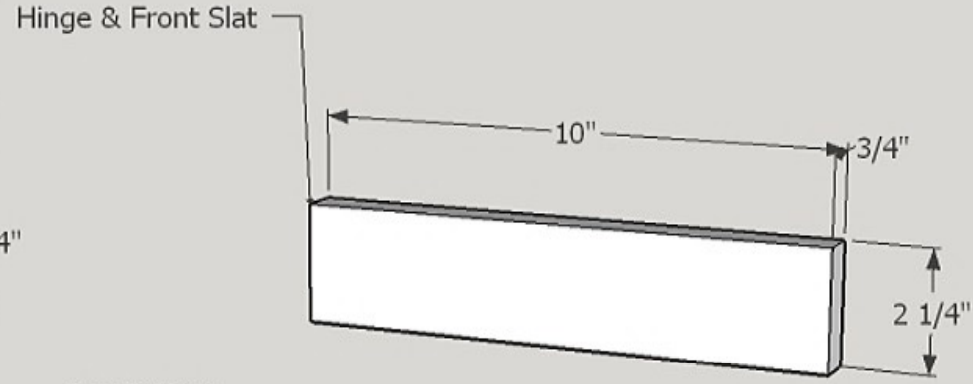
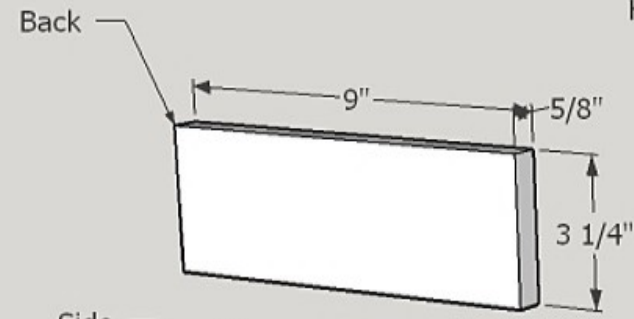
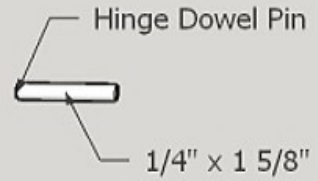
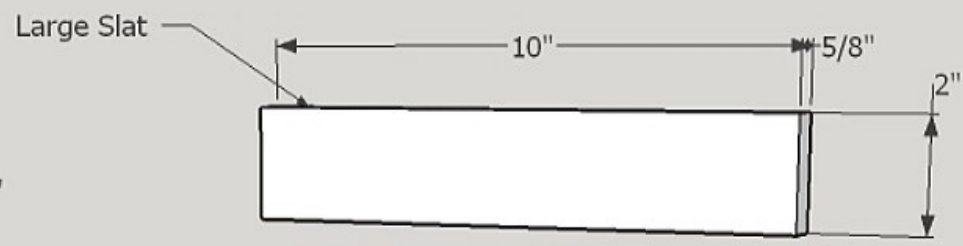
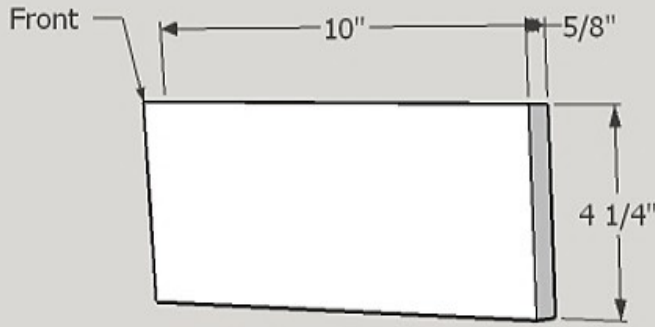


TREASURE CHEST

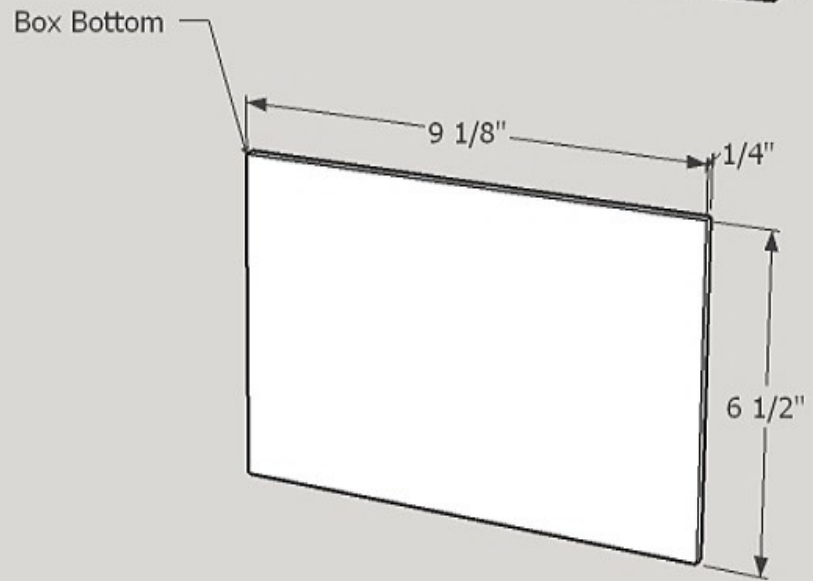
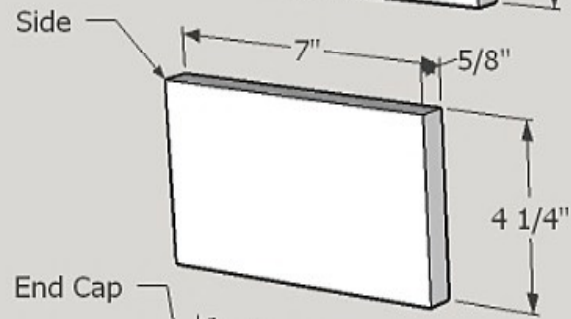
Rev 01-2024

DRAWING 1: PRE-MILLED PARTS

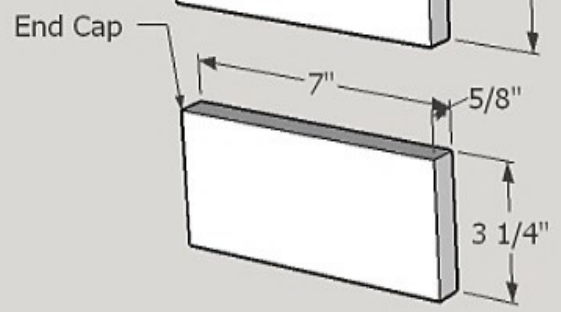
All surfaces should be sanded with 120 grit sandpaper either before or after assembly. However, it's not necessary to ease the sharp corners as they will be rounded or bevelled later.



