

Mounting and Template Alignment

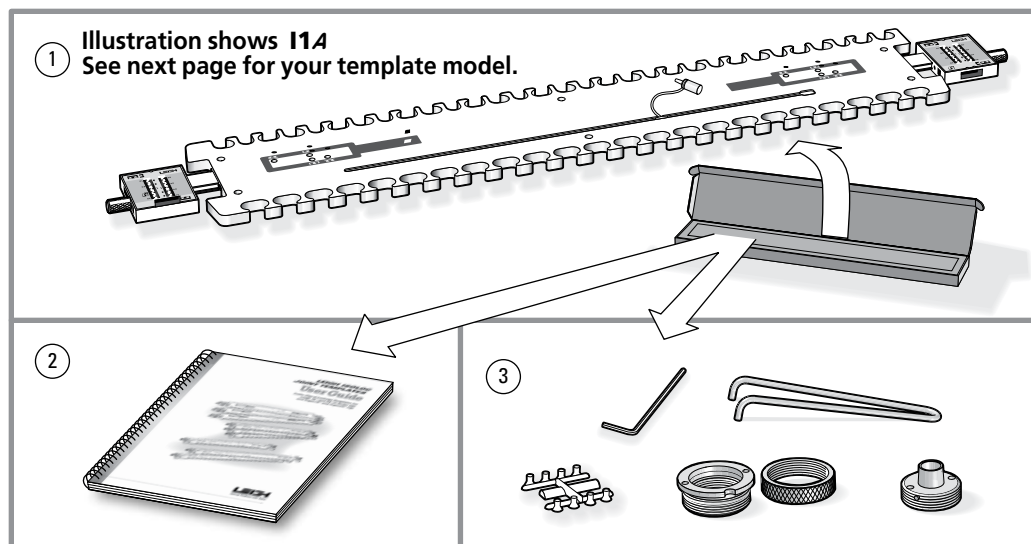
Assembly and Mounting

First, before you begin mounting your Leigh Isoloc template to your Leigh jig, make sure you have all the necessary parts.

1. **One only** complete Isoloc template assembly.
Make sure it is the model you ordered (see next page).
2. 1 User Guide
3. Variable Guidebush System consisting of:
 - 1 713V Guidebush
 - 1 700V Holder complete with lock ring
 - 1 Pin Wrench
 - 6 Bush Plugs (on one tree)
 - 1 Allen Key (for use on I1A, I1B and I1C Templates only)

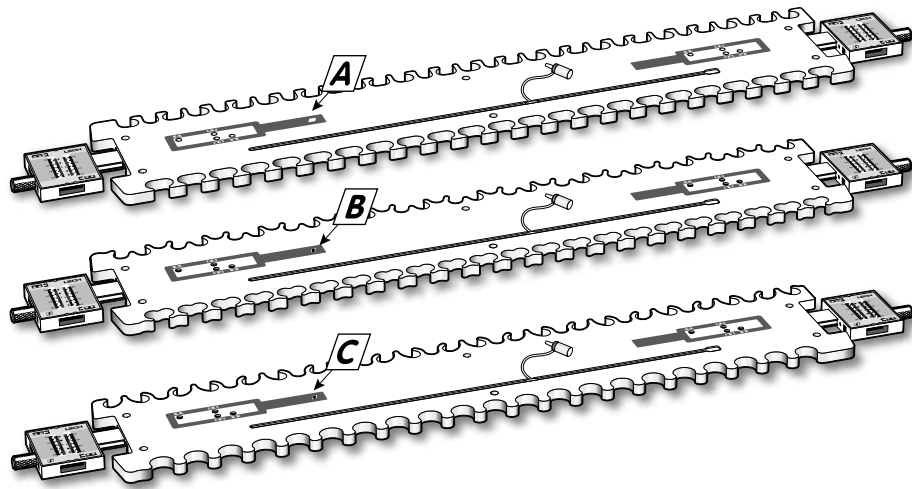
If any of these items are missing from your order, please notify your supplier or Leigh Industries immediately.

