

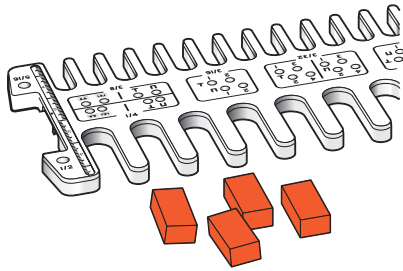
ATTENTION F1,F2,F1600 Template Owners

LEIGH
Joining Tradition with Today

LEIGH INDUSTRIES
BULLETIN
June 2006
TIPS AND TECHNIQUES

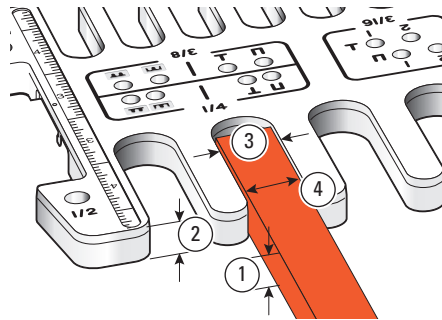
Routing Double & Triple Size Box Joints

This bulletin assumes you've successfully routed standard box joints, and joint fit VGS settings are calibrated. These simple procedures for larger box joints add versatility to your Leigh Finger Joint Template.

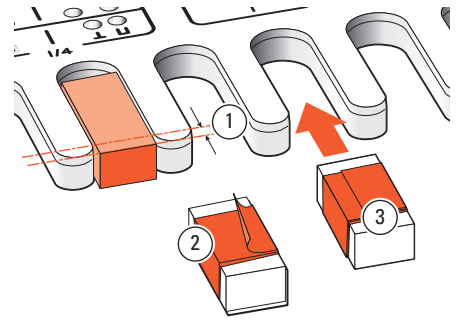


1-1 These procedures require you to rout into some template comb openings and not others. You will need to make "plugs" to block some openings in the selected comb. These are very simple and quick to make on your table or band saw.

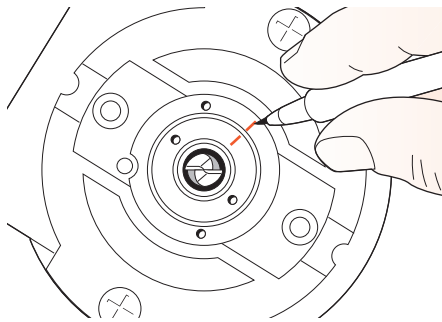
For board width specifications see 2-5.



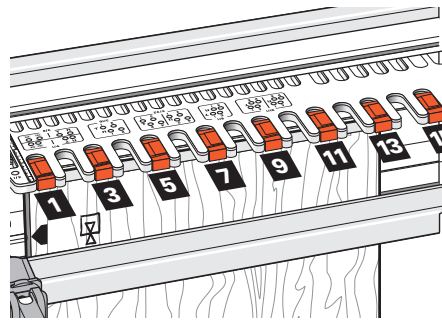
1-2 This example shows plugs for the 1/2" [12mm] template comb. Use 5/16" [8mm] ① thick board (less than the 3/8" [9,5mm] template thickness ②). The openings are 5/8" [16mm] ③ so rip a length of slightly under-sized strip, say 1/64" [0,3mm] smaller ④, so that the strip is a loose fit in the comb openings. **Why make them loose?** Because it's time consuming to get a perfect friction fit, and next time you use them they probably will have shrunk anyway.



1-3 Cut the strip in appropriate lengths (approximately flush with the front of the comb ①). Wrap each plug with masking tape ②, sufficient to make a snug friction fit in the comb openings. Do not force the plugs into place ③; moderate finger and thumb pressure is sufficient. Be sure they are snug and will not fall out under the router's vibration.