Thickness:
 Box Bottom - 1/4" Plywood
 Hinge & Front Slat - 3/4"
 All other parts - 5/8"



Quantity per TC
 Front - 1
 Back - 1
 Side - 2
 End Cap - 2
 Large Slat - 5
 Hinge & Front Slat - 1
 Box Bottom - 1
 Hinge Dowel Pin - 2



DRAWING 2: FRONT

- Step 1: Mill a 3/16" round-over on all corners

Pre Milled Front

4 1/4"

10"

Red striping indicates a 3/16" round over

- Step 3: Mill rabbets for Sides 5/8" by 1/4" deep on the inside face (Note 1)

Lightly sand rabbet faces

5/8"

1/4" Deep

Note 1:
The 5/8" dimension should be adjusted to equal the thickness of the Sides.

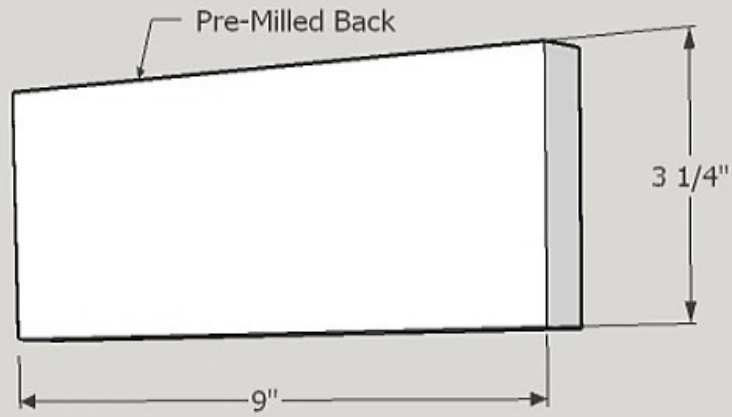
3/16"

1/4"

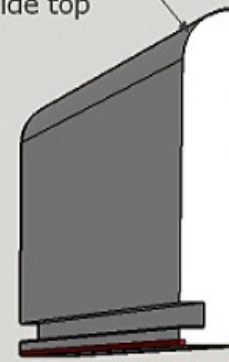
1/4"

- Step 2: Mill a 1/4" x 1/4" groove starting 3/16" from the bottom edge on the inside face

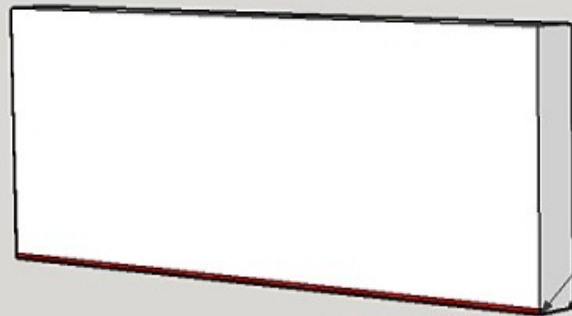
DRAWING 3: BACK



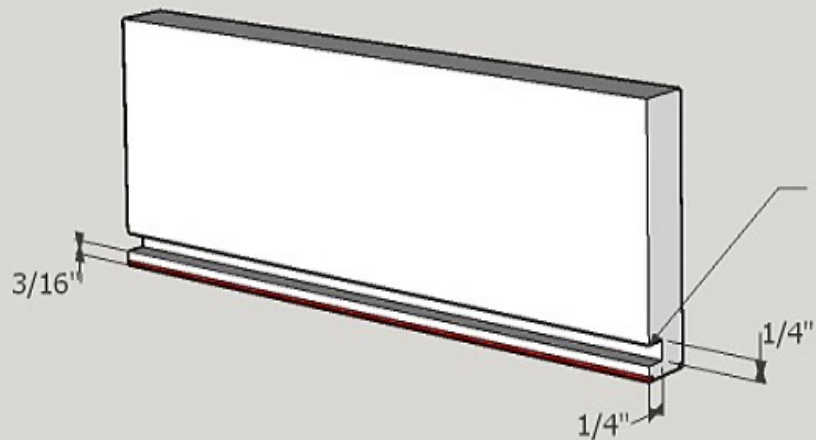
- Step 3: Mill a 1/2" round-over on the inside top



