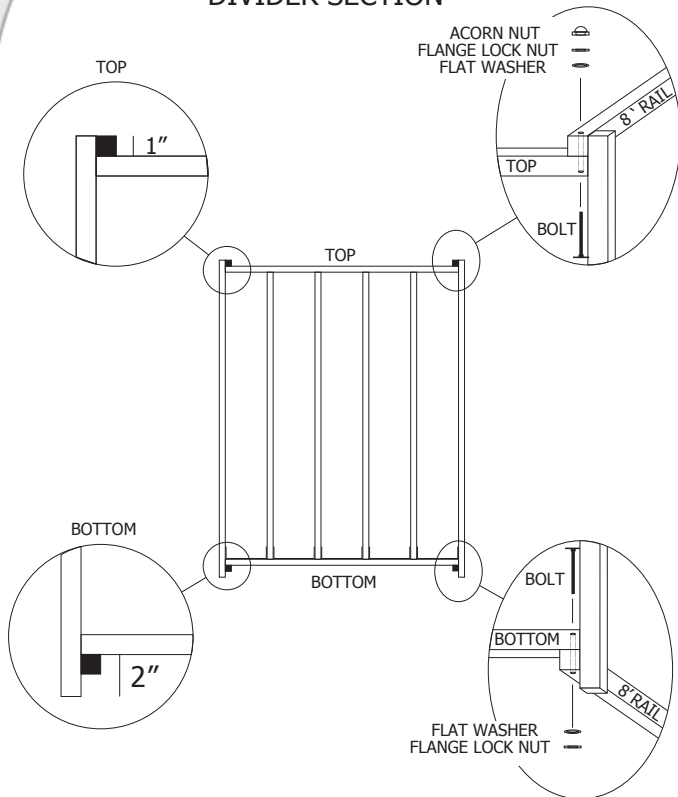


## SUBR48X5 - SUBSTRATE STORAGE RACK - Assembly Instructions Rev. 7/24/14

### DIVIDER SECTION



### SUBSTRATE RACK

1. Prior to assembly, please study both the assembled and exploded pictures of the substrate rack, above. Due to size and handling requirements, we recommend that two people assist in the assembly of this rack.
2. Tap plastic end-caps into open ends of the four sections of 8' rail tubing and the two open ends on the top of each divider. The tops of the dividers can be identified by a 1" offset from the connecting bar. See illustration, above.
3. Stand one divider on its side and attach an 8' rail to the "bottom", as pictured in the drawings (or it will be very difficult to tighten the nuts). Again, note that the bottom of the divider has a 2" leg and the top has a 1" leg. The bolt goes through the divider, first, and then through the 8' rail. Secure with a flange lock nut. Snug but do not tighten until all 4 divider sections have been secured to both of the bottom 8' rails.
4. Attach another 8' rail to the bottom of the 4 dividers. Tighten all eight hardware assemblies, ensuring that the head of the bolt is seated tightly against the rail. Note that the square part of the bolt will wedge into the round hole of the tubing, allowing the nut to be tightened, even though there is no bolt head to grip.
5. Stand the assembly up and attach the last two 8' rails to the top of the dividers. Insert the bolts from below, through the divider and up through the top rail. Secure with a flange lock nut. Snug, but do not tighten until all eight hardware assemblies are installed. Then, tighten as previously described. Cap off the eight bolts on the top section with acorn nuts.
6. Apply double-sided tape to the center of the opening in each divider by cutting (20) strips 7" long. The tape is applied where the pans sit in the dividers. Don't put the tape on any of the bolt heads. Offset the tape in these openings. Be sure to remove the tape backing before installing pans. Two people are required to install the pans. Feed the pans in at an angle, between divider vertical rails. When even at both ends, rotate into place and press down to stick to tape. The substrate rack is now ready to use.

**Suggestions:** A piece of plywood or particle board can be placed on top of the rack and secured with double-sided tape for extra storage. Pegboard can be attached to the sides for tool storage with self-tapping sheet metal screws.

Please contact manufacturer for questions, comments or problems:

METALCRAFT INDUSTRIES, INC.  
120 Cypress Road, Ocala, FL 34472  
Phone (352) 680-3555 FAX (352) 680-3559  
Email: [sales@metalcraftindustries.net](mailto:sales@metalcraftindustries.net)

THANK YOU FOR CHOOSING METALCRAFT!