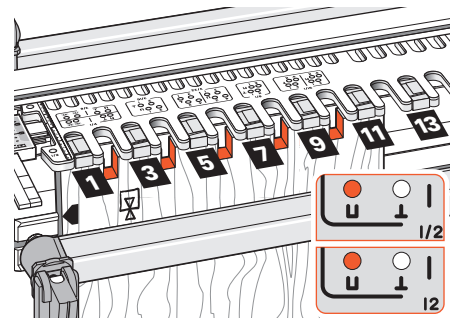


1-4 You are now ready to rout oversized joints. The guidebush adjustment for joint fit on oversized joints should be exactly as it was for the nominal size, **but rout a test oversized joint first to confirm the fit.**

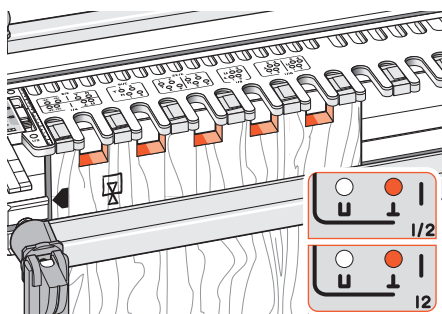


DOUBLE-SIZE JOINTS

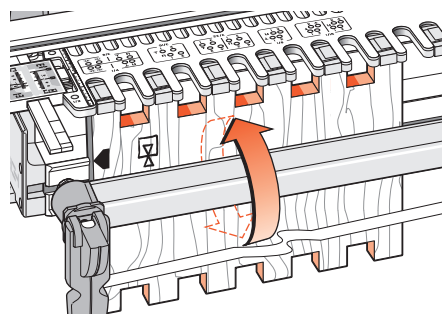
1-5 Starting with the **first opening as number one**, place plugs in this and **each odd numbered opening** (1, 3, 5 etc.) across the comb width.



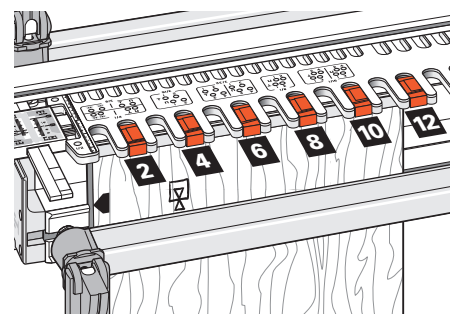
1-6 Board 1: Position the template in the **U** pin position. Rout in the even numbered template openings across one end of board ①. **Do not move the board.**



1-7 Move the template to the **I** pin position and again rout the open sockets.

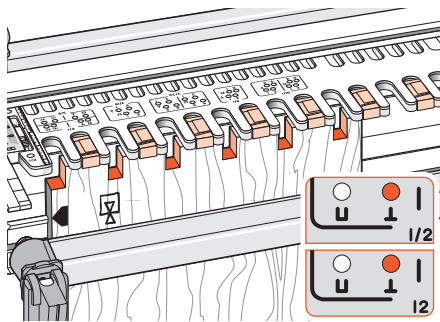


1-8 Turn board ① end-for-end (same side edge to the side stop and opposite face against the jig each time). Repeat steps 6 and 7 on this end of board ① and on both ends of board ③.

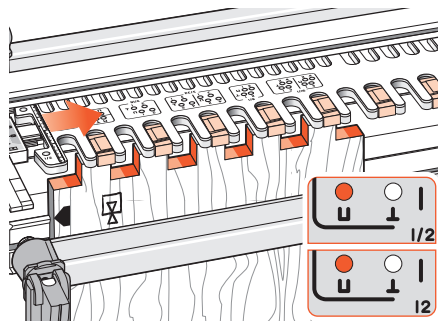


1-9 Remove the plugs and starting with the **second opening in**, place plugs in **all the even numbered comb openings.**

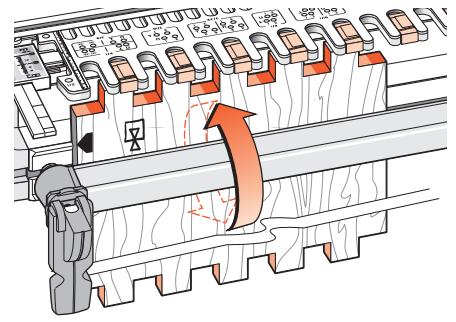
F1,F2,D1600 Routing Double & Triple Size Box Joints



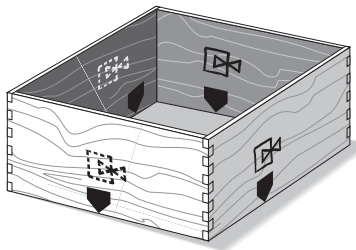
1-10 Board 2: Leave the template in the **I** pin position. Rout the odd numbered template openings in board 2. Do not move the board.



