

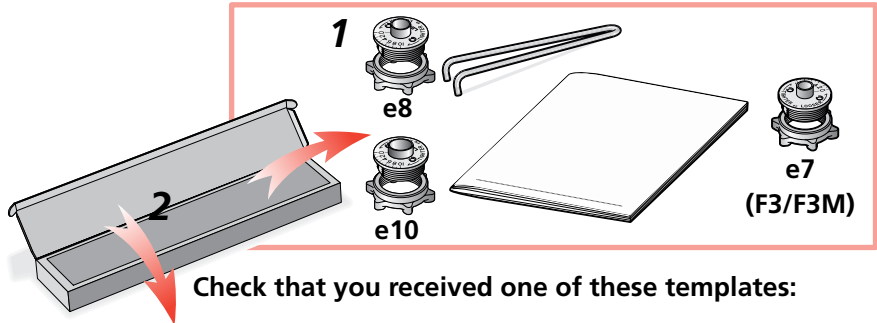
CHAPTER 1

Assembly, Mounting and Template Alignment

Assembly and Mounting

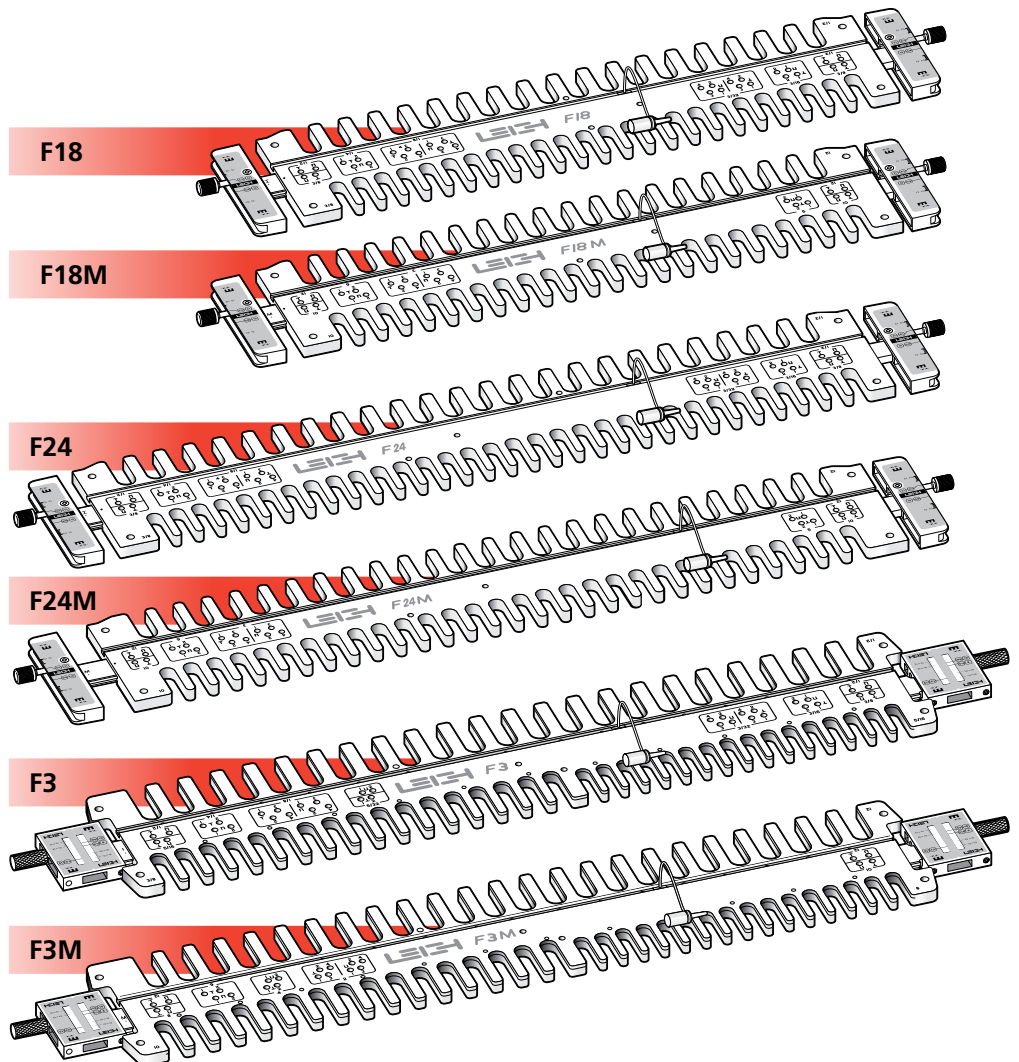
Before you begin mounting the Leigh Finger Joint Template to your Leigh Jig, make sure you have received the model ordered (Inch or Metric), and all the necessary parts.

