

# B R U S S O ®

*Incorporated*

## P R E C I S I O N H A R D W A R E

### S P R I N G - L O A D E D L A T C H I N S T A L L A T I O N I N S T R U C T I O N S

1. Start by making a jig by cutting a piece of good grade 1/2" plywood 3' taller and 3" wider than the front surface of the box where the latch will be installed. Cut 4 strips of 1/2" plywood exactly 1 1/2" wide. Cut two of them to the same length as the length of the jig body. Cut the other two slightly shorter than the height of the box.
2. Glue and nail one of the long strips to one of the long edges of the jig body, making sure that the top edge of the jig body and the top edge of the strip end up exactly flush at the top across their full length. This top edge will now become the reference point for all further measurements. Glue and nail one of the short strips along one of the short edges of the jig body, making sure that it's edge is flush with the edge of the jig body. Now lay the front of the box and lid onto this jig body and push it into the corner created by the two strips. Glue and nail the other two strips onto the jig body and against the box. Remove the box from the jig body. This forms the under side of the basic jig body.
3. Using a router and fence or table saw, cut a slot 3/16" deep across the length of the plywood's top surface, with the top of the slot a measured distance from the edge of the plywood. This measured distance is calculated by taking the height of the box and subtracting 3/8" from it. The slot width is not important. The top edge of this slot will be used for the top edge of the template to bear against, which will keep the latch parallel to the top of the box.
4. Center the brass template on the plywood with its top edge against the top edge of the slot. Draw around the two sides and the bottom of the template. Use a router set at 1/8" depth to route out the inside of the drawn square and screw the brass template into the routed pocket.
5. Draw lines on the plywood around the inside edge of the opening in the brass template and then remove the brass template. Now, using a 3/8 drill, drill out the four corners of the drawn square. With a jigsaw or keyhole saw, cut around the outside of the drawn lines to cut out the newly drawn square. This allows for a clearance of the router's 3/4" O.D. guide bushing that will be used on the router to cut out the latch pockets in the boxes. Reinstall the brass template in the plywood fixture. You now have a Jig made up so that a novice woodworker could install latches into hundred of boxes and have them constantly turn out great.
6. Now stand the box on its back surface so that the surface, where the latch will be set, is up. For a steadier job clamp the box in the position and also clamp the lid and box together at the same time. Lay the plywood jig on the front surface of the box with the brass template up and the top of the box. Clamp the jig to the box.
7. Now you can route out the latch pockets. We suggest using a laminate trimmer because it is lighter than a router and therefore, more accurate. The "System" is set up to use a 3/4" O.D. guide bushing in the trimmer or router and a 1/4" carbide cutter. Adjust the depth of the 1/4" cutter so that it extends 1/4" below the bottom surface of the jig. For a more accurate latch pocket with less tear out, operate the router or trimmer in a counter-clockwise direction to route out the latch pockets. Because the cutter is almost never centered in a router base, always keep the trimmer or router oriented the same way (front of router toward bottom of the box) while cutting out the latch pockets. This jig fixture should make a happy experience of installing the Pushbutton Latch.

J B - 828 Dimensions:  
2" High x 3/4" Wide