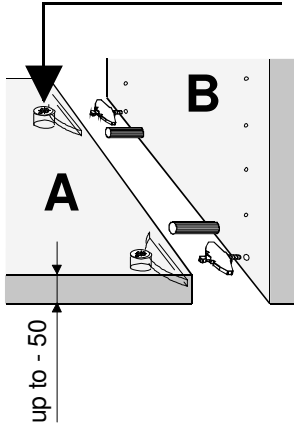


# Drill jigs LF 220.DMC

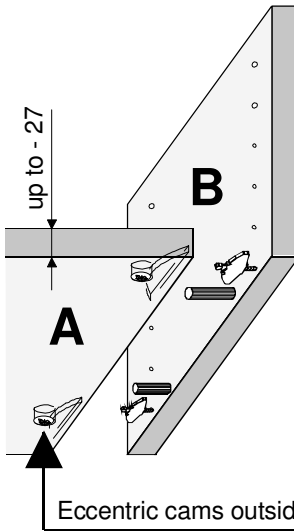
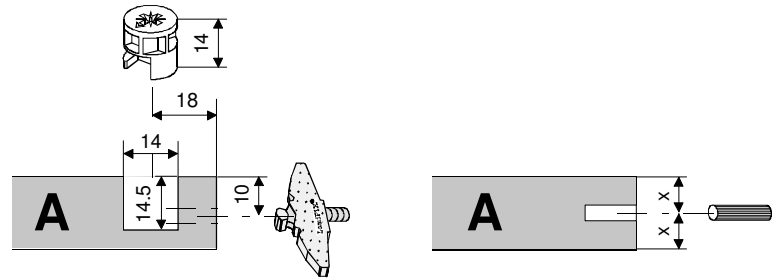
Adjust and apply

## Eccentric cams inside



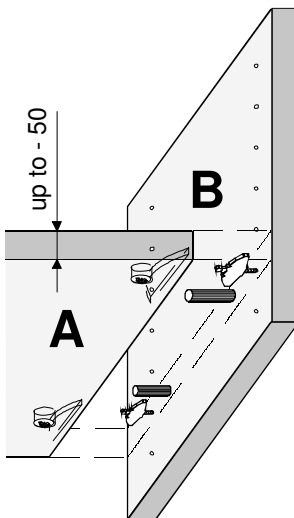
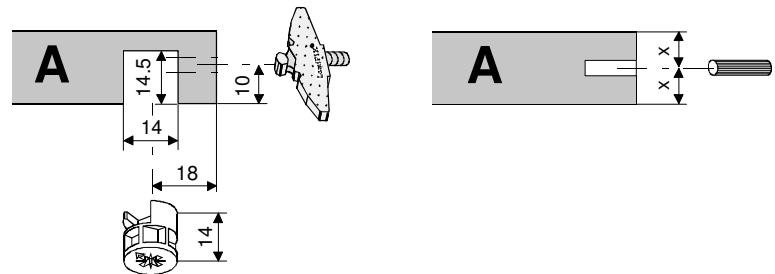
## Eccentric cams inside (Normal application)

Drilling: Eccentric cams, connectors and pins  
Marking of centre line for grooving  
Fig. 1 to 7



## Eccentric cams outside (Special application)

Prepare an auxiliary template:  
Made out of a wood strip, Fig. 1, 2, 3 + 6  
Adjustment for connector: Fig. 8  
Adjusting drill guides for pins:  
Use the prepared auxiliary template, Fig. 9



## Centre walls and centre bases

Work piece A:

Drilling: Eccentric cams, connectors and pins  
Marking of centre line for grooving  
Fig. 1 to 5

Work piece B:

Drilling: Connectors and pins, Fig. 10 + 11

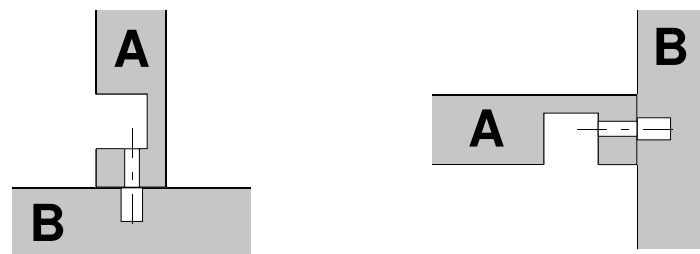


Fig. **1**  
**Plugging zero level piece to zero line**  
to adjust the drill jig

