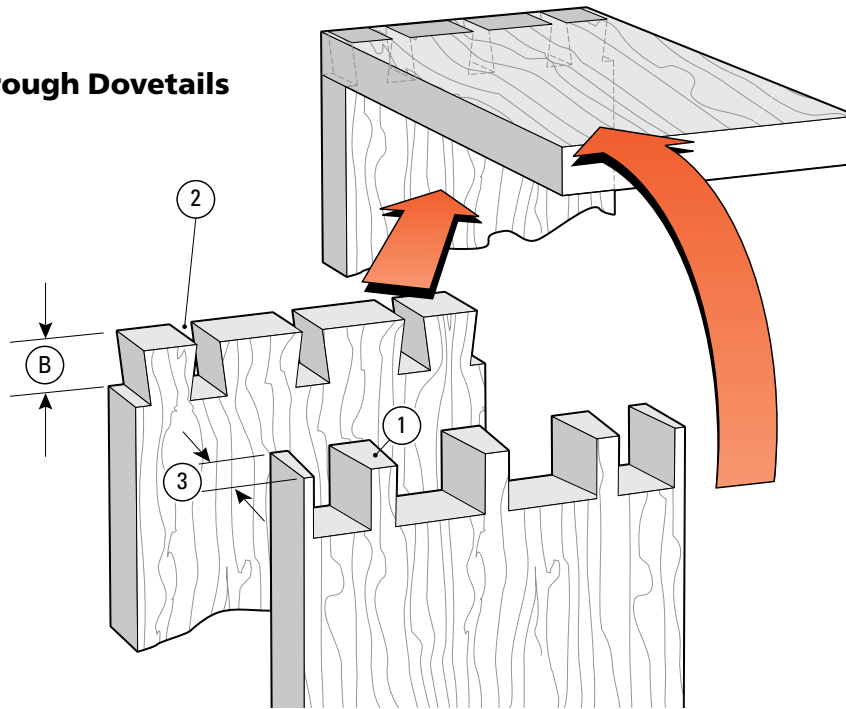


SUPERJIG - Appendix II

Bit Selection

Optional router bits for variably spaced through and half-blind dovetails.

Through Dovetails



Bit Selection for Through Dovetails

8° Dovetail Bit for Tails

The pins ① must fit into the sockets ②. So the dovetail bit's depth of cut ⑧ must be equal to or a little greater than the pinboard thickness ③.

Measure the pinboard thickness ③ and select the dovetail bit with

the correct depth of cut ⑧ from the following pages (bits must be 8° for through dovetails).

Straight Bit for Pins

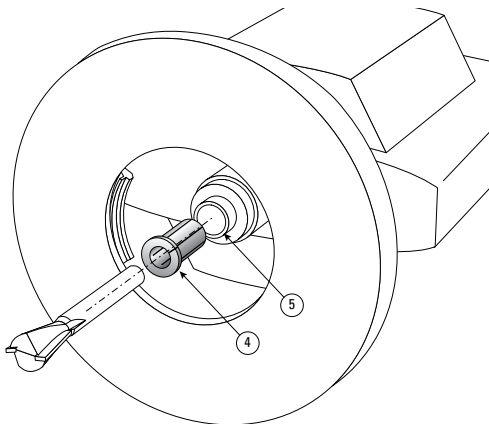
The matching straight bit is listed just below the dovetail bits. The $\frac{5}{16}$ " diameter No. 140-8, 8mm shank is the only straight bit you need with the Superjig.

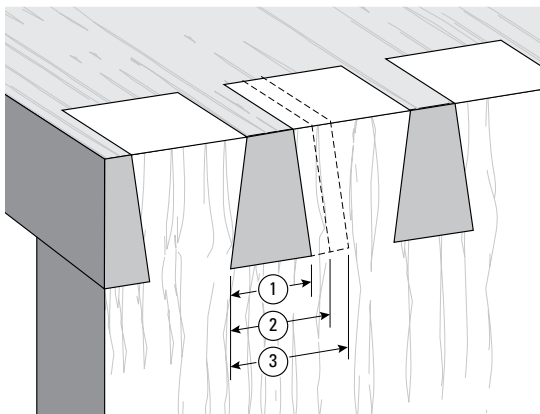
Guidebush

All joints on the Superjig are routed with the e7-Bush, or all but box joints with any $\frac{7}{16}$ " OD guidebush (min. barrel depth $\frac{1}{4}$ "). See page 68.