Your Leigh Isoloc template comes fully assembled and requires only mounting and indexing to your Leigh jig body. **This procedure is critical to the accuracy of the finished joinery, so please follow the mounting instructions carefully.**

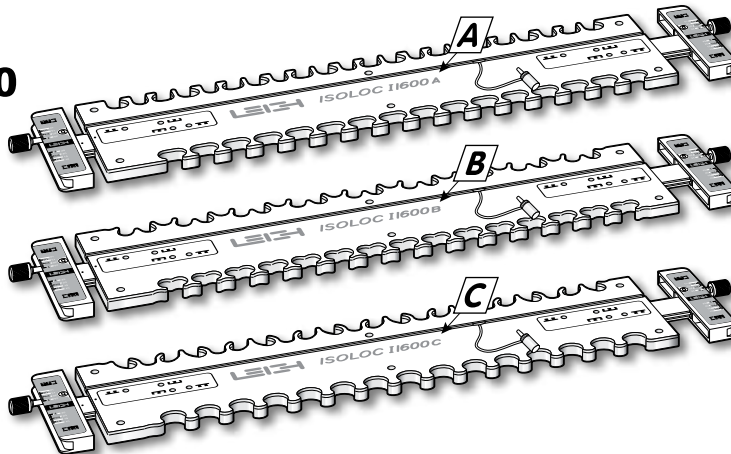


Check that you received one of the templates shown below:

