

**BUILD IT WITH**  **PROJECT PLAN**

# TOOL CHEST

FEATURING  
ROCKLER'S

**LOCK-ALIGN**  
DRAWER ORGANIZER SYSTEM



**BUILD**

QUESTIONS? Go to [www.rockler.com](http://www.rockler.com) or call 800-279-4441

- | Stock # | Item   |
|---------|--|
| 63420   | 1/4" x 24" x 30" Baltic Birch Plywood                              |
| 63446   | 1/2" x 24" x 30" Baltic Birch Plywood                              |
| 63412   | 3/4" x 12" x 30" Baltic Birch Plywood (3)                          |
| 63453   | 3/4" x 24" x 30" Baltic Birch Plywood (2)                          |
| 49778   | 12" Series 757 100-lb. Over-Travel Centerline® Lifetime Slides (2) |

- | Stock # | Item                                      |
|---------|---|
| 49393   | Flat Tip Partial Wrap-Around Hinges, Pair |
| 66649   | Easy-Lift Lid Support                     |
| 1014281 | Stainless Steel 120mm Edge Pull (2)       |

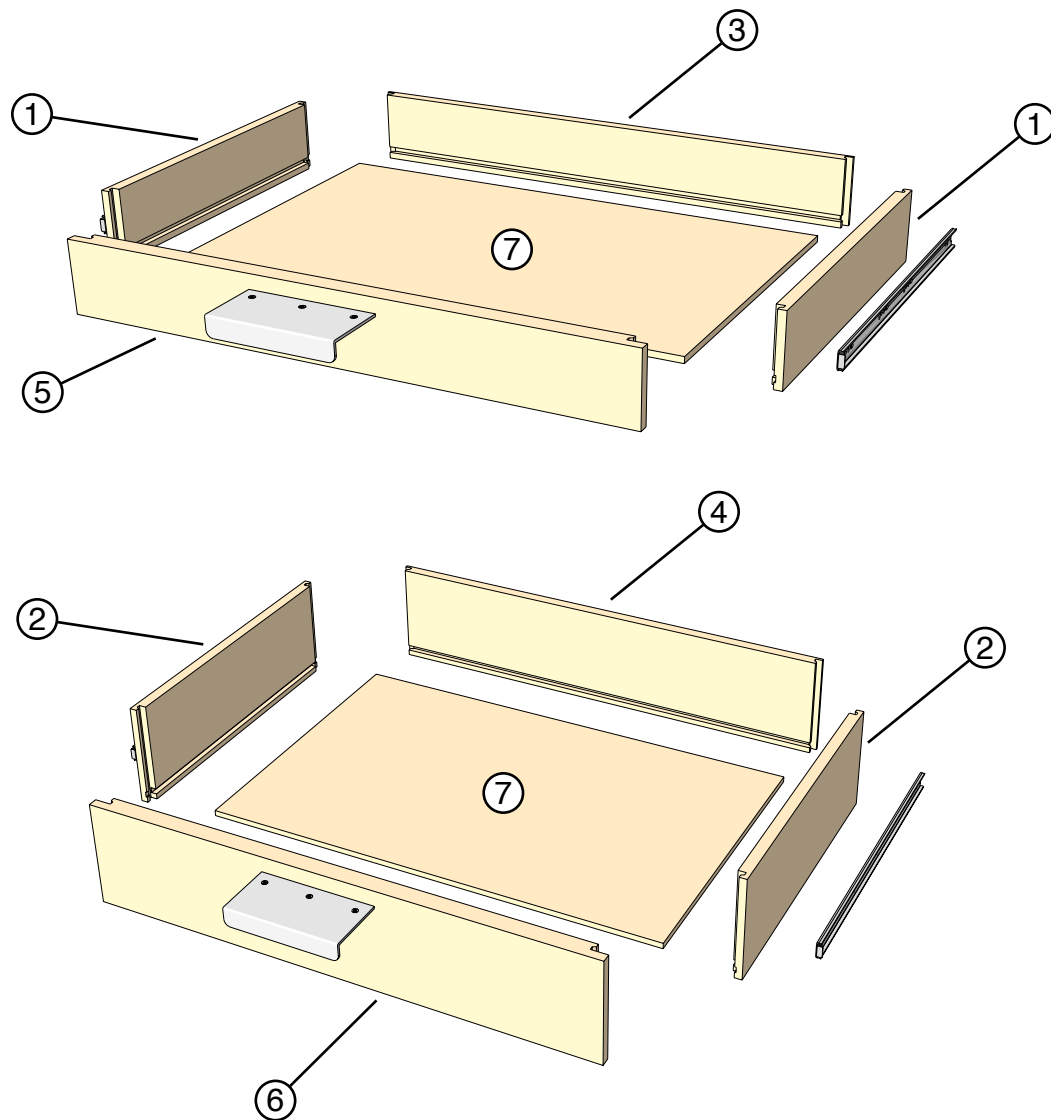


- | Stock # | Item   |
|---------|--|
| 22637   | Rockler Drawer Lock Router Bit                         |
| 53810   | Router Bit Set-Up Jig for 22637 Drawer Lock Corner Bit |
| 20300   | 1x Miller Tru-Fit Drill Bit                            |
| 21366   | 1x Miller Walnut Dowels Lock-Align Drawer Organizers   |

All items subject to changes in availability.

