



ASSEMBLY INSTRUCTIONS

VERTICAL Surerack™ ASSEMBLY INSTRUCTIONS FOR XFIIRE MODELS: BOILER/WATER HEATER: 300B TO 1000B IFIIRE MODELS: BOILER/WATER HEATER: IBGWSF1 0300 TO 1000 KITS: 100-10000609 (300-500), 100-10000612 (650-800) & 100-10000608 (1000)

IMPORTANT NOTICE: These instructions are for use by qualified personnel specifically trained and experienced in the installation of this type of heating equipment and related system components. Installation and service personnel may be required to be licensed in some states. Persons not qualified shall not attempt to install this equipment nor attempt repairs according to these instructions.

SCOPE: The details of this document will provide instructions for the assembly of the XFIire and IFire boiler/water heater vertical SureRack™ assemblies; sizes 300 through 1000.

KIT CONTENTS:

ITEM	QTY.	DESCRIPTION (MODEL 300-500)
1	2	CHANNEL-BASE SKID RACK
2	2	PLATE-3/8" H.R. 5" X 41"
3	1	CHANNEL-SUPPORT
4	2	LEG ASSY-XFIIRE RACK
5	2	LEG ASSY-XFIIRE RACK
6	8	WASHER-FLAT 1/2"
7	24	WASHER-LOCK 3/8"
8	24	SCREW-HX HD 3/8"-16 X 1-1/2"
9	24	NUT-HX 3/8"-16
10	4	SCREW-HX HD 1/2"-13 X 2"
11	4	NUT-HX 1/2"-13
12	2	STEEL PLATE-5/16" H.R. 3.5" X 37"
13	48	WASHER-FLAT 3/8" SAE

ITEM	QTY.	DESCRIPTION (MODEL 650-800)
1	2	CHANNEL-BASE SKID RACK
2	2	PLATE-3/8" H.R. 5" X 50"
3	1	CHANNEL-SUPPORT
4	2	LEG ASSY-XFIIRE RACK
5	2	LEG ASSY-XFIIRE RACK
6	8	WASHER-FLAT 1/2"
7	24	WASHER-LOCK 3/8"
8	24	SCREW-HX HD 3/8"-16 X 1"-1/2"
9	24	NUT-HX 3/8"-16

ITEM	QTY.	DESCRIPTION (MODEL 650-800)
10	4	SCREW-HX HD 1/2"-13 X 2"
11	4	NUT-HX 1/2"-13
12	2	STEEL PLATE-5/16" H.R. 3.5 X 46"
13	48	WASHER-FLAT 3/8" SAE

ITEM	QTY.	DESCRIPTION (MODEL 1000)
1	2	CHANNEL-BASE SKID RACK
2	2	PLATE-3/8" H.R. 5" X 55"
3	1	CHANNEL-SUPPORT
4	2	LEG ASSY-XFIIRE RACK
5	2	LEG ASSY-XFIIRE RACK
6	8	WASHER-FLAT 1/2"
7	24	WASHER-LOCK 3/8"
8	24	SCREW-HX HD 3/8"-16 X 1-1/2"
9	24	NUT-HX 3/8"-16
10	4	SCREW-HX HD 1/2"-13 X 2"
11	4	NUT-HX 1/2"-13
12	2	STEEL PLATE-5/16" H.R. 3.5" X 51"
13	48	WASHER-FLAT 3/8" SAE

TOOLS REQUIRED

- Ratchet
- 3/8" Socket
- 1/2" Socket

ASSEMBLY INSTRUCTIONS:

1. Stand four (4) leg assemblies (Item 4 & 5: Qty 2) vertically. Place each Channel Base Rack (Item 1: Qty 2) on top of the leg assemblies. Secure the assemblies using the provided bolts nuts and washers (Items 7, 8, 9 & 13). See **Figure 1**.

NOTE: All bolts/nuts shall be only hand-tightened until after completing Step 3. The nuts can then be fully-tightened.

