

System 32 Drilling for DWD XP on Hinge Machines

For Front Fix Bracket, Rectangle type and STD Gallery Rail

NB: Nominal distance drilling for carcass Runners is 71mm

ie. 71 to first Runner (top row of holes) from bottom of base then DR Front + Gap + 71 to next etc.

1: 95mm Drawer Side with Single Gallery Rail (DUOWING), Back on top of Base Method

- For 1.5mm Reveal both sides of Drawer Fronts Set Machine Depth at 36mm
- Insert 1 x RH Black 10mm Drill Bit to Centre of Machine Drill Bit holders
- Base = Internal Carcass - 74mm x Runner length - 9mm
- Back = Internal Carcass - 74mm x 164mm O/A
- Set RH and LH Stops at 1 : 62mm (Yellow) , 2 : + 32mm(Orange) , 3 : + 96mm(Blue)
- For Round Gallery Rails Knock in 1 x 10mm Plastic Dowel
- For Rectangle Gallery rails Knock in 1 x 10mm Plastic Dowel to Pick up Top Hole and use 5/8 x 6 wood screw for Second Hole

Back Bracket installation

- Fit Bracket flush with top of Back

2: 95mm Drawer Side with Double Gallery Rail, Back on top of Base Method

- For 1.5mm Reveal both sides of Drawer Fronts Set Machine Depth at 36mm
- Insert 1 x RH Black 10mm Drill Bit to Centre of Machine Drill Bit holder
- Base = Internal Carcass - 74mm x runner length - 9mm
- Back = Internal Carcass - 74mm x 196 mm O/A
- Set RH and LH Stops at 1 : 62mm(Yellow) , 2 : + 32mm(Orange) , 3 : + 64mm(Blue) , 4 : + 64mm(Red)
- For Rectangle Gallery rails Knock in 1 x 10mm Plastic Dowel to Pick up Top Hole and use 5/8 x 6 wood screw for Second Hole

3: 127mm Drawer Side with 1 Gallery Rail, Back on top of Base Method

- For 1.5mm Reveal both sides of Drawer Fronts Set Machine Depth at 36mm
- Insert 1 x LH Black 10mm Drill Bit to Centre of Machine Drill Bit holders
- Base = Internal Carcass - 74mm x runner length - 9mm
- Back = Internal Carcass - 74mm x 196 mm O/A
- Set RH and LH Stops at 1 : 62mm(Yellow) , 2 : + 32mm(Orange) , 3 : + 96mm(Green)
- For Rectangle Gallery rails Knock in 1 x 10mm Plastic Dowel to Pick up Top Hole and use 5/8 x 6 wood screw for Second Hole

Back Bracket installation

- Fit Bracket flush with top of Back