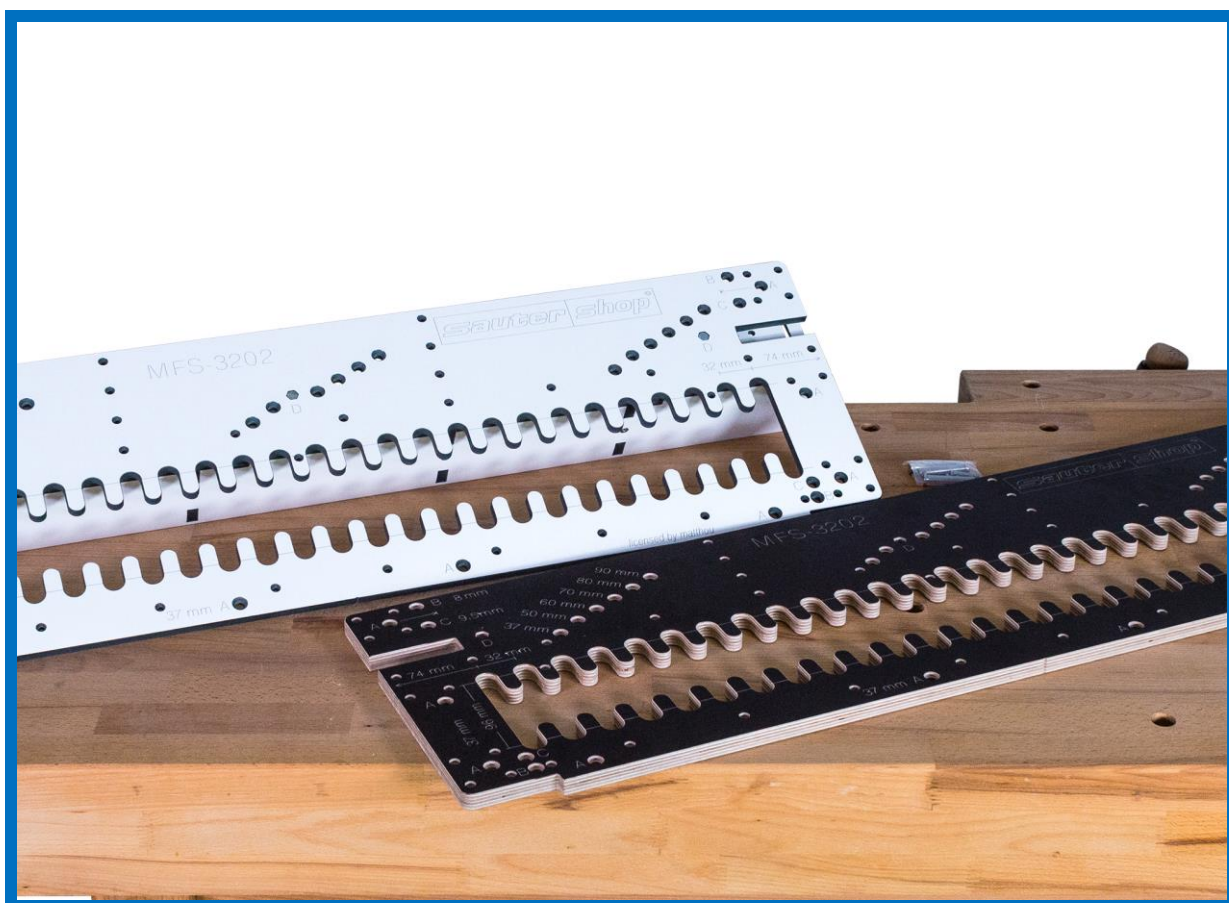


Multi-milling template MFS-3202

Instruction manual



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1. Introduction

Congratulations on the purchase of a sautershop MFS-3202 template. This product enables you to produce absolutely precise hole lines in the System 32 format in the simplest and quickest way, to set pilot holes for drawer extensions and to drill dowel connections.

Especially in furniture construction, all parts can be developed using the System 32 template. You can make the required holes in seconds.

2. Preparations:

- First prepare a flat work surface with sufficient space (depending on the size of the workpiece). Ideally, a workbench should be provided where the workpieces can be clamped horizontally as well as vertically.

