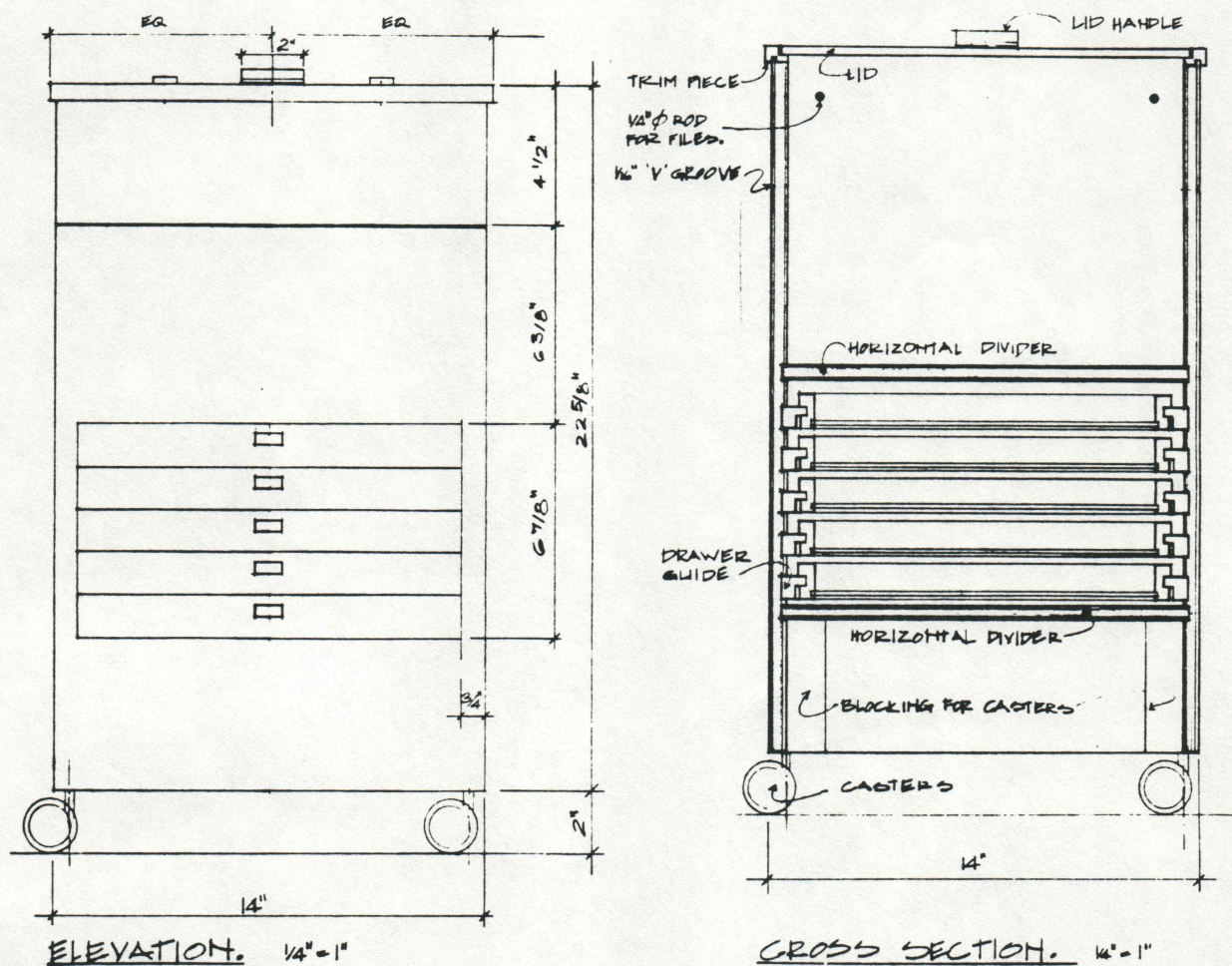


HERMAN MILLER FURNITURE SYSTEMS

ROLLING FILE CABINET



The rolling File Cabinet is available in one standard size and a choice of finishes. The cabinet is finished in melamine or acrylic laquer and the lid is transparent acrylic.