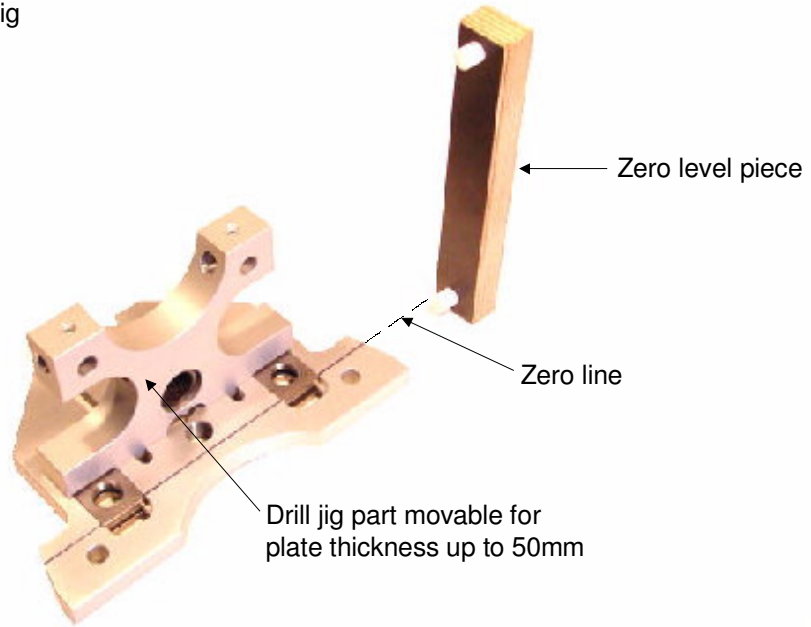


Fig. **2**  
**Adjusting drill jig for eccentric cam from inside**  
(normal application)