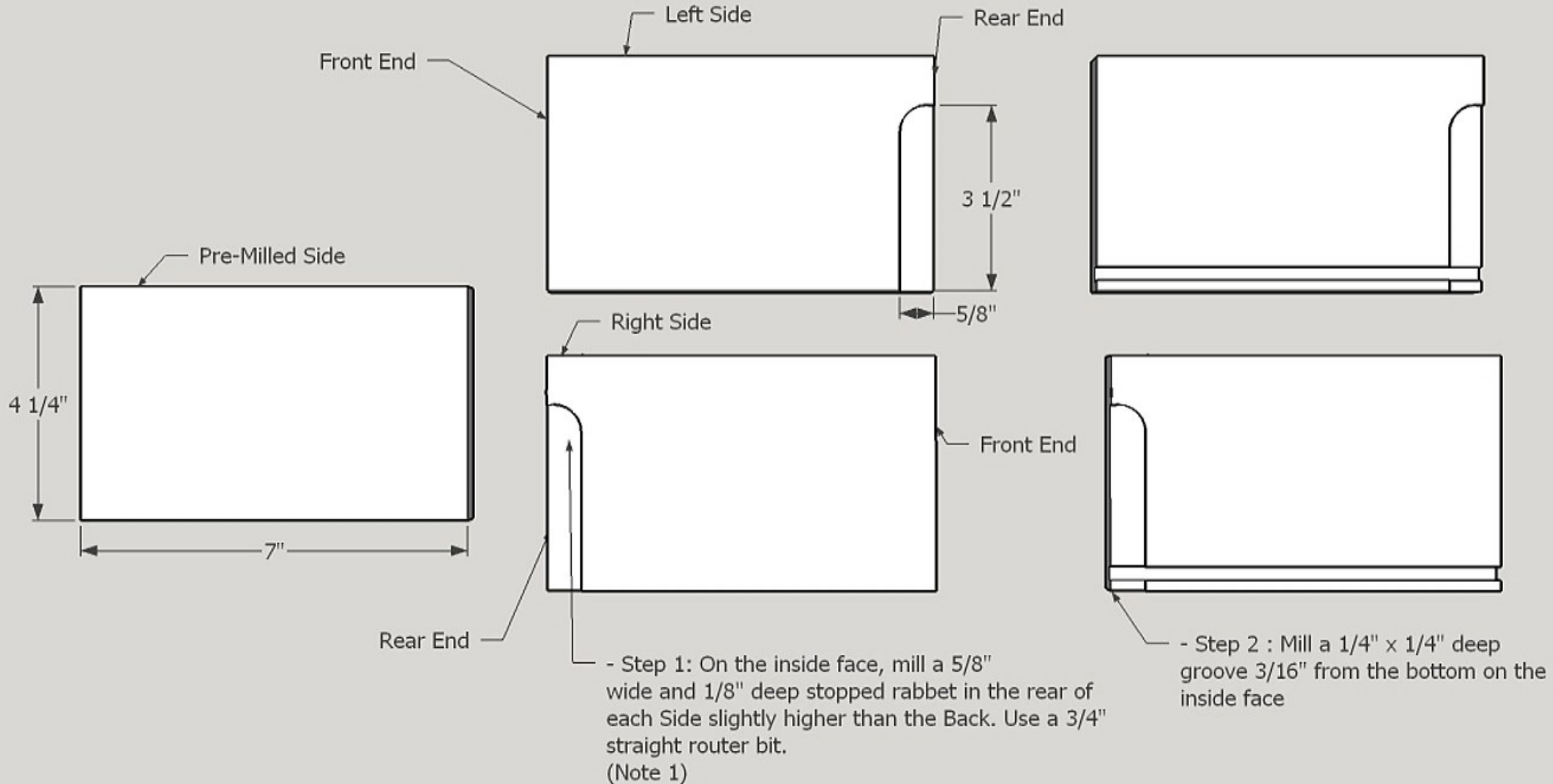
- Step 4: Ease the sharp edge



- Step 1: Mill a 3/16" round over on both bottom corners



- Step 2: Mill a 1/4" x 1/4" groove 3/16" from the bottom on the inside face

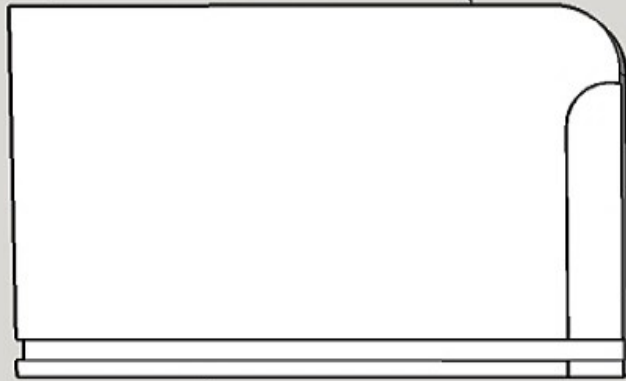


Note 1:
The $\frac{5}{8}$ " dimension should be adjusted to equal the thickness of the Back.

Lightly sand rabbet faces

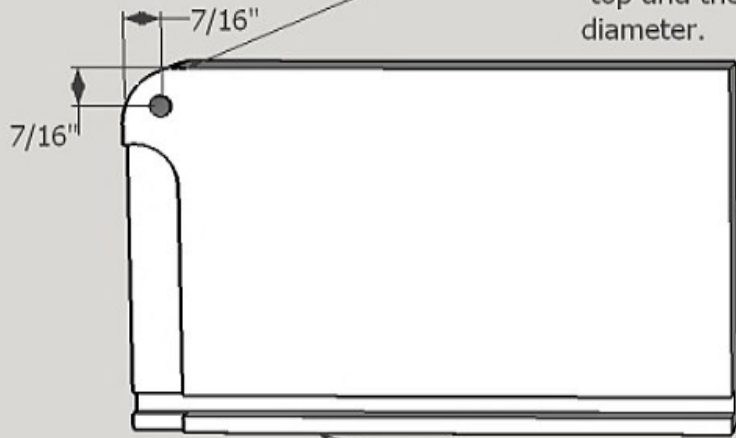
DRAWING 4B: SIDES

- Step 3: Round over the top back corner of both Sides using a 3/4" round over bit. It may take more than one pass to safely mill this.



