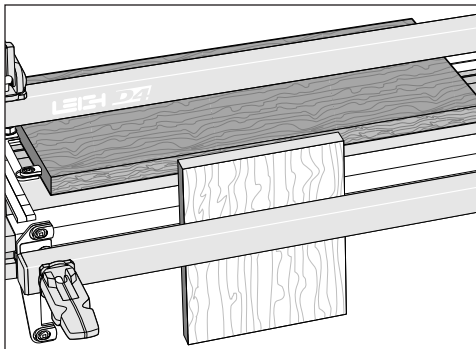


## How to rout WIDER BOX JOINTS on Leigh F1, F2 and F3 Templates

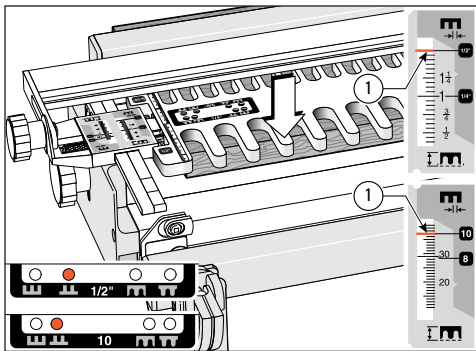
Woodworker and Leigh Jig user Donald Brown of Havana, Florida sent us this good idea on routing procedures for wide box joints on Leigh Finger Joint Templates.



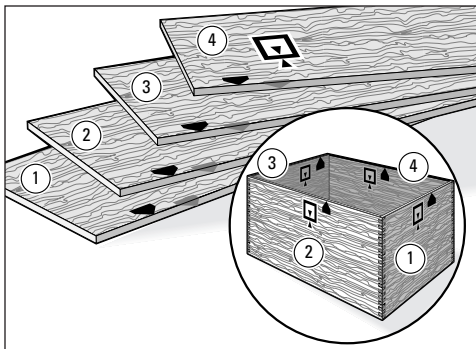
These instructions are based on the assumption that you are fully conversant with the use of your Finger Joint Template and the instructions in the User Guide. Do not attempt the following procedures until you are. Practice with scrap boards before attempting to make a finished project. Note that the side stop configuration may be different on your jig, but the procedure is still the same.



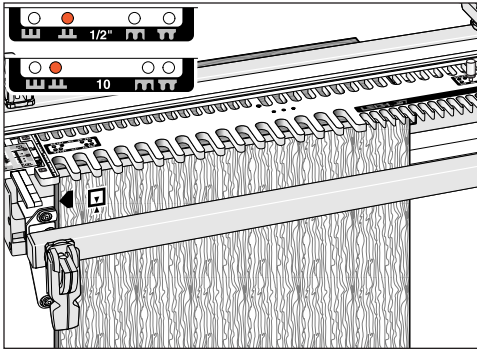
1. Replace the spacer board with a scrap backup board. This board needs to be flat and even thickness like the spacer board and have its front edge straight. It should be long enough to extend past the end of the active comb. Clamp a temporary front board and position the backup board touching it. Clamp the backup board and then remove the front board.



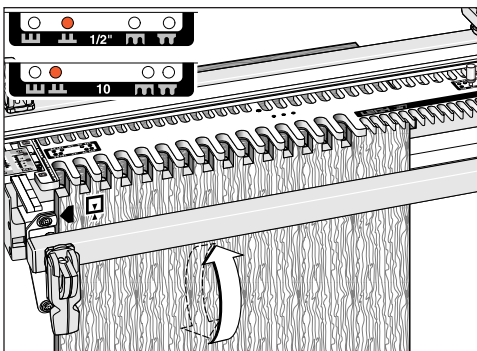
2. Lower the template onto the backup board and set scales on the comb size to be used (example here: 1/2" [and 10mm] combs ①). Position the template with the template pin in the 1/2" position.



3. Refer to the extended board width chart on the back of this bulletin. Prepare four boards and mark them 1,2,3,4. Select the grain alignment and mark the common top (or bottom) edges. Don't worry about face side selection, this can be done after routing.

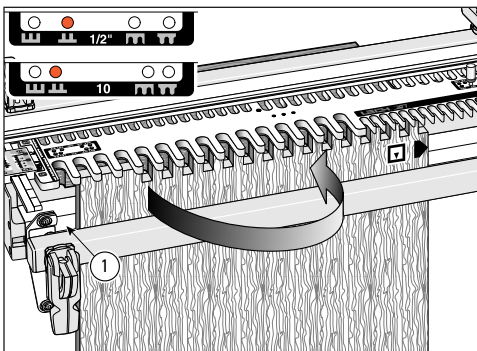


4. Clamp board No. 1 in the jig, side edge mark to side stop, top end edge touching the underside of the template. Make sure the horizontal scrap board is touching firmly against the rear of the workpiece.

