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.

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

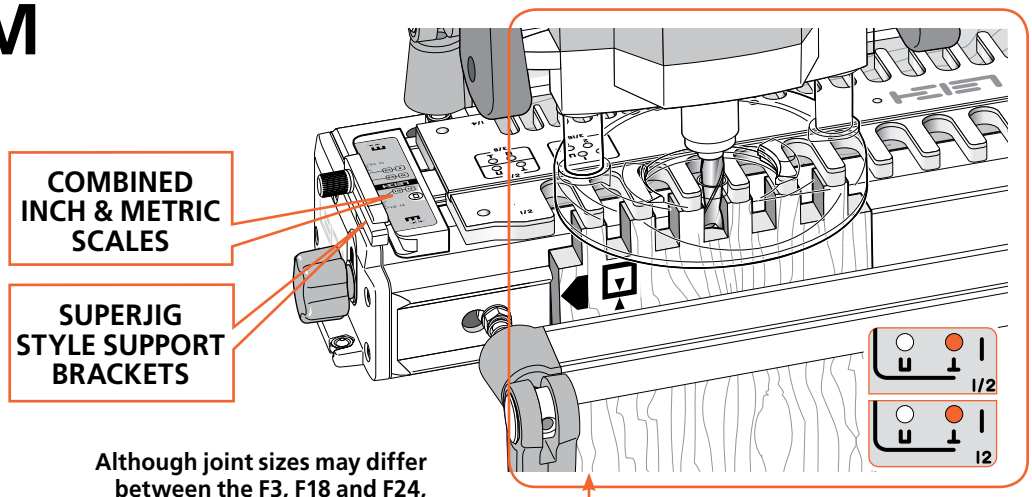
LEIGH FINGER (BOX) JOINT SIZES

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

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

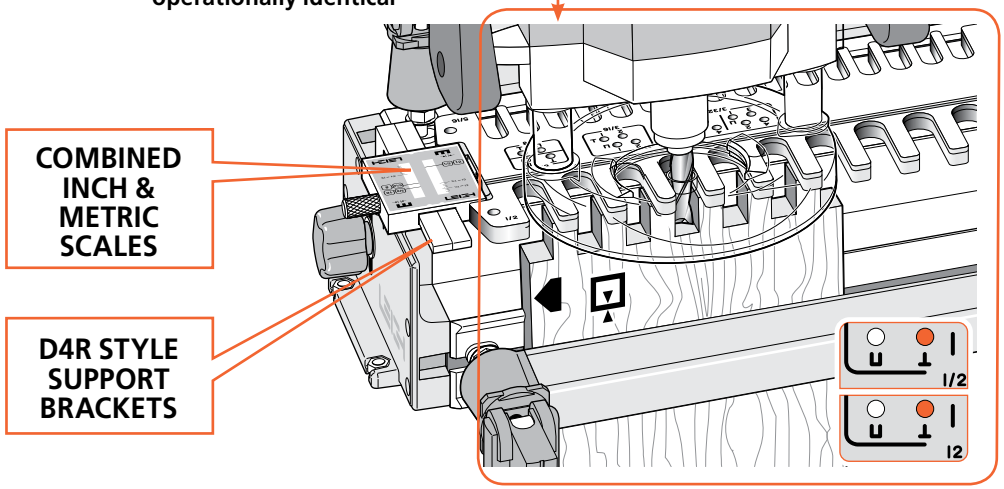
No. While the F18 and F24 are illustrated for most of the procedures in this guide, the differences between the F3 and the F18/24 do not affect the operational instructions. Movements and settings illustrated in each step are identical whether performed on the F3/F3M, F18/24, or F18M/24M. Icon types for template pin positions are the same on all templates.

F18/F18M



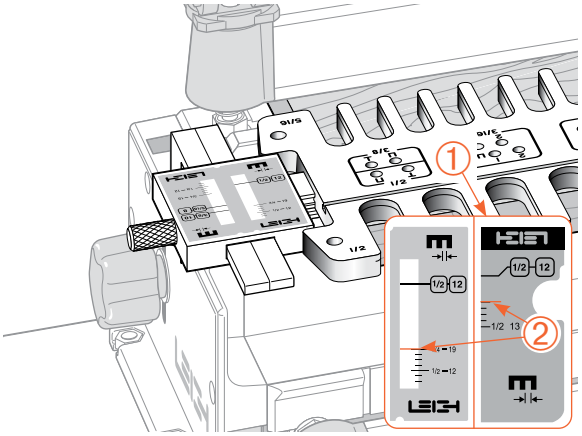
Although joint sizes may differ between the F3, F18 and F24, everything in these frames is operationally identical

