

# Work instruction: Drawer assembly on jig

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## 1 PURPOSE & SCOPE

This work instruction describes the individual steps for assembling a drawer using the mounting jig. It applies to all staff members assembling drawers according to the specified system.

## 2 RESPONSIBILITIES

Implementation	DE-AE-G1
Quality assurance	DE-QS-B1
Revision	DE_SN

## 3 SAFETY INSTRUCTIONS

Ensure fingers do not come between workpieces or tools, avoid risk of crushing. In case of defects or uncertainties, consult immediately. Keep the workplace clean and free of obstructions.

## 4 REFERENCES AND RELEVANT DOCUMENTS

Assembly jig safety instructions, Cordless screwdriver safety instructions

## 5 MATERIALS AND EQUIPMENT

### Materials:

- Drawer sides
- Drawer bottom
- Back panel
- Back panel holders
- 3.5 x 17 mm countersunk screws

### Equipment:

- Assembly jig
- Cordless screwdriver with 3 mm drill bit
- Second cordless screwdriver
- Possibly screws

## 6 PROCEDURE DESCRIPTION

### 6.1 STEP 1: PREPARATION AND WORKPLACE CHECK

#### Materials and Tools

Workplace

Assembly jig

	<p><b>Procedure</b></p> <ul style="list-style-type: none"> <li>- Clear the work area and prepare all required parts and tools.</li> <li>- Check the assembly jig for functionality and cleanliness:</li> <li>- Ensure the jig is properly locked in place and that there are no foreign objects obstructing the working area.</li> </ul> <p><b>Notes</b></p> <ul style="list-style-type: none"> <li>- For ergonomic work, pay attention to an upright posture.</li> <li>- Immediately report any defects in the jig.</li> </ul>
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### 6.2 STEP 2: ADJUSTING THE ASSEMBLY RAILS AND STOPS

#### Materials and Tools

Assembly jig

	<p><b>Procedure</b></p> <ul style="list-style-type: none"> <li>- Adjust the rail length to the desired measurement (e.g., 500 mm) using the side scale.</li> <li>- Lock the lever with your right hand.</li> <li>- Set the stop for the bottom panel precisely.</li> </ul> <p><b>Notes</b></p> <ul style="list-style-type: none"> <li>- Do not place fingers between the rail and the stop (risk of pinching).</li> </ul>
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### 6.3 STEP 3: SELECTING AND ADJUSTING THE DRAWER SYSTEM

#### Materials and Tools

Assembly jig



#### Procedure

- Select the required drawer system (e.g., Legrabox, Tandembox, Merivobox) as specified.
- Check and adjust the settings on both sides as needed.
- Ensure the lock audibly engages.

#### Notes

- Only set the required system; ask if unsure.

## 6.4 STEP 4: ADJUSTING REAR PANEL HEIGHT AND POSITIONING

### Materials and Tools

Assembly jig



#### Procedure

- Adjust the rear panel height at the top and bottom using the scale to the specified value.
- Check the scale display and correct if there are deviations.
- Ensure the setting is stable before proceeding.

#### Notes

- Check the setting before further assembly.

## 6.5 STEP 5: ADJUSTING AND SETTING THE WIDTH

### Materials and Tools

Assembly jig

Rear panel



#### Procedure

- Adjust the assembly width by placing the rear panel at the bottom.
- Secure the rear panel with the metal hook and check for a firm fit.
- Ensure all parts are flush and twist-proof.

#### Notes

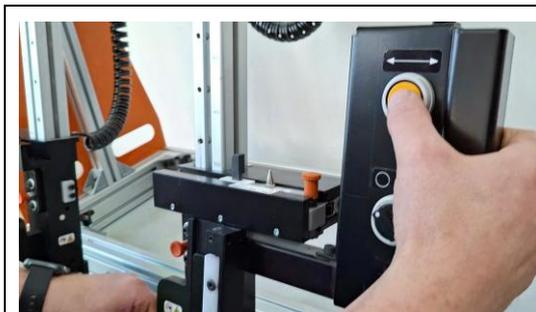
- All parts must be flush and twist-proof.

