Here's the perfect computer desk for people who like lots of space. The top is not only large, it wraps around you providing a convenient surface to rest your elbows while you work. It's made of oak veneered plywood with a small amount of solid oak for the lap drawer and trim. Plus, it's an easy project. Check out these features:

- Convenient lap drawer.
- Plenty of space below for the CPU tower and a large chair.
- A swivel caster on the rear leg for easy positioning in a corner.
- Easily disassembles for moving.
- The top measures 48" by 48" and the height is 30".
- Four Drawer Cabinet may be placed on either side.

Tools You Will Need: Table Saw, Drill, Pocket Hole Jig, Router
Corner Computer Desk

Materials You Will Need

One sheet of ¾” oak veneer plywood ................................................................. see cutout diagram.
Less than 1/4 sheet of ¼” Oak Veneer Plywood or other material ....................... drawer sides and back.
Less than 1/4 sheet of ¼” hardboard or thinner material ................................. drawer bottom.
One 5 ½” by 6” by ¾” solid oak board ............................................................... for the drawer front & stiffeners C, & edge trim.
One sets of 18” drawer slides (may be closer to 17 ¾”) ................................. available in hardware stores.
Box of 100 pocket hole face frame screws 1 ¼” ................................................. (you’ll need about 65)
Seven Hex head bolts with flat washers, & lock washers .............................. (1/4” by 20 threads per inch).
Seven T-Nuts .................................................................................................. (1/4” by 20 threads per inch).

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Cut an opening from the rear corner as shown to the left. This opening is for computer cables. (This opening is optional. If you prefer, you can leave the corner square.)
End Panel
(2 Required)
Make all Edge Trim pieces from solid oak 3/4” wide by 1/8” thick.

Note: The red circle are to pinit out corners tha require miter cuts
Cut a 3/4" by 3" section from M. This provides clearance for Gusset B.

The length of Leg sections M & N are given as 26". This based on the wheel being 2 1/2" from the floor to the top of the mounting plate. If your wheel is a little higher, you need to subtract the difference from the lengths of sections M & N. The total length of the leg and wheel must be 29 1/4".

Example: If your wheel is 2 9/16" high, you should make M & N 1/16" shorter than 26". Remove the difference from the bottoms of M & N.
The Drawer Front is made of 3/4" thick solid oak.

The Drawer Sides are made of 1/2" thick material of your choice.

The Drawer Back is made of 1/2" thick material of your choice.

The Drawer Bottom may be made of 1/4" thick material or thinner if you choose.
Note: Parts "C" are made of solid hardwood. You can use veneered plywood but you will need to make them 1/8" shorter and cover the exposed end with 1/8" thick trim as you did with the exposed edges on the top. The end you cut at 45° will NOT be exposed.

Note: Parts "C", "D", & "E" require a 45° angle on one end!
G, H, & I - (8 Required)

B - (1 Required)

G & L - (2 Required)
Drill pocket holes in stiffeners according to the drawings below.

In addition to the pocket holes, drill two 5/16" dia. holes through Stiffener "J" as shown above.

Stiffeners "A", "D", and "F" have pocket holes on both sides.
Drill and countersink holes for #6 flathead screws in the ends of the Stiffeners A as shown in the drawings below. Note that the holes in the left and right stiffeners have the holes in different positions from the top and bottom. This is so the screws will not interfere with each other when attaching them to the Corner Gusset B.

Position the stiffener with the pocket holes down when determining the position of these holes.
Drill and countersink three 9/64" holes in the End Panel Mounts as shown below. These will be used to attach the End Panel Mounts to the End Panels.

Turn the End panel mount over and drill two 3/4" diameter by 1/8" deep flat bottom holes in back side of each End Panel Mount as shown below. T-Nuts will be used in these holes so they need to be drilled with a bit that leaves a flat bottom. A forstner, brad point, or spade type bit will work. The reason for the 1/8" depth is so the T-Nut will be recessed below the surface of the wood.

Next, drill a 5/16" diameter hole completely through the center of each of the 3/4" holes you just drilled. These are for the threaded section of the T-Nuts.

