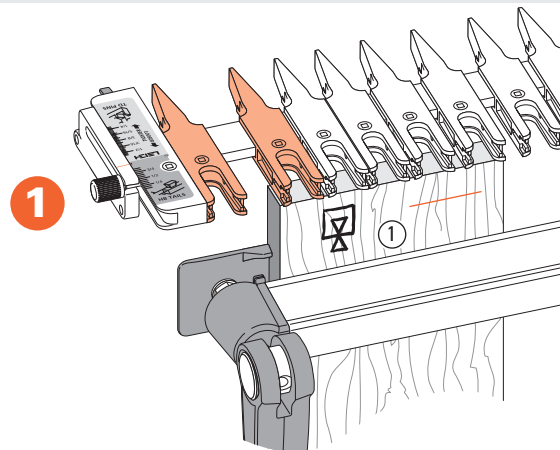
### Actual Joint Sizes

The Superjig finger assembly was originally designed solely for dovetailing. Adapting the assembly for box jointing was a serendipitous combination of luck (existing guides approximately the correct dimension) and clever design; the e7-Bush and Spacer.

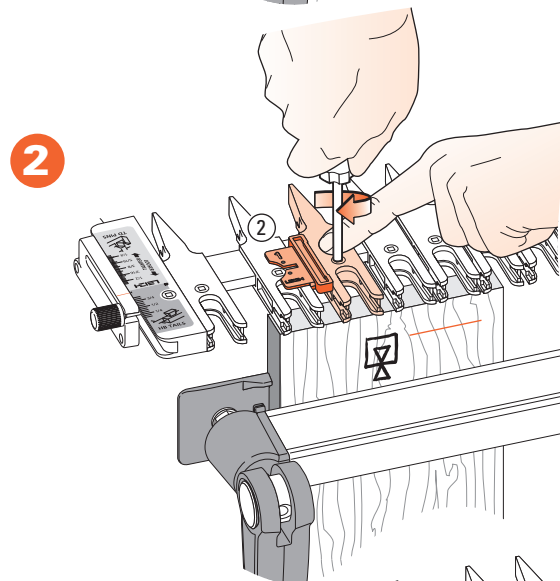
So the nominal  $\frac{5}{16}$ " and  $\frac{5}{8}$ " [8 and 16 mm] box joint sizes are actually  $\frac{21}{64}$ " and  $\frac{21}{32}$ " [8,3 and 16,7mm] respectively.

### Concept of Operation

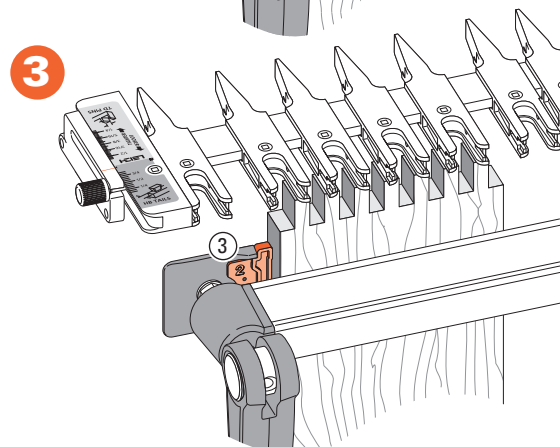
The first board is set against the side stop ①.



The Spacer is used to space the guide fingers ②.



The Spacer is also used on the side stop ③ to accurately offset mating work pieces for correct board to board joint alignment.



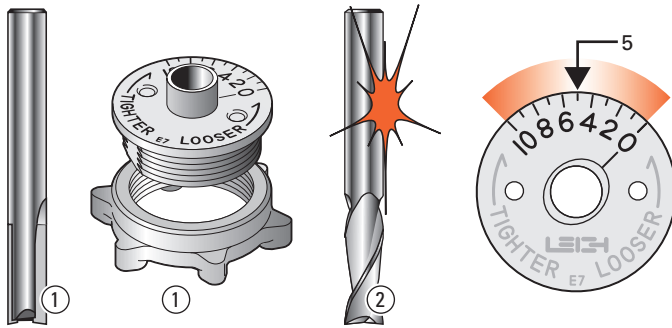
### Choose your Board Width:

Symmetrical joints: Use the red column

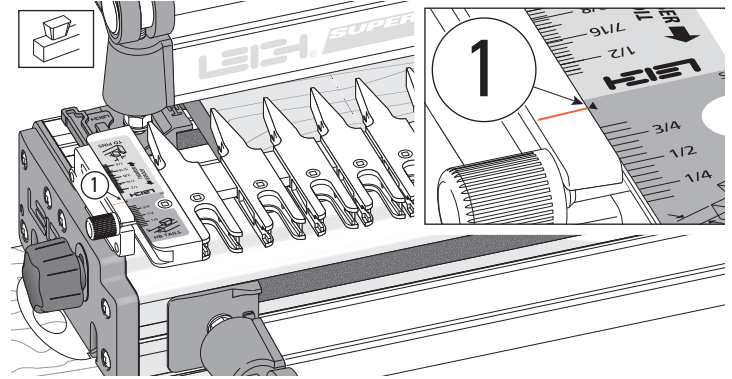
Asymmetrical joints: Use the grey column

Count the total sockets and pins in the first (white) column

Board Width - INCHES				Board Width - MILLIMETERS			
5/16"		5/8"		8mm		16mm	
Symmetrical	Asymmetrical	Symmetrical	Asymmetrical	Symmetrical	Asymmetrical	Symmetrical	Asymmetrical
1		1		1		1	
2		2		2		2	
3	29/32			3	23		
4		1 1/4		4		32	
5	1 9/16			5	40		
6		1 29/32		6		48	
7	2 7/32			7	56		48
8		2 9/16		8		65	
9	2 7/8		2 9/16	9	73		65
10		3 7/32		10		82	
11	3 17/32			11	90		
12		3 7/8		12		98	
13	4 3/16			13	106		
14		4 1/2		14		114	
15	4 27/32			15	123		
16		5 5/32		16		131	
17	5 1/2			17	140		
18		5 13/16		18		148	
19	6 5/32			19	156		
20		6 15/32		20		164	
21	6 13/16			21	173		
22		7 1/8		22		181	
23	7 15/32			23	190		
24		7 25/32		24		198	
25	8 1/8			25	206		
26		8 7/16		26		214	
27	8 25/32			27	223		
28		9 3/32		28		231	
29	9 13/32			29	239		
30		9 3/4		30		248	
31	10 1/16			31	256		
32		10 13/32		32		264	
33	10 23/32			33	272		
34		11 1/16		34		281	
35	11 3/8			35	289		
36		11 27/32		36		301	
37	12 5/32			37	309		
38		12 1/2		38		318	
39	12 13/16			39	325		
40		13 5/32		40		334	
41	13 15/32			41	342		
42		13 25/32		42		350	
43	14 1/8			43	359		
44		14 7/16		44		367	
45	14 25/32			45	375		
46		15 3/32		46		383	
47	15 7/16			47	392		
48		15 3/4		48		400	
49	16 3/32			49	409		
50		16 13/32		50		417	
51	16 3/4			51	425		
52		17 1/16		52		433	
53	17 13/32			53	442		
54		17 23/32		54		450	
55	18 1/16			55	459		
56		18 3/8		56		467	
57	18 11/16			57	475		
58		19 1/32		58		483	
59	19 11/32			59	491		
60		19 11/16		60		500	
61	20			61	508		
62		20 11/32		62		517	
63	20 21/32			63	525		
64		21		64		533	
65	21 5/16			65	541		

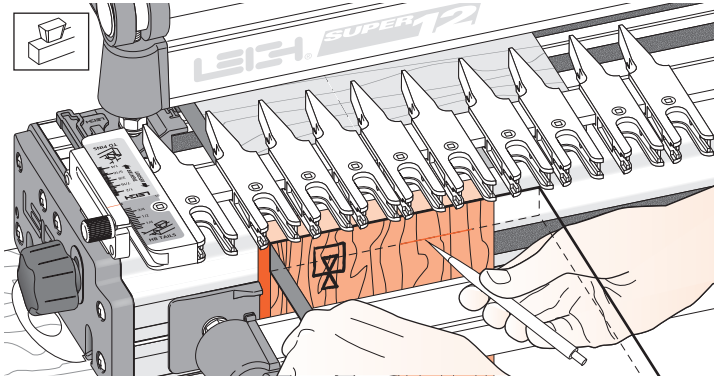


**14-1 Bit and Guidebush selection** Only the e7-Bush and  $\frac{5}{16}$ " bit that came with SUPERJIG ① are required for all SUPERJIG box joints. Note: Spiral upcut router bits ② will cut cleaner than straight flute. Where metric size bits are available an 8mm straight or spiral bit may be substituted for the  $\frac{5}{16}$ ". Always start test routing with the e7-Bush set on "5", the adjustment mid-range.

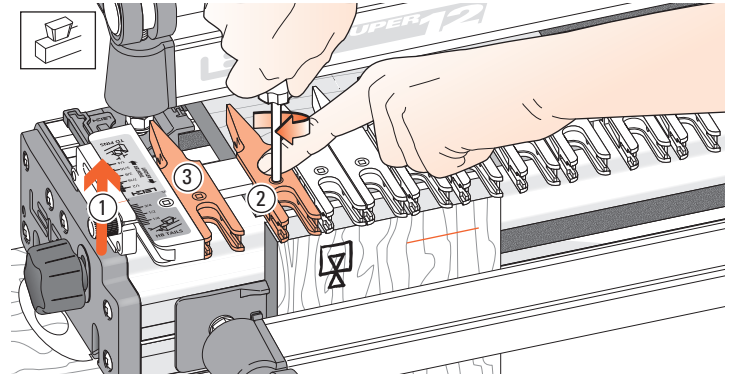


#### 14-2 $\frac{5}{16}$ " [8mm] Box Joints.

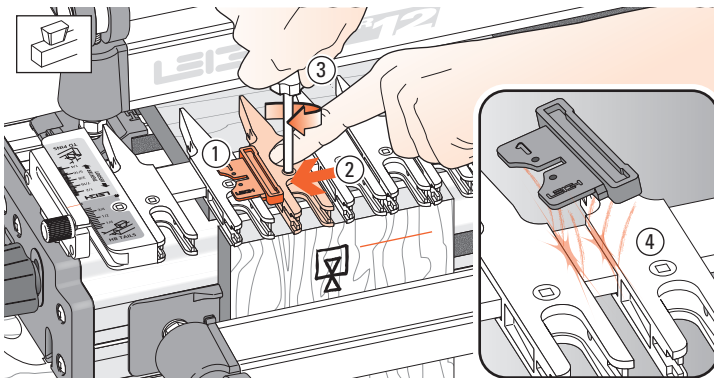
Place the finger assembly on the support brackets in the HB TAILS mode, set the scales on the **small triangular arrow** ① and lower the assembly onto the spacer board.



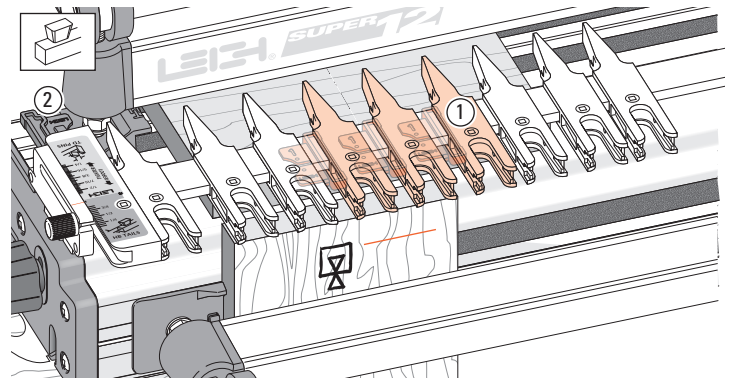
**14-3** Clamp a test board in the front left clamp, against the side stop with the top edge flush under the guidefingers. The board may be clamped face side in or out. Mark and adjust the depth of cut to suit the thickness of the mating boards ①.