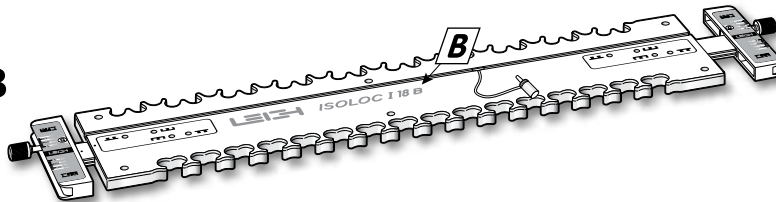
I1



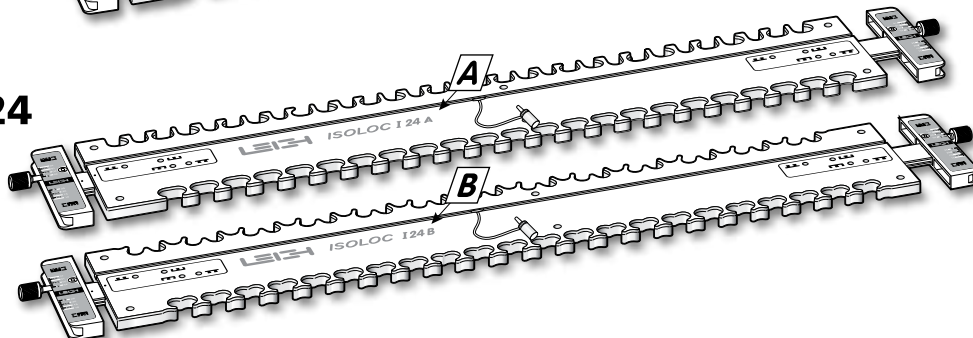
I1600

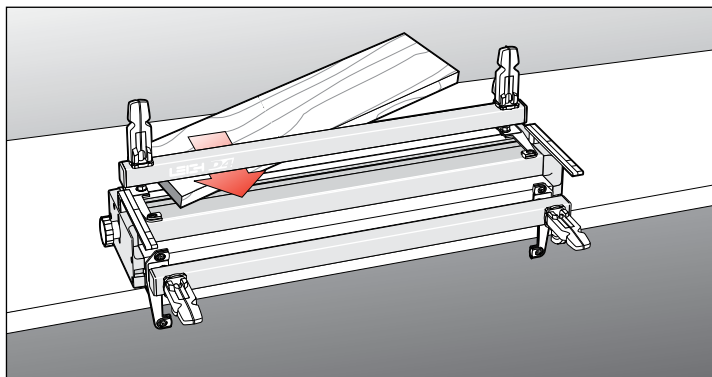


I18



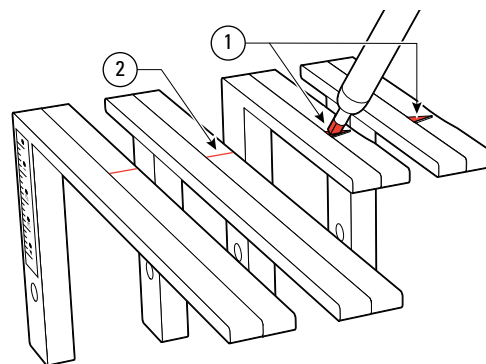
I24



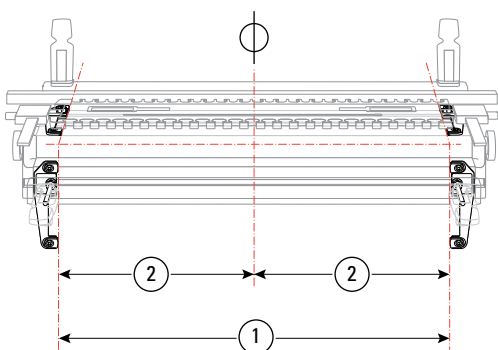


1-1 Mounting the 24" Template

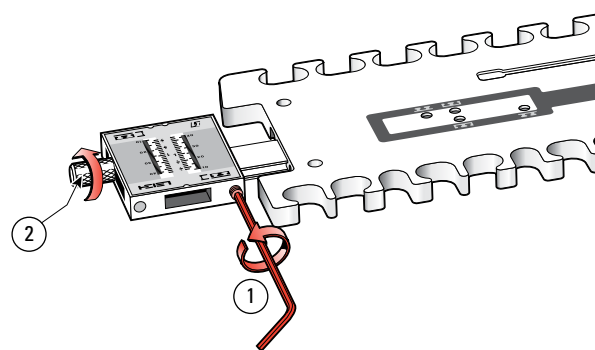
For I1600, I18 and I24 Isoloc mounting go directly to 1-10. Mount the 24" D Series dovetail jig body firmly to a bench as per that jig's instructions. Clamp the spacer board into the rear clamp. The spacer board should be approximately $\frac{3}{4}$ " x 6" x 23" [20 x 150 x 575mm].



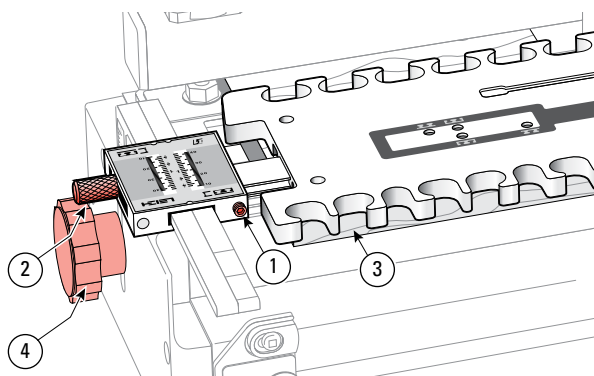
1-2 Support Bracket Markings D1258, D1258R and D3 jigs have short brackets marked with an 'arrow' for scale line-up. Shade the arrows with a black felt pen ① for better visibility. D4 and D4R jigs have either long or short brackets with lines ② in the correct location. Brackets supplied with the optional M2 or VRS systems may be used as is.



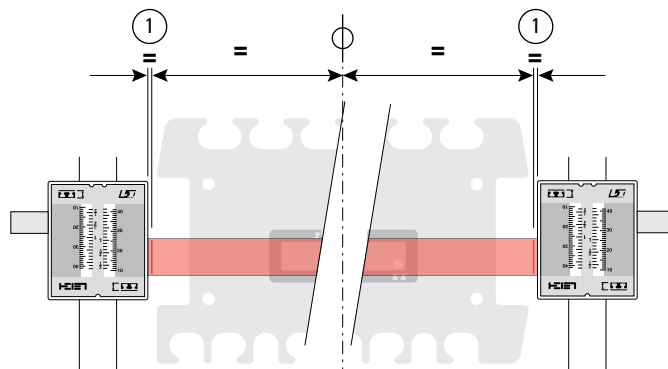
1-3 To ensure the accurate joints your Leigh Isoloc was designed to produce, check that the jig side stops are correctly positioned as per the original jig body instructions, i.e. $24\frac{1}{8}$ " [613mm] apart ① and equidistant from the centreline ②. D4R side stops are machined as part of the body.



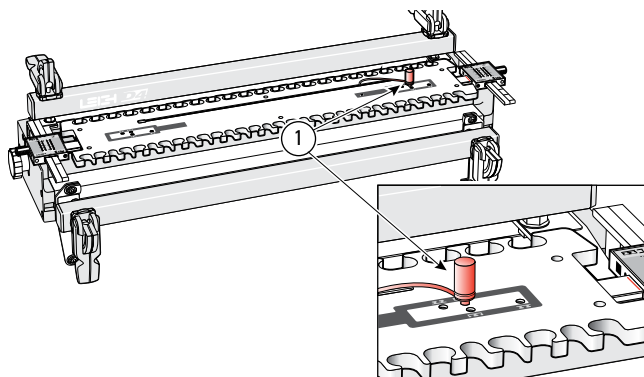
1-4 Loosen the two scale bar set screws ①, and the two scale thumb screws ② at both ends of the template.