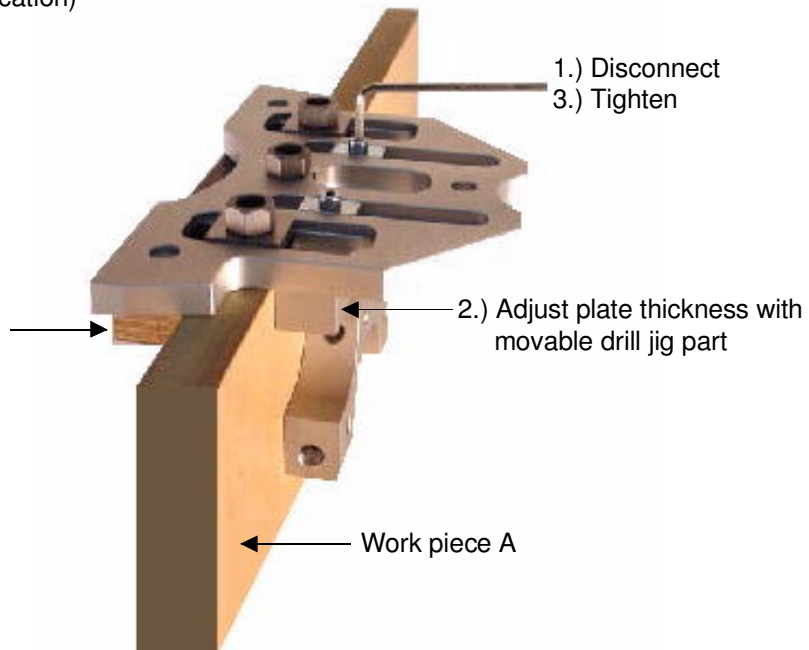


Fig.  
**3**

**Adjusting drill guides for pins**

centre according to plate thickness

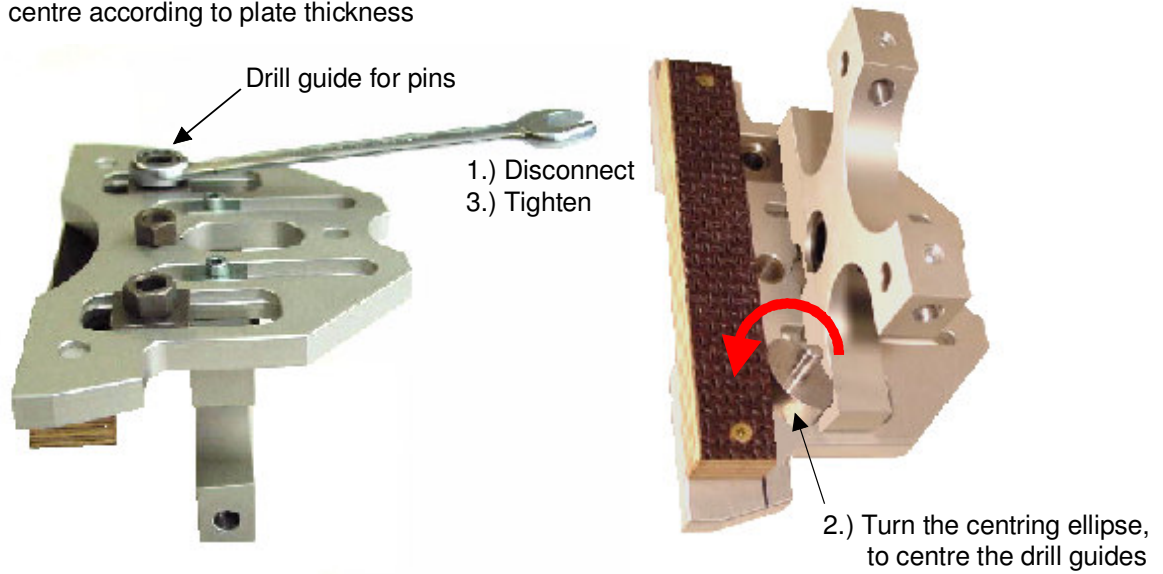


Fig.  
**4**

**Adjusting the end stops**

x = for eccentric cams from outside, requires end stops symmetrically adjusted

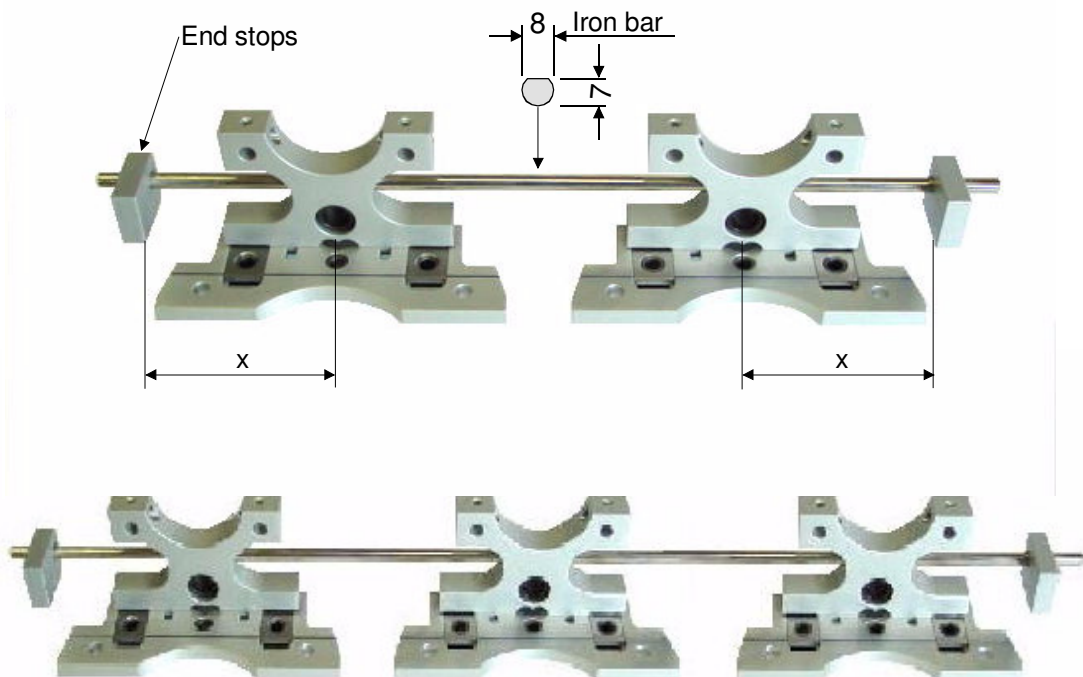


Fig.  