Required accessories:

- - hand-guided router fitted **with** 17mm copy ring
- - at least 2 screw clamps, one-hand clamps or similar clamping tools
- - Drill or router bit with the required diameter

3. Application examples:

The sautershop MFS-3202 milling template is useful in a variety of applications. These include:

- Hole lines for shelves
 - Extension of existing hole lines
 - Holes for hinges / door fittings
 - Cross hole rows for drawer runners
 - Dowel holes up to 14mm diameter
 - Parallel hole rows
 - etc.
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4. Procedures:

4.1 Production of hole lines for shelves:

Variable shelf placement is a standard in furniture construction. To make this possible, rows of holes are made at defined distances from the front or rear edge of the inside of the cabinet. .

Procedure:

1. Put the template against the long side and set the distance.

For cabinets where doors are mounted, insert the supplied bolts in the 37 mm mark. (When using standard door hinges!)

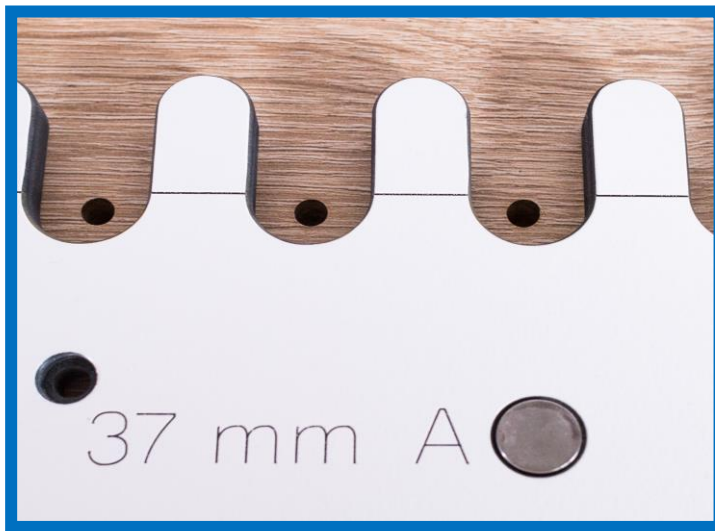


Fig. 1 :

The 37mm distance mark is suitable for making hole lines for mounting standard hinges.

The distance to the upper or lower edge of the workpiece is variable. Symmetrical alignments are often chosen in furniture construction, in which the center of the workpiece forms the axis of symmetry width-ways. See also fig.2

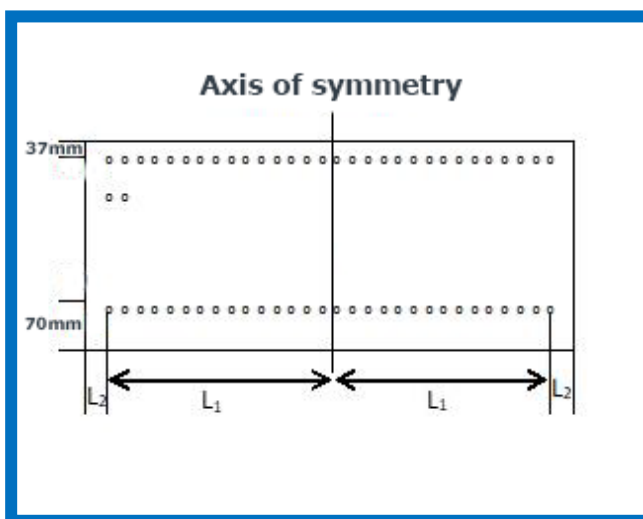


Fig. 2: For existing doors where the holes for the concealed hinges are already drilled, the distance between the fittings is decisive. The hole lines must be adjusted accordingly. The sautershop MFS-3202 offers a simple measuring stop for adjusting the distance of the first hole to the edge of the workpiece. With this, the exact distance can be set easily and accurately using a standard link scale. This scale indicates the distance from the workpiece edge to the center of the first hole.