F3/F3M



Important: Inches and Millimeters

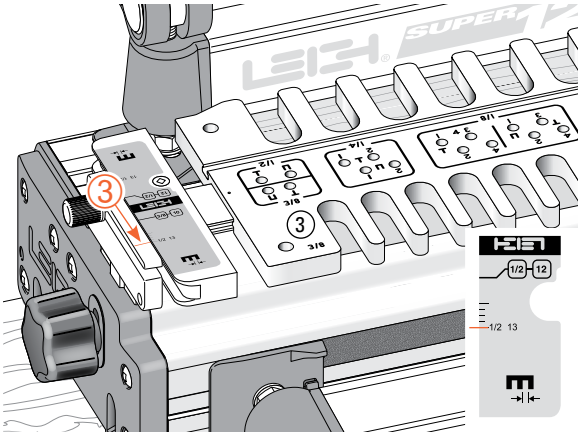
Because Leigh makes F3, F18 and F24 Templates in inch and metric models, measurements in this user guide are shown in both inches and millimeters. Dimensions are indicated with "inches" first, followed by “millimeters” in square parentheses.
Example: ½"[12mm], or ¾"x 5½"x 8"[20x140x200mm].
Do not be concerned if the inch/millimeter equivalents are not always exact. Just use the dimensions which apply to your jig.



Reading the Settings Illustrations

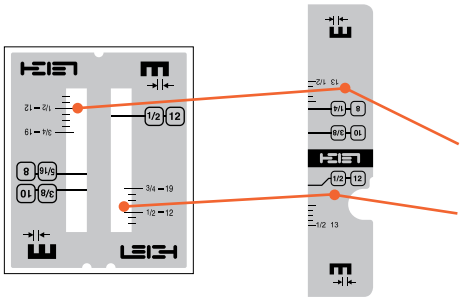
The F Template scales have dual markings for inch and metric.
Note: The scales on some templates may indicate a ¼"[6mm] size. This comb size is only available on F1600 Templates.

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.

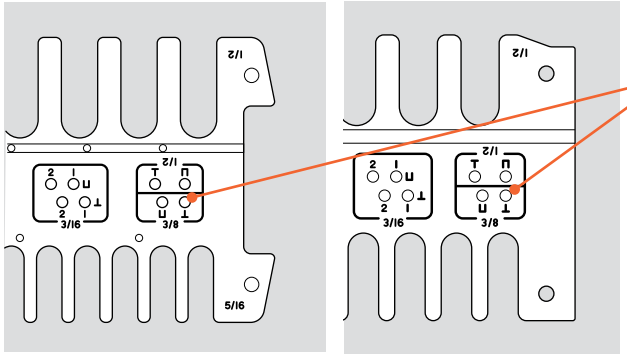


When calibration marks on the support brackets ③ are highlighted, they are illustrated in red for clarity. **On the jig, the lines are *black*.**

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.

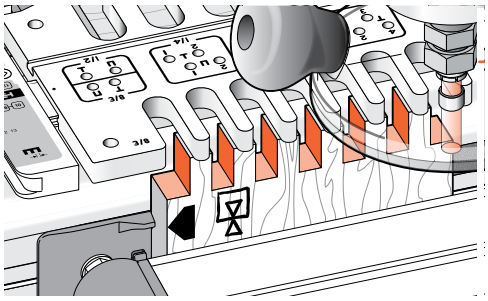


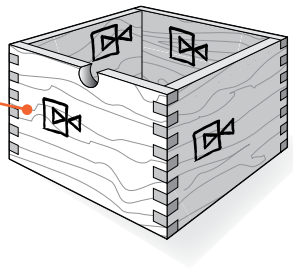
Template Icons and Numbers (engraved)

Template positioning holes (see page 7)

Which Way Round Should the Board Go?

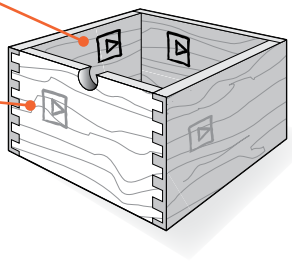
We devised these icons to indicate which side of a board faces out (toward you when it is clamped in the jig), and which faces are in or out when assembled.