**5**

**Work piece A drilling, marking, grooving**

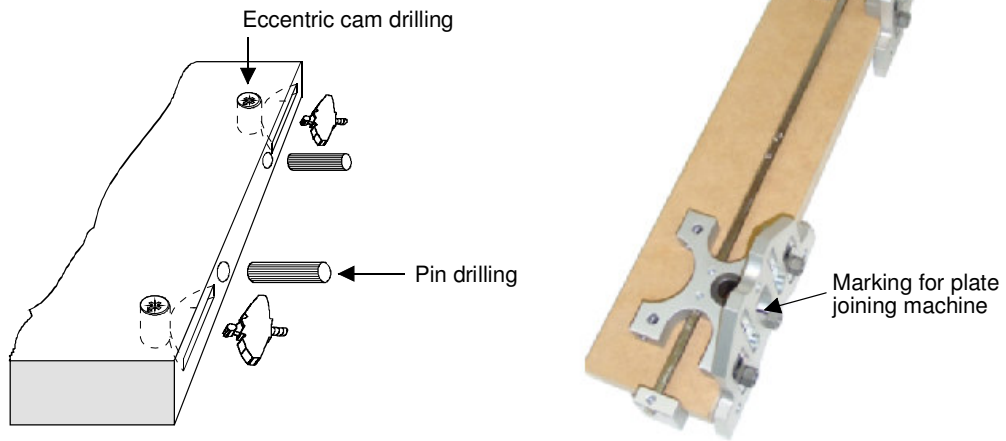


Fig.  
**6**

**Work piece B drilling**

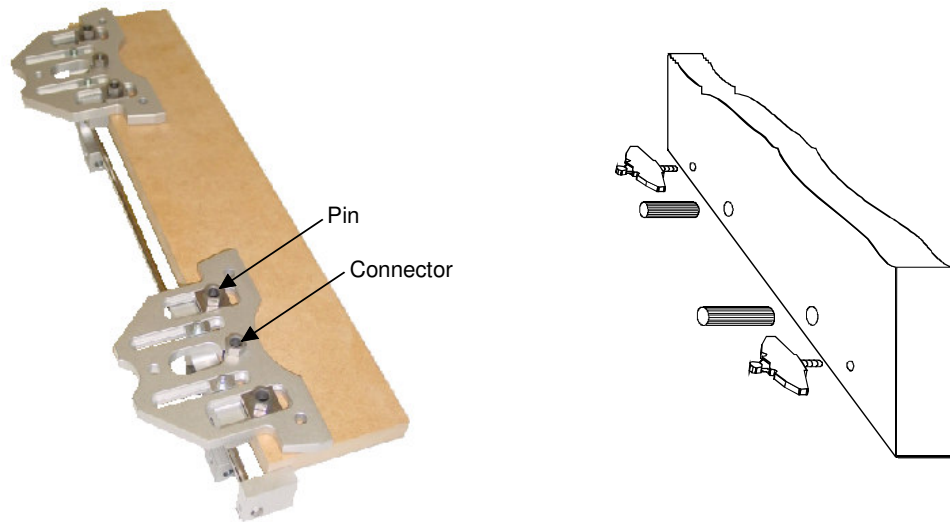


Fig.  
**7**

**Assembly**

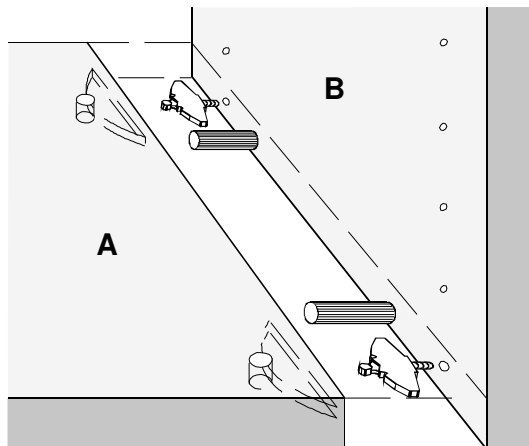


Fig.  
**8**

**Adjusting drill jig for eccentric cams from outside**

(special application)

