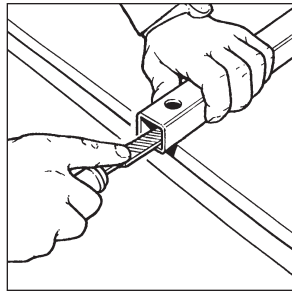
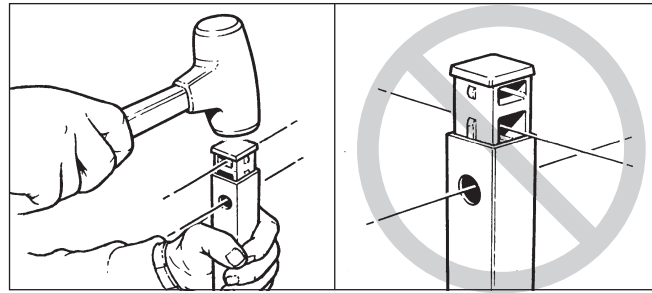


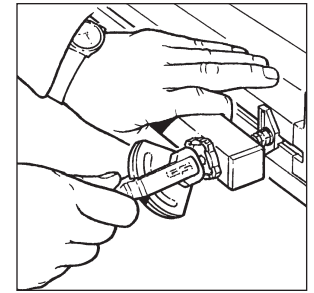
1 Take the clamp knobs and tubes off the jig. Put the Leigh finger adjuster screwdriver through each tube's large bolt hole and into the end plug. Strike down sharply against a solid surface to remove the old plug.



2 File any burrs off the inside of the round bolt holes in the clamp tubes.



3 Insert the compression plugs into the ends of the clamp tubes, making sure the openings in the plugs line up with the bolt holes. Mallet flush into the tube.



4 Remount the clamp tubes on the springs, then place a step washer (flat side against the clamp tube) on each clamp bolt. Finally, screw a clamp lever assembly onto each clamp bolt, ensuring the cam lobes are between the step washer side walls.

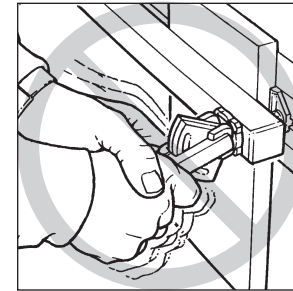
I N S T A L L A T I O N

How to Install and Use your Leigh Cam-Action Speed Clamps

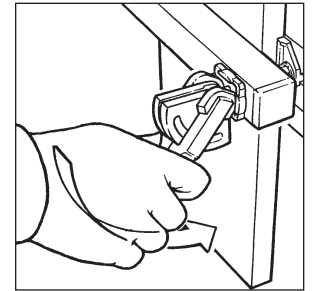
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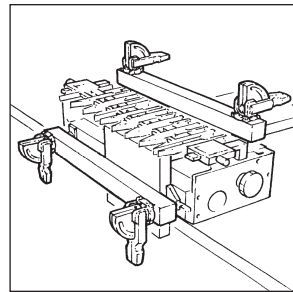
1 Do not force the Leigh Cam-Action Speed-Clamp. A smooth, firm action is all that's required to engage the clamp.



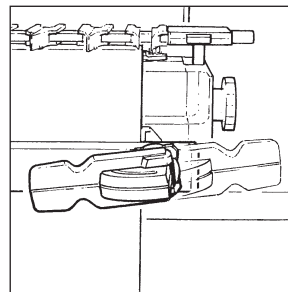
2 If you can't push the lever easily by pressing on the end of it with your thumb, reduce the tension. You'll get the feel of it with a little trial and error.



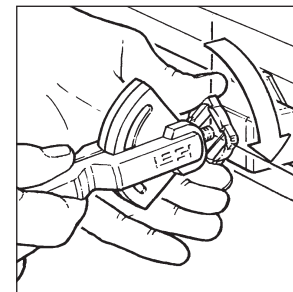
3 Do not use the lever as a torque arm. Adjust the clamp tension only with the clamp disengaged.



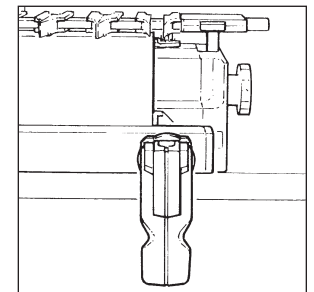
4 On the Leigh Jig, the front clamp levers should point down and the rear clamp levers should point to the rear.



5 If at the optimum clamping pressure the lever is incorrectly positioned...



6 ...release the clamp, remove the workpiece and turn the step washer a quarter turn.



7 Then readjust the clamp pressure until the clamp lever is in its correct position.