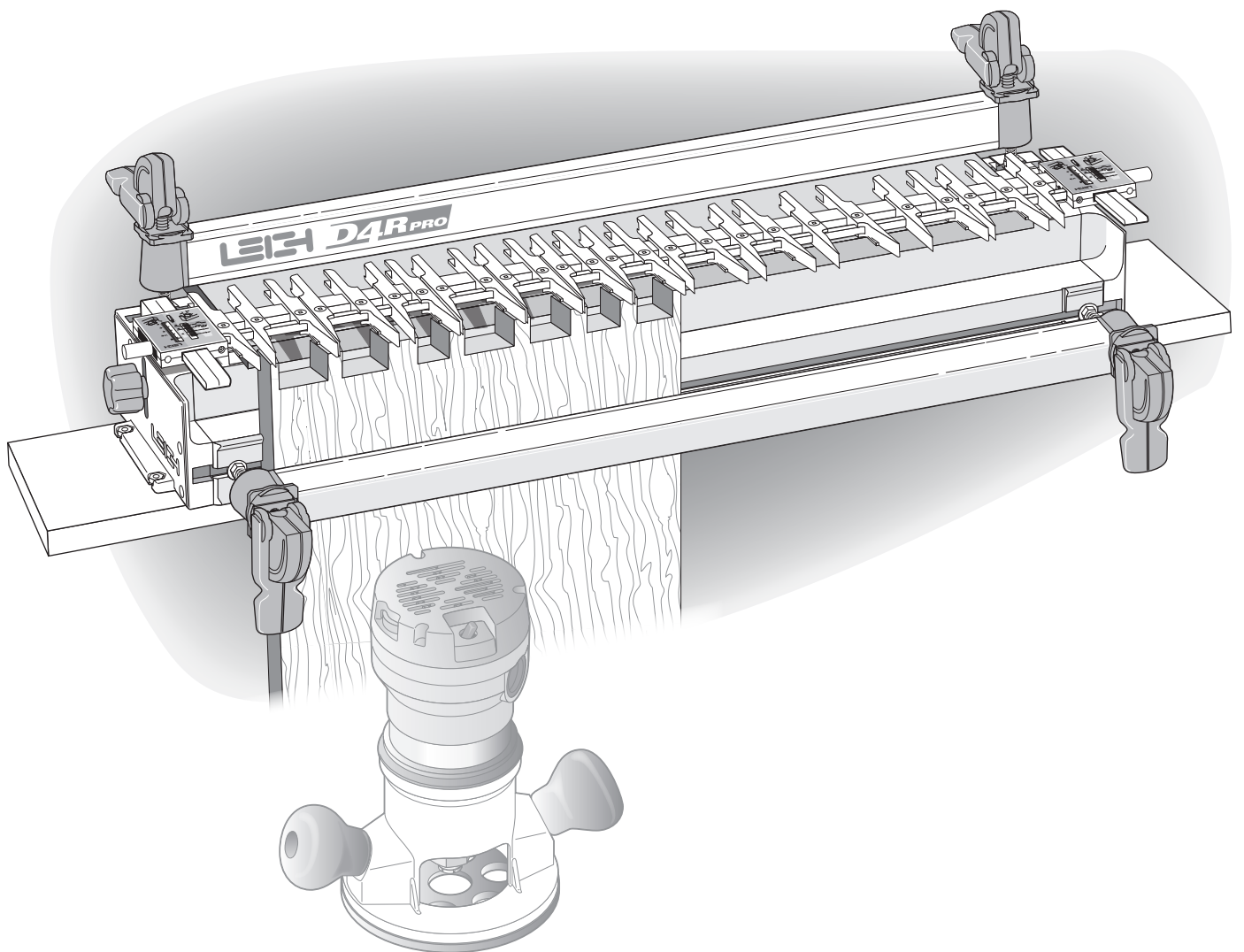


# LEIGH **D4R<sub>PRO</sub>** User Guide

*For the Leigh D4R Pro 24" Dovetail Jig*



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

**LEIGH**  
Joining Tradition with Today

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## TECHNICAL BULLETINS

**Downloadable pdfs are available at [leighjigs.com](http://leighjigs.com) on the Support page for these How To's and more for your Leigh D4R Pro jig:**