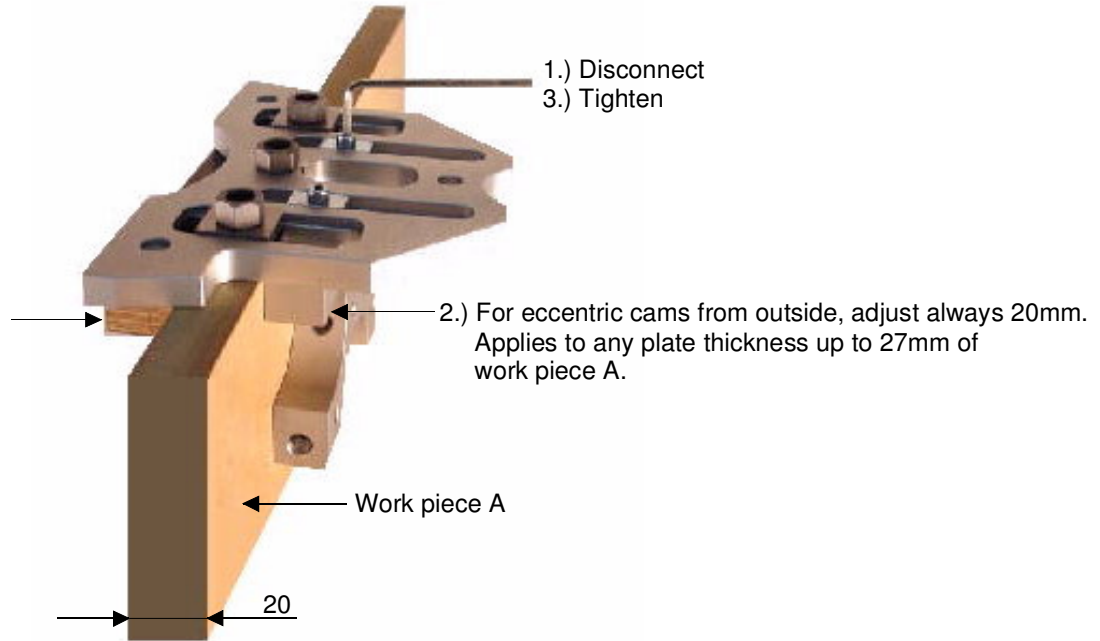


Fig.  
**9**

**Adjusting drill guides for pins, for eccentric cams from outside**

(special application)

