2.1 Design principle System 32

2.1.0 - 2.1.3

2.2 Drilling and insertion machines Blue Max mini

Range summary 2.2.1

2.3 Assembly aids, drilling jigs and hole-marking templates

Range summary 2.3.0 - 2.3.1
Design principle
System 32

· The international standard for furniture construction
· Allows for hole line and fitting and assemblies these to create a constructional unit
· Saves time and money in work preparation, production and assembly
· Ideal for production processes involving CNC, automatic drilling machines and drilling jigs

Design principle System 32
· Hole distance: 32 mm
· Drilling diameter: 5 mm
· Hole-centre distance from hole line to front edge of side: 37 mm (sealing lips, bumper etc. belong to the front edge of the side, are included in the 37 mm dimension and must be taken into account when cutting to size and drilling)
· Hole-centre distance in vertical hole lines: divisible by 32
· Beneficial:
  - The first and last drill hole in a hole line is equal from the upper and lower edge of the side
  - The distance between the rear edge of the side and rear hole line is also 37 mm

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</table>
A wide range of different fittings are mounted in System 32 hole lines:

- Cam fittings Rastex
- Cam fittings VB
- Connecting screws
- Connecting angle
- Quadro runner systems
- Roller runner systems
- Hinge systems Sensys and Intermat
- Shelf support
- Wardrobe tube bearing
- Even handles are mounted within the 32 mm hole pattern...
Hole line and connecting fitting
When processing panels ensure that:
The position of the dowel drilling in the edge of
the top and bottom panels corresponds with
the data given in the catalogue!
Example of connecting fitting VB 20:
distance = 9.5 mm

Door stop
A = distance from upper edge of door to
centre of hinge cup
B = distance from upper edge of side to centre of dowel
F = door overhang or door reveal
X = multiple of 32 mm

Formula for calculation of hinge distance:
A = B + X - 16
  9.5 + 96 - 16 = 89.5 mm
A desired door reveal F is to be subtracted.
A desired door overhang F is to be added.
### Design principle System 32

#### Example application

**Constructing a cabinet side**

\[ \begin{align*}
X / Y &= \text{multiple of 32 mm} \\
B &= \text{hole distance from side upper or lower edge to centre of dowel}
\end{align*} \]

*E.g., for 19 mm shelf thickness:*

\[ B = 9.5 \text{ mm} \]

**Calculation of cabinet side:**

- **Height** = \( X + (2 \times B) \)
- **Width** = \( Y + (2 \times 37 \text{ mm}) \)

**Example:**

- Desired height approx. 2000 mm
- Desired depth approx. 600 mm
- Connecting fitting VB
- 20 - 19 mm shelves

**Advantage to the cabinet maker:**

There is no longer any need to differentiate between a left and right unit side, since the upper and lower hole positions are identical.

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</tbody>
</table>

\[ \begin{align*}
\text{X} &= 1984 + (2 \times 9.5) = 2003 \text{ mm} \\
\text{Y} &= 512 + (2 \times 37) = 586 \text{ mm}
\end{align*} \]
Range summary

2.2 Drilling and insertion machines Blue Max mini

Drilling and insertion machine
Blue Max mini Type 3

Drilling machine
Blue Max mini Type 3 for System 32 hole line boring

Accessories
for drilling and insertion machine Blue Max mini
Drilling and insertion machines
Blue Max mini Type 3

- For drilling and inserting Sensys and Intermat hinges, mounting plates, InnoTech and MultiTech front connectors
- 6-spindle boring head with integrated drilling depth stop (13 mm pre-adjusted)
- 220 V / 60 Hz / 1-phase
- Motor power rating 1.6 kW (2.15 HP)
- Wooden worktop
- Scaled fence and 2 pendulum stops
- Pneumatic stroke movement and hold-down clamps
- Insertion unit
- Dust removal
- Including swing arm and hinge insertion die

Pre-adjusted fixed stops for fence

<table>
<thead>
<tr>
<th>Article</th>
<th>Drilling pattern for hinge cup</th>
<th>Order no.</th>
<th>PU</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blue Max mini Type 3 220 V / 60 Hz / 1-phase / 1.6 kW (2.15 HP)</td>
<td>TH 53 / TH 55 FIX / T 43 / TH FIX</td>
<td>0 047 955</td>
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<td>TB 53 / TB 55 FIX / TB 43 / TB FIX</td>
<td>0 040 019</td>
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</table>

1. Hinges (cup distance 4.5 mm)
2. MultiTech front connector (14.5 mm overlay on cabinet side panel)
3. Mounting plates and InnoTech front connectors (14.5 mm overlay on cabinet side panel)
- For drilling of hole line System 32
- 7-spindle boring head
- 220V / 60Hz / 1-phase
- Motor power rating 1.6 kW (2.15 HP)
- Wooden worktop
- Pneumatic stroke movement
- Foot pedal
- Fixed stops
- Dust removal

