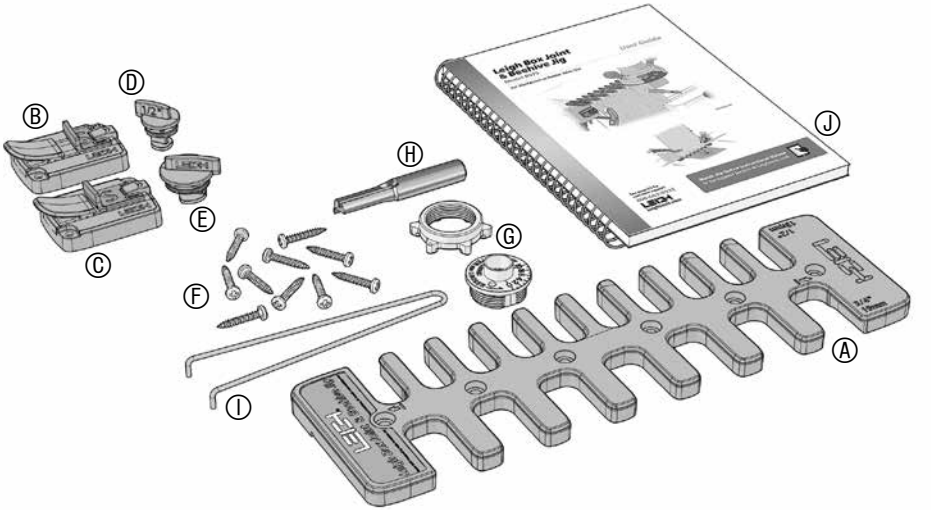
B975 User Guide

CHAPTER 1
Introduction



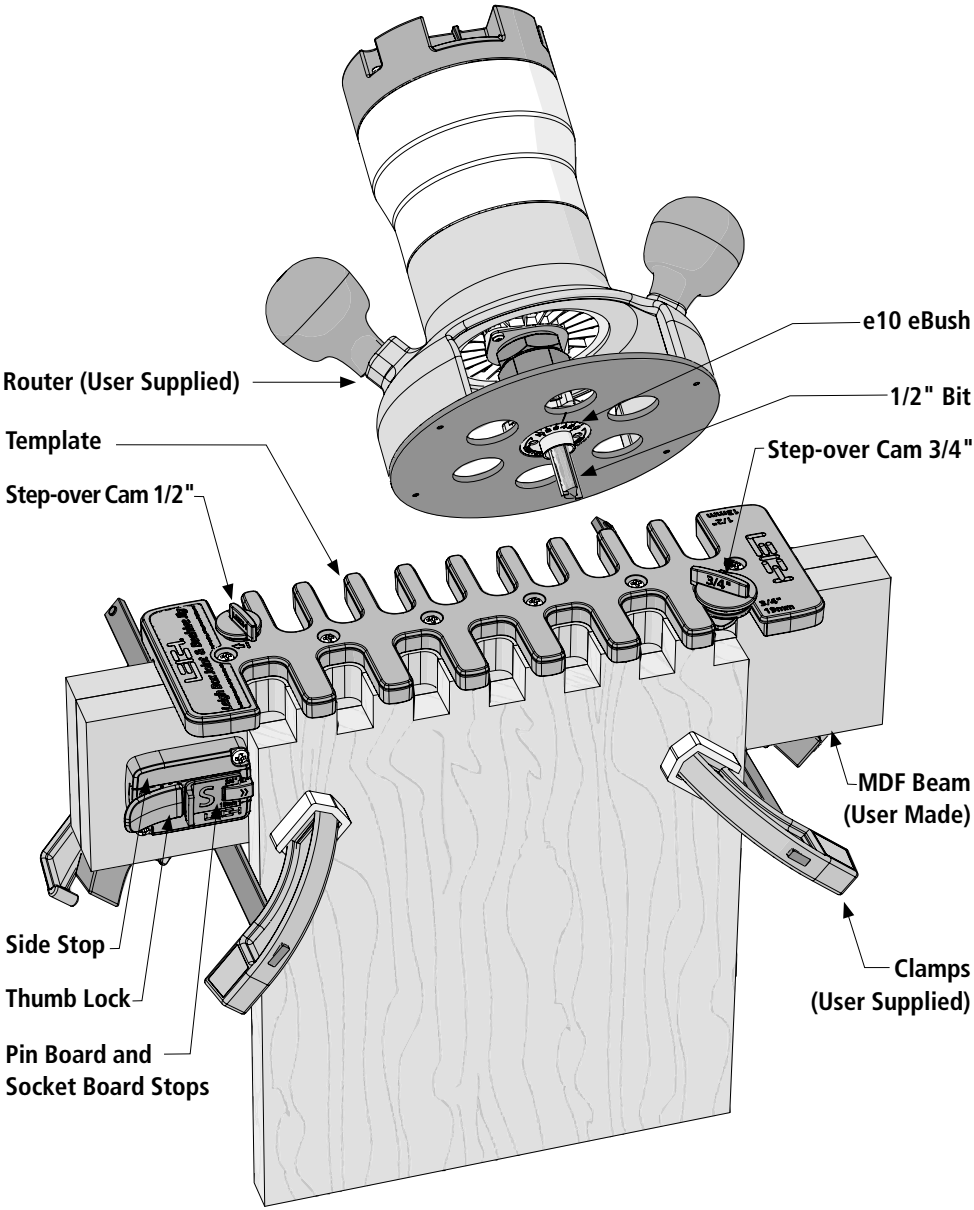
What's Included

	PART DESCRIPTION	PART NO.	QUANTITY
	Ⓐ Jig Template with Decal	313503	1
Bag 1	Ⓑ Side Stop Assembly, 1/2"	313530	1
	Ⓒ Side Stop Assembly, 3/4"	313535	1
	Ⓓ Step-over Cam with O-ring, 1/2"	313550	1
	Ⓔ Step-over Cam with O-ring, 3/4"	313555	1
Bag 2	Ⓕ Pan Head Wood Screws, No.8 x 1"	313585	10
	Ⓖ Guide Bushing, e10* eBush	e10	1
	Ⓗ Straight Bit, 1/2"	160IND	1
	Ⓘ Pin Wrench	730V	1
Bag 3	Ⓙ Fully Illustrated User Guide	313565	1

If any parts are missing from your jig, please notify your supplier or Leigh immediately. See Chapter 9, Customer Support.

*Leigh e10 Elliptical Guide Bushing: U.S. Patent no. 8,256,475 UK Patent no. GB2443974 Canada Patent no. 2,611,232

Leigh Box Joint & Beehive Jig



Units of Measure

IMPORTANT! INCHES AND MILLIMETERS

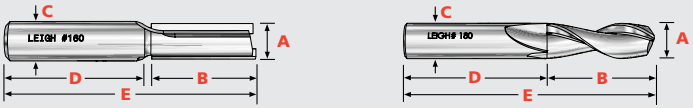
Text and illustrations in this English language user guide indicate dimensions in both inches and millimeters, where applicable, with “inches” first, followed by “millimeters” in square brackets, i.e. 1/2" x 2"[12.7mm x 51mm].

Don’t be concerned that the inch/millimeter equivalents are not mathematically “correct”.

Bit Specifications

