

Universal Stand Assembly Instructions

Description: This is the instructions for assembling of the Universal Stand with material rollers.

Affected Product(s): PL-00-02-800S

PL-00-02-STAND-3(for 536GTS Models only).



(Front View)

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Tools Needed:

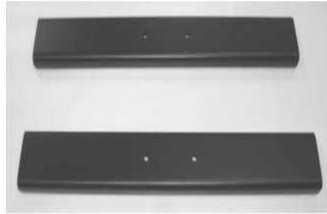
Ratchet handle with 3/8",
7/16" and 1/2"
socket and vise grips

Included in this carton:

6- 5/16-18 bolts
6- 1/16-18 Nuts
8- 8- 1/4" lock washers
16- self tapping screws
8- 1/4-20 x 1/2" bolts

16- 6-32x3/8" screws with
flat and lock washers
2-bases
2 stand uprights
2 top braces

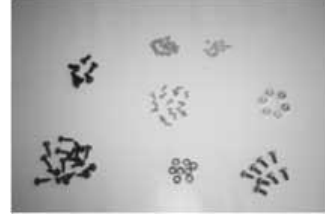
Base Wheel Brackets



Angle Brackets



Hardware Kit



2 Base Assemblies



4 wheels



(Side View)



(Back View of stand with cutter)

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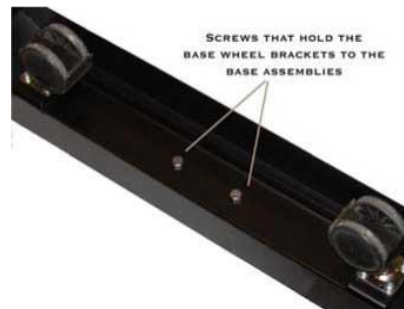
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Universal Stand Assembly

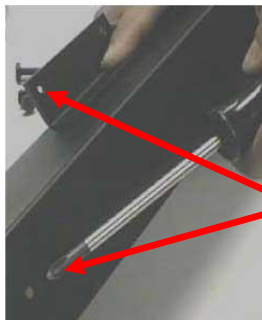
NOTE: Before beginning assembly, make sure all hardware and parts shown below are present in shipment. The rollers bracket, and cross member for the material cradle are packed in the box. Remove all the foam and parts from the box. Store the cutter box in a safe location in the unlikely event that your cutter needs to be returned for service.

1. Assemble the four wheels to the two wheelbase brackets using the 6-32 x 3/8" Philips head screws, lock and flat washers.

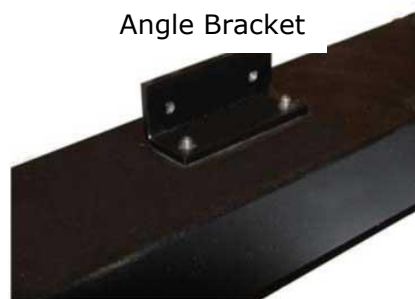


2. Attach the two angle brackets and completed wheel and bracket assemblies to the two base assemblies using the 1/4-20 x 1/2" bolts and lock washers as shown below.

NOTE: The angle brackets have two pairs of holes which are not spaced the same. Align the holes in the angles to the holes in the base for assembly. Note the orientation of the holes in the side of the base assembly prior to attaching the angles. The vertical leg of the angle bracket should be on the opposite side of the base from the hole in the base. See the picture below.



Note position of the holes and angle.



Align the base bracket to be centered in the base to allow full wheel rotation. Once this is done, tighten bolts using 7/16" ratchet or wrench. Once done, you are now ready to attach the leg uprights to the wheel bracket assemblies.

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- 3.** Attach two base assemblies to two uprights using $\frac{1}{4}$ -20 x $\frac{1}{2}$ " bolts and lock washer, making sure that the screw heads on the sides of the legs are facing away from the side of the base assembly that has two holes in it. The screw heads will face in opposite directions when assembled correctly.



- 4.** Lie completed assemblies on the floor so that the two holes near the top of the leg uprights are facing up. The sides with the screw heads should both face outward with the two holes at the center of each leg also facing up. The assemblies will be resting on the narrow edge of both the base assembly and the upright. Attach the upper cross braces using four self-tapping screws. Leave hardware slightly loose until the opposite side is attached. Flip assembly over to attach the opposite brace in the same manner.



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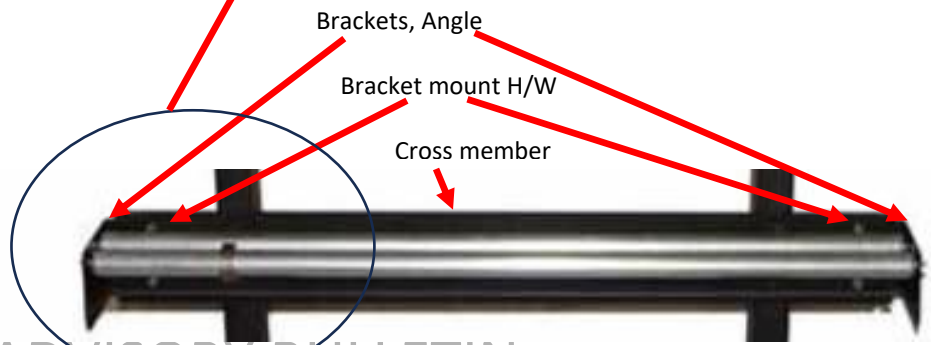
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5. Attach material cradle cross member (Bar, Roll Cart) to the rear of the universal stand using the four self-tapping screws. Loosely mount the angle brackets to the cross members with the 6 screws and nuts provided. Insert rollers into the angle brackets (with the collar towards left back side) by holding the spring-loaded end of the roller in with a screwdriver while inserting into the bracket holes as shown below.

Material Roller /Cradle Assembly (in cutter box)		
Model 24-36	Model 48	Model 60
Collar (1) * TM model (2)	Collar (1) * TM model (2)	Collar (1) * TM model (2)
2-Roller, Conveyor (24-36)	Roller, Conveyor	Roller, Conveyor
2-Bar, Roll Cart (Model 20-40)	Bar, Roll Cart (Model 48)	Bar, Roll Cart (Model 60)
2-Bracket, Roll Cart	2-Bracket, Roll Cart	2-Bracket, Roll Cart
4-Self tapping screws	4-Self tapping screws	4-Self tapping screws
6-5/16-18 Screws	6-5/16-18 Screws	6-5/16-18 Screws
6-½" Nuts	6-½" Nuts	6-½" Nuts

NOTE: When assembling stands for 48- or 60-inch cutters the rollers will have a threaded hexagonal shaft inserted into the roller instead of spring-loaded pins. Align holes in roller/hex shaft assembly with holes in the L-brackets and attach using 5/16-18 and ½ inch wrench. Place material rolls on top of these rollers.



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