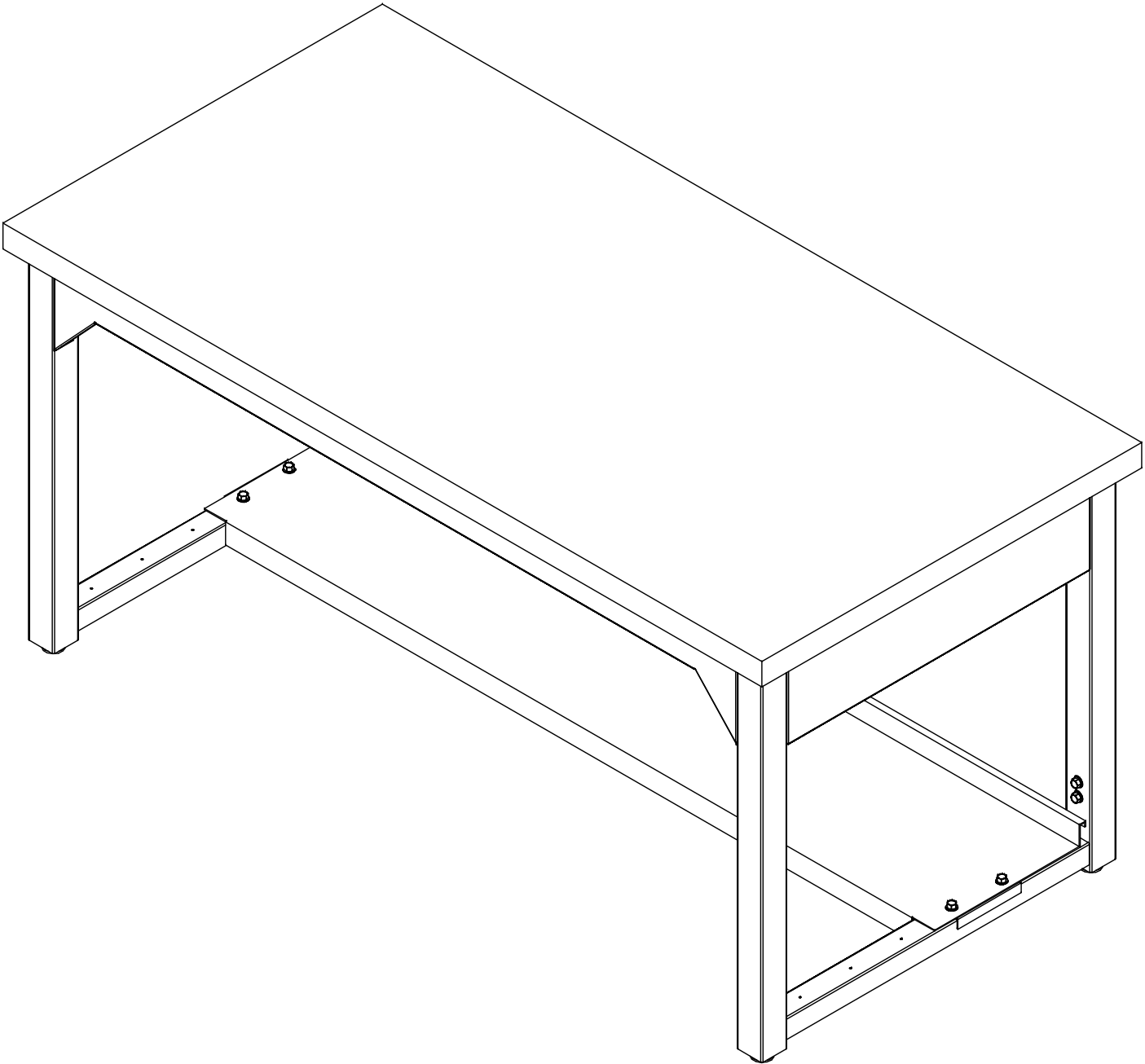


ADJUSTABLE METAL TABLE

AMS SERIES TABLES ASSEMBLY INSTRUCTIONS




NOTE:

1. MODEL VIEWS MAY NOT REPRESENT EXACT MODEL PURCHASED

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
REVISION LEVEL				

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		APR BY:		DATE APR:	
		APR BY:		DATE APR:	
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TITLE:
ADJUSTABLE METAL TABLE
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
AMS SERIES TABLES	NTS	1 OF 12	REV C

TOOLS REQUIRED
½" WRENCH
½" SOCKET AND TORQUE WRENCH - OPTIONAL
DRILL
⅜" DRILL BIT
C-CLAMPS
SHIM STOCK (IF NEEDED)

BREAKDOWN OF HARDWARE BAG

HARDWARE BAG - 255713
QTY (8) - 3/8-16 X 1 BOLT WITH 3/8 STAR WASHER
QTY (12) - 1/4-20 X 1 BOLT WITH 1/4 FLAT WASHER AND 1/4 STAR WASHER
QTY (4) - #8 X 5/8 LG. SCREW FOR BRACE
QTY (20) - #12 X 7/8 LG. SCREW FOR TOP ATTACHMENT

NOTE:

1. COMPONENTS VARY WITH STYLE OF TABLE PURCHASED.
- 1.1. FRAME COLORS:

1.1.1. BLACK, WHITE, CARROT, LIME, AQUA, SILVER, LIGHT GREY, OR DARK GREY.
- 1.2. TOP SELECTIONS:


1.2.1. BLACK PLASTIC LAMINATE, CHEMGUARD, PHENOLIC, 1¾" MAPLE, EPOXY, SHOPTOP, OR COLORED PLASTIC LAMINATE.
- 1.3. SIZES OF TABLE:

1.3.1. WIDTH = 60", 72", & 96"; DEPTH = 30", & 36".
2. **XX** INDICATES ITEMS THAT MAY NOT COME WITH UNIT (DEPENDING ON MODEL PURCHASED).

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REV.	DESCRIPTION	DATE	NAME	ECN No.
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ASSEMBLY COMPONENTS			
ITEMS INCLUDED	PART #	PART DESCRIPTION	QTY
TOP	VARIES	TOP, (STYLE, SIZE, AND THICKNESS VARIES)	1
AMS LEG ASSEMBLY	255583-X	LEG,STEEL,AMS,<COLOR>,MATTE/SATIN	2
AMS STRETCHER	VARIES	STRETCHER,STEEL,AMS,<COLOR>, MATTE/SATIN	1
AMS APRON	VARIES	APRON,STEEL,AMS,<COLOR>, MATTE/SATIN	2
LEG INSERTS	255582-X	LEG,STEEL,ADJ INSERT,<COLOR>,MATTE/SATIN	4
GLIDES	255712	GLIDE LEVELING,BLACK	4
HARDWARE BAG	255713	HARDWARE BAG, AMS TABLE	1
SHELF	VARIES	UTILITY TABLE SHELF, DWI STYLE (LENGTH VARIES)	1
SCREWS - SHELF	100369	SCREW,# 12.00X7/8 PHIL PAN HEAD SM	VARIES
CASTERS	253996	UTILITY TABLE CASTERS	4
THREADLOCKER	259680	VIBRA-TITE,THREADLOCKER,BLUE,1.80ML	1
SILICONE	100711	SILICONE,SEALANT,CLEAR	2

