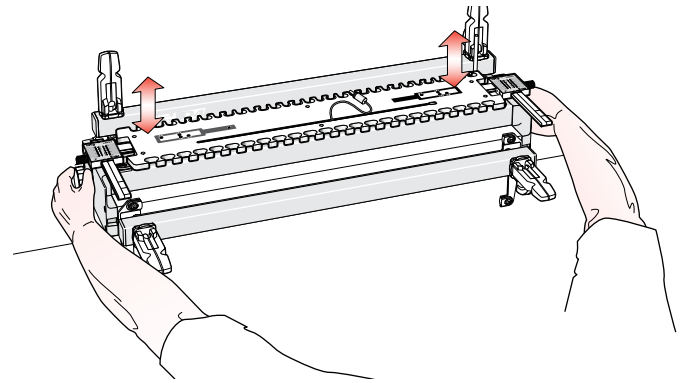
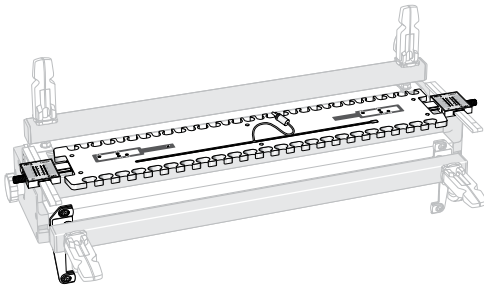


## Operation Concepts and Basic Template Functions

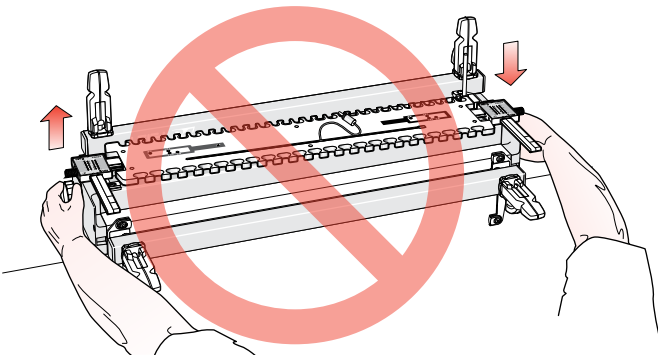
### There are:

Three 24" I1 Isoloc templates, three 16" I1600 templates, one 18" I18 template, and two 24" I24 templates.  
This user guide is common to all; the routing procedures for all Isolocs are identical.

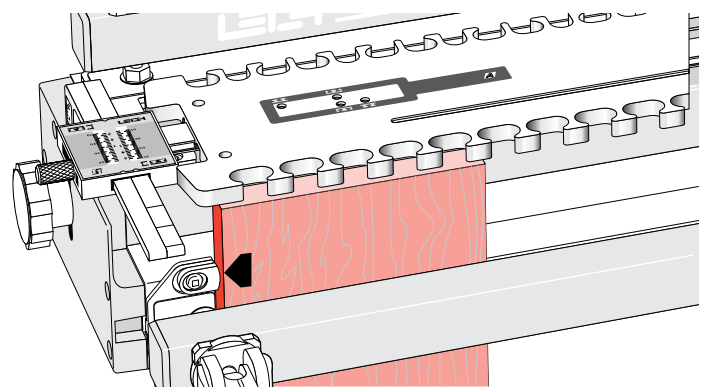


**3-1** Each Isoloc template has two different joint patterns. The “active” pattern (the one you wish to use) is positioned toward you at the front of the jig. Always start at the left hand side of the template using the left hand side stops.

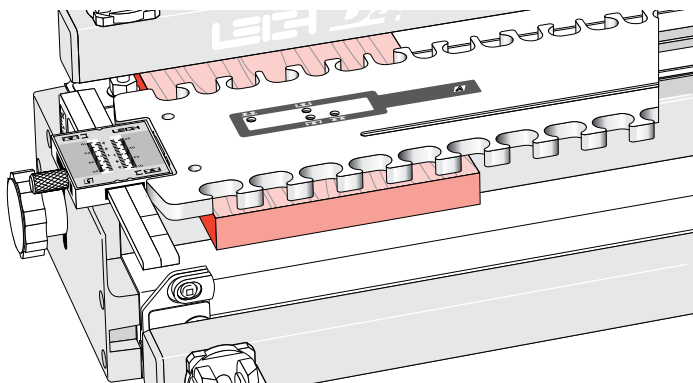
**3-2** The template is raised or lowered using the support brackets to suit different thicknesses of horizontal boards.



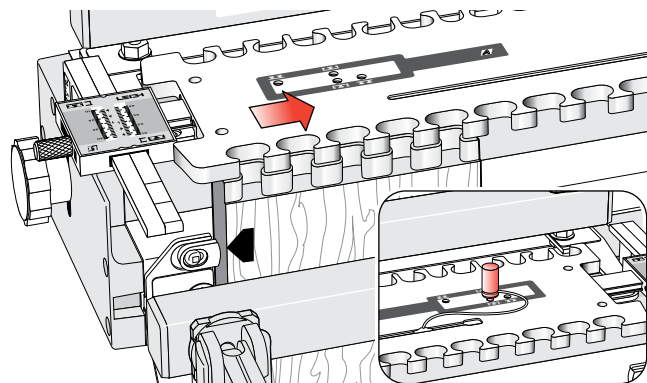
**3-3** Do not raise or lower one end of the template at a time.



