



# Assembly aids

Efficiently install Blum hardware



Blum, Inc. is a leading manufacturer of functional hardware for the kitchen cabinet and commercial casegoods industries specializing in concealed hinges and drawer runner systems. Virtually all of the hardware needed to assemble and make cabinets functional are available within the wide range of quality Blum products.

Blum's manufacturing and distribution facility in Stanley, North Carolina supplies the North American markets through a network of more than 150 dependable distributors. Wholly owned by the Blum family, the company was formed in 1952 by Julius Blum and is headquartered in Hoechst, Austria.

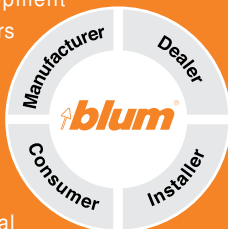
#### Global customer benefits

Product development

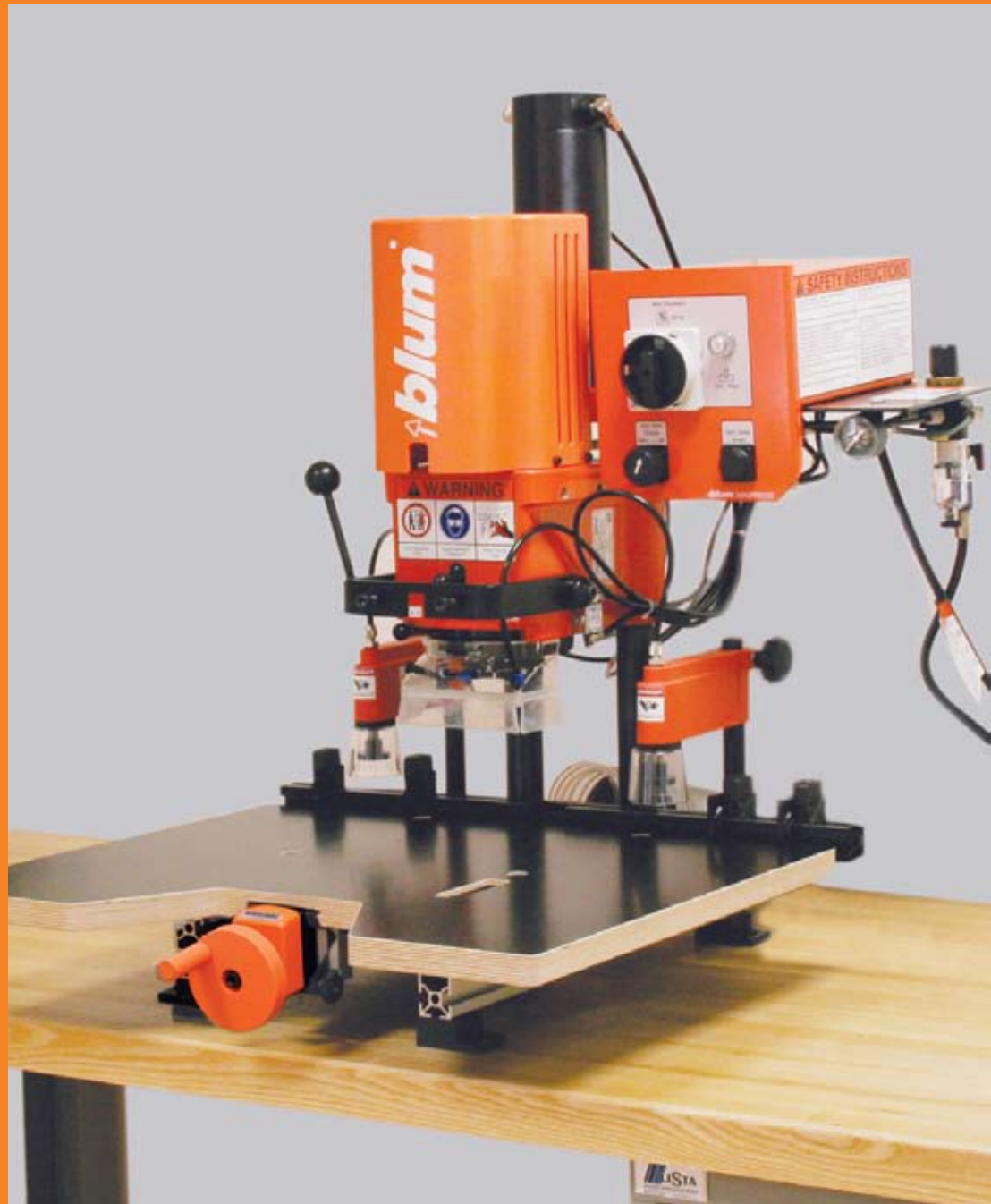
at Blum considers all of the various customers who will come in contact with our products.

With this "Global Customer Benefits"

philosophy we strive to create advantages for all users from the manufacturer to the end consumer.



Blum, Inc. is ISO 9001 certified which means that you are assured of consistent quality in every Blum product. What's more they exceed the requirements of ANSI-BHMA standards for cycle life, static load and self-closing performance. Contact your local Blum representative for more details.



#### Machines

Blum's MINIPRESS is the essential tool for fast, accurate assembly of all Blum hardware. This single machine can be used to install hinges, mounting plates, drawer front-fixing brackets or assembly fittings. Cabinet line boring can also be accomplished economically and efficiently. The MINIPRESS has a line of multi-spindle heads available for

line-boring of cabinet sides and multiple boring of drawer fronts.

Blum's MINIDRILL is an economical machine that bores the Blum hinge pattern in one mode and three 32mm spaced holes in the second mode. It is ideal for use with INSERTA hinges and METABOX or TANDEMBOX drawer components.



## Assembly aids

There are a multitude of assembly aids available for both hinge, drawer and lift system assembly. These aids include but are not limited to: ECODRILL, a low-cost boring device that works with an electric or cordless hand drill to bore Blum's hinge pattern right on the job site; ECOJIG, a simple device for boring Ø5mm holes for

mounting plates; PlateMate, designed to precisely locate pilot holes for CLIP overlay or inset adapter plates. Cabinet profile template, an accurate tool for positioning drawer runners. BOXFIX M, designed for simple and easy assembly of TANDEMBOX drawers.



## DYNALOG LE

DYNALOG LE is software from BLUM for planning panel cabinets and ordering the hardware for those cabinets. It contains DYNACAT (an electronic product catalog) as well as DYNAPLAN (software with all

important tools for cabinet planning and dimension calculation). In DYNASHOP (shopping basket), you can merge data from both applications into a ready-to-order project.





# Table of contents



## **Boring and insertion machines: Custom-built versatility**

Our wide range of boring and insertion machines are well equipped to deal with any assembly situation.

### **MINIPRESS P - Deluxe boring and insertion machine**

**Page 6**

The MINIPRESS P Deluxe is a boring and insertion specialist. Once set up, the MINIPRESS P is great for dealing with frequently used boring patterns.

### **MINIPRESS P - Standard boring and insertion machine**

**Page 8**

MINIPRESS P Standard is a more cost effective boring and insertion machine.



### **MINIDRILL - Standard boring machine**

**Page 10**

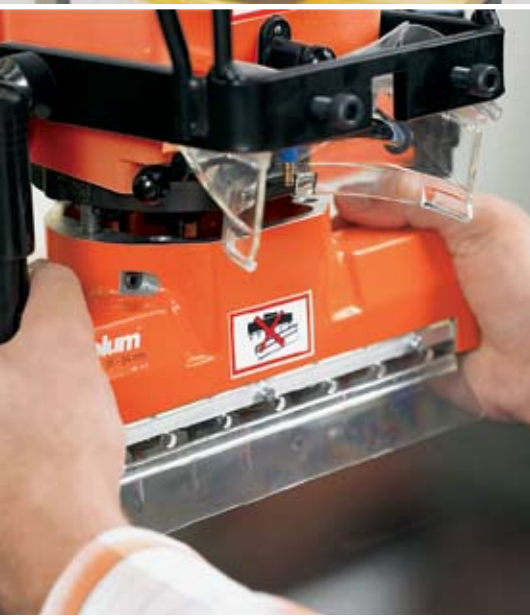
The MINIDRILL is a simple and efficient machine for boring all Blum products.



### **MINIPRESS M - 110V manual boring and insertion machine**

**Page 12**

The Blum MINIPRESS M is a compact boring and insertion tool. It can be used in the workshop or on-site for reliable product assembly.



### **Machine accessories**

**Page 14**

Blum offers a variety of multi-spindle boring heads, insertion rams and general accessories.



### Hinge assembly

Page 16

Many options are offered for the simple and precise transfer, marking and boring of Blum hardware.



### Drawer assembly

Page 23

You can now optimize drawer assembly using practical tools customized to your requirements.



### Assembly accessories

Page 30

Blum offers a variety of accessories for product assembly.



### DYNALOG LE

Page 31

Optimize your cabinet planning and increase your productivity using the DYNALOG LE planning and ordering software.

# MINIPRESS P - Deluxe boring and insertion machine

## A classic boring and insertion machine

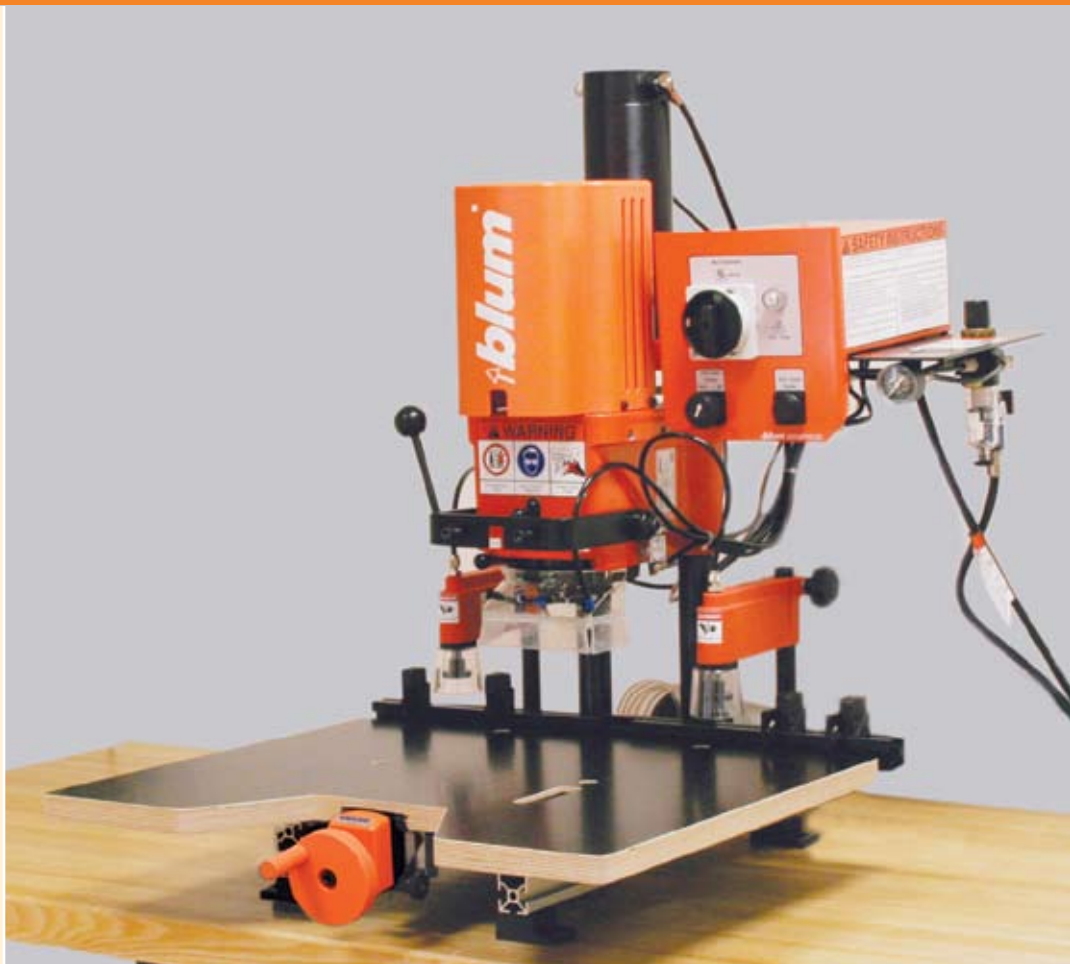
As a boring and hardware insertion specialist, MINIPRESS P takes on the routine jobs in the workshop producing precise assembly results for cabinets, doors, drawer fronts and lift systems. Once set, the desired boring pattern can be quickly made or the desired hardware quickly inserted.

### Features:

- Front adjustable boring distance with digital counter
- Pneumatic hold down clamps
- Improved boring depth adjustment
- Improved positioning stops (4)
- Tool kit included
- Dust collection attachment
- Accepts optional 7 or 8 spindle boring heads

### Recommended for:

- Hinges: Boring/Insertion (press-in)
- Mounting plates: Boring/Insertion (press-in)
- Drawer front: Boring/Insertion (press-in)



One position of the head is dedicated to the 3-hole Blum hinge boring pattern.

An optional 7 or 8 spindle boring head can be used for boring 32mm system hole groups and can be used for drawer front boring and assembly.

## MINIPRESS P - Deluxe equipment

- Center ruler
- Work table
- (4) ruler stops
- (2) fixed boring depth stops
- Tool kit
- Replacement break away clutch

Single phase - 220V power

Laser center line optional.

