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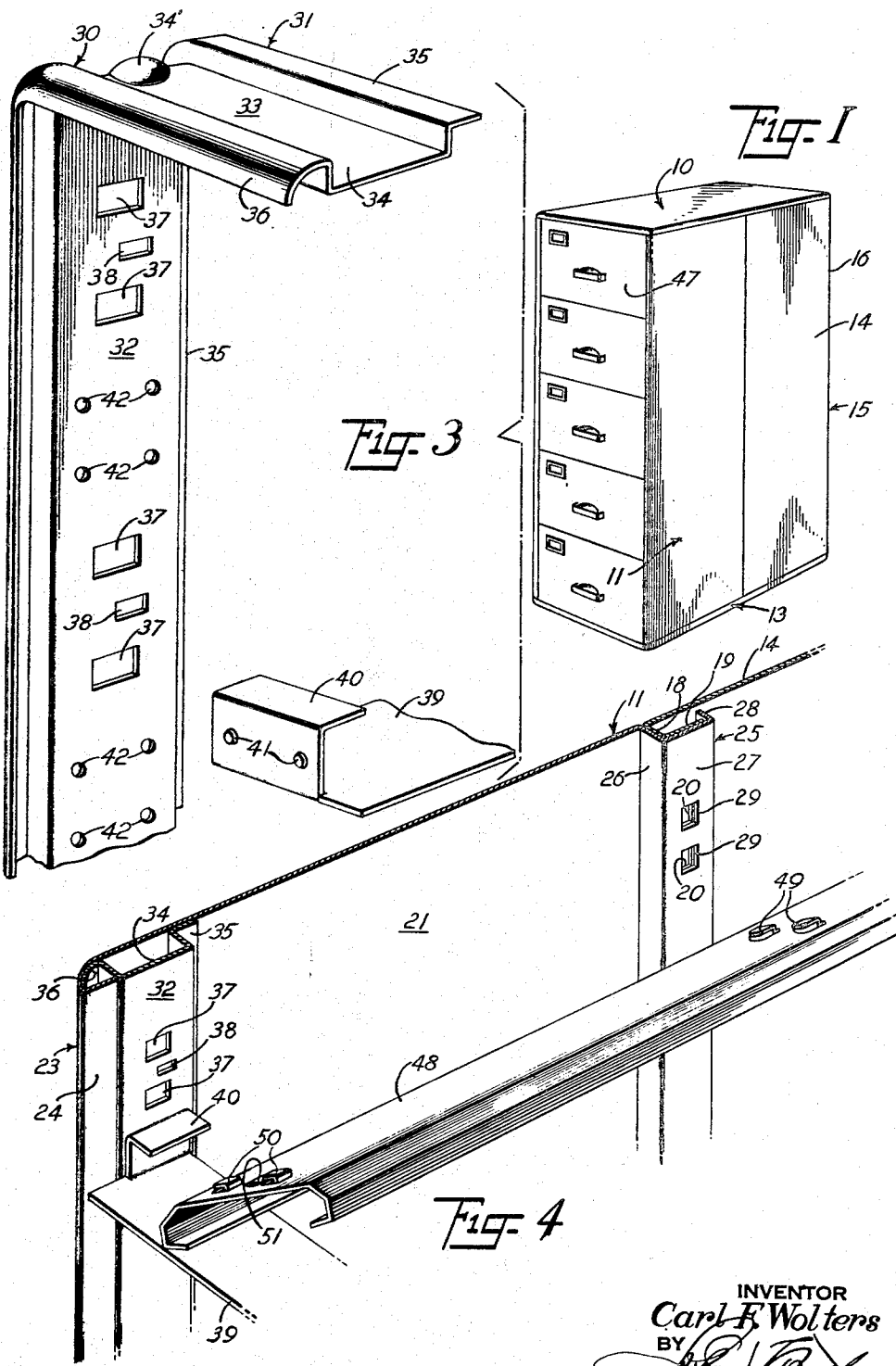
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2,686,704