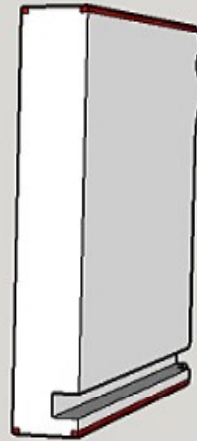
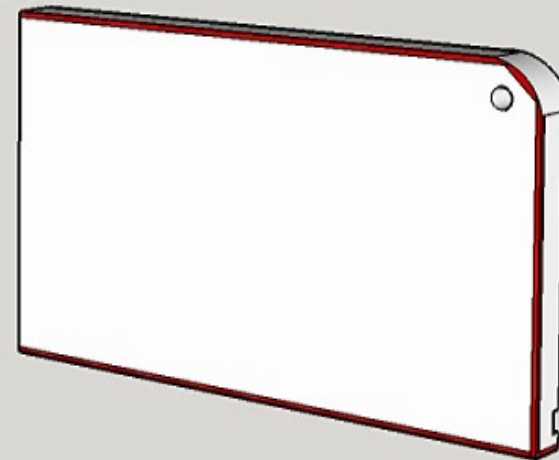
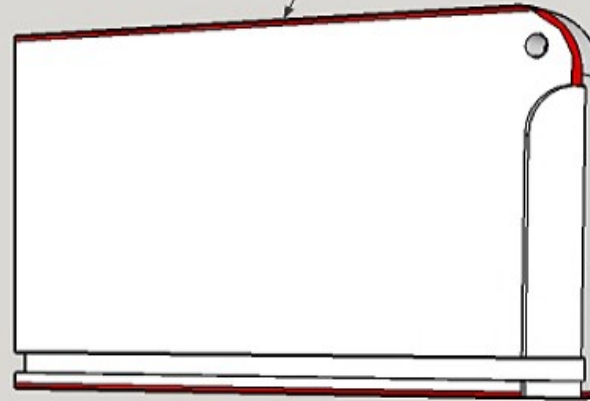
Left Side

- Step 4: Drill a hole in both Sides for the Hinge Dowel Pin, 7/16" from the top and the rear end. Fit the hole to the dowel's diameter.