The process for making the rolling file cabinet is described as a series of minor assemblies:

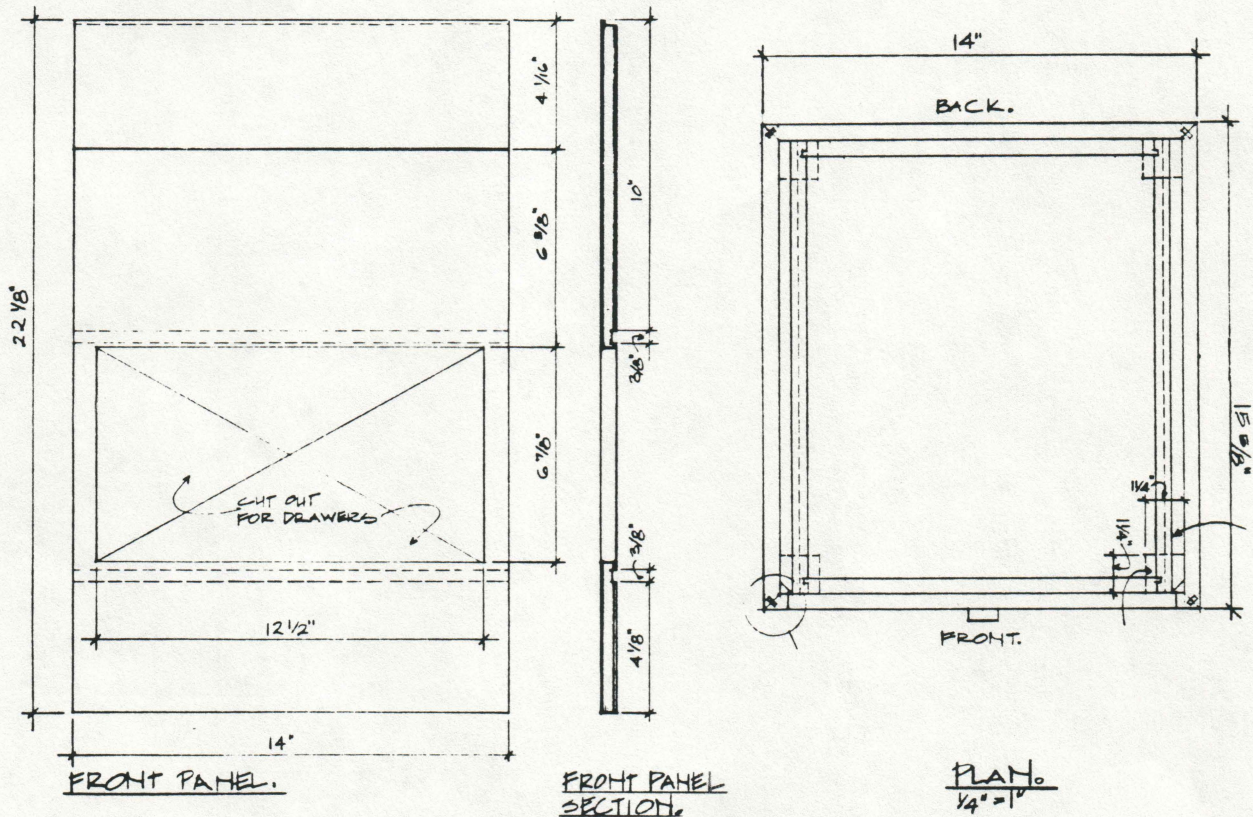
1. The Box.
2. The Trim Piece.
3. The Lid.
4. The Drawers.
5. Final Assembly.

