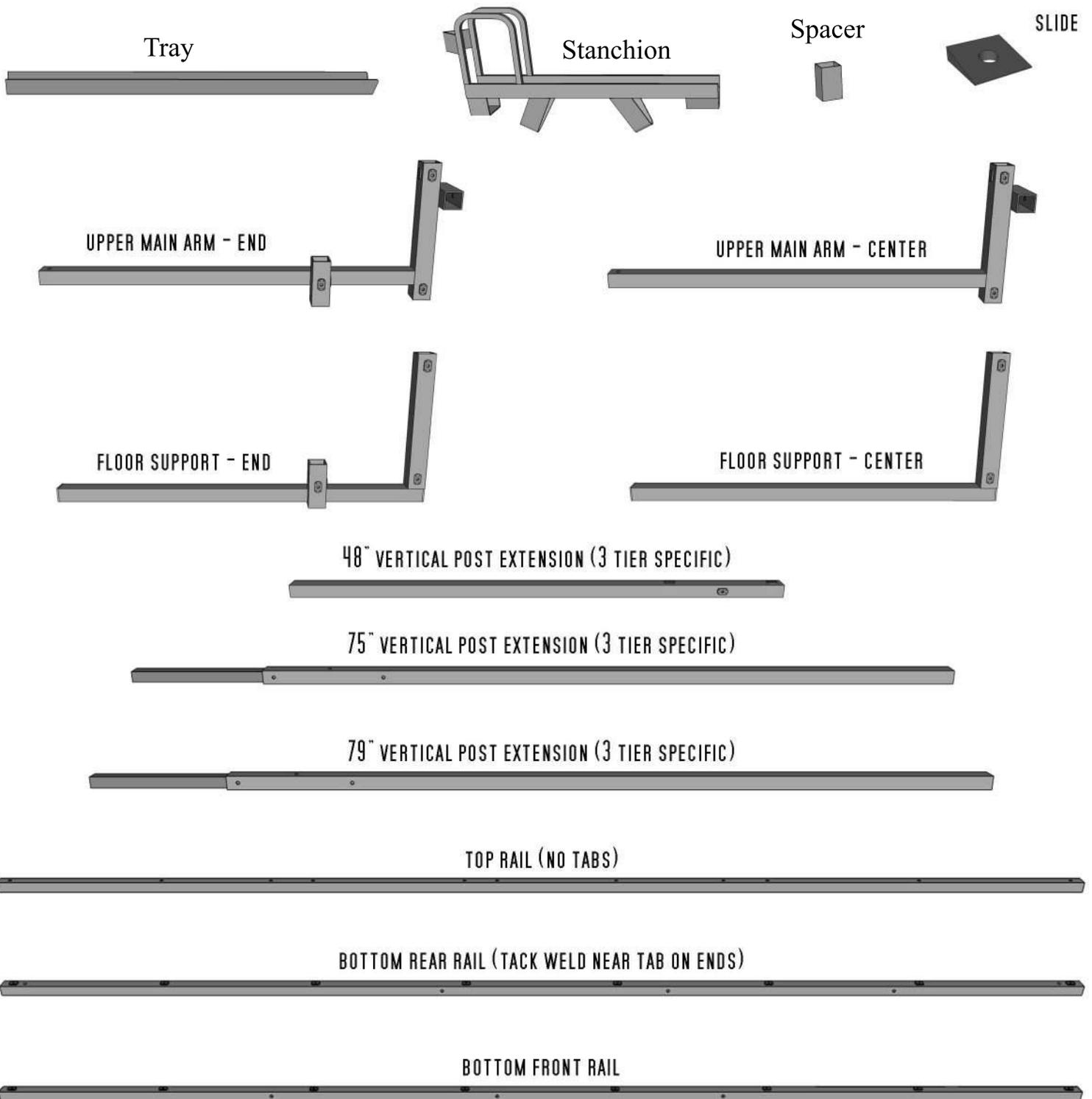


Straight Forward 3 Tier Instructions

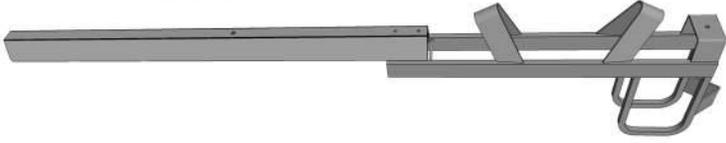


5/16" x 2-1/2" Bolts
5/16" x 2" Bolts
1/4" x 3/4" Bolts
5/16" x 1/2" Bolts
5/16" x 3" Bolts