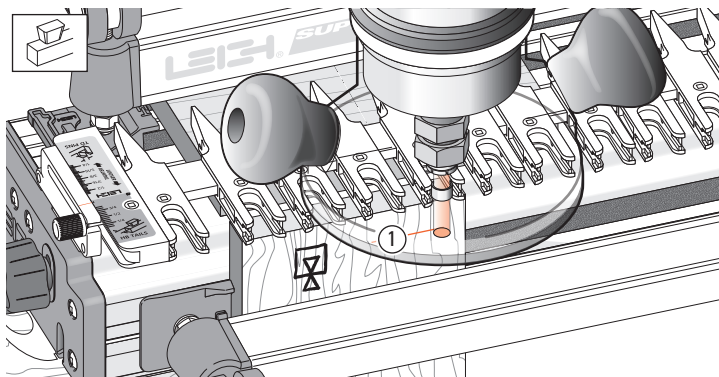
**14-4** Raise the finger assembly about  $\frac{1}{16}$ " [2mm] to allow ease of guide finger adjustment ①. Position the second guidefinger  $\frac{1}{32}$ " [1,0mm] in from the board edge ② and tighten the finger. The first finger stays against the scale block as a router support ③. *Note: Square ended boards are essential to achieve flush joint alignment.*



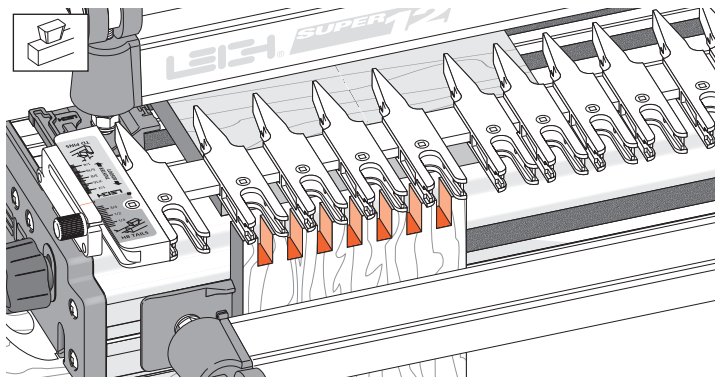
**14-5** Place the Spacer on the finger bar to the right of the second finger, numeral 1 on top overlapping the locked finger ①. Move the next finger in to touch the Spacer ②. Hold the guidefinger firmly against the Spacer and tighten the second finger screw ③. As you remove the Spacer you should feel some friction; this indicates that the guidefinger is correctly spaced ④.



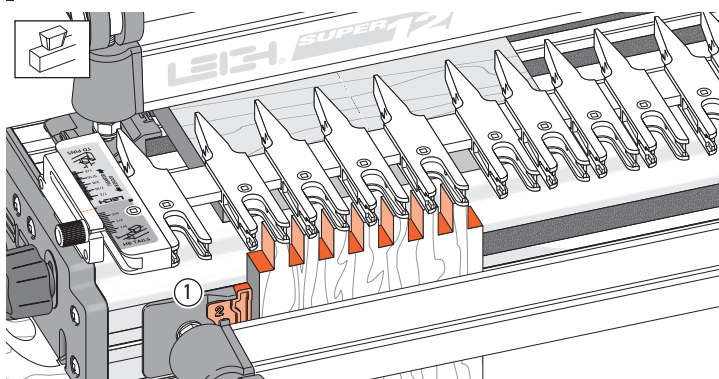
**14-6** Repeat this procedure across the jig until there is at least one guidefinger spaced past the right side of the work piece ①. Tighten the unused guides. Store the Spacer on the outside of a rear side stop ②.



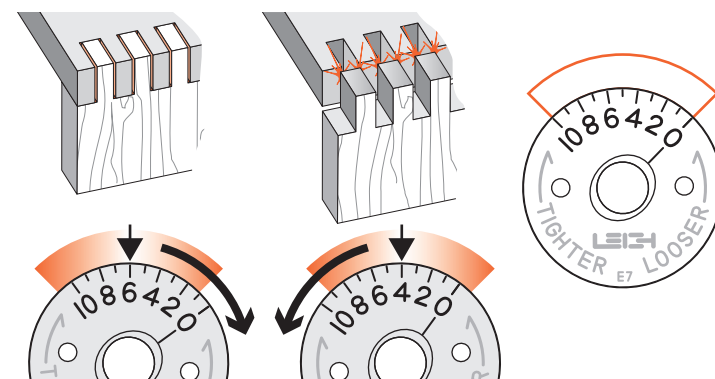
**14-7** Lower the finger assembly onto the spacer board and double-check that the bit depth is down to the center of the pencil line ①. Make sure the collet does not rub on the guidebush.



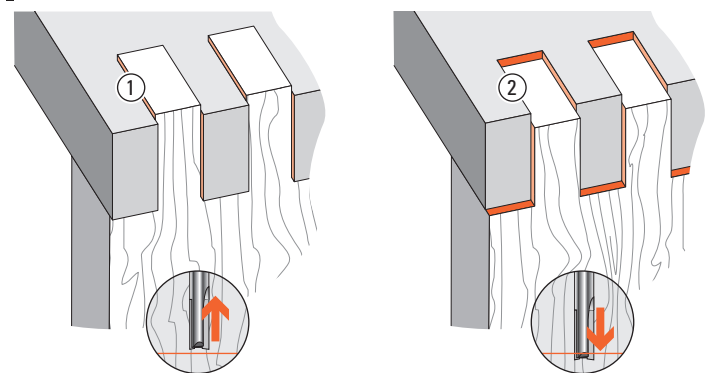
**14-8** Rout one end of the scrap board. Rout into each finger opening and between each finger. Make sure to run the guidebush on both sides of each opening.



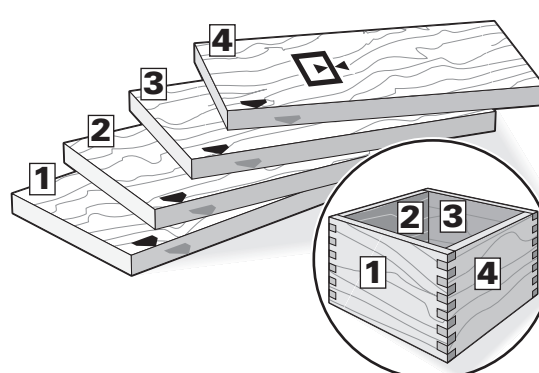
**14-9** Remove the board and fit the SPACER to the front side stop with the **number 2 showing** ①. Make sure it is fully home. Clamp the second test board with its side edge against the Spacer and its top edge touching the guidefingers. Rout this board.  
*Note: Square ended boards are essential to achieve flush joint alignment.*



**14-10** Test the two boards for fit and flushness. If the joint is loose, turn the e7-Bush to a higher number, say “6” and rout two more board ends. If the joint is too tight, turn the e7-Bush to a lower number, say “4”. Trial and error establish the best e7-Bush setting and record this in the space provided here, and/or on the pull-out. Next time this setting will get a good first-time result

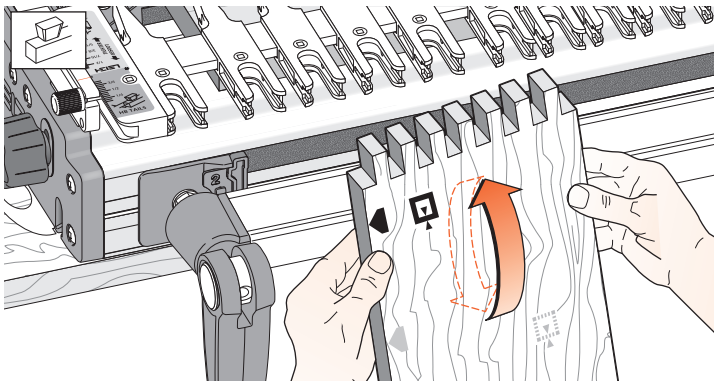


**14-11** If the joint is over-flush ①, raise the bit slightly. If it is under-flush ②, lower the bit.

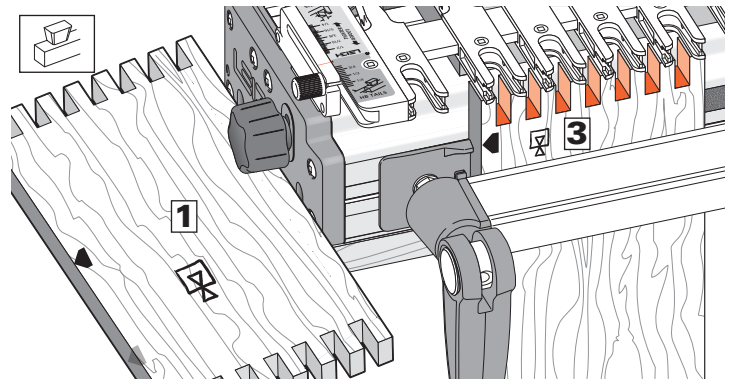


**14-12 Let's make a box.**

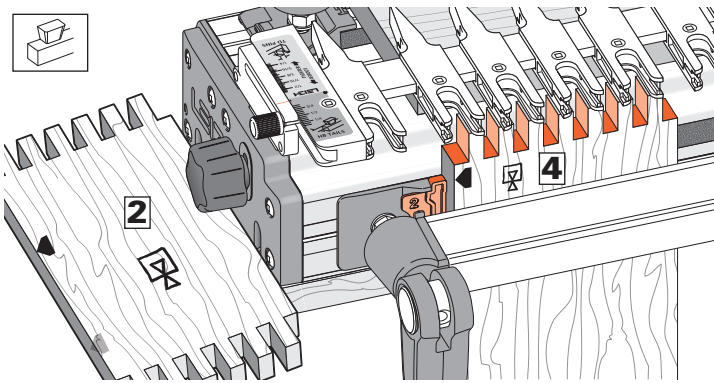
Prepare four boards and number them **1** to **4**. Then select the grain alignment and mark the common top (or bottom) edge. Don't worry about face side selection; this can be done after routing.



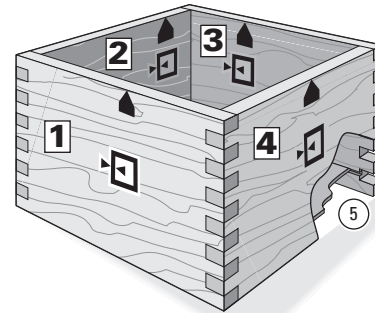
**14-13** All box joint boards are clamped alternating face side in and face side out [icon] always with the same side edge against the side stop (or Spacer).



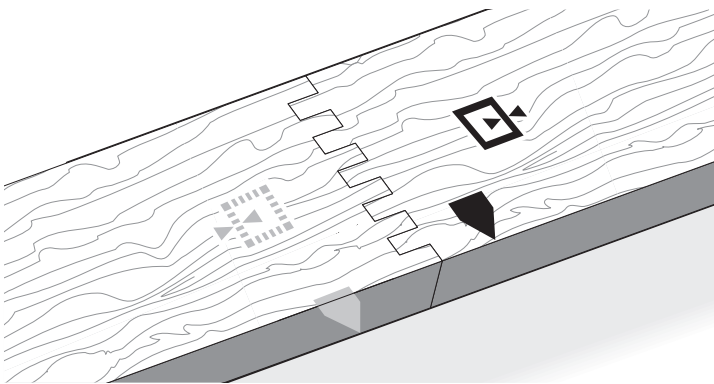
**14-14** Rout both ends of boards **1** and **3** with their edges against the side stop. Be sure to keep the same edge to the stop.