Order no. 0 047 957

1
Accessories for drilling and insertion machine Blue Max mini

2 quick clamping levers for adjusting fence

<table>
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<tr>
<th>Order no.</th>
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<tbody>
<tr>
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Pendulum stop for fence
- Right-hand / left-hand

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<td>0061285</td>
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Tilt stop for fence

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<tr>
<td>Left</td>
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Pendulum-stop system Maxi Stop
- Versatile

<table>
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<tbody>
<tr>
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Working with “Maxi Stop” using the example of a MultiTech drawer-front connector

Blue stop
MultiTech height 86

Green stop:
MultiTech height 118

Yellow stop:
MultiTech height 150

Red stop:
MultiTech height 214
Solid tungsten carbide tipped drill bits
- For less drilling effort
- Easily resharpened
- Enhanced drill-bit rigidity and stability
- Drilling direction marked in colour, right = black, left = orange
- Length 57 mm
- Shaft diameter 10 mm

Insertion dies

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<tr>
<th>Insertion die for</th>
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<tbody>
<tr>
<td>Hinge range Sensys</td>
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<td>Hinge range Intermat</td>
<td>0 061 355</td>
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<tr>
<td>Knock-in System 9000 InLine mounting plate</td>
<td>0 046 626</td>
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<tr>
<td>Connecting fittings VB 35 / 36</td>
<td>0 072 148</td>
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<td>Connecting fittings VB 36</td>
<td>0 068 637</td>
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<tr>
<td>Drawer front connectors MultiTech</td>
<td>0 040 129</td>
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Dust chuck plug
- For standard machine chuck

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<tr>
<td>0 076 497</td>
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Fence extension
- Length 1500 mm
- With scale
- Right-hand / left-hand

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<td>0 061 266</td>
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Set of fixed stops
- For fence fixed positions

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<td>0 072 151</td>
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Diameter | Order no. right | Order no. left | PU |
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### Assembly aids for drawers

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<th>MultiFit Pro</th>
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<td>2.3.4 - 2.3.5</td>
<td>2.3.6 - 2.3.7</td>
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<tr>
<td><strong>Brief description</strong></td>
<td>Transportable</td>
<td>Stationary</td>
<td>Stationary</td>
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<tr>
<td><strong>Suitable for mounting</strong></td>
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<td>MultiTech</td>
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<td>drawers and pot-and-pan drawers</td>
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### Versatile drilling jigs

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<th>MultiBlue</th>
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<td>2.3.24 - 2.3.25</td>
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<tr>
<td><strong>Brief description</strong></td>
<td>Ruler drilling jig</td>
<td>Ruler drilling jig</td>
<td>Small, versatile</td>
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<tr>
<td><strong>Suitable for mounting</strong></td>
<td>· Fittings in System 32</td>
<td>· Fittings in System 32</td>
<td>· Connecting fittings Rastex and VB</td>
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<td>· Hinges and mounting plates</td>
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<td>· Handles and knobs</td>
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<td>· Shelf supports</td>
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# Drilling jigs and assembly aids

## Range summary / Technical comparison

### Drilling jigs and assembly aids for fitting front panels

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<tr>
<th>Practica</th>
<th>BlueJig FB</th>
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<td>Suitable for mounting</td>
<td>Front panels / fronts of · InnoTech drawers · MultiTech drawers</td>
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### Drilling jigs and assembly aids for mounting hinges

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<th>DrillJig hinge</th>
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### Drilling jigs and assembly aids for mounting connecting fittings

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<tr>
<th>BlueJig Dowel</th>
<th>DrillJig VB</th>
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<td>Suitable for mounting</td>
<td>· Steel dowels for Rastex connecting fittings</td>
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### Drilling jigs and assembly aids for mounting handles and runners

<table>
<thead>
<tr>
<th>BlueJig for handles</th>
<th>BlueJig Quadro EB 20 Start</th>
<th>BlueJig FR / MultiTech</th>
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<tbody>
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<td>2.3.37</td>
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<tr>
<td>Suitable for mounting</td>
<td>· Handles and knobs</td>
<td>· Quadro runners to wooden drawers</td>
</tr>
</tbody>
</table>
Assembly aid for InnoTech drawers
InnoFit Start

- For assembling InnoTech drawers
- For all drawers widths from 275 to 1200 mm and depths of 260, 300, 350, 420, 470, 520 and 620 mm
- Lightweight polystyrene elements protect the drawer components from damage
- Quickly set up and dismantled, easily transported for assembly on site

<table>
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Setting up

Position assembly aid on workbench with stops against bench edge and fix in place on left hand side.

