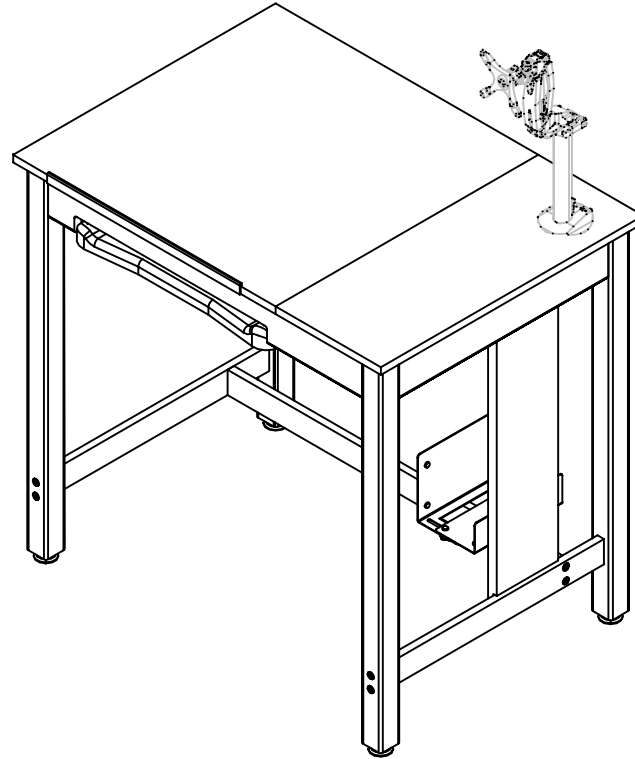


# DRAWING TABLE SYSTEM

DT-30A, DT-60SA, & CDTC-70  
ASSEMBLY INSTRUCTIONS



## NOTE:

1. MODEL VIEWS MAY NOT REPRESENT EXACT MODEL PURCHASED

ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE  
 DECIMALS: .X = ± .030  
 .XX = ± .020  
 .XXX = ± .010  
 ANGLES: = ± 1°  
 CABINET SQUARENESS: = ± .0625

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TITLE:  
 DRAWING TABLE SYSTEM - PLAIN  
 ASSEMBLY INSTRUCTIONS

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	1 OF 12	REV B

**TOOLS REQUIRED**

$\frac{1}{2}$ " WRENCH
$\frac{1}{2}$ " SOCKET AND TORQUE WRENCH - OPTIONAL
4MM ALLEN WRENCH
SCREW DRIVER

**ASSEMBLY COMPONENTS**

ITEMS INCLUDED	PART #	PART DESCRIPTION	QTY
TOP AND APRON ASSEMBLY	N/A	TOP ASSEMBLY (FACTORY ASSEMBLED)	1
LEGS	501102	LEG,MPL 2.25X2.25X38.25	4
LEG HARDWARE KIT	520001-4	LEG HARDWARE KIT, 4 LEGS	1
LEG BRACE	N/A	LEG BRACE - 24.00" LONG	2
STRETCHER	N/A	STRETCHER - 37.50" LONG	1
CONFIRMATS - LEGS	227578	SCREW,7MMX90MM,CONN,ALLENHEAD, BLACK	8
CONFIRMATS - STRETCHER	228564	SCREW,7MMX50MM,CONN,ALLENHEAD, BLACK	4
PENCIL LEDGE	14-0027	PENCIL LEDGE - 22"	1
SCREWS - PENCIL LEDGE	236263	SCREW,#6X $\frac{3}{4}$ TRUSS HEAD,QUAD,BLACK	3
**CPU SUPPORT**	N/A	SUPPORT,CPU,EB4,1.00X7.00X32.50	1
**SCREWS - CPU SUPPORT**	100649	SCREW,#8X $\frac{3}{4}$ PHIL TRUSS HEAD SMS	6
**CPU BRACKET**	257521	BRACKET,MOUNTING,CPU,BLK	1
**CPU BRACKET KNOB**	257522	KNOB,TWO ARM, 1/4-20, BLACK	2
**CPU BRACKET RUBBER BUMPERS**	206604	BUMPER,RUBBER, $\frac{1}{8}$ "THK X $\frac{1}{2}$ " DIAM	12
**KEYBOARD TRAY KIT**	258764	TRAY,KEYBOARD,SLIDE OUT,#KVKD100	1
**MONITOR BASE ASSEMBLY**	243335	HAFELE MONITOR BASE ASSEMBLY	1
**MONITOR ARM**	15-0185	HAFELE FLAT SCREEN ARM	1

**NOTE:**

1. \*\*XX\*\* INDICATES ITEMS ONLY USED FOR THE CDTC-70.