VERTICAL CORRESPONDENCE FILE

Filed April 1, 1949

3 Sheets-Sheet 1



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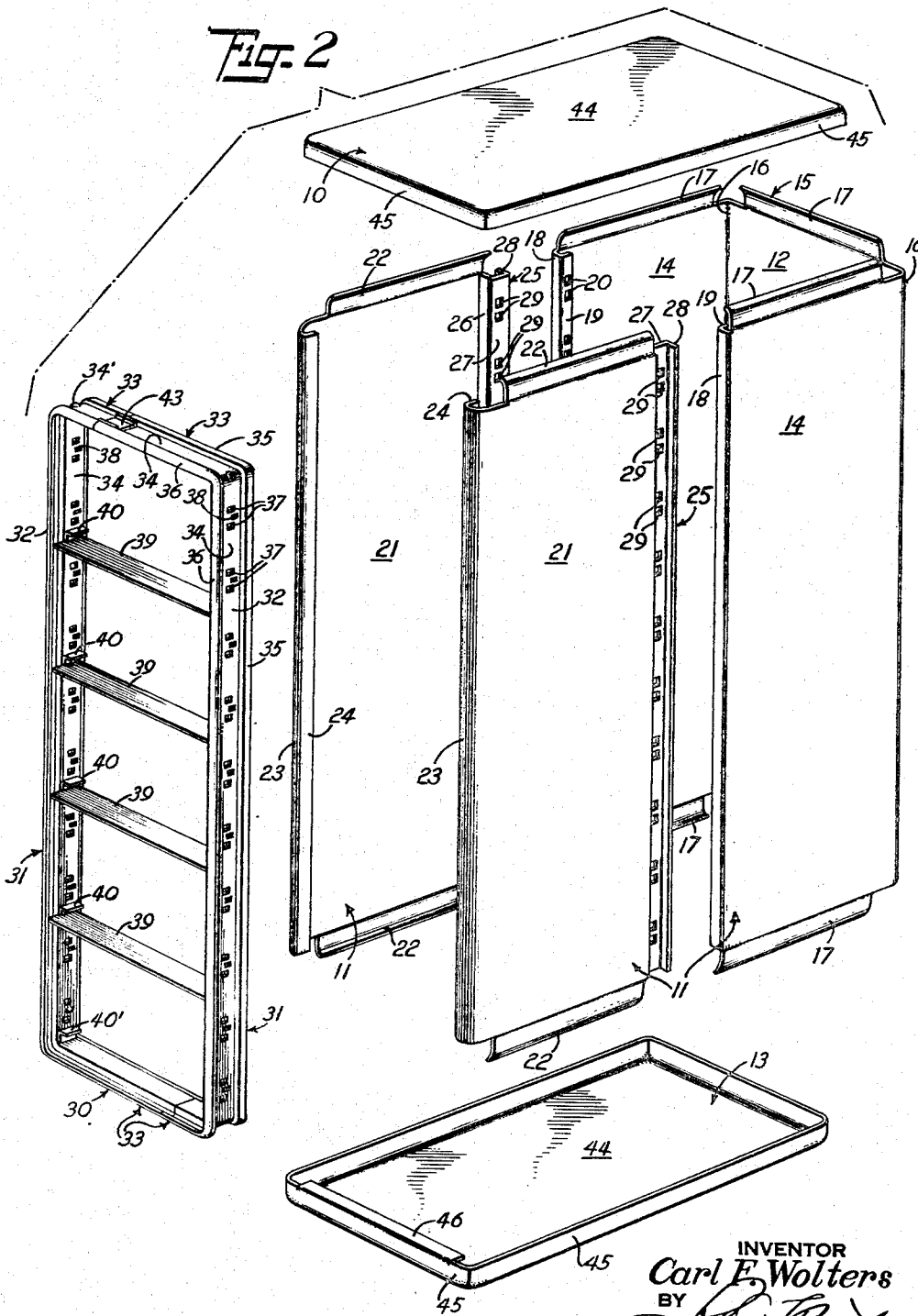
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3 Sheets-Sheet 2