HERMAN MILLER FURNITURE SYSTEMS

I. THE BOX

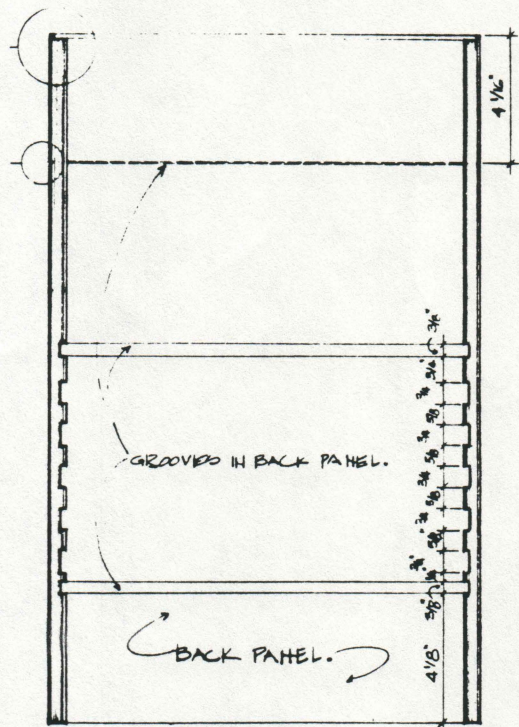
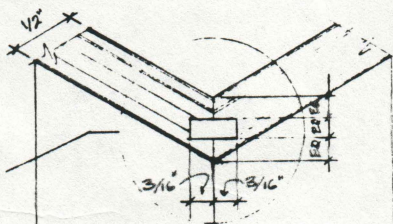
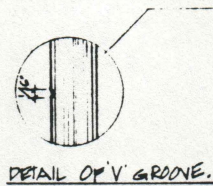
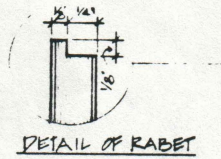
The box of the file cabinet consists of the front panel, the back panel, the two sides and the two horizontal dividers. The six pieces fit together with a splined miter joint to form a rigid structure.

1. Cut the front and back panels and the two sides of the box out of 1/2" finish Birch plywood. All vertical edges to be cut at a 45 degree miter. Cut the opening for the drawers in the front panel as shown. Cut the two horizontal dividers out of 3/8" plywood.



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2. Run the 'v' groove on the outer face of each panel as shown.
3. Run the grooves for the two horizontal dividers on the inside of each of the four panels.
4. Run the grooves for the drawer guides in the two side panels.
5. Cut the rabbet in the top edge of each panel and groove the vertical edges for corner joints as shown.



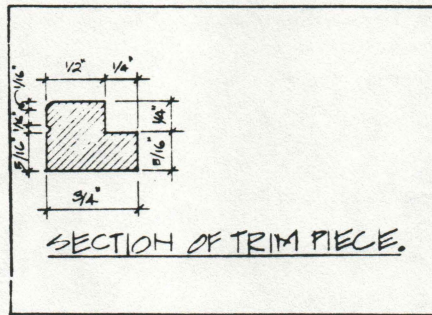
SIDE PANEL.

6. Cut the blocking for the casters.
7. Prime all surfaces with two coats of high build primer. Sand with #220 sandpaper.

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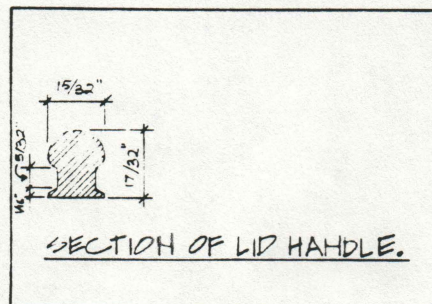
II. THE TRIM PIECE

1. Mill the section for the trim piece out of solid Birch, and cut the four pieces to the standard length. Miter the ends of each piece as shown.
2. Prime all four pieces with 2 coats of high build primer. Sand with #220 sandpaper.