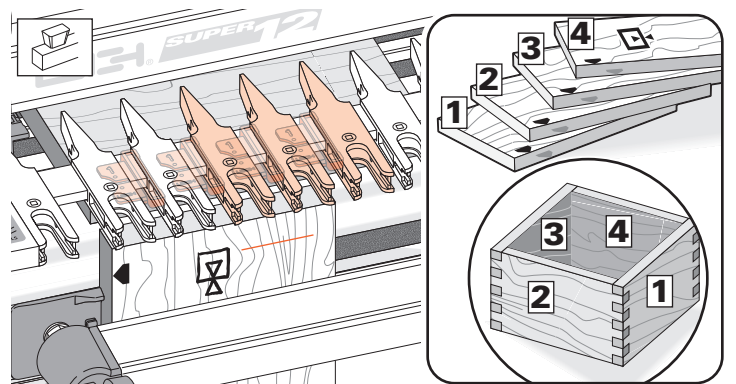
**14-15** Rout both ends of boards **2** and **4** with their edges against the Spacer and the Spacer in the No.2 position. Keep the same edges to the Spacer.



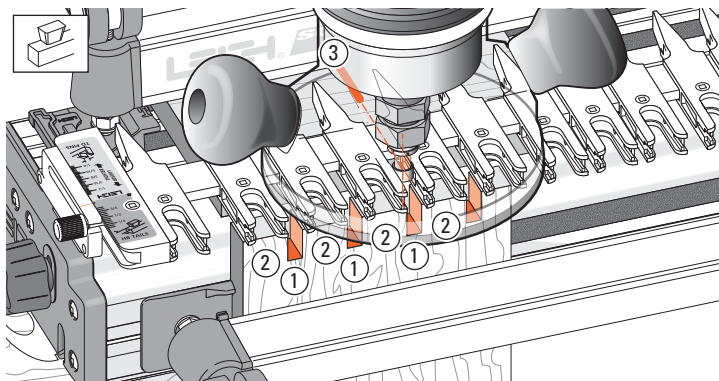
**14-16** Keeping the marked side stop edges of all boards toward the top (or all to the bottom) of the box, select the preferred outside faces before routing the grooves ⑤ for the bottom.



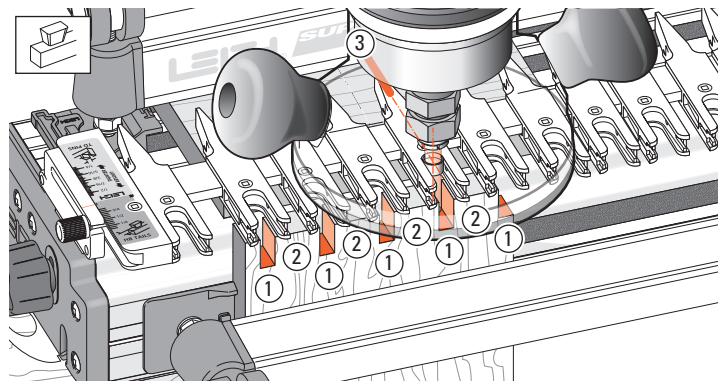
**14-17** The same method will produce end-on-end joints.



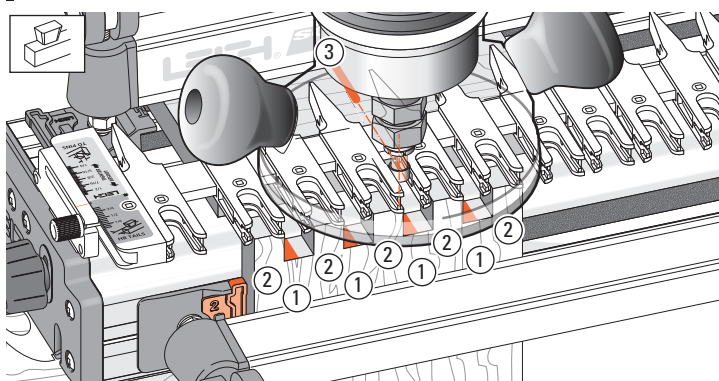
**14-18 5/8" [16mm] Box Joints** Set up and space the guide fingers exactly as for 5/16" [8mm] joints. Start with the same e7-Bush setting. See 14-4 thru 14-10. Prepare four boards using the board width chart for 5/8" [16mm] joints and number them **1** to **4** around the box ① with the common edges marked.



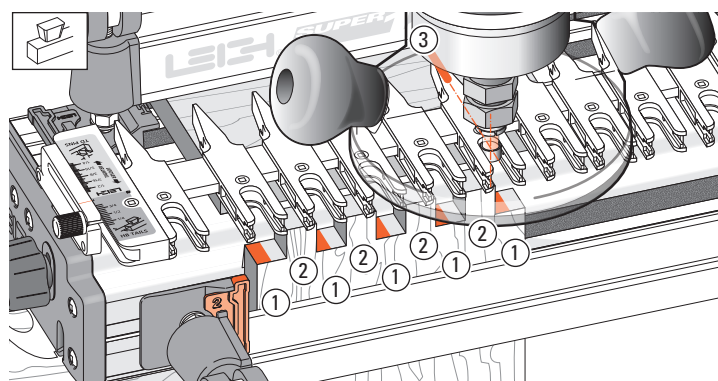
**14-19** Rout both ends of boards 1 and 3 but **only rout between the guide finger sides ① not between the finger openings ②**. Keep the common edge against the side stop  
*Hint:* Mark the router base at the 12 o'clock position ③ and steer this mark between the **pointed ends of the fingers at the rear of the assembly**.



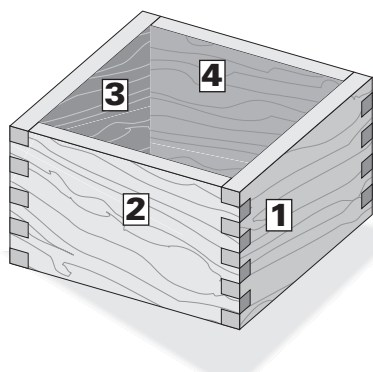
**14-20** Now rout both ends of boards 2 and 4, with the common edge against the side stop but **only rout between the finger openings ① not between the finger sides ②**.  
*Hint:* Now steer the base 12 o'clock mark **along the finger points ③**.



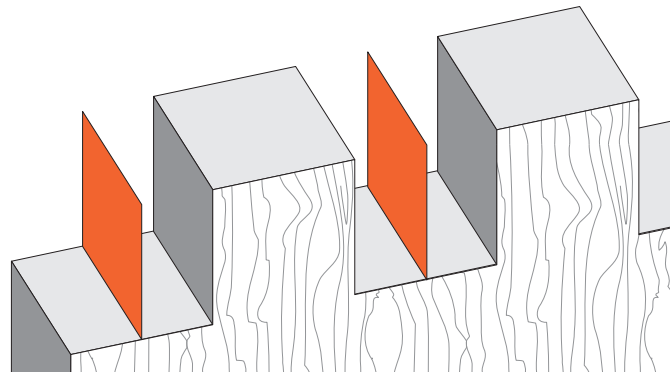
**14-21** Fit the Spacer to the side stop with number 2 showing. Now rout both ends of boards 1 and 3 again, with the common edge against the Spacer and **again ... only rout between the guide finger sides ①, not between the finger openings ②, steering the router mark between the finger points ③**.



**14-22** With the Spacer still in position rout both ends of boards 2 and 4, with the common edge against the Spacer and **again, only rout between the finger openings ①, steering the router mark along the finger points ③**.



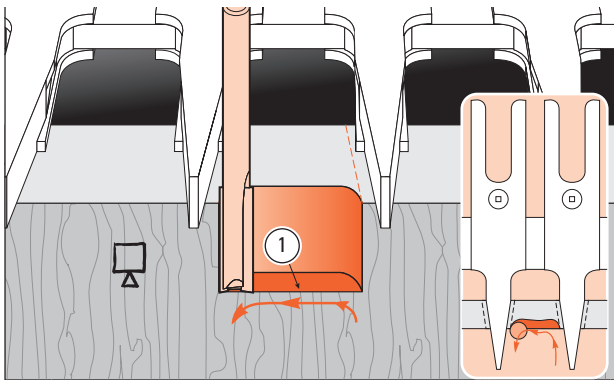
**14-23 Joint fit** Check for joint fit as usual, and repeat testing if required.



**14-24** Theoretically, there will be nothing in the  $\frac{5}{8}$ " [16mm] sockets, literally a zero thickness wall, where the bit has passed by twice. However, routing tolerances can leave a very thin "wall" uncleared by routing. This can be quickly removed with a chisel or sandpaper. ■

## Hints and Tips

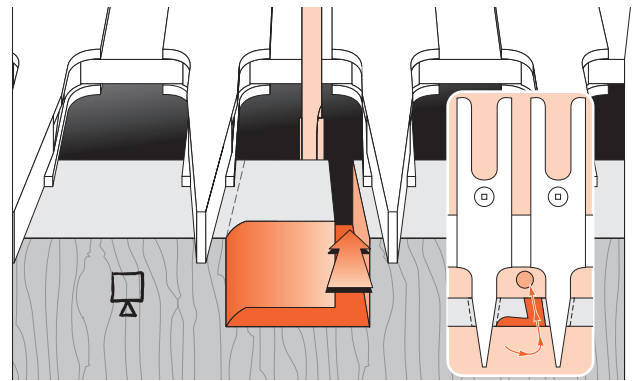
Here are some special techniques and ideas to help you get the most out of your Leigh Superjig.



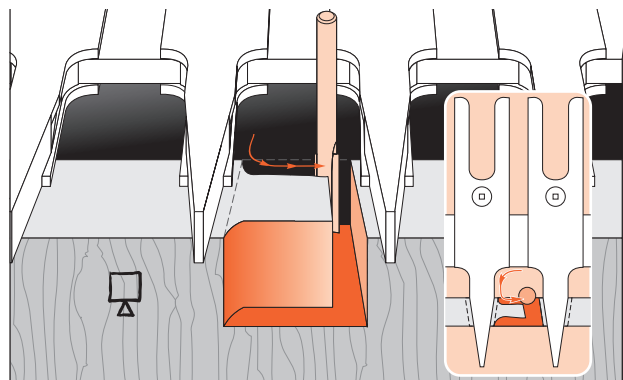
**15-1 Through Dovetail Pins** With the straight bit, carefully climb-rout from right to left. Make sure you control the router firmly when climb routing.

Climb routing produces a nice clean shoulder at ①.

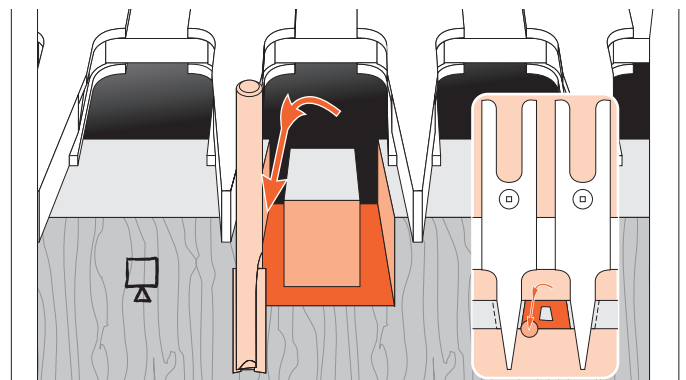
*Note: For clarity, the guidebush is not shown in this sequence.*



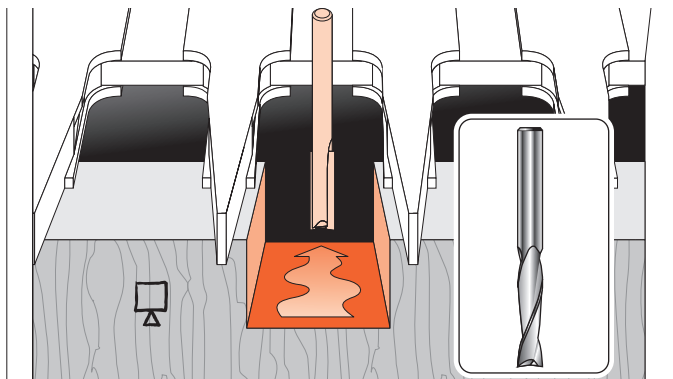
**15-2** ⚠️ Rout through on the right side until the bit is clear of the workpiece. Move the bit to the left side and climb cut left to right.