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
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REV.	DESCRIPTION	DATE	NAME	ECN No.
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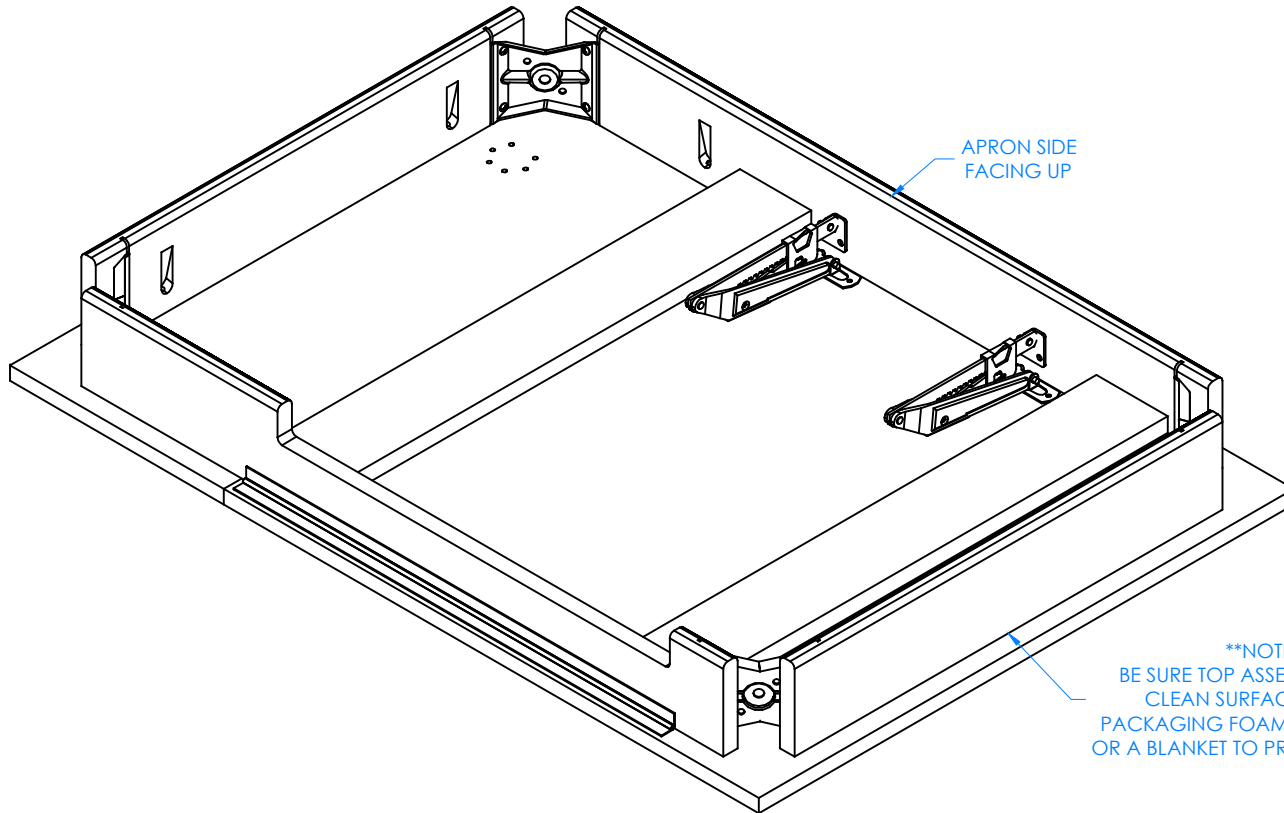
DWN BY: EMR DATE DWN: 1/15/15  
 APR BY: DATE APR:  
 APR BY: DATE APR:



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TITLE:  
 DRAWING TABLE SYSTEM - PLAIN  
 TOOLS AND ASSEMBLY COMPONENTS

DRAWING NUMBER: DT-30A, 60SA, & CDTC-70 SCALE: NTS SHEET: 2 OF 12 REVISION: REV B



APRON SIDE  
FACING UP

STEP 1:

- LAY APRON ASSEMBLY ON FLOOR WITH APRON SIDE FACING UP.

**\*\*NOTE\*\***

BE SURE TOP ASSEMBLY IS ON A  
— CLEAN SURFACE SUCH AS  
PACKAGING FOAM, CARDBOARD,  
OR A BLANKET TO PREVENT DAMAGE

NOTE:

1.

ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE DECIMALS: .X = ± .030 .XX = ± .020 .XXX = ± .010 ANGLES: = ± 1°0' CABINET SQUARENESS: = ± .0625	DWN BY:	EMR	DATE DWN:	1/15/15
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	APR BY:		DATE APR:	

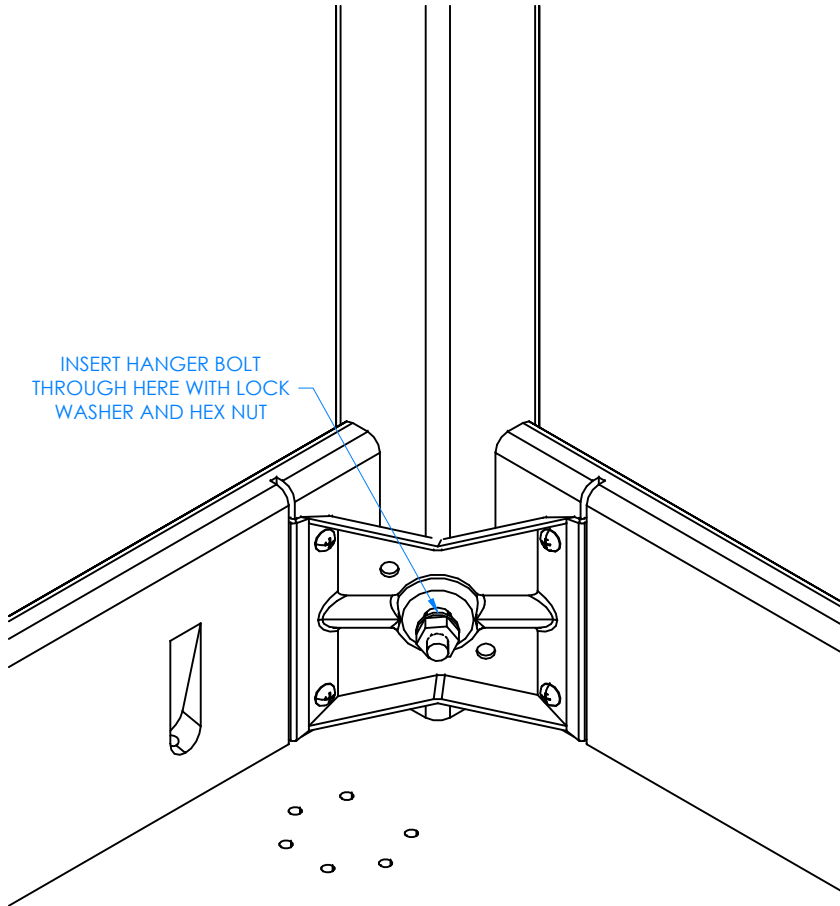
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TITLE:  
DRAWING TABLE SYSTEM - PLAIN  
ASSEMBLY INSTRUCTIONS

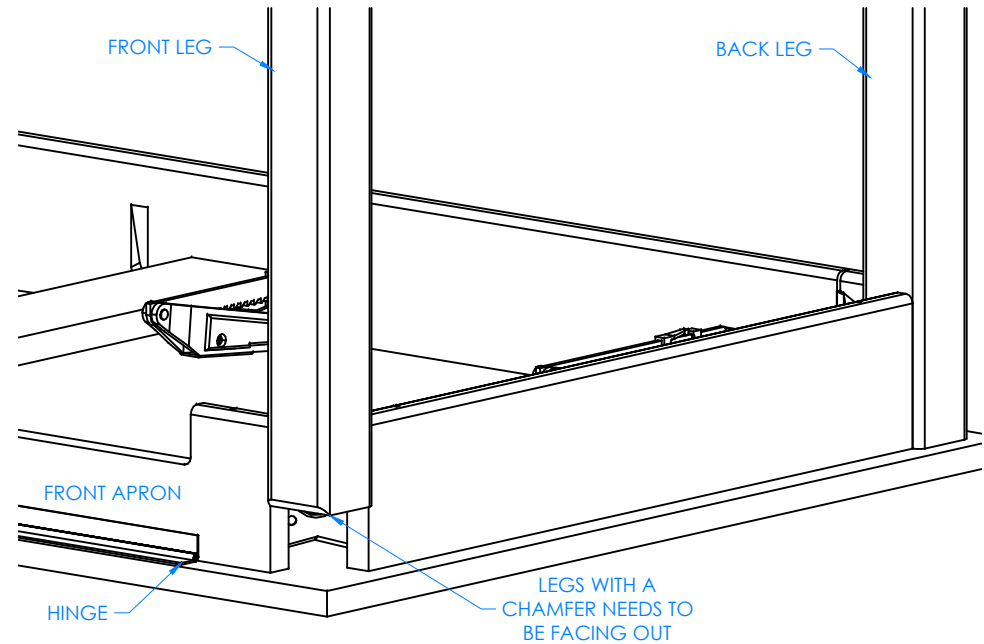
DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	3 OF 12	REV B



CLOSE UP OF CORNER LEG ASSEMBLY

## STEP 2:

- INSERT HANGER BOLT ON ONE LEG THROUGH THE CORNER BRACKET AND INSERT LOCK WASHER AND HEX NUT.
- SCREW ON NUT USING A  $\frac{1}{2}$ " WRENCH OR  $\frac{1}{2}$ " SOCKET AND TORQUE WRENCH. DO NOT TIGHTEN ALL THE WAY.
- REPEAT FOR THE OTHER LEG.
- THE LEGS WITH A CHAMFER MUST GO ON THE FRONT OF THE TABLE WITH CHAMFERED EDGE FACING OUT.



