

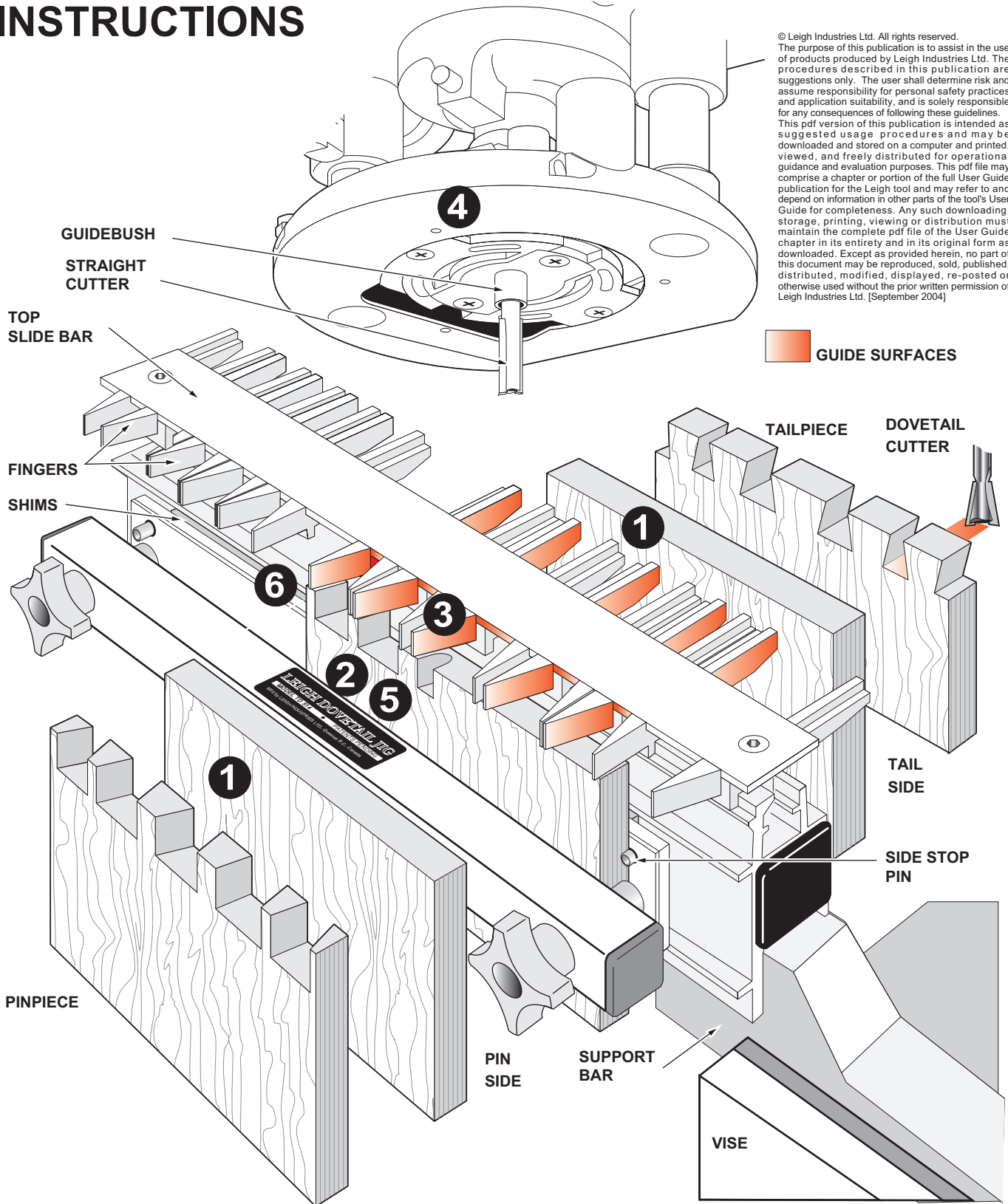
LEIGH®

DOVETAIL JIGS

TD 514 TD 514-L

INSTRUCTIONS

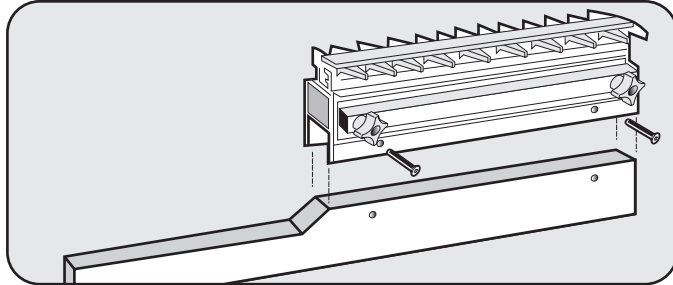
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Precise through dovetails have been a hallmark of fine cabinet-makers for generations. With the unique TD514 Leigh Dovetail Jig , you too will master this most attractive of joints.