Place a T-Nut in each hole and tap with a hammer to make marks where the teeth contact the wood. Then, drill a 1/8" dia. hole about 3/8" deep for each tooth. Apply some glue to each tooth and insert the T-Nuts in place. Insert a 1/4" bolt with a flat washer through the Leg Mount and tighten it to draw the T-Nuts fully into place. (This ensures the T-Nut is aligned correctly.) Remove the bolt. The back side of the End Panel Mount should look like the drawing to the right.
Six gussets are required for re-enforcing the End Panel Stiffeners. The hole arrangement differs depending on the mounting location of each. You'll see what I mean when you view the drawing for attaching these gussets to the Top.

Drill two 9/64" holes in Gussets "I" for mounting to their respective stiffeners with 1 1/4" #6 screws. If you use flathead screws, you should countersink these holes. A single pocket hole is required for each gusset for securing it to the End Panel Stillener. Drill the pocket hole 3/4" from the top. **Note that the pocket hole is on the left for Gussets "I".**

Drill a pocket hole and two 9/64" holes in Gussets "G" as with Gussets "I". **Note that the pocket hole is on the right for Gussets "G".**

Gussets "H" will be mounted to the top between Gussets "G" and "I" and also beside the Leg Mount. These are mounted to the Top with two pocket hole screws and to The Stiffeners with a single screw like Gussets "I" and "G".
Drill and countersink three 9/64” holes in the Leg Mount as shown to the right. These will be used to attach the Leg Mount to the Top.

Turn the Leg Mount over and drill three 3/4” diameter by 1/8” deep flat bottom holes in back side. T-Nuts will be used in these holes so they need to be drilled with a bit that leaves a flat bottom. A forstner, brad point, or spade type bit will work. The reason for the 1/8” depth is so the T-Nut will be recessed below the surface of the wood.

Next, drill a 5/16” diameter hole completely through the center of each of the 3/4” holes you just drilled. These are for the threaded section of the T-Nuts.

Place a T-Nut in each hole and tap with a hammer to make marks where the teeth contact the wood. Then, drill a 1/8” dia. hole about 3/8” deep for each tooth. Apply some glue to each tooth and insert the T-Nuts in place. Insert a 1/4” bolt with a flat washer through the Leg Mount and tighten it to draw the T-Nuts fully into place. (This ensures the T-Nut is aligned correctly.) Remove the bolt. The back side of the Leg Mount should look like the drawing to the right.
Drill and countersink two 9/64" holes through foot "O" as shown below.

Drill three 5/16" holes through L as shown below.

Drill four pocket holes in N as shown to the right.

Drill and countersink two 9/64" holes through Leg Section "N" as shown below.

Drill and countersink two 9/64" holes through Leg Section "M" as shown above.

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Apply contact cement to the mating surfaces of the Top and Edge Trim and allow it to dry as per the instruction on the container. When the contact cement is dry, attach the edge trim to the edges of the Top as shown in the drawings below. Be sure it is positioned correctly the first time. It will be very difficult to remove the trim without damaging it after it is pressed in place.

First, carefully position the Front Edge trim so it is flush with the top and bottom surfaces of the Top and is lined up correctly in the corners. When it is positioned correctly, press it against the Top with your fingers.

Next, carefully attach the two pieces of Front Edge trim and press them in place. Then, attach the two pieces of End Edge trim and press them in place. Finally, use a roller or edge clamp to apply pressure along the length of all the trim.
Choose the side with the best looking grain and attach the End Panel Edge Trim to the side as shown above with contact cement as you did with the top trim. This will be the left End panel.

Again, choose the best looking side and attach the End Panel Edge Trim to the second End panel with contact cement as shown above. This will be the Right End panel.
Using a 1/8” radius roundover bit, round over the indicated edges on the Top, The End Panels, Stiffeners C, and the Drawer Front.

Round over both the top and bottom edges of the Top on the indicated edges. (These are the edges that have the 1/8” thick edge trim.)

Round over both the top and bottom edges of the End Panels on the indicated edges. (These are the edges that have the 1/8” thick edge trim.)

Round over only the bottom edges of pieces C.

Round over all four front edges of the Drawer front.
Apply glue to mating surfaces and position the Left and Right Stiffeners "A" to the underside of the Top as shown in the drawings below. Secure with pocket hole screws. Remember, there are pocket holes on both sides of each Stiffener "A".

Apply glue to mating surfaces and attach Gusset "B" to the inside corner of the Stiffeners with 1 1/4" #6 flathead screws as shown above.

**Top View**

**NOTICE!** The stiffeners go on the bottom! Determine which side of the plywood has the most attractive grain and use the least attractive side for the bottom. **Do not over tighten screws!**
Apply glue to mating surfaces and assemble stiffeners C, D, and E as shown below. Secure with 1 1/4" #6 screws.