CLOSE UP OF LEG WITH A CHAMFER

## NOTE:

1.

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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DATE DWN: 1/15/15  
 DATE APR:  
 DATE APR:



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DRAWING NUMBER:

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SCALE:

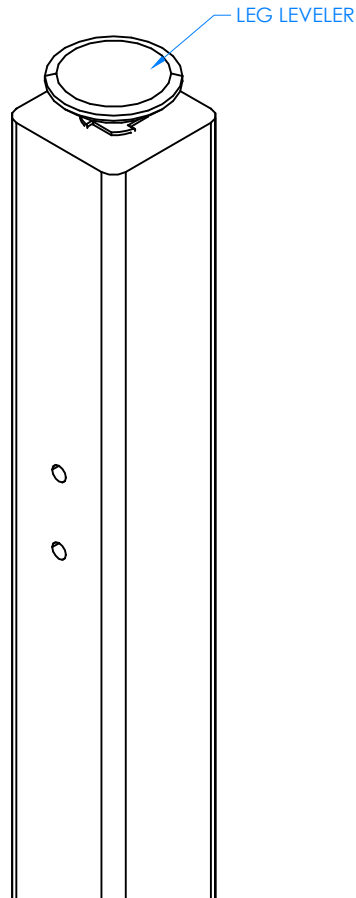
NTS

SHEET:

4 OF 12

REVISION:

REV B



CLOSE UP OF LEG LEVELER ASSEMBLY

## STEP 3:

- SCREW LEG LEVELERS INTO T-NUT ON BOTTOM OF LEGS.

NOTE:

1.

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DECIMALS: $\frac{1}{16} = \pm .030$	APR BY:		DATE APR:	
$\frac{1}{8} = \pm .020$	APR BY:		DATE APR:	
$\frac{1}{4} = \pm .010$	APR BY:		DATE APR:	
ANGLES: $\pm 1^\circ$	APR BY:		DATE APR:	
CABINET SQUARENESS: $\pm .0625$	APR BY:		DATE APR:	

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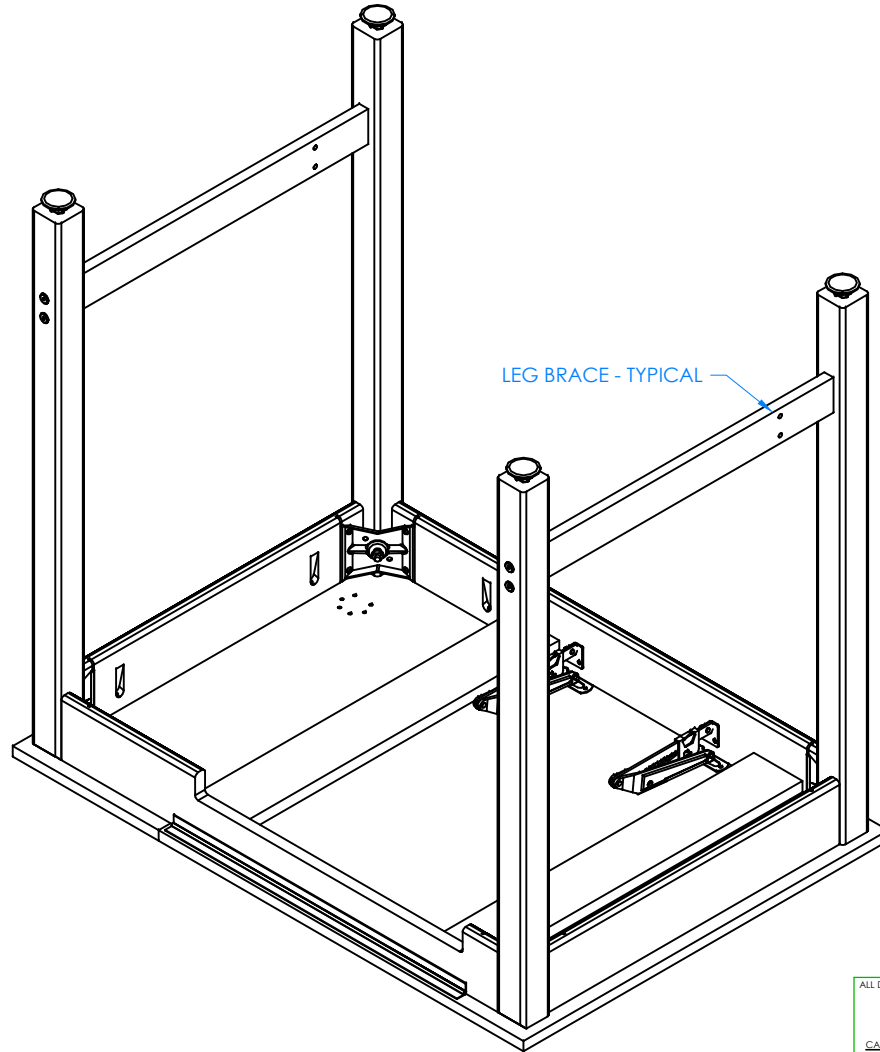