- Angled Through Dovetails
- Jumbo Half-Blind Dovetails
- Inlaid Through and Half-Blind Dovetails
- Needle Pins
- Through Dovetail Pins At Less Than 1" Centers
- Shelf Holes and Notches
- Clamp Short Boards on your Leigh Dovetail Jig – Quick Method
- Clamp Short Boards on your Leigh Dovetail Jig – Adjustable Width

### Your New Leigh D4R Pro Dovetail Jig

*Congratulations! You now own the world's most useful and versatile dovetailing tool (and more!). The Leigh D4R Pro Dovetail Jig will help you rout an infinite variety of joints, and all of its major functions are described in detail in this guide. A very helpful DVD is also included, but the guide is essential reading.*

We recommend that you first assemble and mount the jig, carefully following the instructions in the first section of the guide. Then read the rest of the guide, following along with the basic functions and principles of operation, before you try to do any actual joinery routing. By all means, rout a few practice joints in scrap boards before you use the jig to rout a precious hardwood workpiece!

If you have any questions that are not answered in this guide, please contact Leigh customer support:

Tel: 1-800-663-8932

Tech Support: [help@leighjigs.com](mailto:help@leighjigs.com)

For more contact info, see Appendix IV – Customer Support

*But remember:*

*“If at first you don't succeed, read the instructions!”*

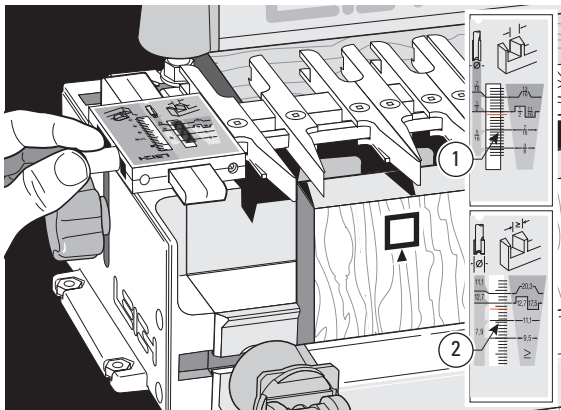
### Important! Inches and Millimeters

The D4R Pro jig can be ordered in inch or metric versions. They're identical except for the calibration scales. This Leigh English-language user guide shows measurements in both inches and millimeters, with “inches” first, followed by “millimeters” in square brackets.

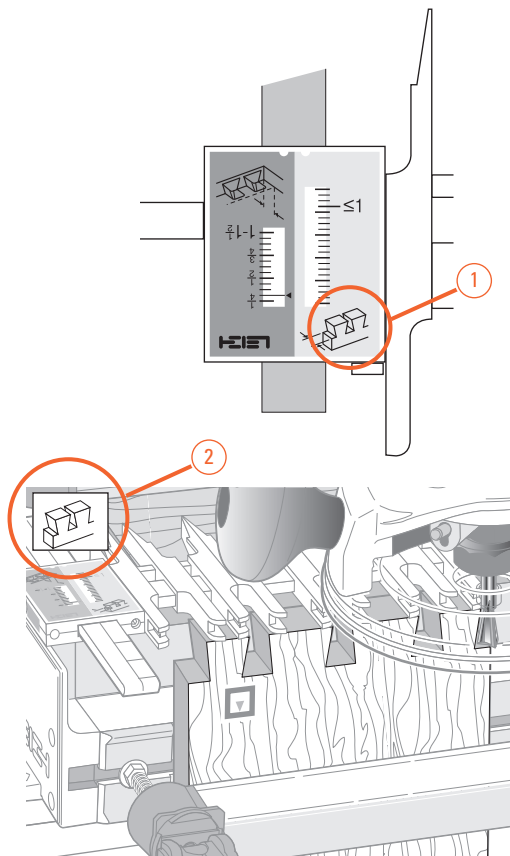
Example:  $\frac{3}{4}$ " x  $5\frac{1}{2}$ " x 8" [20 x 140 x 200mm]

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

To simplify the instructions, most jig illustrations show a jig considerably shorter than the standard 24" [610mm].



