

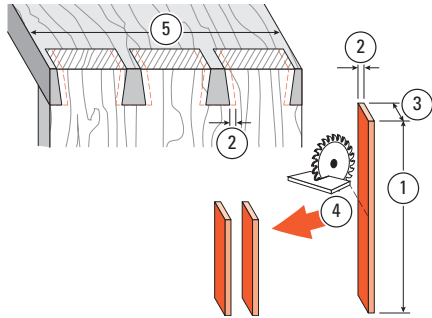
ATTENTION D1600 Jig Owners

LEIGH
Joining Tradition with Today

LEIGH INDUSTRIES
BULLETIN
May 2006
TIPS AND TECHNIQUES

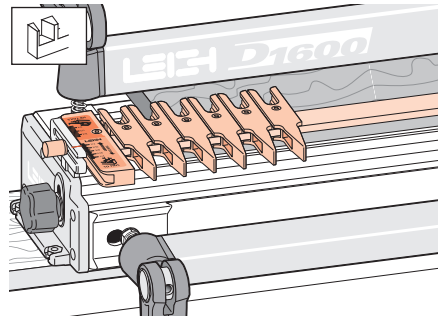
Routing Through Dovetails with Wider Pins

This bulletin assumes you've successfully routed through dovetails on D1600, and joint fit scale settings are properly calibrated. The D1600 jig is perfect for routing traditional dovetail joint layouts with narrow pins and wider tails. Wider pin routing is easy with the Leigh D4R jig's split guidefinger design, and D1600 users asked how they can occasionally rout wider pins with its one-piece guidefingers. We are pleased to offer two simple "wider pins" procedures for the D1600.

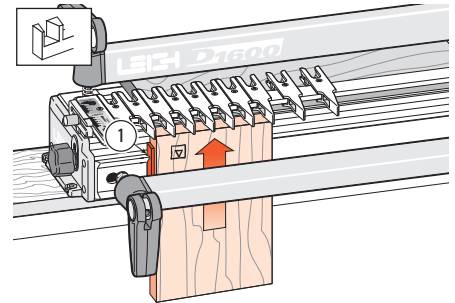


METHOD 1: This method produces equal size pins.

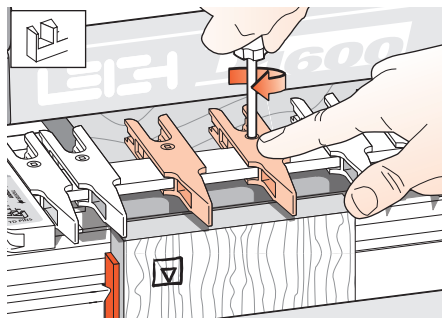
1-1 Make a 4" long shim ①; the thickness equaling **half** the desired increase in pin width ②; the shim width slightly less than the joint board thicknesses ③. Cut it into two pieces ④. Prepare the pin and tail boards to exactly the same width ⑤.



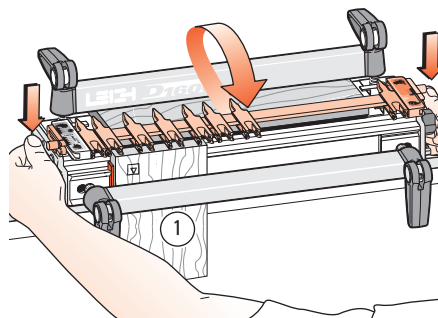
1-2 Place the finger assembly on the jig in TD PINS mode and the assembly touching the spacer board.



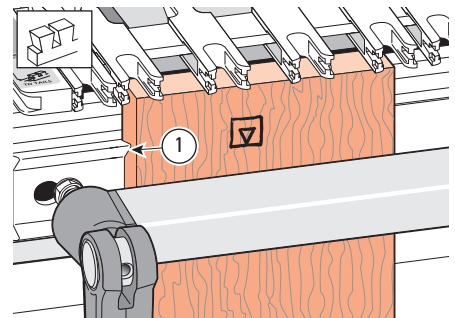
1-3 Clamp a work piece in the jig; its top edge touching flush under the guidefingers and the side edge trapping one of the shims against the side stop ①.