SUPPORT BAR

Make up and mount support bar (not supplied) as shown before using the jig. Never mount the jig directly in the vise.



PREPARE ROUTER

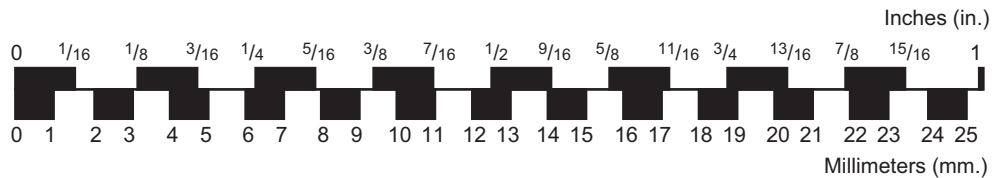
Select cutter/guidebush combination from chart. Fit guidebush concentrically with cutter.

Pinpiece Thickness	Straight Cutter Dia.	Tailpiece Thickness	Dovetail Cutter	Guidebush Dia.	Approx. No. of Shims	Actual Shims:
UP TO 3/8"	5/16" #140	UP TO 1"	3/8" x 14° #110	7/16"	19-20**	<input type="checkbox"/>
UP TO 1/2"			1/2" x 14° #120		19-20	<input type="checkbox"/>
UP TO 3/4"	1/2" #160		3/4" x 14° #130	5/8" *	11-12	<input type="checkbox"/>

*Guide fingers must be at least 3/16" apart.

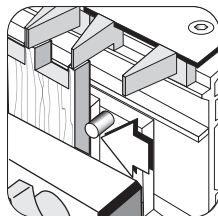
**Add 1/4" packing piece (see special case).

METRIC CONVERSION



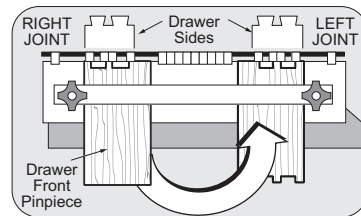
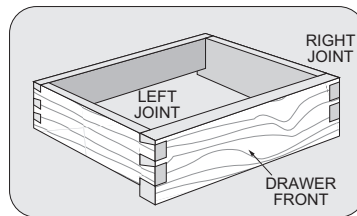
SPECIAL CASE- 3/8" PINS

Make up an insert 1/4" packing piece for pin side as illustrated.



SPECIAL CASE- ASYMMETRICAL JOINTS

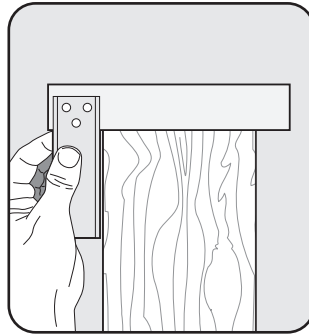
Set a similar layout of fingers at each end of the jig. In the example shown both drawer front and sides are mounted with the top edge to the stop pin at each end of the jig. Joints at the rear of the drawer may be different again.



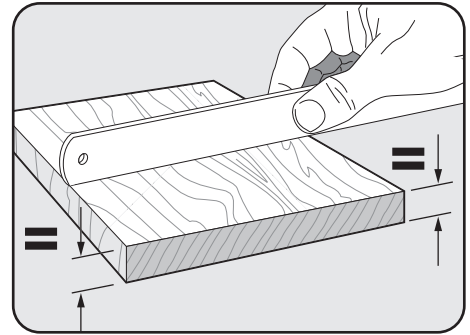
GENERAL INSTRUCTIONS

Follow these instructions in sequence and refer each step to the illustration above. Repeat for each cutter guidebush combination.

STEP 1 PREPARE JOINT PIECES

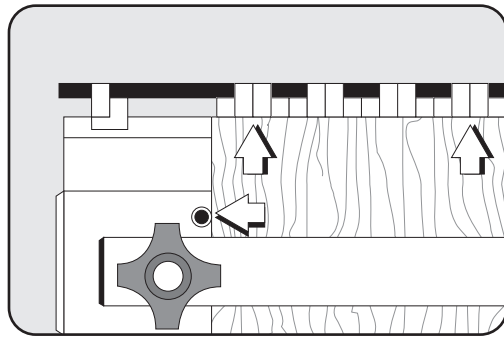


Square



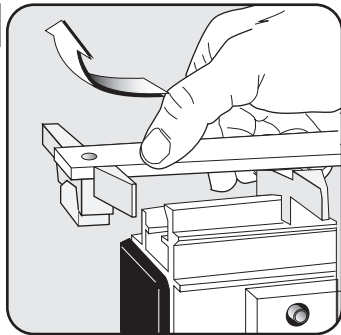
Flat and even thickness.

