

BRUSSO®

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PRECISION HARDWARE

BOX AND CABINET HINGE INSTALLATION INSTRUCTIONS

These instructions are to be used when working with the TJ-101, TJ-102, and TJ-103 installation templates. For instance, the TJ-103 Jig will fit the JB-103, CB-303, and CB-303-B, and so on. You can use one jig to install both hinges by cutting out for one hinge and 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.

These jigs are 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 pocket too small, sand the circumference of the guide bushing down a bit 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 jig in place so that the line up dogs are between the box and lid. Line up the sides of the box, lid and 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 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.

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 its 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 door will not line up with the case.

JB-101 3/4" Pin Spans 5/16" Box Material, CB-301 & 301B 3/4" Barrel 13/16" Open

JB-102 1 1/4" Pin Spans 5/16" Box Material, CB-302 & 302B 1 1/4" Barrel 13/16" Open

JB103 1 1/4" Pin Spans 7/16" Box Material, CB-303 & 303B 1 1/4" Barrel 1 1/16" Open