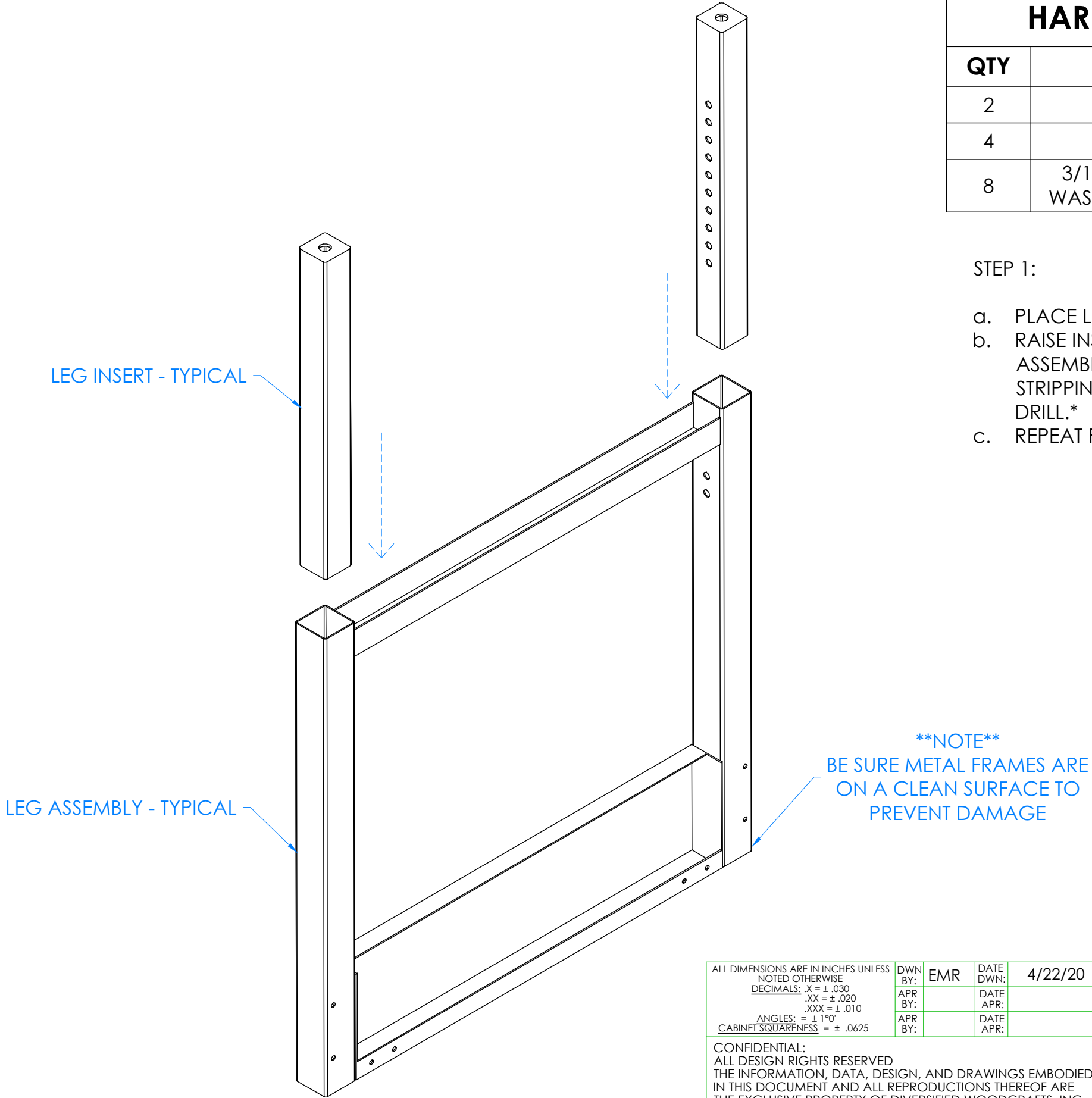
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TITLE:
ADJUSTABLE METAL TABLE
TOOLS AND ASSEMBLY COMPONENTS

DRAWING NUMBER: AMS SERIES TABLES	SCALE: NTS	SHEET: 2 OF 12	REVISION: REV C
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HARDWARE REQUIRED FOR STEP		
QTY	DESCRIPTION	PART NUMBER
2	AMS LEG ASSEMBLY	255583-X
4	LEG INSERTS	255582-X
8	3/18-16 X 1 BOLT WITH 3/8 STAR WASHER - FROM HARDWARE BAG	255713

STEP 1:

- a. PLACE LEG INSERTS INTO LEG ASSEMBLY.
- b. RAISE INSERTS TO DESIRED HEIGHT AND ATTACH TO LEG ASSEMBLY WITH HARDWARE PROVIDED. *TO PREVENT STRIPPING, DO NOT TIGHTEN HARDWARE WITH A POWER DRILL.*
- c. REPEAT FOR OTHER LEG ASSEMBLY.

NOTE:
1.


C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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ANGLES: = ± 1°0'
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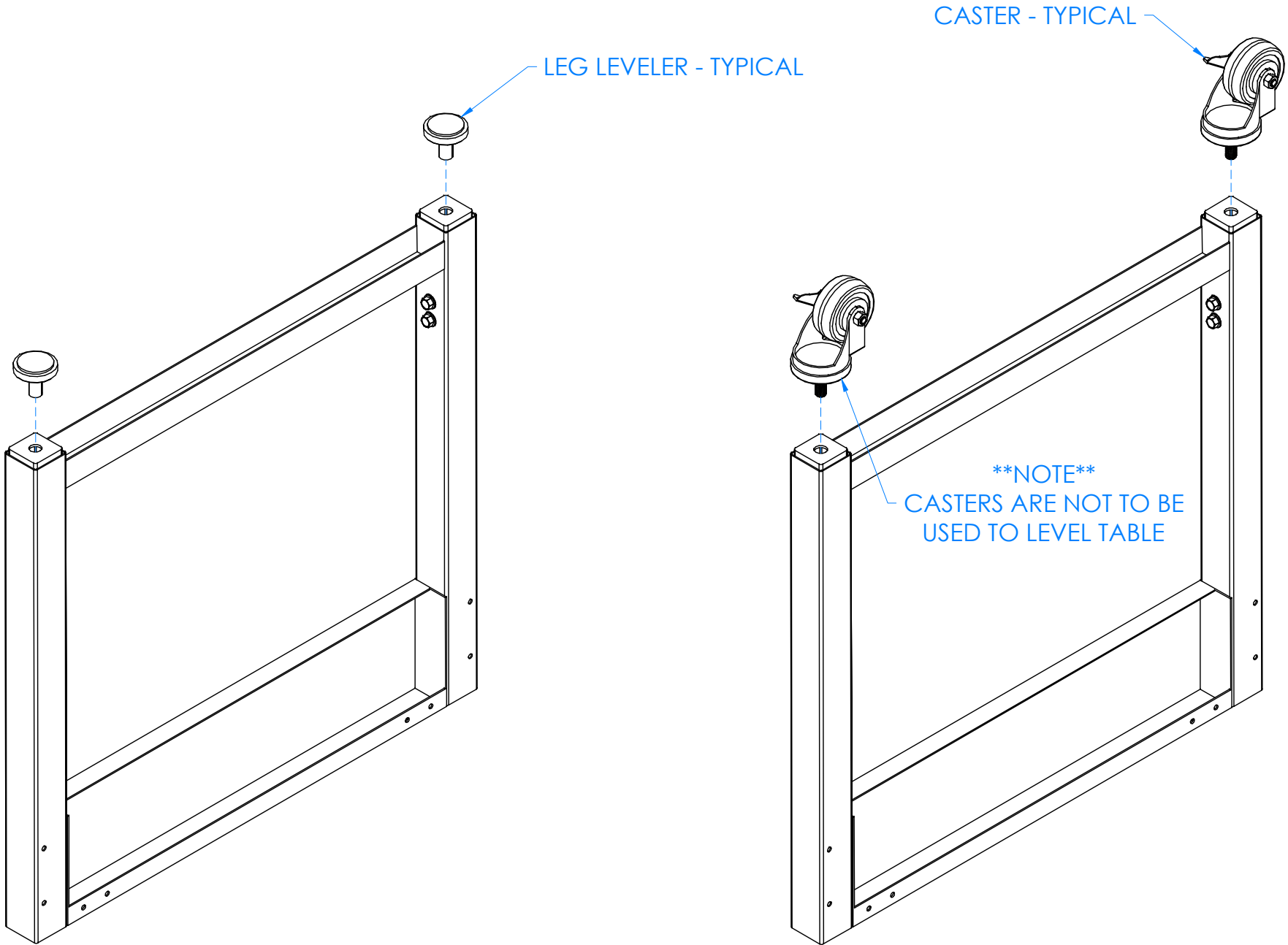


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TITLE:
ADJUSTABLE METAL TABLE
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
AMS SERIES TABLES	NTS	3 OF 12	REV C

HARDWARE REQUIRED FOR STEP		
QTY	DESCRIPTION	PART NUMBER
4	GLIDES	255712
4	**CASTERS**	253996
1	**THREADLOCKER**	259680



STEP 2:

- a. ATTACH LEG LEVELERS OR CASTERS TO EACH LEG INSERT. IF USING CASTERS, APPLY VIBRA-TITE THREADLOCKER TO EACH BEOFRE ATTACHING.
- b. MAKE SURE STEM ON CASTERS ARE THREADED ALL THE WAY AND ARE FULLY TIGHTENED.
- c. CASTERS ARE NOT TO BE USED TO LEVEL TABLE!