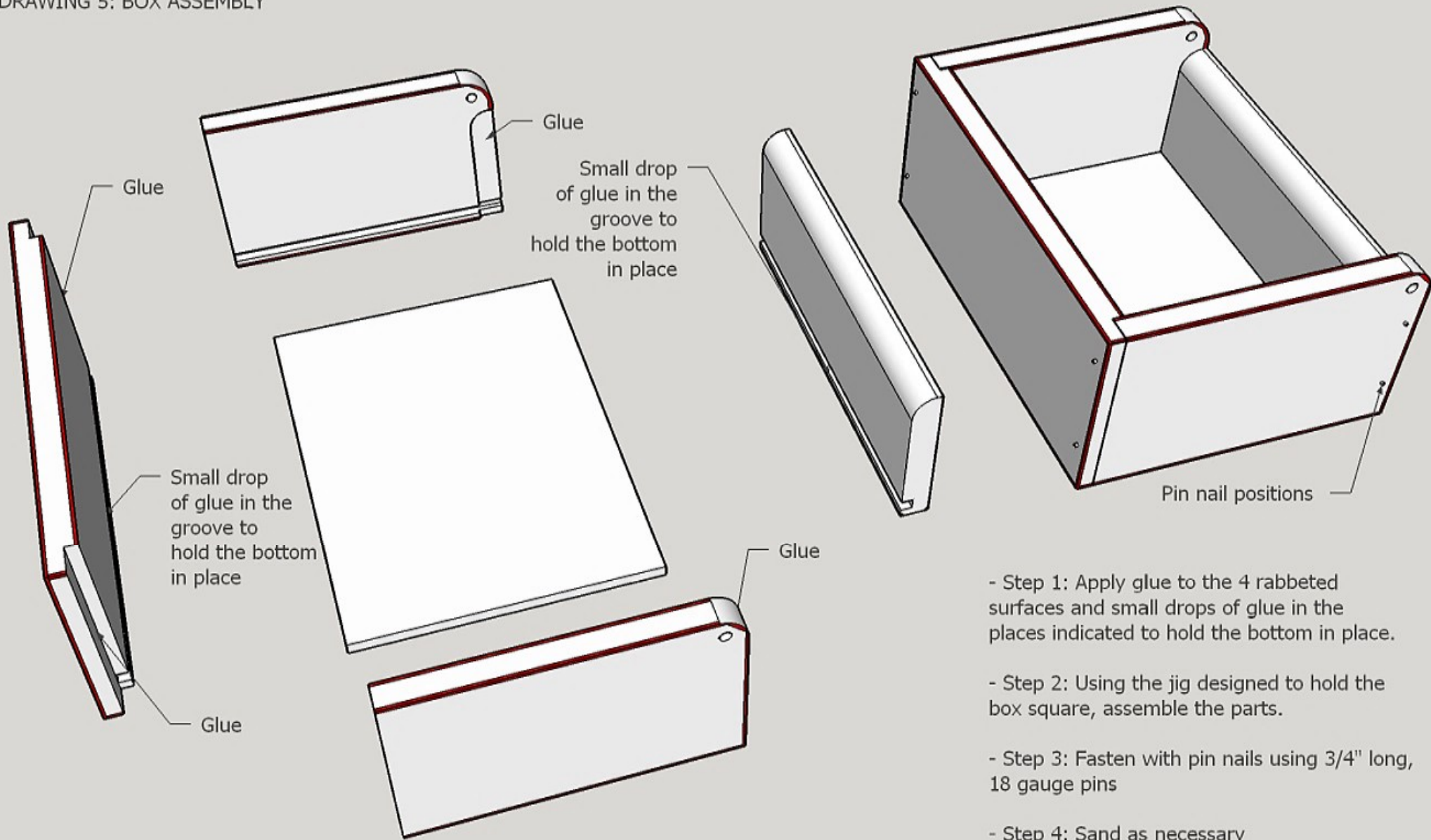


Right Side

- Step 5: Mill 3/16" roundover along all corners as shown

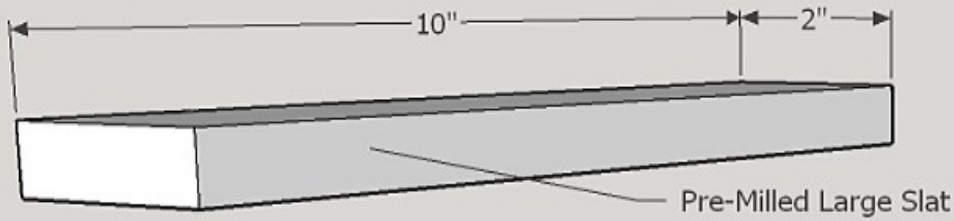


DRAWING 5: BOX ASSEMBLY

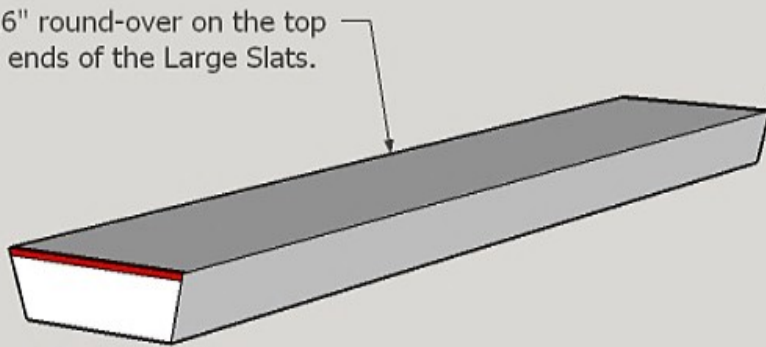


- Step 1: Apply glue to the 4 rabbeted surfaces and small drops of glue in the places indicated to hold the bottom in place.
- Step 2: Using the jig designed to hold the box square, assemble the parts.
- Step 3: Fasten with pin nails using 3/4" long, 18 gauge pins
- Step 4: Sand as necessary

DRAWING 6A: LARGE SLATS

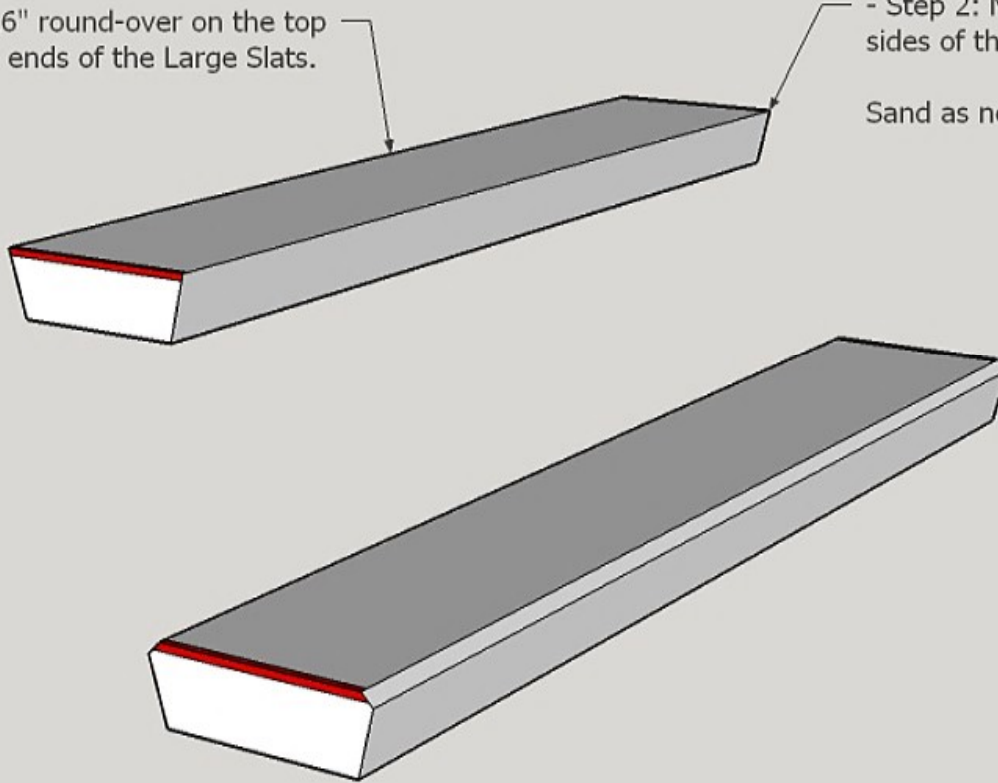


- Step 1: Mill a 3/16" round-over on the top of both ends of the Large Slats.



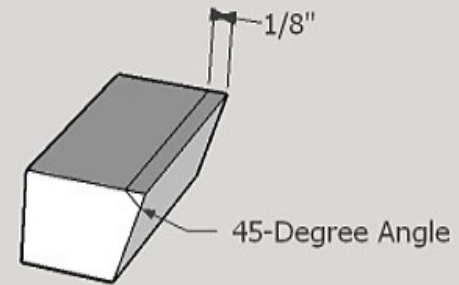
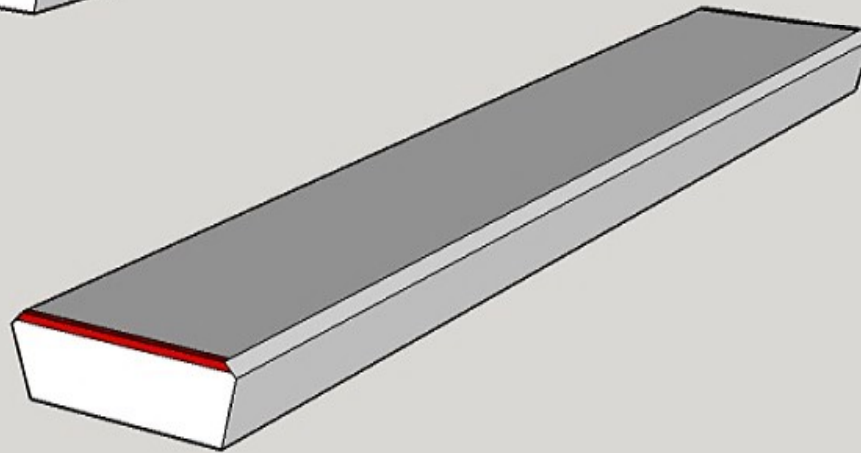
- Step 2: Mill a 15-degree bevel on both sides of the Large Slats.