Mount a drawer slide on each piece D as shown above and secure with the screws provided with the slide. Self closing drawer slides typically have a slope starting about 2 1/2" from the end. Make sure the straight portion of the slide is 1/4" from the bottom of piece D.
Apply glue to mating surfaces and position the pre-assembled stiffeners C, D, and E to the underside of the Top as shown in the drawings below. Secure with pocket hole screws.

Next, apply glue and position stiffener F as show in the drawings and secure with pocket hole screws. Remember, there are pocket holes on both sides of each stiffeners D and F.
Apply glue to mating surfaces and position the Stiffeners G, H, and I to the underside of the Top as shown in the drawings below.

G and I are secured to Stiffeners C and A with 1 1/4" #6 screws.
H is secured to the Top with pocket hole screws.
Apply glue to mating surfaces where stiffeners J contact stiffeners G, H, and I and the underside of the Top as shown. Secure the stiffeners J with pocket hole screws.
Apply glue to mating surfaces and attach the End Panel Mounts to the End Panels with 1 1/4" #6 flathead screws.
Apply glue to mating surfaces and attach the leg sections M and N with pocket hole screws as shown below.
Place the assembled pieces M & N on a flat surface as shown above and place piece K in the inside corner. **Do not apply glue to K.** It is only being used to establish the correct position of piece L.

Insert piece L fully into the corner as shown above (pocket holes down). While holding the pieces in place, insert the nail through each screw hole and tap with a hammer to mark the position of the pilot holes.

Drill four 7/64" pilot holes about 1/2" deep in the edges of section L using the points you made with the nail as shown above.

Apply glue to the mating edges of L and secure L in place with 1 1/4" #6 flathead screws. Remove piece K (K will be attached to the Top later.).

Next, insert two pocket hole screws as shown above to add extra strength.
Apply glue to mating surfaces and position piece "O" so it extends equally over the leg pieces M & N. Secure with 1 1/4" #6 flathead screws.

Attach the Wheel as shown below. If screws did not come with the wheel, 3/4" #6 panheads will work fine.
Position the two remaining Gussets H in the corner to serve as spacers as shown to the right. The Gussets H should be made of material the same thickness as the Leg pieces M & N. This will ensure the ends of the Leg fits behind the Leg Mount. Do not apply glue as these will be removed after the Leg Mount is attached.

Apply glue to mating surfaces of Leg Mount K and the Top. Then, position Leg Mount K against the Gussets H as shown to the left. Secure Gusset K to the Top with 1 1/4" #6 flathead screws. The side of the Leg Mount with T-Nuts goes against the Top.

Remove the two Gussets H and wipe any excess glue from around the edges of The Leg Mount K.

Apply glue to mating surfaces and secure Gussets H to the Stiffeners A and the Top with pocket hole screws as shown below. Be sure the Gussets H provide enough room for the Leg Assembly to sit flat against Leg Mount K.
Step 1. Cut a slot for the Drawer Bottom in the Drawer Front as shown above. The slot is 1/2" from the bottom of the Drawer Front and 3/16" deep. The width of the slot should be just wide enough for the Drawer Bottom to slide in it easily.

Step 2. Cut a 15/16" wide by 3/8" deep rabbet on each end of the Drawer front as shown above. This should leave a section in the center that is 20 5/8" long (the same as the length of the Drawer Back.

Step 3. Cut a slot for the Drawer Bottom in each Drawer Side and the Drawer Back. These slots are only 1/4" from the bottom and 3/16" deep. The width of the slot should be the same as with the slot in the Drawer Front.

Step 4. Drill two 1/16" holes through each end of both Drawer Sides. These hole will ensure the 1" brads will be in the correct position when assembling the drawer.
Step 1. Apply glue to the mating surfaces and attach the First Drawer Side to the Drawer Front and Back as shown below. Make sure the slots for the Bottom are aligned correctly (The Front, Sides, and Back will be flush at the top.) Secure with 1 1/4" finishing nails using the 1/16" holes already drilled. (You made need help holding the assembly in place.)

Use a 3/4" thick piece of wood as a support block so the Front is not touching the workbench.
Step 2. Turn the assembly over and insert the bottom into the slots. Apply glue to the mating surfaces and secure with 1 1/4” finishing nails. Do not glue the bottom in place, it should be free to expand and contract.
Apply glue to the mating surfaces and position the Drawer Front Trim flush against the Drawer Front and the Drawer Side as shown above. Repeat for the other side. Clamp in place until glue dries.