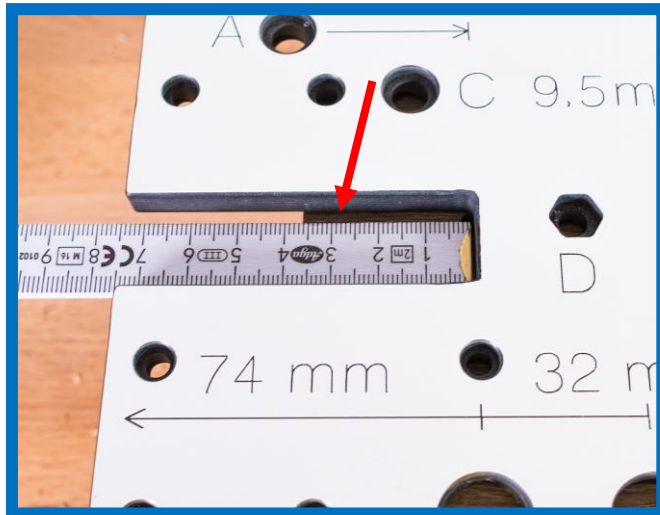


Abb. 3:

The measuring stop is designed in such a way that when using standard ruler, there is sufficient visibility of the workpiece. This allows the distance to be read off easily and precisely.

2. Once the starting position has been found, the template is fixed to the workpiece with a clamp at each end. Please make sure that the template does not slip and that the stop pins are in contact with the workpiece.
3. Insert an appropriate 3 or 5mm hole cutter into the router equipped with a 17mm copy ring. To avoid inaccuracies when working, the sautershop template has virtually no play between the guide lines of the template and the copy ring.
4. Before starting you should guide the machine with the copy ring through the stencil with the power off for a test. It is possible that the guide has some play depending on the copy ring used. However, this is unproblematic due to the centering effect of the circular end stop of each line.

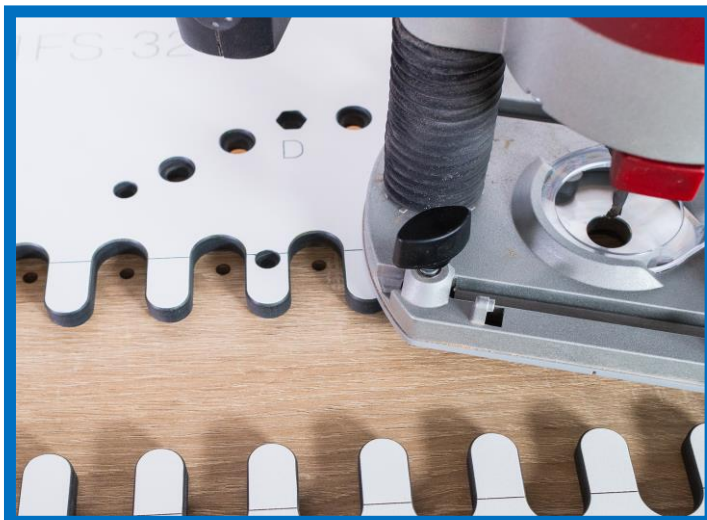


Fig 4:

To use the template, use a 17mm copy ring. Choose the drill diameter according to your application. 5mm is the standard for fittings and shelf holders. Recently 3 mm drill holes have become increasingly popular, which can also be produced with this template.

5. Now you can start cutting the hole line.

When cutting make sure that the router is always positioned correctly before cutting the hole. You have the possibility to drill 27 holes in a row until the template must be moved.

4.2 Extension of existing hole lines:

1. With the sautershop MFS-3202 template, you have the possibility of easily extending 5mm hole lines.
2. To do this, place the template on the hole line and position it with a 5mm bolt hole over an existing hole in the existing hole line.
3. Insert the 5mm bolt into the 5mm hole to fix the position of the existing hole line.

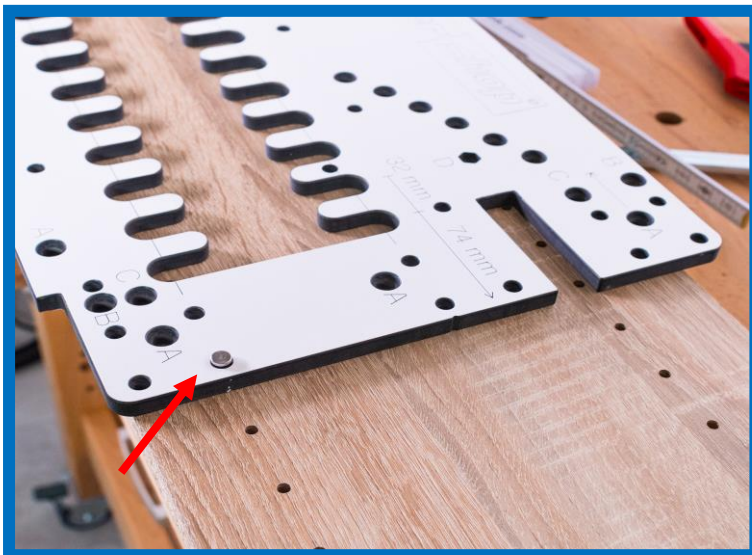


Fig. 5

Using the existing 5mm bolts, existing rows of holes can be used as a starting point for extending holes. This makes it very easy to create endless rows regardless of how long the material is!

