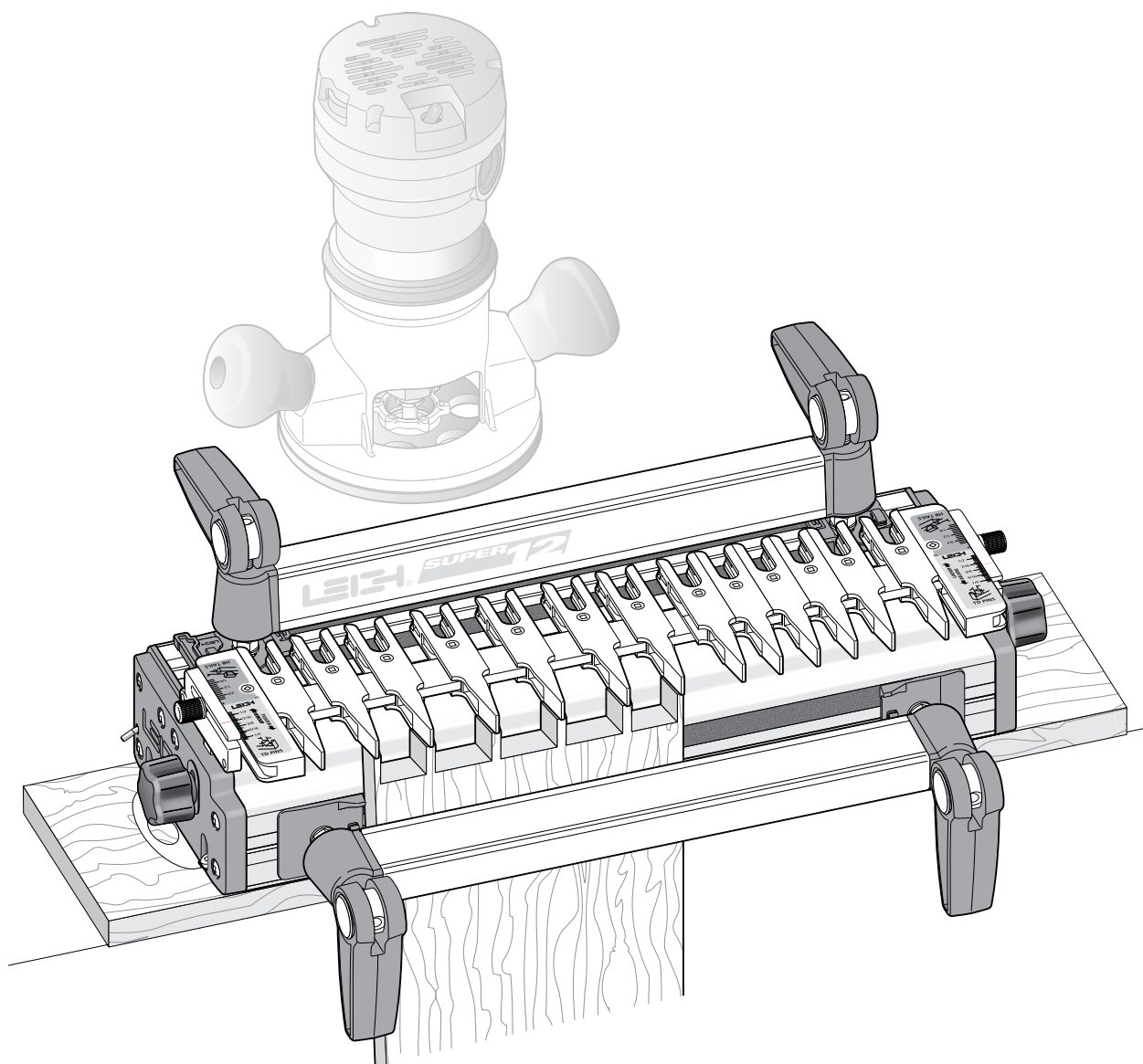


Leigh Super Jigs

Super12, Super18 and Super24 Dovetail Jigs

User Guide

12" (304mm) 18" (457mm) and 24" (610mm)



See page 79 for customer support

1-800-267-8761

LEIGH® Leightools.com

Watch the Online Instructional Videos
in the Support Section at Leightools.com



Your New Leigh Dovetail Jig

Congratulations! You now own a most useful and versatile dovetailing tool. The Leigh Superjig Dovetail Jig will help you cut an infinite variety of joints, and all of its major functions are described in detail in this user guide, plus there's a Quick Reference Guide that pulls out from under the jig. Instructional videos of pertinent chapters are available online on the Instructional Videos and User Guides page in the Support menu.