The right-hand profile mount can be re-positioned. The ruler marks cabinet nominal dimensions.
Assembly

1. Insert profile into assembly aid
2. Insert base between profiles
3. Position profiles so that outer sides rest against stop
4. Insert rear panel and slide base up against rear panel
5. Screw components in place or knock in pins. Remove finished drawer.

Tool for knocking in pins
· For assembling InnoTech

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<tbody>
<tr>
<td>0 078 091</td>
<td>1</td>
</tr>
</tbody>
</table>
Assembly aid for InnoTech drawers
InnoFit Pro

- For assembling InnoTech drawers and pot-and-pan drawers
- Quickly set using latch levers for:
  - Drawer widths of 275 mm and 300 to 1200 mm in 50 mm increments
  - Drawer depths of 260, 300, 350, 420, 470, 520 and 620 mm
  - Rear-panel heights of 70, 144 and 176 mm
- Also for customized drawer widths
- Sturdy aluminium frame

<table>
<thead>
<tr>
<th>Order no.</th>
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<tbody>
<tr>
<td>0041 777</td>
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</tr>
</tbody>
</table>

Assembly

- Setting rear-panel height
  With latch levers for rear-panel heights of 70, 144 and 176 mm

- Setting customized drawer width
  Setting on ruler using cut width of base

- Setting drawer depth
  With latch levers for nominal lengths of 260, 300, 350, 420, 470, 520 and 620 mm

- Setting standard drawer width
  With latch levers for cabinet widths of 275 mm and 300 to 1200 mm in 50 mm increments
Assembly aid for InnoTech drawers
InnoFit Pro

Assembly

1. Insert base into assembly aid, inside facing down
2. Insert profile into assembly aid
3. Clip rear panel into receiver on profiles
4. Pull profiles and rear panel down in one piece
5. Clamp profiles
6. Screw components in place or knock in pins. Remove finished drawer.

Tool for knocking in pins
· For assembling InnoTech

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<tr>
<th>Order no.</th>
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<tbody>
<tr>
<td>0 078 091</td>
<td>1</td>
</tr>
</tbody>
</table>
Assembly aid for MultiTech drawers

MultiFit Pro

- For assembling MultiTech drawers and pot-and-pan drawers
- Quickly set using latch levers for:
  - Drawer widths of 275 mm and 300 to 900 mm in 50 mm increments
  - Drawer depths of 250, 275, 350, 400, 450, 500 and 550 mm
  - Rear-panel heights of 86, 118, 150 and 214 mm
- Also for customized drawer widths
- Sturdy aluminium frame

<table>
<thead>
<tr>
<th>Order no.</th>
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<tbody>
<tr>
<td>9 079 392</td>
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</tbody>
</table>

Assembly

Setting drawer depth
With latch levers for nominal lengths of 250, 275, 400, 450, 500 and 550 mm

Setting standard drawer width
With latch levers for carcass widths of 275 mm and 300 to 900 mm in 50 mm increments

Setting customized drawer width
Setting on ruler using cut width of base

Setting rear-panel height
With latch levers for rear-panel heights of 86, 118, 150 and 214 mm

Drilling jigs and assembly aids

www.hettich.ca
Assembly aid for MultiTech drawers

**MultiFit Pro**

1. Insert rear panel into receiver
2. Insert base into assembly aid, inside facing down
3. Insert profile into assembly aid
4. Clamp profiles
5. Screw profiles to rear panel and base.

Remove finished drawer.
Drilling jig Accura

1. Accura rail with measurement scale
2. Accura drilling template for hinges / mounting plates
3. Centre punch
4. Accura drilling template for handle collection ProDecor
5. Accura drilling template for runner systems
6. Marking pin for cup drillings
7. Viewing window for measurement scale
8. Bolt
9. Marking pin for hole lines
10. Drilling jig Accura for System 32
11. Adjustable stop for assembled cabinet
12. Adjustable stop for individual (un-assembled) cabinet sides
Drilling jigs and assembly aids

- Modular-system drilling jig
- Versatile
- Efficient, economical and professional

**Accura drilling templates for hinges / mounting plates**
are suitable for:
- The Sensys and Intermat series of hinges
- Mounting plates System 8099 / 9000 – Sensys, Intermat
- System 32, hole line drillings
- For overlay and inset doors

**The Accura drilling template for handles and knobs can be used with:**
- Handles with two or three bases with hole spacing 64 mm or greater
- Furniture knobs

**Further functional advantages:**
- Drilling template and rail made of aluminium
- Sleeve drill – minimal bit wear, because the bit is not in direct contact with the jig
- Stops can be used on left and right
- Easy adjustment of the drilling template and stops by means of clamping screws
- Rail with measurement scale
- Simple measurement determination via viewing window in drilling template