Black Plugs 1-1/4" 14 GA
Black Rectangular Plugs
5/16" Washers
1/4" Washers
5/16" Stopnuts
1/4" Stopnuts

Super Tray Assembly

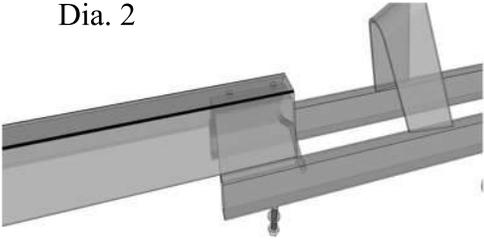
Dia. 1



step 1

Flip a stanchion and tray upside down. Align the 2 holes in the stanchion with the 2 holes in the tray. The tray should be on the outside of the stanchion, as shown in Dia. 1.

Dia. 2



step 2

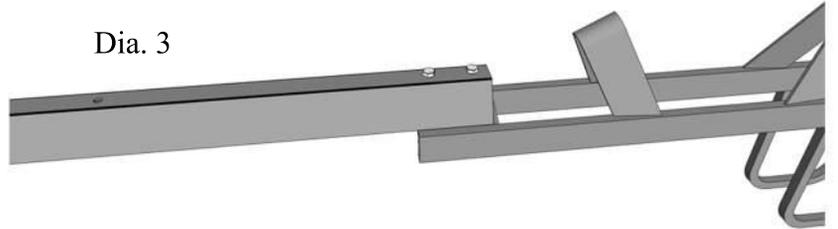
Place a 1/4" washer over a 1/4" x 3/4" bolt. Insert the assembly through one of the holes, as shown in Dia. 2. Tighten loosely with a 1/4" stopnut.

step 3

Repeat Step #2 in the open hole, as shown in Dia. 3.

Tighten using two wrenches.

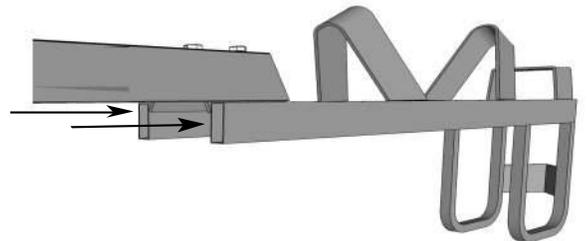
Dia. 3



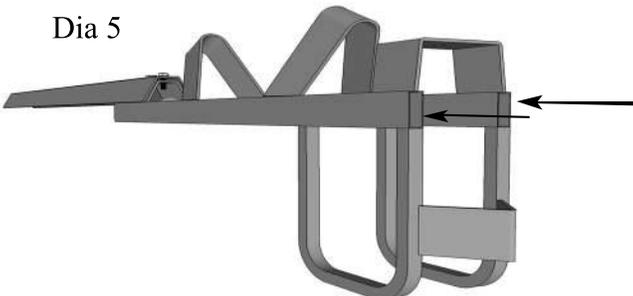
step 4

Insert 2 of the Rectangular Black Plugs in the open holes in the front of the stanchion, as shown in Dia. 4.

Dia. 4



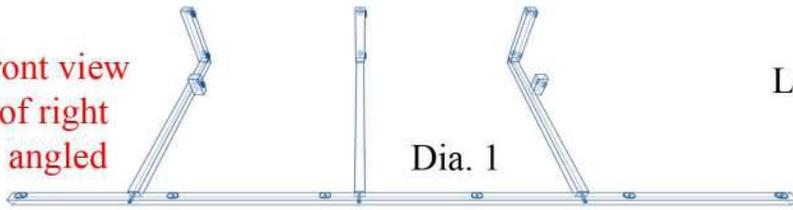
Dia 5



step 5

Insert 2 of the plugs in the back of the stanchion, as shown in Dia. 5. Your tray is now complete!

front view
of right
angled

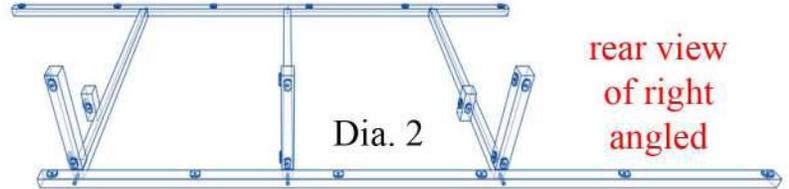


step 1

Locate the bottom front rail (no dot on ends of rail, with weld tabs every 18"). lay out on floor as shown in Dia. 1 , **do not attach**.