Shank Selection

Note: You will require a router with an 8mm or $\frac{1}{2}$ " [12,7mm] collet to use our 8mm shank bits. For a $\frac{1}{2}$ " [12,7mm] collet router you will require our $\frac{1}{2}$ " [12,7mm] to 8mm collet reducer No. 172-8. Note: This is a collet reducer ④, not a collet ⑤. It does not replace the collet, it slides directly into your $\frac{1}{2}$ " collet. **Do not remove the collet nut when installing the collet reducer.**





You will note that some of the dovetail bits' depths of cut overlap.

For example:

No.80-8 bit (B): $\frac{1}{2}$ " – $\frac{13}{16}$ " [12 - 20mm]

No.70-8 bit (B): $\frac{1}{4}$ " – $\frac{1}{2}$ " [6 - 12mm]

This means that $\frac{1}{2}$ " boards can be joined using either the No.80-8 and 140-8 combination, the No. 75-8 and 140-8 combination, or the No.70-8 and 140-8 combination.

The three bit combinations will produce slightly different-looking joints because each dovetail bit produces a different size pin:

No. 70-8 $\frac{3}{8}$ " ①

No. 75-8 $\frac{7}{16}$ " ②

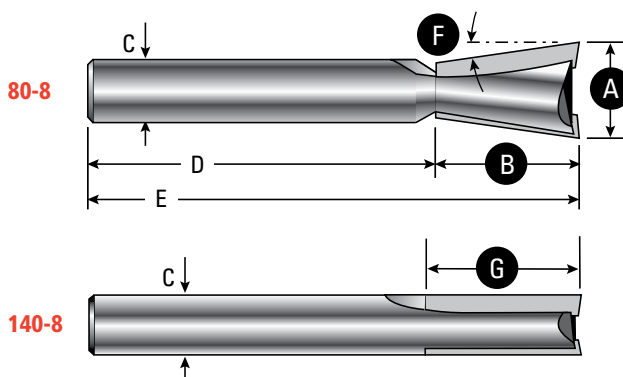
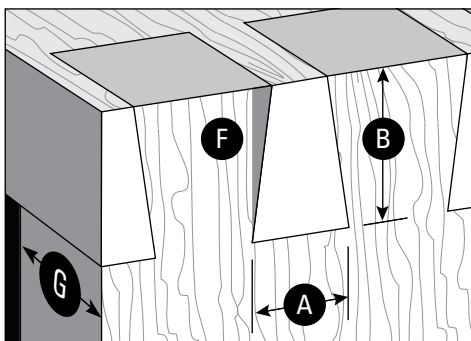
No. 80-8 $\frac{1}{2}$ " ③.



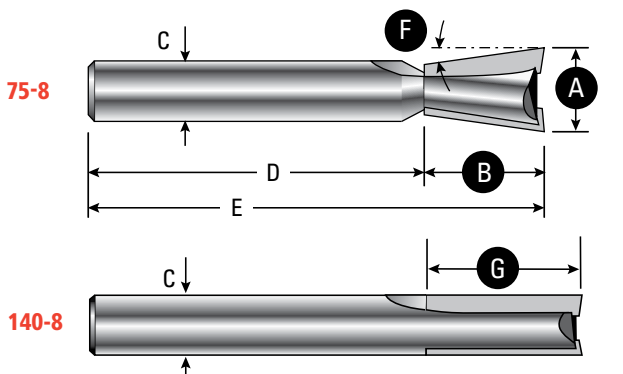
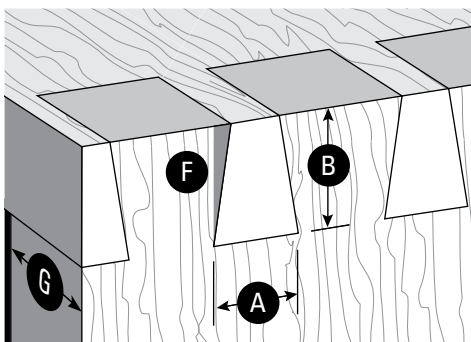
Do not attempt to rout dovetails at less than the minimum depth of cut specified.

Note: Bit and joint drawings are about actual size.