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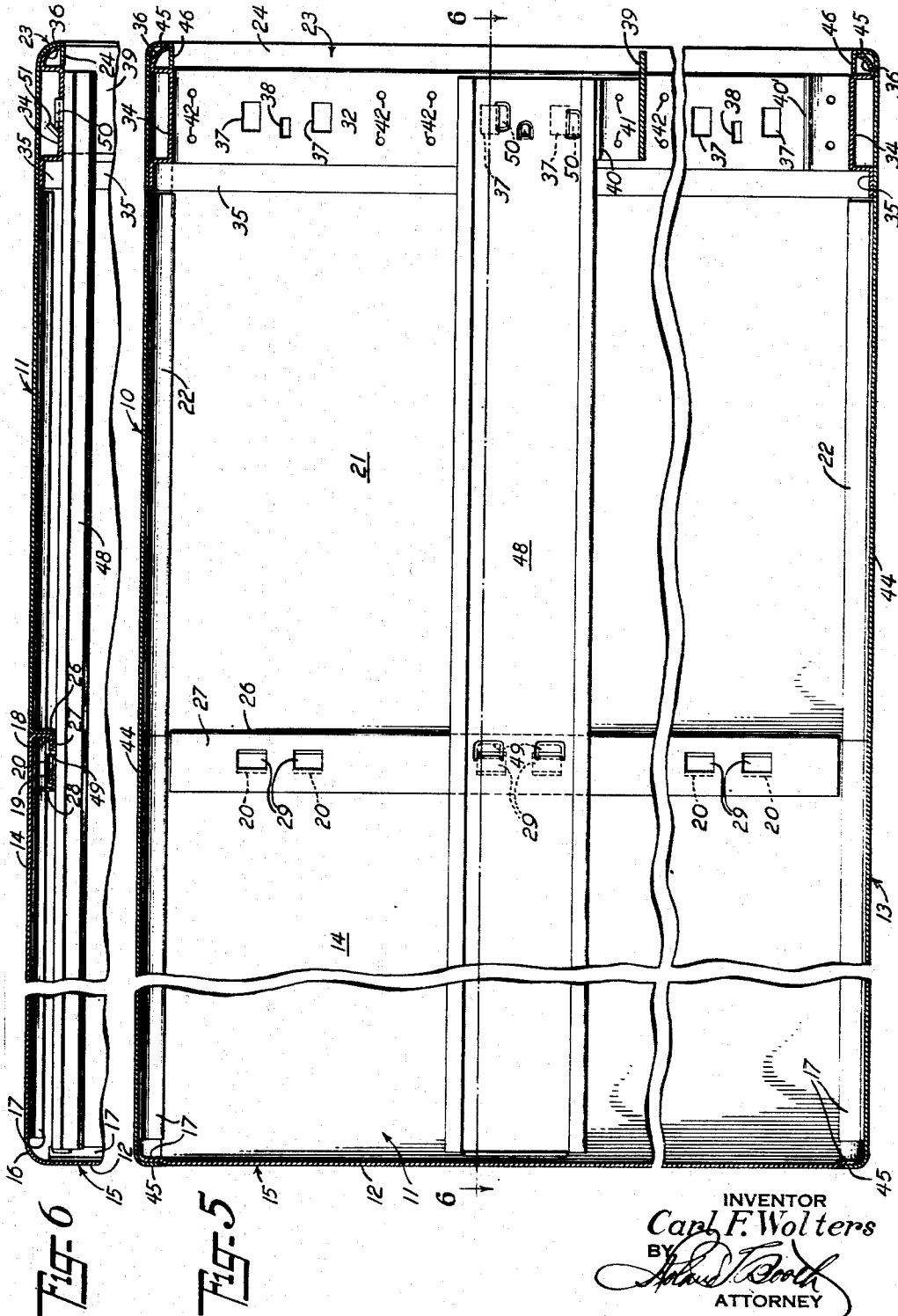
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UNITED STATES PATENT OFFICE

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VERTICAL CORRESPONDENCE FILE

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This invention relates to improvements in correspondence filing cabinets and similar articles of furniture.

It has been customary for many years to provide sheet metal filing cabinets for filing correspondence, both letter and legal size with the papers arranged in position where they stand on edge in a file drawer. This type of filing has become well standardized in business, the papers usually being inserted in folders and being filed in drawers slidable in and out of the cabinets. These cabinets are usually made in three, four, and five drawer units, the four drawer cabinets being used in substantially greater numbers than the others. These filing cabinets have become standardized in size, for the most part, and the four drawer units usually have an overall height of 51 inches or slightly more.

One of the principal factors involved in the construction of filing cabinets is the saving of space in order to accommodate the greatest number of files in a given amount of floor space due to the high cost of floor space per square foot in urban business areas.

Correspondence filing cabinets of the type heretofore used and well known in the art over which the present invention is an improvement are illustrated, for example, by the cabinet structure shown in Patent 1,934,644 patented November 7, 1933.

According to the present invention, improvements have been made in the construction and filing capacity of correspondence filing cabinets of the type heretofore used, as above explained, in which the structural characteristics of the cabinet provide for a well-constructed substantially rigid cabinet in which the capacity has been increased, to the extent that five drawers of correspondence of either letter or legal size can be accommodated in a cabinet having an overall height of 51 inches, which was the standard height of cabinet previously used for four drawers. Cabinets made according to the present invention will also accommodate four drawers of correspondence of standard size in the space heretofore used by three drawers.

In addition to the substantial conservation of space in filing of standard size correspondence in the usual manner now employed, the invention provides a cabinet construction having the casing sections constructed to use duplicate parts at the top and bottom and on opposite sides, as well as in the construction of the front frame, to materially reduce the number of differentially constructed parts necessary for building the cabinet

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and thereby reduce tool, die, and other costs of construction to a substantial extent without sacrificing strength, rigidity and serviceability in the finished cabinet. The cabinet according to the present invention also facilitates modern styling through the use of rounded corners and the elimination of corner joints between the side, back and front sections. The case slides of the drawer suspension cooperate with the cabinet side wall portions and the frame member for interlocking the several parts in assembled cabinet forming relation in order to facilitate efficient and economical assembly of the cabinet parts. By constructing a cabinet in this manner, it is particularly adaptable for use as a pedestal unit in sheet metal desks, either in legal or letter size in which a four drawer unit is provided by the present invention to use the same space as the previous three drawer unit.