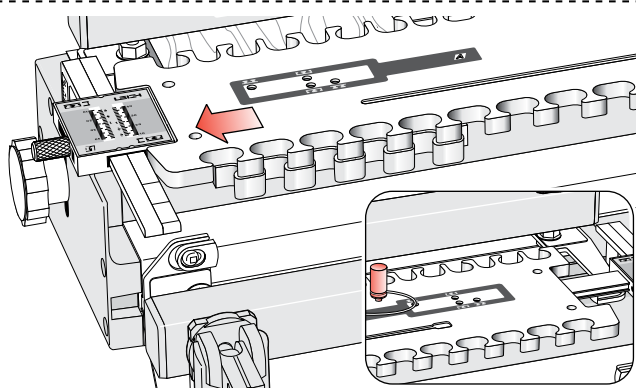
**3-4** You will clamp your work pieces against the left hand front side stop or...



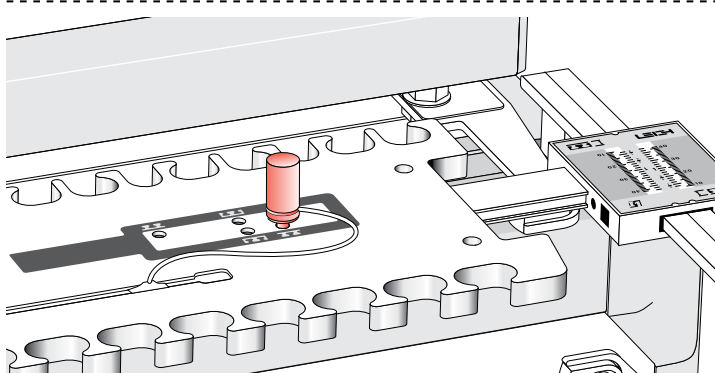
**3-5** ...the mating left hand rear side stop, depending on which procedure is to be used. *Note: Except where specific procedures call for blocking or spacing away from the side stops.*



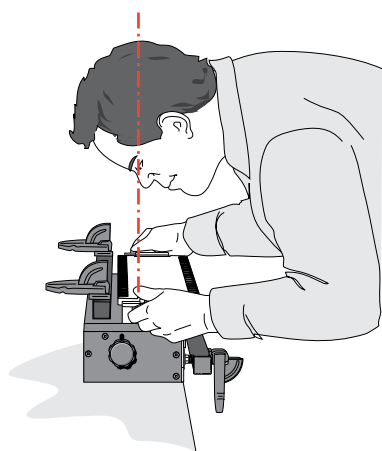
**3-6** Mating joints routed under the same pattern have to be offset to achieve correct joint alignment. On the Leigh Isoloc templates the offset is achieved by moving the template left or right by half the pitch of the pattern. This movement is controlled by the template pin, at the opposite end of the template. Here, the vertical pin board is routed.



**3-7** In this illustration, the template is moved to the left by half the pattern pitch to rout the mating horizontal socket part of the joint in 3-6. The precisely machined template pin holes always ensure exact template position.

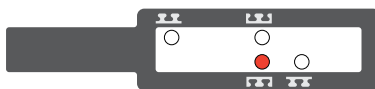
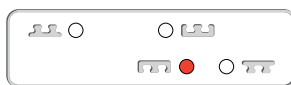


**3-8** The active template pin holes are always at the right hand end of the template, out of the way of the router. Use only the pin holes closest to the front, or active joint pattern. On wide boards, the pin is moved from the right end hole to the matching left end hole to allow the router access to the right side of the board. Most illustrations will have an inset showing the correct template pin hole position for the procedure. ■



Always read scales from directly overhead to avoid parallax problems.

I1

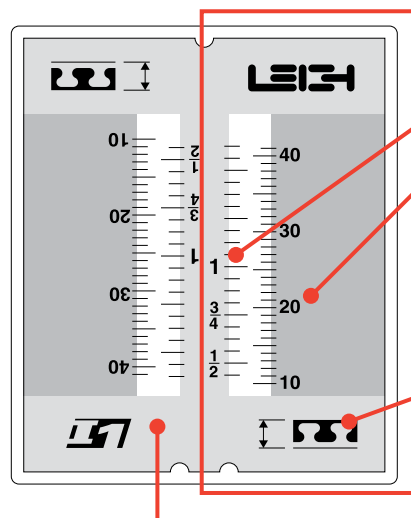
I1600  
I18  
I24

Template pin hole icons denote the joint edge finish at each position. See Chapter 5 for notes on symmetry and board widths.

Throughout the user guide, the proper pin location for each step is highlighted in red. Use only the pin holes closest to the front (active) joint pattern.

### All Leigh Isoloc templates are calibrated for both inch and metric use.

The specific settings for each scale are fully described in the appropriate chapters.



#### Isoloc I1 templates

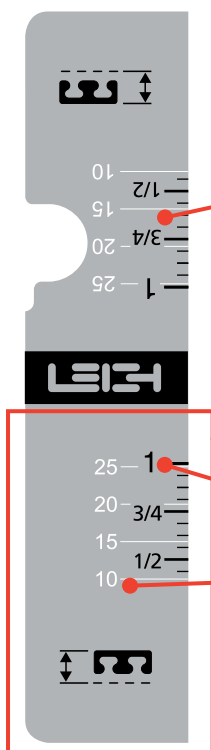
Grey scales are in inches.

Green scales are in millimetres.

The active scale is always on the right side of each scale assembly. Dimensions are for matching to the vertical board thickness.

The icon and dimension arrows are a simple reminder of this.

The inactive scale is always on the left side of each scale assembly and appears upside down.



#### Isoloc I1600, I18 and I24 templates

The inactive scale is always on the top side of the scale assembly (away from you) and appears upside down.

The active scale is always on the bottom of each scale assembly (toward you). Numbers are for matching to the vertical board thickness.

Inch scales have black numbers.

Millimetre scales have grey numbers.

The icon and dimension arrows are a simple reminder of this.

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