Leigh Through Dovetail Bits



Bits	A Overall Diameter	B/G Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 80-8*	$\frac{1}{2}$ " [12,7]	B $\frac{1}{2}$ " to $\frac{13}{16}$ " [13,0-20,6]**	8mm	1- $\frac{3}{4}$ " [45,0]	2- $\frac{9}{16}$ " [65,0]	8°	e7 or 711C $\frac{7}{16}$ " [11,1]
No. 140-8*	$\frac{5}{16}$ " [7,9]	G up to 1" [26,0]	8mm	1- $\frac{3}{4}$ " [45,0]	2- $\frac{3}{4}$ " [70,0]	–	e7 or 711C $\frac{7}{16}$ " [11,1]



Bits	A Overall Diameter	B/G Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 75-8	$\frac{7}{16}$ " [11,1]	B $\frac{3}{8}$ " to $\frac{5}{8}$ " [9,5-16,0]	8mm	1- $\frac{3}{4}$ " [45,0]	2- $\frac{3}{8}$ " [60,0]	8°	e7 or 711C $\frac{7}{16}$ " [11,1]
No. 140-8*	$\frac{5}{16}$ " [7,9]	G up to 1" [26,0]	8mm	1- $\frac{3}{4}$ " [45,0]	2- $\frac{3}{4}$ " [70,0]	–	e7 or 711C $\frac{7}{16}$ " [11,1]

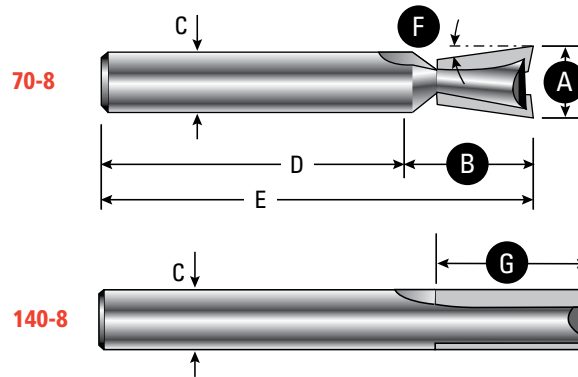
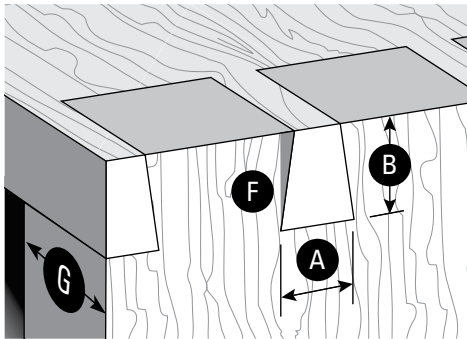
Numbers in brackets are millimeters

* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

**Maximum pin board thickness = $\frac{13}{16}$ "

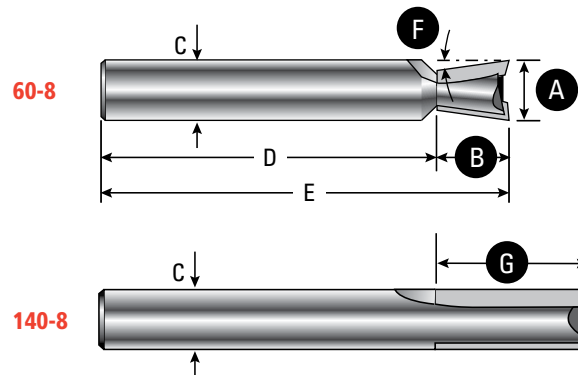
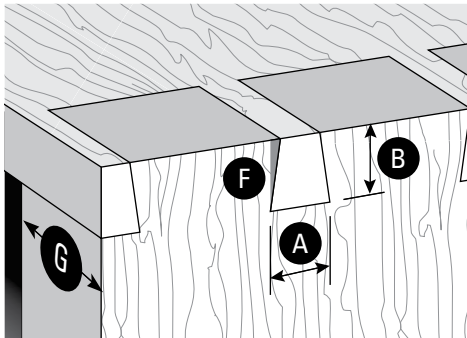
Note: Bit and joint drawings are about actual size.

Leigh Through Dovetail Bits



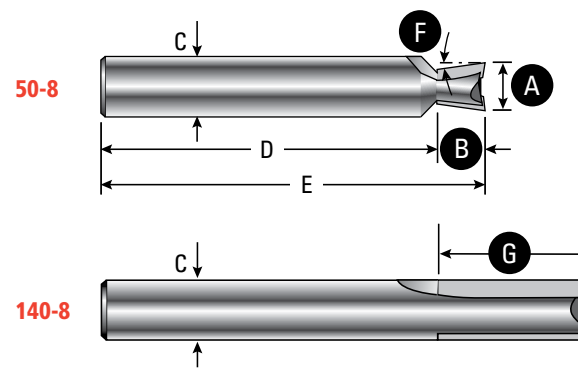
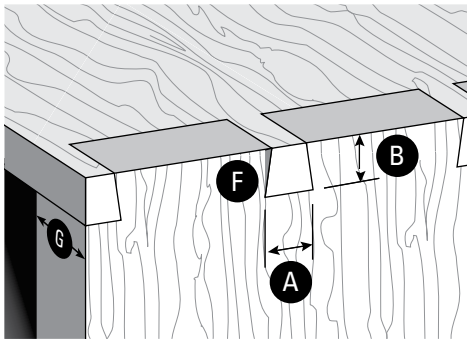
Included
with
Superjig