NOTE: Ensure the legs are placed as shown with labels “1” and “2” diagonally across from each other; and the Channel Base arrows facing outward.

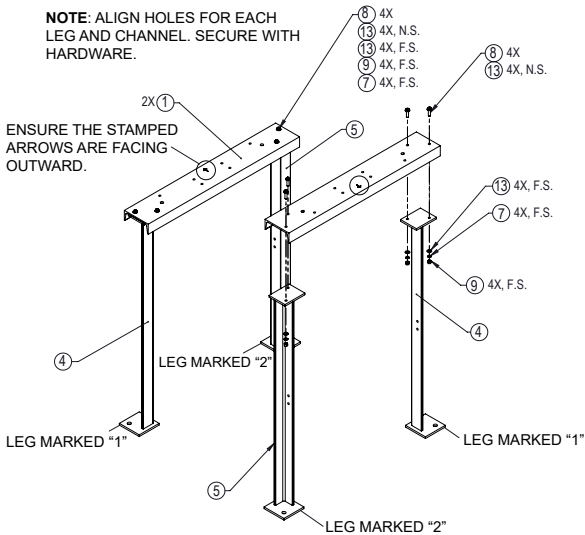


Figure 1. Assemble Legs and Channel Base

2. Attach two (2) Plates (Item 2) and one (1) Channel Support (Item 3) to the Leg and Channel assemblies from Step 1. Secure the assemblies using the provided bolts, nuts and washers (Items 7, 8, 9 & 13). See **Figure 2**. Do not fully-tighten hardware, leave hand-tight for now.

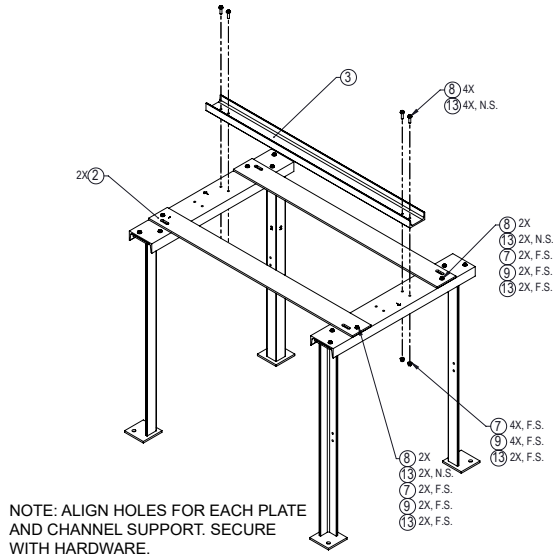


Figure 2. Assemble Plate and Channel Supports

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3. Attach two (2) Steel Plates (Item 12) to the Leg assemblies. Secure the assemblies using the provided bolts, nuts and washers (Items 7, 8, 9 & 13). See **Figure 3**. Fully tighten all hardware.

NOTE: Steel Plates (Item 12) are size-specific for each boiler size range. See Table below for details.

MODELS	PLATE LENGTH
300-500	37"
650-800	46"
1000	51"

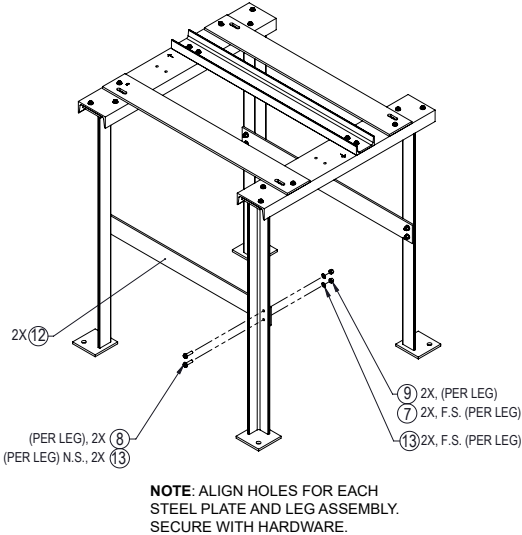


Figure 3. Assemble Steel Plate to Leg Assembly

4. Using a forklift, mount the boiler/water heater on top of the rack system. Secure the unit to the rack using provided bolts, nuts and washers (Items 6, 10 & 11). The completed rack is shown in **Figure 4**. The complete assembly including the mounted unit is shown in **Figure 5**.