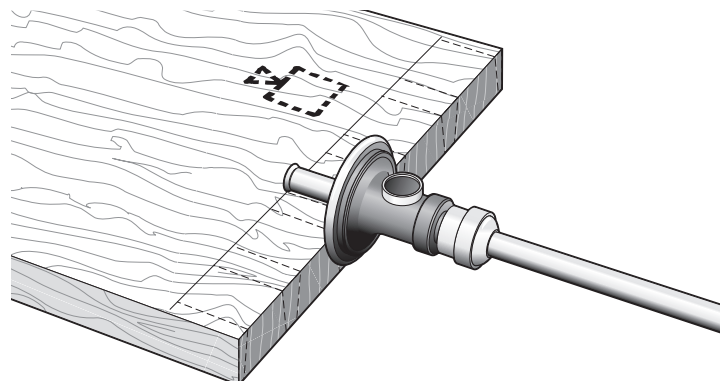
**15-3** Climb rout from left to right from the rear of the cut. Take care to control router.



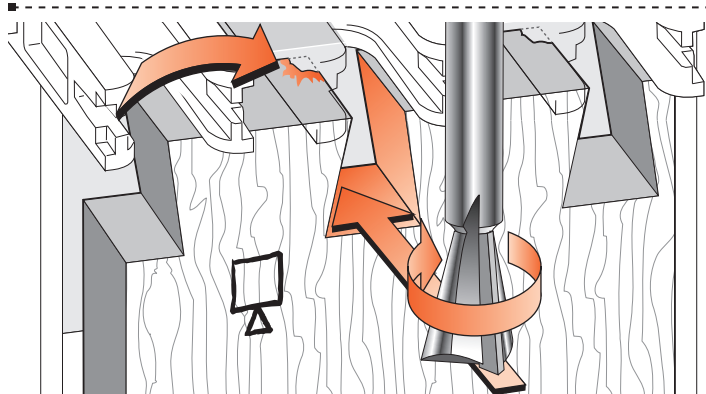
**15-4** ⚠️ Rout back through towards you on the left side.



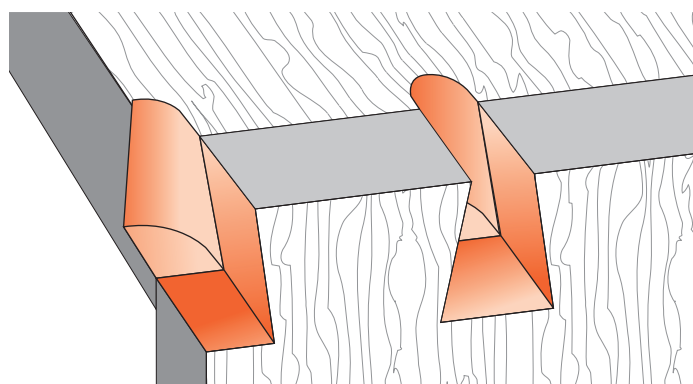
**15-5** Rout away the rest of the waste. **Note:** Spiral up-cut straight bits (inset) generally rout more smoothly than the two-flute carbide-tipped bits. If you want to try them, you should be aware that while the high-speed steel bits take a better edge, they are much less durable than the more costly solid carbide type (Leigh bits 170 HSS or 170C solid carbide).



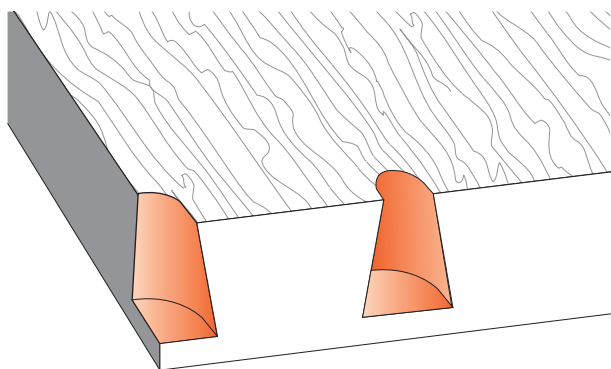
**15-6 Preventing TD Pins Tearout** To help prevent tearout at the back bottom part of a straight cut, scribe a line with your marking gauge across the back of the pin board at exactly the depth of cut.



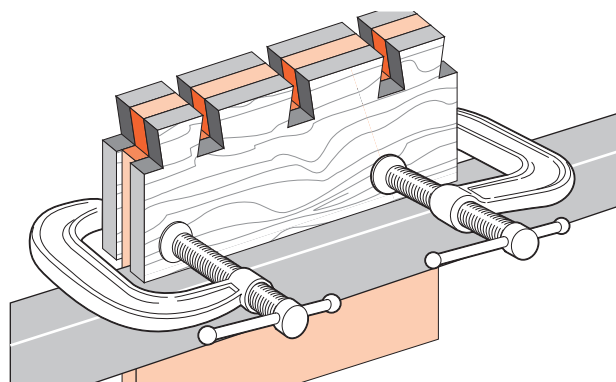
**15-7 Dovetail Tails Tearout** With the dovetail bit, most tearout occurs at the top left exit of the cut.



**15-8** To help prevent this, back up the cut with the end-grain of a horizontal board pushed against the back of the workpiece and held in the rear clamp. This board replaces the spacer board.

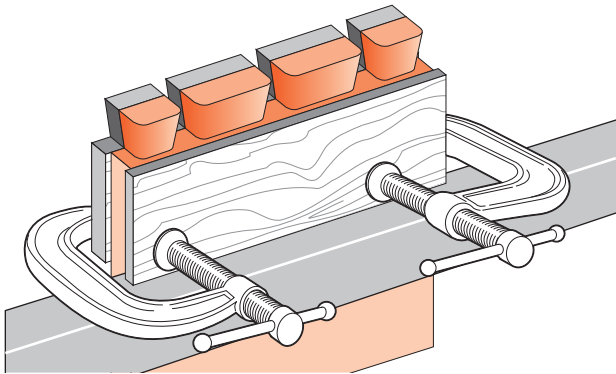


**15-9** This same scrap piece can remain in place for successive cuts.

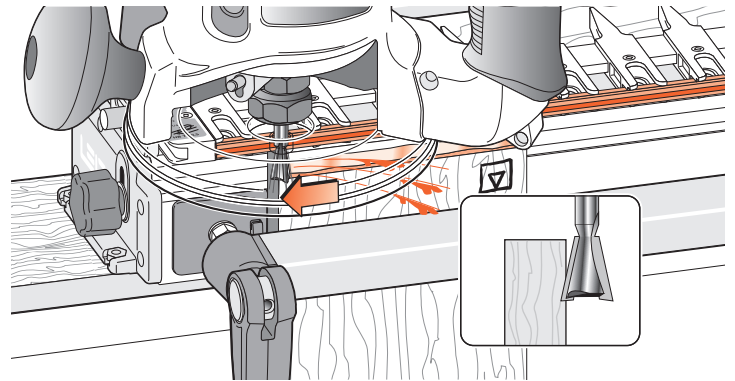


**15-10** For vulnerable or that last piece of exotic wood, clamp horizontal scrap pieces to the front and back of the work piece. **Make sure clamps are below the bit depth.**

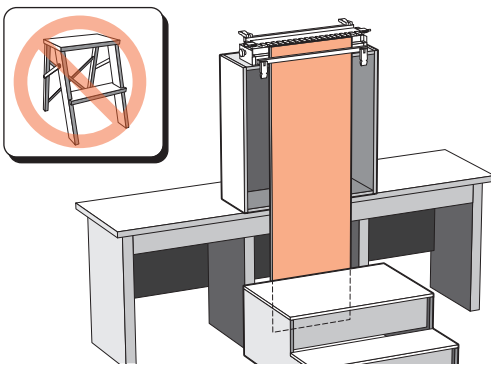
⚠️ **PLYWOOD** is not suitable for routing; the laminates are very prone to tearout. Either of these two procedures (15-10 or 15-11) are essential for plywood but provide no guarantee of success.



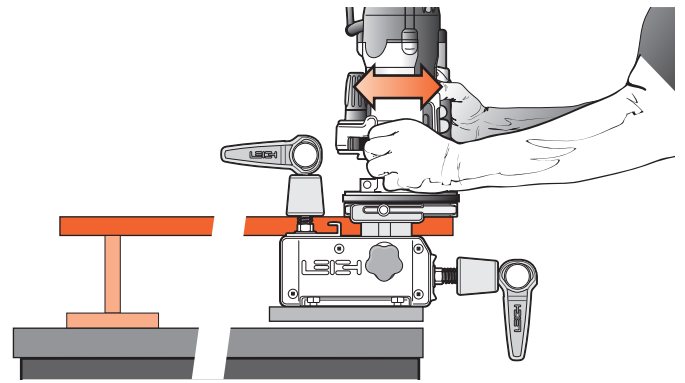
**15-11** A single scrap piece can be C-clamped on the back of half-blind tails, *but make sure you protect the workpiece from the clamp pads.* *Note:* There's no 100% solution to tearout. It's not the jig's fault, just something that happens when machining, sawing and even chiseling wood. Important pieces fall off from where you least want them to.



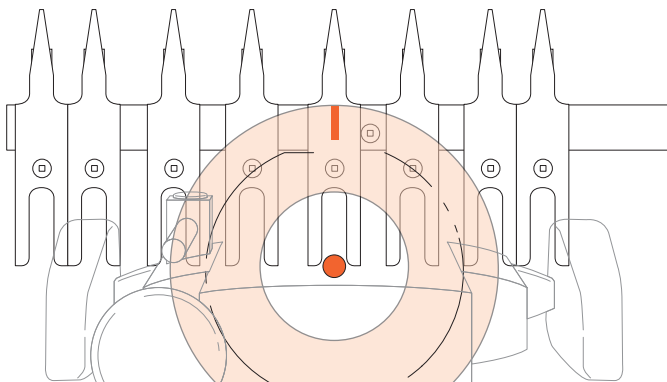
**15-12** On face cuts, whether using a straight bit or a dovetail bit, climb routing or back routing will leave a clean edge; **but great caution must be exercised in controlling the router's movement from right to left, as the bit rotation pulls the router in that direction anyway.**



**15-13 General Hints** For routing long vertical boards it may be necessary to build a jig stand to mount securely on your bench. Make the stand and bench height combination sufficient to accept the board length you have in mind. The jig stand should be bolted securely to the bench. Build a stable platform to stand on as in the illustration. **Do not use a set of steps; they're too unstable.**

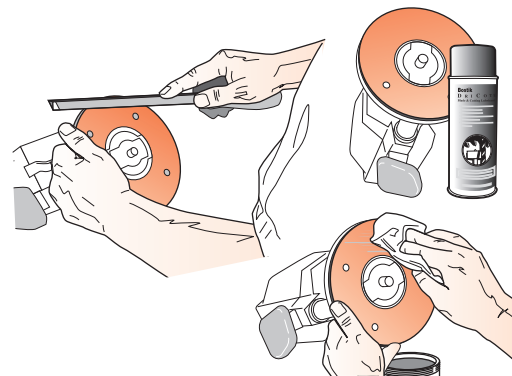


**15-14** When placing long horizontal boards in the rear clamp, make sure the rear end of the board is supported to prevent unnecessary racking of the jig.