Three phase - 220V power

Laser center line optional.

Three phase - 440V power

No laser center line option.

Part No.

M53.1053.US

M53.1004.US

M53.1005.US

### Optional items:

- Laser center line kit

MZR.5300.01

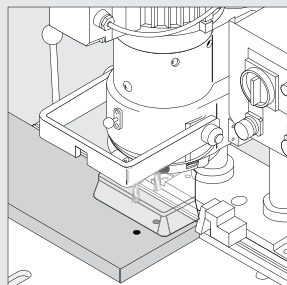
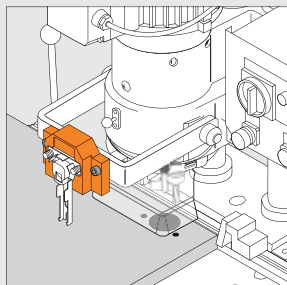
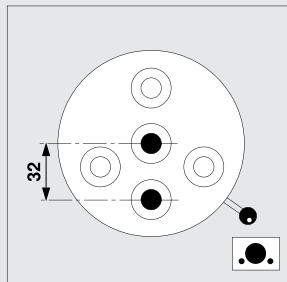
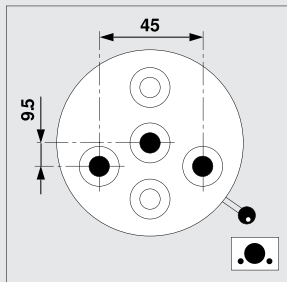


## Boring configurations

### At hinge pattern position

Blum hinge boring pattern

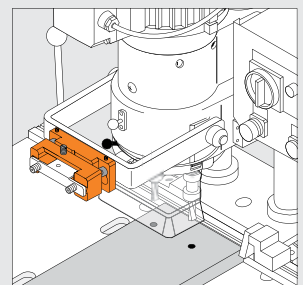
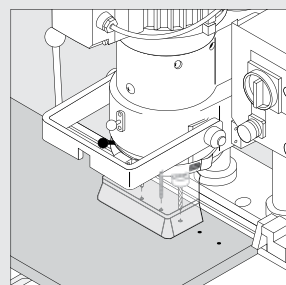
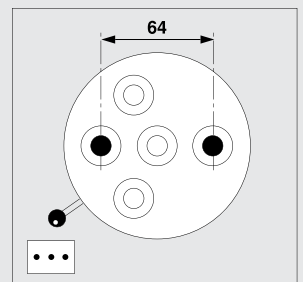
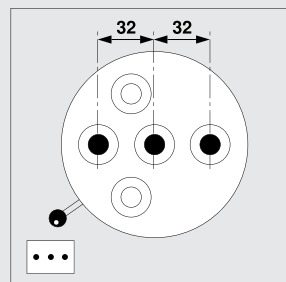
TANDEMBOX front fixing brackets and METABOX 320N front fixing brackets, in-line, press-in mounting plates



### At line-boring position

3-hole line-boring and METABOX 320/330 M, K and H front fixing brackets

METABOX 320/330 M, K and H front fixing brackets



#### 5 spindle swiveling head

Multiple patterns are achieved by turning the head 90°.



#### Depth adjustment

The boring depth is set using an adjustment wheel.



#### Accurate ruler adjustment system

Precise boring distance adjustment can be achieved with new front adjustment handle. (digital scale optional)

# MINIPRESS P - Standard boring and insertion machine

## A classic boring and insertion machine

MINIPRESS P Standard is a more cost effective boring and insertion machine. The MINIPRESS P Standard is an efficient machine designed to bore all hinge and mounting plate systems, METABOX and TANDEMBOX front fixing brackets, METABOX C-15 drawer components and 3-hole line boring of cabinet sides.

### Features:

- Pneumatic hold down clamps
- Improved boring depth adjustment
- Improved positioning stops (4)
- Tool kit included
- Dust collection attachment
- Accepts optional 7 or 8 spindle boring heads

### Recommended for:

- Hinge boring and insertion (press-in)
- Mounting plate boring and insertion (press-in)
- Drawer front boring and insertion (press-in)



## MINIPRESS P - Standard equipment

- Center ruler
- Work table
- (4) ruler stops
- (2) fixed boring depth stops
- Tool kit
- Replacement break away clutch

Single phase - 220V power

Laser center line, digital counter and hold down clamps optional.

Part No.

**M53.1053.UB**

One position of the head is dedicated to the 3-hole Blum hinge boring pattern.

An optional 7 or 8 spindle boring head can be used for boring 32mm system hole groups and can be used for drawer front boring and assembly.

### Optional items:

- Laser center line kit
- Digital counter kit
- Hold down clamp kit

**MZR.5300.01**

**MZE.2110**

**M53.0720.US**

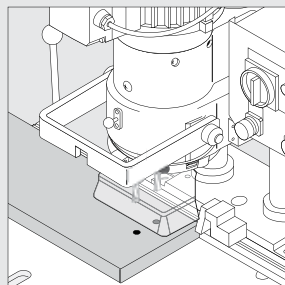
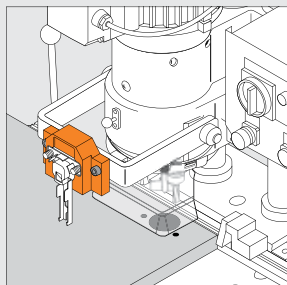
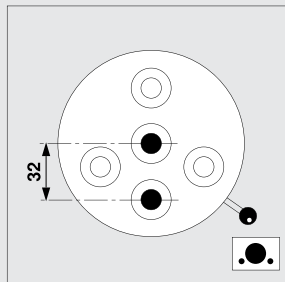
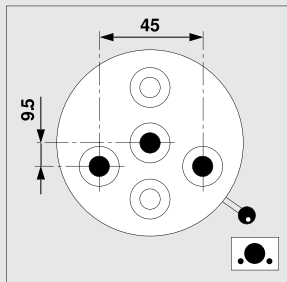


## Boring configurations

### At hinge pattern position

Blum hinge boring pattern

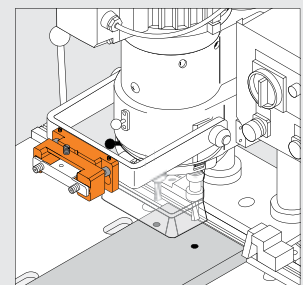
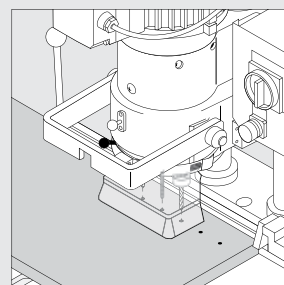
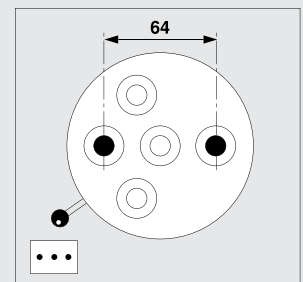
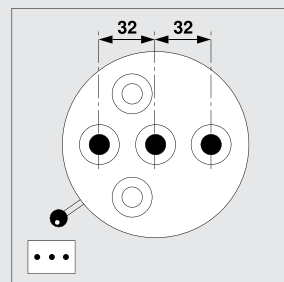
TANDEMBOX front fixing brackets and METABOX 320N front fixing brackets, in-line, press-in mounting plates



### At line-boring position

3-hole line-boring and METABOX C-15 drawer parts

METABOX 320/330 M, K and H front fixing brackets



#### 5 spindle swiveling head

Multiple patterns are achieved by turning the head 90°.



#### Depth adjustment

The boring depth is set using an adjustment wheel.



#### Accurate ruler adjustment system

Precise boring distance can be achieved and viewed with new front adjustment handle and view window.

# MINIDRILL P - boring machine

## An efficient assembly device

The MINIDRILL P is a simple and efficient machine designed to bore all hinge and mounting plate systems, lift systems, METABOX and TANDEMBOX front fixing brackets, METABOX C-15 drawer components and 3-hole line boring of cabinet sides.

### Features:

- Front adjustable boring distance
- Improved boring depth adjustment
- Improved positioning stops (4)
- Tool kit included
- Dust collection attachment
- Accepts optional 7 or 8 spindle boring heads

### Recommended for:

- Hinge boring
- Mounting plate boring
- Drawer front boring



One position of the head is dedicated to the 3-hole Blum hinge boring pattern.

An optional 7 or 8 spindle boring head can be used for boring 32 mm system hole groups and can be used for drawer front boring and assembly.

## MINIDRILL P equipment

- Center ruler
- Work table
- (4) ruler stops
- (2) fixed boring depth stops
- Tool kit
- Replacement break away clutch

Part No.

Single phase- 220V

M53.1053.50

Optional hold down clamps, laser center line and digital counter.

Three phase - 220V

M53.1004.50

Optional hold down clamps, laser center line and digital counter.

Three phase - 440V

M53.1005.50

Optional hold down clamps and digital counter.

No laser center line option.

### Optional items:

- Laser center line kit
- Digital counter kit
- Hold down clamp kit

MZR.5300.01

MZE.2110

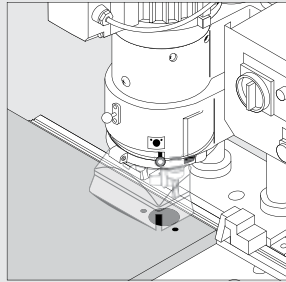
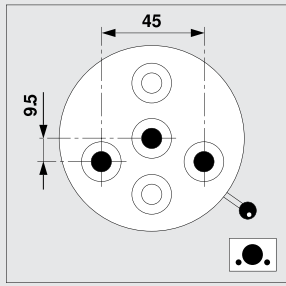
M53.0720.US



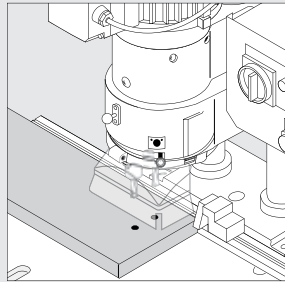
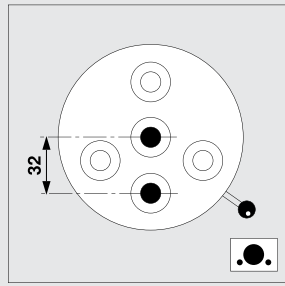
## Boring configurations

### At hinge pattern position

Blum hinge boring pattern

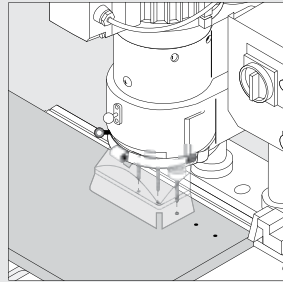
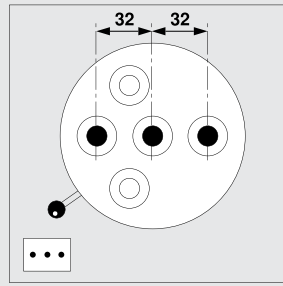


TANDEMBOX front fixing brackets and METABOX 320N front fixing brackets, in-line, press-in mounting plates

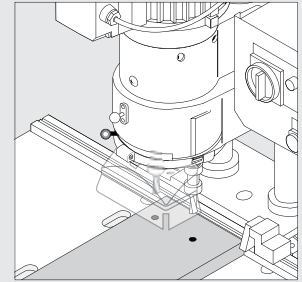
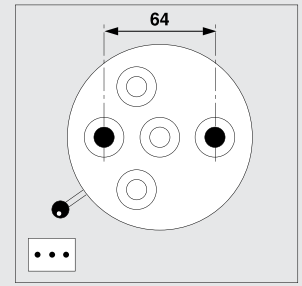


### At line-boring position

3-hole line-boring and METABOX C-15 drawer parts



METABOX 320/330 M, K and H front fixing brackets



#### 5 spindle swiveling head

Multiple patterns are achieved by turning the head 90°.



#### Depth adjustment

The boring depth is set using an adjustment wheel.



#### Accurate ruler adjustment system

Precise boring distance can be achieved and viewed with new front adjustment handle and view window.



# MINIPRESS M - 110V manual boring and insertion machine

## The compact, practical tool

The MINIPRESS M from Blum is a robust tool that is flexible enough to be used in the workshop or on-site. This manual machine operates on 110 voltage and does not require pressurized air. The machine is a simple and efficient machine designed to bore all hinge and mounting plate systems, METABOX and TANDEMBOX front fixing brackets, METABOX C-15 drawer components and 3-hole line boring of cabinet sides.

### Features:

- 110V power (portable)
- Does not require pressurized air
- 4 positioning stops included
- Tool kit included
- Dust collection attachment
- Accepts optional 7 or 8 spindle boring heads

### Recommended for:

- Hinge boring and insertion
- Mounting plate boring and insertion
- Drawer front boring and insertion



One position of the head is dedicated to the 3-hole Blum hinge boring pattern.

An optional 7 or 8 spindle boring head can be used for boring 32 mm system hole groups and can be used for drawer front boring and assembly.



## MINIPRESS M equipment

- Center ruler
- Work table
- (4) ruler stops
- (2) fixed boring depth stops
- Tool kit
- Replacement break away clutch

110V power

Boring distance stop kit optional.  
No laser center point option.

Part No.