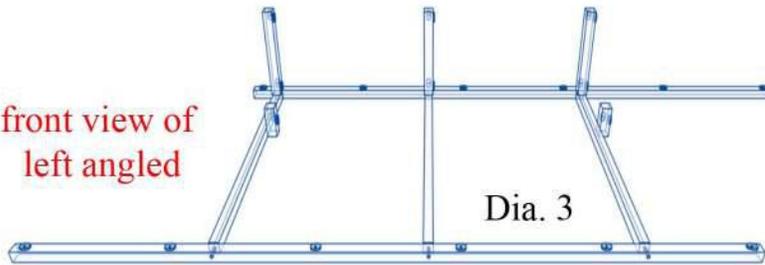
step 2

Next locate the bottom rear rail (spot welds on both ends of rail, and weld tabs every 18"). Layout on floor as shown in Dia. 2, **do not attach**



rear view
of right
angled

front view of
left angled



STOP!

Dia. 1 and Dia. 2 are pictures of a right angled set up, Dia 3 is a picture of a left angled orientation. To achieve a left angled rack you need to spin **only** the rails 180 degrees.

Step 3

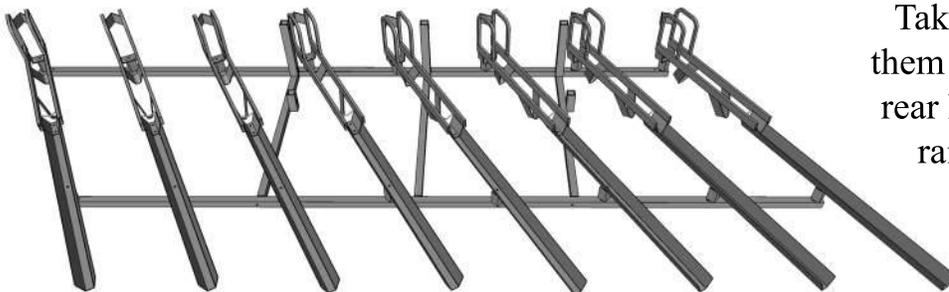
Now it's time to pre-assemble your trays. Please refer to the Super Tray Assembly page.

step 4

Place the Straight Forward Spacers over the rear and front weld tabs. Make sure to place these at an angle because the trays will be angled.



Dia. 5

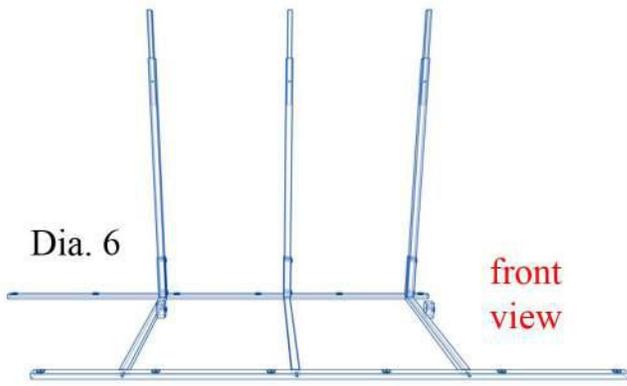


step 5

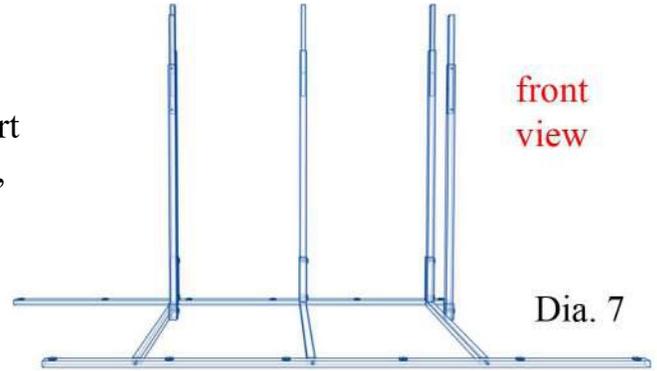
Take the pre-assembled trays and place them over the Spacers. Align the front and rear holes of the tray with the holes in the rails. Attach the trays and spacers to the rails using 5/16 x 3" Bolts and 5/16" Washers. Tighten.