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<table>
<thead>
<tr>
<th>Article</th>
<th>Order no.</th>
<th>PU</th>
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<tbody>
<tr>
<td>1 Accura rail with measurement scale, Aluminium Length 1000 mm</td>
<td>0 070 263</td>
<td>1</td>
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<tr>
<td>Length 2000 mm</td>
<td>0 020 014</td>
<td>1</td>
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<tr>
<td>2 Accura drilling template for hinges / mounting plates with centre punch and cup pattern, aluminium / plastic</td>
<td>0 013 841</td>
<td>1 set</td>
</tr>
<tr>
<td>3 Accura drilling template for handles and knobs, aluminium / plastic</td>
<td>0 044 765</td>
<td>1</td>
</tr>
<tr>
<td>Replacement slide rail with drilling bushes for Accura drilling templates for handles and knobs</td>
<td>0 044 767</td>
<td>1</td>
</tr>
<tr>
<td>4 Accura drilling template for runner systems aluminium / plastic</td>
<td>0 070 265</td>
<td>1</td>
</tr>
<tr>
<td>5 Additional centre punch</td>
<td>0 023 680</td>
<td>1</td>
</tr>
<tr>
<td>6 Adjustable stop for assembled cabinet, plastic</td>
<td>0 070 267</td>
<td>1</td>
</tr>
<tr>
<td>7 Adjustable stop for individual (un-assembled) cabinet sides, plastic</td>
<td>0 070 266</td>
<td>1</td>
</tr>
<tr>
<td>8 Sleeve drill ø 3 mm</td>
<td>0 078 095</td>
<td>1</td>
</tr>
<tr>
<td>Spare drill ø 3 mm without sleeve</td>
<td>0 079 004</td>
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</tr>
<tr>
<td>Sleeve drill ø 5 mm</td>
<td>0 070 268</td>
<td>1</td>
</tr>
<tr>
<td>Spare drill ø 5 mm without sleeve</td>
<td>0 070 269</td>
<td>1</td>
</tr>
<tr>
<td>Sleeve drill ø 8 mm</td>
<td>0 046 084</td>
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</tr>
<tr>
<td>Spare drill ø 8 mm without sleeve</td>
<td>0 046 628</td>
<td>1</td>
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<tr>
<td>Sleeve drill ø 10 mm</td>
<td>0 078 096</td>
<td>1</td>
</tr>
<tr>
<td>Spare drill ø 10 mm without sleeve</td>
<td>0 079 005</td>
<td>1</td>
</tr>
<tr>
<td>9 Measuring pin for Accura drilling template for guide components</td>
<td>0 046 629</td>
<td>1</td>
</tr>
<tr>
<td>10 Accura drilling template 1000 mm, aluminium with 3 stop pins / marking pins</td>
<td>0 010 573</td>
<td>1</td>
</tr>
</tbody>
</table>
Drilling jig Accura
for hinges / mounting plates

Hole pattern for System 8099 / 9000
cross-mounting plates for Sensys and Intermat
hinge series (overlay doors)

Hole pattern for System 8099 / 9000
cross-mounting plates for Sensys and Intermat
hinge series (inset doors)

Punching positions for automatic hinges
of the Sensys and Intermat product series,
for cup diameter 35 mm and cup distance
C = 4,5 mm

Punching positions for automatic hinges,
for cup diameter 26 mm
and cup distance C = 3,5 mm

Drilling positions for
System 32 hole lines
Drilling jig Accura for hinges / mounting plates

1. Align the drilling template and adjustable stop. Using the centre punch, mark and start the holes for the relevant hinge type. Drill the cup holes for the hinges.

2. Determine the hinge spacing using the cup pattern. The desired reveal can be set by sliding the adjustable stops with reference to the scale on the rail.

3. Remove cup pattern and position the drilling template as required in the cabinet. Directly drill the holes for the mounting plates with the sleeve drills.
Drilling jig Accura
for handles / knobs

- Accura drilling template set for handles with hole spacing 64 mm or greater and knobs

Set contains:
2 Accura drilling templates for handles with hole spacing 64 mm or greater and knobs
2 drill plates with guide sleeve for 5 mm high-powered high-speed steel twist drill (HSS)
1 Accura slide rail with measuring scale in mm and inch, length 500 mm
1 adjustable stop for front edge alignment

<table>
<thead>
<tr>
<th>Article</th>
<th>Order no.</th>
<th>PU</th>
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</thead>
<tbody>
<tr>
<td>Accura drilling template set for handles and knobs</td>
<td>0 044 763</td>
<td>1 set</td>
</tr>
<tr>
<td>Replacement slide with drilling bush for Accura drilling jig for handles and knobs</td>
<td>0 044 767</td>
<td>1</td>
</tr>
</tbody>
</table>