Each front frame section has locating means at opposite sides of each of the parts thereon for attaching a drawer supporting member thereon, one of which is used with the other means on an oppositely positioned section in an assembled frame for locating and supporting a separator in position to define a drawer opening.

The invention provides a sheet metal filing cabinet having a back-side section formed with an attaching means in the form of an angular flange structure on the forward edges of the side portions having interfitting and interlocking engagement with attaching means in the form of channel portions of front side sections of duplicate construction. The front side sections have front corner sections formed with inwardly curved and return bent flanges embracing the forward edges of the front frame while the drawer supporting members are formed for interlocking engagement with the front frame member at the front end and with the interlocking portions of the front side and back-side members toward the rear portion thereof for detachably interlocking the front frame, the front side sections and the back-side member in rigid assembled cabinet forming relation. Duplicate top and bottom members are then applied to the assembled side and back-side members and rigidly secured thereto for completing the cabinet structure. This provides a cabinet structure and assembly that may be readily formed and assembled in a most convenient and economical manner.

In the drawings:

Fig. 1 shows a five drawer filing cabinet embodying the invention, in perspective.

Fig. 2 is an exploded perspective showing the

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front frame, interchangeable side sections, back-side member and top and bottom sections; the drawers, drawer suspension, and some other parts omitted.

Fig. 3 is a fragmentary perspective showing the corner portion of one of the frame sections and a separated fragment of one end of a drawer separator, respectively, illustrating how a drawer separator is secured to the frame and the details of construction of the frame.

Fig. 4 is an enlarged perspective showing fragmentary portions of a frame section, side wall section, back-side member and drawer separator in assembled relation with a case slide in detached position.

Fig. 5 is a vertical longitudinal cross-section through the assembled file cabinet, the drawers being omitted.

Fig. 6 is a horizontal cross-section through one of the side walls of the assembled file cabinet, taken substantially on line 6--6 of Fig. 5.

The filing cabinet illustrated in Fig. 1 has a top wall 10, side walls 11, rear wall 12, and bottom wall 13. The cabinet has five separate pieces, as shown in Fig. 2 forming the top, side, bottom and rear walls. However, as will become apparent, only three differently formed parts are used to provide the five pieces, since the two front sections of side walls 11 are alike, and the top 10 and bottom 13 are alike.

Rear wall 12 and rear side wall portions 14 of side walls 11 are formed by a U-shaped back-side member 15, Fig. 2, provided at the rear vertical corners with rounded corner sections 16 joining rear wall 12 with rear side wall portions 14. Short offset flanges 17 are formed of rear side wall portions 14 and rear wall 12 but do not extend into corner sections 16. The front edge of each rear side wall portion 14 is formed with an inwardly extending lateral flange 18 terminating in a rearwardly directed flange 19 in spaced parallel relation to the adjacent portion of side wall portion 14 forming a rearwardly opening channel along each forward edge of the back-side member. Flange 19 is formed with a plurality of vertically spaced pairs of apertures 20 for receiving interlocking tongues on a case slide as hereinafter described.

The forward portions of side walls 11 are formed by a pair of identical front side members 21. Each member 21 is interchangeable for use on either the left or right side of the cabinet by reversing its position so the top end on one side is at the bottom on the other side. Attaching flanges 22 are formed on the top and bottom edges of each front side member 21 and have the same height and contour as flanges 17. In assembled relation flanges 22 are aligned with flanges 17 on the sides of the cabinet at the top and bottom edges. Front end sections 23 of curved form are provided on the front portion of each front side wall section 21 and terminate in a rearwardly extending flange 24 forming a rearwardly opening channel. The curved front end sections 23 facilitates more convenient and economical manufacture and also an improved appearance to conform to current style designs.

The rear edge of each front side member 21 is formed with an attaching channel 25 formed by lateral flange 26 having offset strip 27 at the inner edge thereof extending in parallel relation to side member 21 and terminating in an outwardly extending flange 28. Offset strip 27 is formed with a plurality of pairs of apertures 29 having the same spaced relation as apertures

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20 for registry therewith. Two front side members 21 are used in each cabinet arranged in reversed position end for end as shown in Fig. 2 so that each member is assembled with the back-side member by having flanges 18 and 19 engaged in attaching channels 25. The plurality of pairs of apertures 20 and 29 will register when each flange 19 is engaged in the proper position in each attaching channel 25. Channels 25 and flanges 18 and 19 cooperate to provide a rigid structure along the sides of the cabinet and eliminate the use of angle bars, channels, and the like which have been heretofore used to provide adequate strength.

