

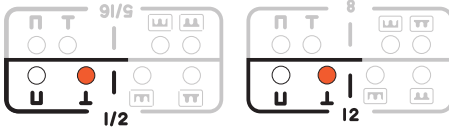
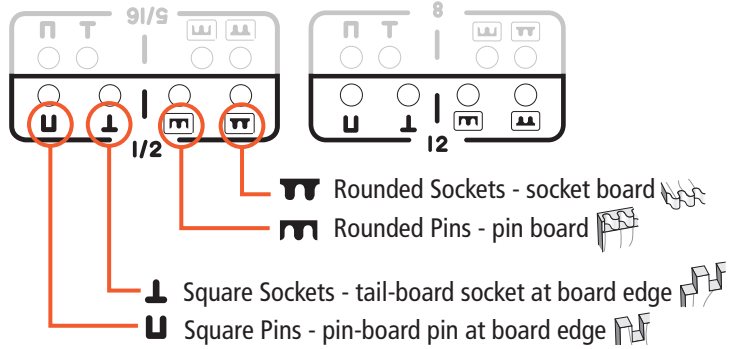
F2, F1600 **CHAPTER 3**

Operation Concepts and Basic Template Functions



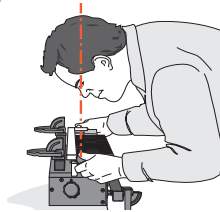
Template Modes F2

Template pin hole icons denote the type of joint and edge finish from each position.



Throughout the manual, the proper pin location for each step is highlighted with red in an inset. Only the front (active) pinholes will be shown.

Scale Modes F2



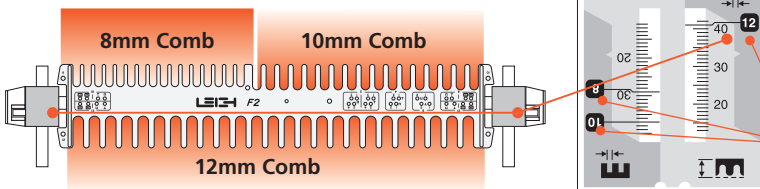
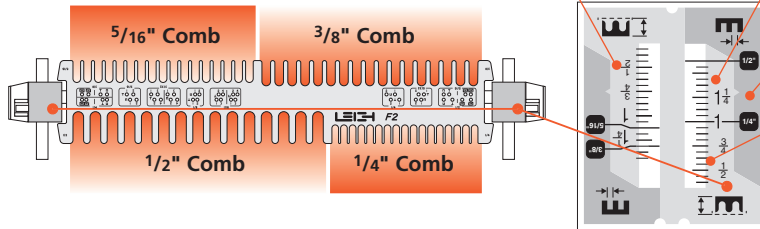
Always read scales from directly overhead to avoid parallax problems.

The inactive scale is always on the left side of each scale assembly and is upside down.

The active scale is always on the right side of each scale assembly.

Green scales are for box joints.

Grey scales are for rounded finger joints and denote the thickness of the vertical pin board.



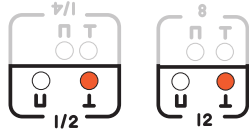
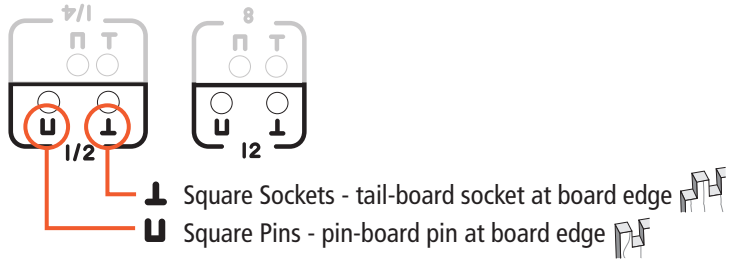
Each scale has its own mode icon representing the current joint part being made.

There are four settings for inch box joints, and three for metric.

The specific settings for each scale are fully described in the appropriate chapters.

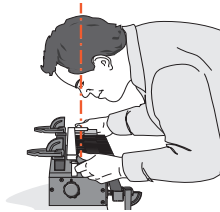
Template Modes F1600

Template pin hole icons denote the type of joint and edge finish from each position.