step 6

Locate the 79" vertical posts (3). Insert the 79" posts into the vertical tubes on the rear of the floor supports, with the inserts up. Using 5/16" x 1/2" bolts, secure the vertical posts to the floor supports as shown in Diagram 6.

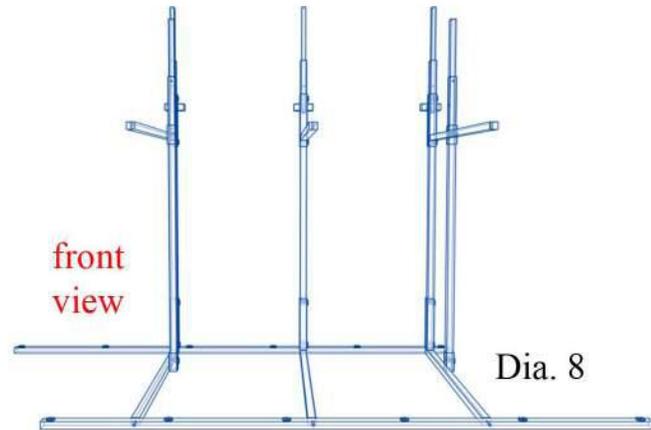


Then take the remaining 75" vertical posts (2) and insert them into the other vertical tubes of the floor supports, with inserts up, as shown in Dia. 7. Secure using 5/16" x 1/2" bolts.



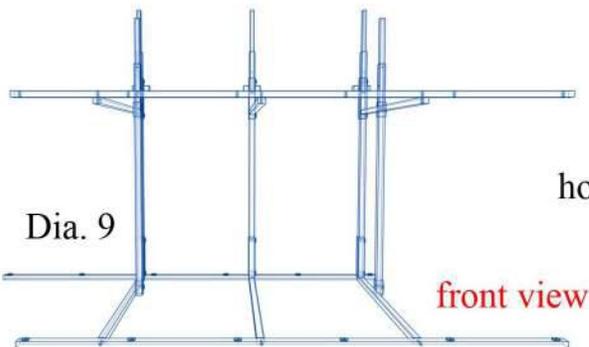
step 6

Now you need to locate the upper main arms (two ends, one center). Slide the upper arms over the vert posts, as shown in Dia. 8. At this point you need to decide at which height from the floor that you want the second tier to be. We recommend about 50" inches (127 cm) from the bottom of the rail to the floor. Then using 5/16" x 1/2" bolts secure the upper main arms to the vert posts at desired height.



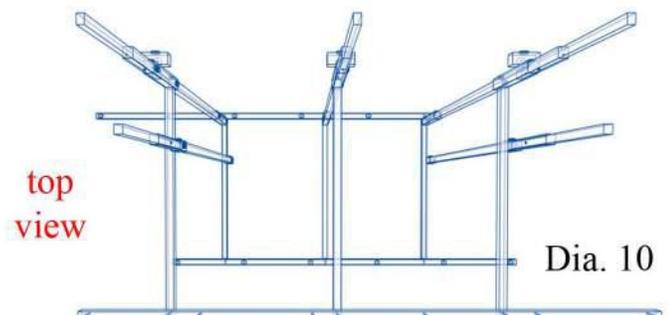
step 7

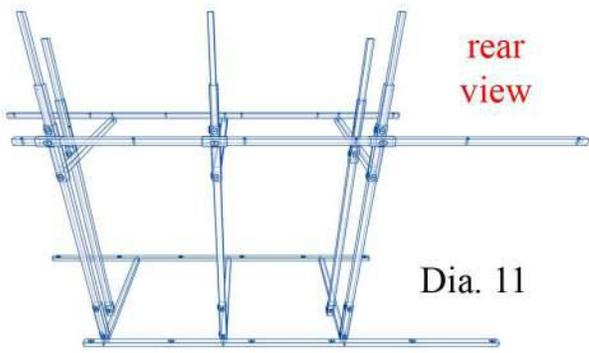
Locate one of the top rails (should only have holes through it). Place the rail on the front of the upper main arms corresponding to the placement of the bottom front rail. As shown in Dia. 9.