## 6.6 STEP 6: INSERTING AND FIXING THE REAR PANEL

### Materials and Tools

Assembly jig

Rear panel



### Procedure

- Align the rear panel precisely using the yellow lever and check the locking.
- Tilt the metal hook back once the width is set correctly.
- Ensure the rear panel is properly locked and not jammed.

### Notes

- Ensure proper locking.

## 6.7 STEP 7: INSERTING THE REAR PANEL HOLDERS

### Materials and Tools

Rear panel holders

Rear panel



### Procedure

- Align the rear panel holders and position them together with the rear panel.
- Check that the holders are firmly seated and no parts protrude.

### Notes

- Use only suitable components.

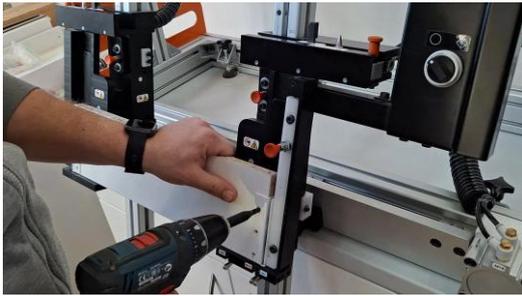
## 6.8 STEP 8: PRE-DRILLING THE MOUNTING HOLES

### Materials and Tools

Cordless screwdriver with 3 mm drill bit

Rear panel holders

Rear panel



#### Procedure

- Drill six holes as specified using the cordless screwdriver and 3 mm drill bit.
- Remove drill chips and check the drilling depth
- Ensure all holes are clean and straight.

#### Notes

- Remove drill chips; maintain correct drilling depth.

## 6.9 STEP 9: SCREWING THE REAR PANEL HOLDER TO THE REAR PANEL

### Materials and Tools

Second cordless screwdriver  
3.5 x 17 mm countersunk screws  
Rear panel holders  
Rear panel



#### Procedure

- Fix the rear panel holder to the rear panel with countersunk screws.
- Insert the screws straight and tighten them
- Ensure the material is not damaged or misaligned.

#### Notes

- Avoid material misalignment or damage.

## 6.10 STEP 10: INSERTING THE REAR PANEL AND BOTTOM

### Materials and Tools

Rear panel  
Drawer bottom



#### Procedure

- Place the rear panel in the upper support of the fixture.
- Position the bottom between the sides and fit it exactly.
- Ensure the bottom lies flat and is not skewed.

	<p><b>Notes</b></p> <ul style="list-style-type: none"> <li>- Do not skew; watch for pinching hazards.</li> </ul>
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## 6.11 STEP 11: ASSEMBLING THE DRAWER SIDES

### Materials and Tools

Drawer sides



### Procedure

- Assign the drawer sides correctly (metal fittings at the back).
- Insert the sides into the fixture and fit them flush.
- Ensure all sides are stable and not skewed.

### Notes

- Do not skew parts.

## 6.12 STEP 12: PRE-ASSEMBLY AND PRESSING

### Materials and Tools

Drawer side parts

Rear panel

Drawer bottom



### Procedure

- Check that all parts are correctly positioned and no components protrude.
- Operate the fixture lever to press the drawer.
- Ensure the drawer is firmly and flushly joined.

### Notes

- Keep fingers away from parts before pressing.

## 6.13 STEP 13: PRE-DRILLING AND SCREWING ON THE BOTTOM

### Materials and Tools

Cordless screwdriver with drill bit

Screws

## Drawer bottom



### Procedure

- Pre-drill the bottom and then fasten it with screws.
- Tighten the screws evenly and check for a firm fit.
- Ensure the material is not damaged.

### Notes

- Tighten screws evenly; watch the material.

## 6.14 STEP 14: RELEASING AND REMOVING THE ASSEMBLY

### Materials and Tools

Assembly jig



### Procedure

- Release the clamping device and remove the finished drawer.
- Place loose parts safely and tidy up the tools.
- Ensure the workspace is free of obstacles.

### Notes

- Place loose parts safely, keep the machine area clear.