A front frame 30 is formed of a pair of duplicate frame sections 31. Each frame section 31 is formed to provide a vertical side member 32 having laterally extending arm portions 33 on the opposite ends, one of which is relatively short, while the one on the opposite end is of substantially greater length. The longer arm 33 has its dimension fixed so that when it is placed in end to end abutting relation with a shorter arm 33 of another duplicate frame section 31 in reversed position, the total length will provide the proper dimension for the width of the file cabinet at the front so that opposite sides 11 of the cabinet will be substantially parallel. Frame sections 31 are formed with unequal arm portions 33 on opposite ends in order that the joint between the arms at the top and bottom of the frame in assembled relation as shown in Fig. 2, for example, will be adjacent opposite sides which enables a frame having greater strength to be produced as compared with one where the joints are in the same vertical plane such as in the center.

Each frame section 31 is formed of sheet metal to provide a central channel portion 34 in vertical side member 32 and also arm portions 33. A rearwardly extending flange 35 formed on the rear side of channel member 34 extends throughout vertical side member 32 and arm portions 33. Channel 34 has a curved front section 36 formed to have the same shape as the curved portion of front section 23 of front side member 21 in addition to providing substantial strength to the frame structure and the finished cabinet at the front end. A rigid support is provided for the front of the side members by this frame structure. The portion where arms 33 are joined to vertical side member 32 have curved sections formed to have the same curvature as the top and bottom corner portions at the front of the cabinet. In order to provide for the desired curvature of sheet metal in forming the corner sections between vertical side member 32 and arm 33 it has been found desirable to form each portion joining an arm 33 to vertical side member 32 with a bead 34' in the center portion of channel 34. Each vertical side member 32 is formed with spaced pairs of apertures 37 in the central channel portion 34, as clearly shown in Figs. 2 and 3, to provide corresponding pairs of apertures to apertures 20 and 29 for receiving interlocking projections or ears on case slide members in a manner that will be described. Channel 34 is also formed with a smaller aperture 38 between each pair of apertures 37 and offset slightly from the aligned arrangement of apertures 37 to provide an opening in front frame 30 for receiving an interlocking tongue on the case slide member to be described.

Front frame 30 supports the side, top and bottom walls of the cabinet to define the front open-

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ing for receiving the file drawers. Separators 39 in the form of flat bars have return bent portions 40 on opposite ends each formed with a pair of beads 41 in the laterally extending portions for engagement in a pair of apertures 42 formed in horizontal alignment in any one of a plurality of positions in vertical side members 32. The upper ends of portions 40 are formed to support the drawer supporting members on the frame in cooperation with the means engaging in apertures 37 as hereinafter described. Projections 41 on each separator are engaged in pairs of apertures 42 in the front frame at opposite sides thereof to place it in the desired position for the size of drawer to be used in the cabinet. A pair of apertures 42 is formed in each side member 32 on opposite sides of each pair of apertures 37 in equi-distant relation from apertures 37. One pair of apertures is used in one position of a side member 32 while the other pair is used when the side member is in a reversed position. Front frame 30 is formed with a sufficient number of sets of apertures as shown, to provide for receiving five correspondence size drawers for standard letter-size sheets and also for receiving two half-size drawers in place of each letter-size drawer to adapt the cabinet for use with drawers for receiving index cards filed on edge.

Four separators 39 are used where correspondence or letter size drawers are to be mounted in the cabinet to provide for five drawers. The separators for five drawers are positioned in front frame 30 in the manner shown in Fig. 2. Projections 41 are welded at the outside of channel 34 to vertical side members 32 for cooperation with the side members in forming a rigid vertical frame structure. Separators 39 are assembled in front frame 30 at the time sections 31 are brought together for assembly. This is done by inserting projections 41 in apertures 42 to accurately locate the separators as the sections are assembled and welded.