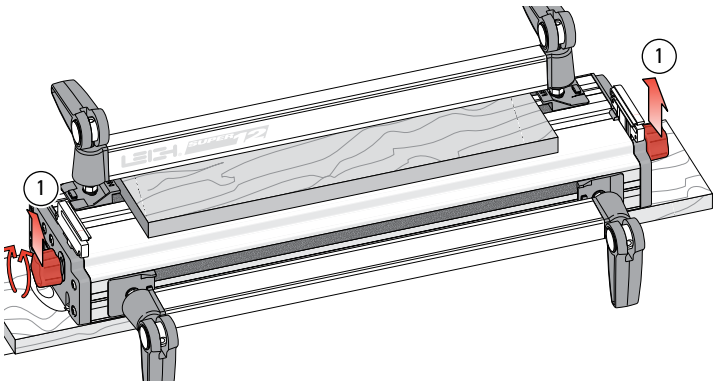
1. 1 e7-Bush incl nut (F3 only)
 1 e8-Bush incl nut
 1 e10-Bush incl nut
 1 Pin Wrench
 1 User Guide
2. 1 Template “inch” assembly,
 or:
 1 Template “metric” assembly



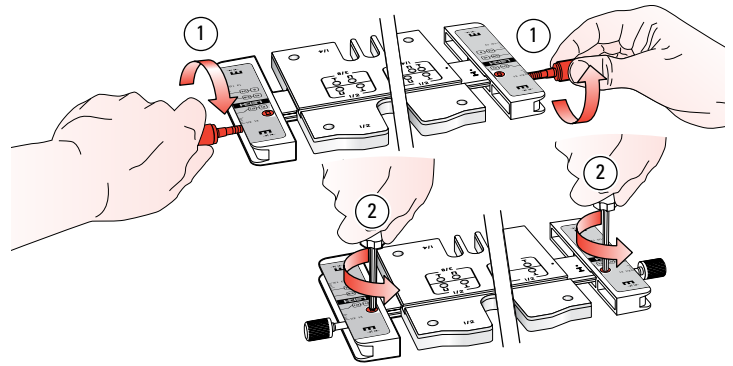
If any of these items are missing, please notify your supplier or Leigh Industries immediately.

Except for the scale thumbscrews (packed in a bag attached to the template), your Leigh F-Template comes fully assembled and requires only mounting and indexing to your Leigh jig. **This procedure is critical to the accuracy of the finished joinery**, so please follow the mounting instructions carefully.

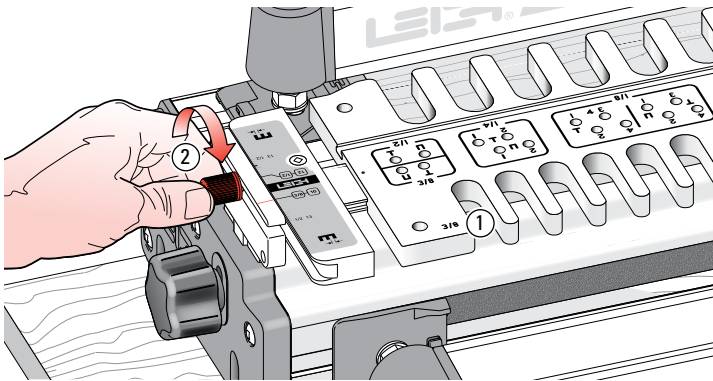




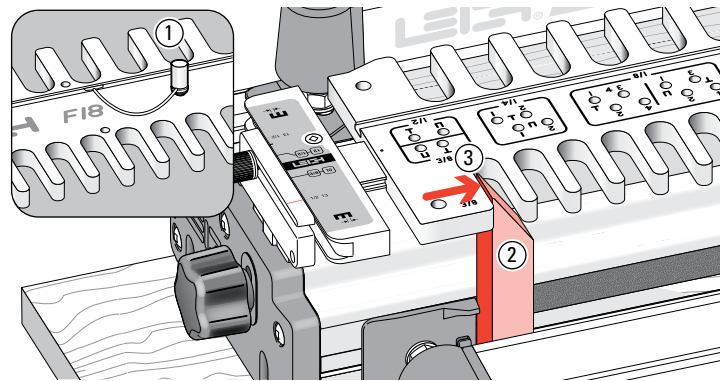
1-1 Super18 & Super24 Jig Owners D-Series jig owners go straight to 1-6.
Raise both end support brackets and tighten the support bracket knobs ①.