Sand as necessary

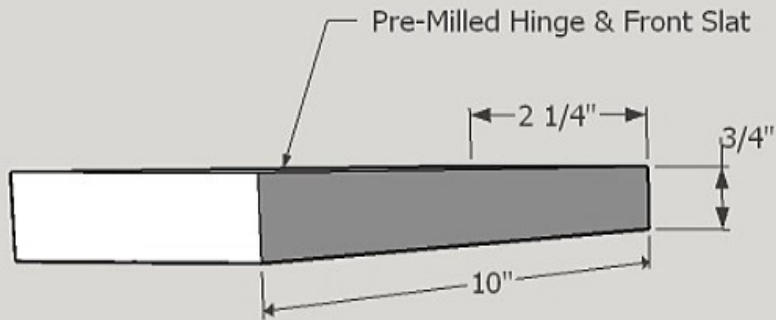


- Step 3 : Mill a 45-degree bevel on both angled ends of the Slats per the dimensions shown below.

Sand as necessary

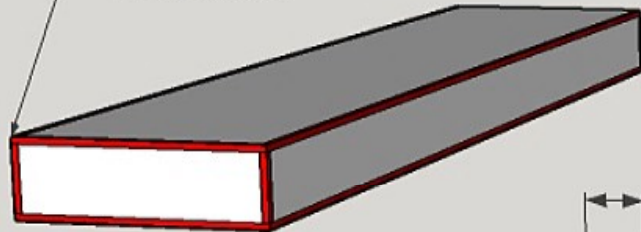


DRAWING 6B: HINGE AND FRONT SLATS



Pre-Milled Hinge & Front Slat

- Step 1: Mill a 3/16" round-over on all corners



Hinge Slat

Front Slat

1 1/2" 1/8"

- Step 2 : With the table saw blade set at 15 degrees, align the fence to rip at the distance noted.

Saw Blade Kerf

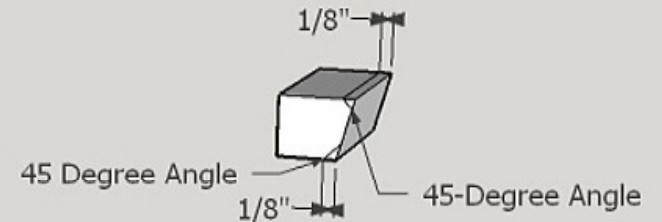
- Step 5: Using a hand plane, ease the bottom edges of the angled side.



- Step 3: Rip saw the part into the two Slats.



- Step 4: Mill a 45-degree bevel on top edges of the angled sides of both Slats per the dimensions shown below.

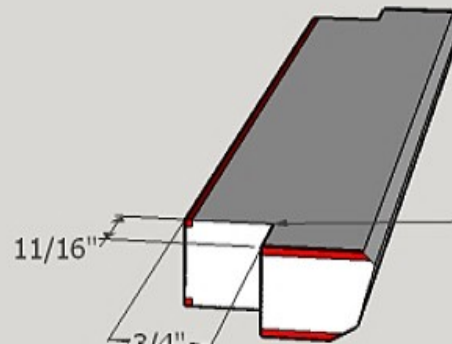


- Step 6: Mill a notch in the non-angled sides of the Hinge Slat to the dimensions shown.

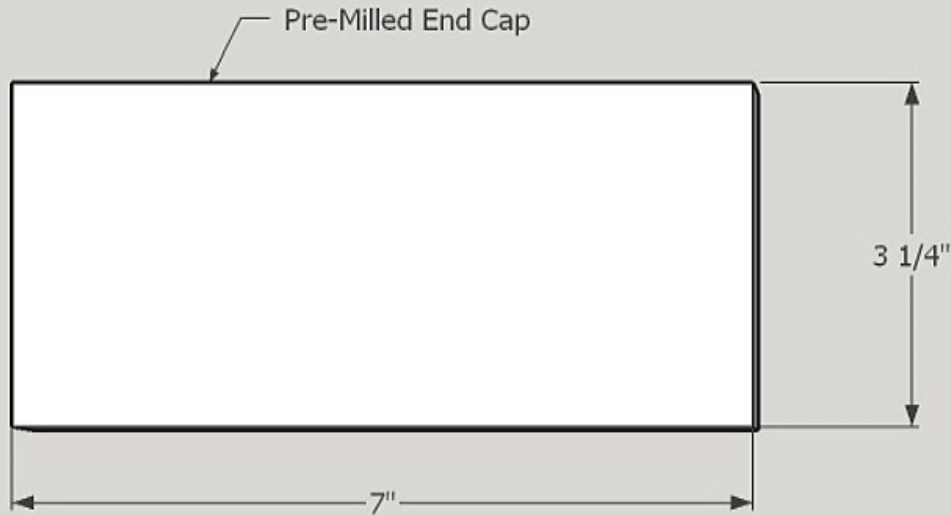
Sand as necessary.

