

# BRUSSO®

*Incorporated*

## PRECISION HARDWARE

### BACK MOUNT STOP HINGE INSTALLATION INSTRUCTIONS

These instructions are to be used when working with the TJ-804 installation template. The TJ-804 Jig will fit the JB-804 . You can use one jig to install both hinges by cutting out for one hinge then moving the jig to cut out for the other. However, it would be a great time saver and far more accurate to use 2 jigs, one for each hinge. You can also use a third jig to install a third or center hinge.

The template is designed to be used with a router, a 3/4" OD guide bushing and a 1/4" carbide router bit. Since many guide bushings are cast, they are not always accurate. You may have to tailor yours to make it precise. First of all, you must shorten it to protrude from the bottom of the router base by slightly less than 1/8." Second, if it's cutting the pockets too small, sand the circumference of the guide bushing down a bit until the hinge fits the pocket. If it's cutting too large, place a piece of scotch tape around the circumference of the guide bushing.

Clamp the jig into place so that the line up dogs are between the box and lid. Line up the sides of the box, lid and the jig edge with an accurate straight-edge. Use the straight-edge across the top of the box and lid to check them also. Now route in the hinge pockets, being careful to keep the router oriented in the same direction throughout all cuts, otherwise you lose accuracy. Also, operate the router in a counter-clockwise direction to minimize tear-out. The mortises should be 1/8" deep.

One last tip. Be sure to clean the chips out of the hinge mortise before making the final finish pass. These chips may hold the guide bushing away from the inside edges of the jig cutout.

One very last tip. After a test cut in some scrap to check mortise depth, unplug the router, turn it on it's end with the base up, adjust the base to exactly center the cutting bit in the guide bushing. If the bit is not centered in the bushing, the lid will not line up with the box.

JB-804 Dimensions:

1 1/4" x 1 1/32" Wide & Radius Corners