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

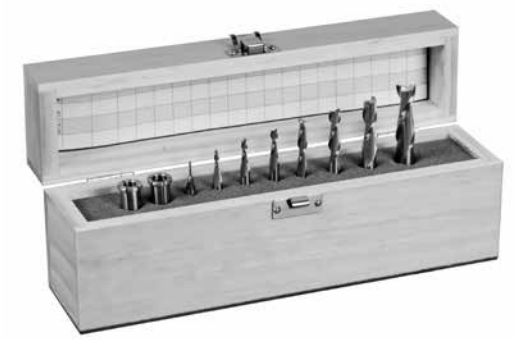
± Plus/Minus

= Equals

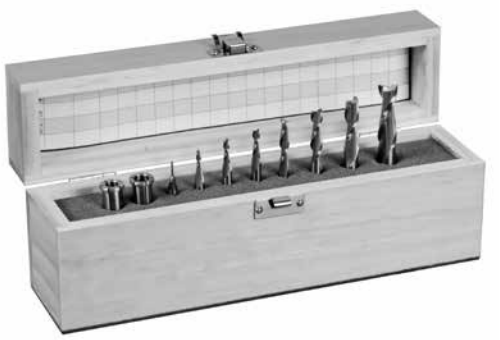
Leigh Bit Sets make your jig even more versatile, and offer great savings and a free bit box!

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. Sets are available in either quality high speed steel or longer lasting solid carbide.

FOR THE **F3**

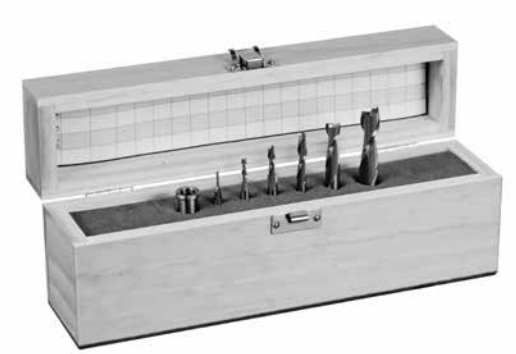


1608F High Speed Steel Boxed Bit Set, 10 pc
Features 7 two-flute HSS spiral upcut bits and 1 single-flute (Bit 163). Set includes bits 163 (3/32"), 164 (1/8"), 165C (5/32"), 166 (3/16"), 168 (1/4"), 170 (5/16"), 173 (3/8"), 180 (1/2") and two collet reducers 172-8 (1/2" to 5/16") and 172-375 (1/2" to 3/8").

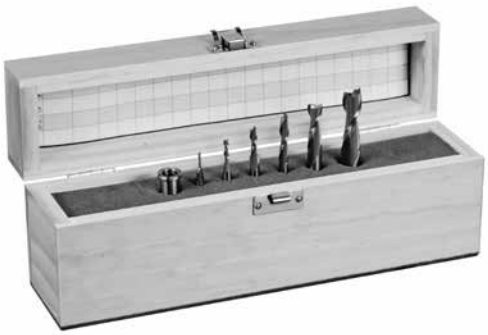


1608C Solid Carbide Boxed Bit Set, 10 pc
Features 7 two-flute solid carbide spiral upcut bits and 1 single-flute HSS (Bit 163). Set includes bits 163 (3/32" HSS), 164C (1/8"), 165C (5/32"), 166C (3/16"), 168C (1/4"), 170C (5/16"), 173C (3/8"), 180C (1/2"), and two collet reducers 172-8 (1/2" to 5/16") and 172-375 (1/2" to 3/8").

FOR THE **F18/24**



1806F High Speed Steel Boxed Bit Set, 7 pc
Features 5 two-flute HSS spiral upcut bits and 1 single-flute (Bit 163). Set includes bits 163 (3/32"), 164 (1/8"), 166 (3/16"), 168 (1/4"), 173 (3/8"), 180 (1/2"), and collet reducer 172-375.



1806C Solid Carbide Boxed Bit Set, 7 pc
Features 5 two-flute solid carbide spiral upcut bits and 1 single-flute HSS (Bit 163). Set includes bits 163 (3/32"), 164C (1/8"), 166C (3/16"), 168C (1/4"), 173C (3/8"), 180C (1/2"), and collet reducer 172-375.