**15-15 Using The Router** Mark the router base top edge at the 12 o'clock position with a felt marker pen. Without wood or bits, try some **dry runs** in each jig mode. This will soon get you used to positioning the guidebush against the correct guide surface without looking under the router.

**⚠ Do not rout at face level.**



**15-16** Some router bases have sharp edges on the outside and inside corners. A slight chamfer of the edges with a fine file or sandpaper block will ease router movement on the jig. An occasional light spray of TopCote® or application of soft wax to the router base makes for smooth, easy router movement on the jig. ■

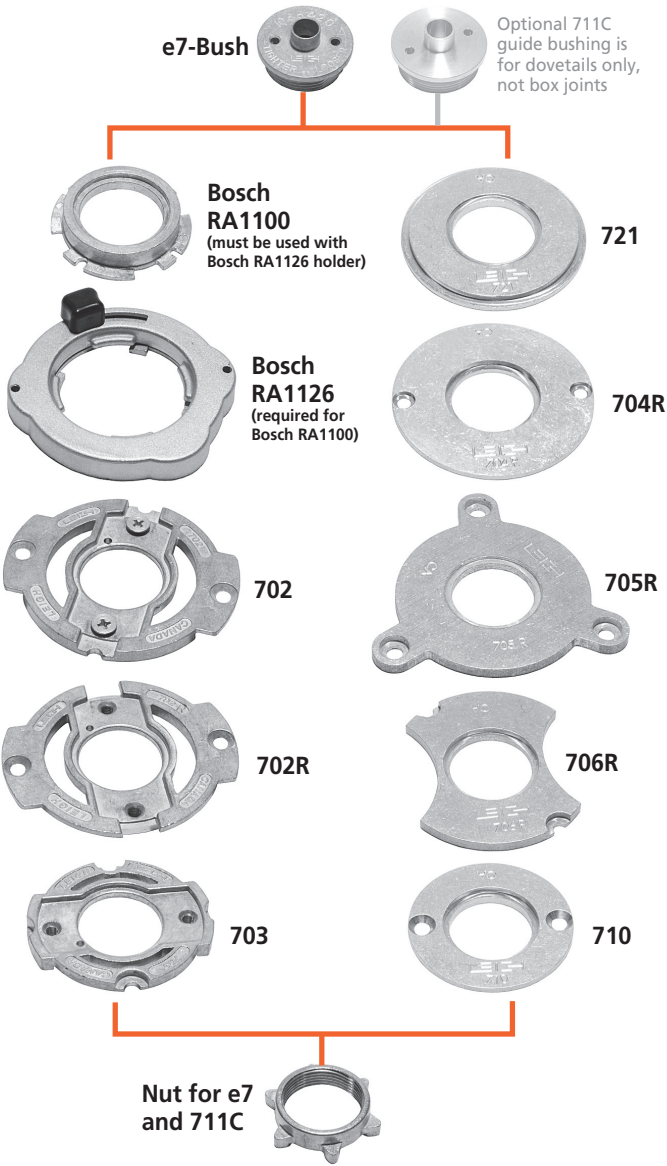


# Attaching the Leigh e-Bush to the Router

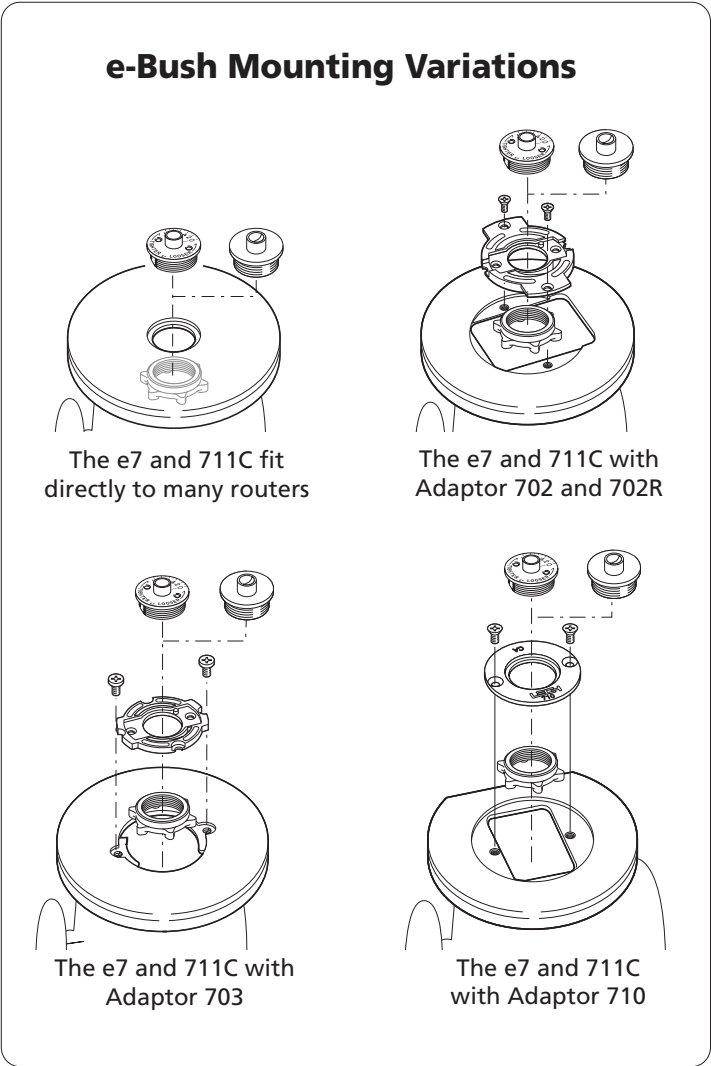
## e-Bush and Guidebush Adaptors

The Leigh e-Bush fits directly to some popular routers such as Porter Cable, Black & Decker, and Dewalt. Many other makes, e.g. Bosch, Fein, Festool, Milwaukee etc., offer or come with base adaptors that accept the e-Bush. Leigh offers eight adaptors, plus the Bosch RA1100 and RA1126, allowing the use of over one hundred other router models, new and old. The 711C (-7/16" OD) may be used in place of the e7 for dovetails, however it does not allow fit adjustment for box joints. See the next page for a list of routers.

### e-Bush Adaptors



### e-Bush Mounting Variations



# Template Guide Bushing and Adaptor Selection

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

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.

**D.** Guide bushings in Column 4 fit all adaptors listed and may be ordered if required.

◆ A ~7/16" e7 guide bushing is supplied with all Leigh Super jigs. Order only if you require a replacement.

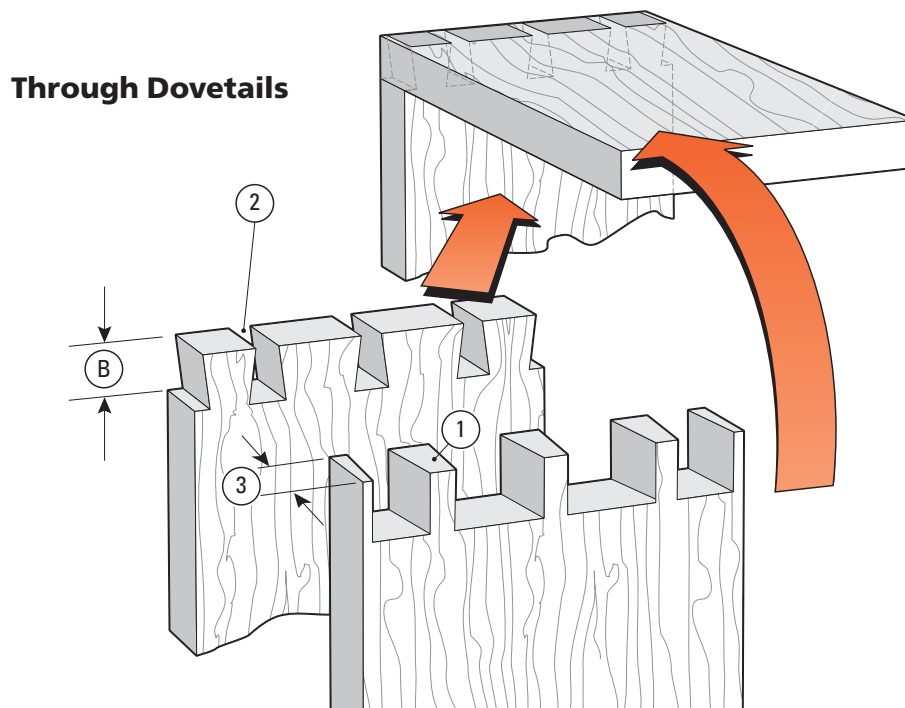
All 8mm shank bits work with the e7-Bush supplied with your Leigh jig, or with any 7/16" OD guide bushing that has a min. barrel length of 1/4". No other guide bushing sizes can be used.

