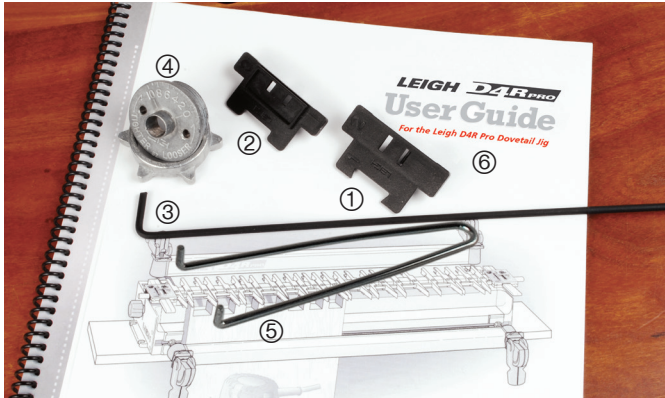


Joinery Upgrade Kit

for Earlier Model D-Series Jigs

The D4R, D4, D3, D1258R or D1258 Dovetail Jig can be upgraded to make Single Pass Half-Blind Dovetails and Box Joints (Finger Joints).



Parts included with Upgrade Kit (D4RKIT)

- ① Single pass half-blind dovetail spacer
- ② Box joint (finger joint) spacer
- ③ Single pass half-blind nylon stop rod
- ④ e7 elliptical guide bushing
- ⑤ Pin wrench for e7 guide bushing
- ⑥ D4R Pro user guide (instructions to make these joints)

Use this Upgrade Kit to rout:

- Box joints in two sizes: 3/8" and 3/4" (no guidefinger modification required).
- Single pass half-blind dovetails (with modified guide fingers* or a new set of guide fingers)

*See **Guide Finger Modification** on next page.

To purchase a new set of guide fingers, see [D4R Pro Guide Finger Set](#) in Dovetail Jig Upgrades at Leightools.com

IMPORTANT NOTE FOR D4, D3, D1258R & D1258

Shop-made spacers are required to offset the tail board for single pass half-blind dovetails, and the socket board for 3/8" and 3/4" finger (box) joints. They're easily made from scrap 1/4" plywood, solid wood or press-board.

The single pass half-blind dovetail offset spacer must be 5-1/2" long by 0.544" wide by 1/4" thick.

Tip: Cut the spacer to 35/64". You may need to sand lightly to specification.

The box joint offset spacer must be 5-1/2" long by 0.386" wide by 1/4" thick.

Tip: Cut the spacer to 25/64". You may need to sand lightly to specification.



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GUIDE FINGER MODIFICATION

In order to produce single pass half-blind dovetails on your Leigh dovetail jig, a $9/64$ " hole must be drilled in the tail end of each guide finger at a specific location. Although fingers may be marked and drilled free hand, we recommend using a shop-made drilling jig similar to the drawing on the following page, and your drill press, to ensure holes are drilled at the same location in every guide finger.

D4R/D4 (see drawing on next page)

1. Remove the guide finger assembly from the jig, and remove the scales and all fingers from the finger bar.
2. Use a flat board approximately 10" x 6" as a base.
3. Mount a crosspiece (A), 4" long by $3/4$ " x $1/2$ " approximately 2- $1/2$ " from one end of board.
4. Mount the first perpendicular piece (B), 5" x $3/4$ " x $1/4$ " approximately on crosspiece (A).
5. Place a finger firmly against the first horizontal piece.
6. Mount the second perpendicular piece (C) firmly against the finger and secure in place.
7. Make a spacer block (D), $7/32$ " x 1" x $7/16$ ".
8. Using a left hand finger, mark layout lines on the flat surface of the tail end of the finger as indicated, i.e. $11/64$ " from the screw face of the finger and $29/32$ " from the end of the finger.

NOTE: All fingers are identified with "L" (Left hand) or "R" (Right hand) cast into the tail of the finger.