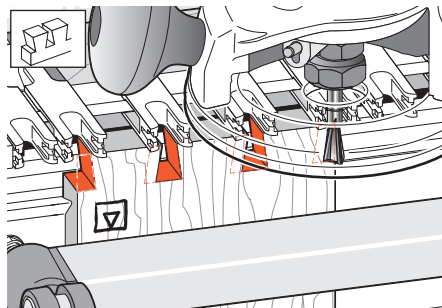
1-4 Raise the finger assembly slightly and position the guides to the desired layout, just as you would for a regular joint.



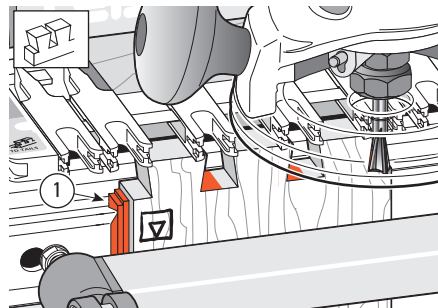
1-5 Rotate the finger assembly to the TD TAILS mode and lower the assembly onto the spacer board and tail board ①.



1-6 Unclamp, remove the shim, and move the tail board to touch the side stop ①. **Keep the shims handy**, you will need them momentarily.

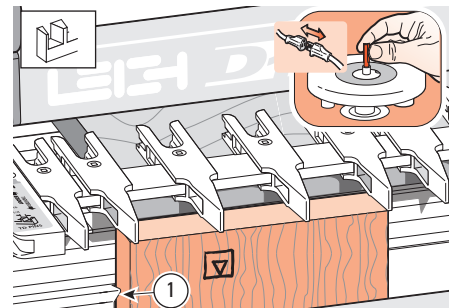


1-7 Rout the sockets with the dovetail cutter.



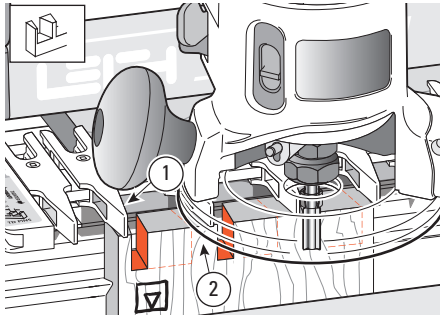
1-8 Unclamp the tail board. Re-clamp with **both** shims between the side stop and board ①. Rout in through the sockets again. Repeat this double routing procedure on the other end of this board and on each end of all tail boards.

If the combined thickness of the two shims is greater than cutter diameter you'll need to re-position the tailboards again half-way and rout to clean out the socket centres.

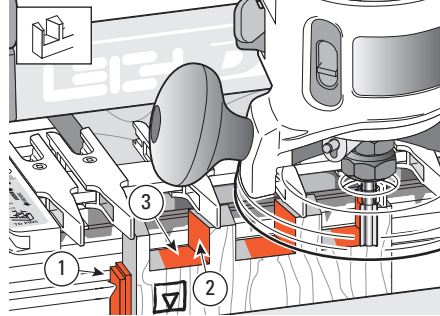


1-9 Change to the straight cutter. Clamp a pin board in the jig, one edge touching the side stop ①.

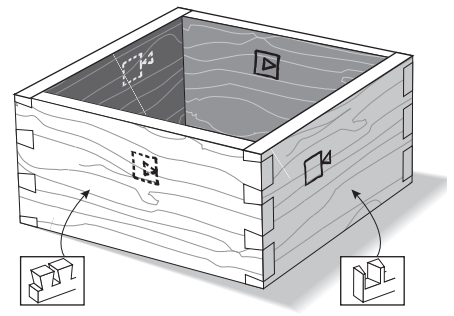
D1600 Jig Routing Through Dovetails with Wider Pins



