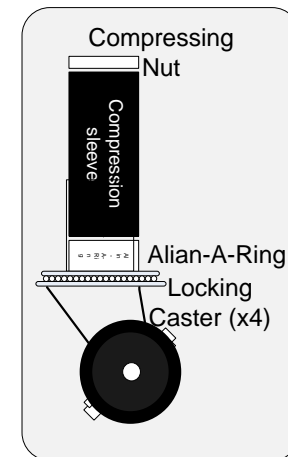
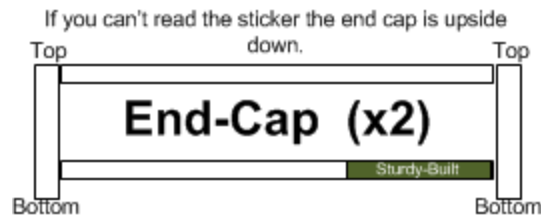


STURDY-BUILT ASSEMBLY INSTRUCTIONS



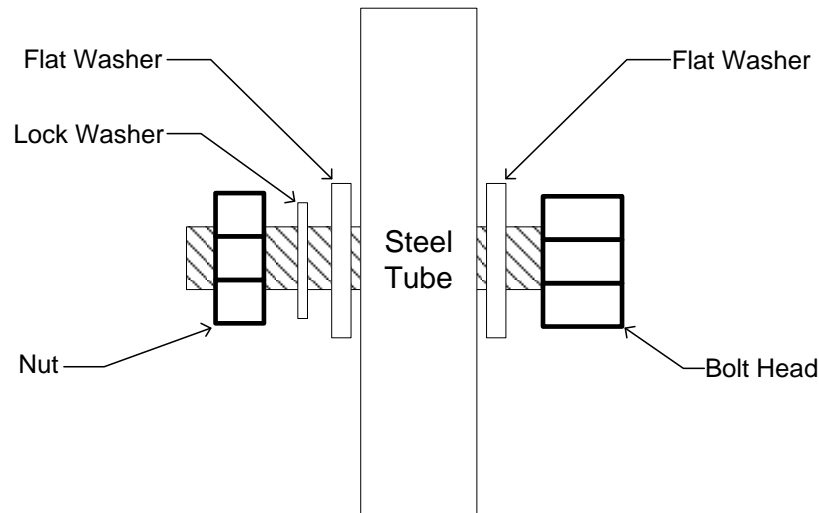
Parts Identification

- The Sturdy-Built basic kit includes 2 rails, 2 end caps and 2 cross members for smaller stray stands and 4 cross member



Tools Required

- Two 7/16 wrenches or battery operated hand drill with 7/16 nut driver socket adaptor to install fasteners. Never torque the fasteners above 60 inch pounds.
- One rubber mallet to install casters.
- **Never tighten greater than 60 inch pounds**



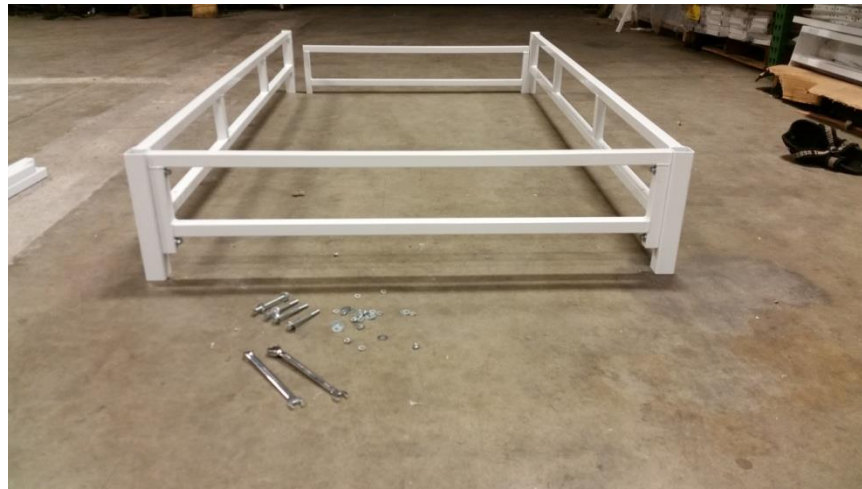
Available kits

XGEN-Fastener Kit	
4 inch Trellis Corner Bolts	0
3 INCH CORNER BOLTS	8
3 inch CROSS MEMBER bolts	8
2.0 inch POD Base Bolts	4
TOTAL# OF BOLTS	20
splits	20
flats	40
nuts	20

XGEN-Plastics kit	
1.25 inch black leg caps	4
1 inch cross memeber caps	8
cross member spacers	0

Basic Assembly

- Assembly of the basic stand is simple and fast. Each corner requires two bolts either 3" or 4" depending on your accessories.. Adjoin the end caps to the rails to form the basic structure.
- Apply 3" bolts to fasten the cross members from one rail across to the next.
- If you have legs, trellis, and casters please read on before you assemble your kit to save time, dismantling and reassembly.
- If you have purchased only the basic kit...you are finished.