Handles with two bases
centred or positioned as desired

1. Set up drilling template
   1. Adjust hole spacing
   2. Adjust handle to front distance
   3. Check hole spacing using feeler gauge

2. Drill holes

3. Screw on handle
Drilling jig Accura for handles / knobs

Handles with three bases centred or positioned as desired

1. Set up drilling template
2. Adjust hole spacing
3. Adjust handle to front distance
4. Use measuring components to check hole spacing

Drill holes

3. Screw on handle

Two handles aligned symmetrically

1. Set up drilling template
2. Adjust hole spacing
3. Adjust handle to front distance
4. Use measuring components to check hole spacing

2. Drill holes

1. Drill holes for first handle
2. Turn drilling jig over
3. Drill holes for second handle

3. Screw on handles
Drilling positions for
- Quadro slide-on technology
- Roller runner systems FR
- Ball-bearing slides KA
1. The drilling template and adjustable stop are placed on the bottom panel, thereby permitting interchangeability between the Quadro 30 partial extension and Quadro V6 full extension runner whilst maintaining the same position for the drawer / front panel.

2. The adjustable stop is fixed “flush” with the rail: using the inspection window, you can read off the exact screw-on positions for the individual runner systems from the rail scale.

3. Position of universal drilling template system on individual, un-assembled cabinet sides.
Drilling template Accura for System 32 hole line

Enables you to drill a hole line in System 32, economically and expertly.

**Applications**
- Hole line spaced 37 mm from front edge
- Hole line at a distance of 13 mm from the front edge
- Drilling the first hole line for connecting fittings (for 16 mm and 19 mm panel thickness)
- Stop for continuing hole line
- Stop for rear hole line in assembled cabinet

**Practical advantages:**
- Drilling template in aluminium
- Sleeve drill – minimum bit wear, because the bit does not come into contact with the jig
- Can be used for left and right
- Functions easily set using stop / rig pins

**Article** | **Order no.** | **PU**
--- | --- | ---
Accura drilling template 1000 mm, aluminium with 3 stop pins / marking pins | 0 010 573 | 1 set
Sleeve drill Ø 3 mm | 0 078 095 | 1
Spare drill Ø 3 mm without sleeve | 0 079 004 | 1
Sleeve drill Ø 5 mm | 0 070 268 | 1
Spare drill Ø 5 mm without sleeve | 0 070 269 | 1
Sleeve drill Ø 8 mm | 0 046 084 | 1
Spare drill Ø 8 mm without sleeve | 0 046 628 | 1
Sleeve drill Ø 10 mm | 0 078 096 | 1
Spare drill Ø 10 mm without sleeve | 0 079 005 | 1

1. Stop for front edge of cabinet side
   Hole line at distance of 37 mm from the front edge
2. Stop for bottom edge of cabinet side
   first hole line drilling at 8 mm for 16 mm panel with connecting fittings
3. Stop for bottom edge of the cabinet side
   first hole line drilling at 10 mm for 19 mm panel with connecting fittings
4. Stop for continuing the hole line.
   The pin is inserted in the last hole in the line.
5. Stop for front edge of cabinet side
   hole line at distance of 13 mm from the front edge
   (office furniture: Systema Top 2000)
6. Rear edge of drilling template for drilling the rear hole line in a ready assembled cabinet
   the distance to the back panel is 37 mm.
Drilling jig Exakta

- Practical for small furniture batches, constructing samples and contract furnishing
- For greater accuracy and rational production
- Can be used for mounting:
  - Hinges
  - Mounting plates
  - Shelf supports
  - And other fittings in System 32

The Exakta drilling template can be used also without the rail: simply fit to the workpiece with a clamp!

![Diagram of the Exakta drilling template]

<table>
<thead>
<tr>
<th>Article</th>
<th>Description</th>
<th>Order no.</th>
<th>PU</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>Rail with 2 stops</td>
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<td>1</td>
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<tr>
<td></td>
<td>1000 mm</td>
<td>0 014 826</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>Drilling template</td>
<td>0 022 617</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Centre punch</td>
<td>0 023 680</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>Adjustable stop</td>
<td>0 073 788</td>
<td>1</td>
</tr>
</tbody>
</table>
With Exakta, hole lines at a distance of 37 mm from the side front edge can be drilled directly. For this purpose, several drilling templates can be pushed closely together and drilling can be performed directly through the hardened bushes. Hole distances are 32 mm, drilling diameter 5 mm. All fittings denoted with □□□ can be mounted in the hole lines. For transfer from right to left, the Exakta can be placed in the same position on the opposite side.

