

# 8525 Hinge Jig

*Please Read Carefully!*

<b>Parts List:</b>		
<b>Part</b>	<b>Description</b>	<b>Quantity</b>
8525	2-1/2" Hinge Jig .....	1
STP001	#8 x 3/4" Screws .....	2
WB001	3/16" Washers .....	2
BUSH002	1/4" Spacers .....	2
5503	1/2" Thumb Screws .....	2

**ASSEMBLY**

Identify and verify that you have all the parts listed. Read the instructions at least once before beginning.

Cut a wood fence approximately 3/4" thick, 1-1/4" wide and approximately 10" long to mount the Hinge Jig to. You can make the wood fence longer if you want to cut two or more hinge mortises at a time.

Drill two 1/8" pilot holes in the edge of the wood fence 4-5/8" on center. Mount the Hinge Jig to the wood fence using the 3/16" Washers (**WB001**) and 3/4" Screws (**STP001**). See fig. 1.

Place the 1/4" Spacers (**BUSH002**) on the 1/2" Thumb Screws (**5503**) and screw them in to the two holes of the Hinge Jig shown. The remaining two holes in the Hinge Jig are for storing the thumb screws & spacers when not needed. The hinge side of the spacers indicate where the rear cut line of the bit is. See fig. 2.

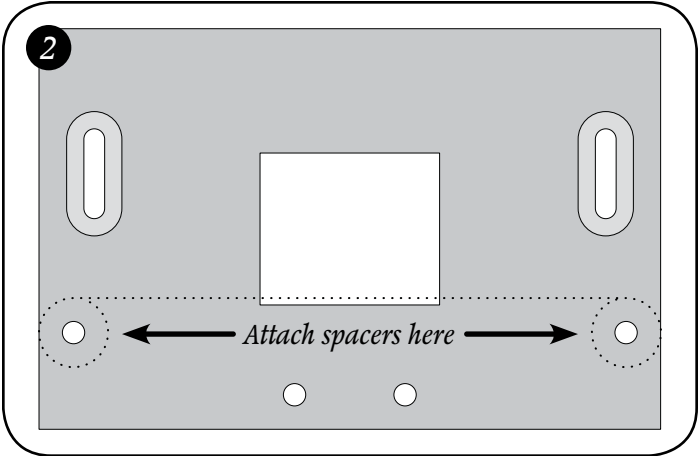
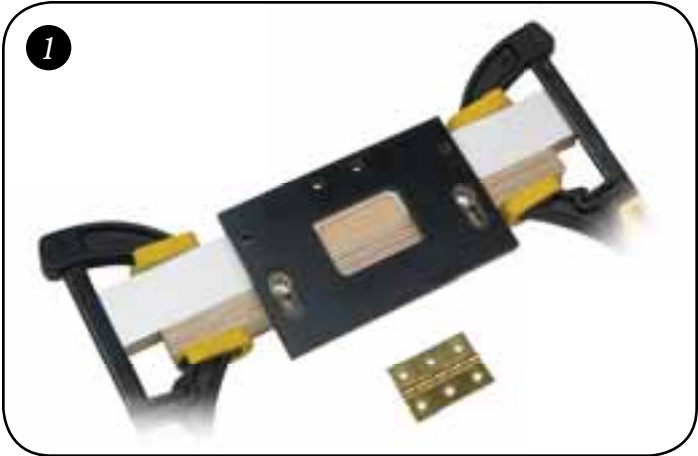
By adjusting the wood fence forward or back in relation to the spacers (the cut line of the bit), you control the hinge position on the work. See fig. 1.

Cut a 1/4" thick x 6" long spacer to the width required to position the hinge in the desired location. Place it between the two 1/4" spacers and the wood fence and tighten the wood fence in position.

**USING THE JIG**

Mark the hinge locations on the part. The opening in the Hinge Jig is 1/8" wider (1/16" on each side) than the hinge mortise it cuts. Position the Hinge Jig so it's 1/16" from the hinge location marks and clamp it to the part using the wood fence and two clamps. See fig. 1.

Install our **8500 Hinge Bit** (1/2" diameter with a 5/8" bearing), or a 1/2" bit (**13416**) and 5/8" bushing (**5030K**), in your router. If using the **8500 Hinge Bit**, make sure the bearing rides firmly on the edge of the jig before attempting any cuts. Since the cutting depth for hinges is shallow (usually 1/8" or less), any router will work. Set the cutting depth of the bit, taking into account the thickness of the jig.



Plunge or tilt the router bit into the approximate center of the jig opening, moving in a small clockwise circle as you do so to cut a relief opening. With the router base riding firmly on the jig, move towards an edge of the jig opening. Moving clockwise, follow the jig until the outline has been cut. Make clean up passes to remove any remaining material.

After making the first cut, the wood fence will have a cut out area that corresponds to the hinge size. You can use this to align the jig to the hinge location marks for the remaining cuts.

**ACCESSORIES**

Self-Centering drill bits (**PN 6505 - 5/64"**, **PN 6507 - 7/64"** or **PN 6509 - 9/64"**) are available to insure perfectly centered pilot holes for your hinges. A Corner Chisel (**PN 8508**) is available to square the radiused corners left by the 1/2" router bit.