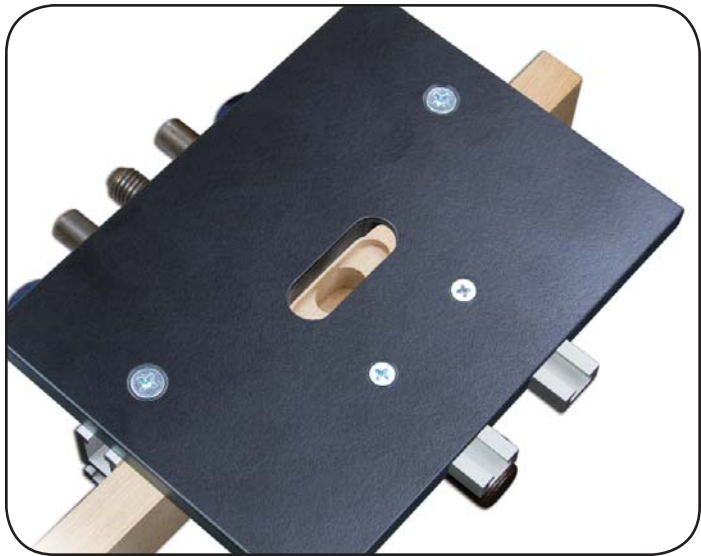


WOODHAVEN

8664 SOSS 204 Hinge Jig Owners Manual *Please Read Carefully!*



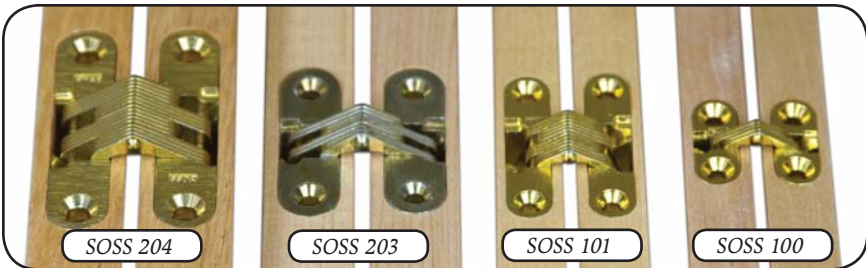
Parts List 8664:
Please identify and verify that you have all of the parts listed below prior to assembly.

Part	Description	Quantity
8664B	Hinge Jig for SOSS 204	1
4008	8" Double Track	1
MF010	1/4-20 x 3/4" flat head screw	2
5760B	1/4-20 oval nut	2
8660T	2-7/8" One Track	2
MF001	10-24 x 5/16" flat head screw	2
5750B	10-24 oval nut	2

BEFORE BEGINNING

Identify and verify that you have all the parts listed. Read thru the instructions at least once, familiarizing yourself with the parts and their use before proceeding. You'll need a #2 & #3 Phillips screwdriver for assembly.

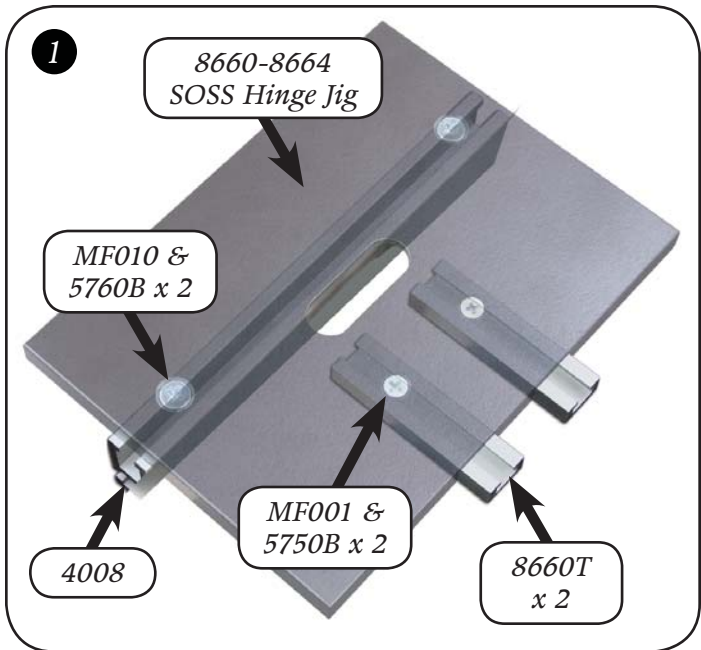
The **8664 SOSS Hinge Jig** is designed to work with a 3/4" bushing & locknut (*our PN 5032K*) and a 1/2" upcut spiral bit (*our PN 15407*). If you have your own 3/4" bushing, make sure the nose isn't over 3/8" long. You'll need a plunge router to cut the hinge mortises. The quality of the plunge mechanism can effect the size of the mortise, resulting in a poor fit if the plunge mechanism has excessive slop. Note: The pictures in the instructions are of the **8663 SOSS 203 Hinge Jig**, but all of the **SOSS Hinge Jigs** assemble, and function, the same way.



