

*F2, F1600* **CHAPTER 1**

# **Assembly, Mounting and Template Alignment**



## Assembly and Mounting

Before you begin mounting the Leigh Finger Joint Template to your Leigh jig, make sure you have received the model ordered (Inch or Metric), and all the necessary parts.

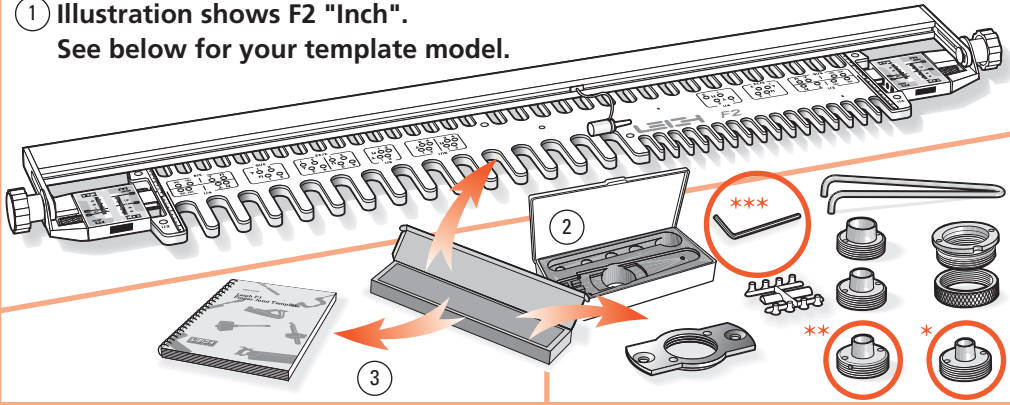
1. 1 complete Template “inch” assembly  
or  
1 complete Template “metric” assembly
2. Variable Guidebush System consisting of:
  - 1 storage box
  - 1 pin wrench
  - \*\*\*1 hex key (F2/F2M only)
  - 1 700V holder with lock nut
  - 1 701V holder
  - \*1 709V bush (inch templates only)
  - \*\*1 711V bush (with F2 inch/metric, F1600M)
  - 1 713V bush
  - 1 716V bush
  - 6 bush nylon plugs (on one tree)
3. 1 user guide

*If any of these items are missing, please notify your supplier or Leigh Industries immediately.*

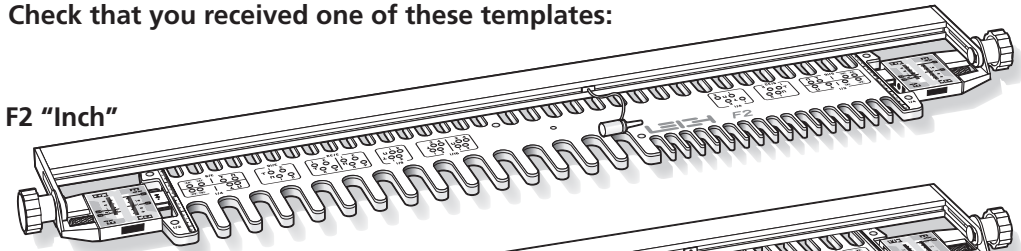
Your Leigh F2 or F1600 comes fully assembled and require only mounting and indexing to your Leigh jig. This procedure is critical to the accuracy of the finished joinery, so please follow the mounting instructions carefully.

Record your template serial number (located on the underside of the scale block) in the space reserved on page 82 or 84.

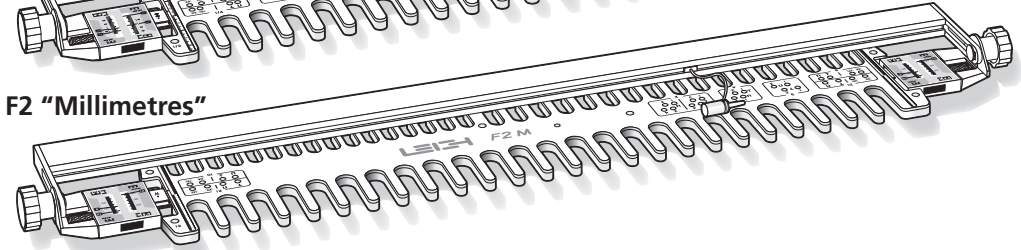
① Illustration shows F2 "Inch".  
See below for your template model.