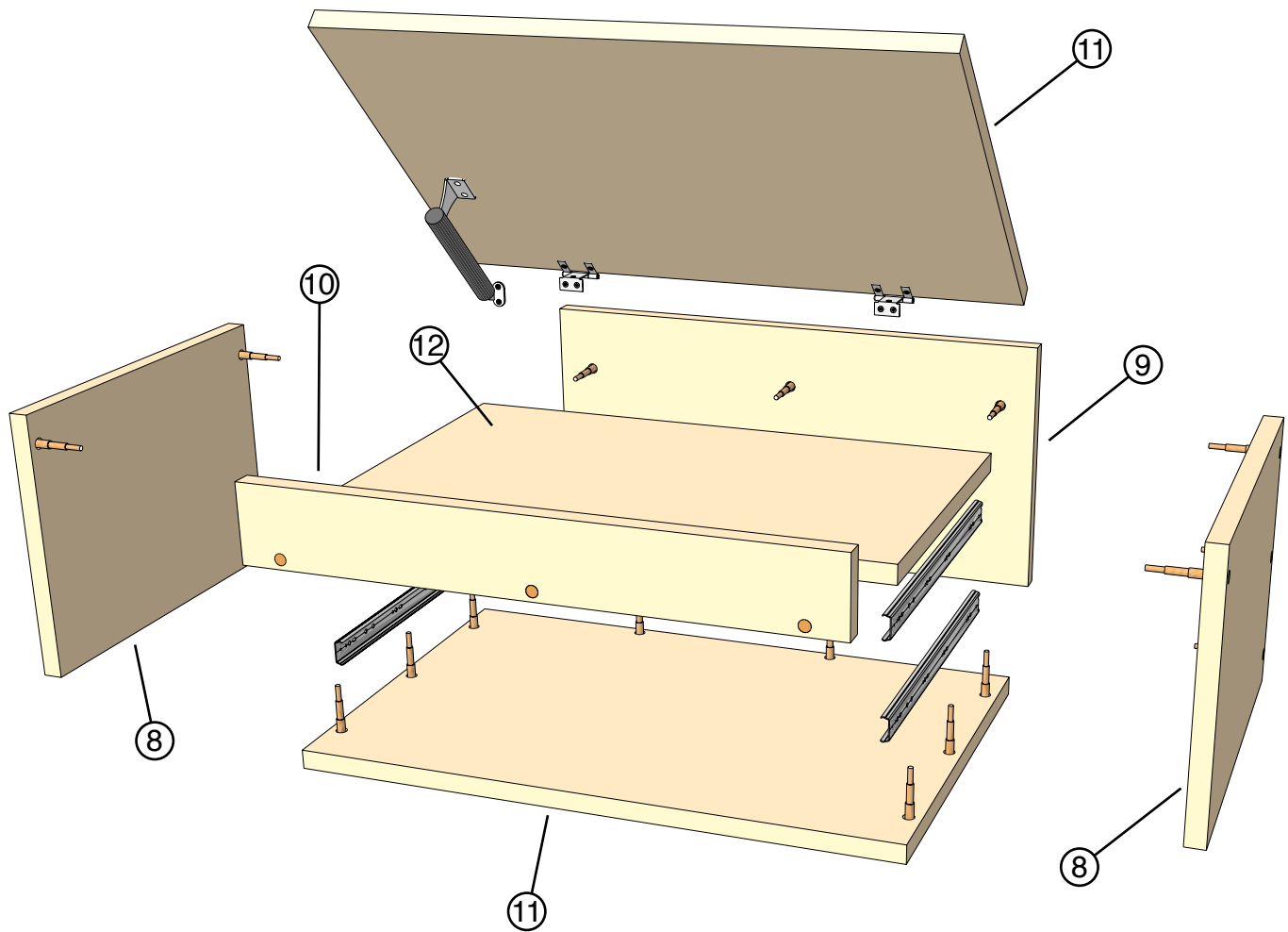
## TOOL CHEST PARTS – DRAWERS

Exploded View



### MATERIAL LIST – DRAWERS

	T x W x L
1 Top Drawer Sides (2)	1/2" x 2 <sup>3</sup> / <sub>4</sub> " x 13"
2 Bottom Drawer Sides (2)	1/2" x 4 <sup>1</sup> / <sub>2</sub> " x 13"
3 Top Drawer Back	1/2" x 2 <sup>3</sup> / <sub>4</sub> " x 20 <sup>3</sup> / <sub>4</sub> "
4 Bottom Drawer Back	1/2" x 4 <sup>1</sup> / <sub>2</sub> " x 20 <sup>3</sup> / <sub>4</sub> "
5 Top Drawer Front	3/4" x 2 <sup>3</sup> / <sub>4</sub> " x 21 <sup>1</sup> / <sub>2</sub> "
6 Bottom Drawer Front	3/4" x 4 <sup>1</sup> / <sub>2</sub> " x 21 <sup>1</sup> / <sub>2</sub> "
7 Drawer Bottoms (2)	1/4" x 13" x 20 <sup>1</sup> / <sub>4</sub> "

