

BRUSSO®

American Made

PRECISION HARDWARE

INSTALLATION INSTRUCTIONS

ROUTING TEMPLATE TJ-SR680 FOR SIDE RAIL HINGE SR-680

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.



TJ-SR680 is designed to be used with a plunge router, a 3/4" OD guide bushing, and a 1/2" carbide router bit.

Many guide bushings are cast and they're not always accurate so you may have to tailor it to make it precise. First, you must shorten the guide bushing to protrude from the bottom of the router base by slightly less than 1/8". If it's cutting the pocket too small, sand the circumference of the guide bushing down slightly until the hinge fits the pocket. If it's cutting the pocket too large, place a piece of scotch tape around the circumference of the guide bushing.

Set up a small platform under the lid to hold it face up and in the same plane as the top of the box. Clamp the template in place so that the line-up legs are secure between the box and lid. Line up the sides of the box and lid with an accurate straight-edge. Use the straight-edge across the top of the box and lid to check them as well.

After making a test cut in some scrap pieces 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.

Elevate the router and locate the guide bushing into the template slot. Plunge to the preset depth and route in the hinge pockets. The depth of the hinge pocket determines the amount of gap between the lid and box, the deeper the pocket, the smaller the gap. If the pocket is too deep the lid will not close. Slight depth corrections can be made with shim stock.

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 edge of the template cutout.

We recommend using a plunge router to avoid having the cutter wander when you enter the work. When you engage the guide busing and the template first then plunge to depth this will not happen.

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