NOTE:
1.

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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ANGLES: = ± 1°
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DATE APR:

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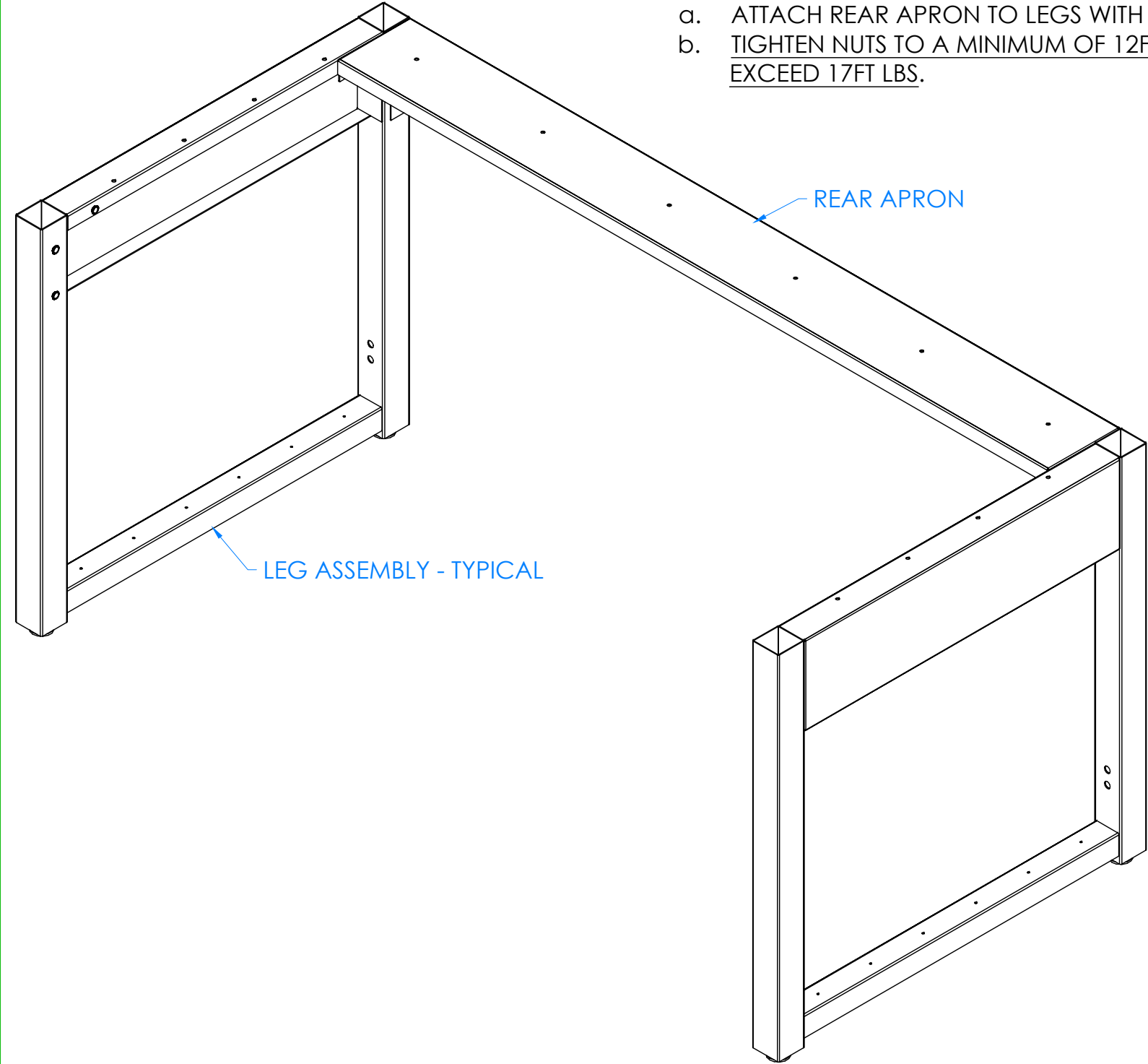
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ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:
AMS SERIES TABLES

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4 OF 12

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REV C

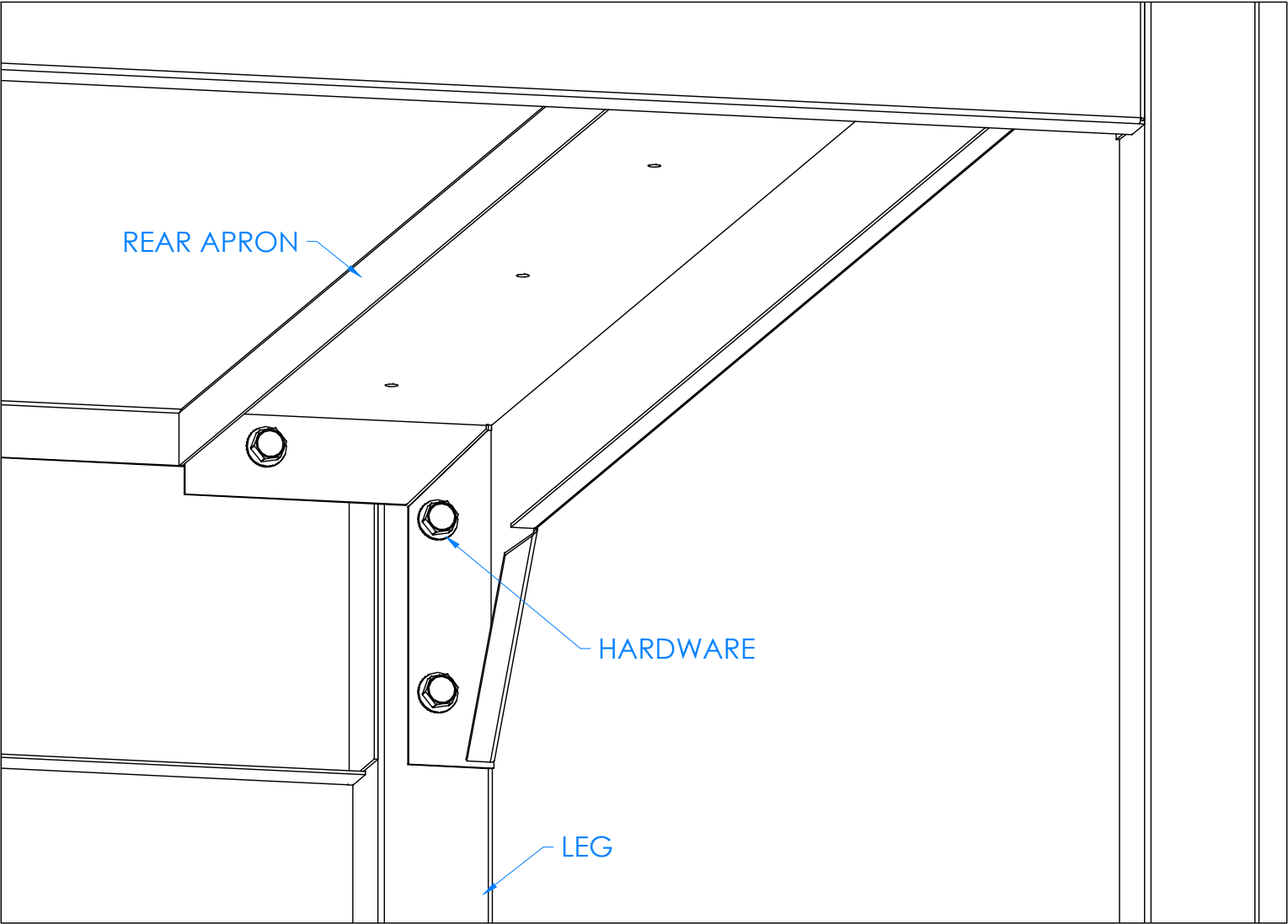


STEP 3:

- a. ATTACH REAR APRON TO LEGS WITH HARDWARE PROVIDED.
- b. TIGHTEN NUTS TO A MINIMUM OF 12FT LBS BUT NOT TO EXCEED 17FT LBS.

HARDWARE REQUIRED FOR STEP

QTY	DESCRIPTION	PART NUMBER
1	AMS APRON	VARIES
6	1/4-20 X 1 BOLT WITH 1/4 FLAT WASHER AND 1/4 STAR WASHER - FROM HARDWARE BAG	255713




UNDERSIDE OF TABLE SHOWN FOR CLARITY
(REAR BRACE ASSEMBLY)

NOTE:

1.

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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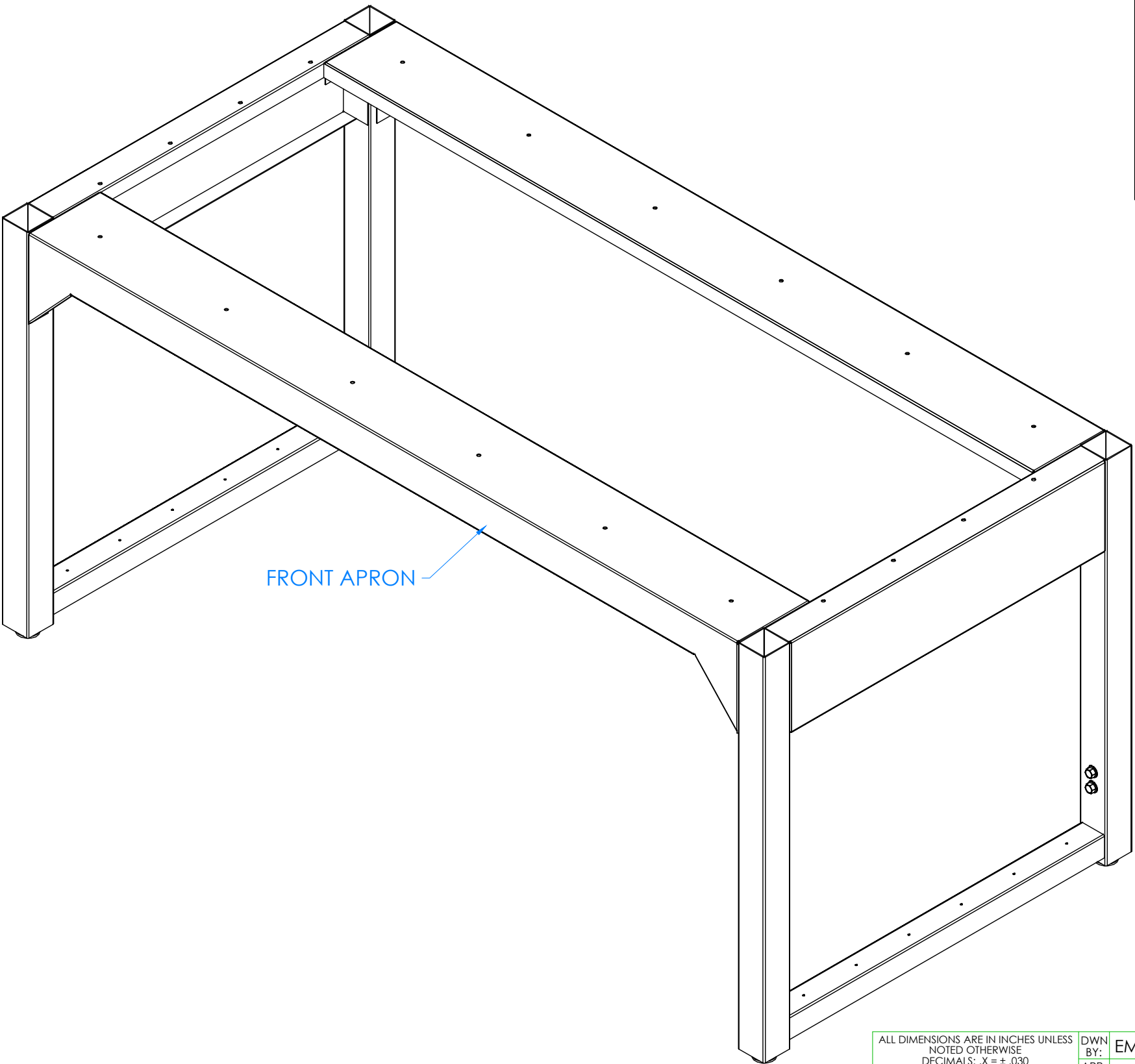
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ADJUSTABLE METAL TABLE
ASSEMBLY INSTRUCTIONS

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AMS SERIES TABLES

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HARDWARE REQUIRED FOR STEP		
QTY	DESCRIPTION	PART NUMBER
1	AMS APRON	VARIES
6	1/4-20 X 1 BOLT WITH 1/4 FLAT WASHER AND 1/4 STAR WASHER - FROM HARDWARE BAG	255713

STEP 4:

- α. REPEAT STEP 3 FOR FRONT BRACE.

NOTE:
1.


C	THREADLOCKER ADDED	5/16/24	RJM	1483
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REV.	DESCRIPTION	DATE	NAME	ECN No.
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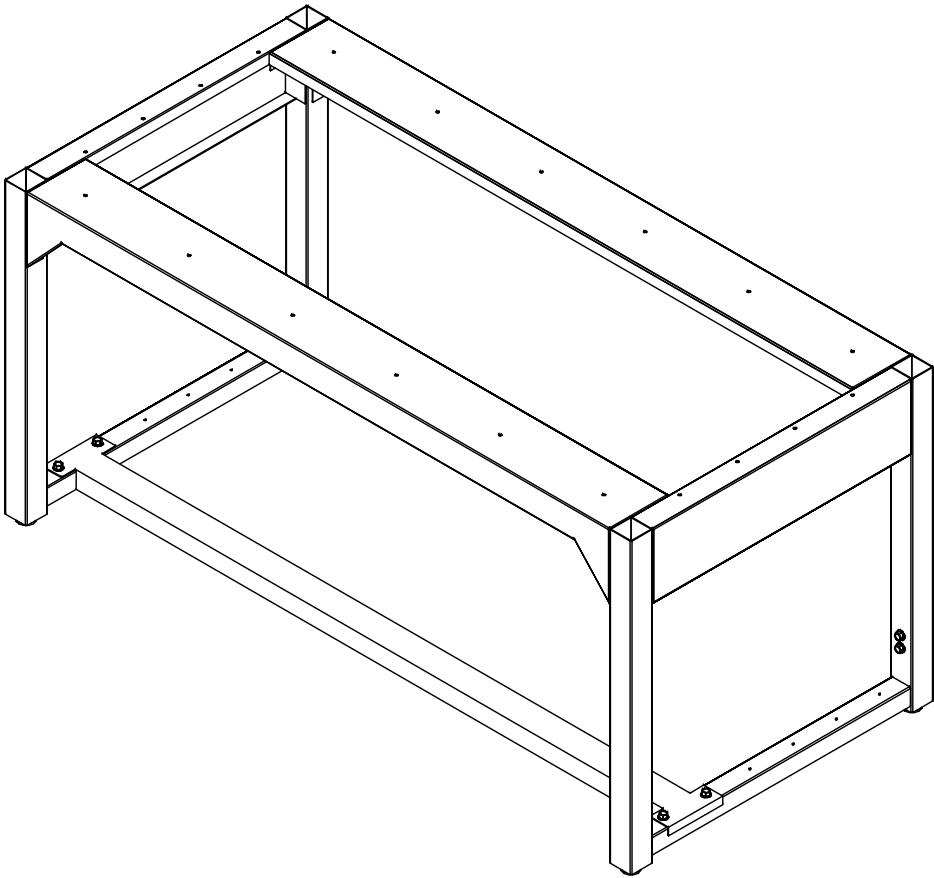
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AMS SERIES TABLES	NTS	6 OF 12	REV C