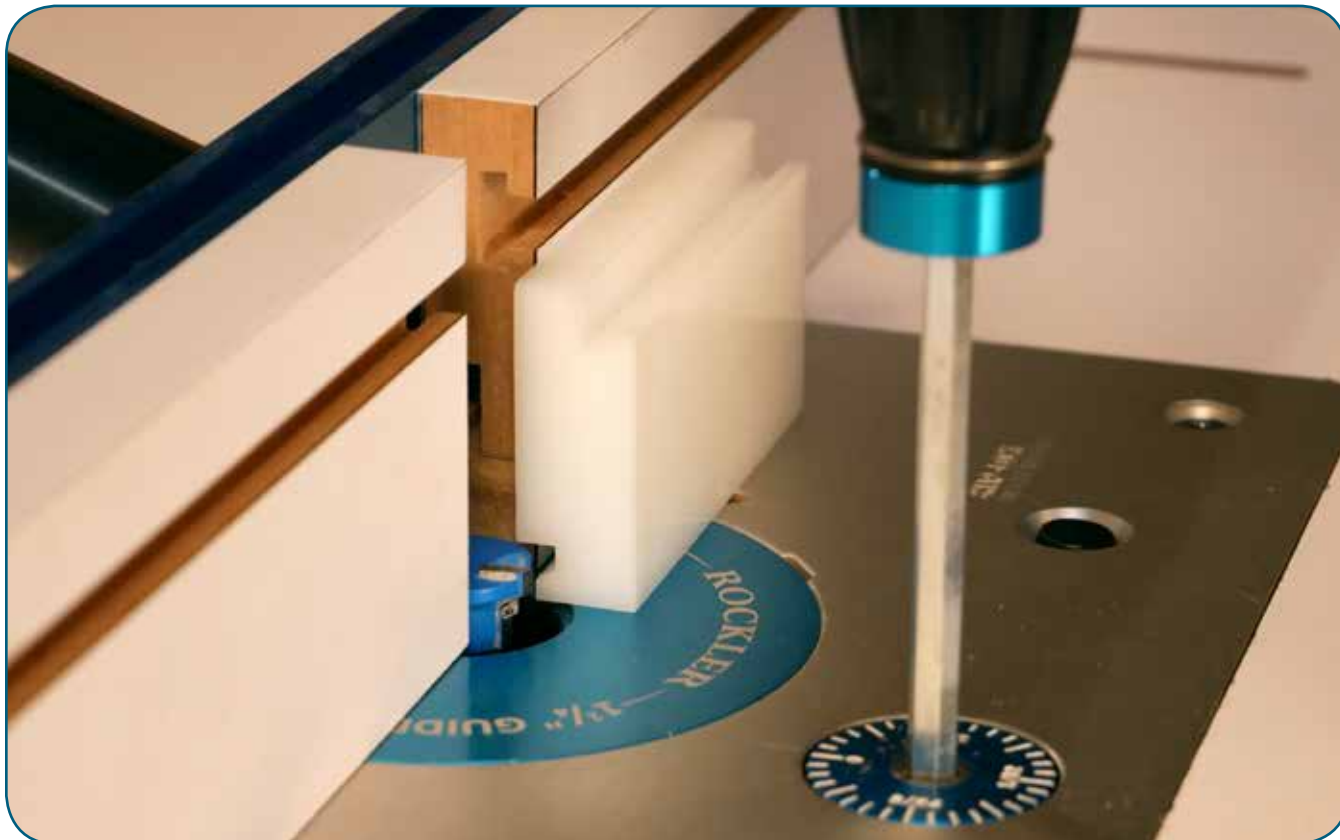


**MATERIAL LIST – CASE**

	T x W x L
8 Case Sides (2)	$3/4'' \times 10^{5/8}'' \times 14^{5/8}''$
9 Case Back	$3/4'' \times 10^{5/8}'' \times 21^{3/4}''$
10 Case Front Rail	$3/4'' \times 3'' \times 21^{3/4}''$
11 Case Top and Bottom (2)	$3/4'' \times 15^{1/8}'' \times 23^{1/2}''$
12 Case Middle Tray	$3/4'' \times 13'' \times 21^{3/4}''$

## 1. MAKE THE DRAWERS

The corner joints for the drawers of this cabinet were cut using the Rockler Drawer Lock Router Bit (22637) in a table-mounted router, but you could use another drawer corner joinery method. **For efficiency, we chose to cut the drawer corner joints in the upper and lower drawer parts before ripping them to their final heights.**



**A. Set bit height:** Cut two 7½" x 13" pieces of ½" thick Baltic birch plywood. These pieces will yield all four upper and lower drawer sides. (You'll rip cut them apart later.) Use the Rockler Drawer Lock Setup Jig (53810) to set the router bit height.