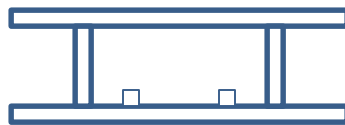
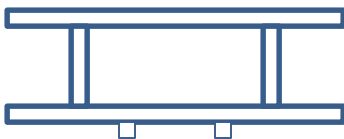
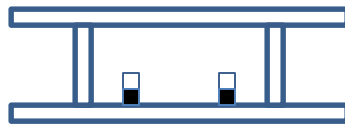
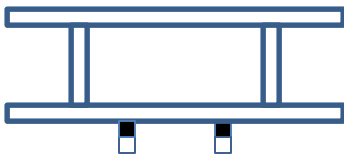
Mounting the legs, slope and no-slope

- There are four legs to a kit. Each leg requires two 3 inch bolts, two nuts, four flat washers, two lock washers, and one black plastic cap. Each leg has mount holes near one end of the leg. The holes located nearest that end defines the top of the leg. Put a black 1-1/4 plastic cap into the top of the leg. The legs are sized to slip into the ends of the rails noted as "receivers". Pay attention to the mount holes of the leg. One face is offset by one inch as compared to the other face. If your application requires "slope" the legs at one end of the stand should share the same mount point location and face. The legs at the opposite end should share the opposing face of the leg and also share their mount location. When done correctly, one set of legs will be flush to the top receiver while the legs at the opposite end will be extended one inch beyond the top of the receiver tube. If your application requires no-slope, then all mount point locations and leg face will be the same amongst all four legs. The slop option may require cutting 1/2 inch of the corner from tray of choice where the legs are extended beyond the top of the receiver tube.
- If the option choice was "No-Leg" and "No-slope", then the kit will include a "Leveler-Kit". This kit includes two 11 inch short legs that go up inside the shorter (10 inch) end of the rail receiver tube. As we have said, out-of-the-box, there is built in slope with each rail weldment we ship. Identify the shortest receiver tube and insert the 11' leveler-leg. It is installed correctly when one inch of leg is extending beyond the bottom of the receiver tube. There are no pictures that demonstrate in this manual.



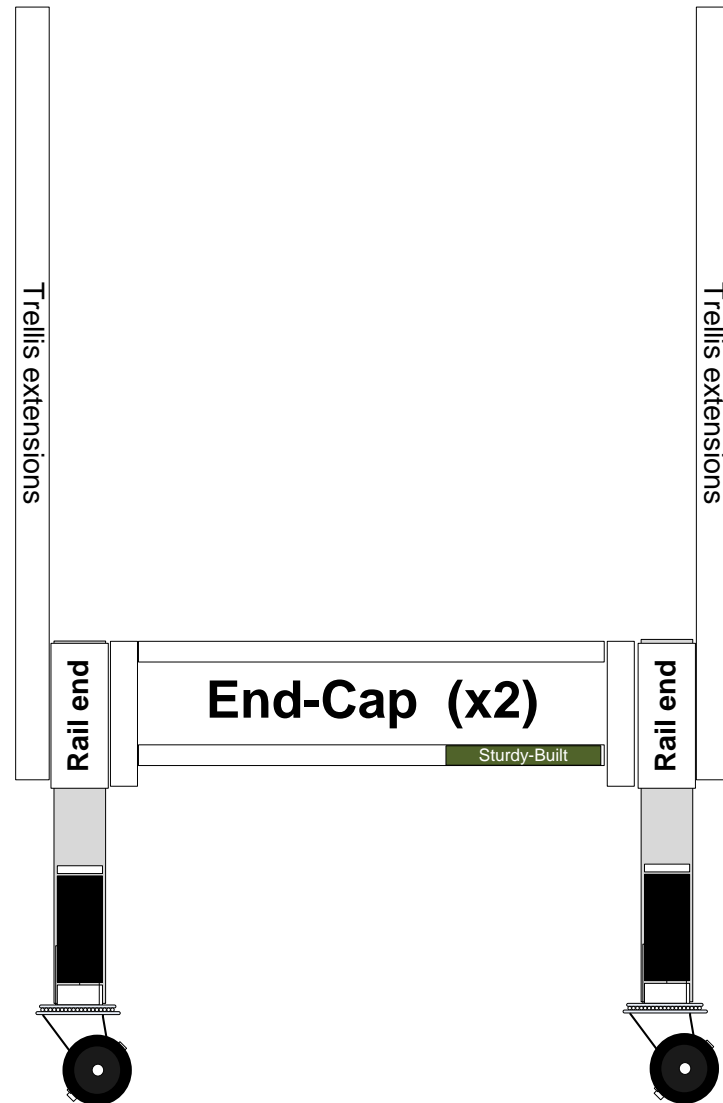
Cross Member Installation and Spacer Placement

- The cross members may be applied based on the style of tray you have chosen. The low tide tray style typically requires the largest count in horizontal support of six cross member. The I.D. tray style typically require the lowest count in horizontal support of four cross members. The rail used in all Sturdy-Built trays stands typically are manufactured with at least 6 to 8 locations for reliable support of the tray without sag and pooling of water. Choose location averaging less than 12 to 22 inches average spread between cross members for the optimum performance. The cross member also can be mounted with tray depth in mind. The common term is “pocket depth” and it can be adjusted to allow for the tray to sit within pocket height equivalent to the top on the stand. If you use the spacer kit use 3.0” bolts, no spacer, then use 2.5” bolts.
- This is accomplished with the use of spacers in combination with lower and upper placement of the cross member to the lower mount location of the lower rail tube. There are four configuration depicted below:



Trellis Extensions

- Trellis Extensions
- Fit trellis extensions to the exterior of the receiver tubes.
- Not inside the receiver tube
- Use 4 inch bolts to accomplish the installation.



Trellis Legs

- **Trellis Legs**
- Fit trellis legs into receiver tubes.
- Not the outside of the receiver tube.
- Use 3 inch bolts to accomplish the installation.
- Note: use the leg installation “slope/no-Slope” procedures as the trellis legs install the same way.