... e.g. for the shelf support range
Drilling jigs and assembly aids

Drilling jig Exakta

Drilling pattern / Connecting fittings

VB 35 M
See page 8.2.8

VB 36 M
See page 8.2.9

Rastex 15
See pages 8.2.2 - 8.2.3

When using dowels with a dowel length of 30 mm (drilling dimension = dowel length + 4 mm)
Drilling jig Exakta
Cabinet assembly with cam fittings

1 Drilling cabinet sides

· Mark constructional dimensions for panels on the cabinet side
· The dimensions depend on the fitting and panel thickness
· Several drilling templates can be used for marking all drilling dimensions for height construction on the cabinet side in one operation
· Place Exakta against front edge of side, with fixed stop on lower edge of side
· Position drilling template with the locating points on the markings
· Insert drill into hardened bushes and drill directly
· Drill holes:
  - Drilling distance from front of side edge is 37 mm
  - Drilling diameter 5 mm
  - Drilling depth according to dowel dimensions

· For drilling front and rear holes. The drilling templates remain in the same position: simply position Exakta the opposite way round.
Drilling jigs and assembly aids

Cabinet assembly with cam fittings

2.3. Drilling jig Exakta

Drilling the top / bottom panels

- Align fixed stop flush with adjustable stop
- Position Exakta with the adjustable stop against the front edge of the side
- Set drilling template with pins on dowel holes and fix in place
- Transfer distances to the top and bottom panels

- Position Exakta against the panel side edge on the right or left and place the fixed or adjustable stop (for VB 35 M / 36 M and Rastex 15) on the panel front edge
- Using the centre punch, mark the drill holes for the connecting fittings through the appropriate centring holes
- Drill holes according to specified dimensions

- For transfer from right to left, simply position Exakta the other way round!
Drilling jig Exakta
Hole marking positions for hinges from the Sensys and Intermat ranges

Hole marking and drilling positions of the cross mounting plate systems 8099 / 9000 from the Sensys, Intermat and Ecomat hinge ranges

Cup diameters 35 and 26 mm can also be measured with the Exakta drilling template. ... e.g. for hinge versions
· Sensys 8645i
· Intermat 9943

Hole marking position for overlaid doors

Hole marking position for inset doors

... for the mounting plate versions
· System 8099 – Sensys hinges
· System 9000 – Intermat hinges
Drilling jig Exakta
Marking / drilling holes for hinges and mounting plates

- Position Exakta against rear edge of door, with the fixed stop against the door’s lower edge
- Using the centre punch, mark drill holes for relevant hinge type
- Drill cup holes for the hinges. Exakta always guarantees that hinges are mounted perfectly horizontally.

- If the doors are drilled first, the hinge distances can be measured by inserting the cup patterns on the drill templates into the cup holes. These can then be transferred to the cabinet side.
- Set clearance with the adjustable stop
- Position Exakta against front edge of side, with the fixed stop against the side’s lower edge
- For cross mounting plates to be fixed directly (with 5 mm pins or euroscrews), insert drill into hardened bushes and drill directly
- Mark screw holes with centre punch for all other cross mounting plates
Hole marking gauge Multi Blue

- Small and easy to use, yet multifunctional
- Simple hole-marking template: the perfect aid for on-site assembly whenever a fitting has to be mounted professionally without the use of large machinery.

The Multi Blue double-sided hole marking gauge can be used for marking out:

- System 32 hole lines for
  - Mounting plates
  - Dowels
  - Shelf supports
- Cup drillings dia. 35 and 26 with dimension C 4 mm for hinges
- Holes dia. 25 and 20 for connecting fittings

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<tr>
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</table>

Marking position for holes 32 mm apart

... e.g. for different mounting plate versions
- System 8099 (Sensys hinges)
- System 9000 (Intermat hinges)

... e.g. for
- Screw-in dowel
- End and double dowel for Rastex
- Shelf support
Hole marking positions
for cup diameter 35 mm
and cup distance C = 4 mm

... e.g. for hinge versions
- Sensys
- Intermat

Hole marking positions
for hole ø 20 mm

... e.g. for connecting fittings
- VB 35 M
The Practica drawer front template provides a safe and simple method of installing front panel fixings.

The side overlay and height of the front panel are adjustable.

The system contains three elements:
- Practica angle stopper
- Practica drilling template
- Sleeve drill

Suitable for drilling:
- InnoTech drawer systems
- MultiTech drawer systems
Practica angle stopper
for combining with Practica drilling templates for
- InnoTech drawer System
- MultiTech drawer system
- Material: Aluminium

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<tr>
<td>0 078 093</td>
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</table>

Sleeve drill
- Bit wear is minimized, as the bits do not come into contact with the template
- Sleeve for precise drill guidance
- Adjustable drilling depth stop