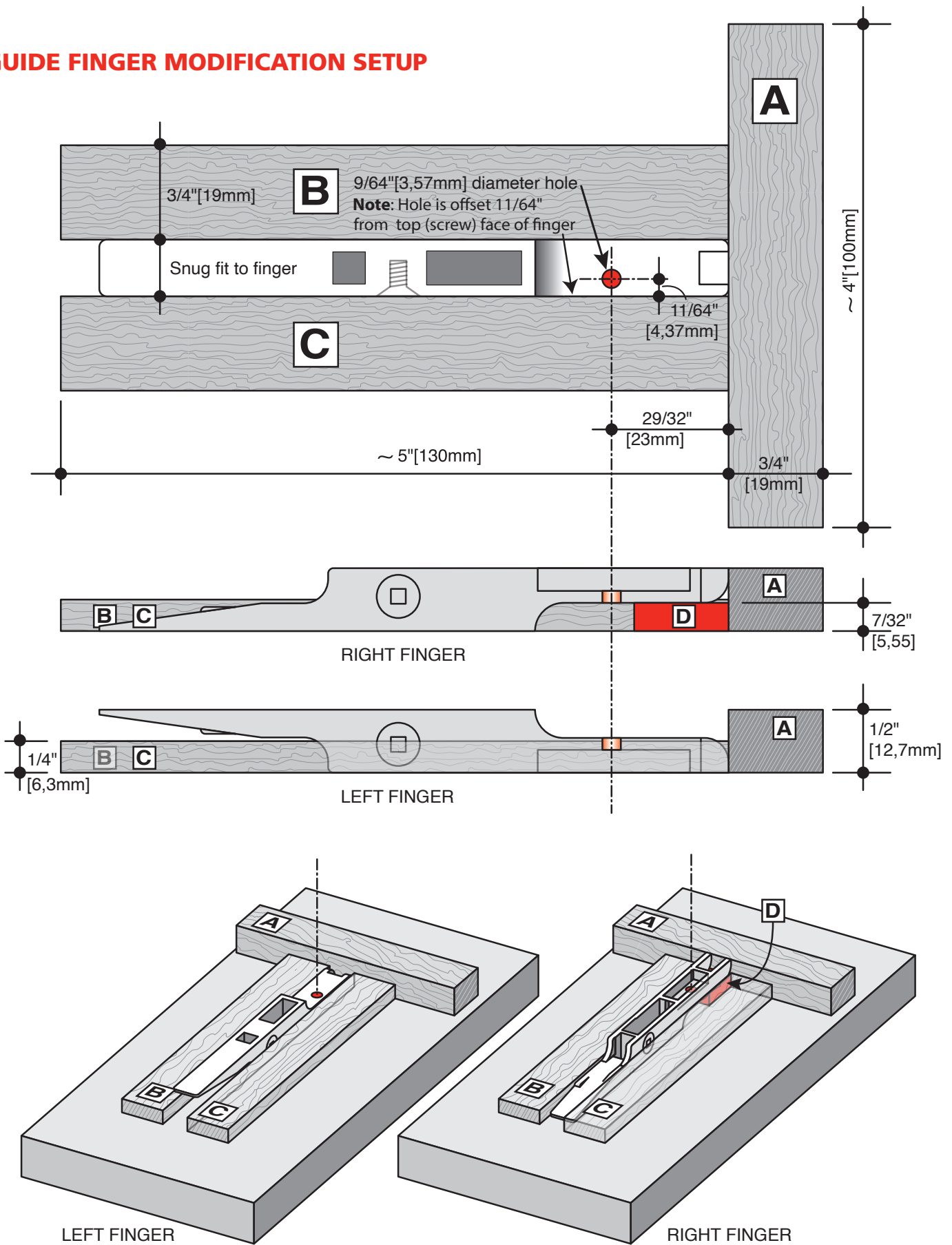
9. Place the left finger in the drilling jig as indicated and mount drilling jig on drill press table.
10. Center the drill bit onto the layout marks and secure the drilling jig to the table with clamps. Tighten clamps securely.
11. Drill all left hand fingers.
12. Before drilling the right hand fingers, place the spacer block in the drilling jig as indicated. This block is necessary to prevent the right hand fingers from bending down when drilling.
13. Drill all right hand fingers.
14. Replace all fingers on the finger bar and refer to Chapter 1, Figures 1-8 and 1-9 of your user guide, when reattaching the scales.

D3, D1258R & D1258

D3 and earlier jigs can have the same drilling procedure as noted above, however the guide fingers for these jigs are solid (not cored out).



GUIDE FINGER MODIFICATION SETUP



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