4. When the hole is fixed, the parallel alignment must be carried out. If the existing row of holes has been created with a standard spacing, the corresponding spacer bolts can also be used here as described above. If the spacing is not in an existing stop dimension, the alignment must be carried out by hand and using a meter scale. For this purpose, the distance is first taken at the fixed point and adjusted at a remote point on the template.
 5. As can be seen in the picture above, this can also be done in parallel alignment. You have countless possibilities to align the template to existing drill holes.
 6. After correct adjustment, the stencil must be fixed again with two screw clamps.
 7. Finally, the hole line is cut.
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4.3 Drilling holes for drawer runners:

Drawer pull-outs, regardless of whether they are telescopic slides with partial or full extension technology, are manufactured and delivered with standardised drill holes.

The 32mm system can be found in all current systems. It is advisable to first create a row of holes parallel to the front of the body.

1. Creation of a row of holes parallel to the front of the body. Proceed as described in point 4.1. Pay attention to the required distances of the first or last hole to the bottom or top panel.
2. To cut the cross rows, rotate the stencil by 90 degrees. Use the two outer 5mm bolts to fix the template in the existing hole line

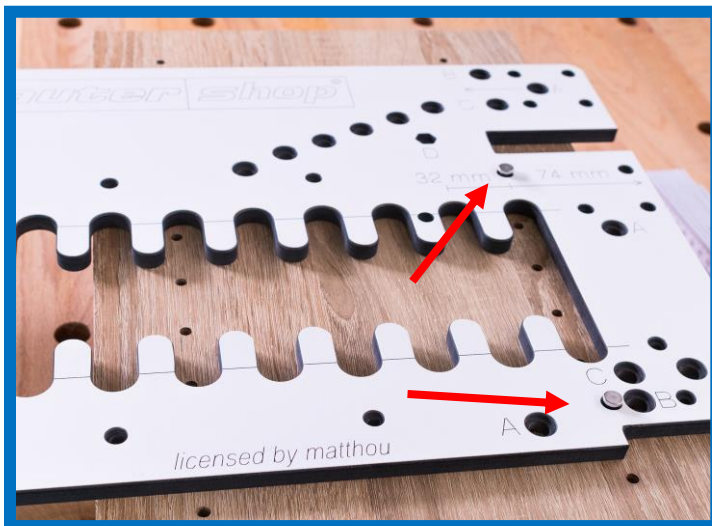


Fig. 6

The 5mm bolts give the stencil a firm hold on the workpiece. Nevertheless, the stencil must always be firmly fixed to the workpiece by means of clamps. One-hand clamps are easy to use and speed up the work many times over.

3. If it is not yet clear which hole positions of the telescopic slides you are using, it is recommended to drill a continuous cross row.
 4. Repeat the procedure for each pull-out position.
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4.4 Creating a corpus connection with simple wooden dowels