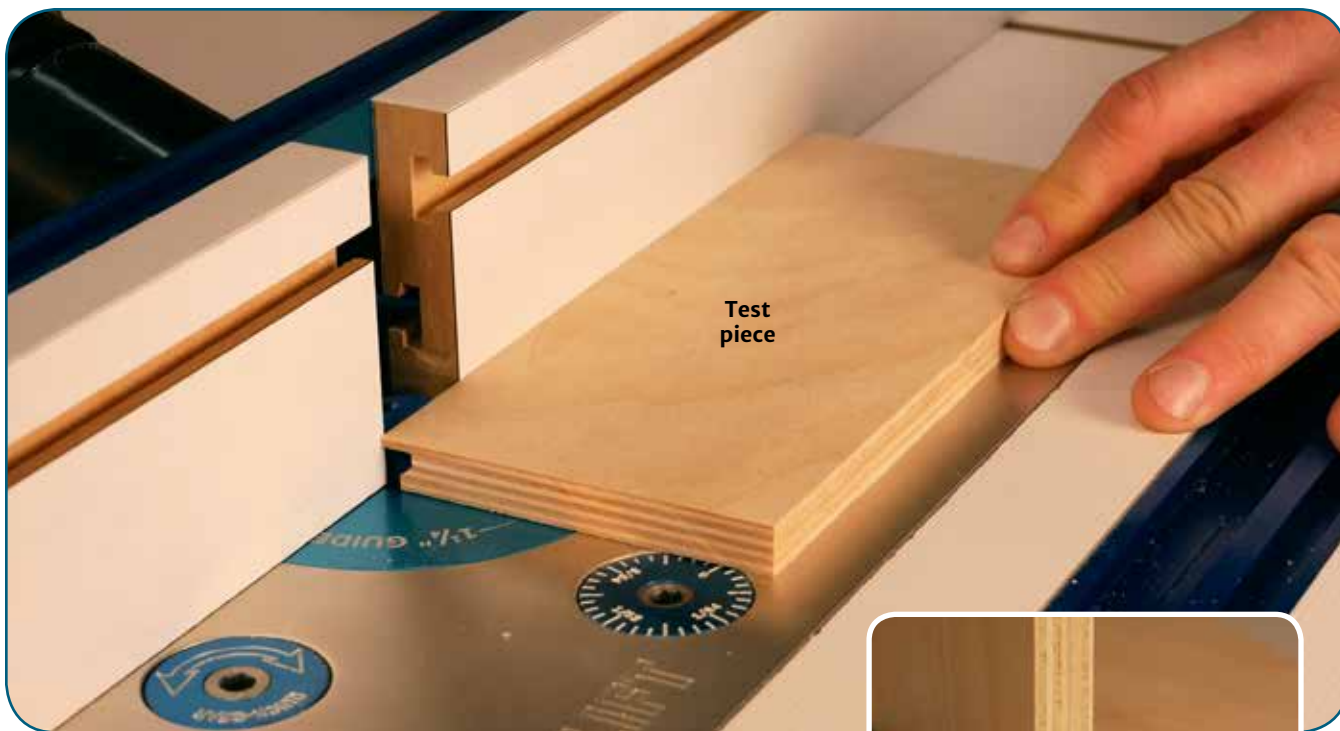
**B. Score cut line:** To prevent chipping of the plywood veneer, score the plywood 3/8" in from the edge with a knife several times before routing.



## 1. MAKE THE DRAWERS (CONTINUED)



**C. Rout the drawer sides:** With the panel positioned vertically against the fence, rout the corner joint profile along both ends of the drawer sides.

