



'BOLT-TOGETHER' END FRAME ASSEMBLY INSTRUCTIONS

Before pallet rack can be installed, racking end frames must be assembled. Instructions as follows:

1. Lay (2) frame posts parallel to each other with slots facing outward and in similar directions ensuring frame posts are square with the ends aligned. Ideally frame posts should be elevated off the ground for easy assembly.

****Note frame posts are directional; see detail 'A'.**

2. Layout horizontal and diagonal braces between the (2) frame posts as detailed in the master bolted frame assembly drawing.

3. Starting from one end and working your way up, install each horizontal and diagonal brace adjoining them to the (2) parallel frame posts. Secure horizontal and diagonal braces to the side holes of each frame post using a set of 3/8" UNC x 2-1/2" Grade 5 hex bolt and 3/8" UNC Nyloc hex nut; see detail 'B' & 'C'. At this time do not fully tighten the bolts and nuts so that some flexibility may be maintained to help with the installation of remaining braces.

****Note: In areas where braces do not overlap a 1.67" long brace spacer must be used; See detail 'D'.**

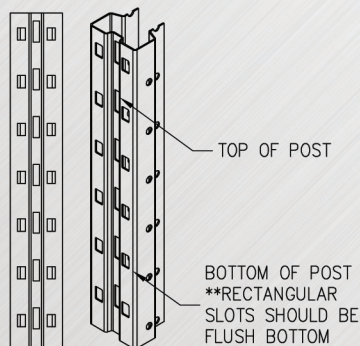
4. With all horizontal and diagonal braces in place, tighten all nuts and bolts for final assembly. All bolts shall be brought to a 'snug-tight' condition ensuring all plies are in firm contact plus a 1/4 turn. 'Snug-tight' condition is attained with a few impacts of an impact wrench or the full effort of a person using an ordinary spud wrench.

5. Install base plate provided using (2) 3/8" UNC x 1" Grade 5 serrated flange hex bolt and (2) 3/8" UNC serrated flange hex lock nuts; see detail 'E'.

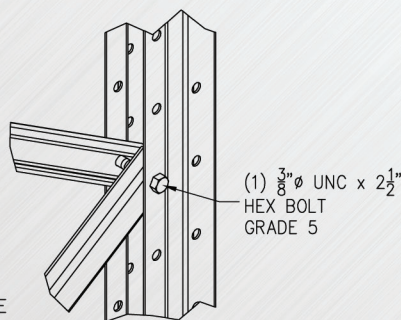
6. Pending engineering requirements, saddle style base plates may be provided. Install base plate provided using (1) 3/8" UNC x 4-1/2" Grade 5 hex bolt, (2) 3/8" flat washers and (1) 3/8" UNC Nyloc jam hex nut; see detail 'F'.

7. Once the first end frame has been assembled this can be used as a jig to assemble the balance of the end frames.

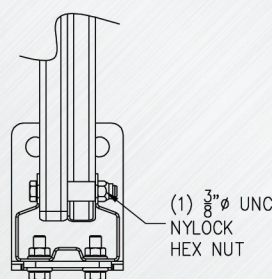
8. Repeating steps 1-6, finish assembling all end frames necessary for pallet rack installation; see detail 'G'.



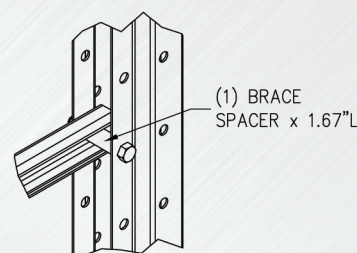
DETAIL A



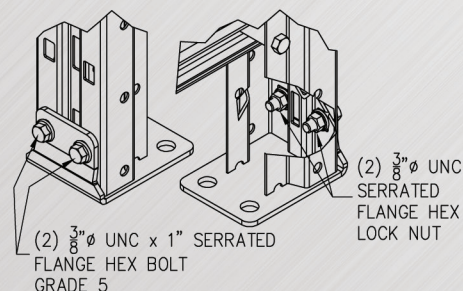
DETAIL B



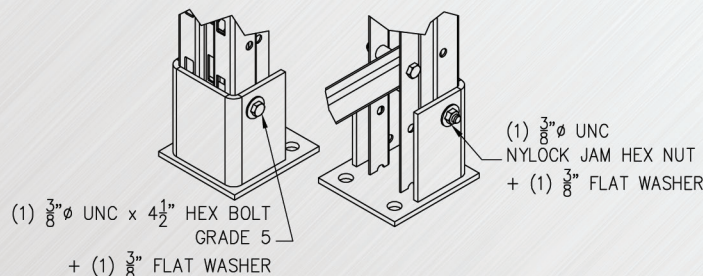
DETAIL C



DETAIL D



DETAIL E



DETAIL F



DETAIL G

call now, or visit www.spaceaidmfg.com for more information

43 Regan Road, Brampton, Ontario

Tel: (905) 840-5550 | Fax: (905) 840-5560

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