The position of the separators is predetermined by punched apertures 42 and projections 41 so they may be readily assembled into the proper position for the desired size of drawer. The ends of arms 33 of two frame sections 31 are secured together in a suitable manner, such as by welding, through the use of a channel-shape welding strip 43 engaged in channel 34 and extending across the joint in the assembled frame sections. When strip 43 is welded in place a substantially rigid frame structure is obtained. Bottom corner brackets 40' similar in form to the end portions 40 on each separator are mounted in the bottom corners of the front frame for supporting the bottom drawer supporting members in assembled relation. Brackets 40' have positioning projections thereon similar to the separators and are assembled and positioned by apertures 42 in the same manner as a separator. Top and bottom wall members 10 and 13 respectively are formed from a pair of duplicately formed pieces of sheet metal. Each member has a flat imperforate rectangular wall forming portion 44 provided with a laterally extending curved peripheral flange 45 forming curved corner sections about all four sides of the cabinet at both the top and the bottom. Peripheral flange 45 at the front of the cabinet is formed with a rearwardly extending lip 46 in spaced parallel relation to wall forming portion 44, as clearly shown in Figs. 2 and 5. In assembling the top and bottom wall members using these duplicate sheet metal structures, lips 46 engage over the inner edge of the arms at

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the top and bottom of front frame 30 with flanges 45 extending about curved flange 36 in the manner shown in Fig. 5, while peripheral flanges 45 at the sides and rear of the cabinet engage in overlapping relation with flanges 17 and 22 on back-side member 14 and front side members 21, respectively.

A drawer suspension substantially similar to that shown in the aforementioned patent is used for supporting the drawers 47 for movement into and out of the cabinet in a manner well known in the art. The case slide for the drawer suspension mechanism used is of slightly different construction from that shown in the aforementioned patent and performs a new cooperation in the present cabinet not shown by the aforementioned patent. It is only necessary however to show the case slide for the drawer suspension mechanism to illustrate the improvements provided by the present invention. The case slide 48 is of channel-shaped construction having top and bottom tracks for cooperation in mounting the remainder of the drawer guide mechanism in a well-known manner. Case slide 48 is provided with offset attaching ears 49 in forwardly extending relation in an intermediate portion, as shown in Fig. 4. Ears 49 are spaced apart transversely of case slide 48 a distance equal to the spacing of apertures 20 and 29 in flanges 19 and 27 respectively, for projecting through these apertures to engage in interlocking engagement with flanges 19 and 27. The vertical dimension of ears 49 and apertures 20 and 29 respectively, provides for slidable engagement of the ears in the apertures into interlocked position with the flanges but prevents relative vertical movement of the flanges and ears.

In assembling the sections to form a complete file cabinet, front side members 21 have their front corner sections 23 engaged about the outer sides and front edges of vertical side members 32 of frame 30 with rearwardly extending flanges 24 extending rearwardly on the inside of side members 32 to embrace the front frame in the manner shown in Fig. 6. When side members 21 are assembled in this relation with frame 30 attaching channels 25 are then arranged to receive flanges 19 therein in interfitting relation. In this way, a back-side member and two front side members are assembled at opposite sides with frame 30. Pairs of case slides are then inserted into a position as shown in Fig. 4 for assembly in the cabinet. The rear central portions of case slides 48 are formed with outwardly offset and forwardly extending ears 49 arranged in spaced vertical relation for registry and interlocking engagement in apertures 20 and 29 respectively. Ears 49 on a plurality of case slides 48 are inserted through these registering apertures and then each case slide is moved forwardly so that the ears overlie the forward portions of flanges 19 and 17 in advance of apertures 20 and 29 respectively. Ears 49 have a spaced position beyond the outer face of case slide 48 equal to the thickness of the metal of flanges 19 and 27 respectively for holding these flanges in tightly engaged non-shifting position in the interlocked relation, as shown in Figs. 5 and 6. When each case slide 48 has the tongues 49 engaged in this interlocked position, a pair of downwardly extending tongues 50 on each case slide will then be in position to extend through apertures 37 in front frame 30 in horizontal alignment with the apertures through which tongues 49 have been engaged, see Figs. 4 and 5. Interlocking

ears 50 are in downwardly extending relation and have a spaced vertical relation to each other equal to that of apertures 37. Ears 50 are offset outwardly beyond the outer face of case slide 49 at the front end thereof a distance equal to the thickness of the metal of channel 34 in side frame member 32 for firmly interlocking the case slide with front frame 30 when the laterally extending portion of ears 50 engage channel member 40 forming the bottom margins of apertures 37. This position of ears 50 in assembled relation on front frame 30 is shown in dotted lines in Fig. 5. When case slides 48 are in this assembled position a locking tongue 51 is in position to be bent laterally through aperture 39 between the pair of apertures 37 through which tongues 50 extend. This provides for rigidly locking the case slide in the cabinet in the manner described in the aforementioned patent.

It will be noted that the case slide in the present application has the ears 49 cooperating with the back-side member and front side members 21 to form an interlocking connection with these cabinet forming sections for rigidly retaining them in assembled cabinet forming relation in a manner not shown or suggested in the aforementioned patent. Then, by the interengagement of tongues 50 through the apertures or front frame 30 and the securing thereof in interlocked position by bending tongue 51 into aperture 39 the entire structure of the cabinet at the back and sides with front frame 30 is permanently assembled together in cabinet forming relation. It will thus be appreciated that this assembly can be made in a minimum amount of time through this cooperation of the back-side member, front frame 30, front side members 21 and the desired number of case slides 48 arranged in pairs at each side of the cabinet for supporting each drawer for movement into and out of the drawer opening in the front of the cabinet defined by separators 39 as shown in the drawings.

