Instructions for the 10 Drawer Cabinet

1. Let's begin by cutting the sides from ¾" plywood. The dadoes for the hardboard drawer slides are ¼" deep as is the plow for the plywood back. The mortices that join the top and bottom are 3/8" deep plus a little bit more to allow the tenons to fully seat. To create a more finished appearancerabbet the front edge of the sides and apply a 1/16" thick by ½" wide piece of hardwood.
2. Next, cut the top and bottom from ¾" plywood. The tenons are ¼" thick. Don't worry about the fillet left at the root of the tenon because the mortices are sized ¼" wider than the tenons to allow for clearance.
3. Cut out the back from ¼" plywood using a table saw or CNC router.
4. Test fit the sides, top, bottom and back. If everything goes together well, get out your glue bottle and assemble the carcass. I used a brad nailer to secure the back to the top and bottom after sliding it into the groove on the sides.
5. Cut the top and bottom facia from ¾" hardwood and apply a 3/8" round over to the ends. Glue the facia in place.
6. Using ¼" thick hardboard cut out the horizontal divider and glue it in place. The horizontal divider will help keep the sides parallel to each other.
7. The drawers run on simple ¼" hardboard runners. Cut these out and glue in place. Note – if the runners are tight don't force them in place as doing so will bow the sides. The runners should be an easy fit.
8. Making the legs and corbels is the next step. I used 8/4 stock and cut them out with an upcut bit. Thick stock needs to be cut using some care. Use a ¼" upcut bit with a 1/8" deep depth of cut to prevent the bit from overloading as it gets deeper and deeper. Also, help clear the chips with compressed air or with a vacuum cleaner. Round the edges of the legs and corbels with a 1/8" round over bit.
9. The finish top is made from ¾" thick hardwood. The front is curved to match the curve of the handles so cut this on your CNC router. The front and side edges of the finish top have a 1/8" round over applied.
10. Drill clearance and pilot holes for the legs. Glue and screw in place.
11. Add the corbels. Glue and a pin nail make quick work of this task.

12. Add the finish top by drilling oversized holes to allow for wood movement in the plywood top of the carcass and screw it into place – no glue.
13. It's time to begin making the (10) drawers that make this cabinet so useful. Let's begin by making the drawer faces. The drawer faces are made from ¾" hardwood. The pockets for the drawer sides are cut ½" deep and the plow for the drawer bottom is ¼" deep. The ends of the drawer faces are softened with a 3/8" round over. Using a fence and stop block to ensure accuracy, drill the holes for the drawer pull.
14. The sides and back of the drawers are made of ½" plywood. The dadoes for the back tenons and the drawer bottom are ¼" deep. The tenons on the backs are ¼" thick. There are 20 sides and 10 backs – perfect work for a CNC router.
15. Assemble and glue the drawer faces, sides and back. Slide the bottom in place and nail it off to the back with a brad nailer. Make sure that each drawer is square. An out of square drawer will not seat properly and will show.
16. It is easy to buy cabinet pulls but it is a lot more fun to make them. Using your CNC cut the 10 drawer pulls out of ¾" stock, then route the edges with a 1/8" bit. Drilling the pilot holes for the screws to attach the handles needs to be done accurately and must match the holes drilled in the drawer faces. I found that using the blank that the handles were cut out of made a nice cradle to hold the handles when drilling the pilot holes on the drill press.
17. Attach the handles, fit the drawers, and enjoy your 10 drawer cabinet.