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<thead>
<tr>
<th>Article</th>
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<tbody>
<tr>
<td>Sleeve drill ø 3 mm</td>
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<tr>
<td>Spare drill ø 3 mm, without sleeve</td>
<td>0 079 004</td>
<td>1</td>
</tr>
<tr>
<td>Sleeve drill ø 5 mm</td>
<td>0 070 268</td>
<td>1</td>
</tr>
<tr>
<td>Spare drill ø 5 mm, without sleeve</td>
<td>0 070 269</td>
<td>1</td>
</tr>
<tr>
<td>Sleeve drill ø 8 mm</td>
<td>0 046 084</td>
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<tr>
<td>Spare drill ø 8 mm, without sleeve</td>
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</tr>
<tr>
<td>Sleeve drill ø 10 mm</td>
<td>0 078 096</td>
<td>1</td>
</tr>
<tr>
<td>Spare drill ø 10 mm, without sleeve</td>
<td>0 079 005</td>
<td>1</td>
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</table>

Practica drilling template
InnoTech drawer system
For installing the front panel fixings for
- InnoTech drawer
- InnoTech pot-and-pan drawer
- InnoTech pot-and-pan drawer with 2nd railing level

Range of adjustment
- Side overlay of front panel:
  up to −6 mm to +20 mm
- Front panel height:
  from bottom edge of bottom panel
  up to +35 mm
- Material: Aluminium

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<tbody>
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</table>
Practica drilling template
MultiTech drawer system
For installing the front panel fixings for
- MultiTech drawer
  Height 54, 86, 118, 150 and 214 mm
- MultiTech pot-and-pan drawer

Range of adjustment
- Side overlay of front panel: up to +20 mm
- Front panel height:
  from bottom edge of bottom panel
  up to +35 mm
- Material: Aluminium

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</table>
**Drilling jigs and assembly aids BlueJig FB for drawer-front connectors**

**Drilling template BlueJig**
- For InnoTech / MultiTech railing
- Aluminium / steel

**Order no.** | **PU** | **1 set**
--- | --- | ---
0048437 | | 

**Drilling template BlueJig IT**
- For InnoTech front panels
- Plastic / steel

**Order no.** | **PU** | **1 set**
--- | --- | ---
0078097 | | 

**Drilling template BlueJig MT**
- For MultiTech front panels
- Plastic / steel

**Order no.** | **PU** | **1 set**
--- | --- | ---
0051425 | | 

**Mounting tool**
- For knock-in assembly of MultiTech front connectors or Sensys Inline mounting plates

**Article** | **Order no.** | **PU**
--- | --- | ---
1 Suitable for all front connectors MultiTech 86 / 118 / 150 / 214 | 0040133 | 1
2 For Sensys Inline mounting plate | 9102188 | 1
Drilling jig DrillJig hinge

DrillJig hinge

Hinge installation made easy: with a standard commercially available power drill and the DrillJig hinge, Hettich hole patterns can be made everywhere – simply, rationally and precisely.

Regardless whether you are retrofitting doors on pre-installed shelves or blind panels, for individual or special applications, the DrillJig hinge eliminates the need for unprofitable and time-consuming machine adjustment – simply drill and fit, and that's it.

- Precise and clean hole drilling for hinges and mounting plates
- Angled, precise drilling with tungsten carbide tipped drill bits
- No "runaway" of the drill bit when cut-drilling half-moon holes
- Commercially available power drills, 230 V / min. 350 W or cordless screwdriver, min. 9,6 V

The following hinge and mounting plate ranges can be processed with the Hettich DrillJig hinge:

- Sensys
- Intermat
- Seleka Pro 2000
- Mounting plate series System 8099 (Sensys)
- Mounting plate series System 9000 (Intermat)

The DrillJig hinge set contains:
1 drilling template for hinges
1 drilling template for mounting plates
1 hexagonal driver
1 drill bit, ø 35 mm installed
2 drill bit, ø 10 mm installed

Drill bits

<table>
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<tbody>
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Accessories / Replacement parts

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<tr>
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<tbody>
<tr>
<td>1 Drill bits ø 35 mm</td>
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<td>2 Drill bits ø 10 mm</td>
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<td>2a Drill bits ø 2,5 mm</td>
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<tr>
<td>3 Hexagonal follower</td>
<td>0020695</td>
<td>1</td>
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<tr>
<td>4 Allen screw M8 x 16 DIN 912</td>
<td>0020689</td>
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<tr>
<td>5 Washer 8,4 DIN 125</td>
<td>upon request</td>
<td></td>
</tr>
<tr>
<td>6 Sleeve</td>
<td>upon request</td>
<td></td>
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<tr>
<td>7 Spring</td>
<td>upon request</td>
<td></td>
</tr>
<tr>
<td>8 Washer 12x18x0,5 DIN 988</td>
<td>upon request</td>
<td></td>
</tr>
</tbody>
</table>
Hinge and mounting plate fixing holes

The door overlay on the top or bottom panel can be precisely marked on the scale:
Overlay for "overlay door": up to +24 mm
Reveal for "inset door": up to -3 mm