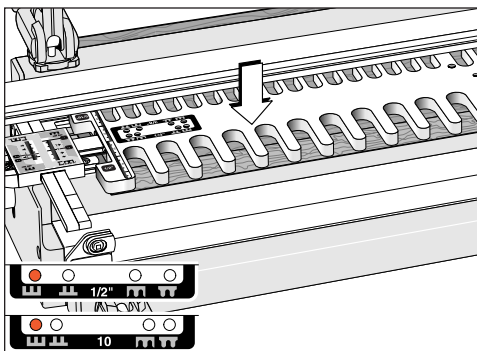


5. Rout the full width of the active comb on both ends of boards 1 and 3 in position 1. Be sure to keep the same side edges to the side stop. **Do not move or remove the backup board.**

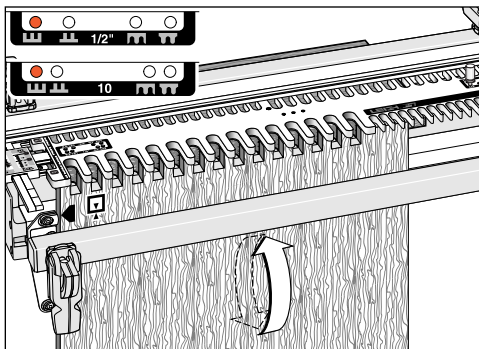
*Remember: All square box joint boards (for boxes or end-on-end joints) are clamped alternately face-in and face-out 1.*



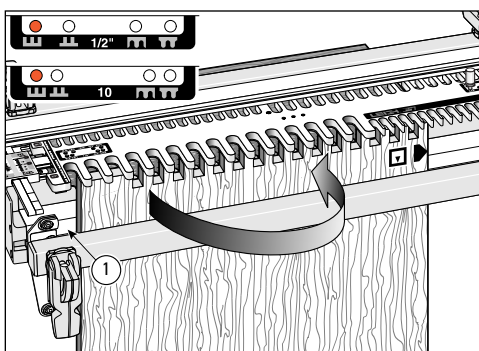
6. Turn board No. 1, like turning the page of a book so the side stop mark is now to the right. Very carefully position and clamp the board in the jig so the previously routed sockets in the workpiece **perfectly line up with the routed sockets in the backup board.** Keep the left edge of the board away from the side stop ①. Rout the left side of this end. Repeat this procedure to complete the routing of the other end of board 1, and both ends of board 3.



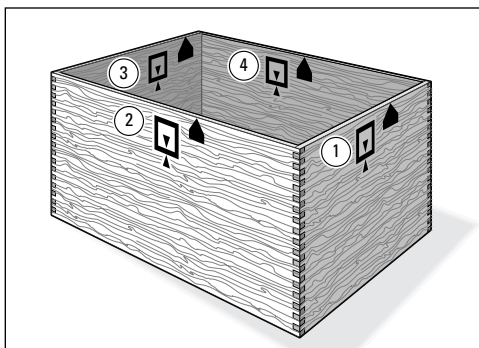
7. Move the template to position 2 and replace the backup board with a new clean-edged piece.



8. Rout both ends of boards 2 and 4, first routing both ends of each board against the the left side stop, and then...



9. ...reposition (as with boards 1 and 3) to align and complete the routing. **Keep the left edge of the board away from the side stop ①.** Rout the left side of this end of boards 2 and 4.



10. Keeping the marked side stop edges of all boards toward the top (or bottom) of the box, select the preferred outside faces of the boards and assemble the box. Remember; box joint corners need clamping from both directions, or use strap clamps and blocks.

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



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01/2000

## BOARD WIDTH CHART (INCHES and MM)

Numbers in white column are number of sockets and pins

	1/2"	3/8"	10mm	8mm
				
30				
31	15.686 ▼15 11/16			
32				
33	16.702 ▼16 11/16			
34				
35	17.718 ▼17 23/32			
36				
37	18.734 ▼18 23/32			
38				
39	19.750 ▼19 3/4			
40				
41	20.766 ▼20 3/4			
42				
43	21.782 ▼21 25/32			
44				
45	22.798 ▼22 13/16			
46				
47	23.814 ▼23 13/16			
30		15.178 ▼15 3/16		
31				
32		16.194 ▼16 3/16		
33				
34		17.210 ▼17 7/32		
35		13.343 ▼13 11/32	12.960 ▼12 31/32	
36		14.109 ▼14 3/32	13.726 ▼13 23/32	
37		14.875 ▼14 7/8	14.492 ▼14 1/2	
38		15.641 ▼15 5/8	15.258 ▼15 1/4	
39		16.407 ▼16 13/32	16.024 ▼16 1/32	
40		17.173 ▼17 3/16	16.790 ▼16 25/32	
41		17.939 ▼17 15/16	17.556 ▼17 9/16	
42		18.705 ▼18 23/32	18.322 ▼18 5/16	
43		19.471 ▼19 15/32	19.088 ▼19 3/32	
44		19.854 ▼19 27/32	19.854 ▼19 27/32	
45		20.237 ▼20 1/4	20.620 ▼20 5/8	
46		21.003 ▼21	21.386 ▼21 3/8	
47		21.769 ▼21 25/32	22.152 ▼22 5/32	
48		22.535 ▼22 17/32	22.918 ▼22 29/32	
49				
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Use to the nearest 1/32" or 1mm for width selection. To make symmetrical square joints, use the board widths in dark grey. For asymmetrical square joints, use the board widths in light grey.