**Note:** The 711C (~7/16" OD guide bushing) has replaced the 711TP.

1 ROUTER MAKER	2 ROUTER MODEL	3 ROUTER ADAPTOR	4 7/16" OD BUSHING ◆	
AEG	OFE 710 in plunge base	Not Required	e7 or 711C/711TP	
	OFSE 2000	703	e7 or 711C/711TP	
	RT1350E	706R	e7 or 711C/711TP	
BLACK & DECKER	All Professional, HD1250, RP400K,7614	Not Required	e7 or 711C/711TP	
	6200	720673-00	e7 or 711C/711TP	
	SR100, 7AEE, KW780 series, KW 800, KW850	710	e7 or 711C/711TP	
BOSCH	1600, 90085, 90088, 90098, 90140, 90150, 90300, 90303, 90305, 91264	Aftermarket base plate required	e7 or 711C/711TP	
	1601, 1602, 1603, 1604, 1606, B1350	RA1110	e7 or 711C/711TP	
	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 req'd		e7 or 711C/711TP
	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		e7 or 711C/711TP
	1611, 1611EVS, 1615, 1615EVS, B1550, GOF1600, GOF1700ACE	702		e7 or 711C/711TP
CRAFTSMAN (SEARS)	All non-plunge models	Aftermarket base plate required	e7 or 711C/711TP	
	135275070 Plunge	See Skil 1823 or 1835		
	Other plunge models	702	e7 or 711C/711TP	
DEWALT	MD11 Plunge & Fixed Base. MD9.5 Fixed Base	Not Required	e7 or 711C/711TP	
	DW610, DW616, DW618	Not Required	e7 or 711C/711TP	
	DW613, DW615(UK)	710	e7 or 711C/711TP	
	DW614, DW615, DW621, DW624, DW625, DW626	N. America Only, Supplied w/router	e7 or 711C/711TP	
	DW621K & DW626 outside N. America	706R	e7 or 711C/711TP	
ELU	DW625 Type 1,2,3,5 outside N. America	702	e7 or 711C/711TP	
	DW624 & DW625 Type 4 outside N.America, DW625EK	702R	e7 or 711C/711TP	
	OF15, OF15E, OF97, OF97E	706R	e7 or 711C/711TP	
	MOF68, MOF69, MOF96, MOF96E	710	e7 or 711C/711TP	
	MOF131, MOF177 Type 1,2, & 3	702	e7 or 711C/711TP	
	MOF177 Type 4, MOF177EK	702R	e7 or 711C/711TP	
	2720, 2721, 3328	Not Required	e7 or 711C/711TP	
FEIN	3303, 3304	E09600 or 761 270-00	e7 or 711C/711TP	
	3337, 3338, 3339	702	e7 or 711C/711TP	
	RT1800	Supplied w/router	e7 or 711C/711TP	
FESTOOL	OF1E, OF2E, OF650, OF900E, OF1000, OF1010E	704R	e7 or 711C/711TP	
	OF2000, OF2000E	705R	e7 or 711C/711TP	
	OF1400 and OF2200 North America Only	Supplied w/router	e7 or 711C/711TP	
	OF1400 Outside North America	493566	e7 or 711C/711TP	
	OF2200 Outside North America	494627 O-Ring may be required to keep bushing centered	e7 or 711C/711TP	
FREUD	FT700(2), FT2000, FT2200, FT3000	721	e7 or 711C/711TP	
HITACHI	TR8, TR12, FM8, M8, M12 Series	325211 OR 703	e7 or 711C/711TP	
	M12VC, KM12SC, KM12VC	Not Required	e7 or 711C/711TP	
	M12SA2, M12V2	325224	e7 or 711C/711TP	
MAFELL	LO65E	702 ■	e7 or 711C/711TP	
MAKITA	M363, MRP090, RP1800, RP1801, RP2301, RP2301FC, 3612C Europe Qk Fit Base	721	e7 or 711C/711TP	
	3600, 3606, 3608, 3612, 3612B, 3612BR, 3612C N. America, 3620, 3621, RP0900, RP900K	703	e7 or 711C/711TP	
	3601B	321 493-1	e7 or 711C/711TP	
	RP0910, RP1110C	706R	e7 or 711C/711TP	
	RF1100, RF1101, RD1100, RD1101, RP1101	Not Required	e7 or 711C/711TP	
MASTERCRAFT	Please contact Leigh for assistance			
METABO	OF1612, OFE1812 (for all others, please contact Leigh for assistance)	704R	e7 or 711C/711TP	
MILWAUKEE	5615, 5616, 5619	49-54-1040	e7 or 711C/711TP	
	5625	49-54-1026	e7 or 711C/711TP	
	5670	Not Required	e7 or 711C/711TP	
PERLES	OF808 Series, OFE6990	710	e7 or 711C/711TP	
PORTER CABLE (ROCKWELL)	All	Not Required or Supplied w/router	e7 or 711C/711TP	
RIDGID	R2930 (for all others, please contact Leigh for assistance)	704R	e7 or 711C/711TP	
RYOBI	R30, R50, R150, R151, RE155, R500, R501, R502	703	e7 or 711C/711TP	
	R600, R601, RE600, RE601	702	e7 or 711C/711TP	
	R160, R161, R162, R163K, R165, R170, R175, RE175, R180, R180PL, R181, R185, ERT1150	706R	e7 or 711C/711TP	
SKIL	1823 or 1835	91803	e7 or 711C/711TP	
	SK1810, 1815, 1820, 1825	RAS140	e7 or 711C/711TP	
	All others	Aftermarket base plate required	11592	
TREND	T3, T4, T5, T9, T10, T11 – UniBase required	710	e7 or 711C/711TP	
TRITON	TRC001	TGA006 or 704R	e7 or 711C/711TP	
	JOF001, MOF001, TRA001	Accessory Kit (includes adaptor) TGA001 or TGA150	e7 or 711C/711TP	
WEGOMA	OF850 Series	710	e7 or 711C/711TP	

## Bit Selection

Optional router bits for variably spaced through and half-blind dovetails.



### Bit Selection for Through Dovetails

#### 8° Dovetail Bit for Tails

The pins ① must fit into the sockets ②. So the dovetail bit's depth of cut ③ must be equal to or a little greater than the pinboard thickness ③.

Measure the pinboard thickness ③ and select the dovetail bit with

the correct depth of cut ③ from the following pages (bits must be 8° for through dovetails).

#### Straight Bit for Pins

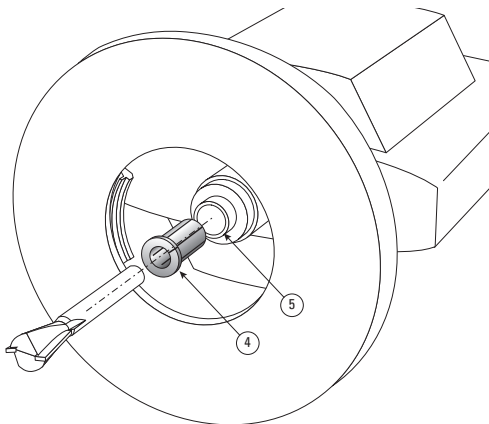
The matching straight bit is listed just below the dovetail bits. The 5/16" diameter No. 140-8, 8mm shank is the only straight bit you need with the Superjig.

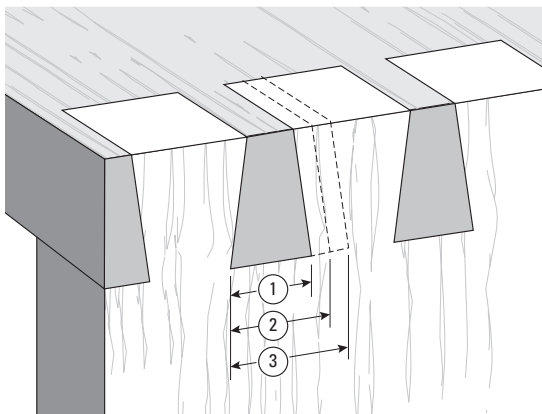
#### Guidebush

All joints on the Superjig are routed with the e7-Bush, or all but box joints with any 7/16" OD guidebush (min. barrel depth 1/4"). See page 68.

#### Shank Selection

Note: You will require a router with an 8mm or 1/2" [12,7mm] collet to use our 8mm shank bits. For a 1/2" [12,7mm] collet router you will require our 1/2" [12,7mm] to 8mm collet reducer No. 172-8. Note: This is a collet reducer ④, not a collet ⑤. It does not replace the collet, it slides directly into your 1/2" collet. *Do not remove the collet nut when installing the collet reducer.*





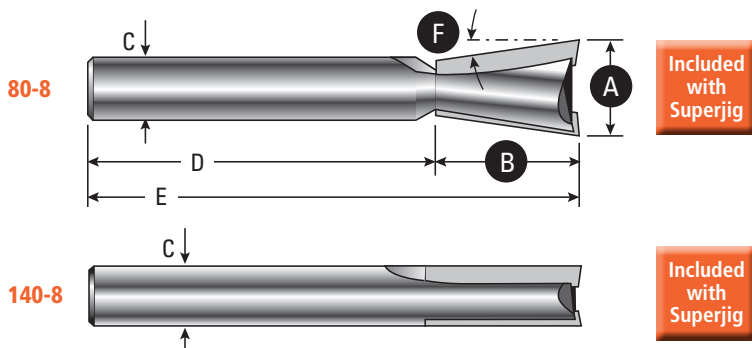
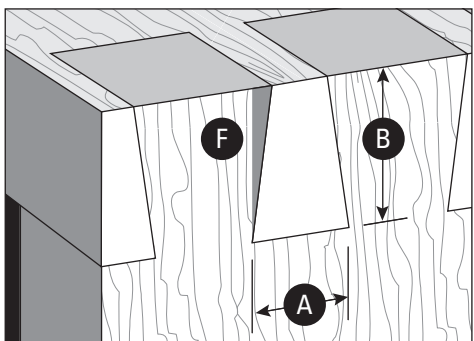
You will note that some of the dovetail bits' depths of cut overlap. For example:  
 No.80-8 bit (B): 1/2" - 13/16" [12 - 20mm]  
 No.70-8 bit (B): 1/4" - 1/2" [6 - 12mm]

This means that 1/2" boards can be joined using either the No.80-8 and 140-8 combination, the No. 75-8 and 140-8 combination, or the No.70-8 and 140-8 combination. The three bit combinations will produce slightly different-looking joints because each dovetail bit produces a different size pin:  
 No. 70-8 3/8" ①  
 No. 75-8 7/16" ②  
 No. 80-8 1/2" ③.

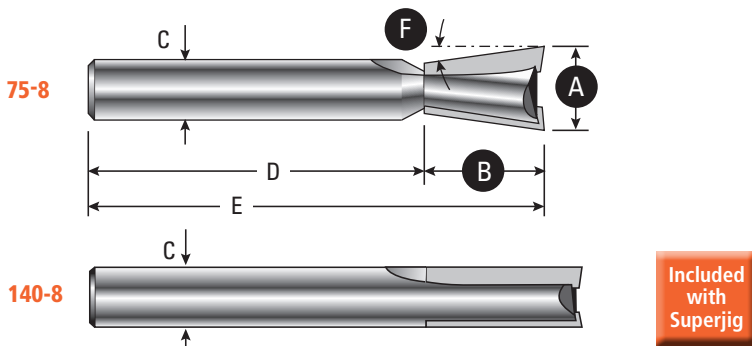
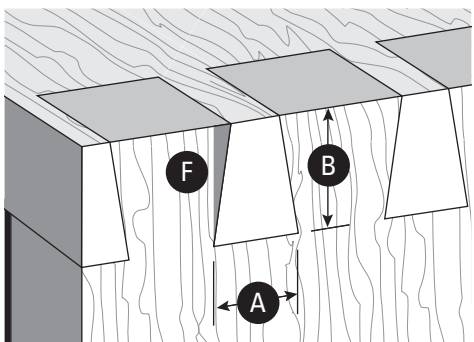
**⚠ Do not attempt to rout dovetails at less than the minimum depth of cut specified.**

**Note: Bit and joint drawings are about actual size.**

**Leigh Through Dovetail Bits**



Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 80-8*	1/2" [12,7]	1/2" to 13/16" [13,0-20,6]**	8mm	1-3/4" [45,0]	2-9/16" [65,0]	8°	e7 or 711C ~7/16" [11,1]
No. 140-8*	5/16" [7,9]	up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	-	e7 or 711C ~7/16" [11,1]



Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 75-8	7/16" [11,1]	3/8" to 5/8" [9,5-16,0]	8mm	1-3/4" [45,0]	2-3/8" [60,0]	8°	e7 or 711C ~7/16" [11,1]
No. 140-8*	5/16" [7,9]	up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	-	e7 or 711C ~7/16" [11,1]

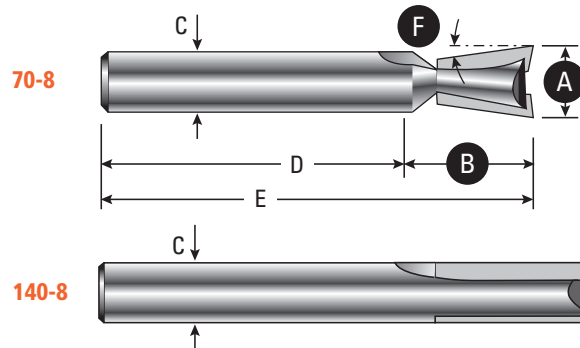
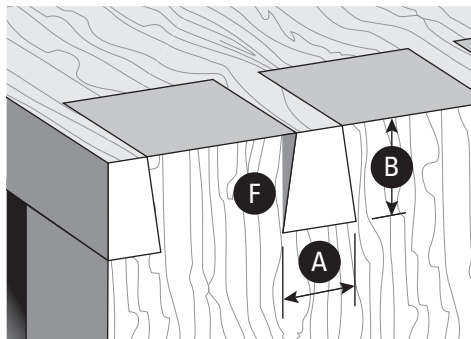
Numbers in brackets are millimeters

\* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

\*\*Maximum pin board thickness = 13/16"

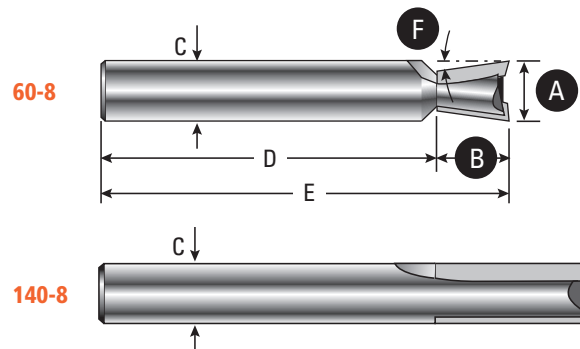
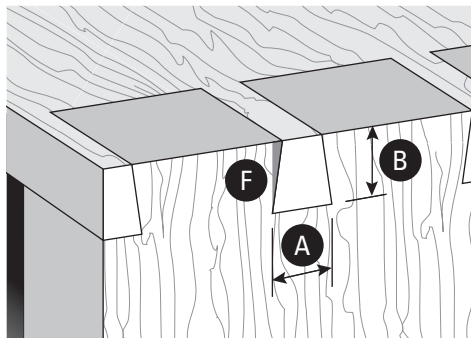
Note: Bit and joint drawings are about actual size.