ASSEMBLY

Insert the two 1/4-20 x 3/4" flat head screws (**MF010**) thru the larger countersunk holes in the SOSS Hinge Jig (**8664B**). Start a 1/4-20 oval nut (**5760B - flat side first**) on the end of each screw. Slide the 8" Double Track (**4008**) on to the oval nuts and in the groove in the underside of the Hinge Jig until centered end-to-end, then tighten the screws. *See fig. 1.*

Insert the two 10-24 x 5/16" flat head screws (**MF001**) thru the remaining two countersunk holes in the Hinge Jig and start a 10-24 oval nut (**5750B - raised side first**) on the end of each screw. Slide a 2-7/8" One Track (**8660T**) on to each oval nut and in to the grooves in the underside of the Hinge Jig until covering the oval nut, then tighten each screw. *See fig. 1*



Turn Page Over

USAGE

The SOSS Hinge Jig has the correct setback built-in to it for your SOSS hinge. Always index the face of the work against the Double Track and an edge against the underside of the Hinge Jig. The center of the Hinge Jig is 3-7/8" from each end. Use this measurement to index your work along the Double Track and locate where the hinge mortise will be cut. Clamp the work/Double Track together in a vise, *see fig. 2*, or clamp the work in a vise and use bar clamps to clamp the Double Track/SOSS Hinge Jig to the work.

The debris generated during cutting will interfere with the bushing travel in the Hinge Jig. Make as many passes as needed, cleaning out the debris between passes, until the cut is complete.

After installing the bushing and bit in your plunge router, set the bushing in the opening in the Hinge Jig. Plunge the bit down until it just touches the edge of the work and lock it in place.

CUT THE LONG/SHALLOW MORTISE FIRST

Place the mounting flange of the SOSS hinge between the turret and the stop rod to set the plunge depth for the long/shallow mortise. *See fig. 3A.*

Slide the One Tracks out until they are no longer visible in the Hinge Jig opening, tighten the screws and cut the long/shallow mortise. *See fig. 4.*

CUT THE SHORT/DEEP MORTISE LAST

Place the main body of the SOSS hinge (or cut a wood block 1/32" taller) between the turret and the stop rod. Adjust the stop rod so it's approximately 1/32" above the main body to set the plunge depth for the short/deep mortise. *See fig. 3B.*

Loosen the two One Tracks and push them into the Hinge Jig opening until they bottom out and are visible. Tighten the screws and cut the short/deep mortise in 1/4" deep incremental passes until you reach the full depth of cut. *See fig. 5.*

ACCESSORIES

Optional **4512 Flip Stop** mounts on a **4016 16" Double Track** (minimum length recommended) for quicker part indexing and allows setting the stop up to 6" from the hinge mortise, with a spacer required for distances less than 4-1/4". We recommended two Flip Stops, one for each side of the jig. Optional longer **Double Tracks** available to mount multiple jigs & stops. Optional Self-Centering drill (**6507 or 6509**) centers itself in the hinge screw mounting hole for a perfectly centered pilot hole. *See fig. 6.*

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