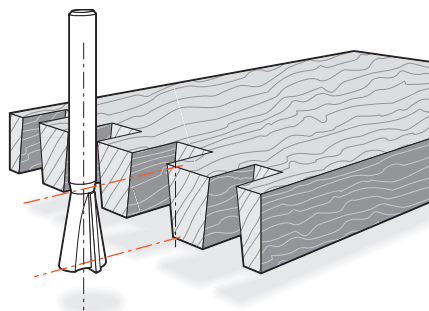
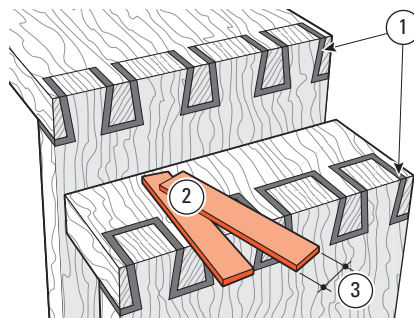


Inlaid Through Dovetails on the Leigh D-1600

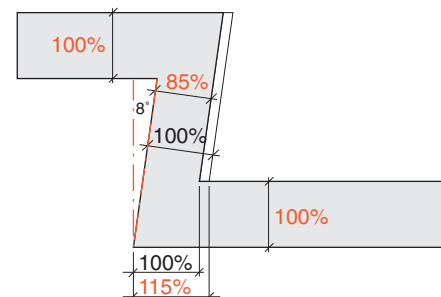
It is assumed that you have successfully routed regular through dovetails on the D1600, and that the scale settings for joint fit have been properly calibrated.



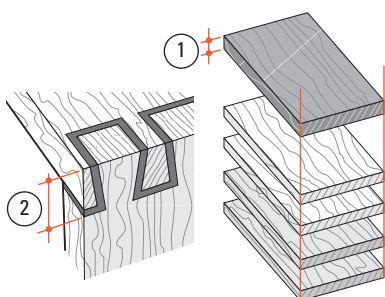
1 Select the dovetail bit that equals or slightly exceeds the maximum depth of cut required, i.e. the thickness of the **inlay board**.



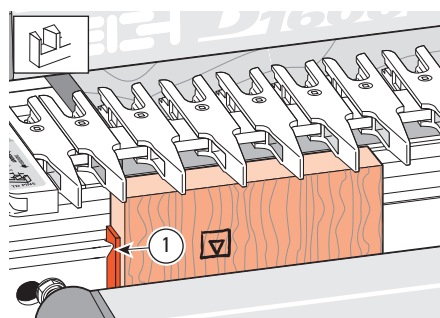
2 This procedure requires precise movement and re-positioning of the work pieces between routing steps. First determine the required inlay band thickness ① and make two 3' long shims ②. Shim width must be less than joint board thickness ③. Shim thickness is: **desired inlay thickness x 1.15** (e.g. 1/8" [3mm] inlay will require shims 9/64" [3.5mm]). This will ensure the inlay on the angled pin sides is equal to the adjacent inlay.



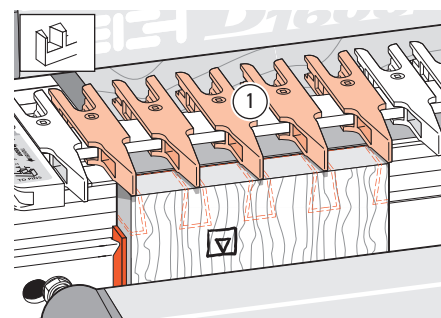
3 Here's why. The 8° angle will decrease the inlay thickness by about 15%. Adding 15% will bring the angled inlay thickness back to approximately the same as the vertical and horizontal thickness.



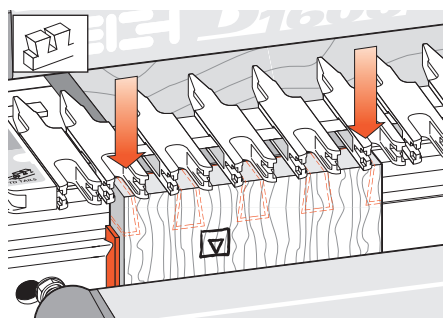
4 Prepare the pin, tail and inlay boards to **exactly the same width** but make the **inlay board thickness ① equal to: the pin board plus the inlay thickness ②**.