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TITLE:  
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A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	5 OF 12	REV B



## STEP 4:

- ATTACH BRACES TO LEGS.
- INSERT CONFIRMATS INTO ONE LEG AND SCREW INTO BRACE.
- REPEAT FOR OTHER LEGS.
- MAKE SURE BRACES ARE STRAIGHT AND ALL CONFIRMATS ARE SECURE.

## NOTE:

1.

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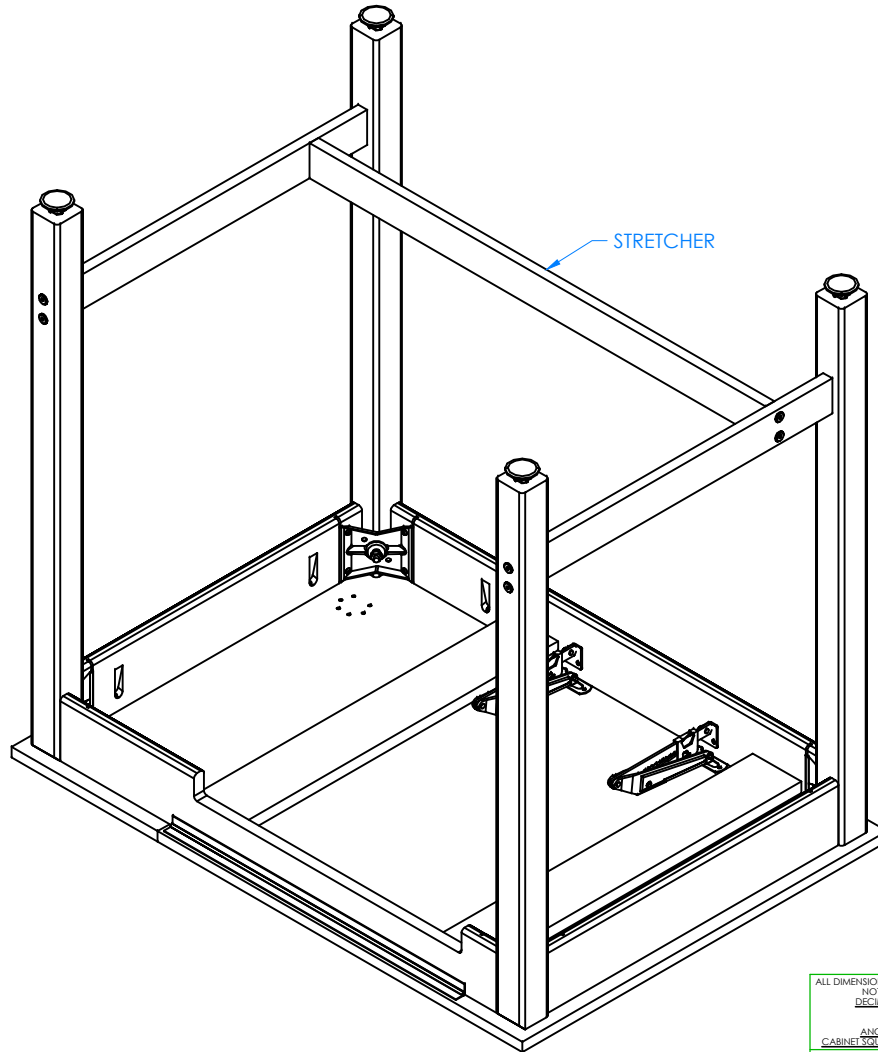


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REV.	DESCRIPTION	DATE	NAME	ECN No.
REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	6 OF 12	REV B



## STEP 5:

- ATTACH STRETCHER TO BRACE WITH HARDWARE PROVIDED.
- GO BACK TO STEP 2 AND TIGHTEN UP THE HANGER BOLTS FOR EACH LEG USING A  $\frac{1}{2}$ " WRENCH OR  $\frac{1}{2}$ " SOCKET AND TORQUE WRENCH, TO A MINIMUM OF 12FT LBS BUT NOT TO EXCEED 17FT LBS.

## NOTE:

1.