Position the drawer slide flush against the Drawer front as shown.

Drawer slide extends past the end of the drawer.

Using the screws provided with the drawer slides, attach a drawer slide to each side of the drawer as shown above. The drawer slides will protrude past the end of the drawer. This is necessary so the drawer can be removed and installed.

This completes the drawer.
Attach the End Panels to the Stiffeners J with 1 1/2" long bolts (1/4" dia. by 20 threads per inch), lock washers and flat washers as shown below.

Do not use glue. You may want to disassemble the desk to move it.

Attach the Leg Assembly to the Leg Mount with three 1 1/2" long bolts (1/4" dia. by 20 threads per inch), lock washers and flat washers as shown above.

Again, do not use glue.
This drawing shows the layout and positions of the stiffeners. The edge trim should already be attached at this point or else the dimensions will be incorrect.
Working with Veneered Plywood

When building projects that require large panels, veneered plywood is usually a great choice. It is just as attractive as solid wood, is less likely warp and split, and it’s less expensive.

While it offers some excellent benefits over solid wood, veneered plywood presents some challenges that need to be considered.

1. First, the edges that will be visible need to be covered with some type of edge trim. With this project, I chose to make 1/8” thick edge trim from solid oak boards and glue it to the edges with contact cement. To finish off the edges, use a 1/8” radius rounding over router bit. This is the reason the trim needs to be 1/8” thick.

2. The second issue is “tearout”. A saw blade presses fibers toward the wood when it enters the work piece (which is good) but it tears fibers loose when it leaves the work piece. This can leave a terrible looking edge that cannot be corrected. Tearout occurs on solid wood too but it’s worse with plywood.

   You can prevent tearout by placing a piece of ¼” hardboard like Masonite® or thin MDF board between the saw and the work piece. This “sacrificial board” will hold the fibers against the wood and prevent tearout.

   I strongly recommend that you use this technique to prevent tearout when cutting the Top and End Panels. The stiffeners and gussets won’t be visible and a little tearout won’t matter so much with them.

3. The third issue is that the veneer is very thin and you cannot sand out defects without sanding through the veneered surface. If you do, you will have an unsightly blotch that will ruin the appearance of your project.

   For this reason, you need to be careful not to drive the pocket hole screws too deep when attaching the stiffeners and gussets to the bottom surface of the desk top. If you over tighten the screws, you will have an unsightly bump on the top surface. The illustrations below show you how to prevent this.

4. When the project is completed and you’re ready to finish it. You can sand the surface with 220 grit sandpaper. Only sand enough to get a smooth finish. Don’t over do it.

The depth of the pocket hole is determined by how far the drill goes into the jig. Use a stop collar on your drill bit to adjust the depth of the hole so no more than half the screw protrudes.

Use a screwdriver instead of an electric drill driver so you can be sure not to over tighten the pocket hole screws.

If you over tighten the screw and it crushes the wood under the screw head, you will have a bump on the surface of your desk top.
Make the router guide plates out of scrap material as shown above. The thickness of the plates may be anywhere from 1/4" to 3/4". These are used in the next step when you make the Top. Be sure the edges are straight and smooth so the router will leave a straight smooth edge.
First, cut the Top about 1/16" larger than the 47 7/8 and the 23 7/8 dimensions shown in the drawings. You will use your router and straight edges to remove this extra 1/16". The router will provide a nice smooth edge suitable for applying the edge trim. Because of the shape of the Top, you will need to use a jig saw for this cut. Be sure to place a sacrificial board under the jig saw to prevent tearout.

Next, select the best looking side for the top surface and being careful not to scratch the surface, turn the work piece so the best looking side is down. Place masking tape around the edges as shown below and layout your cut lines on the masking tape according to the dimensions given. The cut lines should be about 1/16" from the edges. Remember, this side will be the bottom surface of the finished Top.

Attach the router guide plates along the cut marks and secure to the workpiece with small brads as shown above. Select brads that are long enough to penetrate about 1/2" into the Top. Be sure the brads are flush with the surface so the router doesn't hang up on them. Use a 5/16" flush trim bit in your router to trim the edges of the workpiece flush to the guide plates.