11/16"

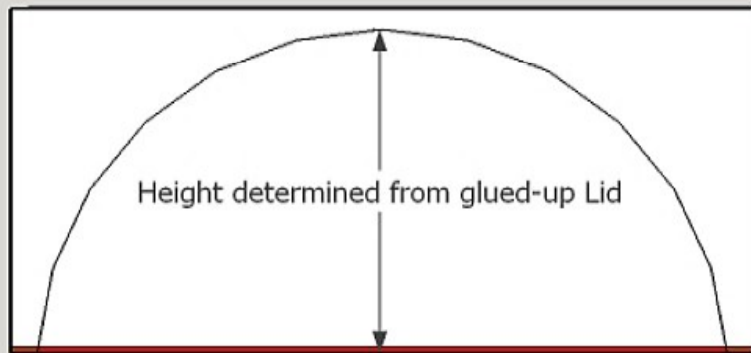
3/4"



DRAWING 7: END CAP

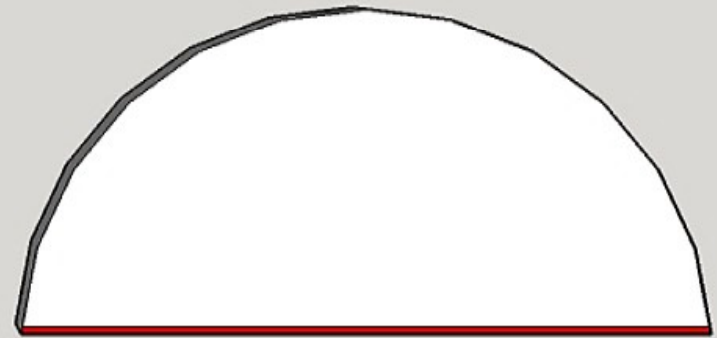


- Step 1: 3/16" round-over on bottom corners only



- Step 2: Small variations in wood thicknesses can lead to small changes in the height of the arc.

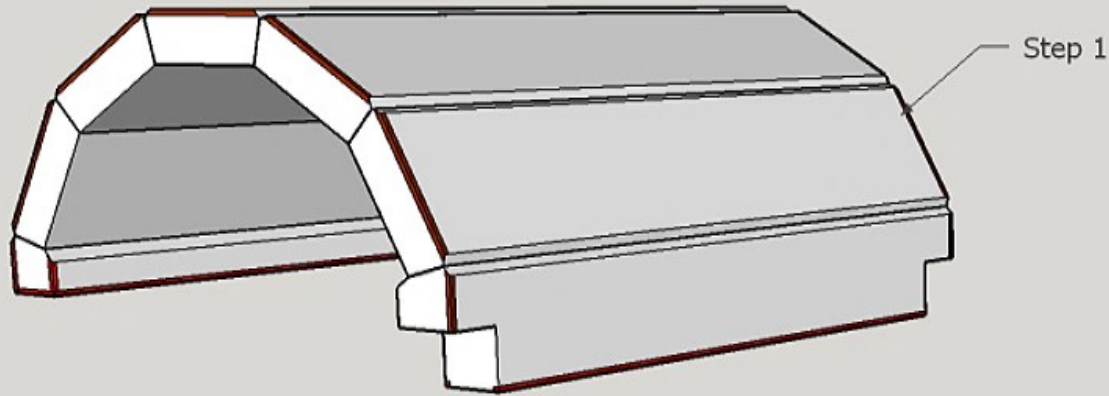
After a Lid has been completed (see Drawing 8, Step 2) the exact height of the arc for the End Cap can be determined



- Step 3: The arc of the End Cap is first cut as close as possible using a band saw or jigsaw

- Step 4: Using the jig designed for this purpose, mill to final dimensions on a router table.

DRAWING 8: LID ASSEMBLY & MILLING



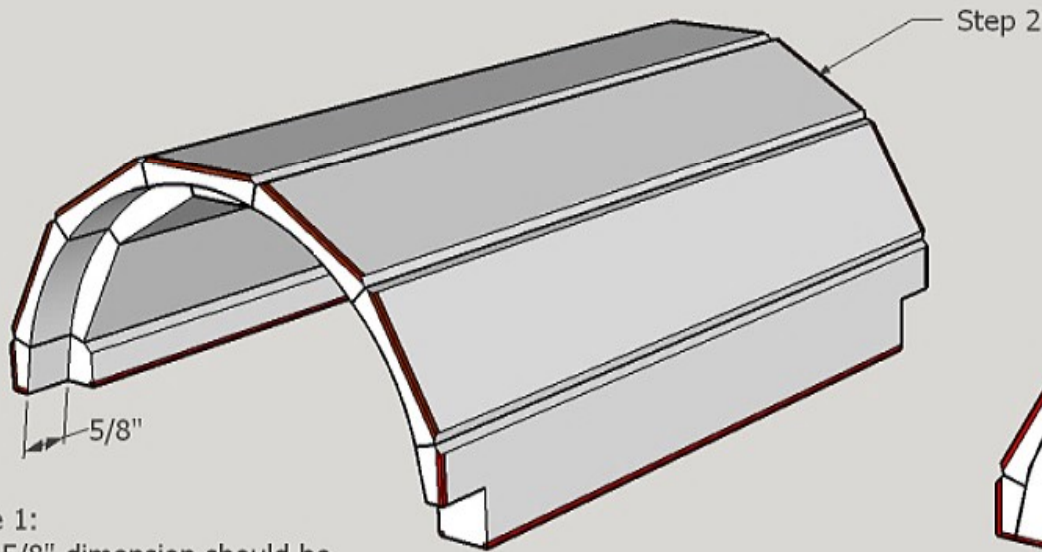
Lid Assembly instructions:

- Step 1: Slats are glued together in the configuration shown using the jig developed for this purpose.