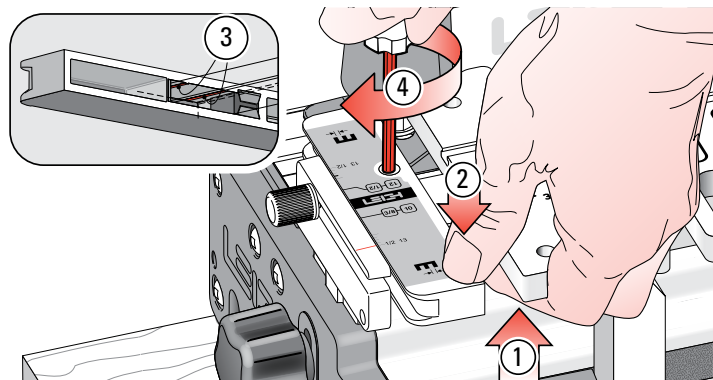
1-2 Install the two thumbscrews a few turns into the scales ①. Loosen the scale lock screw ② at both ends (by one turn only).



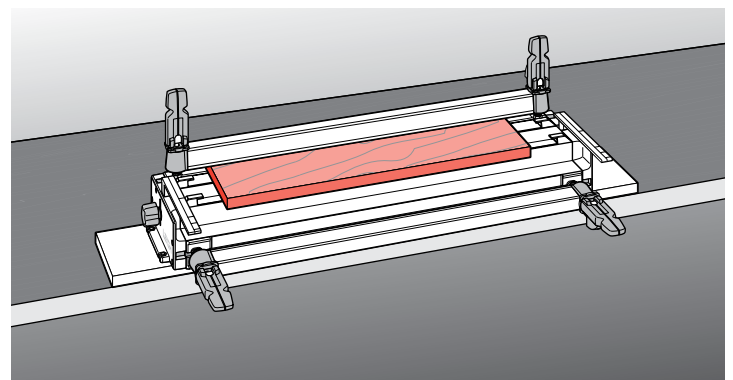
1-3 Slide the template onto the support brackets, with the $\frac{3}{8}$ " [10mm] comb toward you ① and set on the $\frac{3}{8}$ " [10mm] setting. Tighten both thumbscrews ②. Do not lower the assembly onto the finger support board.



1-4 Align the template so that its centre hole aligns with the hole in the bar and firmly insert the template pin ①. Angle trim the end of a straight block and clamp it tight against the left stop; the top protruding into the last $\frac{3}{8}$ " [10mm] opening ②. Move the combined assembly to the right until the left side of the opening touches the block ③. Taking care to not move the template assembly...

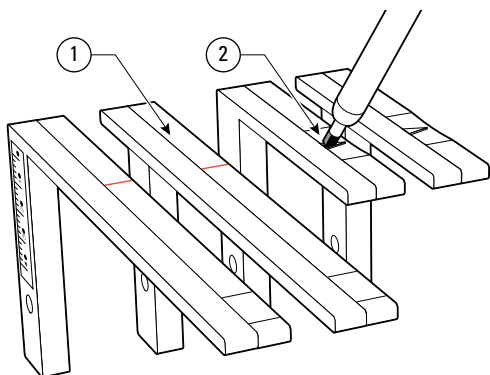


1-5 ...pull up on the template bar ① while pushing down on the scale ② to ensure the bar is touching the two registration pads ③ inside the scale. Maintain pressure and tighten the scale lock-screw ④. Repeat at the other end. Remove the block and your template is ready to use. To maintain correct template alignment, follow this procedure whenever you remove the scales from the finger assembly.

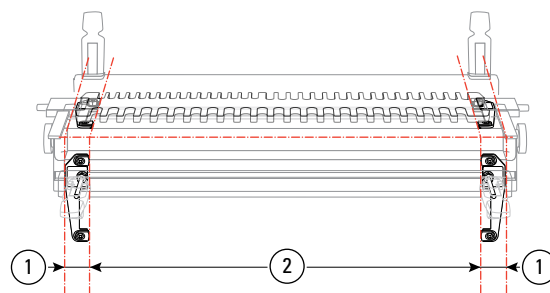


1-6 Mounting F3/F3M to D-Series Jigs

Procedure is the same for Inch and Metric 24" templates. Make sure your jig is mounted as per its User Guide, and the spacer board is clamped into position.