Align the holes on the rail with the holes on the upper main arms, as shown in Dia. 10. Using 5/16" x 3" bolts, secure the rail to the upper main arms.

right angle rack is pictured.



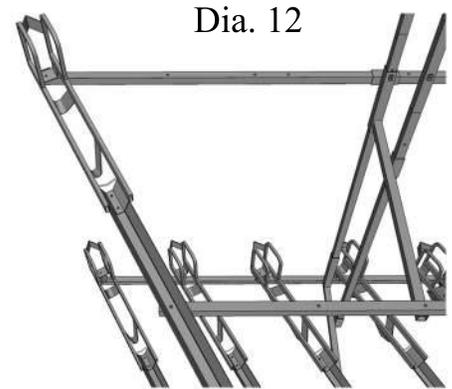


step 8

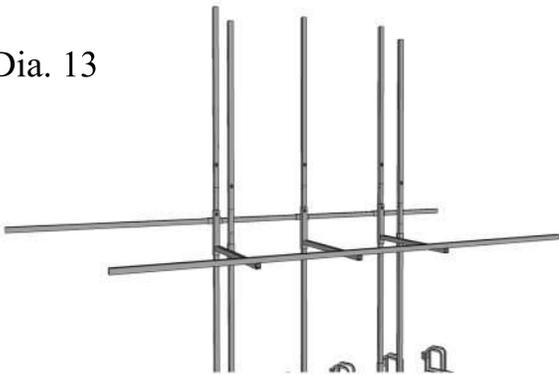
Now find another top rail, slide it through the horizontal tubes on the back of the upper main arms. As shown in Dia. 11.

step 9

The next step is aligning the rear rail. This is easiest done by taking a tray and setting it on the rails with the front hole of the tray on the end of the top front rail. Put a bolt in the hole but do not secure. Now adjust the rear rail by sliding it so the back hole in the tray lines up with the hole in the rail, as shown in Diagram 12. Using 5/16" x 1/2" bolts, secure the rear rail to the upper main arms. Loosely tighten.



Dia. 13



step 10

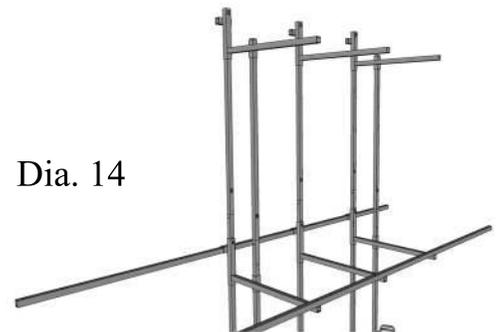
Find the (5) 48" third tier vertical posts. Slide them over the inserts at the end of the 79" and 75" vertical posts, with the weld tabs down. Using 5/16" x 1/2" bolts, secure the 48" vert posts to the 79" and 75" vert posts, as shown in Dia.

13.

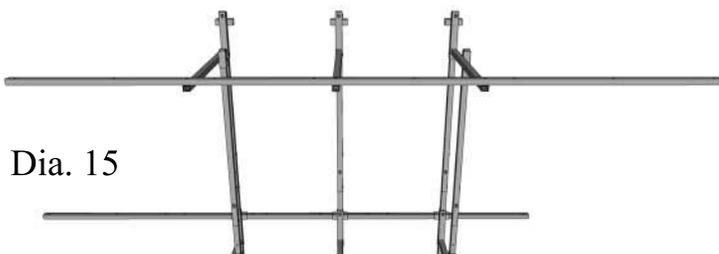
step 11

Repeat step 6. Sliding upper main arms over vert posts, determine the height that you want the third tier to be, and secure using 5/16" x 1/2" bolts. We recommend making the front portion of the upper main arms flush with the top of the 75" vert posts, as shown in Dia. 14.