The two inside corners will be slightly rounded. With the guide plates still in place, use a file to clean up the corners so the edges are straight all the way to the corners.
Four Drawer Cabinet

A computer desk is not complete without a matching drawer cabinet. This cabinet is designed to compliment our Corner Computer Desk plans. Features an 18” by 24” top and the height is 30”.

Like the Corner Computer Desk, it's made of oak veneered plywood with solid oak for the drawer fronts and trim. Self closing drawer slides are easy to install, provide smooth operation, and facilitates easy drawer removal. Check out these features:

- The 18” by 24” top is perfect for your printer or scanner.
- Shallow top drawer for pens, pencils, paper clips, and other small items.
- The second drawer is large enough for a stapler, hole punch and other mid sized items.
- The third drawer is large enough to hold CD jewel cases and envelopes.
- The bottom drawer is for regular size file folders.

Tools You Will Need: Table Saw, Drill, Pocket Hole Jig, Router
# Four Drawer Cabinet Plans

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<tr>
<td>Drawer Front Slots - A</td>
<td>16</td>
</tr>
<tr>
<td>Drawer Front Slots - B</td>
<td>17</td>
</tr>
<tr>
<td>Assemble the Drawers</td>
<td>18</td>
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<tr>
<td>Attach Drawer Slides</td>
<td>19</td>
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<tr>
<td>Cabinet Cutouts</td>
<td>20</td>
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<tr>
<td>Drawer Cutouts</td>
<td>21</td>
</tr>
</tbody>
</table>
Four Drawer Cabinet

Materials You Will Need

One half sheet (48” by 48”) of ¾” oak veneer plywood ............................................... see cutout diagram.
One quarter sheet of ½” Oak Veneer Plywood or other material ...................... drawer sides and back.
Less than 1/4 sheet of ¼” hardboard or thinner material ........................................... drawer bottom.
One 7 ½” by 8’ by ¾” solid oak board ............................................................. for the drawer fronts, dividers, & edge trim.
Four sets of 18” drawer slides (may be closer to 17 ¾”) ................................... available in hardware stores.
Box of pocket hole face frame screws 1 ¼” ........................................................... (you’ll need about 65)

<table>
<thead>
<tr>
<th>Item Name</th>
<th>Size</th>
<th>Material</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Top</td>
<td>18 ¼” by 23 7/8”</td>
<td>¾” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>Side Panels</td>
<td>29 ¼” by 22 ½”</td>
<td>¾” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>Top Side Trim</td>
<td>24” by ¾” by ½”</td>
<td>⅛” Thick Solid Oak</td>
<td>2</td>
</tr>
<tr>
<td>Top Front Trim</td>
<td>18 ½” by ¾” by ½”</td>
<td>⅛” Thick Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>Side Panel Trim</td>
<td>29 ¼” by ¾” by ½”</td>
<td>⅛” Thick Solid Oak</td>
<td>2</td>
</tr>
<tr>
<td>Front Top Gusset</td>
<td>15” by 3”</td>
<td>¾” Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>Rear Top Gusset</td>
<td>15” by 3”</td>
<td>¾” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>Drawer Dividers</td>
<td>15” by 2”</td>
<td>¾” Solid Oak</td>
<td>3</td>
</tr>
<tr>
<td>Bottom Trim</td>
<td>15” by 1 7/8”</td>
<td>¾” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>Side Gussets</td>
<td>16 ¼” by 1 ½”</td>
<td>¾” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>Rear Gussets</td>
<td>15” by 5”</td>
<td>¾” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>File Folder Slide Support</td>
<td>13” by 1”</td>
<td>½” Thick Wood (Any Type)</td>
<td>2</td>
</tr>
<tr>
<td>Top Drawer Back</td>
<td>13” by 2 ³/₈”</td>
<td>½” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>2nd Drawer Back</td>
<td>13” by 3 ¼”</td>
<td>½” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>3rd Drawer Back</td>
<td>13” by 6”</td>
<td>½” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>Bottom Drawer Back</td>
<td>13” by 10 ¾”</td>
<td>½” Oak Veneer Plywood</td>
<td>1</td>
</tr>
<tr>
<td>Top Drawer Side</td>
<td>16 ³/₈” by 2 ³/₈”</td>
<td>½” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>2nd Drawer Side</td>
<td>16 ³/₈” by 3 ¼”</td>
<td>½” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>3rd Drawer Side</td>
<td>16 ³/₄” by 6”</td>
<td>½” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>Bottom Drawer Side</td>
<td>16 ³/₈” by 10 ¾”</td>
<td>½” Oak Veneer Plywood</td>
<td>2</td>
</tr>
<tr>
<td>Top Drawer Front</td>
<td>15 ½” by 3 3/₈”</td>
<td>¾” Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>2nd Drawer Front Filler</td>
<td>15 ½” by 4 ¼”</td>
<td>¾” Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>3rd Drawer Front</td>
<td>15 ½” by 7”</td>
<td>¾” Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>Bottom Drawer Front</td>
<td>15 ½” by 11 3/4”</td>
<td>¾” Solid Oak</td>
<td>1</td>
</tr>
<tr>
<td>File Folder Slide</td>
<td>15 ½” by ½” by ⅛”</td>
<td>Steel Bar</td>
<td>2</td>
</tr>
</tbody>
</table>
Four Drawer Cabinet
Top & Side Panel Dimensions