Bits	A Overall Diameter	B/G Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 70-8	3/8" [9,5]	B 1/4" to 1/2" [6,0-13,0]	8mm	1-3/4" [45,0]	2-1/4" [57,0]	8°	e7 or 711C 7/16" [11,1]
No. 140-8*	5/16" [7,9]	G up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	—	e7 or 711C 7/16" [11,1]



Included
with
Superjig

Bits	A Overall Diameter	B/G Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 60-8	5/16" [7,9]	B up to 3/8" [9,5]	8mm	1-3/4" [45,0]	2-1/8" [54,0]	8°	e7 or 711C 7/16" [11,1]
No. 140-8*	5/16" [7,9]	G up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	—	e7 or 711C 7/16" [11,1]



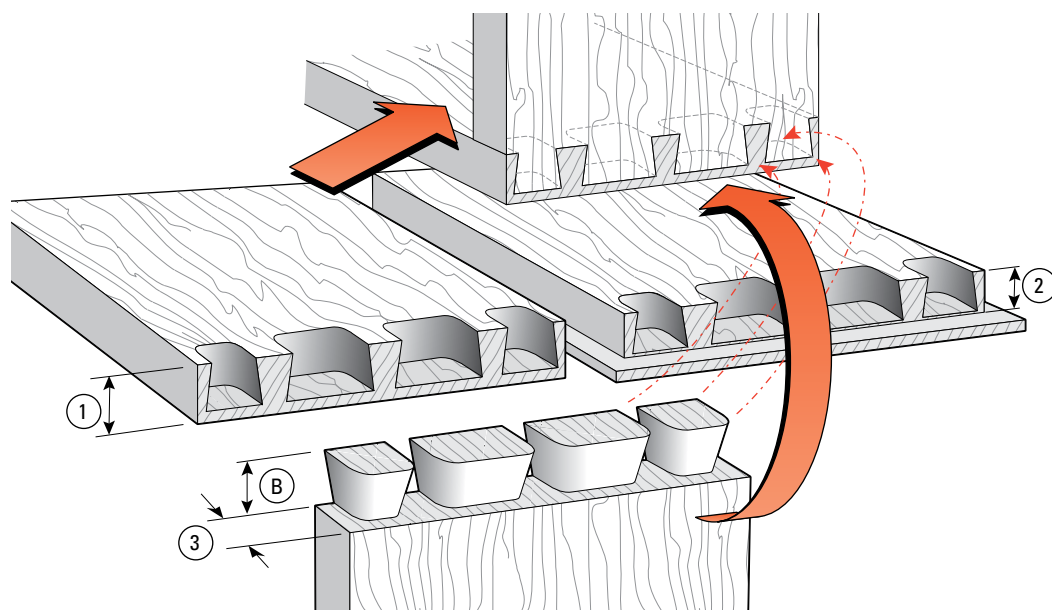
Included
with
Superjig

Bits	A Overall Diameter	B/G Cutting Depth Range	C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
No. 50-8	1/4" [6,35]	B up to 1/4" [6,35]	8mm	1-3/4" [45,0]	2" [50,0]	8°	e7 or 711C 7/16" [11,1]
No. 140-8*	5/16" [7,9]	G up to 1" [26,0]	8mm	1-3/4" [45,0]	2-3/4" [70,0]	—	e7 or 711C 7/16" [11,1]