We recommend that you first assemble and mount the jig, carefully following the instructions in the first section of the user guide. Then read the rest of the guide, following along with the basic functions and principles of operation, before you try to do any actual joinery routing. By all means, cut a few practice joints in scrap boards before you use the jig to rout a precious hardwood work piece!

If you have questions not answered in this user guide, please call the Leigh customer support line: **1-800-267-8761** or email Leigh: **customerservice@leevalley.com**.

But remember: "If at first you don't succeed, read the instructions!"

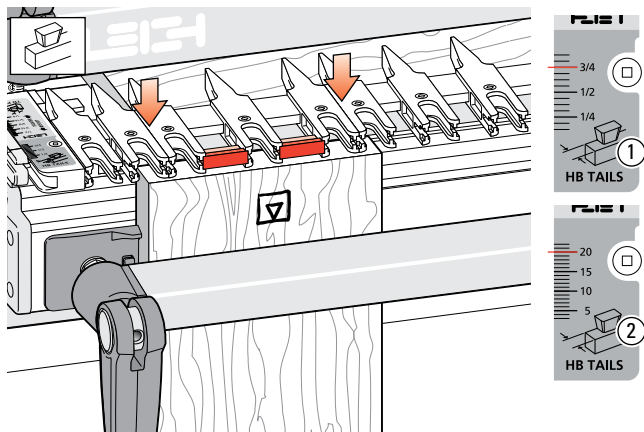
*See Appendix IV – Customer Support

Important! Inches and Millimeters

The Superjig can be ordered in inch or metric versions. They're identical except for the calibration scales. This Leigh English-language user guide show measurements in both inches and millimeters, with "inches" first, followed by "millimeters" in square brackets.

Example: $\frac{3}{4}$ " x $5\frac{1}{2}$ " x 8" [20 x 140 x 200mm]

Do not be concerned if the inch/millimeter equivalents are not exact. Just use the dimensions which apply to your jig.



Where finger assembly scales overlay an illustration, the "inches" scale ① will be at the top, the "millimeters" scale ② will be at the bottom. Only the front "active" half of the scales are illustrated. For clarity, setting positions are indicated with a red line in the user guide only. **On the jig, the lines are black.**



**Watch the Online
Instructional
Video**



Scan QR Code

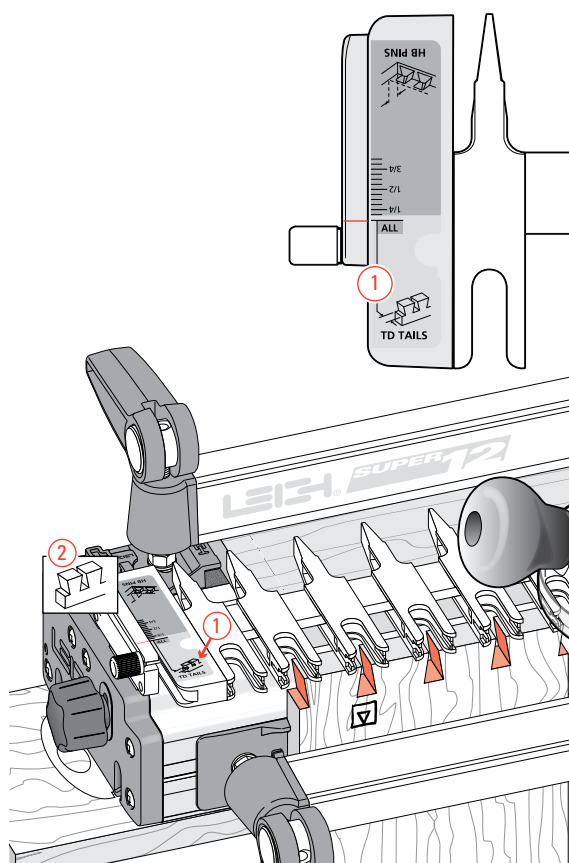
Reduce your learning time dramatically! Stream to your smart phone or tablet to use in your workshop while you're working. See Instructional Videos section in Support menu at **leightools.com** or **scan QR code for instant video.**

