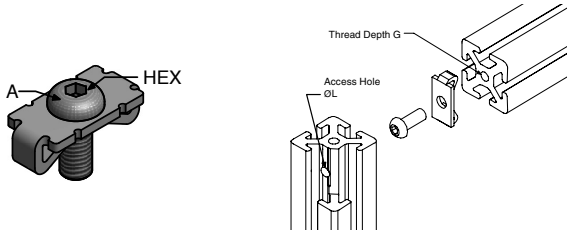


IPS Assembly Instructions

Main Assembly Components



Standard Fastener

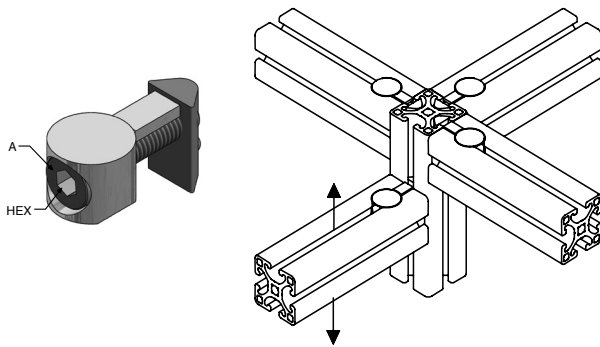


Ordering Information

Profile Series	Type	Dimensions							Torque Nm (in-lb)	Weight (g)	Part #*
		A	Hex	B	C	D	E	F			
40	Std	M8x18*	5	36	7.8	17	11	2.9	25 (220)	25	20-002
	SS	M8x18*	5	36	7.8	17	11	2.9	20 (180)	21	20-002SS
	SAE	5/16-18 x 3/4"	3/16"	36	7.8	17	11	2.3	25 (220)	25	25-003
	SAE SS	5/16-18 x 3/4"	3/16"	36	7.8	17	11	2.3	25 (220)	25	25-003SS
	S End	5/16-18 x 3/4"	3/16"	27	7.6	14	13	2.3	25 (220)	21	25-014
	S End	M8x18	5	27	7.8	17	11	2.3	25 (220)	21	20-144
30/28	Std	M8x18	5	23.7	7.8	16	8.9	1.9	25 (220)	15	20-003
	SS	M8x18	5	23.7	7.8	16	8.9	1.9	20 (180)	14	20-003SS
	S End	M8x18	5	21	7.8	14	8.9	1.9	25 (220)	15	20-143
20	Std	M5x12	3	4.8	4.8	10	4.5	1.1	4.5 (40)	5	20-021
1.5"	Std	5/16-18 x 3/4"	3/16"	1.42"	0.307"	0.669"	0.433"	0.114"	25 (220)	25	25-003
	SS	5/16-18 x 3/4"	3/16"	1.42"	0.307"	0.669"	0.433"	0.114"	25 (220)	25	25-003SS
	S End	5/16-18 x 3/4"	3/16"	1.05"	0.300"	0.550"	0.510"	0.090"	25 (220)	21	25-014
1"	Std	1/4-20 x 5/8"	5/32"	0.795	0.250	0.520	0.300	0.060	20 (180)	13	25-022

*Fastening plates may be ordered without a screw by adding "Z1" to part number, i.e. 20-002Z1.

Universal Fastener

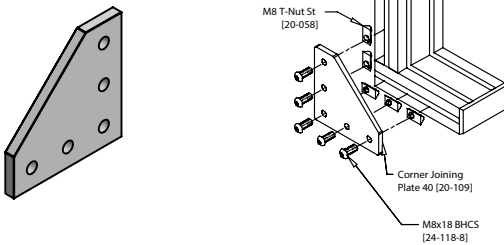


Ordering Information

Profile Series	A (SHCS)	Hex	B	C	D	E	Torque Nm (in-lb)	Wt. (g)	Part #
40	M8x30	6	16	8	20	33.8	25 (220)	41	20-004
28 to 40	M6x30	5	11	8	20	33.5	14 (125)	36	20-011
30	M6x27	5	11	8	20	31.3	14 (125)	31	20-008
28	M6x27	5	11	8	20	31.3	14 (125)	30	20-005
20	M4x14	3	8.5	5	12	17.2	3 (26)	7	20-040
1.5"	5/16-18 x 1 1/4"	3/16"	16	8	20	33.8	25 (220)	41	25-004
1"	1/4-20 x 3/4"	5/32"	10.7	6.4	14	21.5	13 (120)	25	25-023
Universal Zinc Casting 40 (40 Series without T-Nut or Screw)									20-004Z1
Universal Zinc Casting 28 (28 Series without T-Nut or Screw)									20-005Z1

*Fastening plates may be ordered without a screw by adding "Z1" to the part number, i.e. 20-004Z1

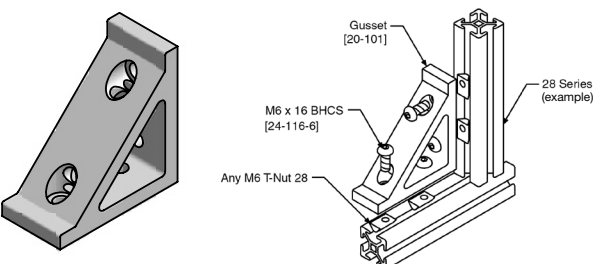
Corner Plate



Recommended Fasteners (Order Separately)

Series	Screws	T-Nuts	Double T-Nut (if applicable)
40	24-118-8	20-058	20-050
30	24-110-8	20-058	20-050
28	24-110-8	20-057	—
1.5"	25-110-5	25-002, 25-082 or 20-182	25-041 or 25-046
1"	25-108-4	25-031 or 25-034	—

Machined Gussets



Recommended Fasteners (Order Separately)

Series	Screws	T-Nuts	Double T-Nuts
40	24-118-8	20-058 or 20-050	20-050
30	24-116-6	20-056	—
28	24-116-6	20-055	—
1.5"	25-112-5	25-002 or 25-041	—
1"	25-110-4	25-031 or 25-034	—

IPS Assembly Instructions



Main Assembly Components

Pre-Assembly Instructions and Tips

1. Upon receipt of your order, check to see that you have received a complete kit with numbered components. All extrusions are clearly marked with a number designation. Sort all the extrusions according to these designations. If a drawing was supplied, these numbers will correspond with the numbers shown on the drawing and also with those on the bill of materials.
2. Assembly should be performed on a flat surface as this helps insure proper alignment and perpendicularity of the frame.
3. Thread all end fasteners into tapped ends of extrusions but do not tighten the bolts.
4. Pre-assemble all joiner plates, gussets, brackets, wire mesh clamps and anchor fastener assemblies but do not tighten the bolts.
5. If economy T-nuts are being used on joiner plates, gussets, brackets and any accessories which are to be mounted between end fastenings of the main assembly, then these systems of the T-nut should be installed in the proper T-slot at this time.
6. Install all wheels, leveling feet, hinges, handles and end caps after the main frame is constructed.
7. If solid panels are part of the installation, they should be installed in the T-slot after three sides of its frame have been formed. If panel gasket (12-106) is being used, it should be wrapped around the panel, notched at each corner and then slid into the extrusion's "u-shaped" frame.
8. Use a rubber mallet when installing panels and tap panels evenly to insure that they seat to depth within the T-slot.

Main Extrusion Services and Most Used Tools