STEP 5:

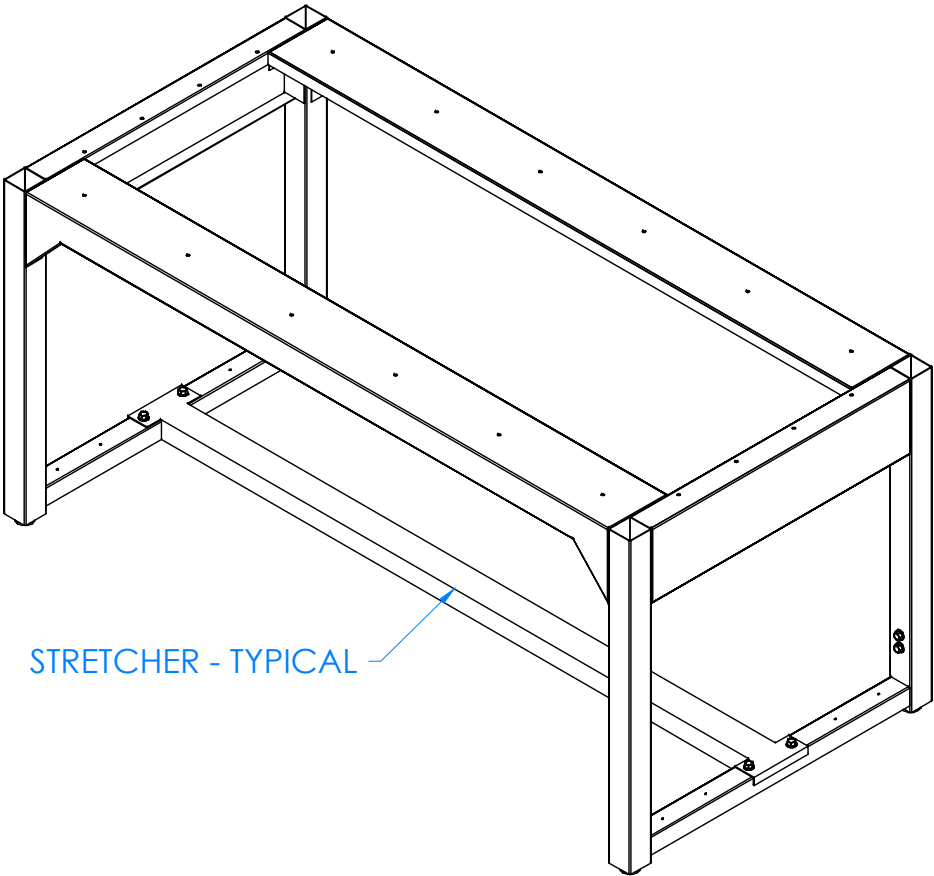
- a. ATTACH STRETCHER TO BOTH LEG ASSEMBLIES.
- b. STRETCHER CAN BE PLACED IN FRONT, CENTER, OR REAR OF THE DEPTH OF TABLE (SEE IMAGES BELOW).
- c. TIGHTEN NUTS TO A MINIMUM OF 12FT LBS BUT NOT TO EXCEED 17FT LBS.

HARDWARE REQUIRED FOR STEP

QTY	DESCRIPTION	PART NUMBER
1	AMS STRETCHER	VARIES
4	#8 X 5/8 LG. SCREW FOR BRACE - FROM HARDWARE BAG	255713

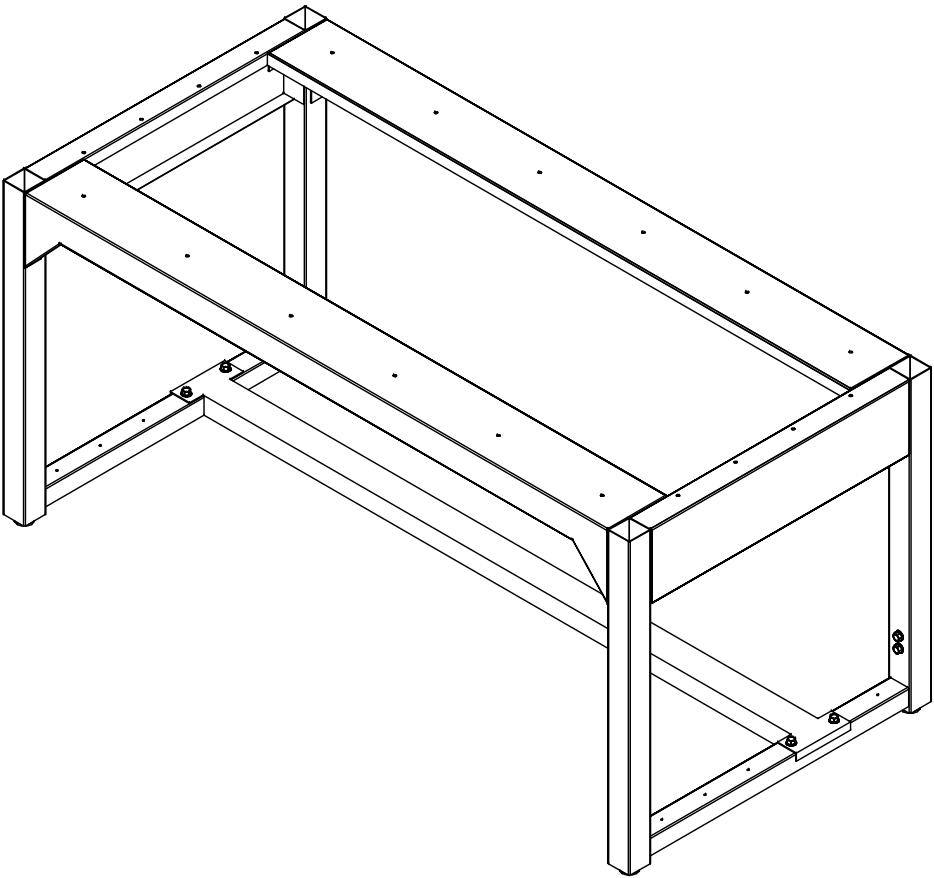


STRETCHER MOUNTED IN FRONT OF TABLE



STRETCHER - TYPICAL

STRETCHER MOUNTED IN MIDDLE OF TABLE



STRETCHER MOUNTED IN BACK OF TABLE

NOTE:

1.