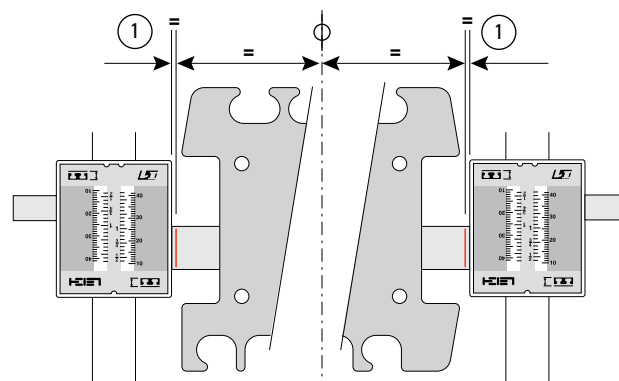
1-5 Slide the template assembly onto the jig support brackets with the set screws ① toward you and lower the completed assembly gently onto the spacer board ③. Tighten the support bracket knobs ④. **Do not tighten the set screws ①.** Make sure the scale reading is the same on both scales, say on the 1" [25mm] mark, then tighten the thumb screws ②.



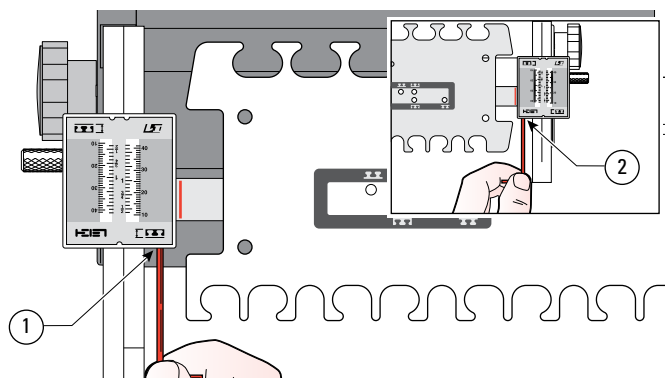
1-6 The template bar must now be centred between the two scale assemblies ①. The following instructions show how to do this.



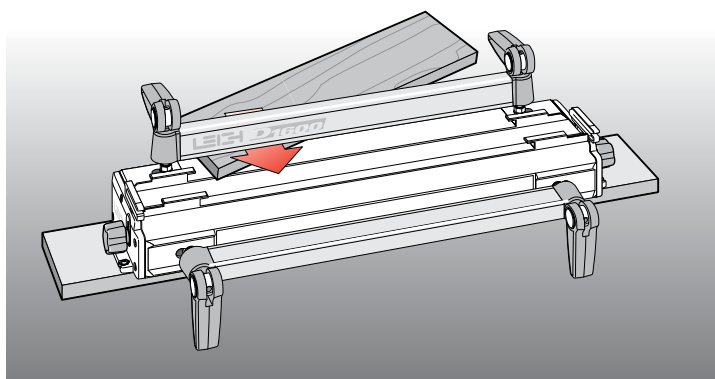
1-7 Discard the plastic shipping plug from its hole in the template. Move the template until you can insert the template pin through the rear right hand hole ① and into the bar.



1-8 Move the template with its template bar left and right in the scales until the scored lines at each end of the bar are approximately equidistant from the scales ①. You can do this by eye; the human eye is an excellent comparator. If the gap appears the same, it is close enough. If you're more comfortable using a rule or dial caliper, by all means use it. *Note: The scored lines are illustrated in red for clarity.*

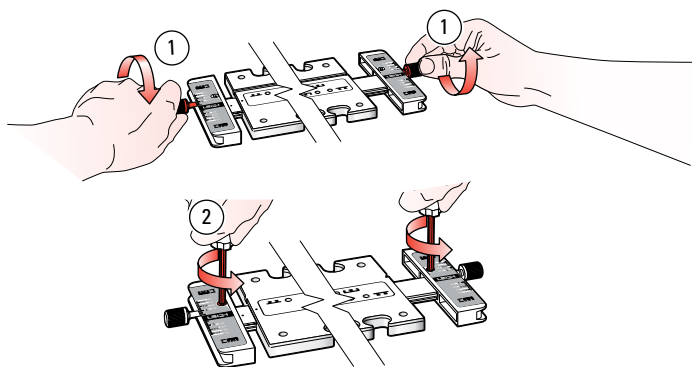


1-9 Taking care not to move the template and template bar, tighten first one scale bar screw ①, then the scale screw at the other end ②. The template bar is now centred.