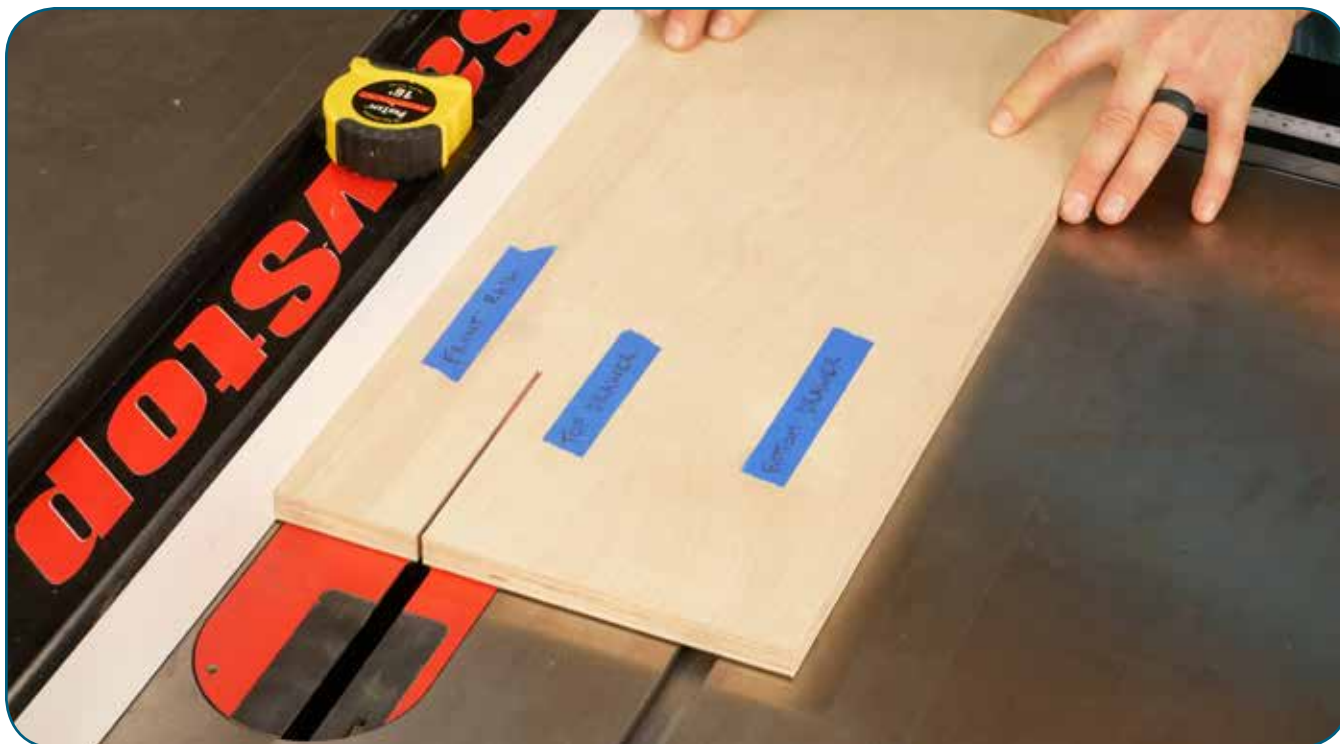


**D. Rout test piece to set bit for drawer back:** Find or cut a piece of scrap 1/2" Baltic birch plywood to use as a test piece for routing the lock joint profile in the drawer backs. Rout the scrap piece and test the fit of the joint with one of the drawer side pieces. If the joint does not fit well, adjust the router bit height or fence position and make another test cut until the joint fits.

## 1. MAKE THE DRAWERS (CONTINUED)



**E. Rout back panel:** Cut a piece of 1/2" thick Baltic birch plywood measuring 7<sup>1</sup>/<sub>2</sub>" x 20<sup>3</sup>/<sub>4</sub>". This