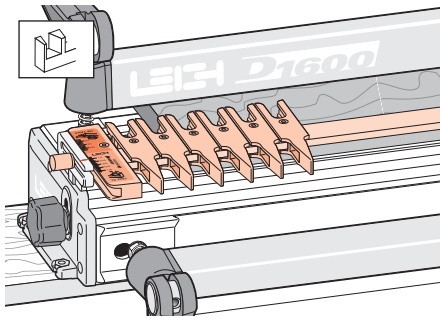
1-10 ⚠️ Rout in through the pin board **only on the sides of the pin guides furthest from the side stop**; the right hand pin sides in this illustration ①. Take great care not to rout toward the adjacent guide finger ②.



1-11 Unclamp the pin board and re-clamp **with both shims** between the side stop and board ①. Now rout in through the pin board only on the sides of the guides **closest to the side stop** ②; the left hand pin sides in this illustration. Take great care and rout away only the waste between the pins ③, without routing into the unprotected side of the adjacent pins. Repeat this procedure on each end of all pin pieces.

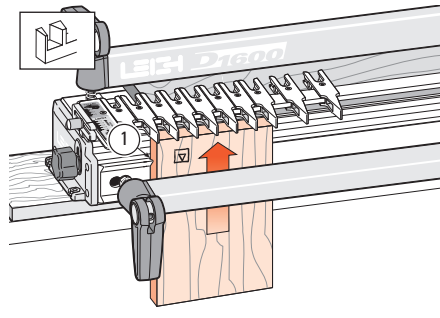


1-12 Glue and assemble in the usual way. ■

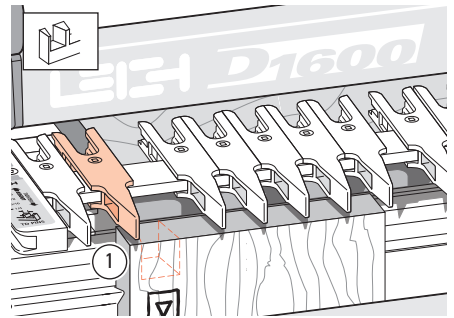


METHOD2: Different pinwidth combinations.

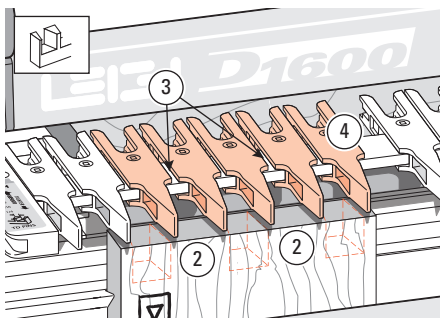
2-1 Place the finger assembly on the jig in the TD PINS mode and the assembly touching the spacer board.



2-2 Clamp a work piece in the jig; its top edge touching flush under the guidefingers and the side edge against the side stop ①.

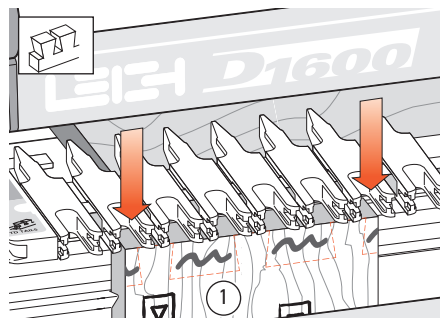


2-3 Raise the finger assembly slightly and position one guide at one edge of the board to form a half-pin to the desired width ①.

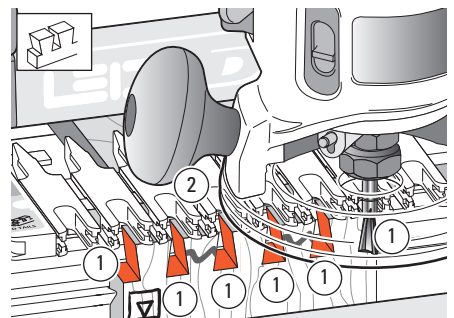


2-4 Now position pairs of pin guides to form "double-wide" pins ② centred on the desired positions.