Leigh Through Dovetail Bits



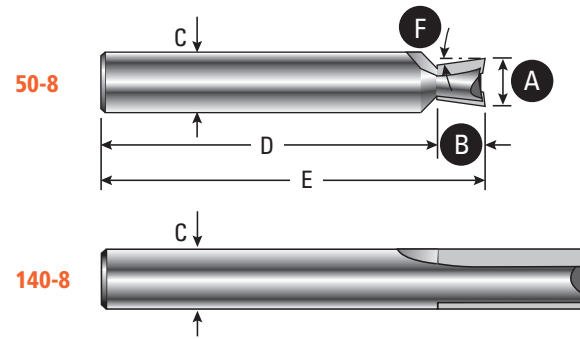
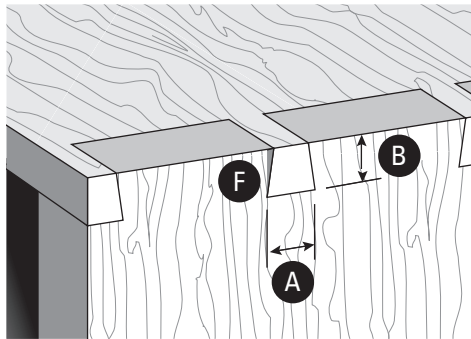
Included with Superjig

Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 70-8	3/8" [9,5]	1/4" to 1/2" [6,0-13,0]	8mm	1-3/4" [45,0]	2-1/4" [57,0]	8°	e7 or 711C ~7/16" [11,1]
No. 140-8*	5/16" [7,9]	up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	-	e7 or 711C ~7/16" [11,1]



Included with Superjig

Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 60-8	5/16" [7,9]	up to 3/8" [9,5]	8mm	1-3/4" [45,0]	2-1/8" [54,0]	8°	e7 or 711C ~7/16" [11,1]
No. 140-8*	5/16" [7,9]	up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	-	e7 or 711C ~7/16" [11,1]



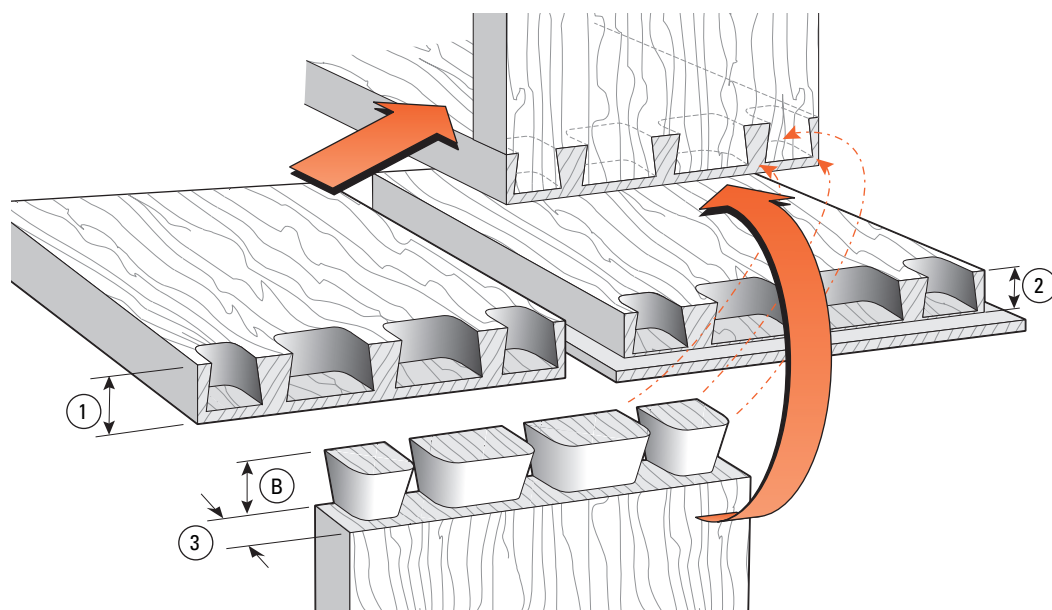
Included with Superjig

Bits	A Overall Diameter	B Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 50-8	1/4" [6,35]	up to 1/4" [6,35]	8mm	1-3/4" [45,0]	2" [50,0]	8°	e7 or 711C ~7/16" [11,1]
No. 140-8*	5/16" [7,9]	up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	-	e7 or 711C ~7/16" [11,1]

Numbers in brackets are millimeters

\* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

## Half-Blind Dovetails



### Bit Selection for Half-Blind Dovetails

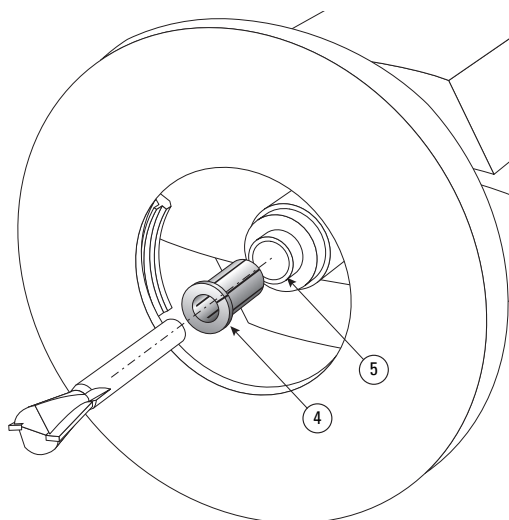
Both parts of a half-blind dovetail are cut with the same dovetail bit. The dovetail bit's working depth of cut (B) must be less than the pinboard thickness (1) for flush drawers by at least  $\frac{1}{8}$ " [2mm], and slightly less than the rabbet depth (2) for rabbeted drawer fronts. Minimum pin board (drawer front) thickness is  $\frac{1}{2}$ " [12mm].

**Drawer side thickness (3) does not affect bit selection.**

*Note:* (B) is the nominal working depth for half-blind

dovetails, not the maximum depth. (B) must not be varied, except for minor adjustments for joint fit. *See page 35.*

Measure the drawer front thickness (minimum  $\frac{1}{2}$ " [12mm]) (1) or rabbet depth (minimum  $\frac{7}{16}$ " [11,1mm]) (2) and select the bit with the appropriate depth of cut (B) from one of the five bits on the following pages.



### Guidebush

All joints on the Superjig are routed with the e7-Bush, or all but box joints with any  $\frac{7}{16}$ " OD guidebush (min. barrel depth  $\frac{1}{4}$ "). *See page 68.*

### Shank Selection

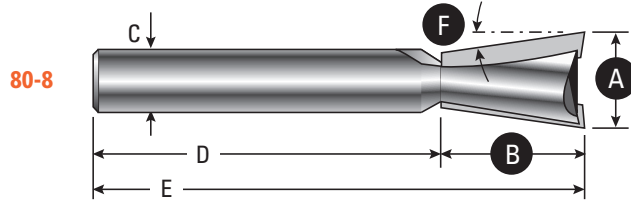
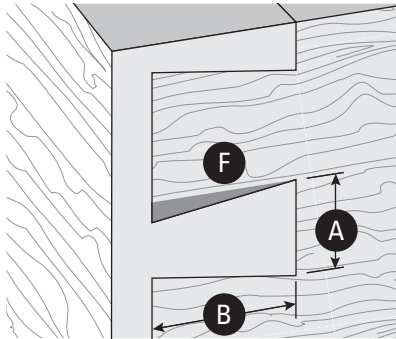
**Note:** You will require a router with an 8mm or  $\frac{1}{2}$ " [12,7mm] collet to use our 8mm shank bits.

For a  $\frac{1}{2}$ " [12,7mm] collet you will require our  $\frac{1}{2}$ " [12,7mm] to 8mm collet reducer No.172-8.

**Note:** This is a collet reducer (4), not a collet (5). It does not replace the collet, it slides directly into your  $\frac{1}{2}$ " collet. *Do not remove the collet nut when installing the collet reducer.*

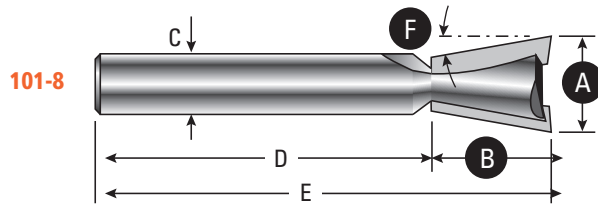
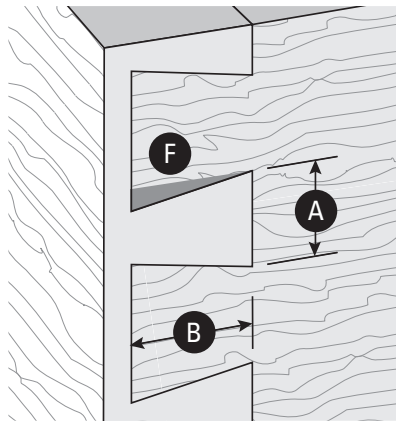
Note: Bit and joint drawings are about actual size.

