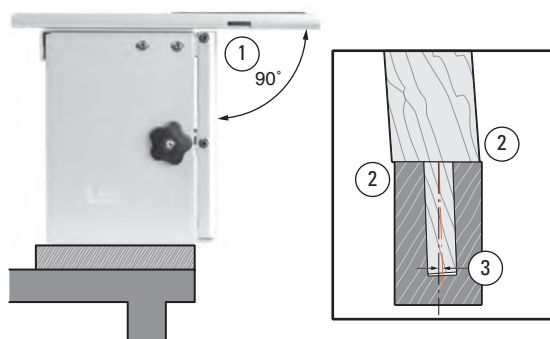
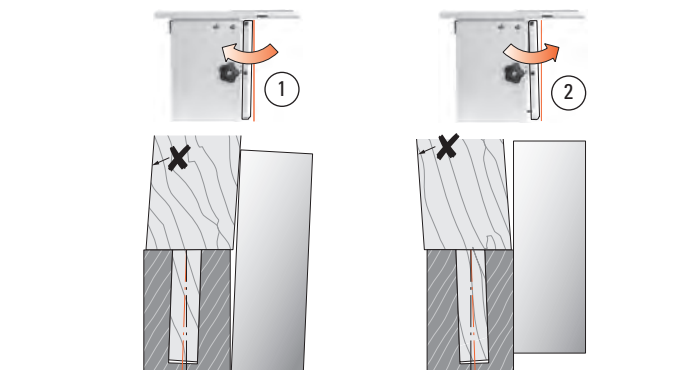


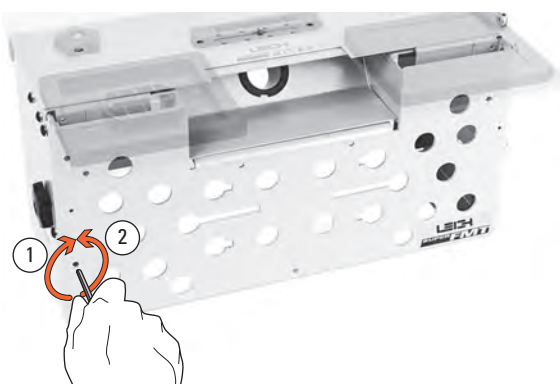
Jig Adjustments



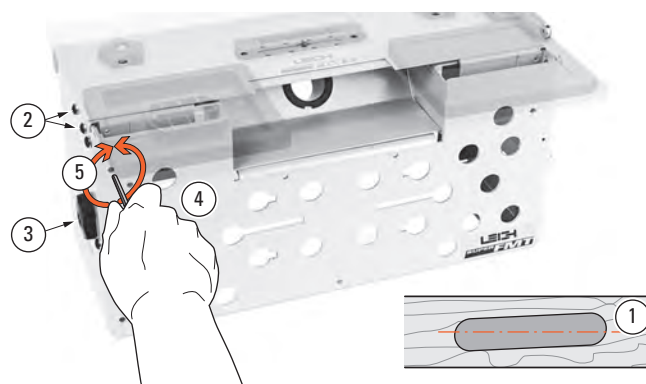
A2-1 Clamp Plate The clamp plate is factory set square to the table ①. However, this does not guarantee perfectly in-line joints. If your router shaft and bit are not perpendicular to the router sub-base and the Leigh sub-base, then the bit will not be square to the jig table (nor parallel to the clamp plate). This will cause a tiny “step” in the joint alignment ②. This is because the tenon center mark is now offset from the mortise center mark in the assembled joint ③. For clarity, the angle and step in this example is highly exaggerated.



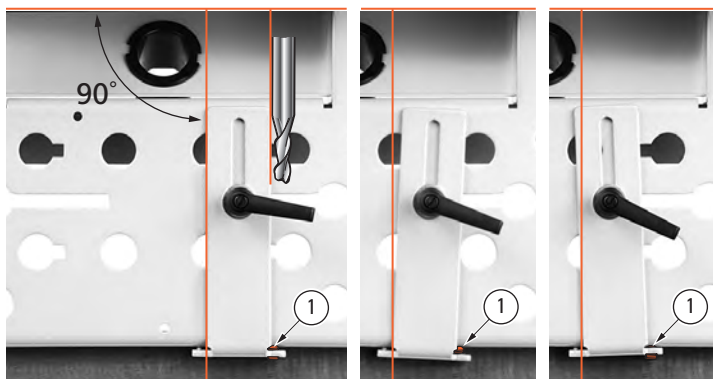
A2-2 Check your test joints for alignment with a straightedge. The cross represents the inside face toward the clamp face. The left example shows the clamp plate should be adjusted in toward the jig body ①. The right example shows the clamp plate should be adjusted away from the jig body ②. Test and adjust the clamp plate angle (see below) until the workpieces are in the same plane, with no joint misalignment.