Top and bottom walls 13 and 13 may then be applied by engaging a pair of the duplicate members forming these walls with the upper and lower parts of the cabinet assembled as above described with lips 46 engaged on the inside of arms 33 at the upper and lower portions of front frame 30 as shown in Fig. 5. Then, peripheral curved flange 45 will engage on the outer sides of flanges 17 and 22 at the top and bottom of the sides and back of the cabinet with the free edges terminating adjacent the offset portions of the walls where the flanges 17 and 22 are attached to provide a smooth wall surface on the outside of the cabinet at the sides and back merging into the curved corners on all sides of the cabinet. The top and bottom wall members may be suitably spot welded or welded by other suitable means to the side and back walls of the cabinet for completing the cabinet structure to produce a rigid assembled cabinet unit.

By constructing the cabinet in this manner, considerable space is saved so that the height of the cabinet for holding five drawers of correspondence size files can be reduced so that it will only occupy the space heretofore used for four drawers of such correspondence. This saving in space is obtained partly in the cabinet construction by reason of the structural features herein described providing for the elimination of structural frame members within the cabinet shelves that have been heretofore required to provide sufficient strength to make the cabinet structures practical. In the present invention the formation

of the wall members themselves gives the desired strength in the assembled cabinet structure in cooperation with front frame 30, places the seams between the metal sections of the cabinet at the sides and thereby provides for the construction of the cabinet with rounded corners to meet the requirements of modern styling without sacrificing strength and rigidity in the completed cabinet structure.

The invention claimed is:

1. A filing cabinet comprising a pair of duplicate U-shaped members formed to provide an open rectangular front frame, a pair of duplicate front side wall members, a back-side member, attaching means integrally formed on each of said members and front frame for complementary engagement of said front side wall members with said frame and back-side member, and drawer supporting means having a part formed in complementary relation to said attaching means and interengaged therewith and securing said wall members and frame in interlocked relation to form a file cabinet rigidly supporting said drawer supporting means.

2. A filing cabinet comprising a pair of duplicate side wall members arranged in reversed relation end for end at opposite sides of the cabinet, duplicate top and bottom wall members reversed in position with inner sides facing each other in opposed relation, a front frame embraced by and interengaged with the front margins of said side wall and top and bottom wall members, a rear wall member, interengaged complementary attaching means on the margins of said side and rear wall members, and drawer supporting members at opposite sides in said cabinet formed with means for locking said complementary attaching means in engaged relation and interengaging with said front frame rigidly attaching said drawer supporting members to said cabinet and rigidly retaining said side and rear wall members and front frame in assembled cabinet forming relation.

3. In a filing cabinet, a rectangular front frame, front side and rear side wall members formed of sheet material, said front wall members having a spaced parallel relation at opposite sides of said frame and formed with corner sections to embrace said frame in attaching said side wall members to opposite sides thereof, said side and rear wall members having marginal portions formed into a plurality of U-shaped angularly extending flanges forming complementary interengaged attaching means rigidly supporting said side and rear wall members, and drawer supporting members at opposite inner sides of said cabinet formed with spaced attaching parts complementary to attaching apertures in said marginal portions of said side and rear wall members and said front frame for rigidly interlocking said U-shaped side wall flanges, said drawer supporting members further interlocking said wall members and said front frame in rigid assembled cabinet forming relation.

4. In a filing cabinet, a rectangular front frame, a pair of duplicate front side members at opposite sides of said frame, frame embracing corner sections formed on the front margins of said front side members, channel-shaped attaching means formed on the rear margins of said front side members, a back-side member having laterally extending angular flanges on forwardly extending portions at opposite sides thereof engaging in the channels of said attach-

ing means, said attaching means and angular channels having registering apertures in engaged relation at spaced intervals aligned with apertures formed in the side portions of said front frame, and drawer supporting members at opposite inner sides of said cabinet formed with attaching tongues at the front and rearward portions having the rear set of tongues engaged through the registering apertures in said attaching means and angular channels and the tongues at the front engaging in the apertures in said frame for interlocking said side, back-side and front frame members in rigid assembled cabinet forming relation with said drawer supporting members in drawer supporting position thereon.