Introduction	ii
Chapter 1 – Jig Assembly, Mounting, and Using The Clamps	1
Chapter 2 – Adjusting the Finger Assembly	7
Chapter 3 – The Leigh e-Bush and Optional Guidebushes.....	9
Chapter 4 – Basic Jig Functions and Scale Modes	11
Chapter 5 – Using Your Jig Safely.....	13
Chapter 6 – Wood Preparation	15
Chapter 7 – Router Preparation	17
Chapter 8 – Through Dovetail Procedures	19
Chapter 9 – Variably Spaced Half-Blind Dovetail Procedures	29
Chapter 10 – Single Pass Half-Blind Dovetails	37
Chapter 11 – Rabbeted Half-Blind Dovetails	45
Chapter 12 – Asymmetric Dovetails	47
Chapter 13 – Sliding Dovetails.....	51
Chapter 14 – Box Joints.....	57
Chapter 15 – Hints and Tips	63
Appendix I – Attaching the Leigh e-Bush to the Router	67
Appendix II – Bit Selection	69
Appendix III – Jig Parts	75
Appendix IV – Customer Support.....	79

TECHNICAL BULLETINS

Downloadable pdfs are available in the Support menu at leightools.com/technical-bulletins:

- Inlaid Through Dovetails on the D1600 and Super Jigs
- Wider Pins on the D1600 Jig and Super Jigs
- End-on-End Dovetails on the D1600 and Super Jigs



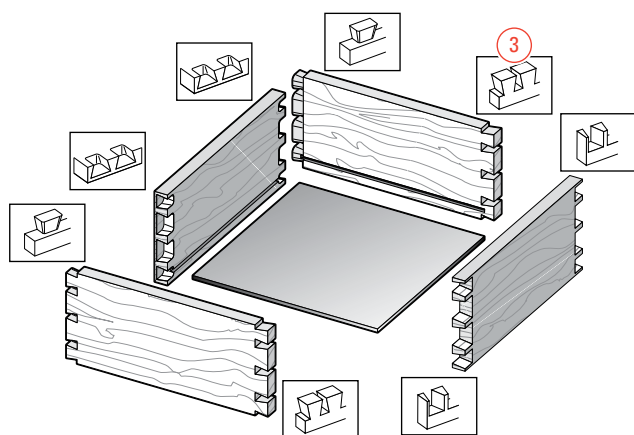
Glossary of Symbols

To help you understand the instructions and illustrations in this user guide, we have used a number of international symbols, plus a few special ones of our own. They are all explained below. **You needn't worry about memorizing these symbols now**, because they are repeated quite frequently throughout the user guide, and you will soon get used to them.

The Leigh jig's guidefinger assembly can be in any one of four joint modes, depending on what type of joint and which part of the joint you are routing. Each finger assembly scale has its own mode icon ①, identifying that joint part. You will also find the joint mode icon in the top left corner of most illustrations ②, indicating which finger assembly mode to use.

Sometimes a joint mode icon will be used to identify a board ③.

These are the four joint mode icons:



TD Tails
(tails for through dovetail joints)



TD Pins
(pins for through dovetail joints)



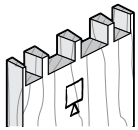
HB Tails
(tails for half-blind dovetail joints)



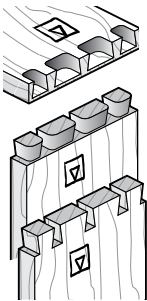
HB Pins
(pins for half-blind dovetail joints)

Which Way Round Should the Board Go?

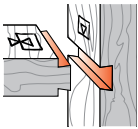
As virtually all dovetail joinery is used to make boxes, drawers and chests etc., we devised these simple (and hopefully intuitive) icons to indicate which side of a board faces inwards or outwards on the finished “box”, and which side of the board faces outward (toward you, the operator), when it is clamped in the jig.



This icon  indicates the “outside” of a board. All through dovetail pin boards are mounted in the jig with this “outside” face away from the jig (toward you, the operator).

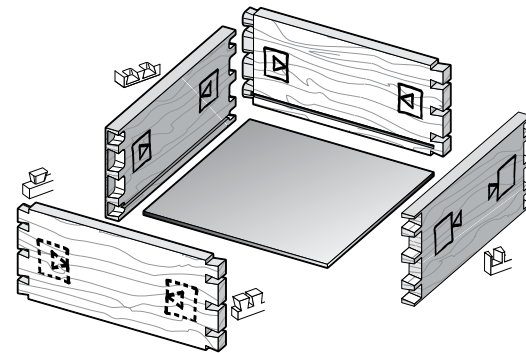
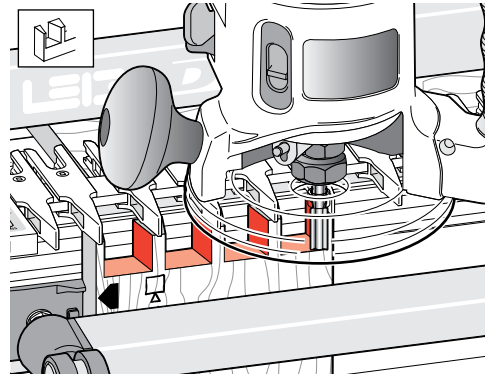


This icon  indicates the “inside” of a board. All half-blind pin and half-blind tail boards, and through dovetail tail boards, are mounted in the jig with the “inside” face away from the jig toward you, the operator.