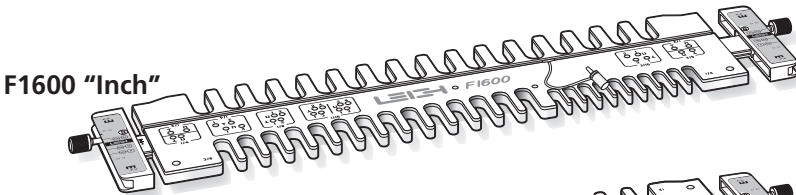
Check that you received one of these templates:



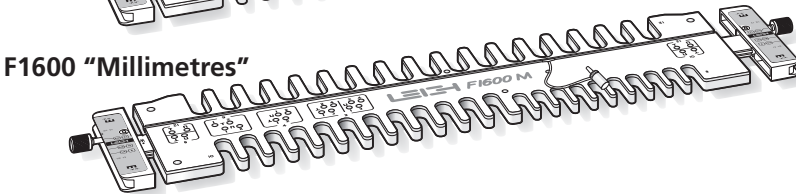
F2 "Inch"



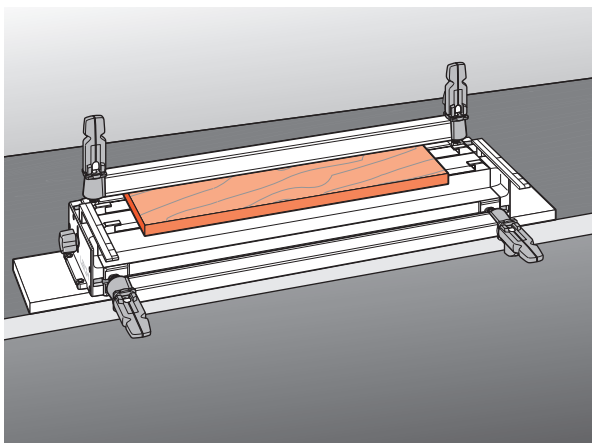
F2 "Millimetres"



F1600 "Inch"



F1600 "Millimetres"

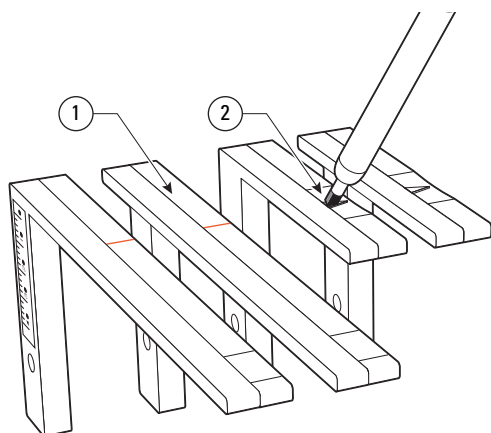


### 1-1 Mounting F2/F2M to 24" Series Jig

*Note: See 1-11 for F1600 setup.*

Procedure is the same for Inch and Metric 24" templates.

Make sure your jig is mounted as per its User Guide, and the spacer board is clamped into position.

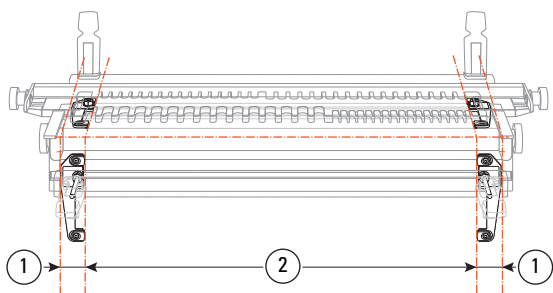


### 1-2

#### D1258, D1258R and D3 jig owners:

If you already own the Leigh Mortise and Tenon Attachment, fit the extended support brackets ① of this attachment and use for all finger jointing and dovetailing procedures. If not, mark the tops of the arrow pointers on the standard support brackets ② with a dark felt pen.

D4 and D4R Jig owners already have the extended brackets.