1. Clamp the workpiece vertically.



2. Attach the mitre fence to the hole line template..
(the fence is available as an optional accessory)



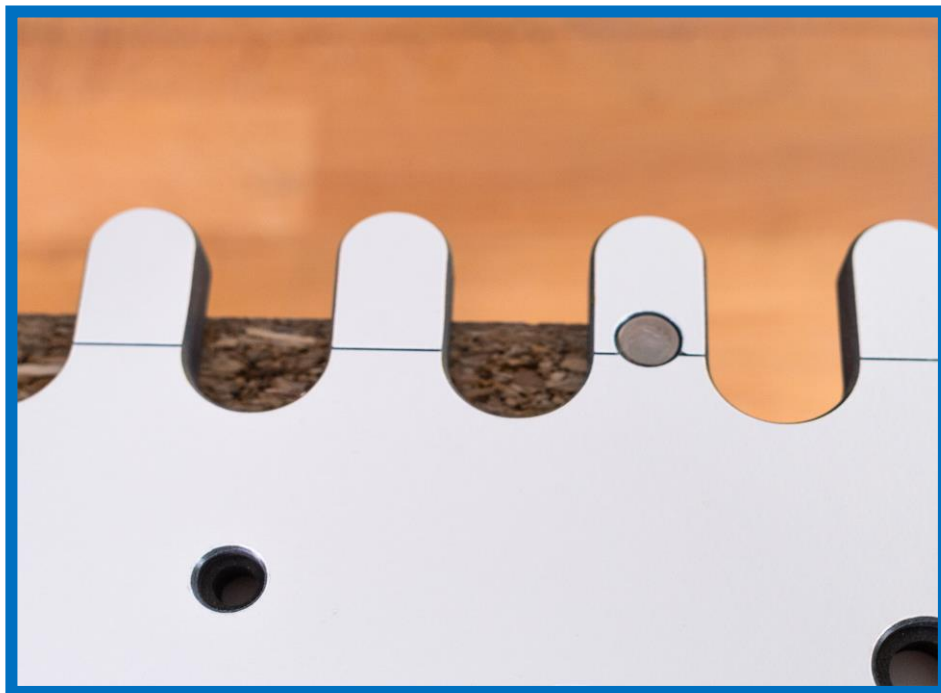
It is fastened by means of three M6 hexagonal bolts and wing nuts. There are 6 selectable standard distances to suit common material thicknesses.

3. Fix the template to the workpiece

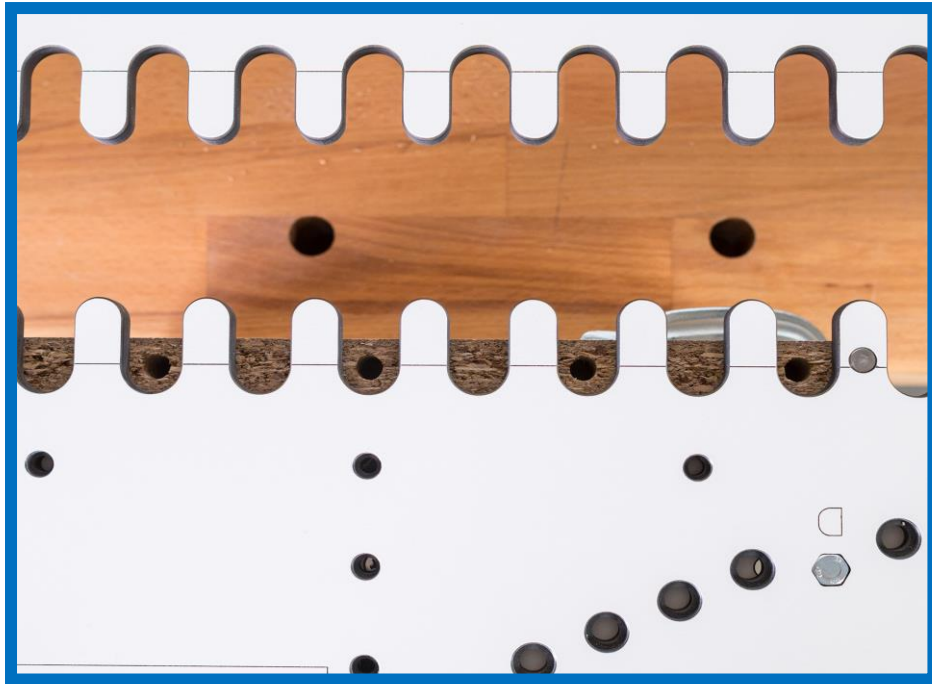


The template is fastened to the workpiece by means of two clamps from below.

Before final fixation the template must be aligned. The attachment points on the row of tines serve this purpose. First select the front edge of the workpiece (visible edge) as the stop position. .



4. Drill the row of holes on the front side. (we recommend a distance of 64 mm, every second tine)



This process is repeated on all front sides of the construction shelves.