M52.1056.US

### Optional items:

- Boring distance stop kit

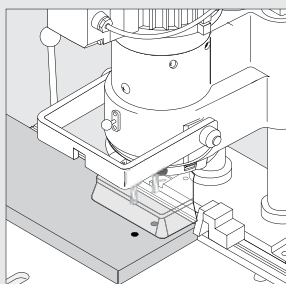
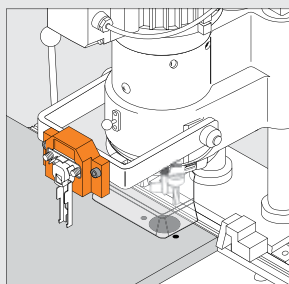
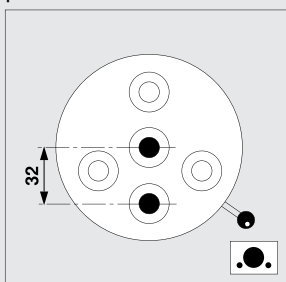
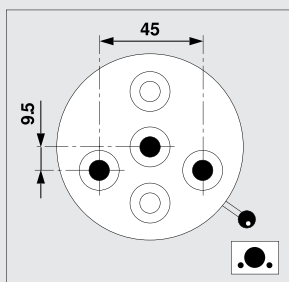
MZS.1020

## Boring configurations

### At hinge pattern position

Blum hinge boring pattern

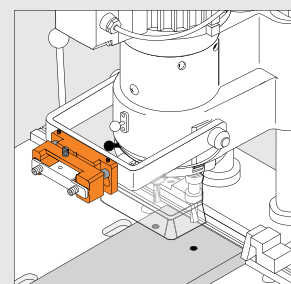
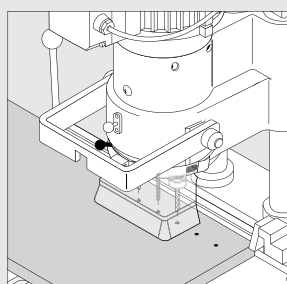
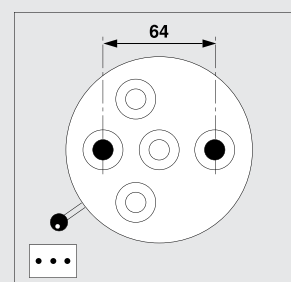
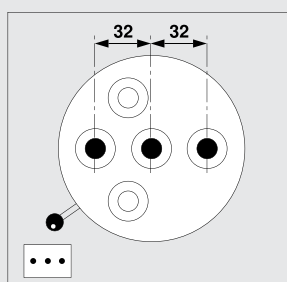
TANDEMBOX front fixing brackets and METABOX 320N front fixing brackets, in-line, press-in mounting plates



### At line-boring position

3-hole line-boring and METABOX 320/330 M, K and H front fixing brackets parts

METABOX 320/330 M, K and H front fixing brackets parts



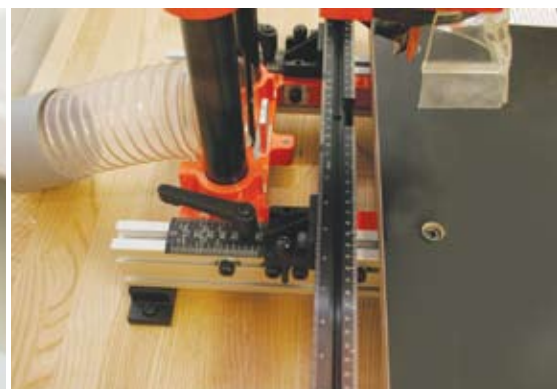
### 5 spindle swiveling head

Multiple patterns are achieved by turning the head 90°.



### Depth adjustment

The boring depth is set using an adjustment wheel.



### Ruler adjustment system

The exact boring distance setting is fixed using the lock handle or using the optional boring distance stop kit.

# Machine accessories

## MINIPRESS 7 & 8 spindle heads



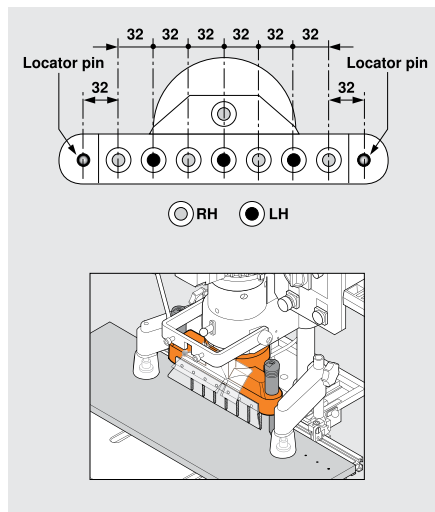
### 7 spindle head features:

- Bores 7 holes, spaced 32mm apart, parallel to the fence
- Retractable index pins located on both sides permit continuous boring
- Bores for 32mm system

7 spindle head

Part no.

**MZK.1000.US**



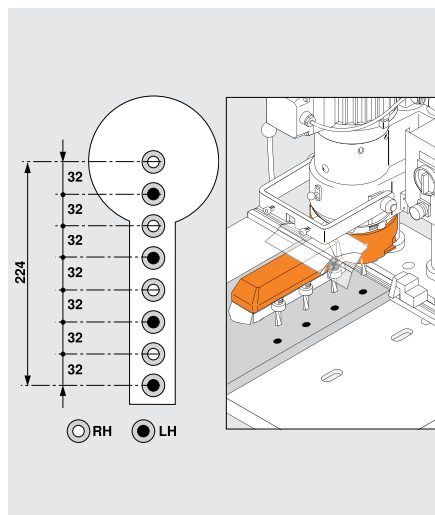
### 8 spindle head features:

- Bores 8 holes, spaced 32mm apart, perpendicular to the fence
- Bores for all METABOX and TANDEMBOX front fixing brackets and galleries
- Bores cabinet side panels for all Blum runner systems (except SOLO)

8 spindle head

Part no.

**MZK.8000.US**



Both heads include: Set-up template and distance spacer for machine stroke depth.

### Accessories (order separately)

- Ø5mm right hand drill bits
- Ø5mm left hand drill bits
- Ø10mm right hand drill bits
- Ø10mm left hand drill bits

Part no.

**M01.ZB05.D2 R**

**M01.ZB05.D3 L**

**M01.ZB10.02 R**

**M01.ZB10.03 L**

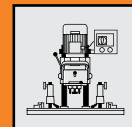
### Replacement parts

- Drive pin
- Depth spacer

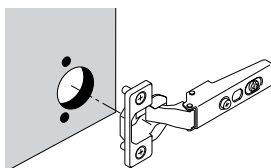
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**MZK.100-14.01**



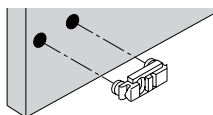


## MINIPRESS insertion rams for hinges



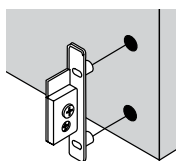
		Part no.
107° and 120° hinges	10	MZM.0010
100° and 95° thick door hinges	11	MZM.0011
170° hinge	18	MZM.0018
Blind corner hinge	19	MZM.0019
Bi-fold hinge	21	MZM.0021
Zero protrusion hinge	22	MZM.0022
COMPACT 33, 38 and 39 series hinges	37	MZM.0037
Modified ram to insert dowels	38	MZM.0038
Replacement pin for 38 ram		MZM.0383

## MINIPRESS insertion rams for mounting plates



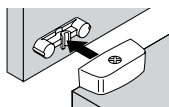
		Part no.
Press-in mounting plate 177H51X0	50	MZM.0050

## MINIPRESS insertion rams for METABOX front fixing brackets



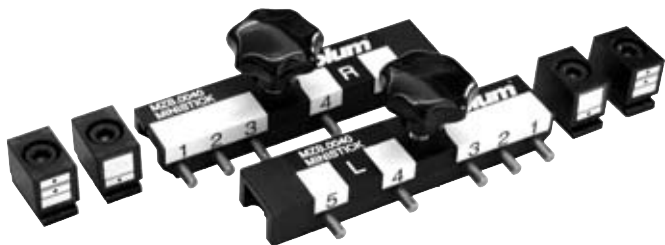
		Part no.
ZSF.1300 / ZSF.1800 for 320/330M, K and H	92	MZM.0092.01
ZSF.1610 for 320N	93	MZM.0093.02

## MINIPRESS insertion rams for RTA drawer and fittings front adjusters



		Part no.
295.1000 drawer front adjuster	95	MZM.0095
40.2110 housing	72	MZM.0072
42.0110.01 housing	77	MZM.0077

## MINISTICK



- Enables process boring for the front fixing brackets of Blum's METABOX and TANDEMBOX drawer systems
- For METABOX C15 bottom and back boring
- Drawer fronts using various runner heights (with or without galleries) can be bored

### Suitable for the following drawers:

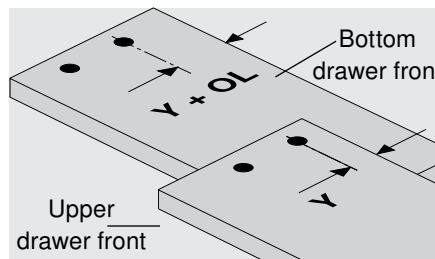
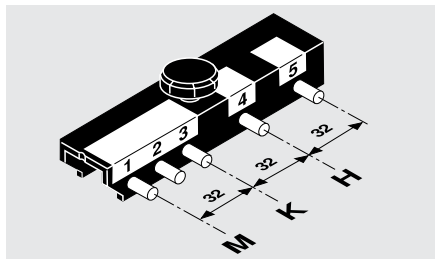
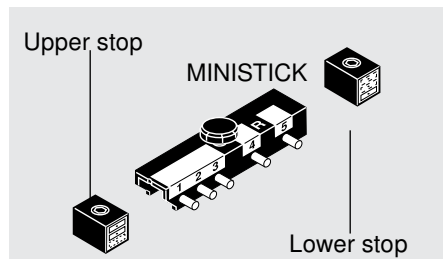
- TANDEMBOX 358N and M
- METABOX 320N, M, K, H
- METABOX 330M and H

Part no.

MINISTICK

**MZS.0040**

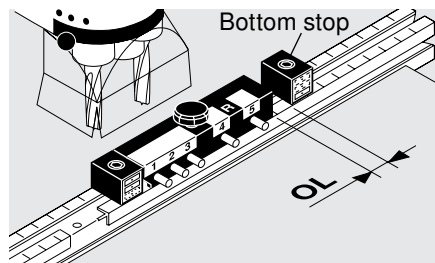
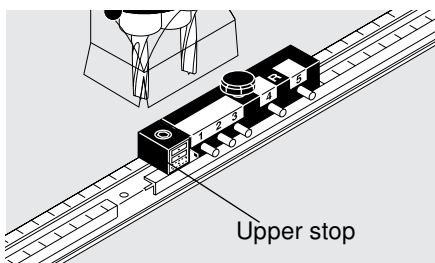
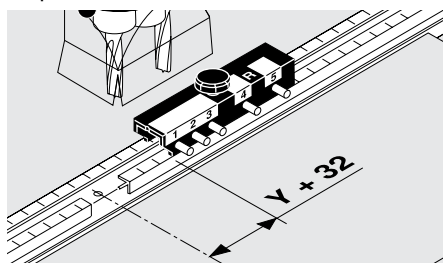
## Using the MINISTICK for METABOX drawer system



MINISTICK components: R & L MINISTICK, (2) upper and (2) lower stops.

Each MINISTICK has five retractable stop pins used for the various drawer heights.

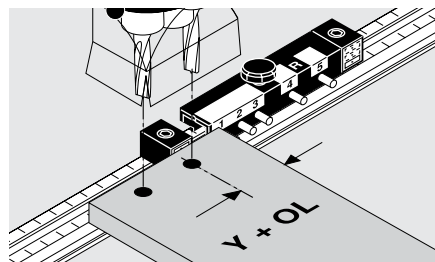
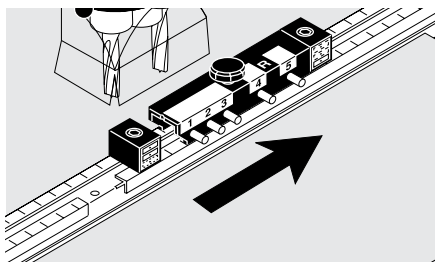
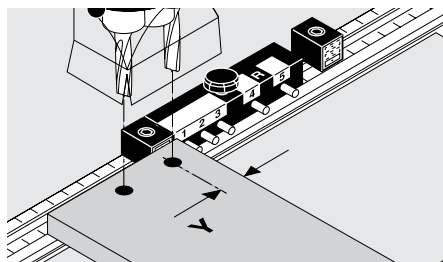
The front fixing bracket holes are located. Bottom drawer fronts are usually different.



Begin set-up for top drawers first. Position MINISTICK at 'Y' distance plus 32mm.

Next, install the upper drawer stop and secure it to the ruler.

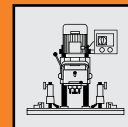
Secure the lower stop at a distance equal to the bottom drawer overlay.



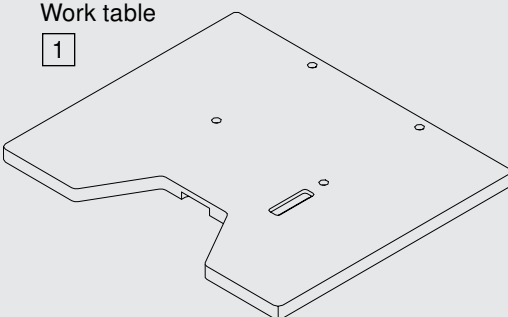
Bore all top drawer fronts. Use pin #1 for M, pin #3 for K and pin #4 for H drawer heights.

