

# BRUSSO®

*Incorporated*

## PRECISION HARDWARE

### QUADRANT HINGE INSTALLATION INSTRUCTIONS

The TJ-680 Jig will fit the HD-680 Quadrant Hinge. It is designed to be used with a router or laminate trimmer, a 3/4" OD guide bushing and a 1/2" 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 plain as the top of the box. Clamp the jig in place so that the line up dogs are between the box and lid and the long cut in the jig 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 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.

The cutout in the lid and box for the quadrant link to drop into can also be cut with this jig. Use a plunge router, a 1/4" cutter with the same 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. Be sure to hold the guide bushing against the long edge of the template cutout when making this cut.

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 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.

HD-680 Dimensions:

1 1/2' Barrel x 2" Leg 1/8" Thick Leaf