This icon  indicates boards that are mounted both ways e.g. sliding dovetails and box joints.

Dotted line icons  indicate the “other” side of the board in the illustrations.



The following symbols indicate:



This edge against sidestop



This edge against sidestop



Sawcut allowance



Caution: use special care for this operation

①②③ Numbered References in text



Centerline of board or layout



Equals



Does not equal



Approximately

CONSIDER
THE...

Leigh VRS Vacuum & Router Support



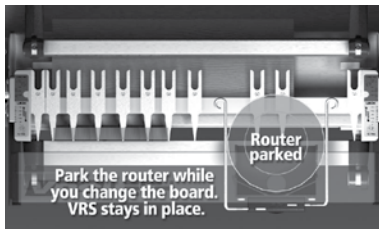
Dust-Free Routing!

The revolutionary Leigh VRS Vacuum & Router Support* provides almost 100% dust and chip collection as well as amazing full width router support. The VRS is a must-have for all Leigh dovetail jig owners.

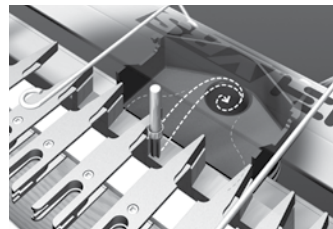
*US patent: USPN 7,507,060 B2 UK patent: GB2446909 Canada Patent No. 2,611,233

Here's How It Works

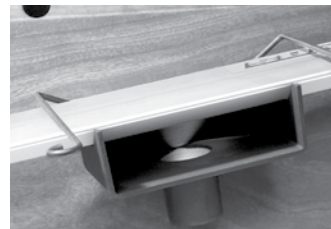
The VRS is mounted on brackets on the front of the jig and the router is supported by the finger assembly and the full width beam of the VRS. The vacuum chute rides under the router support beam. Control arms, attached to the vacuum chute, surround the router. These arms are adjustable to accommodate any router base. As the router moves across the joint, the vacuum chute glides effortlessly from side to side on nylon rollers. The chute is always in perfect position to catch the dust and chips thrown out by the router bit. Chips and sawdust are drawn into the vacuum chute and down through the vacuum hose. Each VRS comes complete with two adaptors to fit all popular vacuum hose sizes and the VRS can be used with a small shop vac or a large built in system. The VRS is easily attached without jig modification. Each VRS comes complete with all mounting hardware needed for any Leigh 24" D-Series jig, all Super Jigs or the earlier model Leigh D1600.



The VRS is a full width router support. When the work piece has been routed on one side of the jig, the router can be effortlessly moved to the other side of the jig and parked while the work piece is being changed. There is no need to remove the router from the jig.



Because the vacuum box is always in perfect position relative to the router bit, the dust and chips coming off of the router bit are automatically drawn into the chute and vacuum hose.



The dust chute rides beneath the router support beam. Control arms ensure accurate positioning of the chute and the size and shape of the chute ensures total waste collection regardless of bit size or joint type being routed.



The VRS will work with almost any shop vac or large vac system. Two adaptors are included with every VRS to handle hose sizes from 1" to 2-1/2".

VRS Vacuum & Router Support Features



- Full width router support
- Easy on Easy Off. Powerful rare earth magnets secure router support beam
- Park the router when not in use
- Vacuum box glides effortlessly under router support beam
- Control arms position vacuum box
- Control arms adjust to any router
- No hoses to obstruct view
- No jig modifications necessary
- Models for all Leigh jigs
- All mounting hardware included
- Adapt to any hose size

Standard Equipment

- Router Support Beam
- Vacuum chute
- Hose adaptors – small and large
- Support rails
- Screws and washers
- Hex key

VRS Models

Item VRS12 Vacuum & Router Support for the Super 12 Dovetail Jig

Item VRS18 Vacuum & Router Support for the Super 18 Dovetail Jig

Item VRS24 Vacuum & Router Support for the Super 24 Dovetail Jig



Accessory Kits

Item AC12 VRS12 and 1607-8 Bit Set for the Super 12 Dovetail Jig

Item AC18 VRS18 and 1607-8 Bit Set for the Super 18 Dovetail Jig

Item AC24 VRS24 and 1607-8 Bit Set for the Super 24 Dovetail Jig