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DECIMALS: .X = ± .030	APR BY:	DATE APR:
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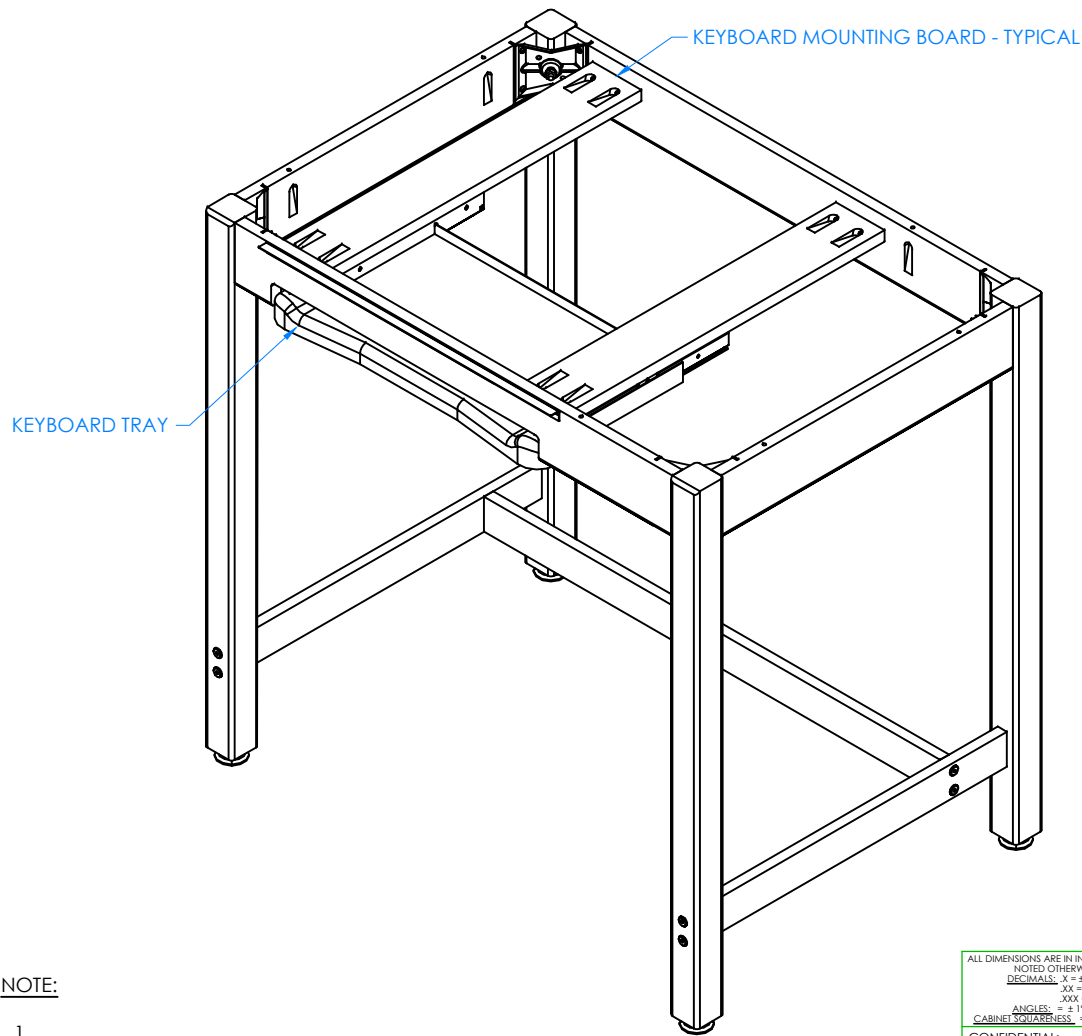


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DRAWING TABLE SYSTEM - PLAIN  
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REV.	DESCRIPTION	DATE	NAME	ECN No.
REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	7 OF 12	REV B

**NOTE:**

1.

TOPS REMOVED TO SHOW CLARITY

**STEP 6:**

- IF YOUR TABLE DOES NOT HAVE A KEYBOARD TRAY OR CPU SUPPORT SKIP TO STEP 9.
- ATTACH KEYBOARD TRAY TO THE TWO KEYBOARD MOUNTING BOARDS WITH THE HARDWARE PROVIDED.
- IT MAY BE EASIER TO ATTACH KEYBOARD TRAY WHILE TABLE IS ON ITS TOP.
- ATTACH THE MONITOR POST TO THE TOP USING HARDWARE PROVIDED (NOT SHOWN).

