

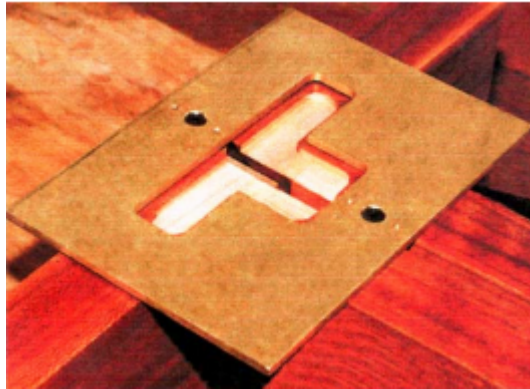
# BRUSSO®

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HARDWARE FOR CRAFTSMEN

## INSTALLATION INSTRUCTIONS ROUTING TEMPLATE TJ-680 FOR QUADRANT HINGE HD-680

These instructions are to be used when working with the HD-680 Quadrant Hinge and TJ-680 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.



TJ-680 is designed to be used with a laminate trimmer or router, a 5/8" OD guide bushing, and a 7/16" 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 dogs are between the box and lid, and the long cut in the template is centered on the box edge. 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.

Route in the hinge pockets, being careful to keep the router oriented in the same direction throughout all cuts, otherwise accuracy is lost. It's also better to 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.

The cutout in the lid and box for the quadrant link to drop into can also be cut with this template. Use a plunge router, a 1/4" cutter, and the same 5/8" OD guide bushing. Make the cut 3/4" long and 1-1/4" deep in both the lid and box. This cut should begin about 7/16" from the end of the hinge mortise. Hold the guide bushing against the long edge of the template cutout when making this cut.

**Note: When installing the link, the end with a pin goes into the top (lid) side.**

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.

Most people drill the waste wood away with a 3/16" drill. First, place the hinge leaf into place in the hinge cutout and trace around the inside of the quadrant slot in the hinge leaf with a pencil. Drill the waste wood away along this pencil marking, then use the router with the 3/16" cutter.

If the fit between your link pocket and stop pin is too tight you have two options. Either file down the pin on either side by 1/32 or chisel an extra 1/32 on either side of your link pocket.