Numbers in brackets are millimeters

* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

Half-Blind Dovetails



Bit Selection for Half-Blind Dovetails

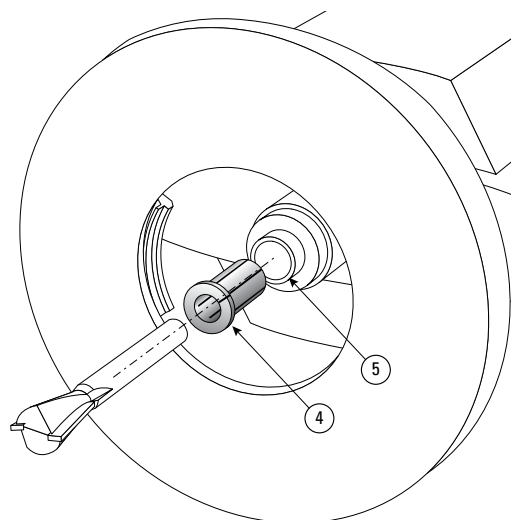
Both parts of a half-blind dovetail are cut with the same dovetail bit. The dovetail bit's working depth of cut (B) must be less than the pinboard thickness (1) for flush drawers by at least $\frac{1}{8}$ " [2mm], and slightly less than the rabbet depth (2) for rabbeted drawer fronts. Minimum pin board (drawer front) thickness is $\frac{1}{2}$ " [12mm].

Drawer side thickness (3) does not affect bit selection.

Note: (B) is the nominal working depth for half-blind

dovetails, not the maximum depth. (B) must not be varied, except for minor adjustments for joint fit. *See page 35.*

Measure the drawer front thickness (minimum $\frac{1}{2}$ " [12mm]) (1) or rabbet depth (minimum $\frac{7}{16}$ " [11,1mm]) (2) and select the bit with the appropriate depth of cut (B) from one of the five bits on the following pages.



Guidebush

All joints on the Superjig are routed with the e7-Bush, or all but box joints with any $\frac{7}{16}$ " OD guidebush (min. barrel depth $\frac{1}{4}$ "). *See page 68.*

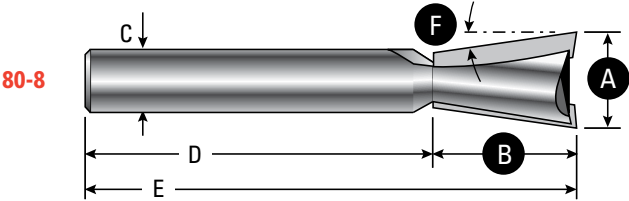
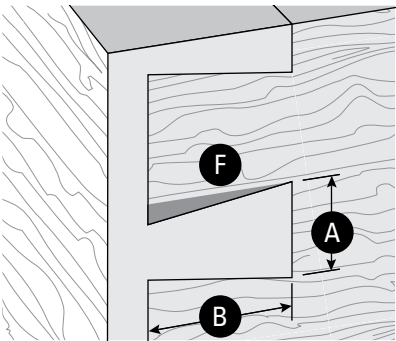
Shank Selection

Note: You will require a router with an 8mm or $\frac{1}{2}$ " [12,7mm] collet to use our 8mm shank bits. For a $\frac{1}{2}$ " [12,7mm] collet you will require our $\frac{1}{2}$ " [12,7mm] to 8mm collet reducer No.172-8.

Note: This is a collet reducer (4), not a collet (5). It does not replace the collet, it slides directly into your $\frac{1}{2}$ " collet. **Do not remove the collet nut when installing the collet reducer.**

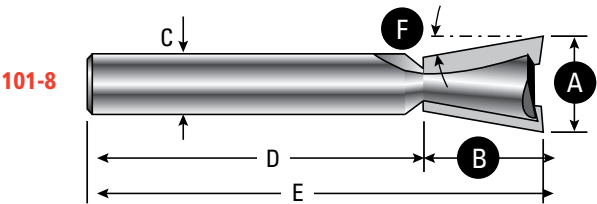
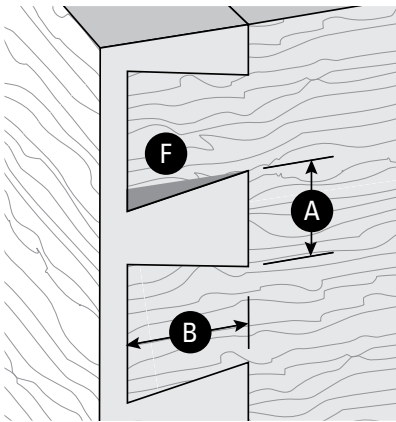
Note: Bit and joint drawings are about actual size.

