

BRUSSO®

American Made

PRECISION HARDWARE

INSTALLATION INSTRUCTIONS

ROUTING TEMPLATE T-804 FOR SURFACE MOUNT STOP HINGE JB-804

These instructions are to be used when working with the JB-804 surface mount stop hinge and JB-804 routing template. You can use one template to install both hinges by cutting out for one hinge and then moving the template to cut out for the other. However, it would be a great time saver and far more accurate to use 2 templates, one for each hinge. You can also use a third template 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, you must shorten it to protrude from the bottom of the router base by slightly less than 1/8". 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

After making a test cut in a piece of scrap to check the mortise depth, unplug the router, turn it on it's end with the base up, and adjust the base to precisely 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.

Clamp the template into place so that the line-up dogs are between the box and lid. Line up the sides of the box, lid and the template edge with an accurate straight-edge. Use the straight-edge across the top of the box and lid to check them. Route in the hinge pockets, being careful to keep the router oriented in the same direction throughout the cuts, otherwise accuracy is lost. Also, operate the router in a counter-clockwise direction to minimize tear-out. The mortises should be 1/8" deep. With the hinge thickness being .188, or about 3/16", the hinges should sit 1/16" proud of the box.

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

Should you require further assistance please contact customer service and we will do our best to help.