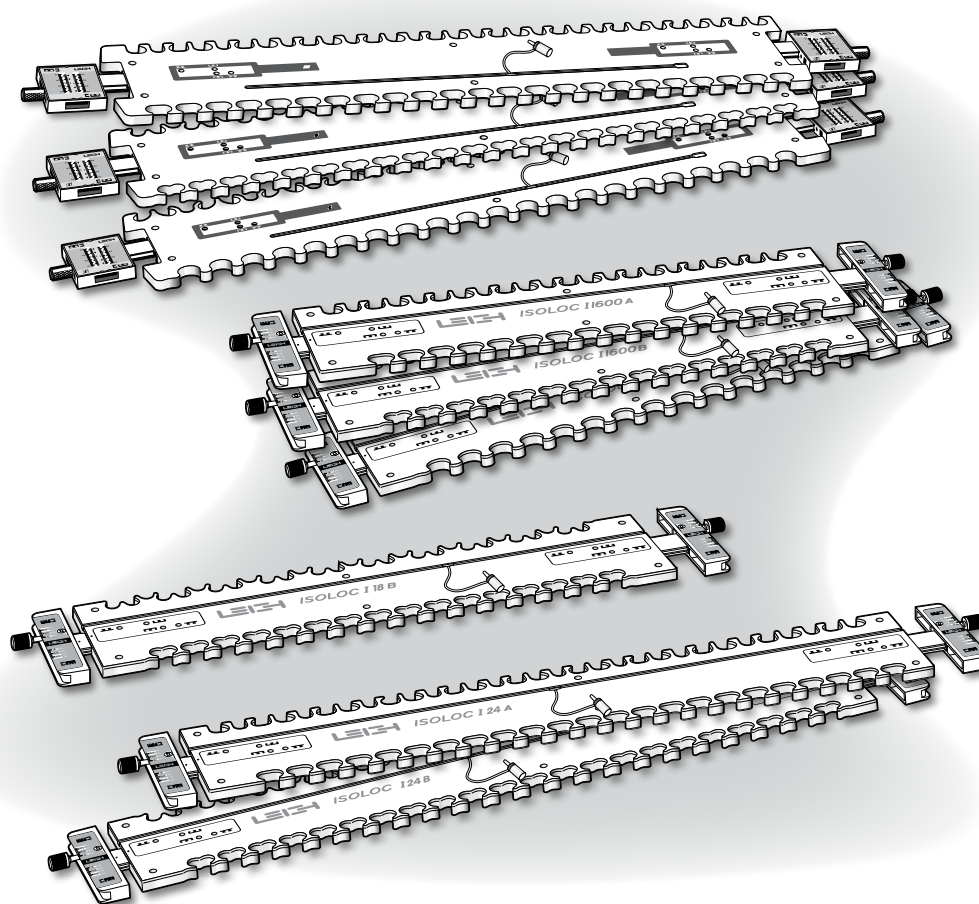


# Leigh Isoloc Joint Templates

**I1A I1B I1C I18B I24A I24B I1600A I1600B I1600C**

**User Guide**

*Templates for Leigh D-Series and Super Jigs Dovetail Jigs*



See page 55 for customer support

**800-663-8932**

**LEIGH** Leightools.com

Preface	Introduction .....	1
CHAPTER 1	- Mounting and Template Alignment .....	5
CHAPTER 2	- Using Your Template Safely.....	11
CHAPTER 3	- Operation Concepts & Basic Template Functions .....	13
CHAPTER 4	- The Variable Guidebush System (VGS) .....	17
CHAPTER 5	- Board Width Selection .....	19
CHAPTER 6	- Half-Blind Isoloc Joint Procedures .....	23
CHAPTER 7	- Rabbeted Half-Blind Isoloc Joint Procedures .....	29
CHAPTER 8	- Inlaid Half-Blind Isoloc Joint Procedures .....	31
CHAPTER 9	- Through Isoloc Joint Procedures.....	37
CHAPTER 10	- Isoloc Joint Symmetry and Asymmetry .....	39
CHAPTER 11	- Routing Procedures Hints and Tips .....	41
Appendix I	- VGS Guidebush and Bit Selection.....	45
Appendix II	- Joint Specifications .....	49
Appendix III	- Template Parts List.....	51
Appendix IV	- Customer Support.....	55

## Your New Leigh Isoloc™ Joint Template

The Leigh Isoloc\* (equal locking) Templates and Variable Guidebush System (VGS)\* are used on all 16" and 24" D-Series jigs, and the 18" and 24" Super Jigs. They will allow you to rout uniquely beautiful half-blind corner joints, plus end-on-end, all with perfect fit thanks to the VGS.

This user guide is common to all Leigh Isoloc joint templates listed in this guide. Almost all illustrations show only the "A" template mounted on the D4 jig in the "Key" joint pattern mode. However, the joint icons ① are identical on all templates and all Isoloc templates work in exactly the same way ...regardless of the jig or template model.

Note that the drawings in this user guide depict earlier model templates. The latest templates are engraved, with no decals ③.

The I1 template scales are different in shape than the I1600, I18 and I24 scales. Where scale readings are illustrated, the I1 scale will appear at the top ②.

