

Veritas® Tool Chest Locking Spring Pins can be used in front rails from 1 1/2" to 3" high. They are easily installed and come complete with springs, bushings, and contact plates for the tool chest lid.

Drill Bits Required: 17/64" (6.75 mm), 3/8" (10 mm) brad point

1. Before assembling your tool chest, lay out and drill the holes for both pins. The holes should be on center and at least 1" from the front rail ends.
2. With the front rail suitably clamped in your drill press, drill both holes with a 17/64" (6.75 mm) bit.

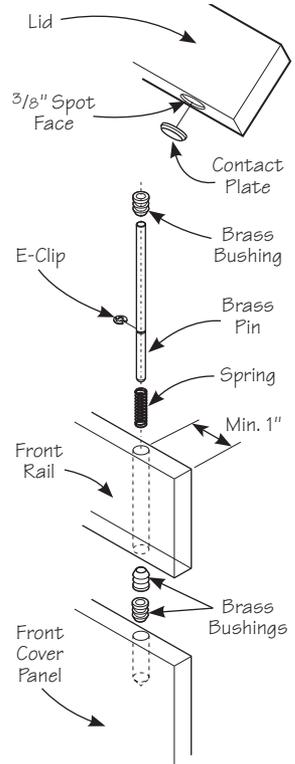
Tip: It is good practice to check your set-up with a scrap piece of wood of the same width and height and make any necessary adjustment if the holes are not accurate.

You may now complete the assembly of the entire tool chest.

3. With the front cover panel taped closed, extend the holes in the front rail 1/2" deep into the top edge of the front panel.

Tip: If the bit is not long enough to drill to the required depth, extend it as much as possible from the drill chuck and/or drill the holes so that the tip just clears the rail and makes centerpoints marking the correct hole positions. Then, remove the front panel and finish drilling the holes.

4. Tap a brass bushing into each hole (chamfered end in) in the front cover panel, and into the bottom end only of each hole of the front rail. Gluing them is optional. The bushings should sit flush or slightly below the surface of the wood.



Sizing Chart

Rail Height + $\frac{5}{16}$ " = Pin Length

Rail Height	Pin Length
$2\frac{3}{4}$ "	$3\frac{1}{16}$ "
$2\frac{1}{2}$ "	$2\frac{13}{16}$ "
$2\frac{1}{4}$ "	$2\frac{9}{16}$ "
2"	$2\frac{5}{16}$ "
$1\frac{3}{4}$ "	$2\frac{1}{16}$ "
$1\frac{1}{2}$ "	$1\frac{13}{16}$ "

- The locking pins fit a 3" tall front rail. If your front rail is less than this, the top (non-spherical) ends must be cut to the height of your front rail + $\frac{5}{16}$ " (see sizing chart).
- Install the E-clip into the groove on each pin. As shown in the illustration, place each pin and spring into the holes in the front rail and check that they mate with the front cover panel bushings when pushed down. If needed, the angle of the bushings can be adjusted by prying them sideways with a small screwdriver. Slide a bushing (chamfered end down) onto each exposed pin. Tap each bushing in until flush with the top of the rail.

Important: *If you ever need to remove the locking pins, it is advisable **not to use glue for the upper bushings.** Without glue, the top bushings can be pressed out by lightly tapping the pins up, from the bottom side of the front rail, using a $\frac{1}{8}$ " to $\frac{5}{32}$ " pin punch (or equivalent). Supporting the top edge of the rail with a scrap piece of wood that has a $\frac{9}{32}$ " hole in it will prevent splintering.*

- With the front panel open, close the lid and lightly tap each pin from the underside to mark the contact plate locations. Using a $\frac{3}{8}$ " brad-point bit, drill a spot face $\frac{1}{16}$ " deep. Place the contact plate in the hole to check that it sits flush with the wood. If not, spot the hole slightly deeper and check again. Once the plates sit flush, glue them in place.