Leigh Half-Blind Dovetail Bits

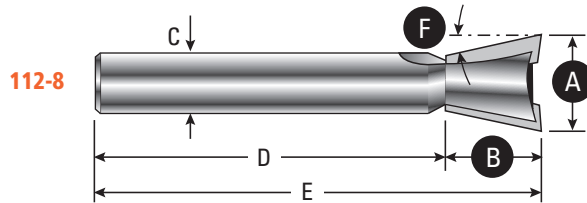
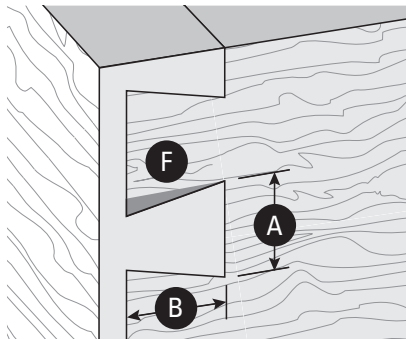


Included with Superjig

Bits	A	B		C	D	E	F	Guidebush Diameter
	Overall Diameter	Working Depth						
		HB Variable	HB 1-Pass					
No. 80-8*	1/2" [12,7]	~3/4" [19]	~1/2" [12,7]	8mm	1-3/4" [45,0]	2-9/16" [65,0]	8°	e7 or 711C ~7/16" [11,1]



Bits	A	B		C	D	E	F	Guidebush Diameter
	Overall Diameter	Working Depth						
		HB Variable	HB 1-Pass					
No. 101-8	1/2" [12,7]	~5/8" [16,0]	~7/16" [11,1]	8mm	1-3/4" [45,0]	2-3/8" [60,0]	10°	e7 or 711C ~7/16" [11,1]

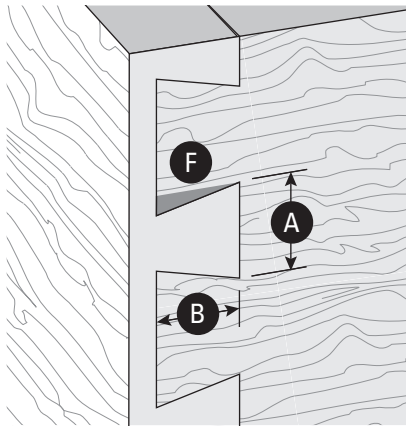


Bits	A	B		C	D	E	F	Guidebush Diameter
	Overall Diameter	Working Depth						
		HB Variable	HB 1-Pass					
No. 112-8	1/2" [12,7]	~1/2" [13,0]	~3/8" [9,5]	8mm	1-3/4" [44,0]	2-21/64" [59]	12°	e7 or 711C ~7/16" [11,1]

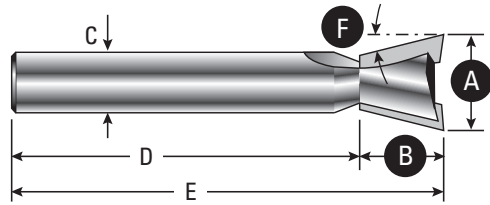
Numbers in brackets are millimeters

\* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

**Note: Bit and joint drawings are about actual size.**

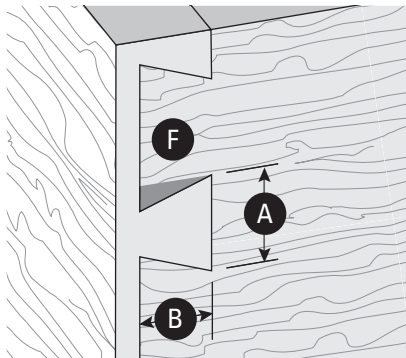


120-8

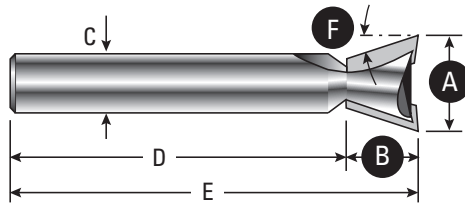


Included with Superjig

Bits	A	B		C	D	E	F	Guidebush Diameter
	Overall Diameter	Working Depth		Shank Diameters	Shank Length	Overall Length	Angle	
		HB Variable	HB 1-Pass					
<b>No. 120-8*</b>	1/2" [12,7]	~7/16" [11,0]	~9/32"[7,1mm]	8mm	1-3/4" [45,0]	2-1/4" [57]	14°	e7 or 711C ~7/16" [11,1]



128-8



Bits	A	B		C	D	E	F	Guidebush Diameter
	Overall Diameter	Working Depth		Shank Diameters	Shank Length	Overall Length	Angle	
		HB Variable	HB 1-Pass					
<b>No. 128-8</b>	1/2" [12,7]	~3/8" [9,5]	7/32"[5,5]	8mm	1-3/4" [45,0]	2-1/8" [54,0]	18°	e7 or 711C ~7/16" [11,1]

Numbers in brackets are millimeters

\* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

## *SUPERJIG - Appendix III*

# **Jig Parts**

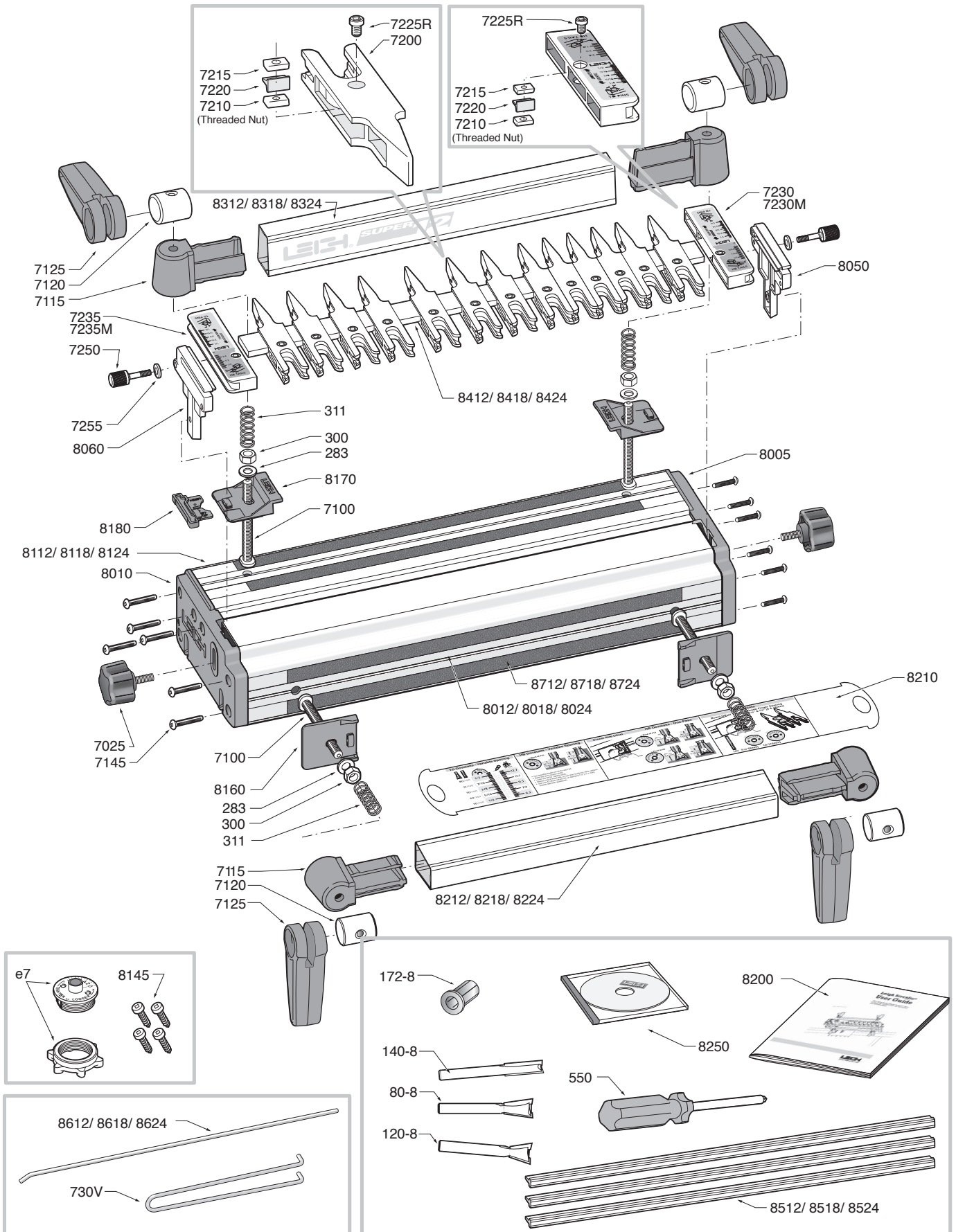
***See parts list and drawing on the following pages.***

*When ordering parts, please quote the jig model, serial number, part number, part description and quantity required. Pay particular attention to the scale measurement, and let us know if yours is inch or metric.*

## How to Order Parts

Order directly from Leigh by calling toll free 800-663-8932, or if you're outside North America contact your national distributor. Have your jig information ready — You'll need the jig model, serial number, part number, part description and quantity required. **Note:** Place the finger assembly in half-blind mode to determine left hand and right hand scales.

PART DESCRIPTION	QUANTITY	PART NO.	SUPER 12	SUPER 18	SUPER 24
Super Jig Front Body Extrusion	1		8012	8018	8024
Super Jig Rear Body Extrusion	1		8112	8118	8124
Fingers	see model	7200	Quantity 13	Quantity 16	Quantity 19
Finger Nuts (Threaded)	see model	7210	Quantity 15	Quantity 18	Quantity 21
Finger Washers	see model	7215	Quantity 15	Quantity 18	Quantity 21
Finger Wedges	see model	7220	Quantity 15	Quantity 18	Quantity 21
8/32 x 7.35mm Finger Screws	see model	7225R	Quantity 15	Quantity 18	Quantity 21
R.H. Inch Scale Assembly, complete (R.H. in H.B. Tail Mode)	1	7230			
or R.H. Metric Scale Assembly, complete (R.H. in H.B. Tail Mode)	1	7230M			
L.H. Inch Scale Assembly, complete (L.H. in H.B. Tail Mode)	1	7235			
or L.H. Metric Scale Assembly, complete (L.H. in H.B. Tail Mode)	1	7235M			
SJ End Housing R.H.	1	8005			
SJ End Housing L.H.	1	8010			
SJ Support Bracket R.H.	1	8050			
SJ Support Bracket L.H.	1	8060			
Scale Block R.H. (RH in HB Tail Mode)	1	7230			
Scale Block L.H. (LH in HB Tail Mode)	1	7235			
SJ Non-Slip Self Adhesive Strips	4		8712	8718	8724
SJ Front Side Stops	2	8160			
SJ Rear Side Stops	2	8170			
SJ Spacer	1	8180			
Clamp Tube Extrusion - Front	1		8212	8218	8224
Clamp Tube Extrusion - Rear	1		8312	8318	8324
Clamp Tube End Plugs	4	7115			
Screwdriver	1	550			
1" Aluminum Finger Bar	1		8412	8418	8424
Plastic Bridge Extrusions	3		8512	8518	8524
Nylon Depth Rod	1		8612	8618	8624
Support Bracket Knobs	2	7025			
Clamp Bar Springs	4	311			
Scale Thumb Screws	2	7250			
Scale Thumb Screw Washers	2	7255			
T-Bolts	4	7100			
End Housing Screws	12	7145			
5/16"x18 Hex Nuts	4	300			
5/16" SAE Flat Washers	4	283			
SJ Hold Down Screws #10 x 1"	4	8145			
SJ User Guide	1	8200			
SJ Instructional Pull Out	1	8210			
Cam Clamps	4	7125			
Cam Nuts 5/16-18	4	7120			
SJ Instructional DVD	1	8250			
# 80-8 1/2" Dovetail Bit	1	80-8			
# 140-8 5/16" Straight Bit	1	140-8			
# 120-8 Dovetail Bit	1	120-8			
1/2" to 8mm Collet Reducer	1	172-8			
e7 Oval Guide Bush & Nut	1	e7-Bush			
Pin Wrench	1	730V			



NOTE: When ordering parts, please quote the jig model, serial number, part number, part description and quantity required. Pay particular attention to the scale measurement, inch or metric.



## SUPERJIG - 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.  
1615 Industrial Ave.  
Port Coquitlam, B.C.  
Canada V3C 6M9

### Distributors

#### AUSTRALIA & NEW ZEALAND

Carba-Tec Pty. Ltd.  
128 Ingleston Rd., Wakerley, Qld., 4154  
Australia  
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

#### 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  
Tel: 81-054-367-6511  
Fax: 81-054-367-6515  
Email: info@off.co.jp  
Web: www.off.co.jp

#### KOREA

Leigh Korea  
1st Floor, Yongyu Building, 25-3,  
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Kyunggi-do, Korea  
Tel: 82 (0) 70-8252-0988  
Fax: 82 (0) 31-765-5602  
Email: smgi@paran.com  
Web: www.htools.co.kr

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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

Axminster Power Tool Centre Ltd.  
Unit 10, Weycroft Avenue  
Axminster, Devon  
EX13 5PH United Kingdom  
Tel: 03332 406406  
Email: cs@axminster.co.uk  
Web: axminster.co.uk/leigh



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