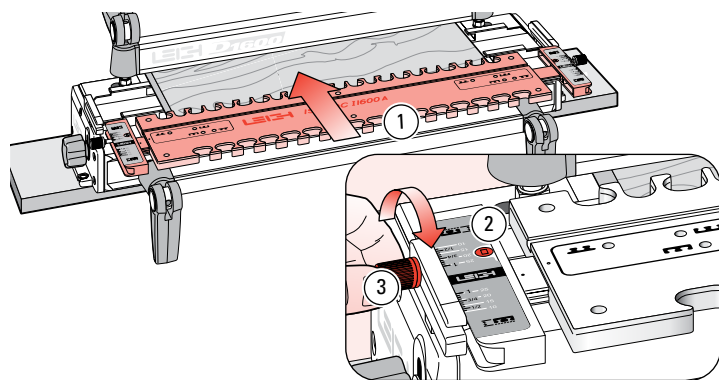
1-10 Mount a Superjig or D1600 jig body firmly to a bench as per that jig's instructions. Clamp the spacer board into the rear clamp.

The spacer board should be approximately $\frac{3}{4}$ " x 6" [20 x 150mm] x 1" [25mm] less than jig length.

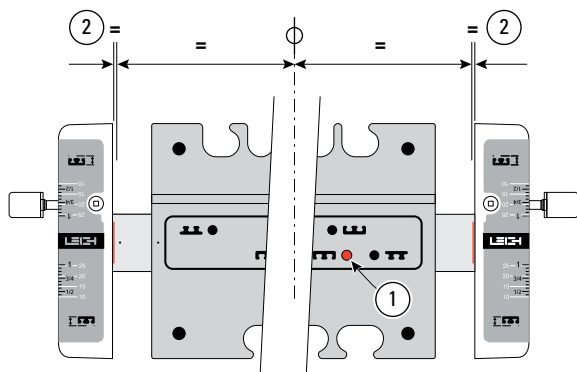


1-11 Mounting I1600, I18, and I24 Isoloc Templates

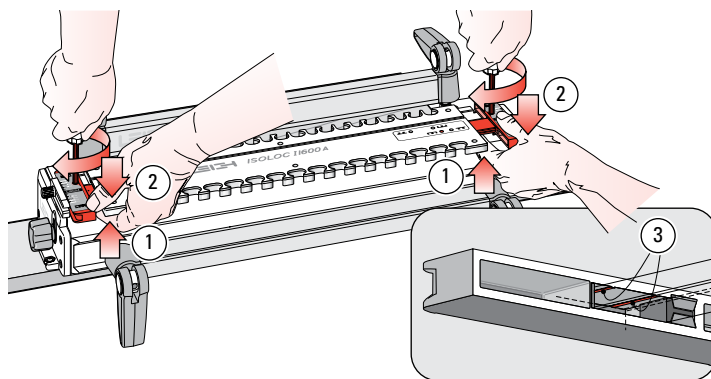
Install the two thumbscrews a few turns into the scales ①. Loosen the scale lock screw ② at both ends (by one turn only).



1-12 Slide the finger assembly onto the support brackets, in the "single" joint pattern (key, clover or ellipse) to the front ① and the scale lock screw to the rear ② and set on $\frac{3}{4}$ " [20mm]. **Tighten both thumbscrews ③.**



1-13 Lower the template onto the spacer board. Discard the plastic shipping pin from its hole in the template. Move the template until you can insert the steel template pin through the right front hole ①. Move the assembly left and right until the scored lines ② (illustrated in red for clarity) at each end of the template bar are about equidistant from the scales. You can do this by eye. If the gap appears the same, it is close enough. If you are more comfortable using a rule or caliper, by all means use it.



1-14 Taking care to not move the template, pull up on the template bar ① while pushing down on the scale ② to ensure the bar is touching the two registration pads ③ inside the scale. Maintain pressure and tighten the scale lock-screw. Repeat at the other end. The template is now centred.

To maintain correct assembly alignment, follow this procedure whenever you remove the scales from the template assembly. ■

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