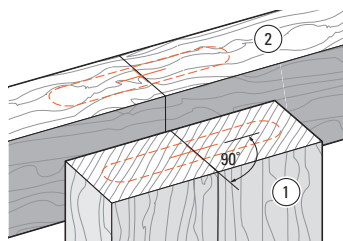
A2-3 The adjusting screw for setting the clamp plate is in the lower left front of the jig base. Loosen the quadrant knobs. Use the hex screwdriver to turn the screw clockwise to move the plate in ①. Turn the screw counterclockwise to move the plate out ②. The screw is treated with Loctite™ to prevent accidental rotation and will require firm pressure to adjust.



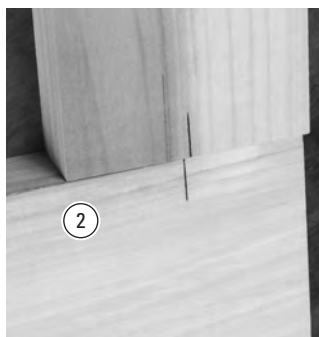
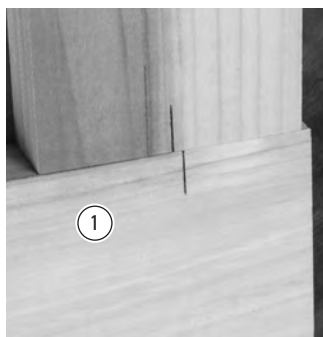
A2-4 Joint Alignment The clamp plate is factory set parallel to the guide track centerline and should not need attention. If the mortise or tenon is angled ① an adjustment may be required. Here's how: Slightly loosen the two screws ② holding the left end quadrant using the hex driver. Also loosen the LH Quadrant Knob ③. While pushing against the left hand end of the clamp plate ④ turn the screw in or out ⑤ to adjust the angle of the clamp plate relative to the guide track centerline. Firmly tighten the screws and then tighten the quadrant knob. After tightening the two screws, turn the adjusting screw in towards the jig body at least two full turns. Rout test joints to check the joint alignment.



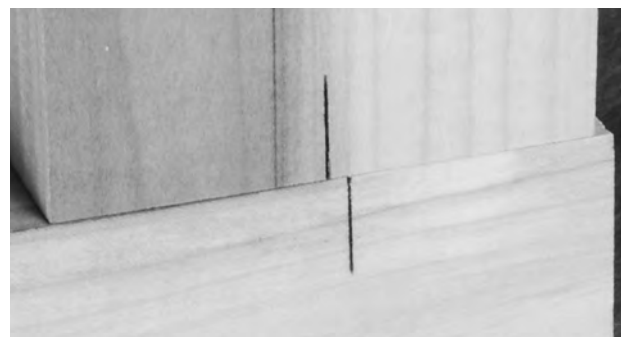
A2-5 Sidestop Squareness The travel of the router bit must be perfectly parallel to the sidestop fence. The fence is factory set square to the bottom of the jig table, however, tolerances in plunge routers may necessitate a small sidestop adjustment. If adjustment is required, the set screw on the bottom right side of the sidestop fence ① is turned in or out to change the angle of the fence.



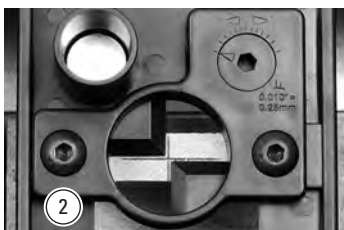
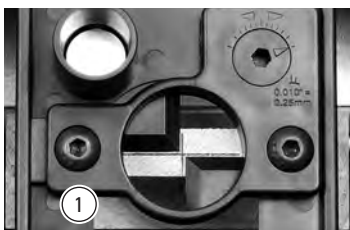
A2-6 Sight Adjustment Procedure Mark layout lines on the tenon piece ① and the mortise piece ②. Carefully sight the tenon piece in the jig ③. Be sure the layout marks are not touching either side of the sight. Rout the mortise and tenon, assemble the joint and check the layout marks.



A2-7 If your joints are misaligned like this ① or this ② (exaggerated) first **double check** that the router collet is perfectly centered on the sub-base as in figures 2-11 to 2-31. When the router is perfectly centered, proceed to A2-8.



A2-8 In this example, the mortise board is clamped on the left side of the jig and the tenon piece is offset to the left. The sight needs to be adjusted by *half* the amount of the offset **because changes to the site position affect the mortise and tenon.**



A2-9 Here's How *Note: Each division on the dial equals an adjustment of 0.010".* If the tenon piece is off **left of center** (A2-7 ①), loosen the sight locking screws and using the hex driver in the sight adjusting dial, move the sight **left, by half of the joint offset** ①. If the tenon piece is off **right of center** (A2-7 ②), using the hex driver in the sight adjusting dial, move the sight **right by half of the joint offset** ②. ■