



i-Tech Cart Assembly Instructions

Tools Needed: Ratchet handle with 3/8", 7/16", and 1/2" sockets, vise grips.

Note: Before beginning assembly, make sure all hardware and parts shown below are present in shipment. The rollers, brackets, and cross member for the material cradle are packed in the bottom of the cutter box. Remove all foam and parts from box. Store the cutter box in a safe location in the unlikely event that your cutter needs to be returned for service. Color Photo Manual is available on CD.

Included in cart box:

Qty 6- 5/16-18 Bolts

6- 5/16-18 Nuts

Qty. 8-1/4" lock washers

16- Self Tapping Screws

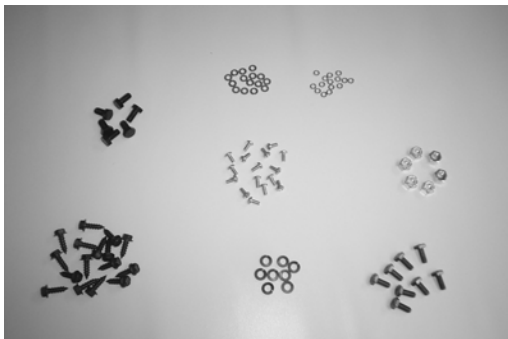
Qty. 8- 1/4-20 x 1/2" bolts

Qty. 16- 6-32x3/8" screws with flat and lock washers

2 Bases

2 Cart uprights

2 Top Braces



Hardware Kit

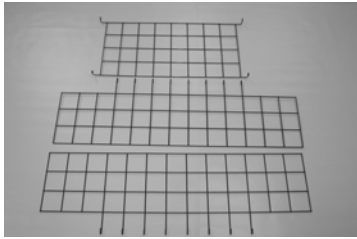


2 Angle Brackets



CONTENTS CONTINUED ON NEXT PAGE:

Front, Rear Baskets & Center Basket



Base Wheel Brackets



4 Wheels

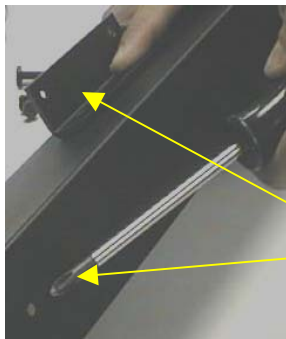


Assembly:

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



Step 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 bases for assembly. Also, 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 holes in base. See picture below, left.



Note position of holes and angle



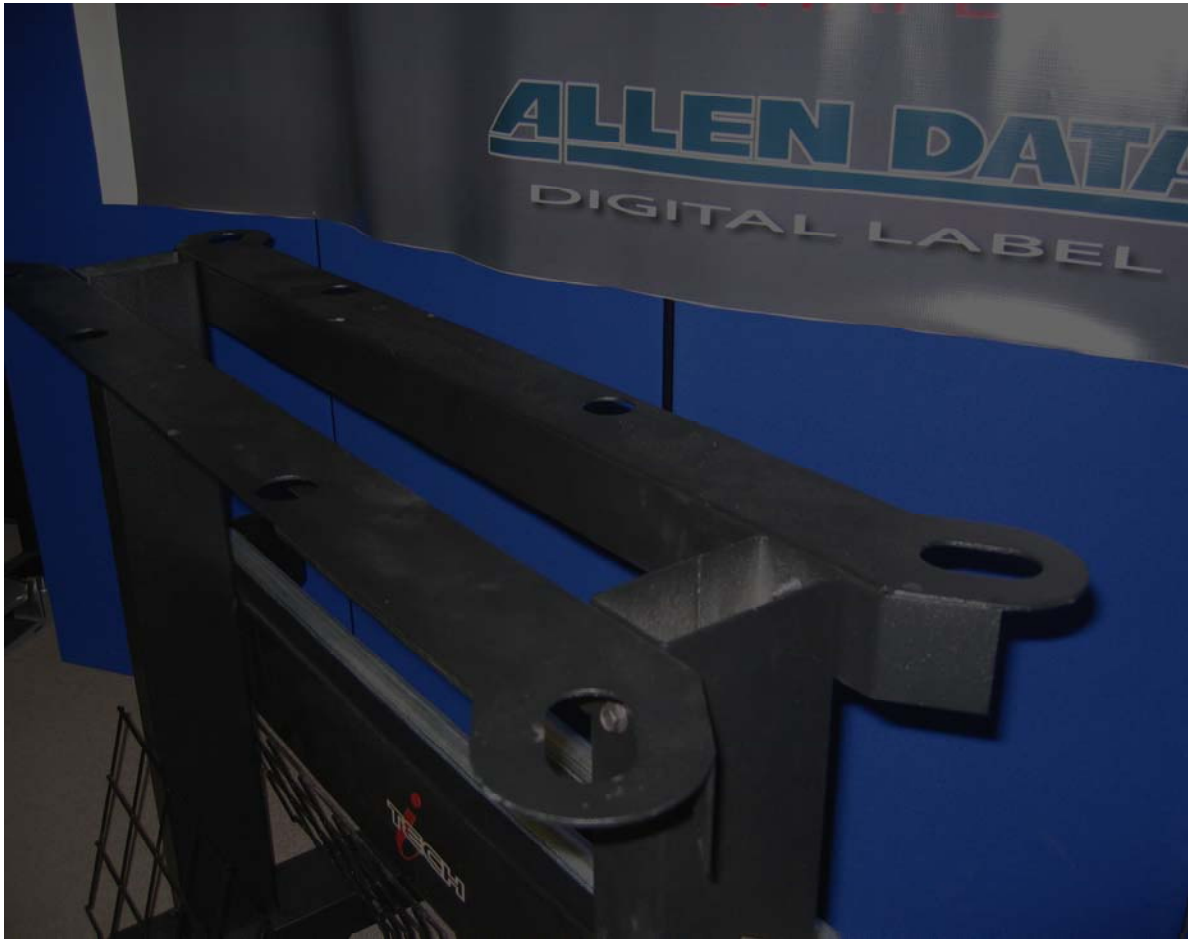
Align base bracket to be centered in base to allow full wheel rotation. Once this is done, tighten bolts using 7/16" ratchet or wrench. Once done you are now ready to attach the leg uprights to the wheel bracket assemblies.

Step 3 - Attach two base assemblies to two uprights using ¼-20 x ½” bolts and lock washers, making sure that the Allen logos on the sides of the legs are facing away from the side of the base assembly that has two holes in it. The logos will face in opposite directions when assembled correctly, as shown below, right.



Step 4 - Lie completed assemblies on floor so that the two holes near the top of the leg uprights are facing up. The Allen logos 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 opposite side is attached. Flip assembly over to attach the opposite brace in the same manner.





Step 5 - Attach center basket top base assemblies using self tapping screws. Secure using 3/8" socket. Do not over tighten.



Step 6 - Attach front and rear baskets, making sure that the vertical wires are facing the inside. This allows the vinyl to flow easily into the basket without interference. Once baskets are installed correctly, use vise grips to crimp outer hooks of basket around base basket wire to prevent basket from becoming dislodged.



Step 7 - Attach material cradle cross member to rear of cart using four self tapping screws. Insert rollers into angle brackets by holding the spring loaded end of the roller in with a screwdriver while inserting into bracket holes as shown below. **NOTE:** When assembling stands for 48 and 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.

The material roll is placed on top of these rollers.

Below is what your stand should look like finished.