piece will yield the upper and lower drawer backs. (You'll cut them apart later.) Rout the corner joint profile along both ends of the back panel.



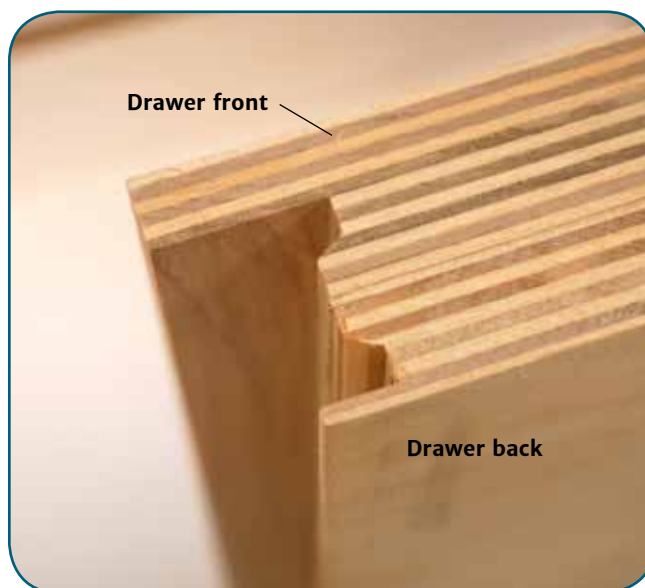
**F. Rip top rail from drawer front panel:** The front rail and drawer fronts are cut from the same piece of plywood to create continuous grain across the front of the chest. Start with a piece of 3/4" thick Baltic birch plywood measuring 10<sup>3</sup>/<sub>4</sub>" x 21<sup>3</sup>/<sub>4</sub>". Cut the 3" front rail off the top of the panel. Then trim 1/8" off each end of the remaining piece for the drawer fronts.