III. THE LID

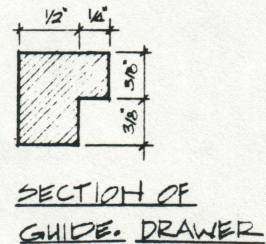
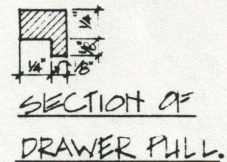
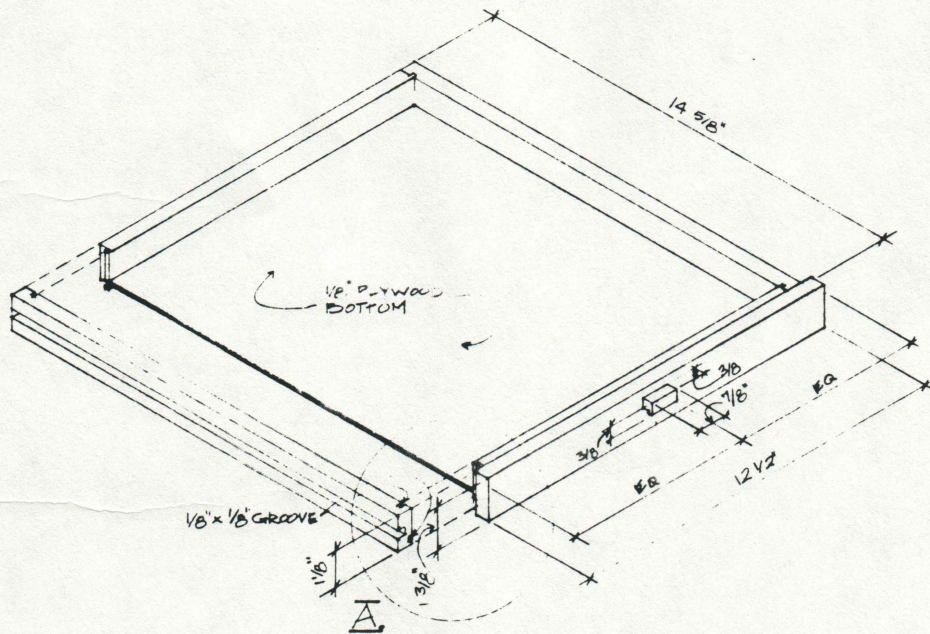
1. Cut the lid to size out of 1/4" th. clear acrylic sheet.
2. Shape the section for the lid handle out of a 1/2"x1/2" section of clear acrylic. Cut the handle to size and attach to the lid with heavy body acrylic cement.



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IV. THE DRAWERS

1. Mill all the stock for the sides of the drawers out of solid Birch as shown. Cut the bottom of the drawer out of 1/8" plywood.
2. Mill the section for the drawer guides out of solid oak as shown. Cut all the drawer guides to length and miter the front end of each as shown.



3. Mill and cut to size the stock for the drawer fronts and drawer pulls. Attach the pulls to the drawer fronts and prime with 2 coats of high build primer. Finish with 2-3 coats Dupont acrylic lacquer.
4. Pre-drill the holes for the screws in the inner front wall of the drawers with sufficient play to allow for some adjustment when positioning the drawer front.
5. Assemble all the pieces of the drawers except for the drawer fronts.

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V. FINAL ASSEMBLY

Prior to this stage all the individual sub-assemblies should have been prepared and primed.

1. Assemble the pieces of the box as shown and attach the blocking for the casters.
2. Attach the trim pieces to the box.
3. Attach the drawer guides to the box and insert the drawers. Position the drawer fronts accurately and attach them to the inner front wall of the drawers with screws.
4. Paint the box with 2-3 coats Dupont acrylic lacquer, or melamine.
5. Attach 2" Shepherd Ball Casters for carpets to the blocking.
6. Insert the 1/8" metal rods for the files inside the box. The holes for the rods should be slightly over sized to allow the rods to be inserted.
7. Attach the lid to the box with #1614 McMurry Pacific free swinging hinges.
8. Inspect finished object.