Isoloc joint templates have dual inch and metric settings and may be used with either  $\frac{5}{16}$ " or 8mm diameter bits. Only one variable guidebush (No. 713V; included) is required.

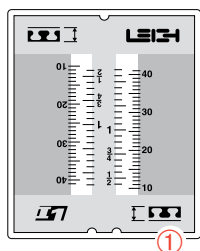
Carefully follow the mounting instructions for your jig model in the first section of the user guide. Then read the rest of the guide, following along with the basic functions. We suggest you rout some practice joints in scrap wood before you rout any precious hardwood work pieces.

**Note:** All operating references to D1600 jigs and I1600 templates throughout this guide apply equally to the I18 and I24 templates on Leigh Super Jigs.

## Customer Support

If you have any questions that are not answered in this user guide, please call Leigh Customer Support: 1-800-663-8932 in North America or email: [help@leightools.com](mailto:help@leightools.com). For support contacts in your country of purchase, see Customer Support at the end of this Guide. Leigh user guides are updated as required. A downloadable pdf of the latest version can be found on the Support page at [leightools.com](http://leightools.com).

\* Leigh Isoloc joints, Isoloc templates, and Variable Guidebush System are protected by U.S., Canadian and European patents.



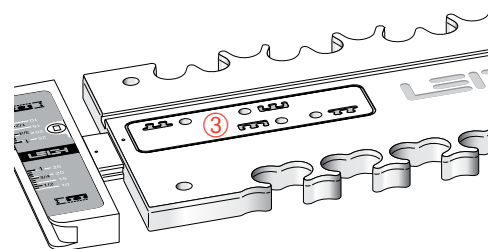
I1 Scale



I18, I24 Scale



Illustrated

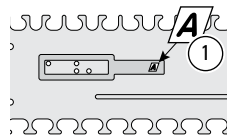


Engraved template

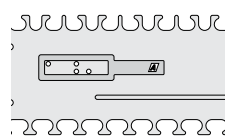
## How to Read the Symbols

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 and are repeated frequently in the user guide, and you will soon get used to them.

There are three templates in the Isoloc Series. Each template has two Isoloc joint patterns for a total of six available joint shapes. Each template is identified by letter; A, B, or C ①, and each joint pattern is named in texts for reference, as below:



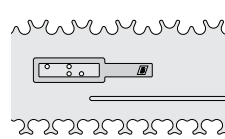
Only the Isoloc **A** “Key” template pattern is used in this user guide. Procedures for all other joints are similar.



“Mirror Key”

**A**

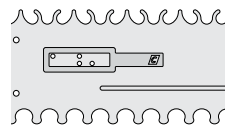
“Key”



“Bears Ears”

**B**

“Clover”



“Wave”

**C**

“Ellipse”

## Scale Icons



The scales all feature the same icon which (this way up) indicates the active scale.

## Template Icons



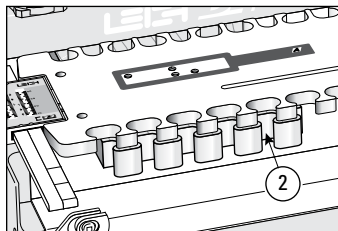
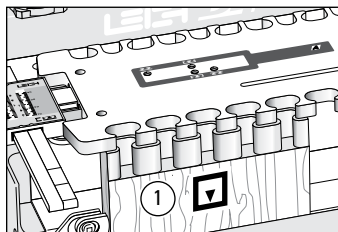
Indicates the template position for vertical pin boards.



Indicates the template position for horizontal socket boards.

## Isoloc Joint Terminology

It's a novel joint with a unique name, but we thought we would keep the joint part terminology simple. It is similar to typical dovetail terminology and should be easy to remember. Straight parts, cut in line with the grain are "pins" ①. Curved parts, cut across the grain are "sockets" ②.



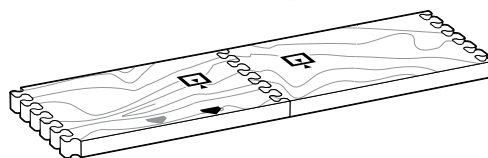
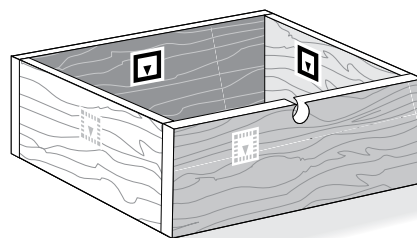
## Board Faces

Most joinery done on the Leigh Isoloc templates is for boxes. In nearly all the illustrations we have indicated which side of the board faces you when it is in the jig. *Note: On all Isoloc joint boards except end-on-end joints, the inside ▣ of the board faces away from the jig body.*

▣ Indicates the side of the board that will face outward.

▣ Dotted icons are on the other side of the board.

▣ Boards are clamped in the jig both "face in" and "face out" for alternate end cuts; e.g. all regular end-on-end Isolocs are routed this way.



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

⊙ Centreline of board or layout

± Plus/Minus

= Equals

≠ Does not equal

~ Approximately

This page is left blank intentionally.