5. A filing cabinet of the character described comprising a rectangular front frame formed of two complementary U-shaped channel members the vertical side portions of which have spaced apertures, a back-side member forming a rear wall having forwardly extending side wall portions, each side wall portion formed with an attaching channel on its forward edge, a second pair of duplicate side wall members each formed with a complementary attaching channel on its rearward edge interengaged with the attaching channel on the adjacent forwardly extending side wall members, said second pair of side wall members being in reversed position end to end with respect to one another, registering apertures in said interengaged channels of said first and second named pair of side wall members respectively, flanged means on the forward edges of said second named pair of side wall members for embracing the adjacent vertical side portions respectively of said front frame, a case slide having tongues some of which cooperate with said registering apertures in said interengaged channels to rigidly interlock said channels relative to one another, and other of which tongues have cooperative interengagement with the spaced apertures in the vertical side portions of said front frame to rigidly interlock and retain said wall forming members and front frame in assembled cabinet forming relation, and duplicate top and bottom walls secured to said back and side wall members and front frame to form a complete cabinet open at the front through said front frame.

6. A filing cabinet of the character described comprising a rectangular front frame formed of two complementary U-shaped channel members the vertical side portions of which have spaced apertures, a back-side member forming a rear wall having forwardly extending side wall portions each side wall portion formed with an attaching channel on its forward edge, a second pair of duplicate side wall members each formed with a complementary attaching channel on its rearward edge interengaged with the adjacent attaching channel on the adjacent forwardly extending side wall members, said second pair of side wall members being in reversed position end to end with respect to one another, registering apertures in said interengaged channels of said first and second named pair of side wall members respectively, flanged means on the forward edge of said second named pair of side wall members for embracing the adjacent vertical side portion of said front frame, means having tongue members engageable with said registering apertures to rigidly interlock said channels relative to one another and other tongue members on said means engageable with said spaced apertures in said side portions of said front

frame to rigidly interlock said front frame with said flange on said second named pair of side wall members in assembled cabinet forming relation, and duplicate top and bottom walls the marginal edges of which are bent to form laterally extending curved peripheral flanges which are secured to said back and side wall members and to said front frame to form a complete cabinet open at the front through said front frame.

7. A filing cabinet comprising a rectangular front frame, a plurality of side wall forming members and a side and rear wall forming member, each side wall forming member having complementary attaching means formed thereon for complementary engagement with attaching means on an adjacent side wall of said side and rear wall forming member, and means having a plurality of parts, some of said parts interengaging with complementary locking parts on said complementary attaching means and other of said parts interengaging with parts on said front frame and cooperating to rigidly retain said wall forming members and front frame in cabinet forming relation.

8. A filing cabinet comprising a rectangular front frame, a plurality of side wall forming members and a side and rear wall forming member, each side wall member having attaching means formed thereon for complementary engagement with attaching means on an adjacent side wall of said side and rear wall forming member, a plurality of drawer supporting members, each having projections formed thereon at spaced intervals for interlocking engagement with registering apertures in the complementary engaged portions of said wall members and independently engaging said frame for retaining said frame and wall forming members in cabinet forming relation, a pair of said drawer supporting members cooperating to support a drawer for movement into and out of said casing through said frame.

9. In a filing cabinet, a front frame formed of a pair of duplicate frame sections, each section comprising a one-piece vertical channeled side member having integral channeled arms extending laterally therefrom at opposite ends, one arm being a substantially long arm and the other arm being a substantially short arm, the sections being reversed in end to end relation relative to one another, the short arm of each section being in aligned abutting relation to the long arm of the other section, plate means rigidly uniting said sections in frame forming relation, a plurality of spaced apertures formed in the vertical channeled side member of each frame section, the apertures in one side member having the same relative position horizontally as the apertures in the other side member, a plurality of drawer separators extending horizontally between the vertical channeled side members of said frame with the ends of each separator abutting said side members, and locating means on the ends of each separator adapted to engage within the apertures in said vertical channeled side members whereby the separators define a plurality of drawer openings in said frame.

10. A filing cabinet comprising a rectangular front frame having channeled top, bottom, and side members the latter having spaced apertures therein; a back member having forwardly extending parallel side wall portions the forward edges of which are bent inwardly and rearwardly to form vertical interengaging channels having spaced apertures therein; a pair of duplicate

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front side wall members the rearward vertical edges of which are bent inwardly, rearwardly, and outwardly forming a second pair of interlocking channels with the forward vertical edges of said front side walls being formed to embrace the channeled side members of said front frame; a case slide having pairs of members engageable with the registering apertures in said first and second named interengaging channels and apertures in said front frame respectively, acting to interlock and rigidly retain said wall members and front frame in assembled cabinet forming relation; and duplicate top and bottom walls

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rigidly secured to said walls and front frame to form a complete cabinet open at the front through said front frame.

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