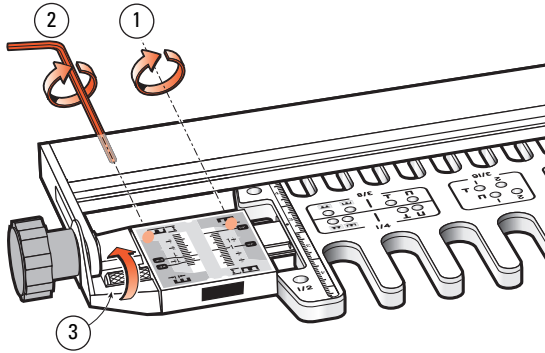


### 1-3 Centring the Template on the Jig

#### All 24" D series jigs except D4R

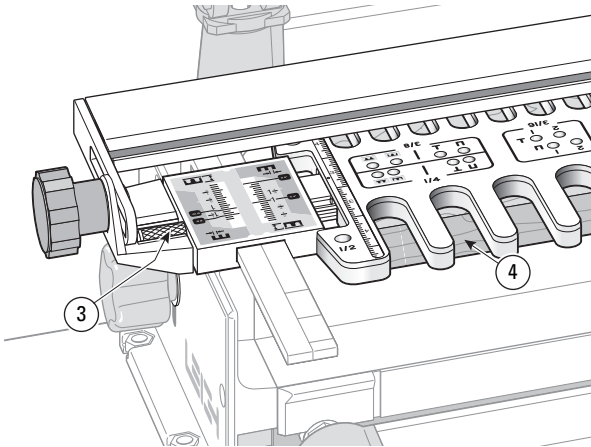
Before installing the F2/F2M on any 24" D series jigs that have adjustable side stops, it is imperative that those stops are correctly set and indexed according to the assembly instructions in the jig's user guide. Are the stops  $1\frac{1}{2}$ " [38mm] in from each end of the jig body extrusion ①? Are the stops  $24\frac{1}{8}$ " [613mm] apart ②? If not set up correctly, this must be done now.

*D4R and D1600 jigs have fixed side stops and do not require setup.*



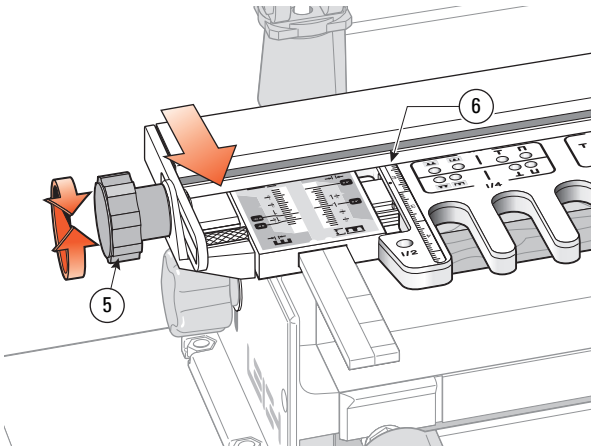
**1-4 Attaching the Scales**

Loosen the two scale bar set screws ①, the two fence bracket screws ②, and two scale thumb screws ③ at both ends of the template.



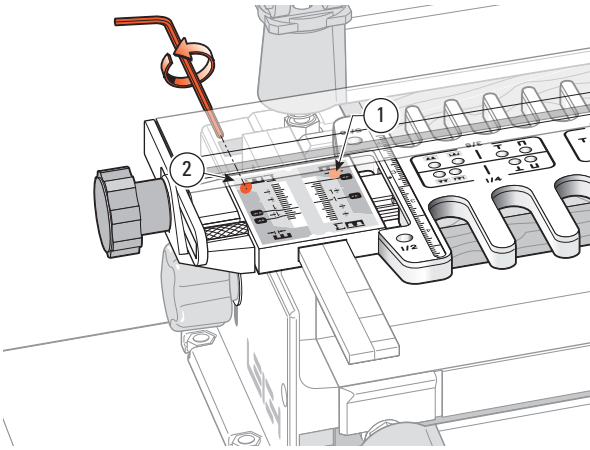
**1-5**

Slide the template assembly onto the jig support brackets with the 1/2" & 1/4" [12mm] combs toward you and lower it gently onto the jig's spacer board ④. Make sure the scale reading is the same on both scales, say on the 1" [25mm] mark, then tighten the thumb screws ③.