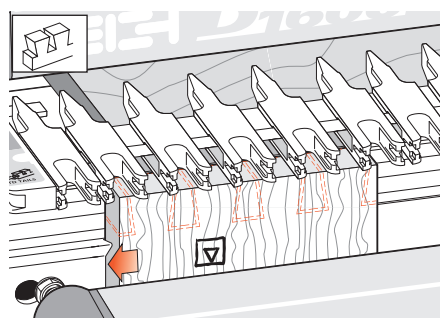
5 Place the finger assembly on the jig in the TD PINS mode and the assembly touching the spacer board. Clamp a tail board in the jig; flush under the guidefingers and the side edge **trapping one of the shims against the side stop ①**.



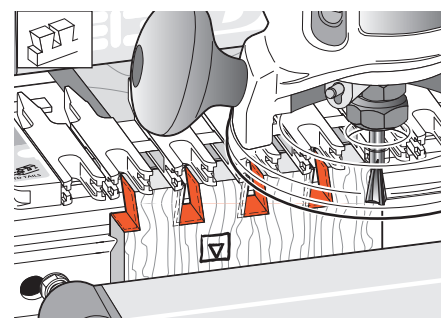
6 Raise the finger assembly slightly and position the guides to the desired layout ①.



7 Rotate the finger assembly to the TD TAILS mode and lower the assembly onto the spacer board and tail board ①.

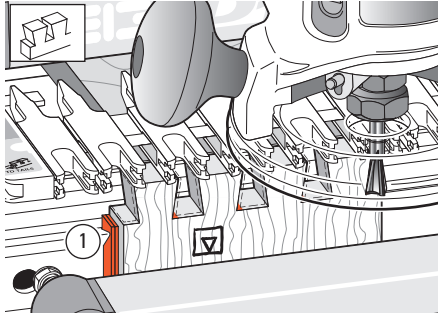


8 Unclamp the tail board, remove the shim and re-clamp the tail board against the fixed side stop ①.
Make sure you save both shims; you will need them shortly.

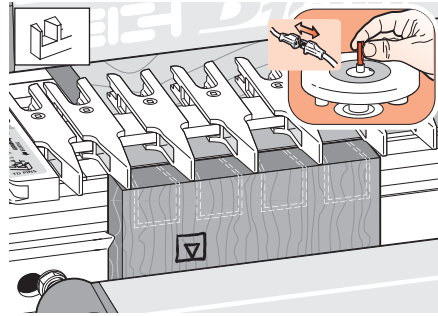


9 Set cutter depth to match the inlay board thickness and rout the sockets with the dovetail cutter.

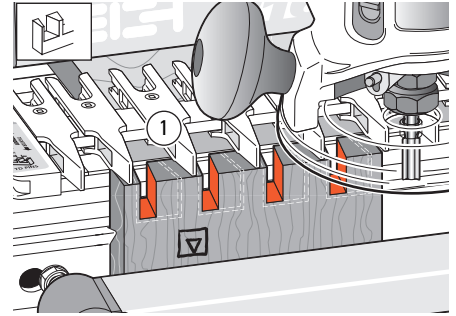
D1600 Jig Inlaid Through Dovetails



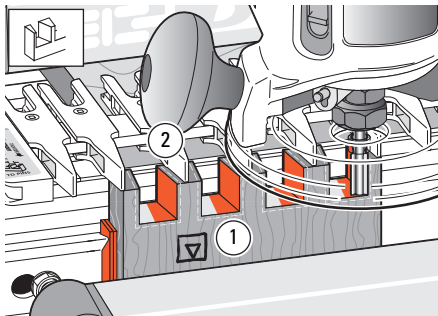
10 Unclamp the tail board and re-clamp **with both shims** between the side stop and board ①. Rout in through the sockets again. Repeat this procedure on the other end of this board and on each end of all tail boards. Remove the boards and shims.



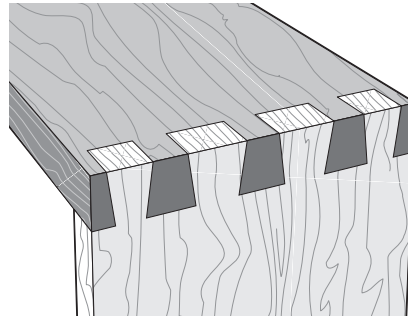
11 Change to the straight cutter and rotate the finger assembly to **TD PINS** mode. Clamp a dark inlay board in the jig; edge touching the side stop.