STEP 2 MOUNT JOINT PIECE

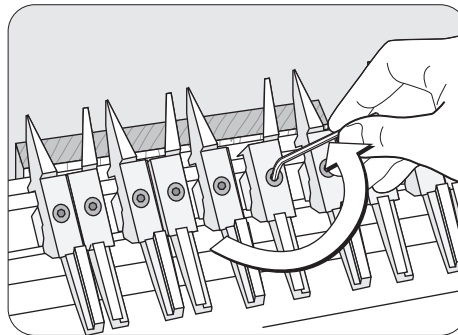


Fit joint pieces flush under fingers and against side stop pin, face sides away from jig body.

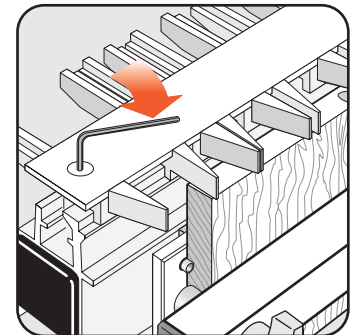
STEP 3 ARRANGE FINGERS



Loosen the two top slide bar screws and remove slide bar as shown. Do not remove screws.



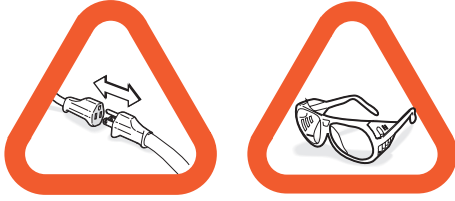
Loosen finger screws 180°, arrange fingers to required joint layout by eye and re-tighten. Ensure no dust is trapped between fingers and rail.



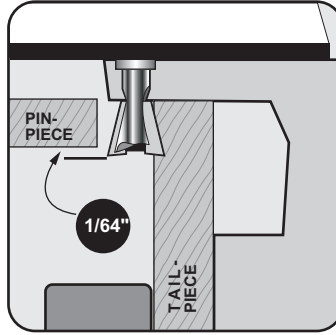
IMPORTANT. Replace top slide bar. Do not overtighten any screws.

STEP 4
SET DEPTH OF CUT

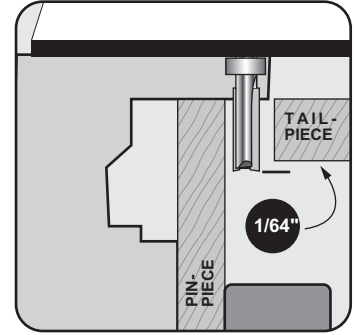
Prepare the router (see above). Familiarize yourself with the router and safety instructions supplied with the tool.



CAUTION: Always disconnect the router before changing or adjusting cutters. Always wear approved eye protection when operating the router.

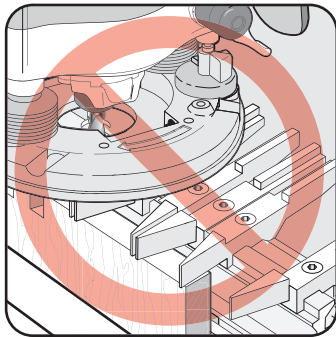


Set dovetail cutter to thickness of pinpiece plus 1/64".

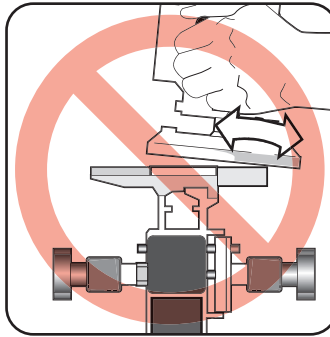


Set straight cutter to thickness of tailpiece plus 1/64" and not more than 1" deep.

STEP 5
CUT TEST JOINT



Top slide bar must be in place when routing

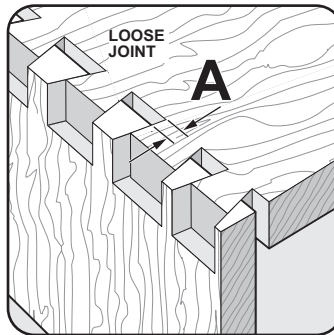


Keep router flat down on top surface of jig.

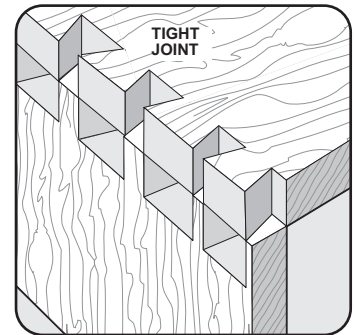
Work the guidebush along the guide faces and ensure that all waste is removed from joint sockets before removing jointpieces from jig.

STEP 6
ADJUST JOINT TENSION

Adjustment of shims does not affect tail size, each shim is 1/64" thick and will alter pin width by .008". Repeat steps 5 and 6 until joint fits, cutting only new pins for re-testing. For each cutter/guidebush combination record on the chart above the number of shims remaining in the jig. Re-check adjustment when using new or reground cutters. Joint tension will also vary with differing hardness of wood.



Remove shims equal in thickness to joint gap A to form larger pins.



Add shims to form smaller pins.