Side Panel
(2 Required)

Top & Side Panel Dimensions

Top (1 Required)

Side Panel Trim (2 Required)

Top Side Trim (2 Required)

Top Front Trim (1 Required)

(All Trim is 1/8" thick solid oak)
Front & Rear Top Gusset
(2 Required)

Note: The Front Gusset is solid oak, the Rear Gusset is 3/4" plywood

Drawer Dividers
(3 Required)

Bottom Trim
(1 Required)

Rear Gussets
(2 Required)

Side Gussets (2 Required)
Drill four pocket holes and two 3/16" diameter holes through the Top Gussets as shown below.

Drill two pocket holes on each end of the Drawer Dividers as shown below.

Drill two pocket holes on each end of the Bottom Trim as shown below. Note: Choose the best looking of the Bottom trim for the front. Drill pocket holes on back side.

Drill two pocket holes on each end of the Rear Gussets as shown below.

Drill two 3/16" dia. holes through the edge and two through the wide surface of the Top Mounts as shown below.
Drawer sides, backs, and file folder slide supports are made of 1/2" thick material.

Drawer bottoms are made of 1/4" thick material but 3/16" material will work just as well. If you use material less than 1/4", cut the slots just wide enough for the bottoms to fit without binding.

All drawer backs are 13" wide and all drawer sides are 16 3/8" long.
Drawer fronts are made of solid oak.

All drawer fronts are 15 1/2" wide.
Attach the End Panel Edge Trim to each End Panel with contact cement as shown above.

Choose the most attractive side and round over the edge with a 1/8" radius rounding over bit. **Only the outside edge should be rounded over.**
Attach the drawer slides to the right panel with screws that were provided with the slides as shown above. If no screws were provided, use 1/2" long #6 flathead screws. Be sure the middle section of each slide is parallel to the top and bottom of the panels.
Attach the drawer slides to the left panel.
Apply glue to mating surfaces and attach the Top Gussets and a Top Mount to the top Right Side as shown below. Use pocket hole screws for the gussets and 2” screws for the Top Mount.

All three pieces should be flush with the top of the side panel.

Apply glue to mating surfaces and attach a Rear Gusset and the Front Trim to the Right Side with pocket hole screws as shown to above.

The Rear Gusset and Front Trim should be flush with the bottom of the side panel.
Apply glue to mating surfaces and place the assembled Right Side with the parts that are already attached to it on the Left Side as shown below.

Make sure all joints are flush at the corners and edges before attaching with screws as with the previous step.
Assemble Cabinet - 3

Each Drawer Divider must be secured with pocket hole screws on both ends before starting the next one. (This is because when the second divider is in place, you won't have room to drive the screws in the previous one.)

Starting with the top Drawer Divider, apply glue to mating surfaces and position the Drawer Dividers as shown in the drawing. Position the Drawer Dividers against the bottom of the drawer slides and flush with the front edge of the cabinet.

Pocket holes go toward the bottom of the cabinet and the oak trim is on the front.
Apply glue to the mating surfaces and position the remaining Rear Gusset about one inch from the Top Gusset and flush with the back. Secure with pocket hole screws. The reason for the one inch distance from the Top Gusset is so you have room to drive the screws.
Round over all four edges of the top (both top and bottom sides) with a 1/8" round over bit before attaching it to the cabinet.

Place the best looking surface of the Top down and position the cabinet on the least attractive surface as shown above. There should be a one inch overhang on both sides and one inch on the front (3/4" on the back).