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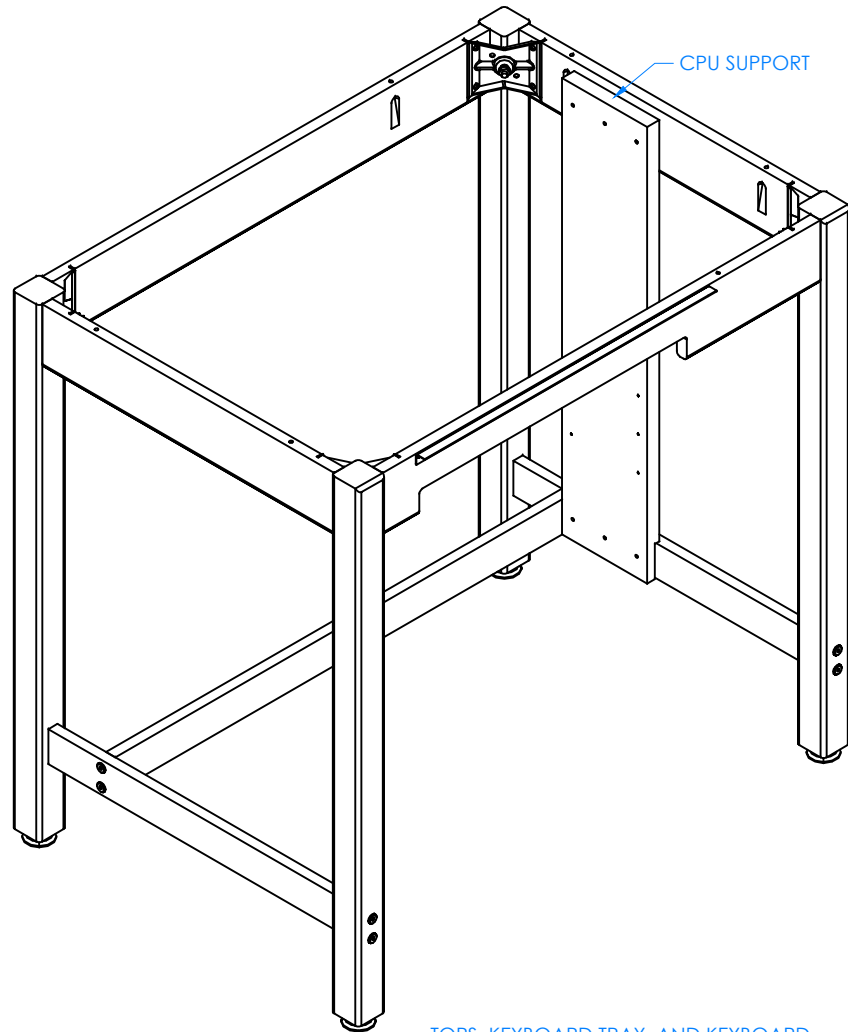
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REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	8 OF 12	REV B





## STEP 7:

- ATTACH CPU SUPPORT TO LEG BRACE AND APRON ASSEMBLY WITH HARDWARE PROVIDED.
- THE SUPPORT SHOULD LAY FLUSH AGAINST BOTTOM OF LEG BRACE AND STRETCHER.
- THERE WILL BE A SMALL GAP BETWEEN TOP OF APRON ASSEMBLY AND TOP OF SUPPORT.

## NOTE:

1.

TOPS, KEYBOARD TRAY, AND KEYBOARD MOUNTS REMOVED TO SHOW CLARITY

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
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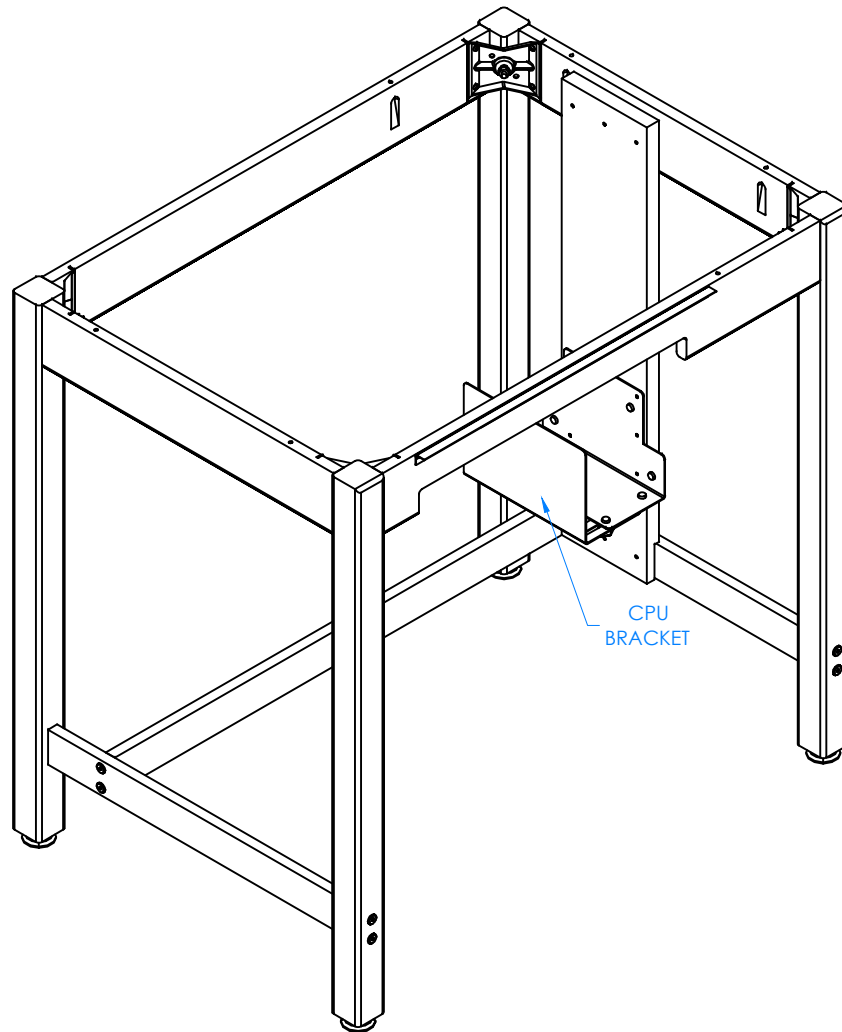
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TITLE:  
DRAWING TABLE SYSTEM - PLAIN  
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	9 OF 12	REV B

