## Prior to Beginning

1. Provide a large and flat work space for the assembly.
2. Sort the extrusions into parts and sizes.
3. Count and confirm the qty. of the nuts to be pre-inserted.

## Assembly of Single Joint connected type.

**Bottom Frame Assy.**

1. Begin assembling with the Bottom Frame. Center post is connected with the Top Assy. in Double Joints.
2. Insert the nuts in bottom frame.

**Top Frame Assy.**

1. Connect the assembly with Single Joint.

## Mount the Posts.

1. Connect the assembly with Single Joint.

## Final Tightening

1. Mount the Middle Posts.
2. Bottom Frame Assy.
3. Top Frame Assy. (2)
4. Top Frame Assy. (1)
5. Adjuster and Caster Mounting

## Aluminum Extrusion Frame Assembly

### Pre-assembly Double Joint

- Insert the pre-assembly fitting nuts.
- Pass the single joint through and position it. (Backlash should be kept.)
- (2) Center joist is connected with Pre Assy. Ins. Double Joints.
- (1) Begin assembling with the Bottom Frame.

### Surface Cleaning

1. Fully tighten while adjusting the extrusions positions.
2. Wipe the surface using alcohol, etc. after the easy work.

### Aluminum Extrusion Q&A

**Q. Can JIS standard hex nuts and square nuts be used with the extrusions?**

A. Yes, they can be used. Our dedicated nuts are designed with larger seating areas to prevent aluminum from buckling under load.

**Q. What is the perpendicularity?**

A. Since the extrusions do not have any datum, perpendicularity of cuts are not defined.

**Q. What are the surface treatment methods used?**

A. There are following methods to mount resin panels. Select an applicable method specific to your application.

- Use Pre Assy. Insertions Nuts with “Stoppers.”
- For extrusions for Brackets (~2490 P.2481):
- Resin plate doors... Hinges, Handles, etc.
- Extrusion frame doors... Use Cover Plates and HFS5-2020/HFS6-3030 extrusions to construct the doors.

**Q. Is Express-T for extrusions free of charge?**

A. Yes, and we intend on keeping it free. If a same day shipping is desired, simply specify as Express-T. There is no additional charge for the service.

**Q. What is the aluminum material used?**

A. AA6015-T6 Aluminum Alloy is used. High rigidity material with more strength compared to 6063 Aluminum Alloy typically used for extrusions.

**Q. I want to size some brackets, what’s a guideline?**

A. Applicable brackets and load capacity guidelines for each extrusion type are separately listed on bracket product pages.

- Pre-assembly Double Joint (P.2390), Post Assy. Insertion Double Joint (P.2299).
- Aluminum Extrusion Q&A

**Q. How can I mount doors on my extrusion frame?**

A. There are following methods to mount doors. Select an applicable method specific to your application.

- Provide a flat and ample space for the assembly work.
- Panel drilling or screws, and recommended for applications where designed appearance is of high priority.
- Requires no panel drilling or screws, and recommended for applications where designed appearance is of high priority.
- Plate Type Top Plate and/or covers also.
- Within ±0.5mm of customer specified length.
- For orthogonality checks and face leveling during the assembly, use plates (assembly jigs on P.2271).
- Be sure to check the screw torques after the assembly is complete.

**Q. Any precautions on the assembly?**

A. There are following methods to mount doors. Select an applicable method specific to your application.

- For orthogonality checks and face leveling during the assembly, use plates (assembly jigs on P.2271).
- We recommend that you purchase some Post Assy. Ins. Nuts prior to the assembly work as spares.
- Be sure to check the screw torques after the assembly is complete.

**Q. In Express-T for extrusions free of charge?**

A. Yes, and we intend on keeping it free. If a same day shipping is desired, simply specify as Express-T. There is no additional charge for the service.

(Extrusions for Brackets (~2490), General Purpose Extrusions (~2429-2430), Fence Extrusions (~2427) are not subject to free Express-T service.)