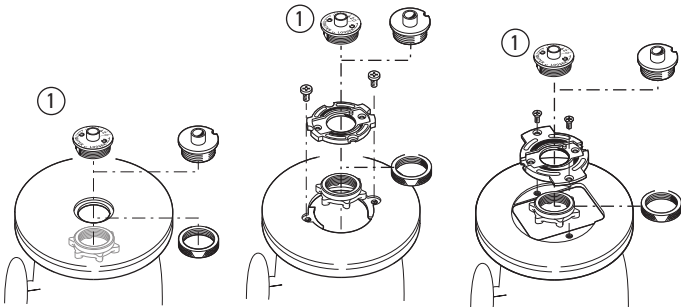
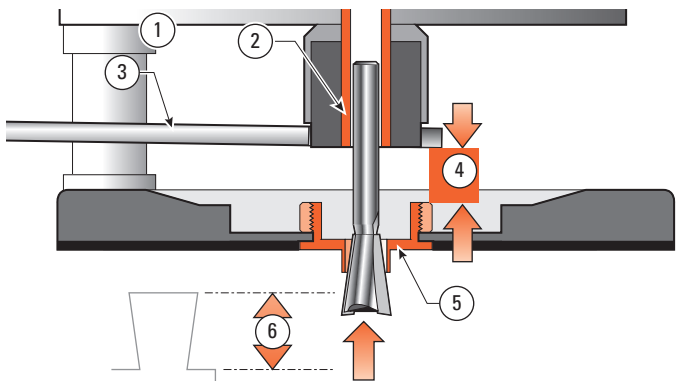


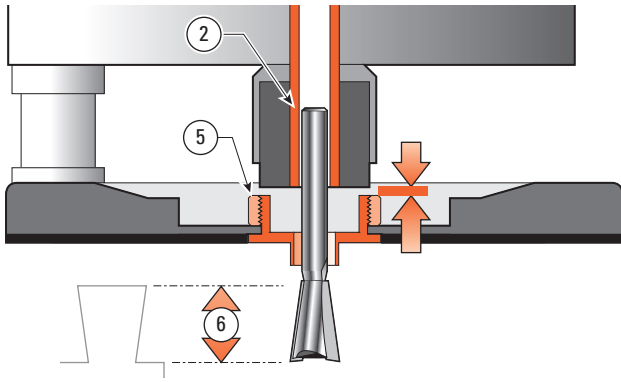
Router Preparation



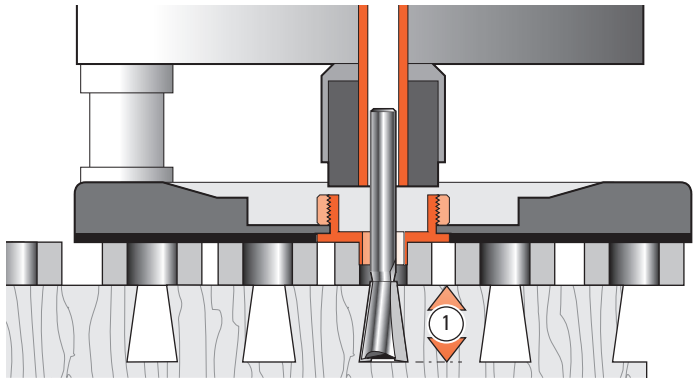
7-1 Fit the e7-Bush ①. One is included with your D4R Pro. If the eBush is incompatible with your router, any 7/16" [11,1mm] guidebush (min. barrel length 1/4", see page 70) will work for all but box joints on the D4R Pro.



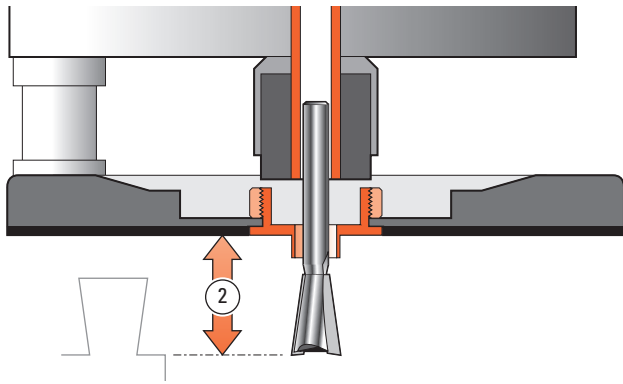
7-2 When fitting a bit to the router ①, fit the shank as far into the collet ② as possible. Always rout with the collet as close to the guidebush as possible. Usually you can't securely grip the collet nut with a wrench ③ if the collet is at its optimum low position. Fit the bit so that the remaining travel ④ between collet and guidebush ⑤ will let the bit reach the required depth of cut ⑥.