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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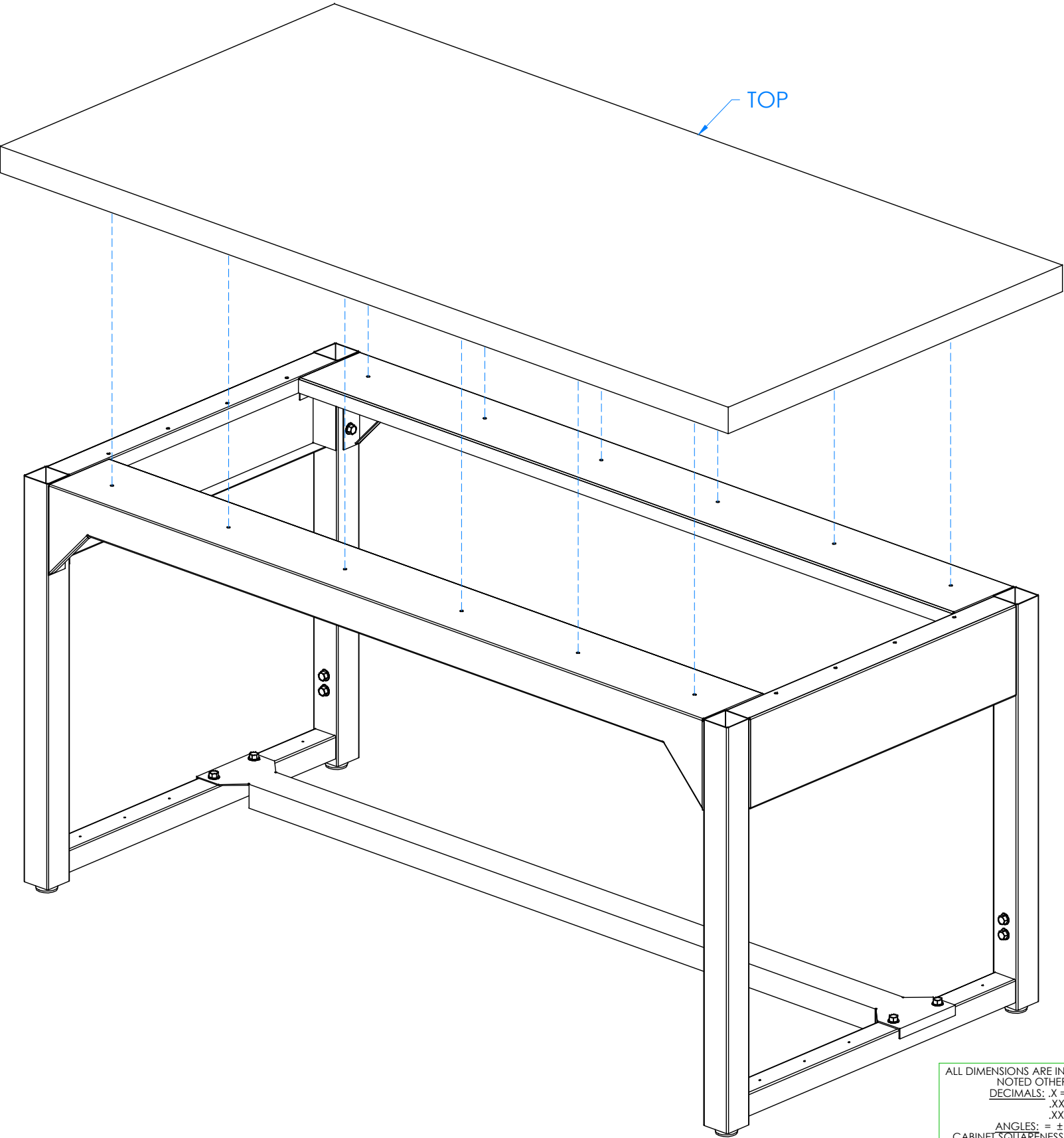
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TITLE:
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ASSEMBLY INSTRUCTIONS

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AMS SERIES TABLES	NTS	7 OF 12	REV C



HARDWARE REQUIRED FOR STEP		
QTY	DESCRIPTION	PART NUMBER
1	TOP	VARIES
20	#12 X 7/8 SCREW FOR TOP ATTACHMENT - FROM HARDWARE BAG	255713

STEP 6:

- a. IF YOU HAVE AN EPOXY OR PHENOLIC TOP, SKIP TO STEP 7.
- b. PLACE TOP ONTO STEEL FRAME WITH PROPER OVERHANG (CENTERED ON TABLE).
- c. USING A 3/16" DRILL BIT, PRE-DRILL HOLES INTO TOP 7/8" FROM THE SLOTS ON EACH STEEL BRACE TO PREVENT CRACKING.
- d. SCREW TOP ONTO STEEL FRAME WITH HARDWARE PROVIDED.
- e. PLEASE MEASURE PROPER DEPTH!
- f. MAKE SURE SCREWS ARE ON TIGHT AND TOP IS SECURE.
- g. SPACE SCREWS ACCORDINGLY PER QUANTITY SUPPLIED!

NOTE:
1.

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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.XXX = ± .010
ANGLES: = ± 1°
CABINET SQUARENESS = ± .0625

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DATE DWN: 4/22/20

DATE APR:

DATE APR:

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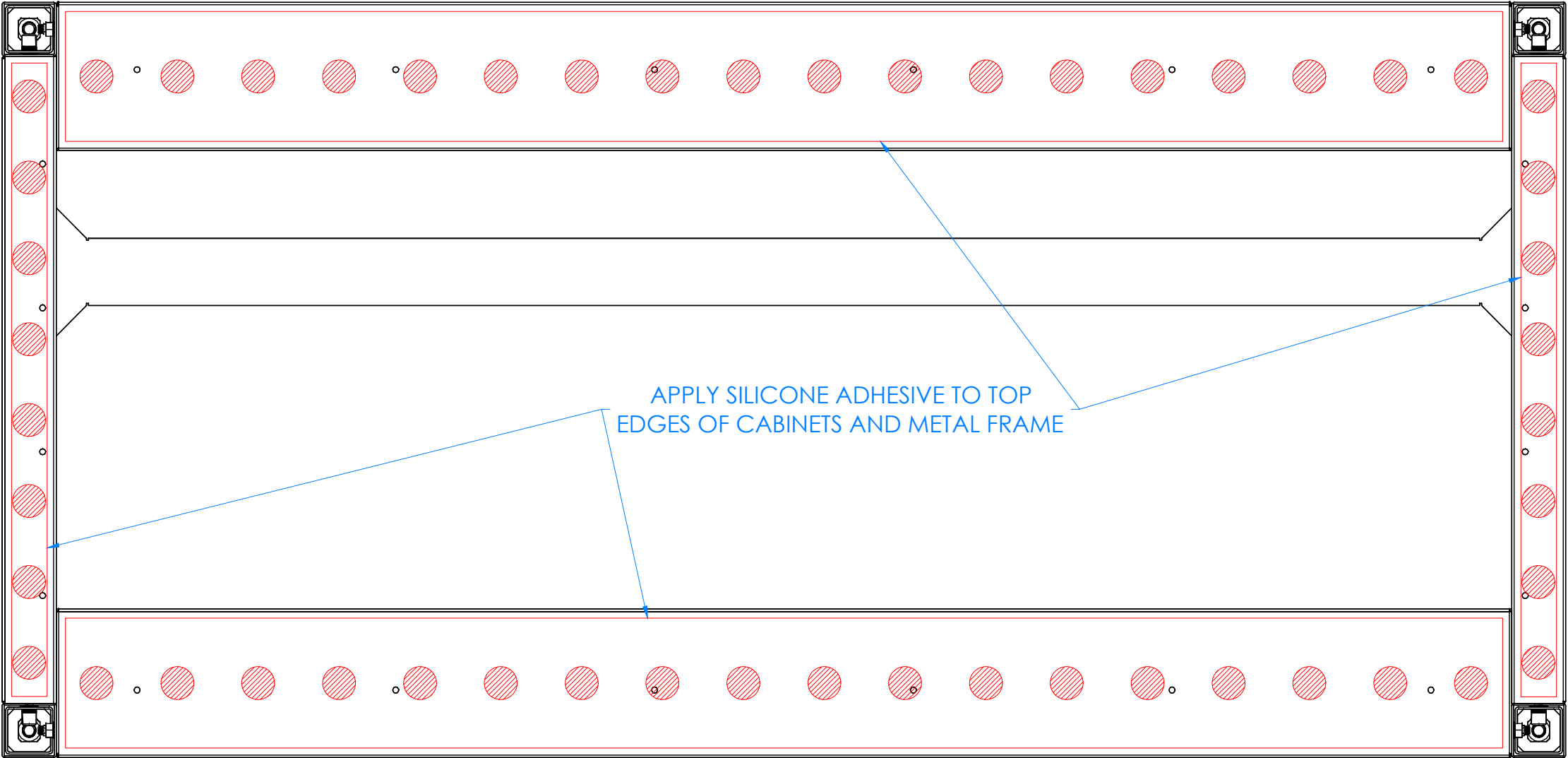
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STEP 7:

- a. IF YOU DO NOT HAVE AN EPOXY OR PHENOLIC TOP, SKIP TO STEP 8.
- b. APPLY SILICONE ADHESIVE TO TOP EDGES OF METAL FRAME.
- c. APPLY SILICONE ADHESIVE IN DOT PATTERN LIKE SHOWN BELOW FOR BEST RESULTS.
- d. PLACE TOP ON METAL FRAME WITH PROPER OVERHANG (CENTERED ON WORKSTATION).
- e. CLAMP ON TOP TO METAL FRAME TO REMOVE ANY WARP USING SHIMS AND C-CLAMPS, IF NEEDED, WHEN ALIGNING THE TOP (DO THIS BEFORE ADHESIVE SETS UP).
- f. LET CURE FOR 6-12 HOURS.

HARDWARE REQUIRED FOR STEP

QTY	DESCRIPTION	PART NUMBER
1	TOP	VARIES
2	**SILICONE**	100711



TOP VIEW OF WORKSTATION SHOWN

NOTE:

1.


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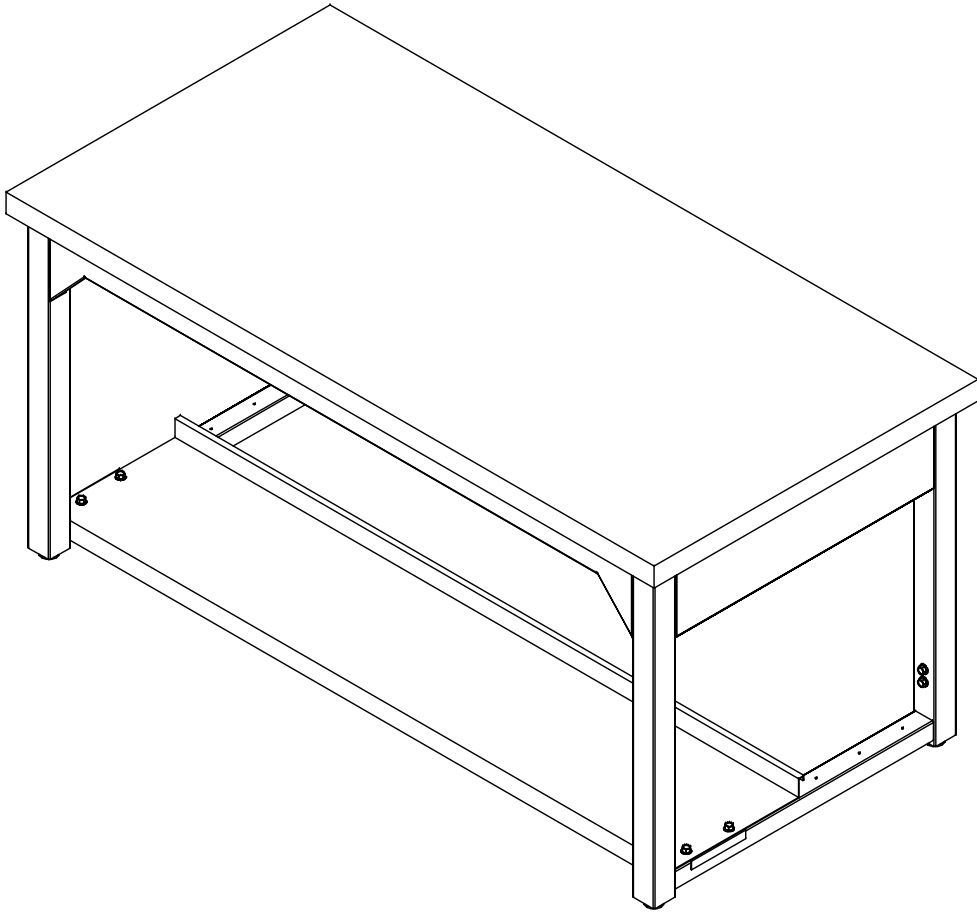
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STEP 8:

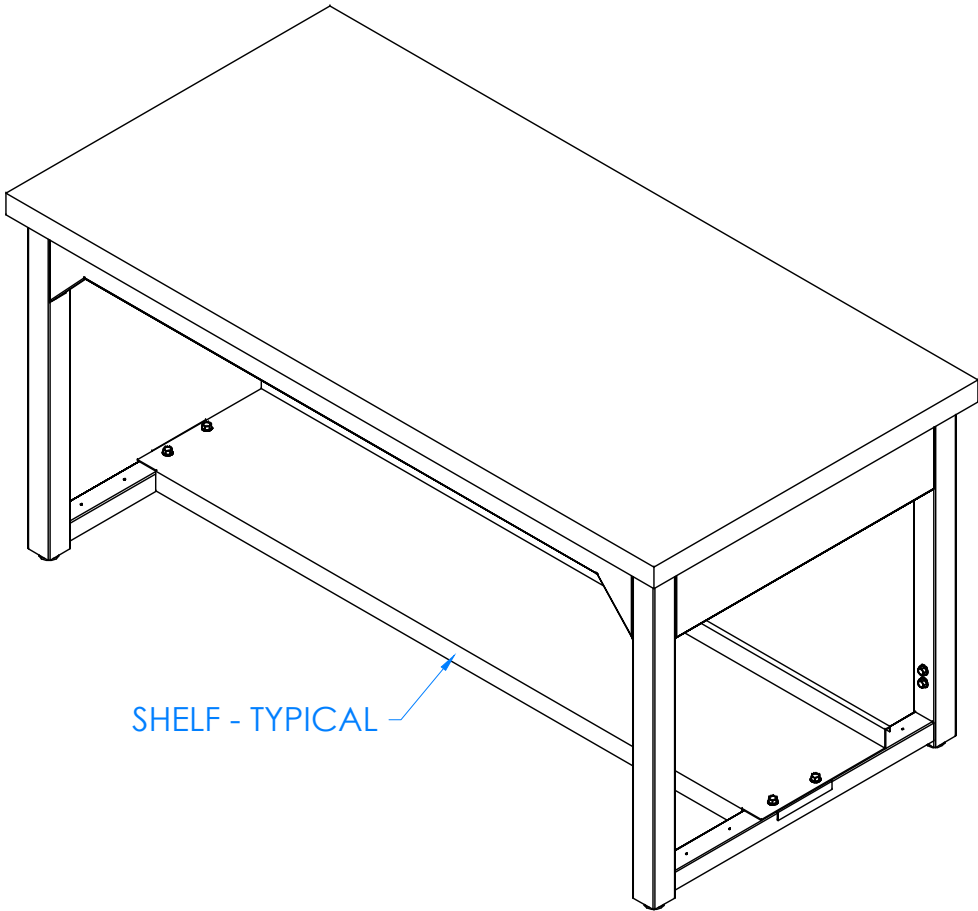
- α. IF YOUR UNIT HAS A SHELF, PLACE SHELF OVER STRETCHER AND ATTACH TO LEGS WITH HARDWARE PROVIDED.