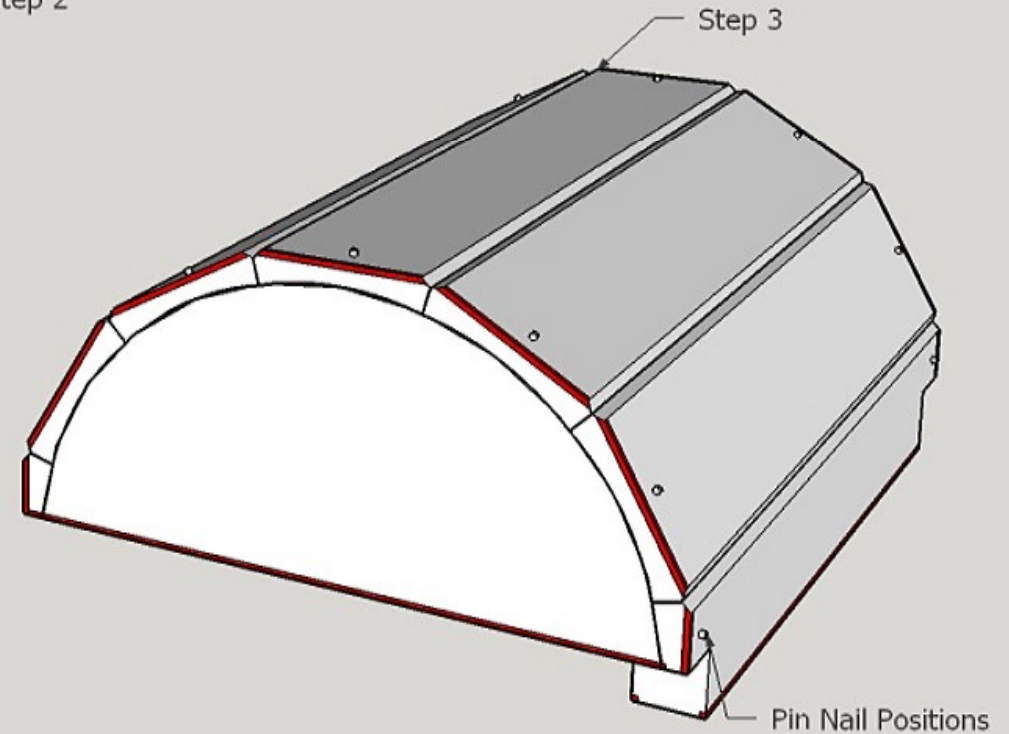
- Step 2: A curved rabbet is routed in both ends of the Lid using the same jig. The rabbet is nominally 5/8" deep but should be milled so the End Cap sits flush with the slats (Note 1)

(Note; This curve is used to set the dimensions of the End Caps, See Drawing 7, Step 2)

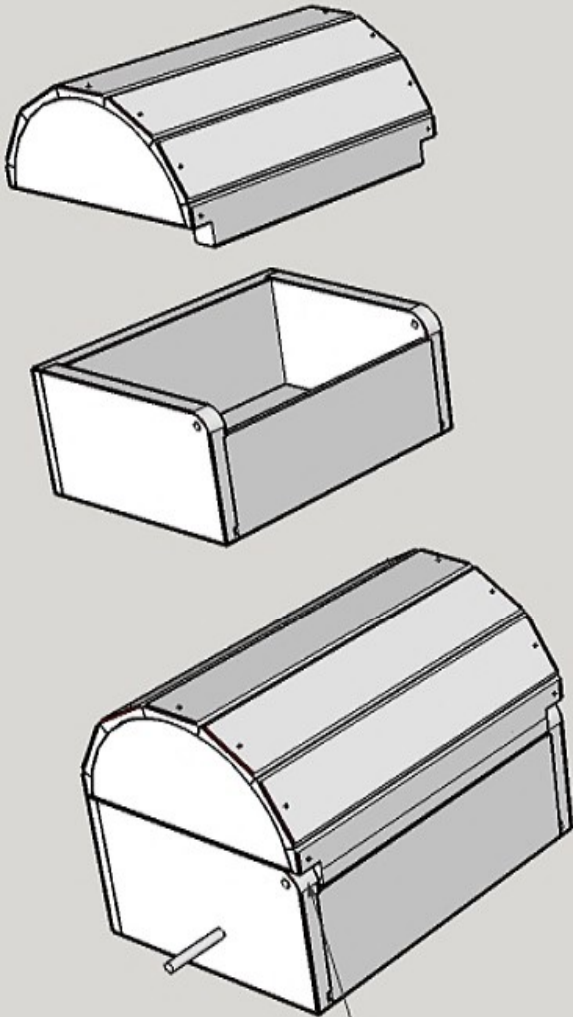
- Step 3: End Caps are glued and brad-nailed into the curved rabbet using 3/4" long, 18 gauge brads



Note 1:
The 5/8" dimension should be adjusted to equal the thickness of the End Caps.



DRAWING 9: FINAL ASSEMBLY



A 23 gage brad goes through the Side and Dowel Pin on both Sides

- Step 1: Place the lid on the box and align the fronts of the lid and the box using the jig made for this.
- Step 2: Set-up a hand-held drill with a 1/4" drill bit. Set a depth marker on the drill to 1 5/8" (See notes 1 & 2)
- Step 3: Insert the drill into the hole that has been drilled in one of the sides and drill into the Hinge Slat until the 1 5/8" depth has been reached. Insert Dowel Pin.
- Step 4: Repeat Step 3 on the other side, the Dowel Pins should protrude slightly.
- Step 5: Using a 23 gage pin nailer, secure the Dowel Pin to the Sides as shown and noted below.
- Step 6: Saw / sand the ends of the Dowel Pins flat.
- Step 7: Sand the completed Treasure chest as necessary.

Regarding the Dowel Pins:

Note 1 - We currently use HDPE (plastic) dowels. If wooden dowels are used, an additional step, slightly enlarging the hole drilled in the Hinge Slat, is required to prevent binding when the Lid is opened.

- Step 4A: Remove the Dowel Pins and lift the Lid off the Box.
- Step 4B: Use a 17/64" or 9/32" drill bit to enlarge the hole in the Lid.

Note 2 - HDPE dowels are often not exactly 1/4". Most often, they are 17/64" so the drill used in Step 2 above needs to be selected to match the dowels.

Drawing 10: PURCHASES

Pad locks:

Hasps: Ace Hardware

HDPE Dowels: Grainger.com, Part Number: 22JL42