There is only one bit size used with the Box Joint & Beehive Jig. Your new jig is shipped with a 1/2", 2 flute, carbide tipped straight bit. You may also use a 1/2" spiral up cut bit in high speed steel or solid carbide.

Bit Specifications



Leigh Bits	A Bit Diameter	B Max. Cutting Depth	C Shank Diameter	D Shank Length	E Overall Length	Use with Collet/ Collet reducer	Use with eBush
 **160IND*** Carbide tipped	1/2"	1-1/4"	1/2"	1-3/4"	3-1/8"	1/2" Collet	e10
 **180**** High Speed Steel	1/2"	1-1/2"	1/2"	2"	3-1/2"	1/2" Collet	e10
 **180C**** Solid Carbide	1/2"	1-5/8"	1/2"	1-7/8"	3-1/2"	1/2" Collet	e10

*** 160IND Bit is included with the B975**

**** Optional spiral upcut bits rout cleaner and faster, leaving a smoother finish**

Symbols for Board Position

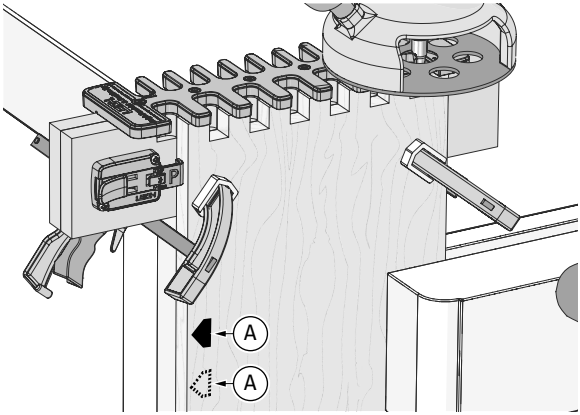
The following symbols are used throughout this user guide. They indicate which edge of the board goes against the side stop.

This board edge against the side stop.

This board edge against the side stop (on other side of the board hidden from view).

Clamping

Note: Before mounting and routing the boards, you should mark them with the appropriate symbols. With box joints, the same board edge Ⓐ always goes against the side stop. Boards are clamped against the beam both face in and face out for alternate end cuts.



Box Assembly

Assemble the box, keeping the marked edges of the boards together as shown.