Drawer Box

- Upcut Saw Instruction Procedure
- Lock Dowel Drawer Box Instruction Procedure
- Dovetail Jointer Instruction Procedure

Upcut Saw Instruction Procedure

Purpose

Using the Upcut saw will provide you with digital accuracy and a cleaner and smoother cut

Powering on Machine

Image 1.jpg

1. Turn on the control panel by pressing the red switch located on the right side of the blue electrical box behind the control panel

Image 2.jpg

2. Turn on the saw by pressing the black start button located on the blue electrical box located left of the control panel

Calibrating Machine

3. On the control panel Press ("Program List", "Space Calib",2) This will bring up the calibration screen

4. Enter 1, 0, "Space Calib", 1, /, 4, "Program List"

> ***Steps 3 and 4 only need to be done in the morning before the shift starts***

Running Machine

5. Using the decimal equivalents enter your length to be cut

> ***For example if your length is 12 1/2 inches you will enter 12.***

6. Press "Start"

Image 3.jpg

7. Measure the length of damage on the board to be cut

8. Press "+", enter the damaged length the press "=" then press the "Start" button

> ***For example our desired length is 12.5 inches and we have 4 inches of damage this step will make your cut length 16.5 inches***

Image 4.jpg

9. Run your board through the press, flat against the fence to the stopper

Image 5.jpg

10. Once the board is in place press the foot pedal located below the machine

11. When the board is cut press "-", re-enter the damaged length then "=" then the "Start" button

> ***This step will take off the 4 inches you added and put you back to your desired 12.5 inches***

Image 6.jpg

12. Rotate the board where the damaged length is out and then press the foot pedal to cut off the damaged length

> ***Note that steps 3, 4, and 7 are only needed when cutting a new board***

Powering off Machine

Image 7.jpg

13. Turn off the saw by pressing the red stop button on the blue electrical box located left of the control panel

Image 8.jpg

14. Turn off the control panel by pressing the red switch located on the right side of the blue electrical box behind the control panel

Lock Dowel Drawer Box Instruction Procedure

Purpose

Lock dowels are used to create a clean non fastener look for melamine boxes

Drawer Box Assembly

Image 1.jpg

1. Gather all your parts by reading the labels

> ***Labels will be coordinated with a number in the top right corner with Left, Right, Front, Back, and Bottom***

2. Inspect all your parts for imperfections before starting

> ***If imperfections are found, show them to your supervisor and they will direct you to the proper method to fix it or instruct you to have the part recut***

Image 2.jpg

3. Using the proper tool, clean the edges of each part of any glue or hang over

Image 3.jpg

4. Place lock dowels in the designated per drilled holes

Image 4.jpg

5. Using a soft mallet, lightly tap the lock dowel down till the bottom of the dowel is flush with part

Image 5.jpg

6. Place glue in the coordinating keyhole slots

Image 6.jpg

7. Insert the Lock Dowell into the coordinating keyhole slot to create the locking mechanism

Image 7.jpg

8. Push the part up to lock in place

Image 8.jpg

9. Place glue in the dado that the drawer box bottom will be placed

Image 9.jpg

10. With the glide holes up and facing toward the inside of the box, slide the bottom into the bottoms' dado

Image 10.jpg

11. Make sure the bottom is flush with the back

Image 11.jpg

12. Using a staple gun and the 1 1/4" staples secure the bottom to the back panel

13. Put fastcaps over drawer front screw holes to prevent cracking

Dovetail Jointer Instruction Procedure

Purpose

Dovetail joints make the drawer box stronger while still giving it a classier look

Powering Up Machine

Image 1.jpg

1. Turn the switch to the on position, located on the right side of the machine

Image 2.jpg

2. Press the white button on the left of the control panel

Image 3.jpg

3. Press the green button on the right of the control panel

Image 4.jpg

4. Press the open door icon located on the lower right side of the screen

Image 5.jpg

5. Press the Zero Research icon on the lower left side of the screen

Image 6.jpg

6. Press the white button on the left of the control panel

Image 7.jpg

7. When the reset is complete press the close icon on the screen

Image 8.jpg

8. Press "PROG" icon on the lower right of the screen

Image 9.jpg

9. Select the "Automatic Pitch" icon on the upper left of the screen

Milling Set Up

Image 10.jpg

10. Press the Folder icon on the lower left of the screen

Image 11.jpg

11. Select the file for the width of the board you will be milling

> ***For example, if the board width is 4 inch select the "4inch" file***

Milling Board

Image 12.jpg

12. Place your side board in first with your panel being upright with the dado facing out and away flush against the fence

Image 13.jpg

13. Push the clamp lever forward to secure the board in place

Image 14.jpg

14. Place your front or back board face up with the dado down and away flush against the side panel and flush against the fence

Image 15.jpg

15. Push the clamp lever forward to secure the board in place

Image 16.jpg

16. Once all boards are in place and secured press the white button on the left side of the control panel to start the milling process. Repeat these steps for the left side.

> ***Make sure to look up in the right side of the screen to make sure the correct file is selected for the board size that is going to be dovetailed***

Image 17.jpg

> ***17. Note, make sure that the "Broad Boards" icon is set to the side that the board will be milled. If boards are set on both sides made sure the "Broad Boards" icon says OFF***

Powering off Machine

Image 18.jpg

18. Simply turn the power switch in the off position, Located on the right side of the machine