## 1. MAKE THE DRAWERS (CONTINUED)



**G. Rout corner joint in drawer front panel:** Back at the router table, prepare to cut the corner joint profile in the piece for the drawer fronts. You want to cut the profile in several passes: Make a pass on each end, check the fit of the joint and then adjust the router table fence back for the next pass. Make shallow cuts as you creep up on the final width for the inside face of the drawer front. It should end up matching the inside width of the drawer back. (The outside face is  $7/8$ " wider so that it will overhang and conceal the drawer slides.)



## 1. MAKE THE DRAWERS (CONTINUED)



**H. Cut the 1/4" x 1/4" grooves:** Once the drawer corner joints all fit well, cut apart the upper and lower drawer front pieces, sides and backs. Then set the table saw blade to a 1/4" cutting height and make multiple passes to cut a 1/4" wide groove for the bottom panels in all of the drawer sides, fronts and backs.



**I. Measure diagonals to check for square:** Cut the 1/4" thick drawer bottoms to size and then glue up the drawer boxes. Measure across the diagonals to check for square.

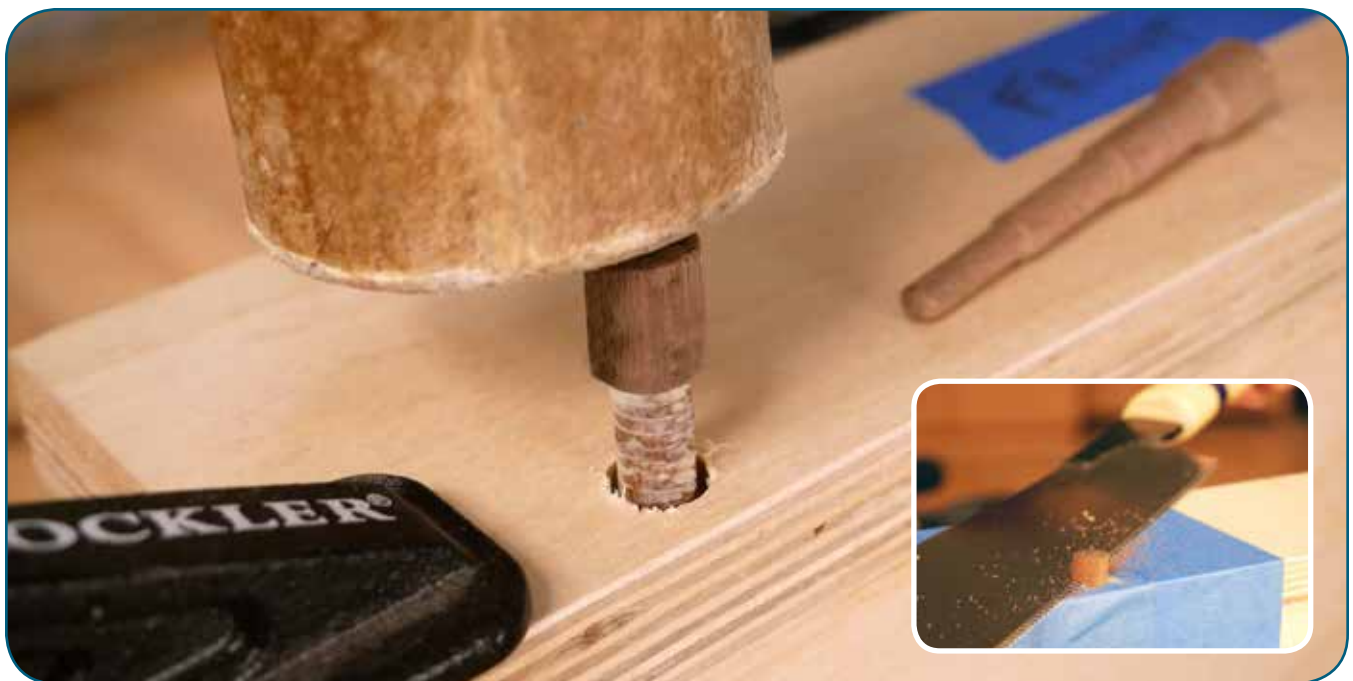


## 2. MAKE THE CASE

Cut the case parts to size, first double-checking the width of the drawer to be sure the front rail, top tray, and back panels will be 1" wider than drawers to make room for the slides. It's easiest to assemble the case as smaller sub-assemblies. Assemble the front rail, top tray and case back first. We used walnut Miller Dowels (21366) to assemble the case parts.



**A. Prep first sub-assembly:** Start with the front rail, top tray and case back. Glue and clamp the parts together. Then use the special stepped Miller Tru-Fit Drill Bit (20300) to bore the dowel holes.



**B. Secure with dowels:** Apply a small amount of glue to the ribbed section of the dowel, and then tap the dowel into the hole with a mallet. Apply painter's tape around the dowel to prevent scratching and trim the dowel with a flush-cut saw. (Refer to the Miller Dowel manufacturer instructions for more specific installation instructions.)