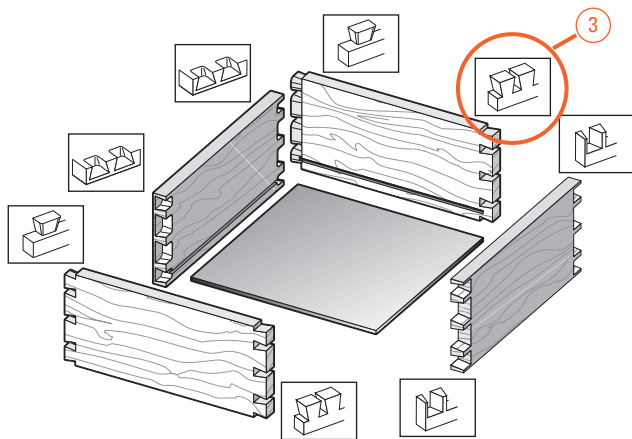
Where finger assembly scales overlay an illustration, the “inches” scale ① will be at the top, and “millimeters” scale ② at the bottom. Only the right hand “active” half of the scales are illustrated. For clarity, setting positions are indicated with a red line in the guide only. **On the jig, the lines are black.**



## Glossary of Symbols

To help you understand the instructions and illustrations in this manual, 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 quite frequently in this user guide, and you will soon get used to them.

The Leigh jig's guidefinger assembly can be in any one of four joint modes, depending on what type of joint and which part of the joint you are routing. Each finger assembly scale has its own mode icon ①, identifying the joint part being routed. You will also find the joint mode icon in the top left corner of most illustrations ②, indicating which finger assembly mode to use.



Sometimes a joint mode icon will be used to identify a board ③.

These are the four joint mode icons:



**TD Tails**  
(tails for through dovetail joints)



**TD Pins**  
(pins for through dovetail joints)



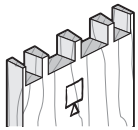
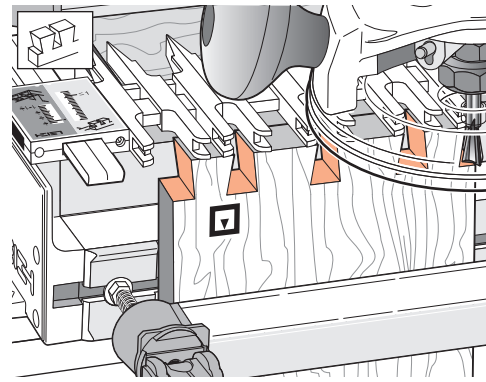
**HB Tails**  
(tails for half-blind dovetail joints)



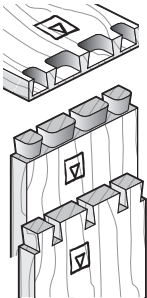
**HB Pins**  
(pins for half-blind dovetail joints)

### Which Way Round Should the Board Go?

As virtually all dovetail joinery is used to make boxes, drawers and chests etc., we devised these simple (and hopefully intuitive) icons to indicate which side of a board faces inwards or outwards on the finished “box”, and which side of the board faces outward (toward you, the operator), when it is clamped in the jig.



⏏ This icon ⏏ indicates the “outside” of a board. All through dovetail pin boards are mounted in the jig with this “outside” face away from the jig (toward you, the operator).

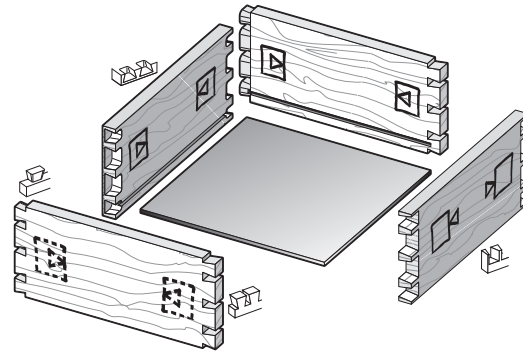


⏏ This icon ⏏ indicates the “inside” of a board. All half-blind pin and half-blind tail boards, and through dovetail tail boards, are mounted in the jig with the “inside” face away from the jig toward you, the operator.



⏏ This icon ⏏ indicates boards that are mounted both ways e.g. sliding dovetails and end-on-end dovetails.

⏏ Dotted line icons ⏏ indicate the “other” side of the board in the illustrations.