To bore bottom drawers, loosen the knob and move the MINISTICK to the lower stop.

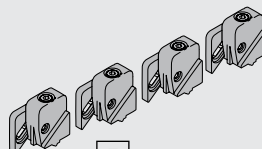
Bore the bottom drawer fronts in the same manner as the top drawer fronts.



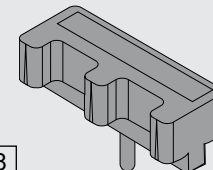
## Machine accessories



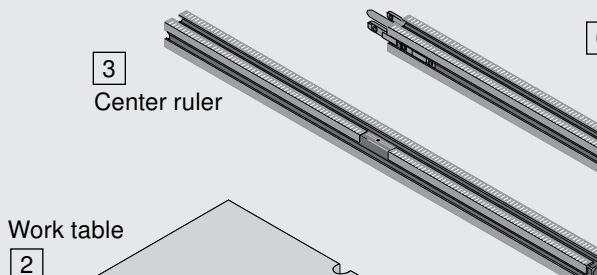
1 Work table



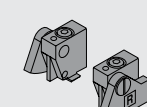
5 Ruler stops



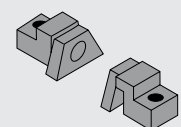
8 Center position indicator



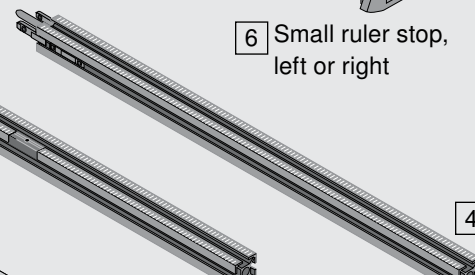
3 Center ruler




6 Small ruler stop, left or right



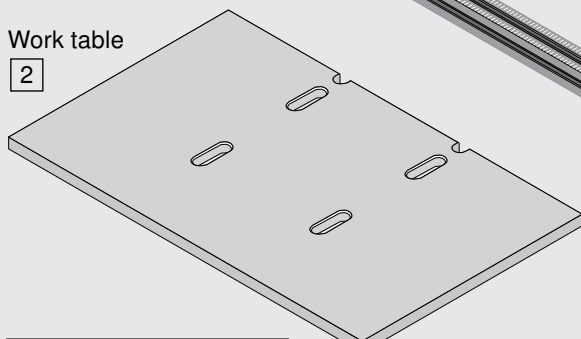
7 Large ruler stop, left or right



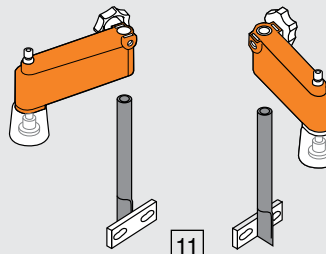
4 Extension ruler



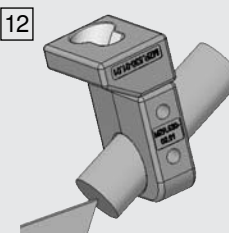
10 Digital counter kit



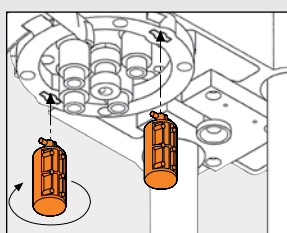
2 Work table



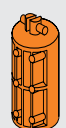
11 Hold down clamp kit



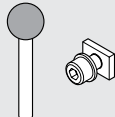
12 Laser center line kit



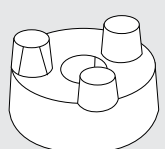
Insertion of fixed depth stops



9 Fixed depth stop



13 Boring distance stop kit



14 Break away clutch

**Accessories** (order separately)

	Part no.
1 Work table for MINIPRESS P / MINIDRILL P	MZA.5300
2 Work table for MINIPRESS M	MZA.1000
3 Center ruler, 600mm	M30.0212
4 Extension ruler, length 1250mm (4')	MZL.1250.US
5 Ruler stop, left or right	MZS.3000
6 Small ruler stop, left or right	MZS.2000
7 Large ruler stop, left or right	MZS.1000
8 Center position indicator	MZR.2000
9 Fixed depth stop for 13mm (1/2")	M30.1304
10 Digital counter kit	MZE.2110
11 Hold down clamp kit	M53.0720.US
12 Laser center line kit	MZR.5300.01
13 Boring distance stop kit (MINIPRESS M only)	MZS.1020

**Replacement part** (order separately)

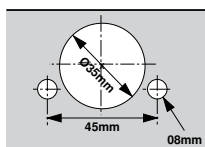
Break away clutch for MINIPRESS and MINIDRILL	MZK.200-90
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# Hinge assembly



## ECODRILL



Blum hinge boring pattern

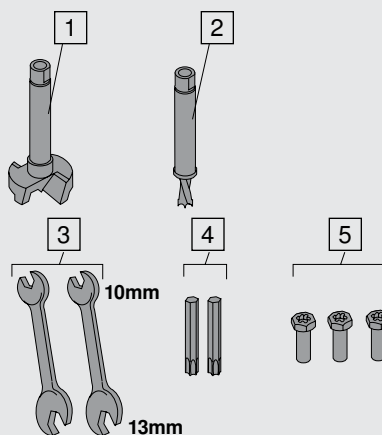
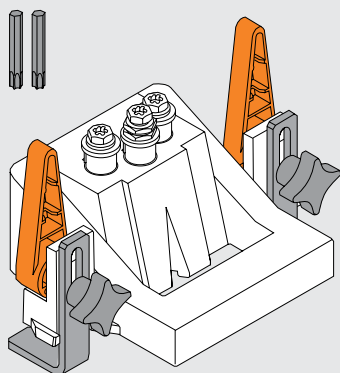
- Simple device for boring Blum hinge pattern
- Driven by electric/cordless drill (14v or better)
- Each drill bit is driven separately and retracts automatically
- Variable boring distance from 2mm to 8mm
- Clamps to various door thicknesses up to 40mm (1-9/16")
- Includes drill bits (pre-installed) and two Torx driver bits

ECODRILL

Part no.

**M31.1000**

### ECODRILL and Torx bits (included)



### Replacement drill bits

- |   |                 |
|---|-----------------|
| 1 | Ø35mm drill bit |
| 2 | Ø8mm drill bit  |

### Tool Set

- |   |                    |
|---|--------------------|
| 3 | 2 wrenches         |
| 4 | 2 Torx driver bits |
| 5 | 3 Torx chucks      |

### Accessories (order separately)

- |   |                 |   |          |
|---|-----------------|---|----------|
| 1 | Ø35mm drill bit |   |          |
| 2 | Ø8mm drill bit  |   |          |
| 3 | 4               | 5 | Tool set |

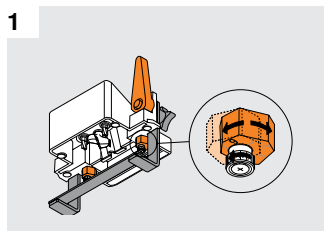
Part no.

**M31.ZB35.02**

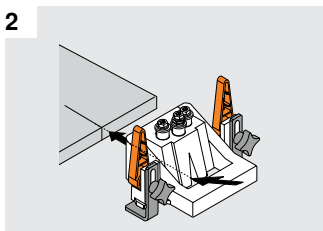
**M31.ZB08.02**

**MZW.1300**

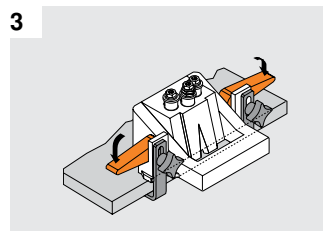
## Using the ECODRILL



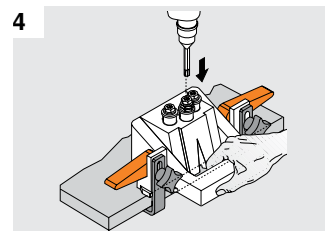
Set boring distance cams by rotating to the desired position.



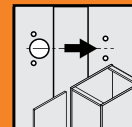
Align ECODRILL body with hinge center line marked on the door.



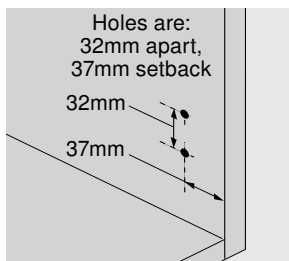
Secure ECODRILL to the door by pushing the clamp arms down.



With the Torx bit inserted into the drill chuck, bore the three holes separately.



## ECOJIG



- Use to bore Ø5mm holes for mounting plates that are mounted with system screws, EXPANDO dowels or INSERTA

- Ø5mm stop collar included

ECOJIG

Part no.

**65.5070**

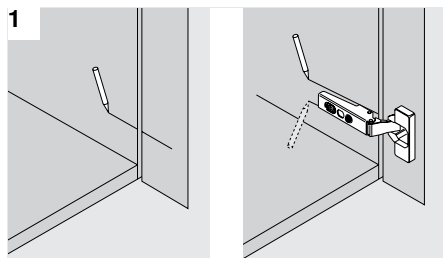
**Accessories** (order separately)

Ø5mm drill bit

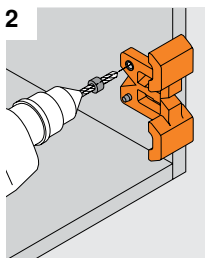
Part no.

**DB-5mm**

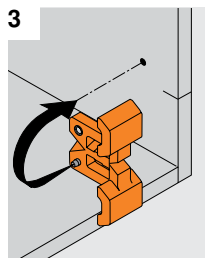
## Using the ECOJIG



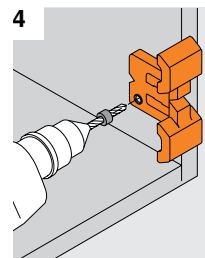
Mark hinge centerline, or hinge arm outline, on cabinet side panel.



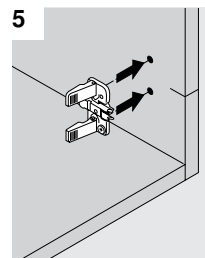
Align template with marks and bore top Ø5mm hole.



Flip template over so locator pin seats into top hole.

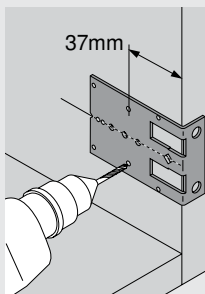


Bore bottom Ø5mm hole.



Install INSERTA, EXPANDO or system screw mounting plates.

## Mounting plate template



- Use with CLIP or MODUL mounting plates on overlay applications in panel cabinets
- Simply locates mounting plate screw positions
- Transfers measurements from door to cabinet
- Pilots Ø2.5mm holes for wood screws

Mounting plate template

Part no.

**65.5300**

**Accessories** (order separately)

Ø2.5mm drill bit

Part no.

**DB-2.5mm**

## Mounting plate knock-in tool



- Magnet holds mounting plate making insertion easier
- Made of hardened steel with durable acrylic handle
- For use with mounting plates 177H5100 and 177H5130

Mounting plate knock-in tool

Part no.

**65.6100**

# Hinge assembly



## BLUMOTION for doors boring template

- For pre-boring BLUMOTION 970.1002
- For all BLUMOTION adapter plates
- 10mm diameter bushing for panel edge boring
- Vertical guides for setting height

### Includes:

- BLUMOTION for doors template
- Ø10mm stop collar
- Ø5mm stop collar
- Ø2.5mm stop collar

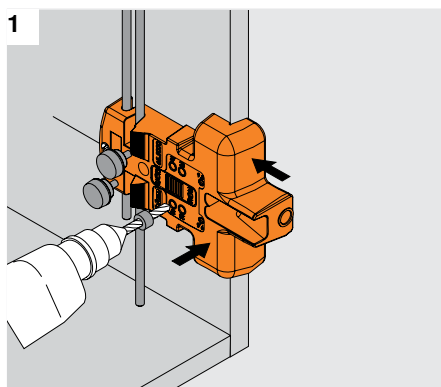
BLUMOTION for doors template

Part no.

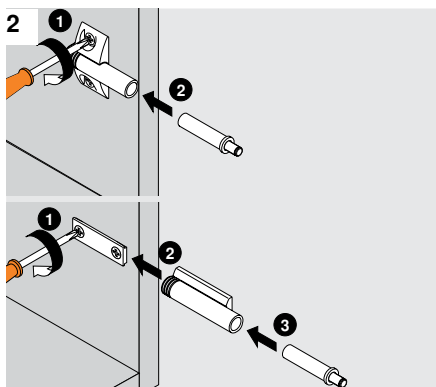
65.5000

## Using the BLUMOTION for doors template

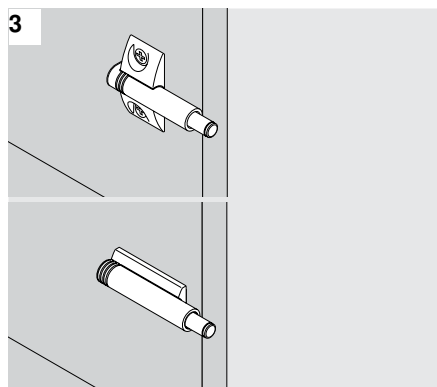
Blum also has various adapter plates for applications including double doors, 32mm line boring and face frame.