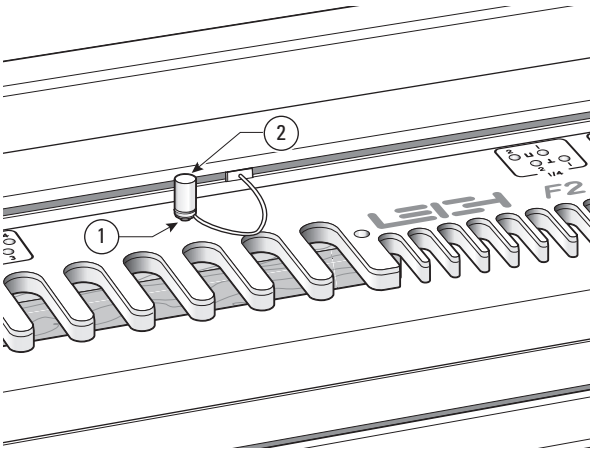


**1-6**

Loosen the fence knobs ⑤ and move the fence on the template toward you as far forward as possible and with the fence scale reading the same at both ends ⑥. Then tighten the fence knobs ⑤.

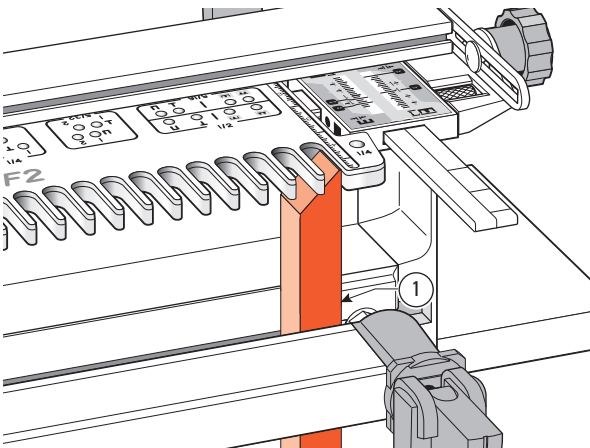
**1-7**

Tighten the scale bracket screws ②, but do not tighten the scale bar ① screws yet.

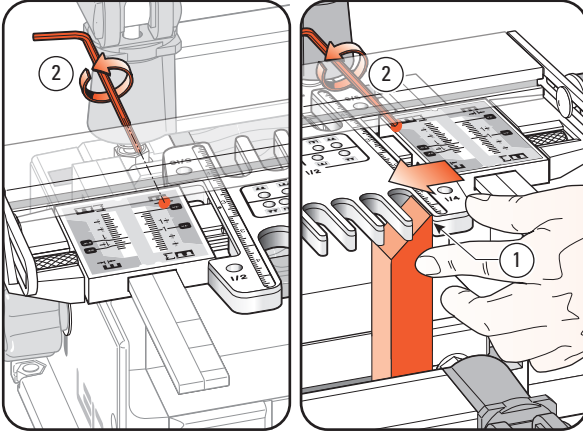
**1-8 Centring the F2**

*For F1600 centring, see 1-11*

Align the template so that the template's centre hole ① lines up with the hole in the bar and insert the template pin ②. *Discard the shipping plug from the hole.* Gently twist and push the tapered pin into the hole until it is fully seated. The template is now perfectly centred on its bar, but now we must centre the bar in the scales.

**1-9**

Angle trim the end of a perfectly straight block. Slide the combined bar/template to allow the block to protrude into the last socket of the 1/4" [8mm] comb. Clamp with its vertical edge tight against the right hand side stop ①.

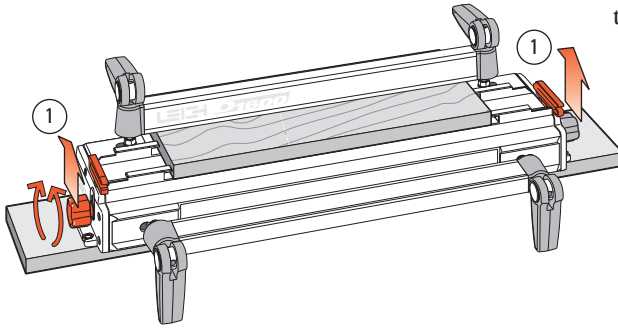


**1-10**

Move the combined template and bar to the left until the right side of the outer 1/4" [8mm] opening touches the block ①. Taking care to not move the template assembly, tighten the scale screws at both ends of the template ②. Remove the wood block and your Leigh F2 is ready for use.