It is important that the stop sides are always the same at the end drillings. For the surface drillings you must then use the corresponding opposite stop side. (e.g. if stop end face left = stop face right)

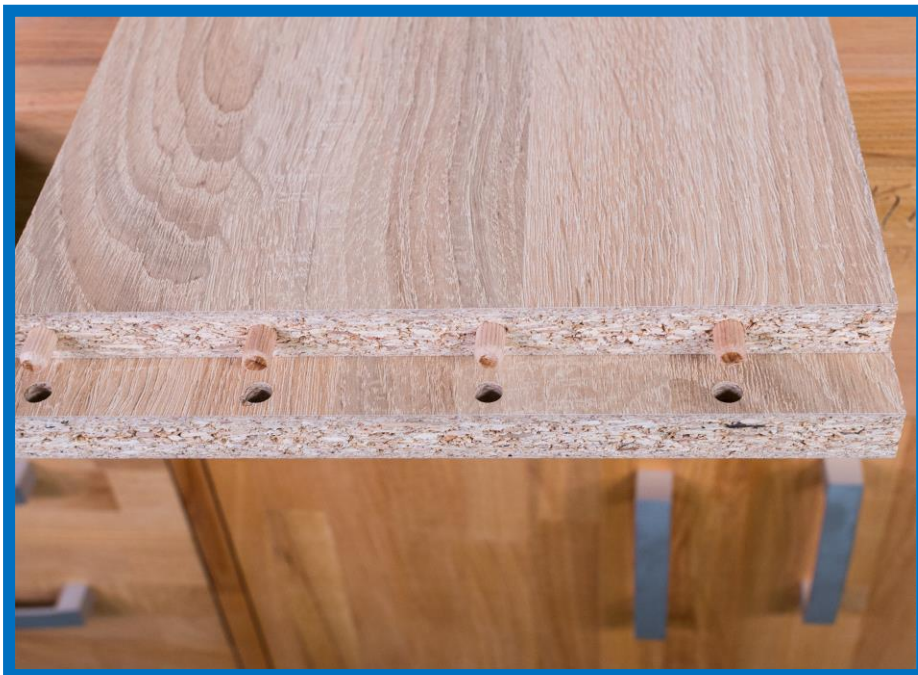


5. Drill the dowel holes

The surface drillings are also carried out with the fence attached.



In this way, the edge distance of the drill holes remains identical.



6. Now you can assemble the parts



By changing the stop positions, the connections are clearly defined.
This results in an exactly flush connection.



In 15 minutes to the finished body without visible screws!

Extra Product information for the use of

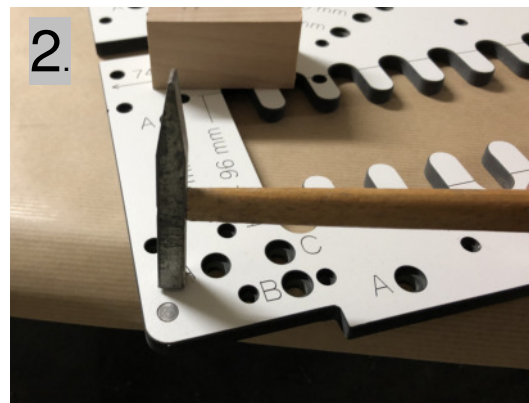
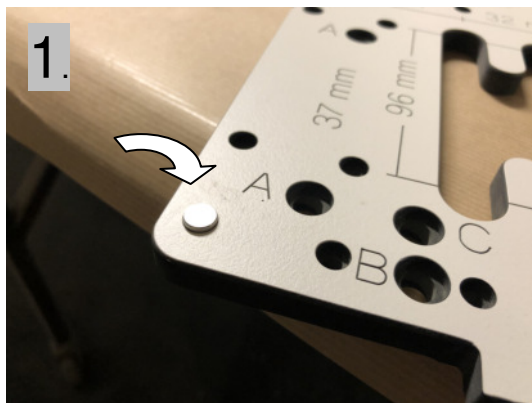
Multi-milling template MFS-3202

The MFS-3202 Multi-milling template makes it easy to produce absolutely precise holes for a wide range of applications. For this purpose, the templates are manufactured with the help of modern CNC machines with an absolutely precise fit.

Due to material and tool-related dimensional changes, it can happen that especially the smaller 5mm bolts are somewhat difficult to insert into the hole.

What to do if a bolt does not fit?

In this case it is no problem to carefully sink the bolt with a hammer, with light blows. The bolt should already be inserted as far as possible into the hole.



1. Insert bolts as far as possible
2. Sink with light hammer blows
3. Bolt sits flush a
4. Press the bolt out vertically from behind to remove it.