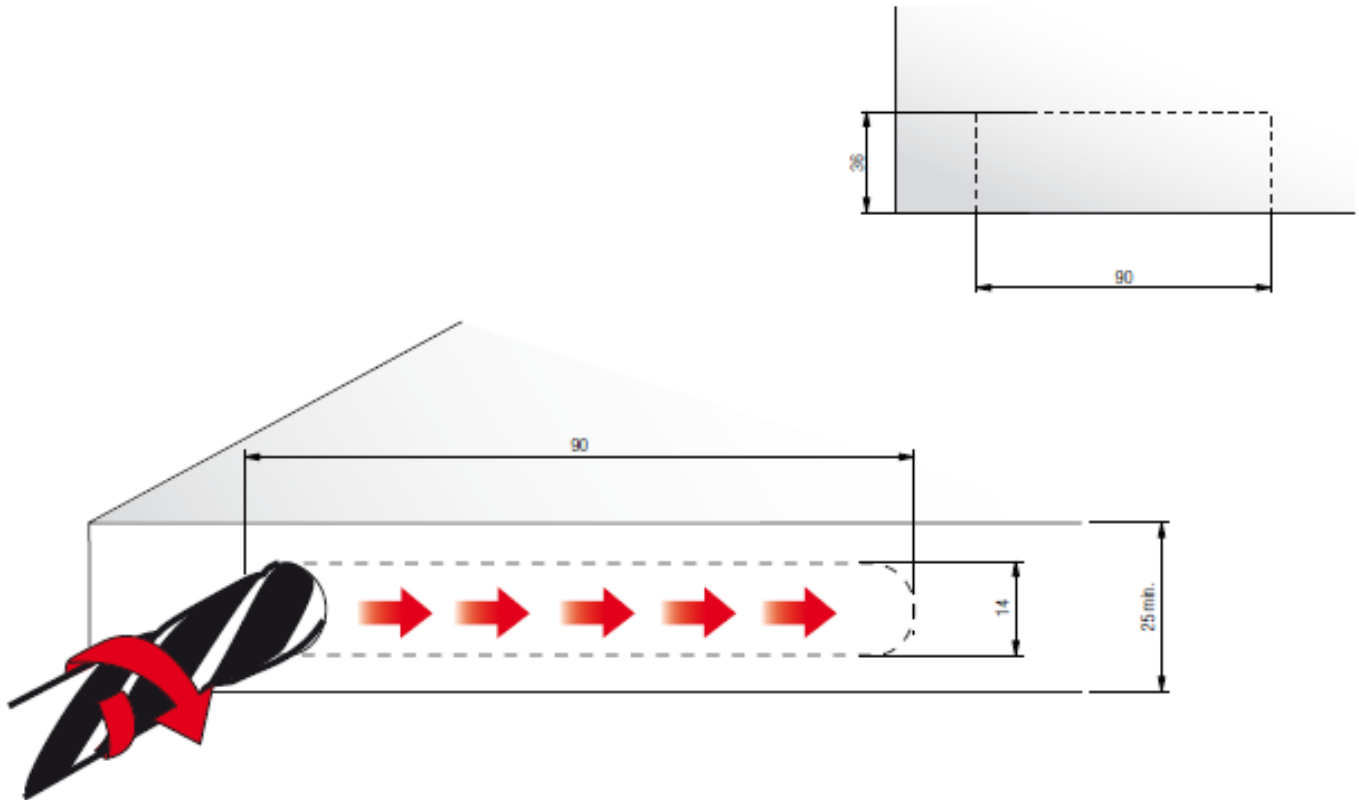
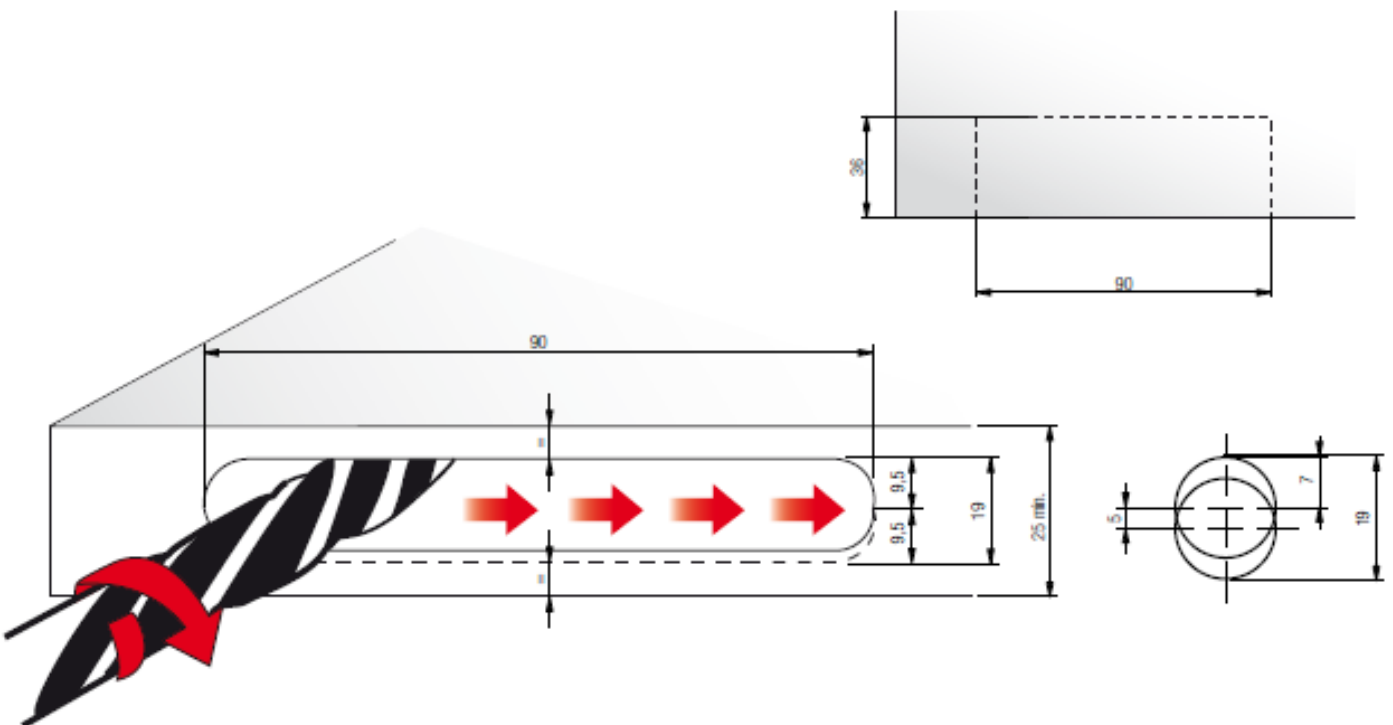


- Drill bit required $\varnothing 14\text{mm}$ for process **1** and **2**
- Drill bit required $\varnothing 14\text{mm}$ for process **3**

1) Drill horizontally the panel by creating a slot 90mm wide.



2) Drill horizontally the panel by making a second slot 90mm wide. Hole centre 5 mm between the first and the second drilling.



3) Drilling 155mm deep centered horizontally and vertically.