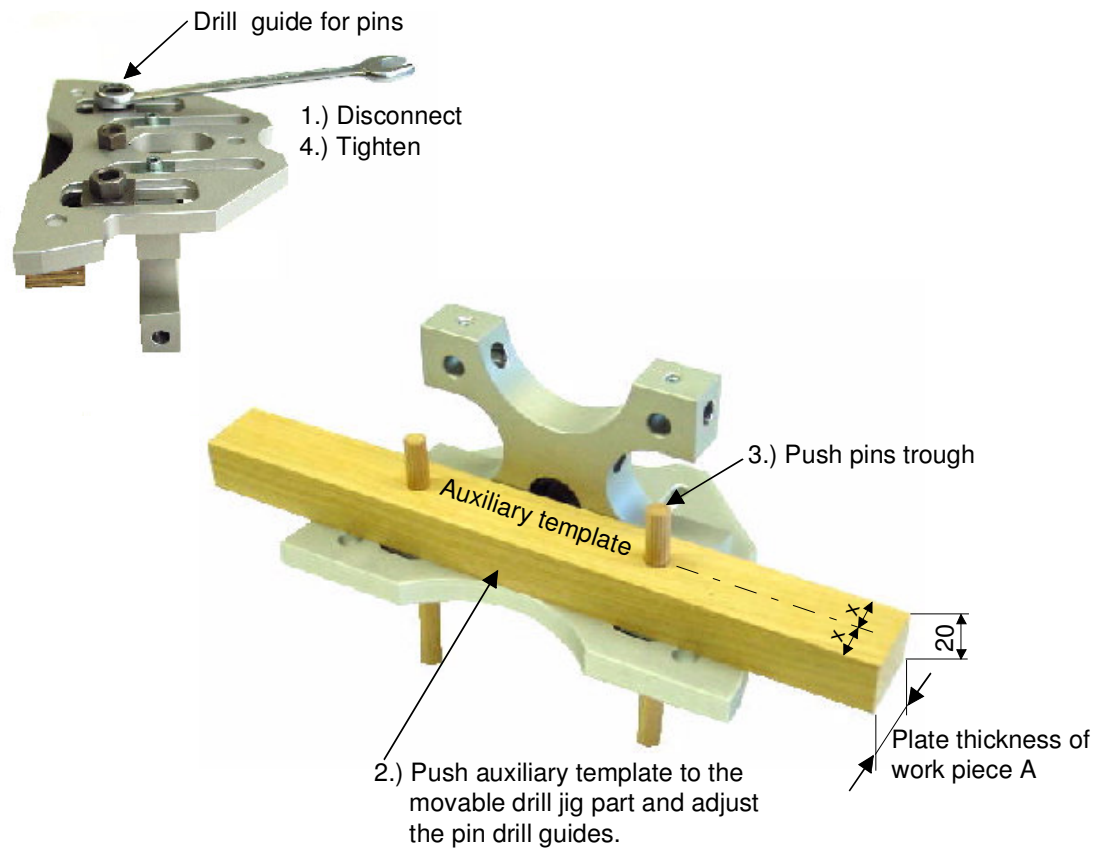
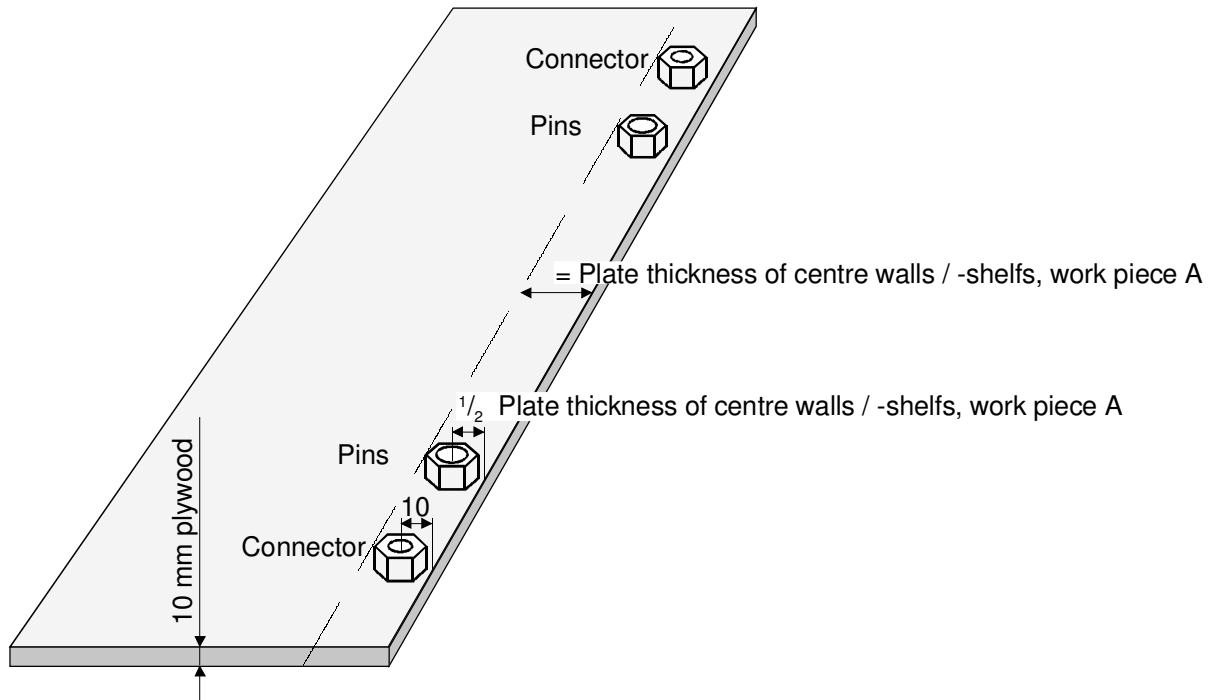


Fig.  
**10**

**Drill jig for centre walls / centre shelves**

for drilling in work piece B



- Adjust drill jig, Fig. 1, 2, 3, 4 + 6 and fix it on plywood.
- Mark plywood with pin drill tip.
- Remove drill jig and drill through the plywood  $\varnothing$  11 mm.
- Screw in drill guides.

Fig.  
**11**

**Drill hole in work piece B**

for pins and connectors