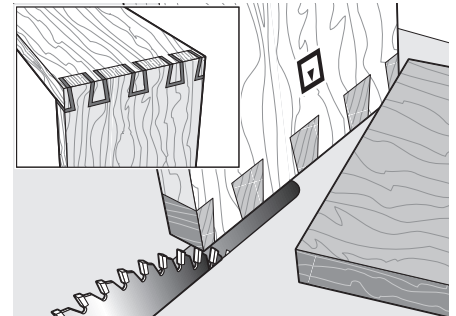
12 ⚠️ Rout in through the inlay pin board **only on the sides of the pin guides furthest from the side stop** (the right hand side of the finger in this illustration). **Take great care not to rout toward the opposing guide finger ①**



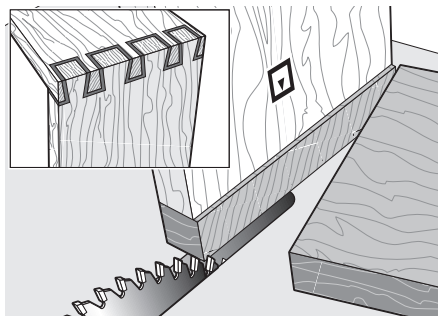
13 Unclamp the inlay piece and re-clamp **with both shim strips** between the side stop and board ①. Now rout in through the inlay pin board **only on the sides of the guides closest to the shim strips ②**; (the left side in this illustration). Take care to rout away only the waste between the pins ①, without routing in the unprotected side of the adjacent pins. Repeat this procedure on each end of all inlay pin pieces.



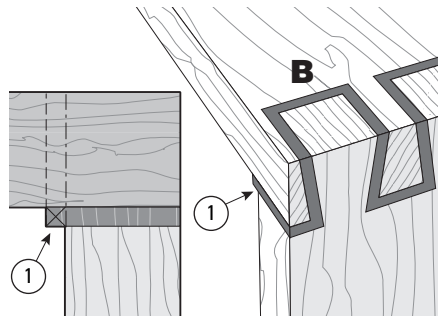
14 Glue the inlay pins in the sockets and allow the glue to fully cure.



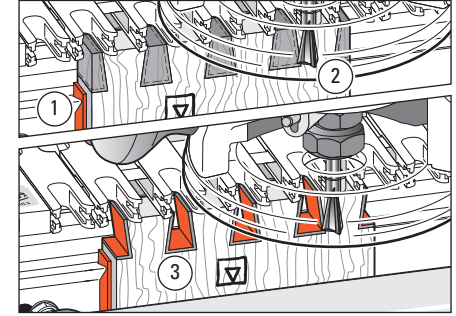
15 Saw off the pin pieces, either flush to the back of the tails, which looks like this (joint finish type A)....



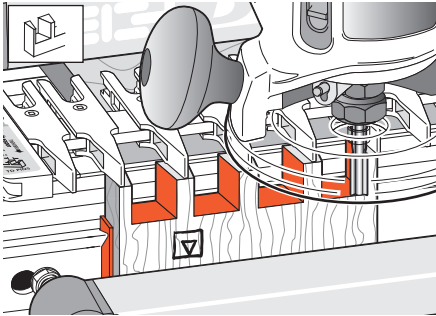
16 ...or further back by the thickness of the inlay, which looks like this (joint finish type B).




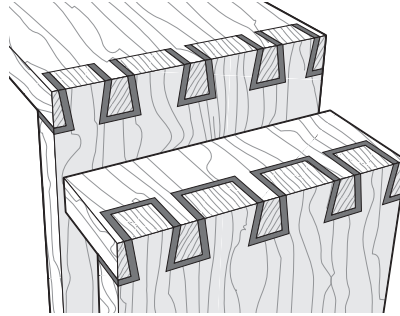
17 This latter (type B) method also leaves a fillet on the inside corner ①. This is best removed before final glue-up.



18 Rotate the finger assembly back to the **TD TAILS** mode. Clamp the "filled" tail board in the jig with the original **single shim** between the board and the side stop ①. Raise the dovetail cutter by the thickness of the inlay ②. Re-rout all of the pin sockets through the inlay wood ③ (joint finish type A illustrated) **making sure the shim is in place for each board**.



19 Rotate the finger assembly to the  TD PINS mode and, **with the single shim in place each time**, rout all the light coloured pin boards, with the straight cutter depth set to suit either joint finish type A or type B.



20 Glue and assemble in the usual way. ■

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