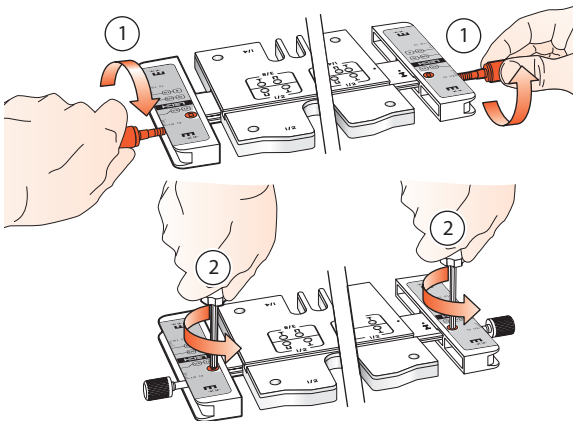
**1-11 D1600 Jig Owners**

Raise both end support brackets and tighten the support bracket knobs ①.

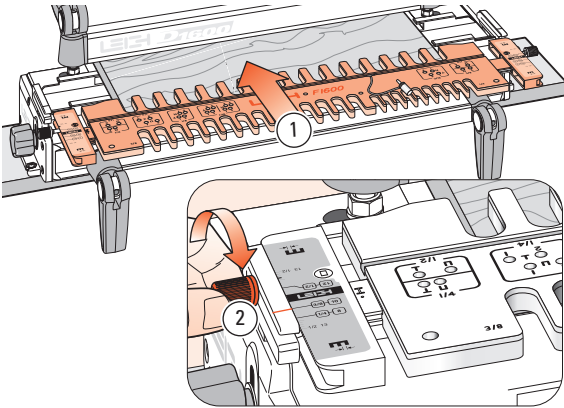


**1-12**

Install the two thumbscrews a few turns into the scales ①. Loosen the scale lock screw ② at **both** ends (by one turn only).



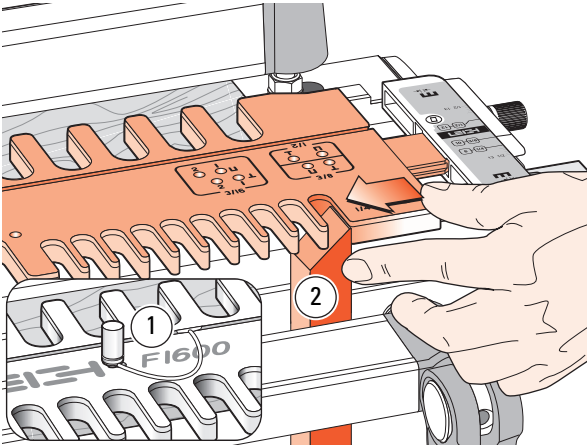


**1-13**

Slide the template onto the support brackets, with the  $\frac{3}{8}$ " [10mm] comb toward you ① and set on the  $\frac{3}{8}$ " [10mm] setting.

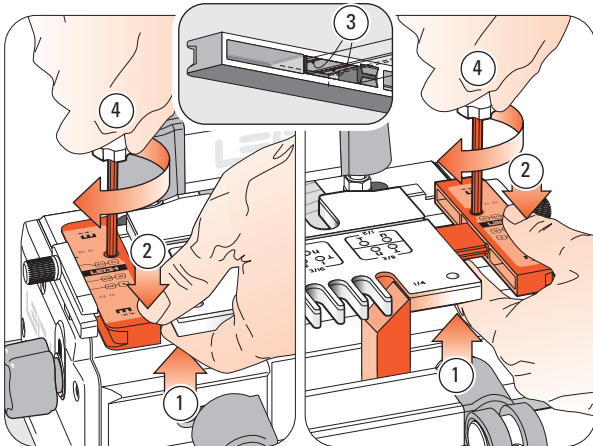
**Tighten both thumbscrews ②.**

**Do not lower the assembly onto the finger support board.**

**1-14**

Remove and discard the shipping plug from the template centre hole. Align the centre hole with the hole in the bar and firmly insert the Template Pin ①.

Move the combined template and bar to the left until the right side of the outer  $\frac{1}{4}$ " [8mm] opening touches the block ②. Taking care to not move the template assembly...

**1-15**

...pull up on the template bar ① while pushing down on the scale ② to ensure the bar is touching the two registration pads ③ inside the scale. Maintain pressure and tighten the scale lock-screw ④. Repeat at the other end. Remove the block and your template is ready to use.

**To maintain correct template alignment, follow this procedure whenever you remove the scales from the finger assembly. ■**