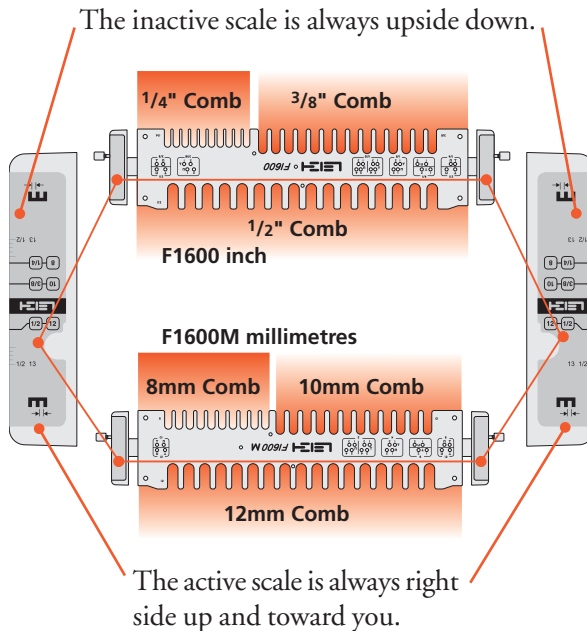


Throughout the manual, the proper pin location for each step is highlighted with red in an inset. Only the front (active) pinholes will be shown.

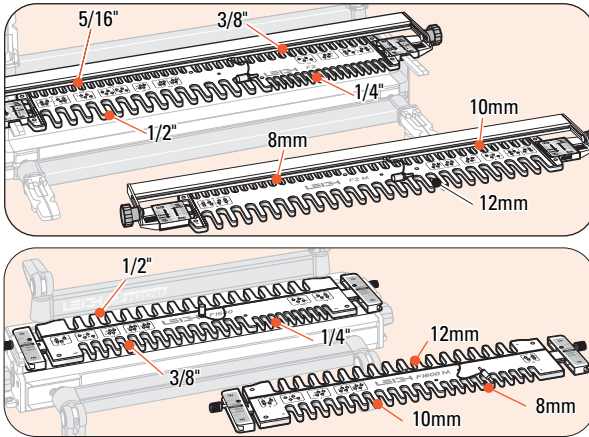
Scale Modes F1600



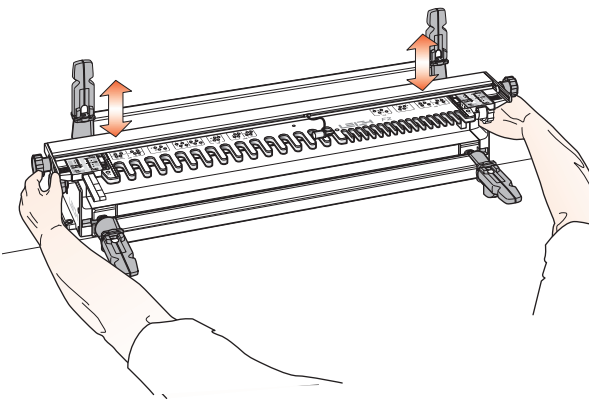
Reading scales from directly overhead improves setting accuracy.



The specific settings for each scale are fully described in the appropriate chapters.

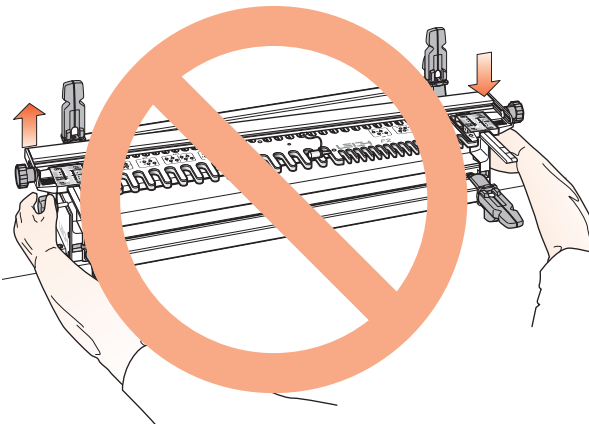
**3-1**

The *active* comb (the one you wish to use) is positioned toward you at the front of the jig. Depending on the Template model and comb size selected, the active comb may start at either the right, or left-hand side of the jig. Combs that are the full width of the template always start at the left side.

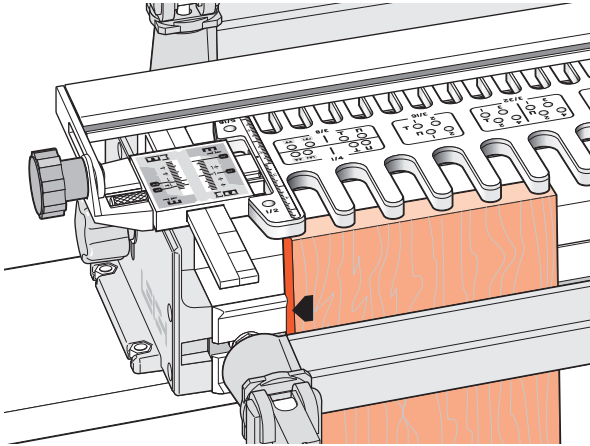
**3-2**

The template is raised or lowered using the support brackets to suit different thicknesses of horizontal boards.