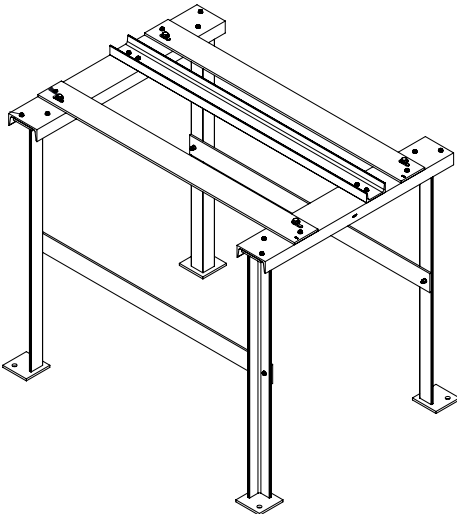


Figure 4. Completed Rack

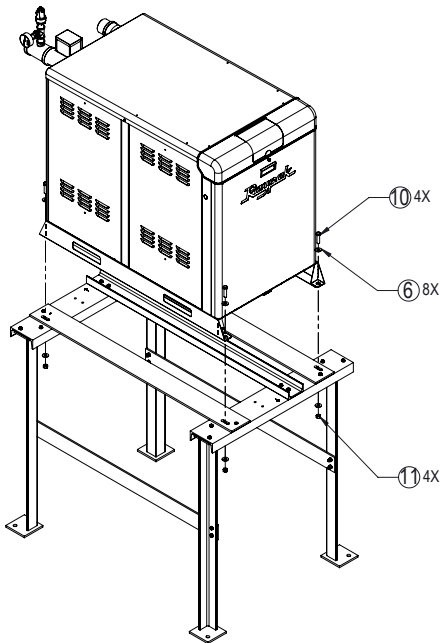


Figure 5. Unit Mounted on Rack

5. If installing a second unit at the bottom of the rack, ensure the secondary unit is placed no further than 0.25" behind the dashed line shown in **Figure 6**.

CAUTION: If the secondary unit is not recessed appropriately in the rack, the plumbing, venting, gas and combustion air can potentially conflict between the two units.

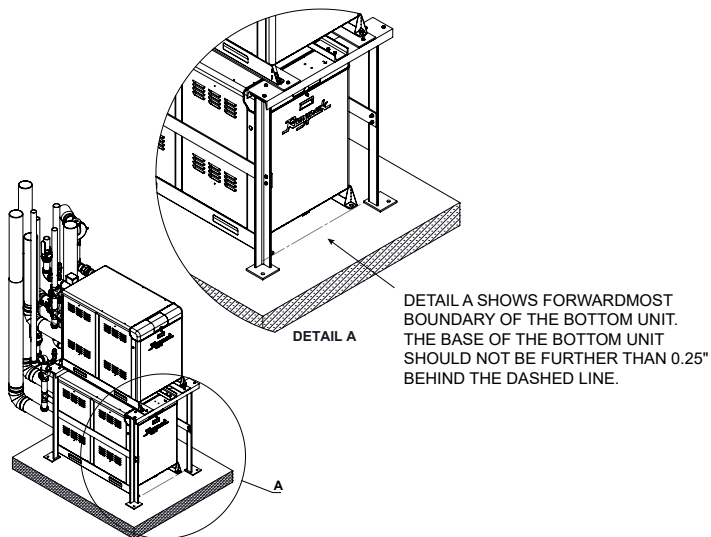


Figure 6. Secondary Unit Positioning