Hole dimensions

**T43 / TH Fix**
Sensys, Intermat

**T42**
Sensys, Intermat

**T22 / 9**
Selekta Pro 2000

Variable "C" setting: from min. 2 to max. 8
Scale point E: template setting for Selekt Pro 2000.
Positioning aid for DrillJig hinge

- For inserting into mounting-plate drill holes or System 32 hole lines
- Facilitates the positioning of hinge cup holes, also in conjunction with retrofitting doors
- DrillJig hinge drilling jig can be simply positioned against the line marker for drilling the cup hole

Order no. | PU
---|---
9 078 866 | 1

• For inserting into mounting-plate drill holes or System 32 hole lines
• Facilitates the positioning of hinge cup holes, also in conjunction with retrofitting doors
• DrillJig hinge drilling jig can be simply positioned against the line marker for drilling the cup hole

www.hettich.ca
Drilling jig BlueJig dowel
for drilling dowel holes

- For end-face drill holes for mounting steel dowels:
  - Rastex 15 with dowel stem size of 20 mm = hole size 24 mm
  - Rastex 15 with dowel stem size of 30 mm = hole size 34 mm
- Practical positioning of drilling jig in relation to existing Rastex holes
  by means of 2 marking pins, 15 and 25 mm diameters
- With spacers for panel thicknesses of 15 / 16, 18 / 19 and 21 / 22 mm
- Designed for combination drilling with wood dowel
- Plastic with hardened drilling bushes in steel

Order no. PU
9 079 402 1

Drilling bushes
8 mm dia., for additional wooden dowels
Drilling bush
8 mm dia., for steel dowel

Thread for mounting marking pin
for 20 mm dowel length
Thread for mounting marking pin
for 30 mm dowel length

Cup pattern Rastex 25
Cup pattern Rastex 15

Spacers
for centring the drilling jig on different panel thicknesses
Drilling jig DrillJig VB

All you need for rapid, rational, simple and at the same time precise installation of Hettich connecting fittings is the DrillJig VB drilling jig and a standard commercially available power drill.

- For retrofitting structural shelves and panels
- Single or special production
- Precise, clean and also angled holes
- Tungsten carbide tipped bits
- No "runaway" of the drill bit when cut-drilling half-moon holes
- Holes spaced at regular 32 mm intervals
- Fixed end stop at 37 mm (= distance between hole line and front side edge)
- Drilling diameter 5 mm
- For wood thickness of 16 / 19 and 22 mm
- Commercially available power drills, 230 V / min. 350 W or cordless screwdriver, min. 9,6 V

Drill-Jig VB can be used with:
- Connecting fittings
  - VB 35 M / 36 M

The DrillJig VB contains:
1 drilling template for VB connecting fittings
1 drilling template for dowels
1 drill bit ø 10 mm, fitted
1 drill bit ø 20 mm, fitted for VB 35 M / 36 M
1 hexagonal driver

Order no.  PU
0020166 1 set

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<td>20 mm dia. drill bit for VB 35 M, VB 36 M</td>
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<td>Allen screw M8 x 16 DIN 912</td>
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<td>Washer 8,4 DIN 125</td>
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<td>Sleeve</td>
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<tr>
<td>Washer 12 x 18 x 1,2 DIN 988</td>
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<tr>
<td>Washer 12 x 18 x 0,5 DIN 988</td>
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Holes for connecting fittings and associated steel dowels

Drilling jig DrillJig VB

Hole centre spacing: 8-11.5 mm in increments of 0.5 mm

Drill depth setting: 12-17 mm in increments of 1 mm
Handle marking jig BlueJig for handles and knobs

- Reversible, two-dimensionally adjustable marking jig
- For marking drilling positions in System 32 for
  - Handles (hole spacing of 32 - 320 mm)
  - Knobs

Range of adjustment:
- Distance from drawer front side edge
to first fixing hole of handle 10 - 334 mm
- Distance from drawer front top / bottom edge
to position of handle 20 - 65 mm

Order no. PU

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Assembly

1. Set drilling jig and mark drill hole positions

2. Drill fixing holes

3. Screw on handle
Drilling jig BlueJig Quadro EB 20 Start
· Helpful for fitting Quadro runners to wooden drawer
· Position the drilling (6 mm) of the Quadro hook for the fixing of runner to the drawer back panel
· Allows for the marking of the drilling positions of rear brackets for drawers or shelves with flush bottoms
· Plastic with hardened, steel bushings

Order no. PU
9 084 515 1

Mounting jig BlueJig FR / MultiTech for FR and MultiTech cabinet runners
· For fast, precision mounting of FR and MultiTech cabinet runners
· Can be used with System 32 hole lines or for direct fixing

Order no. PU
1 008 289 1