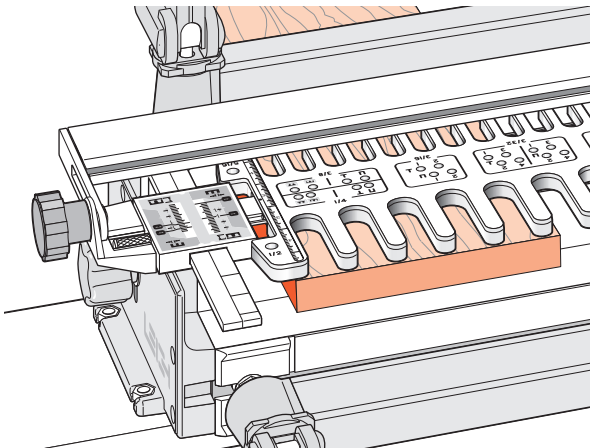
Remember, this sequence of "operation concepts" shows the F2 template, but the same procedures apply to the F1600.

**3-3**

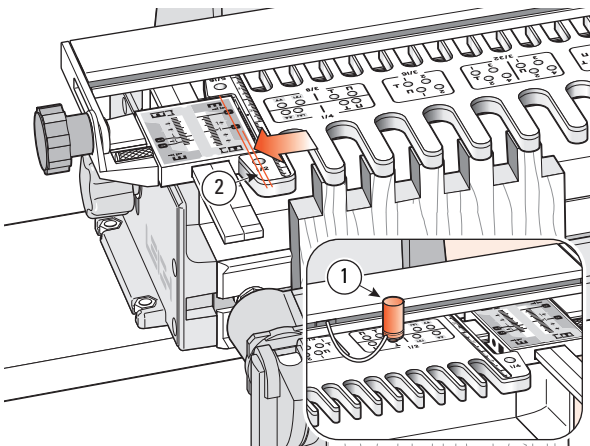
Do not raise or lower one end of the template at a time.



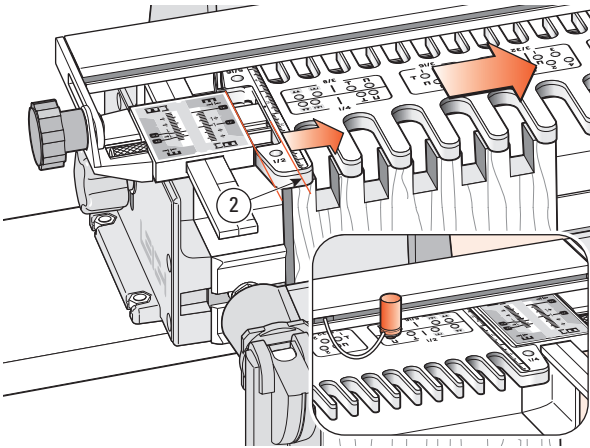
3-4
You will clamp your work pieces against the front side stop or...



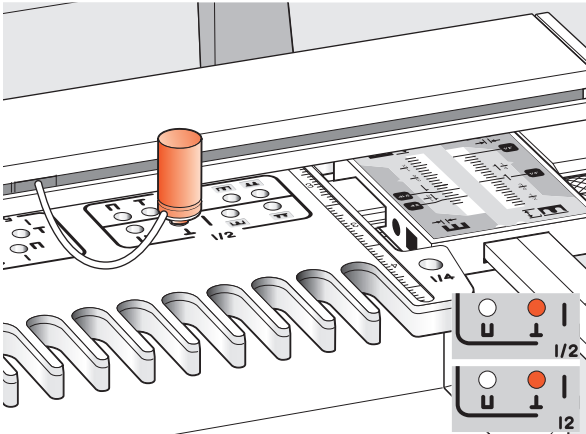
3-5
...the mating rear side stop, depending on which procedure is to be used.



3-6
Mating joints routed under the same comb have to be offset to achieve correct joint alignment. On Leigh templates the offset is achieved by moving the template left or right by half the pitch of the comb. This movement is controlled by the template pin, at the other end of the template ①. *Note that the template is close to the scale ②.*

**3-7**

In this illustration, the template is moved to the right by half the comb pitch and positioned by the template pin to rout the mating half of the joint in 3-6 above. *Note the increased gap between the scale and template ②.*

**3-8**

The template control pin engages the template to the template bar using precisely positioned holes. The active template pin holes are always at the opposite end of the template from the active comb, out of the way of the router. Most illustrations will have an inset ① showing the correct template pin hole position for the procedure. ■