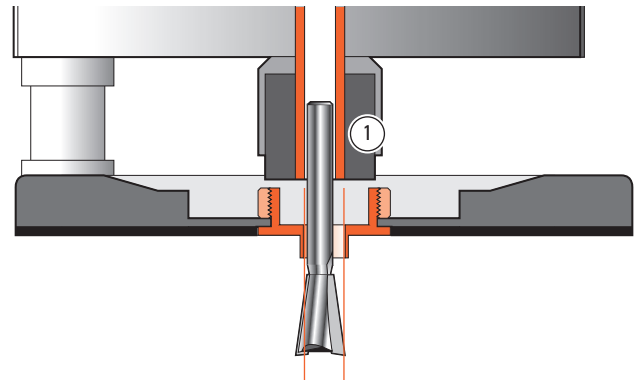
7-3 Tighten the collet ② securely and lower the collet to adjust the depth of cut ⑥, but make sure the collet does not contact the guidebush ⑤. Some smaller collets can go down into the inside of the guide bush. Take advantage of this.



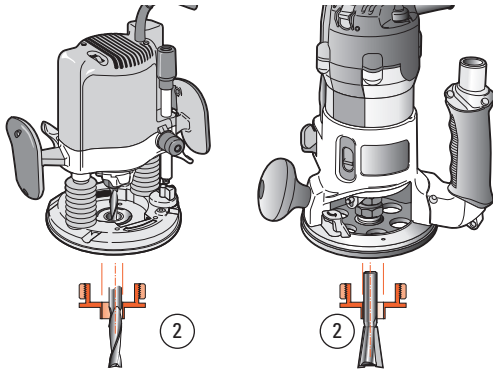
7-4 Depth of Cut: The depth of cut always refers to the actual depth of the cut into the wood beneath the guidefingers ①.



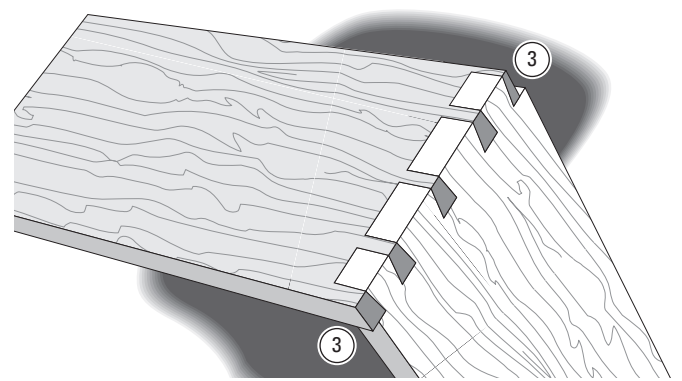
7-5 Depth of cut is **not** the distance the bit projects from the router base. This is **bit projection** ②. This guide generally refers to depth of cut. Bit projection ② is always .450" [11,5mm] more than depth of cut.



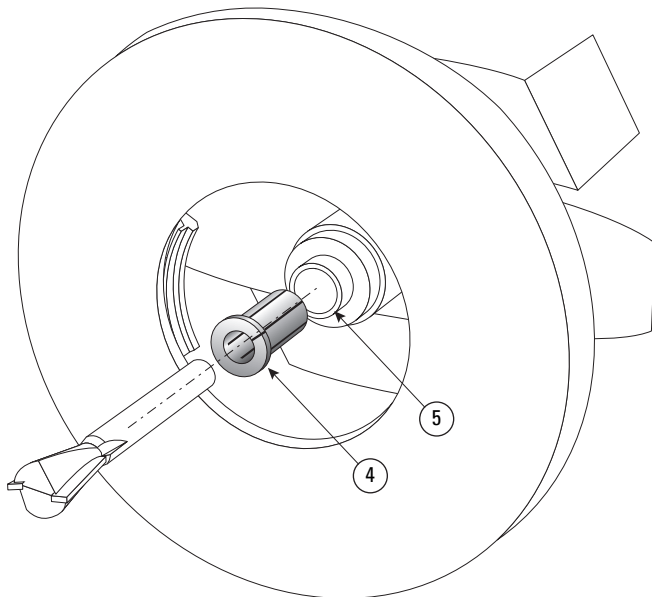
7-6 Ideally, the router collet (and bit) should be concentric (centered) to the guidebush as in figure 7-5. Regrettably, this is often not the case; the bit can be off center (eccentric to) the guidebush ①. The illustration shows the problem highly exaggerated. The good news: bit to bush alignment doesn't affect joint fit or flushness; both are "adjusted out" in normal jig setup.



7-7 Concentricity problems can only arise if two routers are used for through dovetails, (one for pins; one for tails). Routers with different bit to guidebush offsets ② (misalignment shown highly exaggerated)...



7-8 ...will cause pin to tailboard ③ misalignment (again, shown highly exaggerated). Fortunately, some newer routers have sub-bases that can adjust for concentricity. If you don't have this type, it might pay to stick to a single router for through dovetails.



7-9 Shank Selection/Collet Reducer

All Leigh Dovetail jigs are shipped with superior strength 8mm shank dovetail bits and a 1/2" to 8mm collet reducer. The reducer ④ simply slides into the 1/2" collet of your router ⑤ (do not remove the collet nut) and the 8mm shank bit is inserted into the collet reducer. The collet is tightened as normal. The collet reducer is not required with 1/2" [12,7mm] shank bits. ■