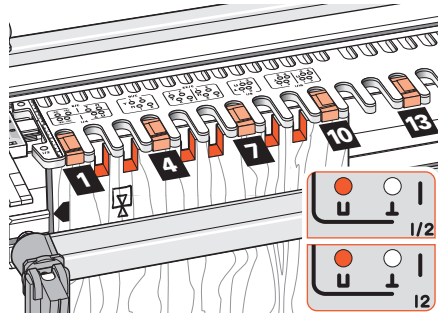
1-11 Move the template to the **U** pin position and again, rout all of the open sockets in board 2



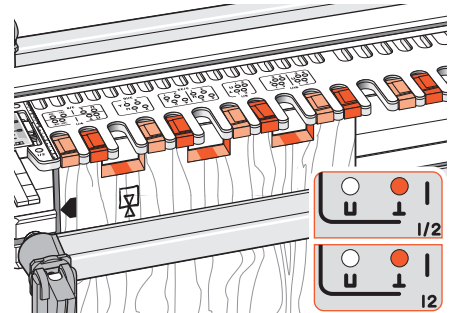
1-12 Turn board 2 end-for-end (don't forget, the same side edge to the side stop) and repeat steps 10 and 11 on this end of board 2 and on both ends of board 4.



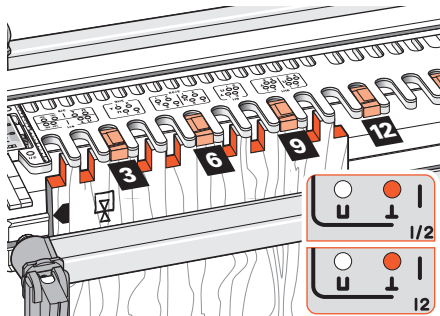
1-13 Assemble the box with all of the four "side-stop edges" either at the top, or at the bottom of the box. ■



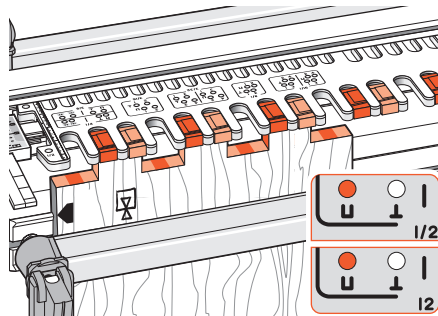
TRIPLE SIZE JOINTS:
2-1 Board 1: Plug openings 1, 4, 7, 10 and 13 (i.e. every third opening thereafter). Set the template in the **U** pin position and rout all of the open sockets in board 1. Do not move the board.



2-2 Move the template to **I** pin position. Add plugs to openings 2,5,8 (and every third thereafter), then rout the remaining openings. *The very bold among you can skip adding the extra plugs and after moving to the **I** position, rout only the template openings to the left of each plug*
Repeat steps 1 and 2 on the other end of board 1, and on both ends of board 3.



2-3 Board 2: Remove the previous plugs and plug openings 3, 6, 9, 12 and 15 (i.e. every third opening thereafter). With the template still in the **I** pin position, rout all of the open sockets in board 2. Do not move the board.



2-4 Move the template to **U** pin position and add extra plugs to openings numbers 2, 5, 8 (and every third opening thereafter). *Again, those with their wits about them can skip adding the extra plugs and after moving to the **U** position, rout only the template opening to the right of each plug.*
Repeat steps 3 and 4 on the other end of board 2 and on both ends of board 4.
Assemble the box with all of the four "side-stop edges" either at the top, or at the bottom of the box, similar to 1-13.

Board Widths

Symmetrical Double Joints -lines 6, 10, 14 etc.
Asymmetrical Double Joints -lines 4, 8, 12 etc.

Symmetrical Triple Joints -lines 9, 15, 21 etc.
Asymmetrical Triple Joints -lines 6, 12, 18 etc.

2-5 To determine appropriate board width, select a joint layout and lookup the "line numbers" in the F-Template User Guide Board Width Chart.

© Leigh Industries Ltd. All rights reserved.

This pdf publication may be downloaded and stored on a computer and printed, viewed, and freely distributed for operational guidance and evaluation purposes. This document supplements the full User Guide publication for the Leigh tool and may refer to and depend on information in other parts of the tool's User Guide for completeness. Except as provided herein, no part of this document may be reproduced, sold, published or modified without the prior written permission of Leigh Industries Ltd. [June2006]