HARDWARE REQUIRED FOR STEP

QTY	DESCRIPTION	PART NUMBER
1	**SHELF**	VARIES
2	**SCREWS - SHELF**	100369

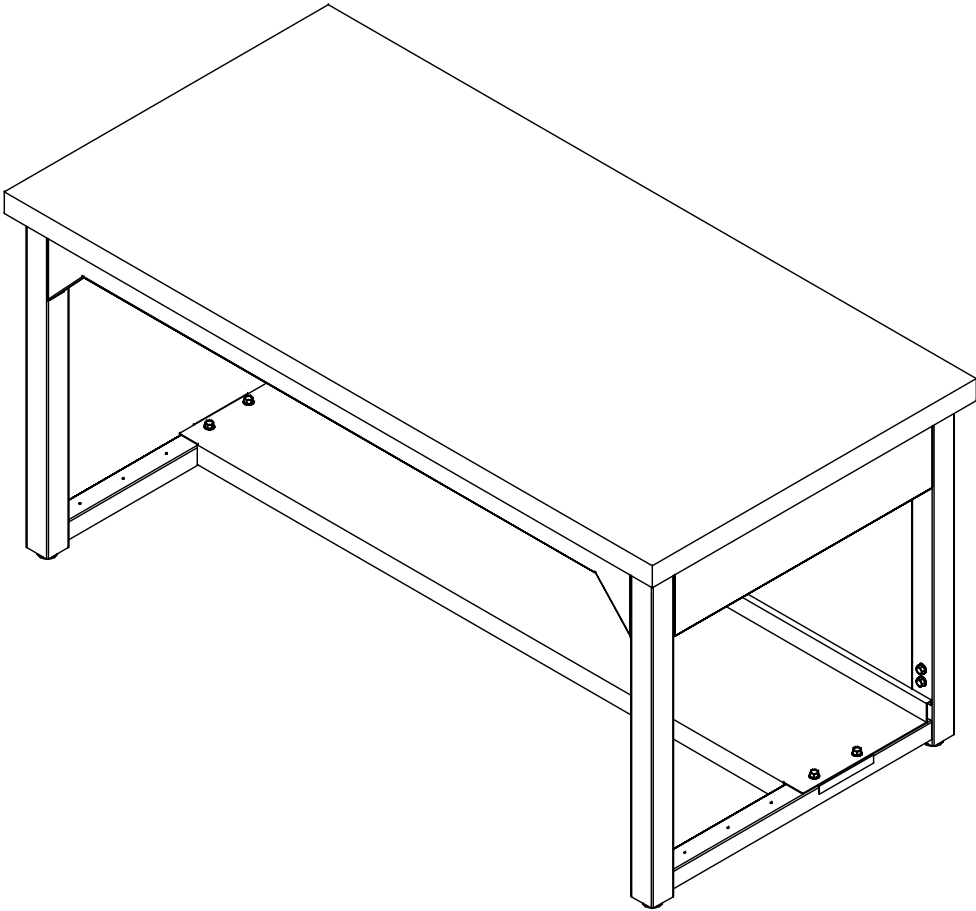


SHELF MOUNTED IN FRONT
OF TABLE



SHELF - TYPICAL

SHELF MOUNTED IN MIDDLE
OF TABLE




SHELF MOUNTED IN BACK
OF TABLE

NOTE:

1.

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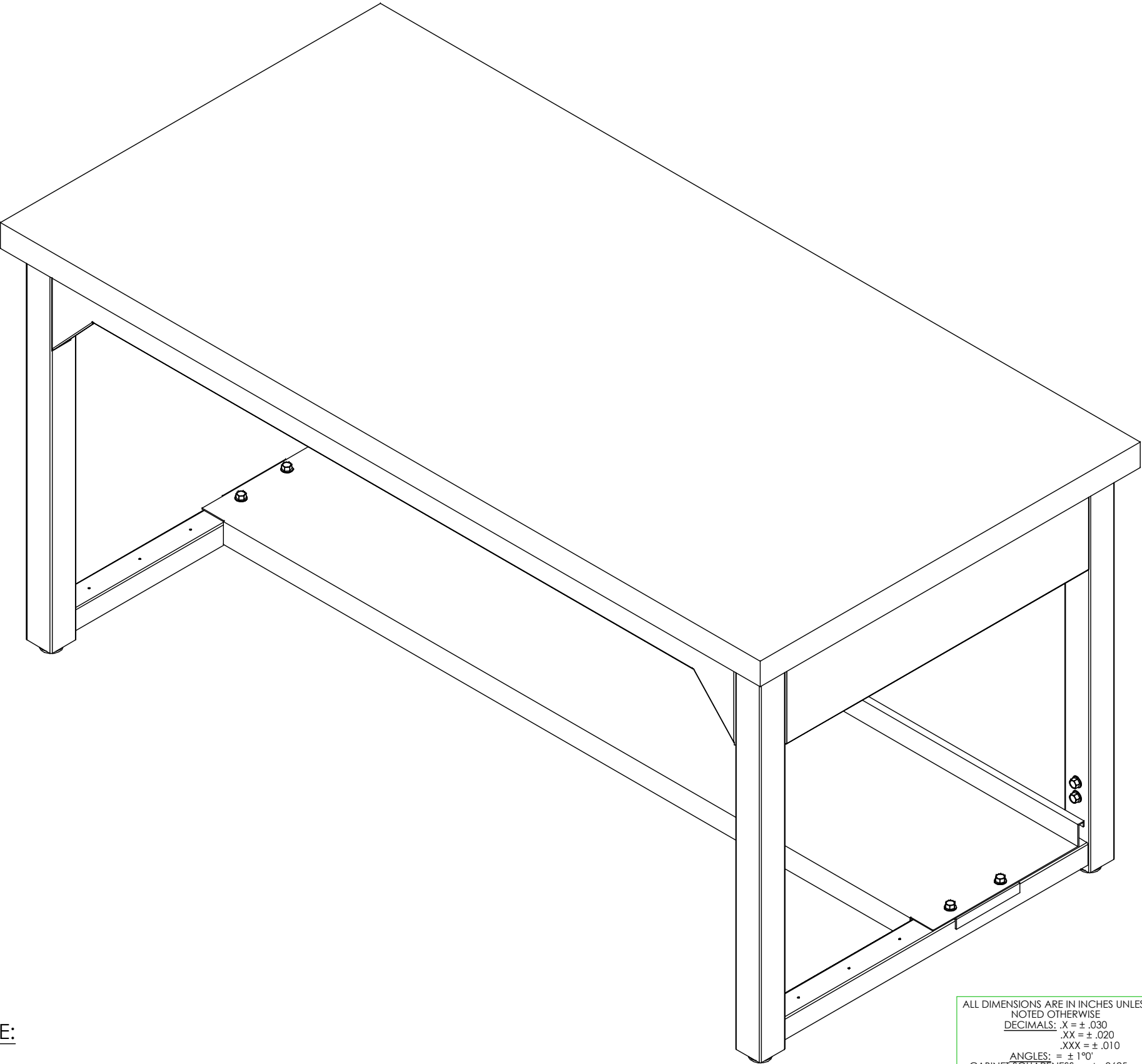
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ADJUSTABLE METAL TABLE
ASSEMBLY INSTRUCTIONS

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REVISION:
REV C



STEP 9:

- a. IF YOU HAVE LEG LEVELERS, ADJUST THEM TO LEVEL TABLE.
- b. PLACE TABLE IN DESIRED LOCATION.

NOTE:
1.

COMPLETE UNIT SHOWN

C	THREADLOCKER ADDED	5/16/24	RJM	1483
A	CREATED DRAWING	4/22/20	EMR	N/A
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ADJUSTABLE METAL TABLE
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
AMS SERIES TABLES	NTS	11 OF 12	REV C