The following symbols indicate:



This edge against sidestop



This edge against sidestop



Sawcut allowance



Caution: use special care for this operation

①②③ Numbered References in text



Centerline of board or layout



Equals



Does not equal



Approximately

## Add **Leigh Accessories** to make your jig even more versatile.



### Finally, **Dust-Free Routing and Superb Router Support!**

A must-have! The VRS Vacuum & Router Support\* is the ultimate dust and chip collector. As an added bonus, the VRS adds full width router support to your D4R Pro. It's simple to attach and the collector adapts to most popular vacuum hose sizes.

#### Item VRSD24

\* US patent: USPN 7,507,060 B2  
UK patent: GB2446909



### Leigh Brand Bit Sets Offer Great Savings...and the Box Is Free!

Save over individual bit prices. Each top quality bit set includes a box with foam insert that accepts all shank sizes, and a handy bit chart in the lid to list out all the bit specs.

Item 1607-8 7-piece Bit Set

Item 2411-8 12-piece Bit Set

Item 5116-8 15-piece Bit Set



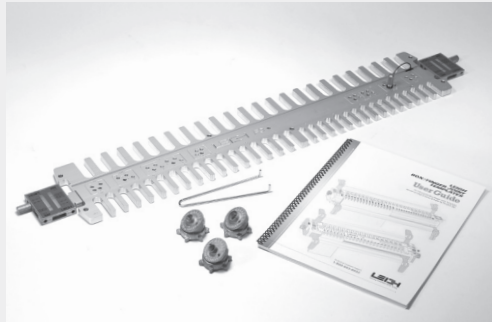
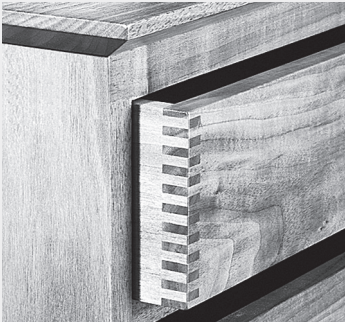
### Combine the VRS with a Bit Set for Exceptional Savings!

The D4R Pro Accessory Kit is the best deal going. Enjoy great savings on the 12-piece Bit Set and even greater savings when you combine it with the VRSD24 Vacuum & Router Support.

Item ACD24

Visit [www.leighjigs.com](http://www.leighjigs.com) for more details

## Optional Leigh Templates and Attachments

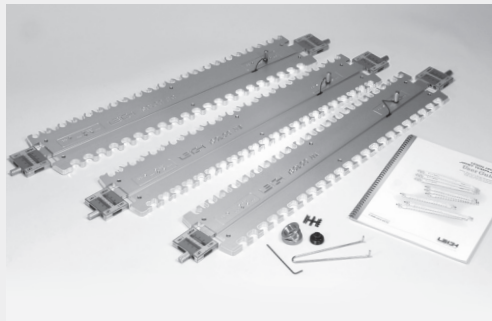
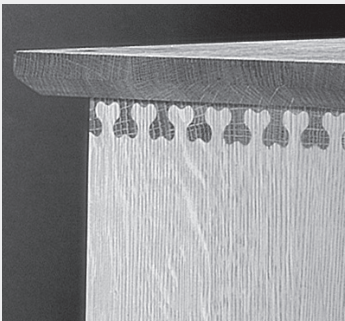


### 11 Sizes of Box/Finger Joints

Add an F3 Finger Joint Template\* to your D4R Pro Jig to make even more sizes of strong, pleasing and easy box/finger joints. Rout perfect joints in minutes, in sizes ranging from 3/32" to 1" [2 to 24mm].