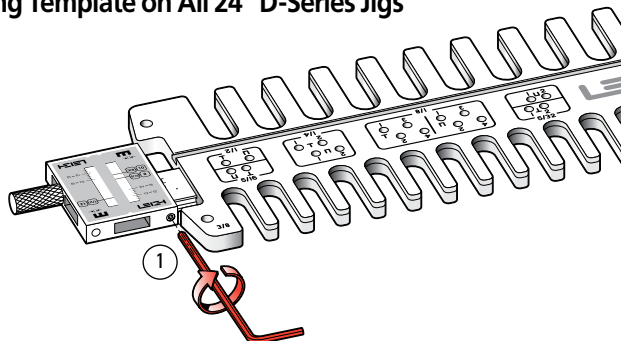
1-7 D1258, D1258R and D3 jig owners: If you already own the Leigh Mortise and Tenon Attachment, fit its extended support brackets ① and use for all finger joint and dovetail procedures. If not, mark the arrow pointers on the standard support brackets ② with a dark felt pen. Some D4 and D4R Jig owners already have extended brackets. Late model D4R brackets are shorter.



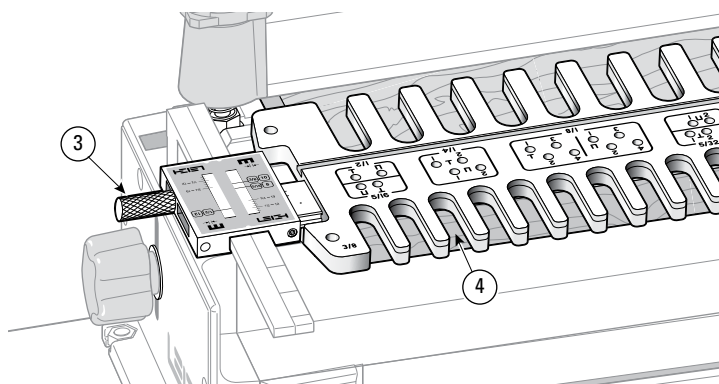
1-8 Before installing the F3/F3M on any 24" D-series jig with adjustable side stops, set and index the stops **according to the jig's user guide**. Are the stops $1\frac{1}{2}$ " [38mm] in from each end of the jig body extrusion ① and $24\frac{1}{8}$ " [613mm] apart ②? If not, do it now.

D4R and D4R Pro Jigs have fixed side stops.

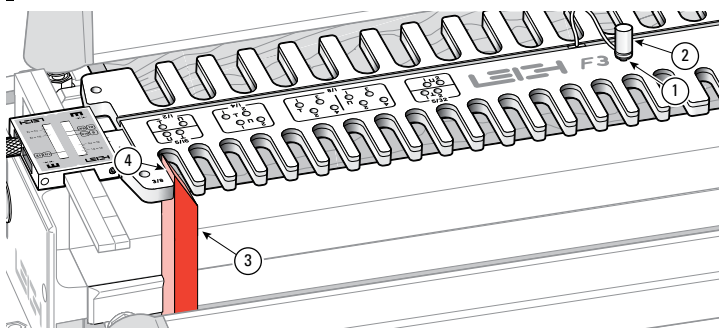
Centering Template on All 24" D-Series Jigs



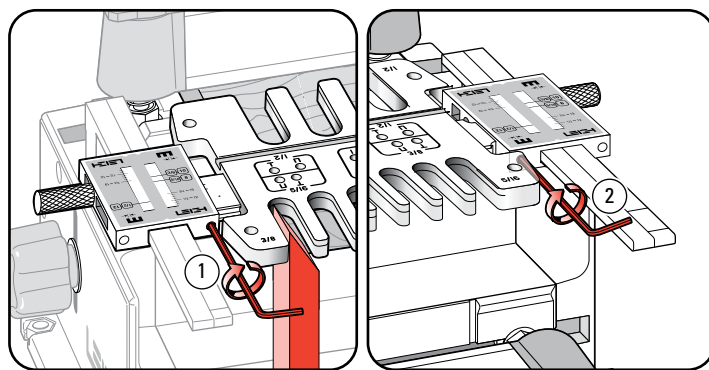
1-9 Loosen the scale bar set screw ①, at each end of the template.



1-10 Slide the template assembly onto the jig support brackets with the $\frac{3}{8}$ " & $\frac{5}{16}$ " [10 & 8 mm] combs toward you and lower it gently onto the jig's spacer board ④. Make sure the scale reading is the same on both scales, e.g. $\frac{1}{2}$ ", then tighten the thumb screws ③.



1-11 Centering the F3 Align the template so its center hole ① aligns with the hole in the bar. Insert the template pin ② with a gentle twist to seat it. Trim the end of a straight block at a 45° angle, then clamp it against the left sidestop and up into the first template opening ③. Move the combined assembly so the left side of the opening touches the block ④. Note: The angled portion of the block should not touch the template. Taking care to not move the template assembly...



1-12 ...tighten both scale set screws ① and ②. Remove the block and your Leigh F3 is ready to use. All 4 combs are now registered. **F3M owners:** Note the left set screw will be covered by the template, so tighten the right set screw first. Then remove the block and move the template to tighten the left set screw. ■