Position template on marking line and use a Ø2.5mm or Ø5mm drill bit to bore into cabinet side panel for various BLUMOTION adapter plates.

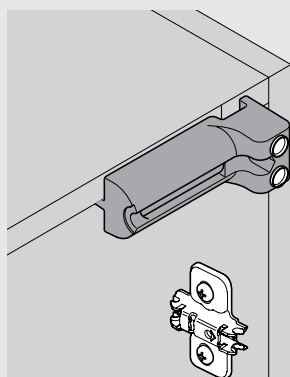


Depending on your mounting plate option, install adapter plate and insert BLUMOTION for doors.



Installation complete.

## BLUMOTION 970A boring template

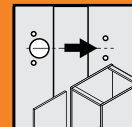


- For pre-boring of BLUMOTION 970A
- 10mm drill bushing for edge boring
- Includes 10mm stop collar
- Universal bores left and right side of cabinet

BLUMOTION 970A boring template

Part no.

65.5010



## QUICKFIX

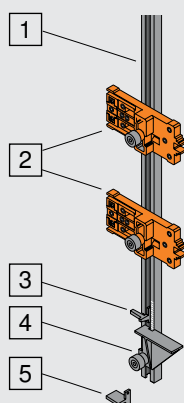


- Simple device to locate hinge and plate positions
- Transfer positions from door-to-cabinet and from cabinet-to-door
- Positions can be transferred from either assembled or unassembled cabinets
- Adjustable stop for various door overlays has calibration to simplify set-up

QUICKFIX

Part no.

65.7500.01



### QUICKFIX parts included

- |   |  |
|---|--|
| 1 | Rail, 1 meter long                     |
| 2 | Template with marking pin (2 included) |
| 3 | Fixed inner stop                       |
| 4 | Adjustable overlay stop                |
| 5 | Fixed outer stop                       |

### Accessories (order separately)

- Additional CLIP template
- MODUL template
- 2.2 meter rail
- Ø5mm drill bit

Part no.

65.7510.01

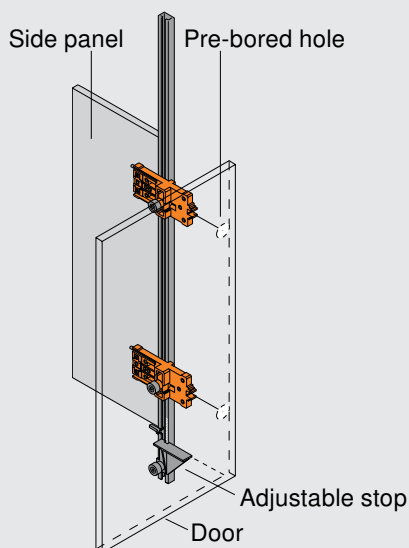
65.9510

65.7590

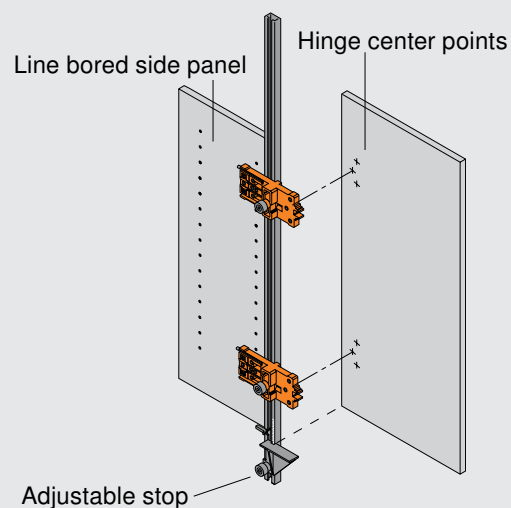
DB-5mm

## Using the QUICKFIX

### Door to cabinet



### Cabinet to door





# Hinge assembly

## PlateMate



- Boring template for all Blum face frame adapter plates
- Clamps to the frame with cam lever. Adjustment knob accommodates frame thickness of 5/8" to 1"
- Spacer screws permit quick use without measuring

### Includes:

- Ø2.5mm pilot bit and extension, Ø5mm stop collar
- Reversible bushing insert for 32mm hole spacing (for 175L6xxx)
- Reversible bushing insert for 40mm hole spacing (for 175H6xxx)

PlateMate

Part no.

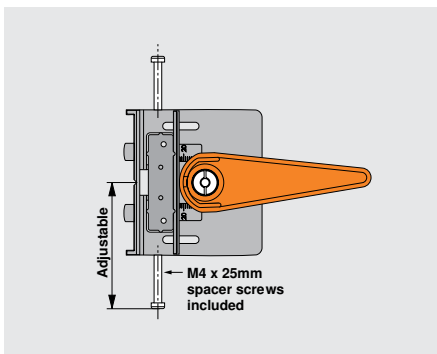
65.5030.01

**Accessories** (order separately)  
Ø2.5mm drill bit

Part no.

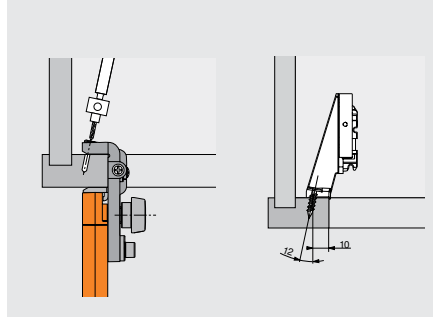
DB-2.5mm

## Specifications

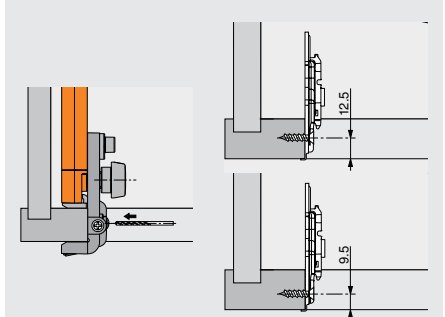


## Using the PlateMate

Boring pilot holes for **inset** face frame adapter plate



Boring pilot holes for **overlay** face frame adapter plate



## Manual doweling template



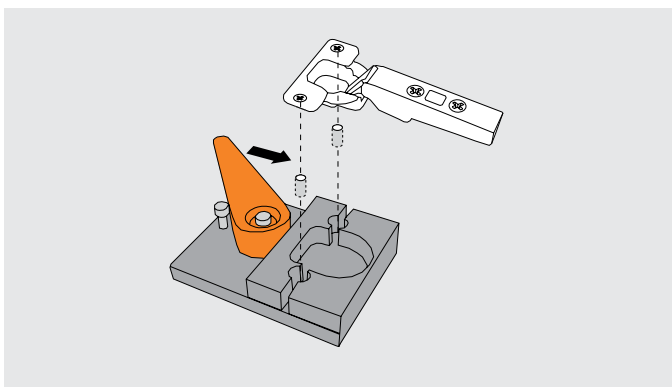
- Template for manually attaching/removing dowels for CLIP top, CLIP, COMPACT and MODUL hinges
- Can be mounted to a work surface for stability
- Works for all Blum hinge and dowel combinations

Part no.

Manual doweling template

69.3600

## Using the manual doweling template

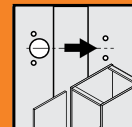


### To remove dowels:

- With the lever in the open position insert hinge with dowels
- Secure hinge by turning orange lever
- Use a POZI driver or drill with POZI bit to remove dowel screws
- Release lever and remove hinge and dowels

### To attach dowels:

- With the lever in the open position insert dowels
- Secure dowels by turning orange lever
- Place hinge in the template
- Use a POZI driver or drill with POZI bit to insert dowel screws
- Release lever and remove hinge and dowels



## INSERTA template

- Used for installing Blum hinges with EXPANDO dowels or INSERTA
- For boring Ø8mm dowel holes after Ø35mm hole is bored
- Boring distance adjusts from 2 to 8mm
- Template for boring Ø5mm holes for system screw mounting plates
- Includes drill stop collar to pilot bore Ø2.5mm for wood screw plates

INSERTA template

**Accessories** (order separately)

Ø8mm drill bit

Ø5mm drill bit

Part no.

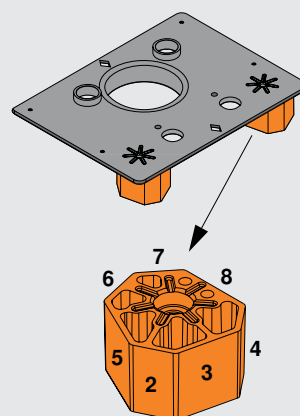
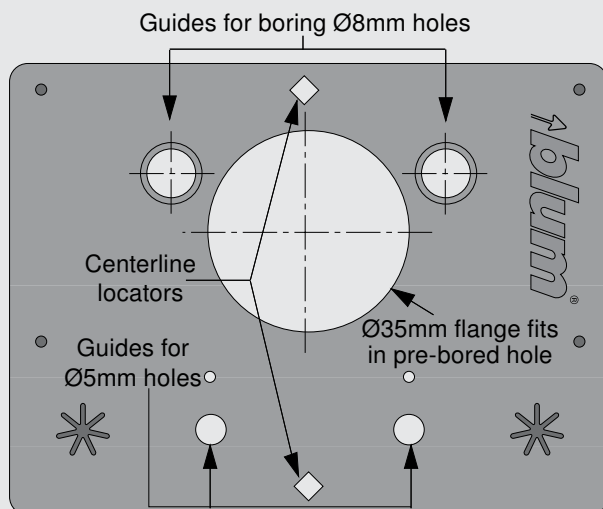
**65.0590**

Part no.

**DB-8mm**

**DB-5mm**

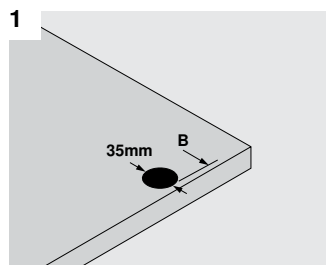
## Specifications



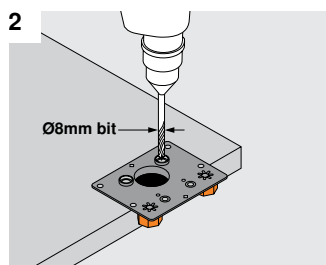
Two rotating cams provide seven boring settings for hinge cups

## Using the INSERTA template

### Using the INSERTA template for hinges

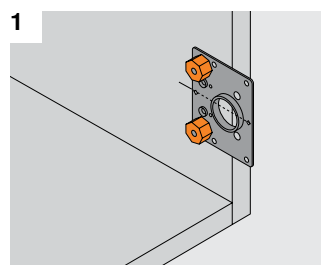


Pre-bore door with Ø35mm bit.

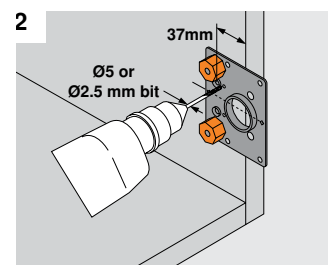


Set boring distance, position in hole and bore Ø8mm dowel holes.

### Using the INSERTA template for mounting plates



Position template on centerline.



Bore holes for mounting plates with Ø5 or Ø2.5mm bit.

# BOXFIX M - TANDEMBOX assembly, simple and easy



## BOXFIX M is designed for TANDEMBOX assembly

BOXFIX M does away with the cluttered assembly of drawer parts on the workbench. Using the new BOXFIX M, you can now assemble TANDEMBOX from an upright position with ease and precision.

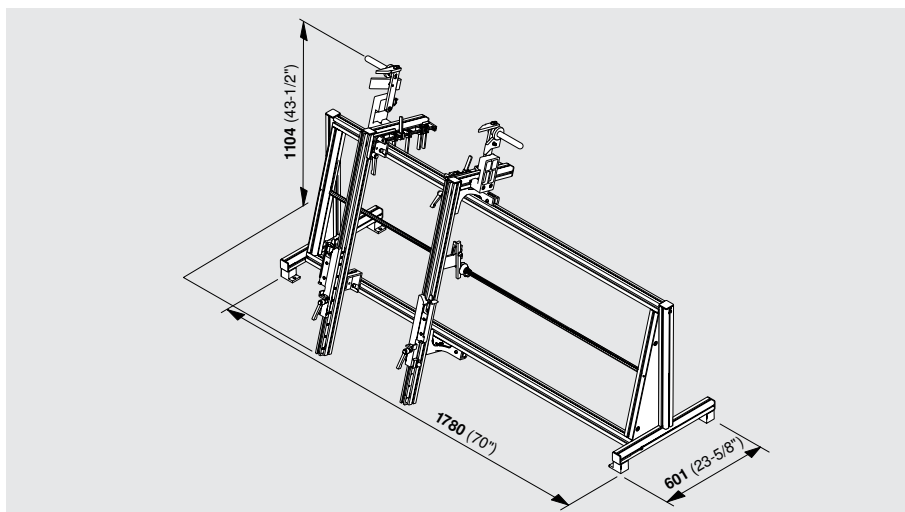
For all drawer side heights (N and M)

- For drawer lengths from 270 to 650 mm
- For cabinet widths from 300 to 1200 mm
- For all back heights up to a max. of 350 mm

Part no.

**ZMM.3350**

## Specifications



Part no.