## 2. MAKE THE CASE (CONTINUED)



**C. Assemble rest of case:** Continue to assemble the cabinet by attaching the sides and the bottom with glue and Miller Dowels.

## 3. FINAL ASSEMBLY



**A. Cut mortises for drawer pulls:** The drawer pulls mount flush to the top edges of the drawer fronts, so you'll need to cut a 1/8" deep mortise in the top of each drawer front to match the pull. One way to do this is to make a simple jig to guide your router and contain the cutting area. We made one with a couple of longer pieces of plywood that sandwich the drawer front and two shorter pieces at right angles that serve as stops.



### 3. FINAL ASSEMBLY (CONTINUED)



**B. Install drawer pulls:** Drill pilot holes for the screws and install the pulls.



**C. Install drawer slides:** Install the 12" Series 757 100-lb. Over-Travel Centerline® Lifetime Drawer Slides (49778) 7/16" back from front edge of the case sides. Locate the slides in the case so they will be centered on each drawer side. Then center and attach the drawer slides on each drawer side.



### 3. FINAL ASSEMBLY (CONTINUED)



**D. Install hinges and lid support:** Mount the hinges on the top and back of the case. Then install the Easy-Lift Lid Support (66649), adjusting the tension as directed in the lid support instructions. Once you are satisfied with the lid and drawer operation, remove all hardware and apply your preferred topcoat finish.

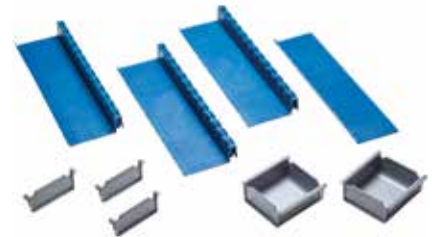
**Turn the page to see how you can keep the contents  
of your tool chest organized and accessible ...**

## 4. FILL AND ORGANIZE

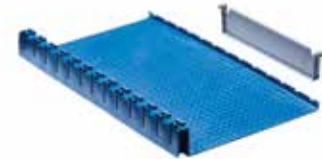


## LOCK-ALIGN DRAWER ORGANIZER SYSTEM

The interlocking trays, bins, dividers and other components of the Rockler Lock-Align Drawer Organizer System allow you to build a grid of compartments that is customized not only to the size of your drawer but also to the tools and hardware that you need to sort. The trays interlock side-to-side and line up end-to-end to fill out drawers of any width or depth.



Starter Kit (56117)



Wide Tray (57914)



Standard Bins with  
4-Way Dividers, 2-Pack (51034)



Wide Bin (56801)



Liner (51454)