Note: the guides may be touching ③ or spaced apart for even wider pins. Position the other half-pin guide ④.

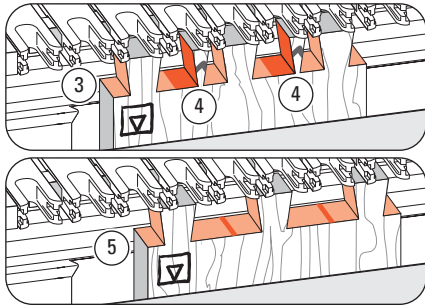


2-5 Rotate the finger assembly to the TD TAILS mode and lower the assembly onto the spacer board and tail board ①. Scribble on the socket areas to be routed.

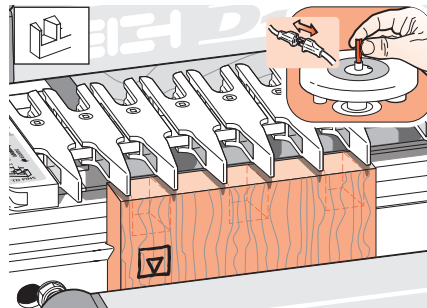


2-6 Rout all the normal socket positions with the dovetail bit ① and, if the guides are far enough apart, between the "pairs" of guides also ②. Take care not to rout where sockets are not required (only rout where you have marked).

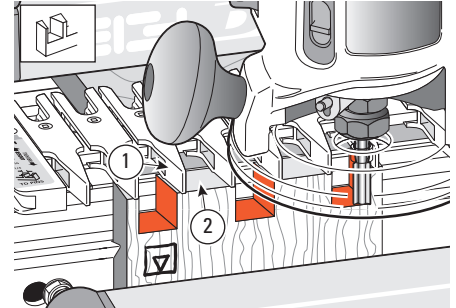
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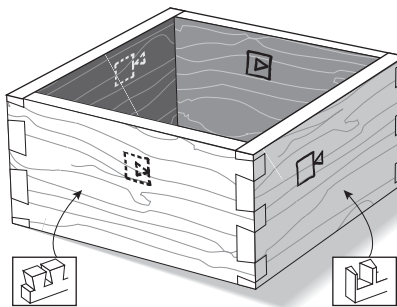
2-7 Unclamp the tail board and move it away from the side stop to a position ③ that will allow the rest of the sockets to be routed and re-clamp. Make sure that the top edge of the board is touching the underside of the guides. Rout out the rest of the sockets ④. Depending on the layout and spacing, it may be necessary to move the board ⑤ and rout again.



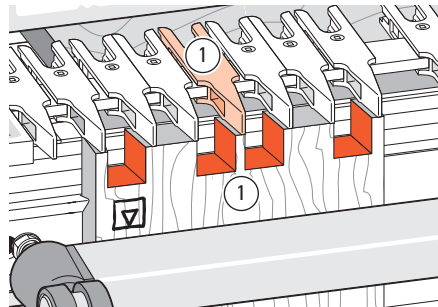
2-8 Rotate the finger assembly to the TD PINS mode. Change to the straight cutter. Clamp a pin board in the jig, the side edge against the side stop.



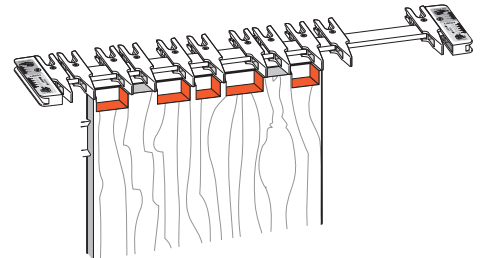
2-9 Carefully rout around the outer sides of the "double-wide" pins ① avoiding any chance of routing between the "pairs" ②. Repeat on all like pin boards.



2-10 Glue and assemble in the usual way.



2-11 Note also, that "single" pins may be positioned between the "double-wide" pins if desired ①.



2-12 Pin size mix and number of pins is determined by your board size and number of fingers on the D1600. ■

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