Leigh Half-Blind Dovetail Bits

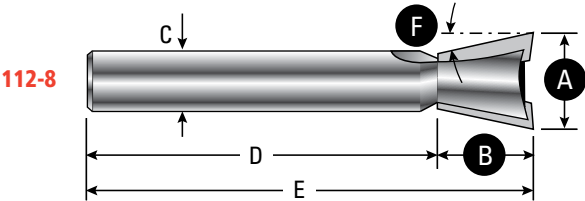
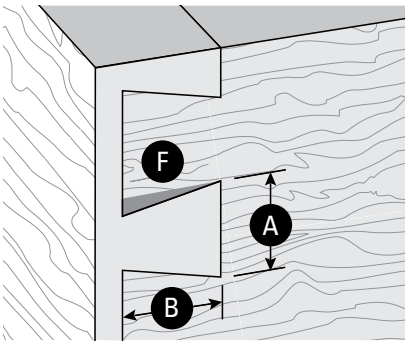


Included with Superjig

Bits	A Overall Diameter	B Working Depth		C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
		HB Variable	HB 1-Pass					
No. 80-8*	1/2" [12,7]	~3/4" [19]	~1/2" [12,7]	8mm	1-3/4" [45,0]	2-9/16" [65,0]	8°	e7 or 711C 7/16" [11,1]



Bits	A Overall Diameter	B Working Depth		C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
		HB Variable	HB 1-Pass					
No. 101-8	1/2" [12,7]	~5/8" [16,0]	~7/16" [11,1]	8mm	1-3/4" [45,0]	2-3/8" [60,0]	10°	e7 or 711C 7/16" [11,1]

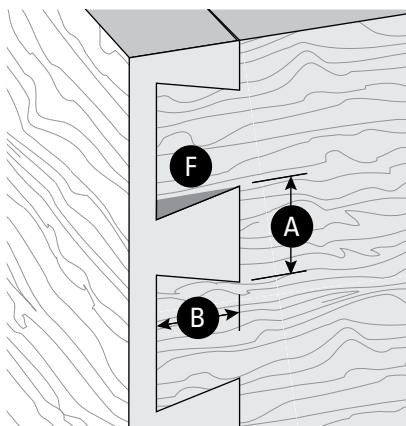


Bits	A Overall Diameter	B Working Depth		C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
		HB Variable	HB 1-Pass					
No. 112-8	1/2" [12,7]	~1/2" [13,0]	~3/8" [9,5]	8mm	1-3/4" [44,0]	2-21/64" [59]	12°	e7 or 711C 7/16" [11,1]

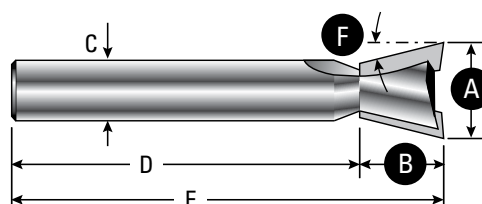
Numbers in brackets are millimeters

* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs

Note: Bit and joint drawings are about actual size.

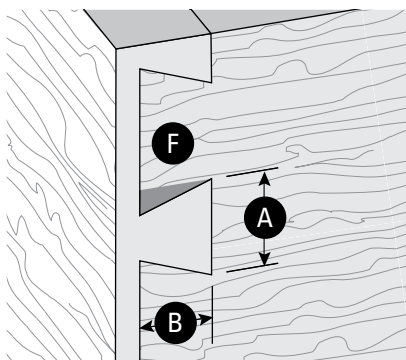


120-8

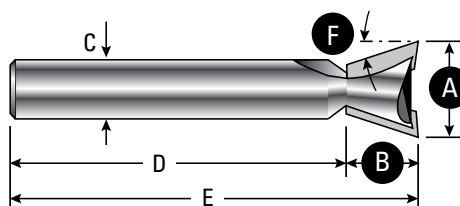


Included
with
Superjig

Bits	A Overall Diameter	B Working Depth		C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
		HB Variable	HB 1-Pass					
No. 120-8*	1/2" [12,7]	~7/16" [11,0]	~9/32" [7,1mm]	8mm	1-3/4" [45,0]	2-1/4" [57]	14°	e7 or 711C 7/16" [11,1]



128-8



Bits	A Overall Diameter	B Working Depth		C Shank Diameters	D Shank Length	E Overall Length	F Angle	Guidebush Diameter
		HB Variable	HB 1-Pass					
No. 128-8	1/2" [12,7]	~3/8" [9,5]	7/32" [5,5]	8mm	1-3/4" [45,0]	2-1/8" [54,0]	18°	e7 or 711C 7/16" [11,1]

Numbers in brackets are millimeters

* Bits 80-8, 120-8, and 140-8 come standard with Leigh Super Jigs