**MZS.4010**



First attach the rear fixing bracket to the drawer back.

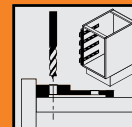


Drawer bottom, profiles and assembled back are then inserted and secured.



Finally, the drawer profiles are attached with screws.

# Drawer assembly



## Cabinet profile template

- For determining cabinet profile positions using the integrated ruler
- Template can be used with assembled or unassembled cabinets
- Ensures precise and level location of cabinet profiles
- Permits quick set-up when using Blum's DYNAPLAN layout software
- Suitable for all Blum drawer runners (except SOLO)

Cabinet profile template

**Accessories** (order separately)  
Ø2.5mm drill bit

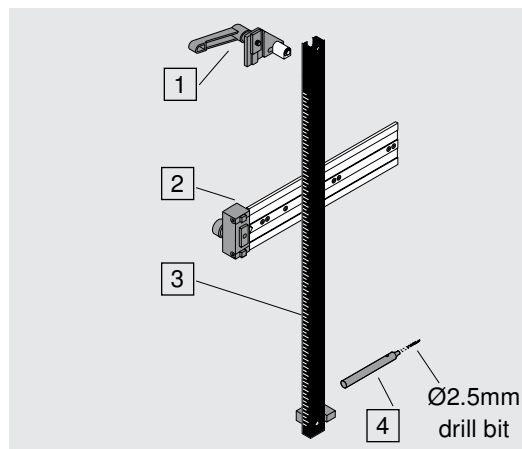
Part no.

**T65.5000.01**

Part no.

**DB-2.5mm**

## Specifications



### Cabinet profile template parts included

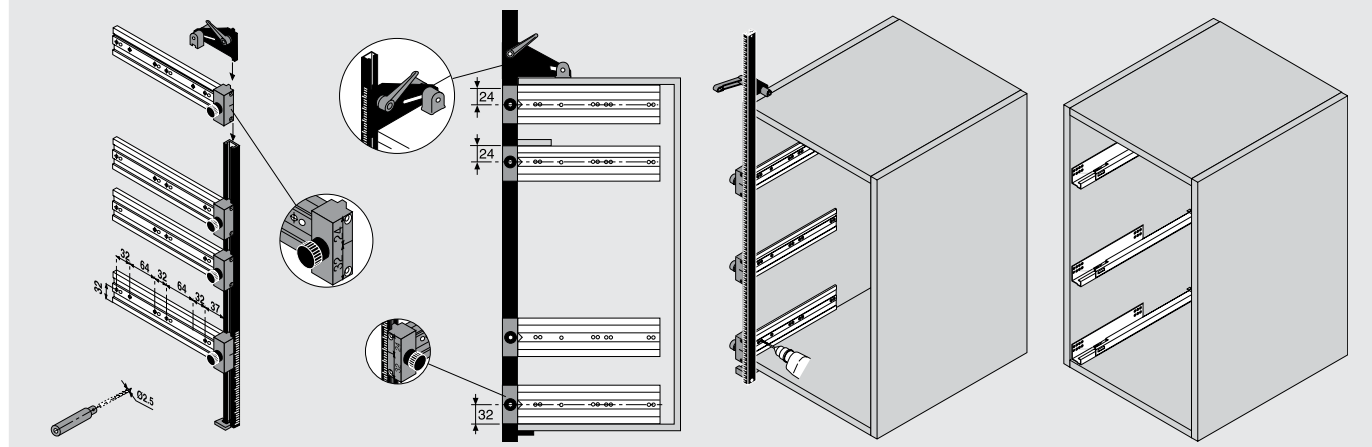
- |   |  |
|---|--|
| 1 | Metric calibrated bar, 1 meter long    |
| 2 | Adjustable templates (4 pcs. included) |
| 3 | Clamping lever                         |
| 4 | Extension for Ø2.5mm drill bit         |

## Using the cabinet profile template

1. Determine runner locations from DYNAPLAN or by manual calculation.
2. Set templates on the bar using the integrated scale.

3. Clamp assembly to the cabinet side.
4. Bore Ø2.5mm pilot holes through templates for front and middle mounting positions.

5. Fasten runners to cabinet sides with wood screws into pre-bored holes.
6. Add screws to back of runner for added strength as required.





# Drawer assembly



## MINIFIX

- Used for positioning cabinet profiles on cabinet sides
- Holds cabinet profile in place while screws are installed or pilot holes are made
- Keeps cabinet profiles level
- Ideal for face frame cabinets when positioning rear mount sockets

### Can be used with the following Blum runners:

- METABOX 320 N, M, K, H
- STANDARD 230M and 230E

MINIFIX

Part no.

65.3300

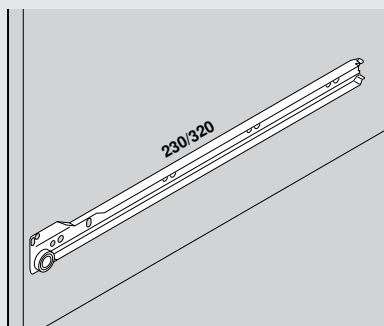
**Accessories** (order separately)  
Ø2.85mm piloting bit

Part no.

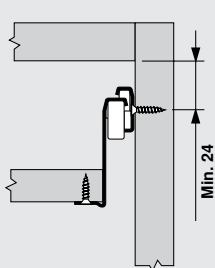
VPB-5

## Using the MINIFIX

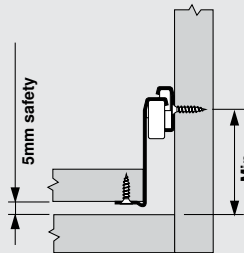
MINIFIX works with Blum 3/4 extension cabinet profiles.



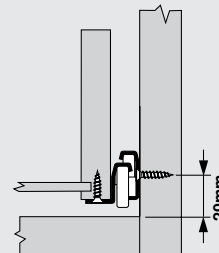
By placing MINIFIX against the top or bottom of the cabinet opening the minimum clearance is automatically set.



METABOX with  
minimum top  
clearance.



METABOX with  
minimum bottom  
clearance by using  
handle scale.



STANDARD 230M  
with minimum  
bottom clearance.

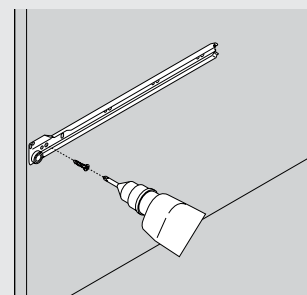
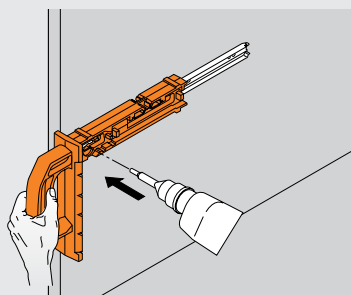
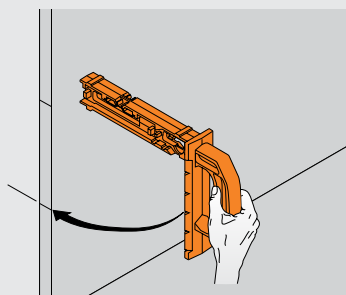
### Using the handle scale with METABOX drawers

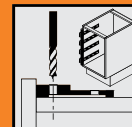
1. Mark on the cabinet front where the bottom of the drawer is to be mounted (includes 5mm safety clearance).

2. Choose the notch on the handle that matches the drawer type.

3. Place cabinet profile in the MINIFIX, hold against the mark and use a piloting bit to bore the mounting holes.

4. Attach the cabinet profiles with wood screws.





## Universal template

- For marking or boring holes for front fixing brackets, drawer backs and bottoms (METABOX C15)

- Works for either overlay or interior drawers

### Suitable for the following drawers:

- METABOX 320/330 N, M, K, H
- TANDEMBOX 358 N, M

Universal drilling template

### Accessories (order separately)

Ø5mm drill bit

Ø10mm drill bit

Part no.

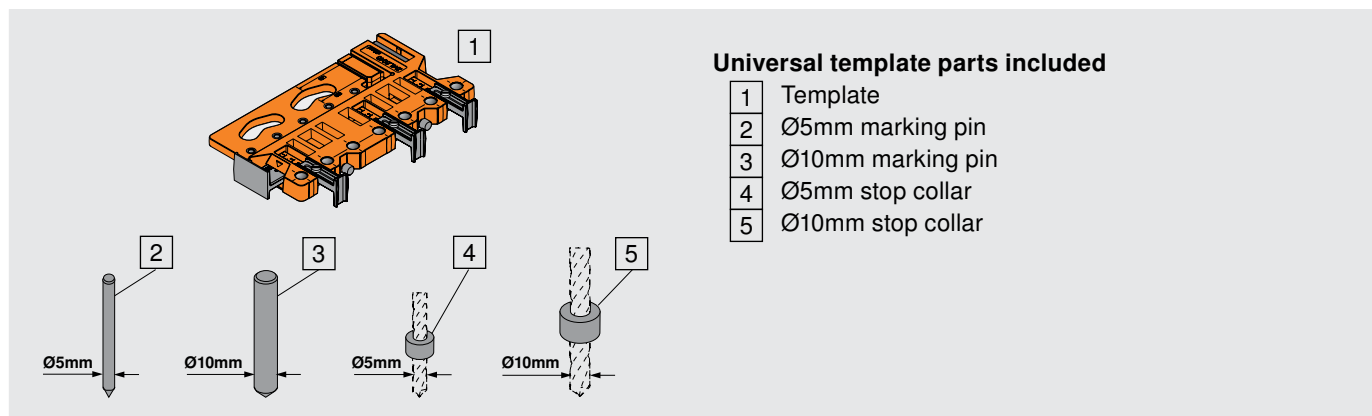
**ZML.0040**

Part no.

**DB-5mm**

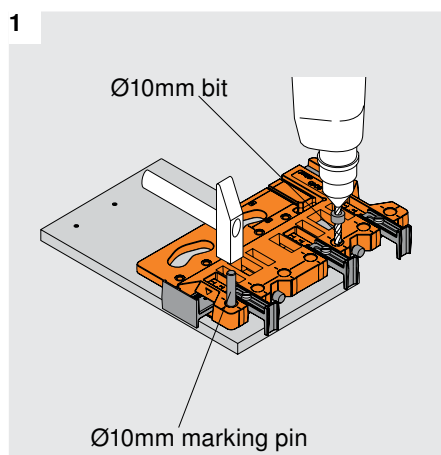
**DB-10mm**

## Specifications

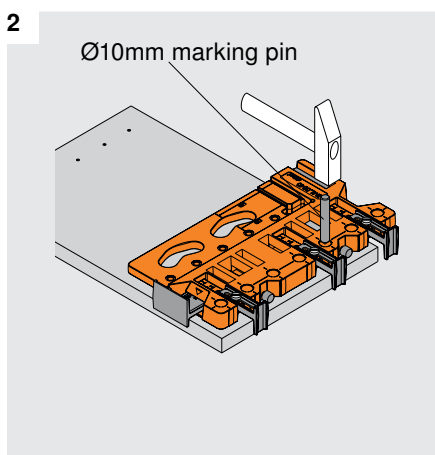


## Using the universal template

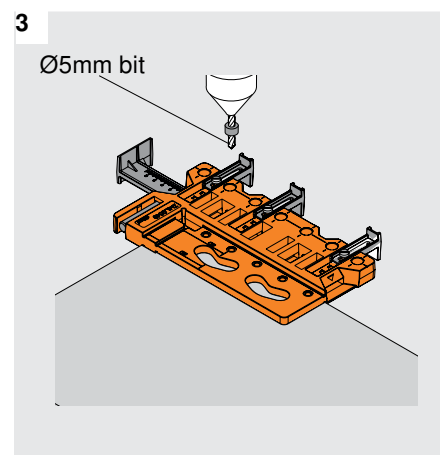
### Example with METABOX C-15 drawer components



Marking and boring drawer front.



Marking drawer back.



Boring drawer bottom.

# Drawer assembly



## Box system front template

- Used for marking the front fixing bracket locations on the drawer fronts for drawers that are already installed in the cabinet
- For one time jobs or production runs
- Eliminates need for calculations and is very accurate

For METABOX 320/330 M,K & H

Part no.

**ZML.1500**

For METABOX 320N

**ZML.1510**

For TANDEMBOX 358M

**ZML.3580**

For METABOX galleries

**ZML.8000.02**

For TANDEMBOX galleries

**ZML.3600**

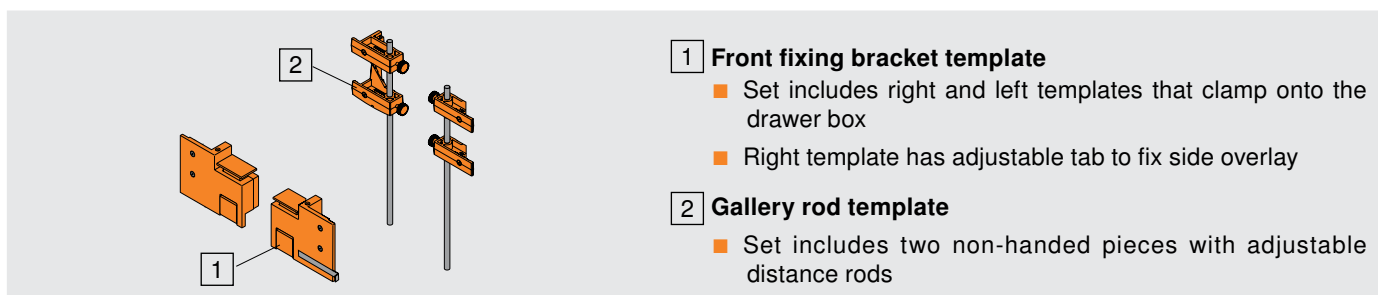
**Accessories** (order separately)

Part no.