**Item F3 / F3M**

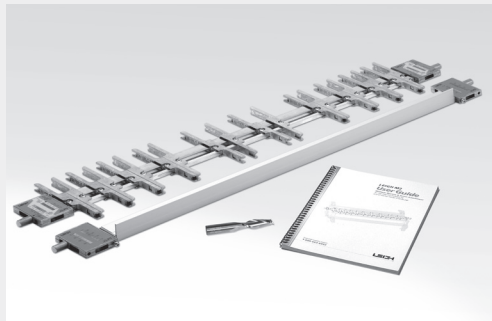
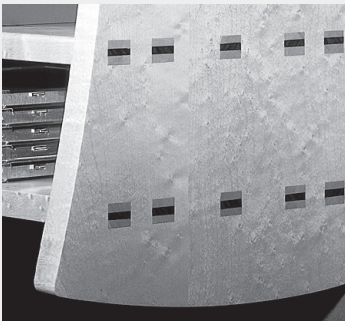
\* US Patent No. 5,711,356  
Canadian Patent No. 2,146,834  
European Patent No. 0698458



### Six Unique Isoloc Joints, Only from Leigh

The patented Isoloc joint gives any corner joint a very unique look. These one-of-a-kind patterns will really set your woodworking pieces apart from the rest. Great savings when you buy all three templates.

**Items I1A, I1B, I1C and I13 (3 pack)**



### Classic Multiple Mortise & Tenon Joints that Last

The Leigh M2 Attachment is the only one of its kind. The multiple mortise & tenon joint is ideal for "shelf to upright" construction and produces extremely strong joints that stand the test of time.

**Item M2-24 / M2M-24**

## Need a Helping Hand? Use Leigh Hold-Down Clamps

Leigh Hold-Down Clamps are tough, versatile and immensely strong! They employ proven cam-action technology developed for the award-winning Leigh D4R Pro and FMT/Pro. Bench clamps can be used in any size hole and surface clamps can be mounted on any flat surface, both on any angle. You can never have too many clamps!

**Item BHDC1** Bench Mount

**Item SHDC1** Surface mount



Visit [www.leighjigs.com](http://www.leighjigs.com) for more details

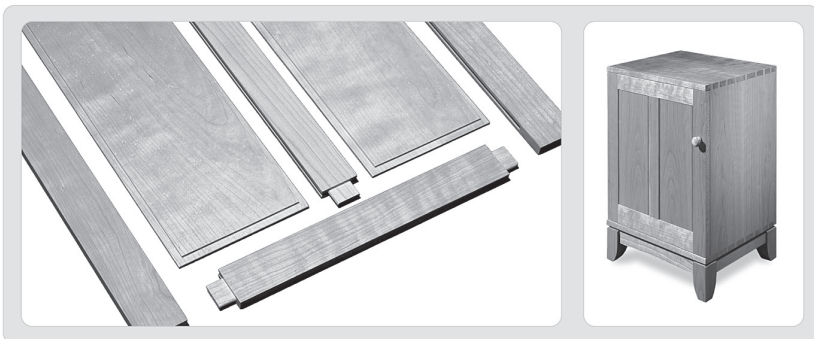
# Mortise & Tenon Joints **have never** been easier!



**Leigh FMT Pro**  
**Mortise & Tenon Jig**  
Item FMT Pro /  
FMT Pro-M

## Rout mortises and tenons in 60 seconds!

**Leigh Jigs make it easy: One guide, one bit, one setup for perfect joints every time. Make tables, chairs, beds, chests, cabinets and so much more!**



### JIG FEATURES

- 68 joint sizes from 1/16" x 1/8" up to 1/2" x 5" [79 metric joint sizes from 2x4mm up to 12x130mm] using 21 standard guides (24 metric)
- Custom joint sizes up to 1/2" x 5" [12x130mm] can also be achieved
- 6 optional specialty guides make square tenons, louver doors, Y-axis 90° mortise
- Single, double (in line and side-by-side), triple, quadruple joints
- Recordable, repeatable fit adjustment
- Angled and compound angled joints
- Works with virtually any plunge router
- Heavy gauge steel frame (Super FMT)
- CNC machined alumin. frame (FMT Pro)
- Multi-position clamping
- Clamp boards up to 3" x 5-1/2" [76 x 140mm]
- Easy and precise joint sighting

### STANDARD EQUIPMENT

- Universal sub-base that attaches to virtually any plunge router
- Two F-Clamps (Super FMT); Cam-action speed clamps (FMT Pro)
- Joint guide stand
- 5/16" HSS spiral upcut bit, 1/2" shank
- Two outrigger bars (FMT Pro only)
- Adjustable side stop fence for tenoning
- Screwdrivers and mounting hardware
- Illustrated user guide

Visit [www.leighjigs.com](http://www.leighjigs.com) for more details