Secure with 1 1/4" #6 screws using the 3/16" holes in the Top Gussets and Top Mounts. If you are sure you will never want to remove the top you can use glue. But it will be strong enough without glue.
Cut a slot 1/4" deep and 3/8" from the bottom of each side and back as shown in the drawing to the right. The width of the slot should be the thickness of the material you use for the drawer bottoms. Just wide enough so the bottom slides in it.

Drill 1/16" dia. holes in each side as indicated by the red arrows above. All holes are 1/4" from the end of the sides. The holes at the top should be 3/4" from the top. The bottom holes are 7/8" from the bottom. For the two larger drawers, place holes approximately centered from top to bottom.
Step 1.

The first step is to cut the slot for the drawer bottom. The width of the slot should be just slightly wider than the thickness of the drawer bottoms. This allows for movement in case for expansion or contraction. The above drawing provides the location of the slots measured from the bottom of each Drawer Front.

Step 2. Cut a 3/8" by 1/2" rabbet along the top edge as shown below.

Step 3. Cut a 3/8" by 1/2" rabbet along the bottom as shown above.

You can use either the table saw or router to make these cuts. We use the 3rd drawer front as an example in these drawings. But since the same procedure applies to all the drawers, you should make the cuts on all four drawer fronts while you have the fence set in the correct position for each cut.
Step 4. Cut a 1 1/4" wide by 3/8" deep rabbet along each end as shown above.

Step 5. Round over all four edges on the front side with a 1/8" round over bit.

Step 6. The last step is to drill the holes for the drawer pulls or knobs. Since there are different sizes and types of drawer pulls and knobs, I cannot provide specific locations for the holes.

You'll need to determine the location of the holes based on whether you use knobs with a single screw or handles with two screws. Either way, you'll need to position the holes so the handle is centered from side to side and top to bottom.
Cut a 1/8" wide slot 5/16" from each end of the File Drawer Slide Supports as shown below. The depth of the slots should be the same as the width of the File Folder Slide.

Drill two 3/16" dia. holes through each of the File Folder Slide Supports as shown above. These holes are 1" from each end and centered from top to bottom.

Mount one of the File Folder Slide Supports to the Bottom Drawer Front and the other to the Bottom Drawer Back with 1 1/4" #6 screws as shown above. The File Slide Supports should be 5/8" from the top of the drawer back and 5/8" from the top of the inner surface of the drawer front. I recommend you do not use glue as you may want to remove the supports if your needs change in the future.

When the Bottom Drawer is completed, insert the File Folder Slides in the slots and you're ready to hang your file folders.
Step 1. Apply glue to the mating surfaces and support the drawer front, one side, and the back as shown to the right. Be sure the slots for the bottom are alligned with each other in all three pieces. Secure with 1 1/4" finishing nails.

Step 2. Turn the assembly over and insert the bottom into the slots. Apply glue to the mating surfaces and secure the second side with 1 1/4" finishing nails. Do not glue the bottom in place, it should be free to expand and contract.
Attach the drawers slides with the screws provided with the slides as shown above. The end of the slide without the roller is flush with the inside surface of the drawer front. The end with the roller protrudes past the other end of the drawer. This is makes it easier to insert and remove the drawers. Repeat for the opposite side.

This completes the drawer assembly.
Four Drawer Cabinet
Drawer Cutouts

1/2" Oak Veneered Plywood

<table>
<thead>
<tr>
<th>Top Drawer Back (1 required)</th>
<th>Top Drawer Side (2 Required)</th>
<th>Top Drawer Side (2 Required)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2nd Drawer Back (1 required)</td>
<td>2nd Drawer Side (2 Required)</td>
<td>2nd Drawer Side (2 Required)</td>
</tr>
<tr>
<td>3rd Drawer Back (1 required)</td>
<td>3rd Drawer Side (2 Required)</td>
<td>3rd Drawer Side (2 Required)</td>
</tr>
<tr>
<td>Bottom Drawer Back (1 required)</td>
<td>Bottom Drawer Side (2 Required)</td>
<td>Bottom Drawer Side (2 Required)</td>
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</tbody>
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3/16" or 1/4" Thick Material

<table>
<thead>
<tr>
<th>Drawer bottom (4 Required)</th>
<th>Drawer bottom (4 Required)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drawer bottom (4 Required)</td>
<td>Drawer bottom (4 Required)</td>
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