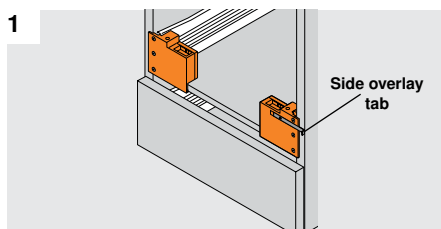
Ø10mm drill bit

**DB-10mm**

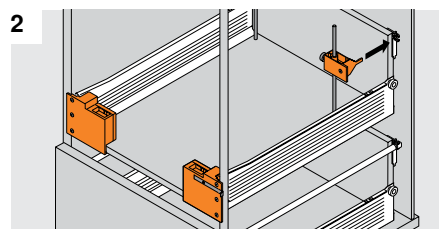
## Specifications



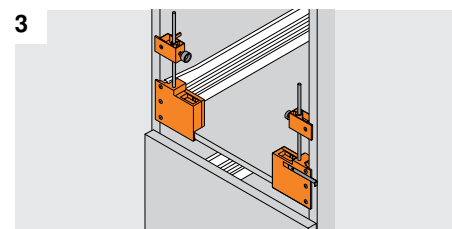
## Using the box system front template



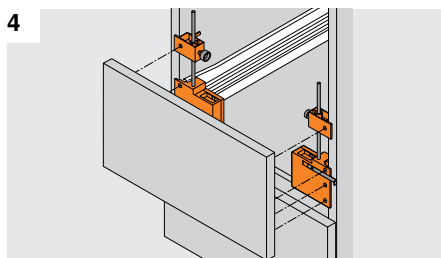
Place marking templates on installed drawer. Place integral spring clamps to drawer bottom.



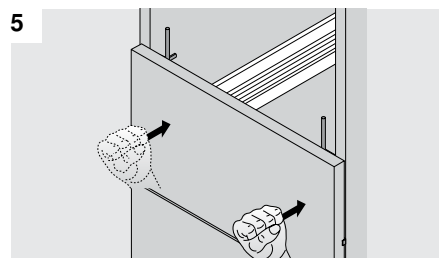
If galleries are used, place gallery template into rear bracket then adjust rod so it rests on the drawer bottom.



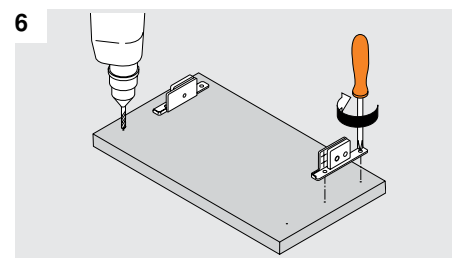
Place gallery templates into the top of the marking templates so that rods rest on the drawer bottom.



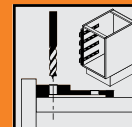
Adjust side overlay tab. Place drawer front against the templates and make sure drawer front is correctly spaced from the drawer front beneath.



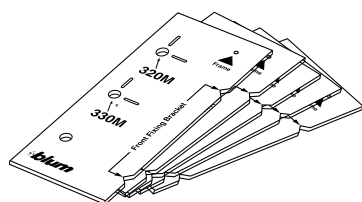
Hold the drawer front in place and tap it by hand to transfer the points of the templates to the back of the drawer front.



Attach the front fixing brackets with wood screws or use the marks to assist in setting up for production boring. Bore Ø10mm holes for INSERTA gallery rods.



## METABOX templates



- A simple system of full scale plastic templates that represent the minimum height requirements for METABOX and have cut outs for marking cabinet profile and front fixing bracket positions.
- The METATEMP kit contains one template each for 320N, 320/330M, 320/330K, 320/330H plus a universal gallery template for all series.

METABOX templates

Part no.

**METATEMP**

## Using the METABOX templates

**Cabinet**

Minimum top clearance

Minimum bottom clearance

320M

330M

Front fixing bracket

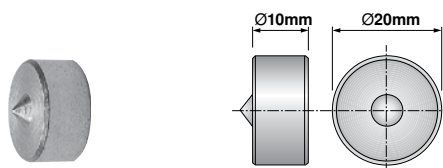
**blum**

**Drawer front**

**The METABOX templates determine if the opening height is adequate for a particular drawer series as its overall size represents the minimum clearance.**

1. Position the template either at the top or bottom of the opening with the front flush with the cabinet edge.
2. Mark the centerline for the appropriate cabinet profile (320 or 330 series) which is pre-set at a 37mm setback.
3. Mark the front fixing bracket locations on the cabinet side at the front V cut outs.
4. Hold the drawer front against the cabinet at the desired height position and carefully transfer the front fixing bracket horizontal center lines.
5. If cabinet is pre-line bored, use Ø5mm shelf pins to position templates on the cabinet side and proceed with steps 3 & 4.

## Drawer front template



- To transfer the center points of the Blum 295.1000 drawer front adjuster from the drawer front to the drawer box
- For drawers using TANDEM, SOLO or STANDARD runners

Part no.

Drawer front template

**65.2950.10**

**Accessories** (order separately)

Part no.

Ø20mm drill bit for center point

**M01.ZB20.02 R**

## Using the drawer front template

**1**

Bore Ø20mm holes in drawer front and insert template.

**2**

Position drawer front in front of installed drawer box.

**3**

Tap drawer front with hand pressure to mark drawer box.

**4**

Bore drawer box for mounting screws.



# Drawer assembly

## TANDEM template



- Essential tool for drawers using TANDEM runners
- To bore the Ø6mm holes for rear hooks
- To pilot bore Ø2.5mm hole for TANDEM standard locking devices at 12° angle

TANDEM template

Part no.

**T65.1000.02**

**Accessories** (order separately)

Ø2.5mm drill bit

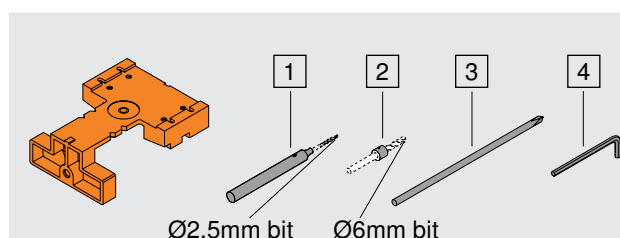
Part no.

**DB-2.5mm**

Ø6mm drill bit

**DB-6mm**

## Specifications



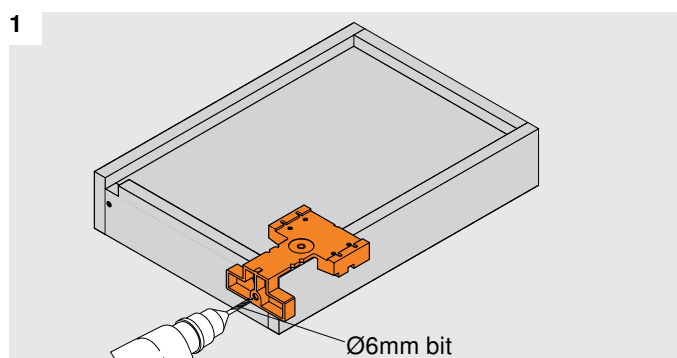
### Tool set

- |   |                            |
|---|----------------------------|
| 1 | Ø2.5mm drill bit extension |
| 2 | Ø6mm stop collar           |
| 3 | Screwdriver tip            |
| 4 | Allen key                  |

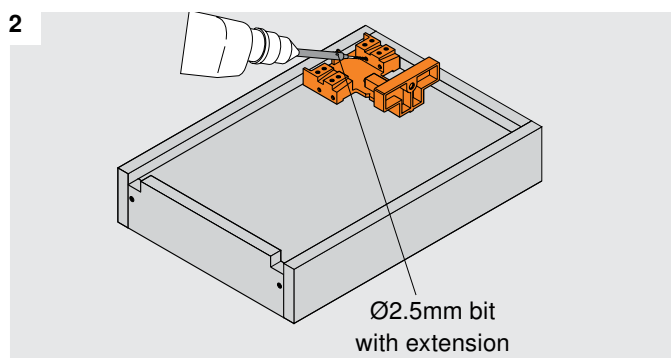
Part no.

**T65.9000**

## Using the TANDEM template

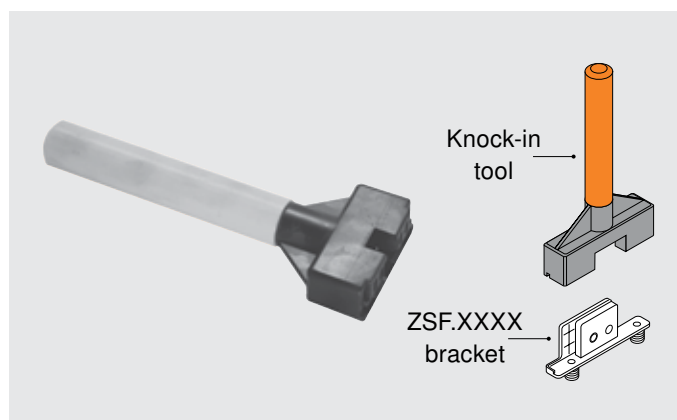


Bore rear fixing holes.



Bore pilot holes for standard locking device screws.

## METABOX front knock-in tool



Knock-in tool

ZSF.XXXX  
bracket

- For manual installation of METABOX press-in front fixing brackets
- For all METABOX heights
- Works with the new Clip-on brackets

**METABOX front knock-in tool**

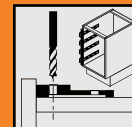
For ZSF.1300/1800 brackets

For ZSF.1610 brackets

Part no.

**ZME.1600.01**

**ZME.1610**



## SYNCROMOTION boring template



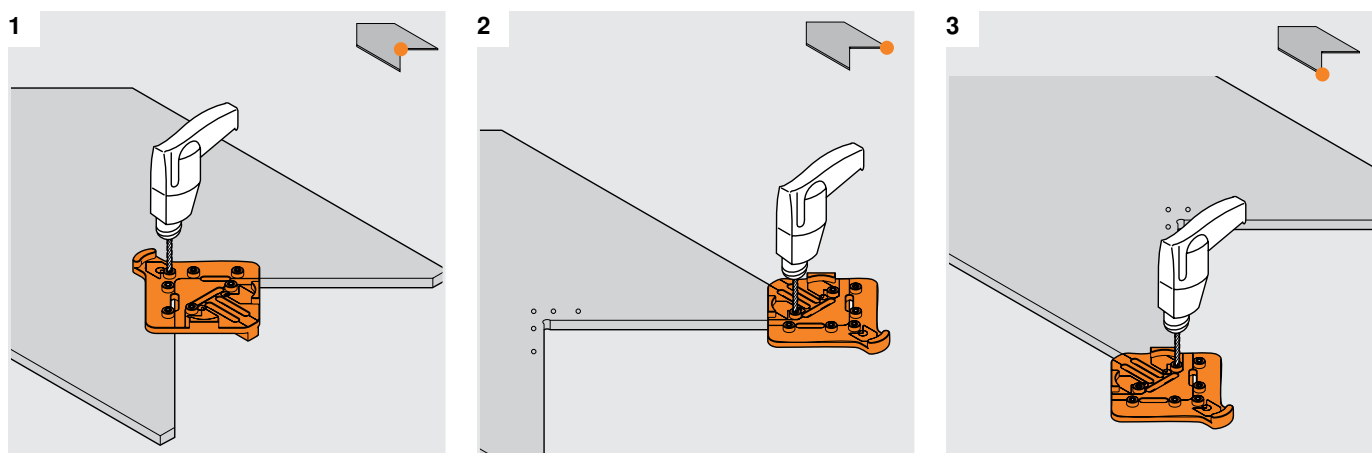
- Essential tool for drawers using SYNCROMOTION
- To bore the Ø5mm holes for the center SYNCRO bracket mounting locations
- To bore the Ø5mm holes for the corner front fixing bracket mounting location

SYNCROMOTION boring template

Part no.

**ZML.0330**

## Using the SYNCROMOTION boring template



## Corner post template



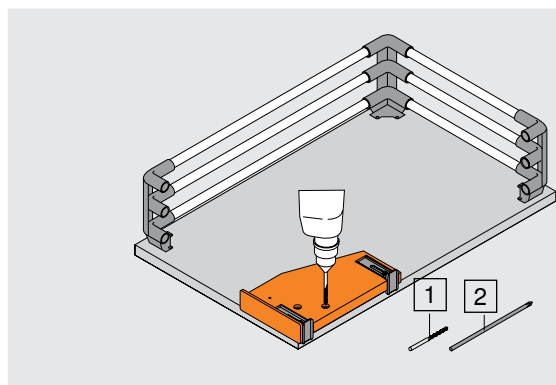
- Used for pilot boring the mounting holes for the corner supports of Blum's interior pullout surround gallery system

Corner post template

Part no.

