

BRUSSO®

Incorporated

PRECISION HARDWARE

RECESSED HANDLE INSTALLATION INSTRUCTIONS

1. Start by making a jig body by cutting a piece of good grade 1/2" plywood 3" taller and 3" wider than the end surface of the box where the handle will be installed. Cut four strips of 1/2" plywood exactly 1 1/2" wide. Cut two of them to the same length as the length of the jig body. Cut the other two slightly shorter than the height of the box.
2. Glue and nail one of the long strips to one of the long edges of the jig body, making sure that the top edge of the jig body and the top edge of the strip end up exactly flush at the top across their full length. This top edge will now become the reference point for all further measurements. Glue and nail one of the short strips along one of the short edges of the jig body, making sure that its edge is flush with the edge of the jig body. Now lay the end of the box and lid onto this jig body and push it into the corner created by the two strips. Glue and nail the other two strips onto the jig body and against the box. Remove the box from the jig body. This forms the under side of the basic jig body.
3. Using a router and fence or table saw, cut a slot 3/16" deep across the length of the plywood's top surface, with the top of the slot a measured distance from the top edge of the plywood. This measured distance is calculated by taking the height of the box lid and adding 1-3/8" to it. The slot width is not important. The top edge of this slot will be used for the top edge of the template to bear against, which will keep the handle parallel to the top of the box.
4. Center the brass template on the plywood with its top edge against the top edge of the slot. Draw around the two sides and the bottom of the template. Use a router set at 1/8" depth to route out the inside of the drawn square and screw the brass template into the routed pocket.
5. Draw lines on the plywood around the inside edge of the opening in the brass template and then remove the brass template. Now, using a 3/8 drill, drill out the four corners of the drawn square. With a jig saw or keyhole saw, cut around the outside of the drawn lines to cut out the newly drawn square. This allows for clearance of the router's 3/4" O.D. guide bushing that will be used on the router to cut out the handle pockets in the boxes. Reinstall the brass template in the plywood fixture. You now have a jig made up so that a novice woodworker could install handles into hundred of boxes and have them constantly turn out great.
6. Now stand the box on its end surface so that the surface, where the handle will be set, is up. For a steadier job clamp the box in this position and also clamp the lid and box together at the same time. Lay the plywood jig on the end surface of the box with the brass template up and the top of the plywood jig to the top of the box. Clamp the jig to the box.
7. Now you can route out the handle pockets. We suggest using a laminate trimmer because it is lighter than a router and therefore, more accurate. This installation is set up to use a 3/4" O.D. guide bushing on the trimmer or router and a 1/4" carbide cutter. Adjust the depth of the 1/4" cutter so that it extends 1/4" below the bottom surface of the jig. For a more accurate handle pocket with less tear out, operate the router or trimmer in a counter-clockwise direction to route out the handle pockets. Because the cutter is almost never centered in a router base, always keep the trimmer or router oriented the same way (front of router toward bottom of the box) while cutting out the handle pockets.

JB-766 Recessed Handle Dimensions:
3/4" x 2- 3/4" and 3/8" thickness