Dia. 14



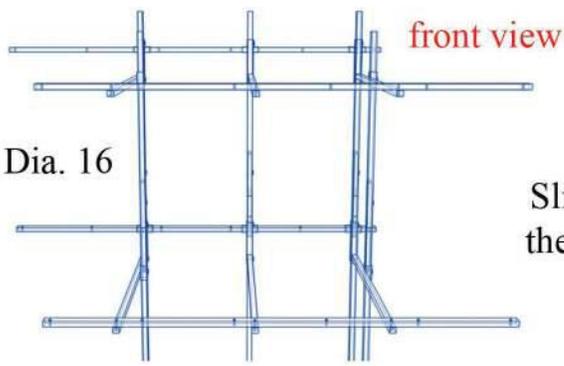
Dia. 15



step 12

Repeat Step 7.

Secure the front rail to the upper main arms of the third tier, as shown in Dia. 15.



step 13

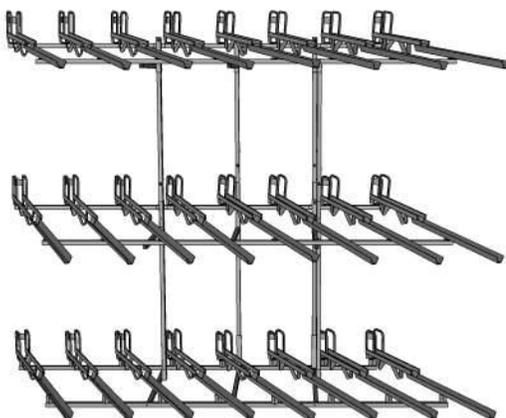
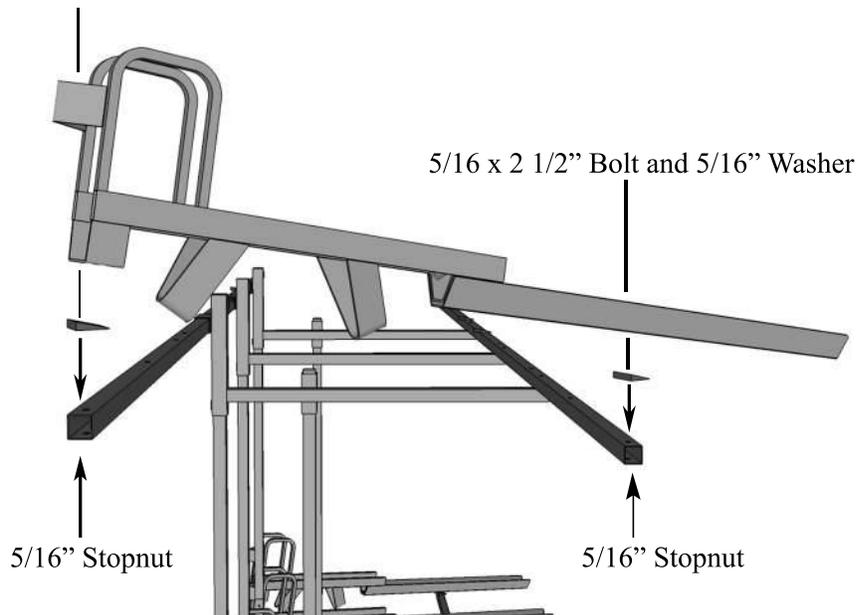
Repeat step 8 and step 9.

Sliding the top rail through upper main arms, using a tray to set the rear rail in proper place and securing with 5/16" x 1/2" bolts. As shown in Dia. 16.

step 14

The last step is to attach the trays to the second and third tier of the structure. Start at one end of the structure (we recommend attaching the trays to the third tier first, then the second), place wedges on the rails so the holes line up. Remember to angle the wedges as the tray will be angled. Using a 5/16" x 2-1/2" Bolt and 5/16" washer, attach the tray to the rails, putting the bolt through the tray and stanchion, then the wedge, and finally the rail. Secure with a 5/16" stopnut from below, as shown in Dia. 17.

5/16 x 2 1/2" Bolt and 5/16" Washer



Go back through and tighten any loose bolts.

Your three tier Straight Forward is now complete!