**ZML.0010**

## Using the corner post template

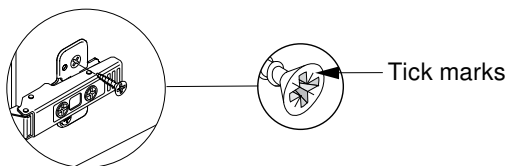
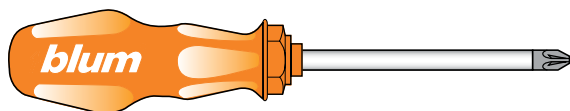


1. Calculate side offset of corner post and set adjustable side stops.
2. Place template on each corner of roll-out shelf and bore Ø2.5mm pilot holes.
3. Use extended screwdriver tip to attach corner post to shelf.

### Corner post template parts included

- |   |                            |
|---|----------------------------|
| 1 | Ø2.5mm drill bit, 3 pieces |
| 2 | Screwdriver tip            |

## POZI screwdriver



A POZI screwdriver (different from Phillips) is the most crucial tool you can use to assure that full torque is applied to all Blum adjustment screws. POZI screws can be identified by the distinctive "tick" marks located in the center of the screw head recess.

Part no.  
#2 POZI driver **POZI DRIVER**

Accessories (order separately)  
1/4" Magnetic bit holder **BIT HOLDER**  
#2 x 1" POZI bit insert **POZI BIT #2x1**  
#2 x 2" POZI bit insert **POZI BIT #2x2**

## Drill bits



Ø5mm



Ø8mm



Ø35mm



Ø10mm



Ø10mm  
with countersink



Ø10mm  
chuck for  
Ø2mm bit



RH  
Ø2.5mm  
twist  
drill bit



Ø2.85mm  
piloting bit  
self-centering

Left handed bits are easily identified by their signature Blum orange color.

Part no.  
Ø2mm twist drill bit, left hand **DB-2mm**  
Ø10mm twist drill bit, right hand **DB-10mm**  
Ø10mm chuck & wrench **DB-10X2mm**  
Ø2.5mm twist drill bit, right hand **DB-2.5mm**  
Ø5mm twist bit, right hand **DB-5mm**  
Ø6mm twist bit, right hand **DB-6mm**  
Ø8mm twist bit, right hand **DB-8mm**  
Ø5mm, right hand **M01.ZB05.D2 R**  
Ø5mm, left hand **M01.ZB05.D3 L**  
Ø8mm, left hand **M01.ZB08.03 L**  
Ø10mm, right hand **M01.ZB10.02 R**  
Ø10mm, left hand **M01.ZB10.03 L**  
Ø20mm, right hand **M01.ZB20.02 R**  
Ø35mm, right hand **M01.ZB35.02 R**  
Ø8mm with countersink, left hand **T108-8mm L**  
Ø10mm with countersink, right hand **T108-10mm R**  
Ø10mm with countersink, left hand **T108-10mm L**  
Ø2.85mm piloting bit, right hand **VPB-5**

## DYNALOG LE



- For planning door and drawer layouts for frameless cabinets using the TANDEMBOX and METABOX drawer system.
- Enter all of the various attributes that are unique to your cabinet construction standards.
- Choose the planning mode: whether point-to-point or within 32mm system constraints.
- Enter drawer and door heights manually or choose automatic.
- DYNALOG LE gives you a component list with dimensions of all drawer and door parts and all boring locations for the hardware.
- Requires Windows® 95, Windows® NT or Windows® XP.

## DYNALOG LE modules

DYNALOG LE

Part no.

**DYA.2413**

### PRO

#### Best suited for high production

- Point-to-point cabinet member location
- Allows for interchangeable drawers
- Identical drawer fronts
- Identical front fixing bracket or drawer front adjuster locations for all drawer fronts

### FREE

#### Provides maximum use of interior space

- Point-to-point cabinet member location
- Identical upper drawer front sizes; bottom drawer is unique because of bottom overlay

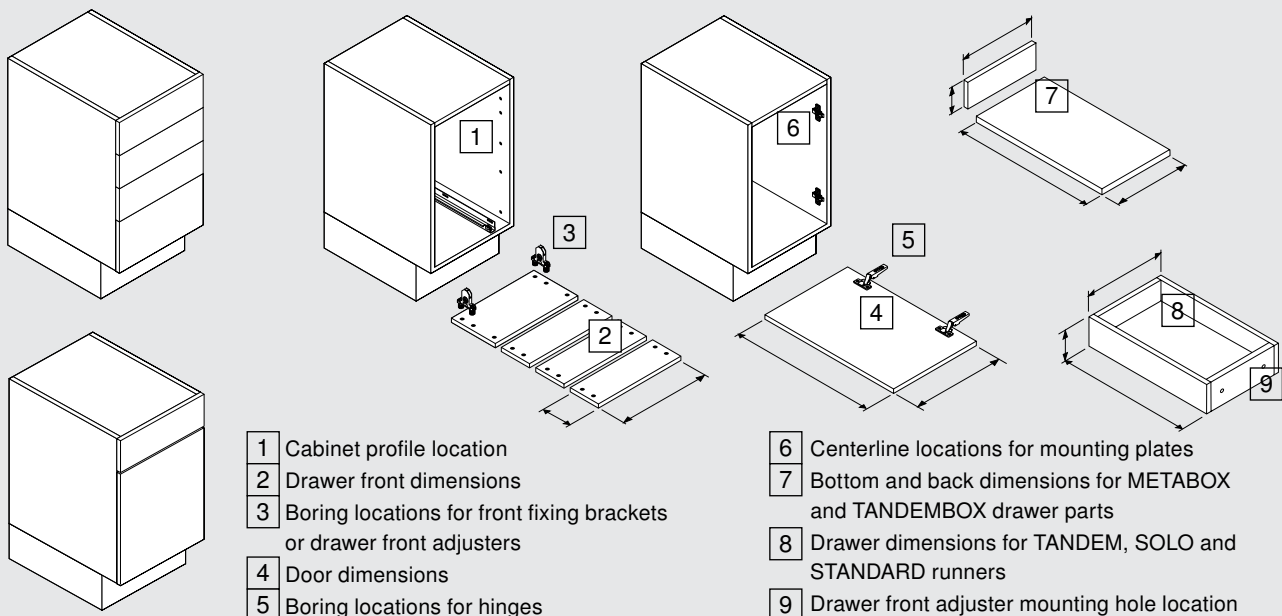
### FREE 32

#### Utilizes 32mm line boring

- Doors and drawer fronts made in 32mm increments
- Front fixing bracket locations in the 32mm grid
- Cabinet profiles and hinge mounting plates locate in line bored holes

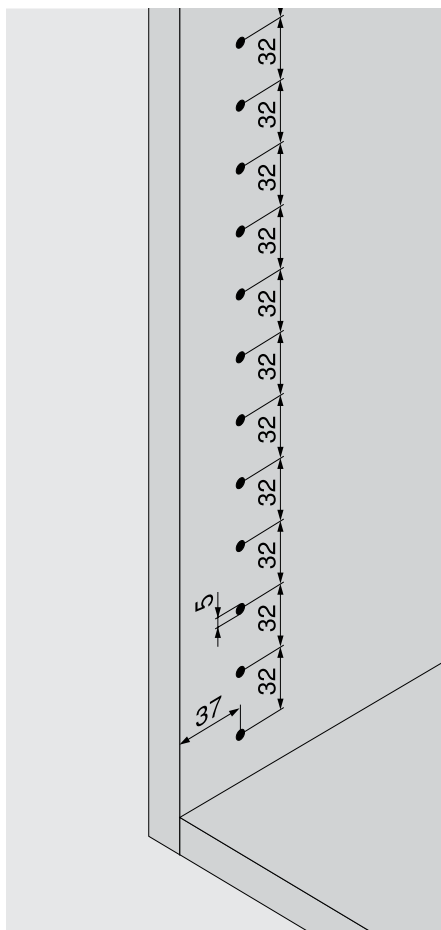
## Dimensions and calculations

DYNALOG LE calculates the crucial dimensions needed for drawers, doors and the corresponding hardware.





## System 32



Most Blum fittings have been designed to work in conjunction with the 32mm system.

All relevant machines and assembly devices are capable of producing the required boring positions and centers.

The 32mm system's greatest advantage is in determination of cabinet and front boring positions:

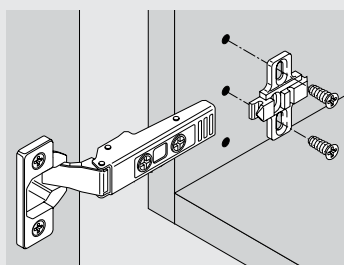
- The majority of Blum's drawer and runner programs have been developed to work in conjunction with the 32mm system, making optimum use of the interior space within a cabinet.
- With the exception of shallow-sided drawers, all options share identical front fixing brackets which gives greater flexibility.
- Both single and full extension runners share identical cabinet drillings.

### These factors ensure:

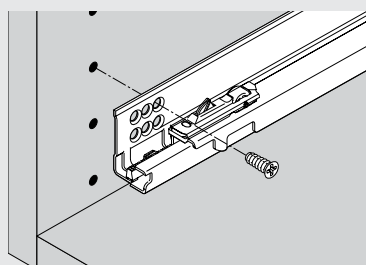
- increased production efficiency
- reduced handling of parts
- reduced chance of errors

**The results are lower production costs.**

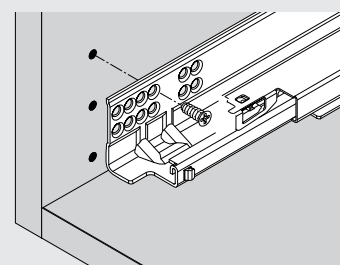
## Applications of the 32mm system



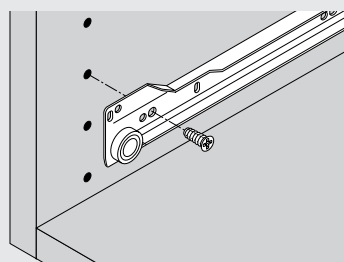
Hinge systems



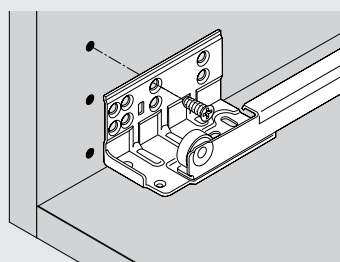
TANDEMBOX



TANDEM runners



METABOX / STANDARD runners



SOLO runners

# Part number index

Part No.	Page No.		
65.0590	23	MZL.1250.US	17
65.2950.10	29	MZM.0010	15
65.3300	26	MZM.0011	15
65.5000	20	MZM.0018	15
65.5010	20	MZM.0019	15
65.5030.01	22	MZM.0021	15
65.5070	19	MZM.0022	15
65.5300	19	MZM.0037	15
65.6100	19	MZM.0038	15
65.7500.01	21	MZM.0383	15
65.7510.01	21	MZM.0050	15
65.7590	21	MZM.0072	15
65.9510	21	MZM.0077	15
69.3600	22	MZM.0092.01	15
BIT HOLDER	32	MZM.0093.02	15
DB-10mm	27, 28, 32	MZM.0095	15
DB-2mm	32	MZR.2000	17
DB-2.5mm	19, 22, 25, 30, 32	MZR.5300.01	6, 8, 10, 17
DB-5mm	19, 21, 23, 27, 32	MZS.0040	16
DB-6mm	30, 32	MZS.1000	17
DB-8mm	23, 32	MZS.1020	12, 17
DYA.2413	33	MZS.2000 L&R	17
M01.ZB05.D2 R	14, 32	MZS.3000 L&R	17
M01.ZB05.D3 L	14, 32	MZW.1300	18
M01.ZB08.03 L	32	POZI BIT #2x1	32
M01.ZB10.02 R	14, 32	POZI BIT #2x2	32
M01.ZB10.03 L	14, 32	POZI DRIVER	32
M01.ZB20.02 R	29, 32	T108-10mm L	32
M01.ZB35.02 R	32	T108-10mm R	32
MZS.4010	24	T108-8mm L	32
M30.0212	17	T65.1000.02	32
M30.1304	17	T65.5000.01	23
M31.1000	18	T65.9000	30
M31.ZB08.02	18	VPB-5	26, 32
M31.ZB35.02	18	ZME.1600.01	30
M52.1056.US	12	ZME.1610	30
M53.0720.US	8, 10, 17	ZML.0010	31
M53.1004.US	6	ZML.0040	27
M53.1004.50	10	ZML.1500	28
M53.1005.US	6	ZML.1510	28
M53.1005.50	10	ZML.0330	31
M53.1053.US	6	ZML.3580	28
M53.1053.UB	8	ZML.3600	28
M53.1053.50	10	ZML.8000.02	28
METATEMP	29	ZMM.3350	24
MZA.1000	17		
MZA.5300	17		
MZE.2110	8, 10, 17		
MZK.1000.US	14		
MZK.112M01	14		
MZK.100-14.01	14		
MZK.200-90	17		
MZK.8000.US	14		

**Information is also available on these other Blum products:**

- AVENTOS lift systems
- Blum Concealed hinges: CLIP top, CLIP, MODUL, and COMPACT
- BLUMOTION for doors
- DYNAMIC SPACE
- METABOX drawer system
- ORGA-LINE organization system
- POCKET DOOR hardware
- STANDARD drawer runners
- SOLO concealed runners
- TANDEM concealed runners
- TANDEMBOX plus BLUMOTION drawer system

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[www.dynamicspace.us](http://www.dynamicspace.us)