**NOTE:**

1.

TOPS, KEYBOARD TRAY, AND KEYBOARD  
MOUNTS REMOVED TO SHOW CLARITY

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
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**STEP 8:**

- INSTALL CPU BRACKETS TO SUPPORTS USING APPROPRIATE HARDWARE FOR YOUR APPLICATION.
- SEE STEP 9 FOR DETAILED INSTRUCTIONS ON HOW TO INSTALL CPU BRACKET.



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TITLE:  
DRAWING TABLE SYSTEM - PLAIN  
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	10 OF 12	REV B

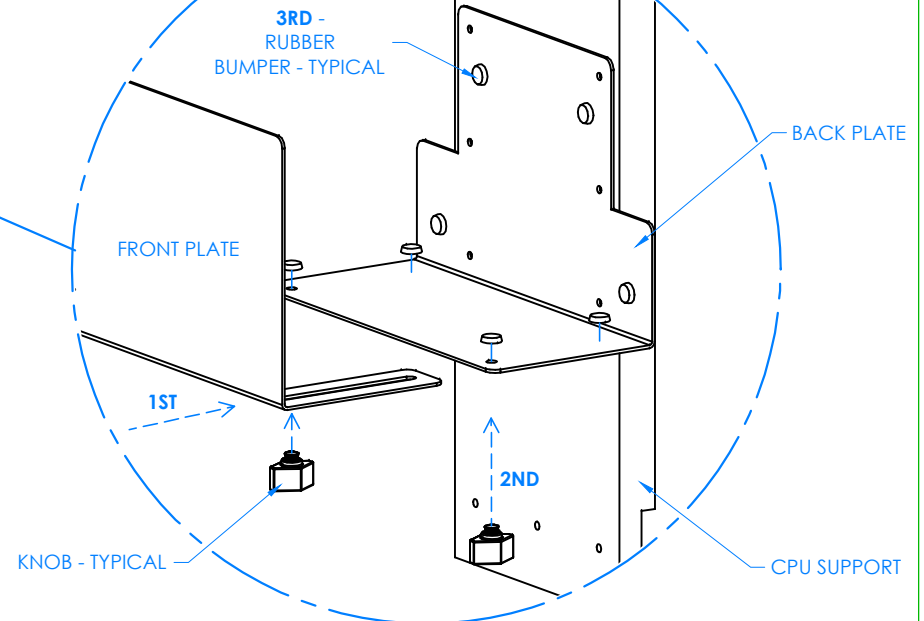
SEE DETAIL - A  
FOR CPU  
BRACKET  
INSTALLATION

## STEP 9:

- SCREW BACK PLATE OF CPU BRACKET ONTO CPU SUPPORT WITH PROPER HARDWARE.
- BACK PLATE WILL HAVE SCREW HOLES TO ATTACH TO CPU SUPPORTS.
- TAKE FRONT PLATE OF CPU BRACKET AND ATTACH TO BACK PLATE.
- FRONT PLATE WILL HAVE SLOT HOLES FOR ADJUSTING TO CORRECT WIDTH.
- USING THE (2) KNOBS, ADJUST PLATES TO CORRECT SIZE AND SCREW TWO PLATES TOGETHER.
- MAKE SURE KNOBS ARE ON TIGHT AND SECURE.
- PLACE RUBBER BUMPERS IN DESIRED LOCATION - (4) ON EACH SIDE AND BOTTOM.

## DETAIL - A

CLOSE UP OF CPU BRACKET



## NOTE:

1.

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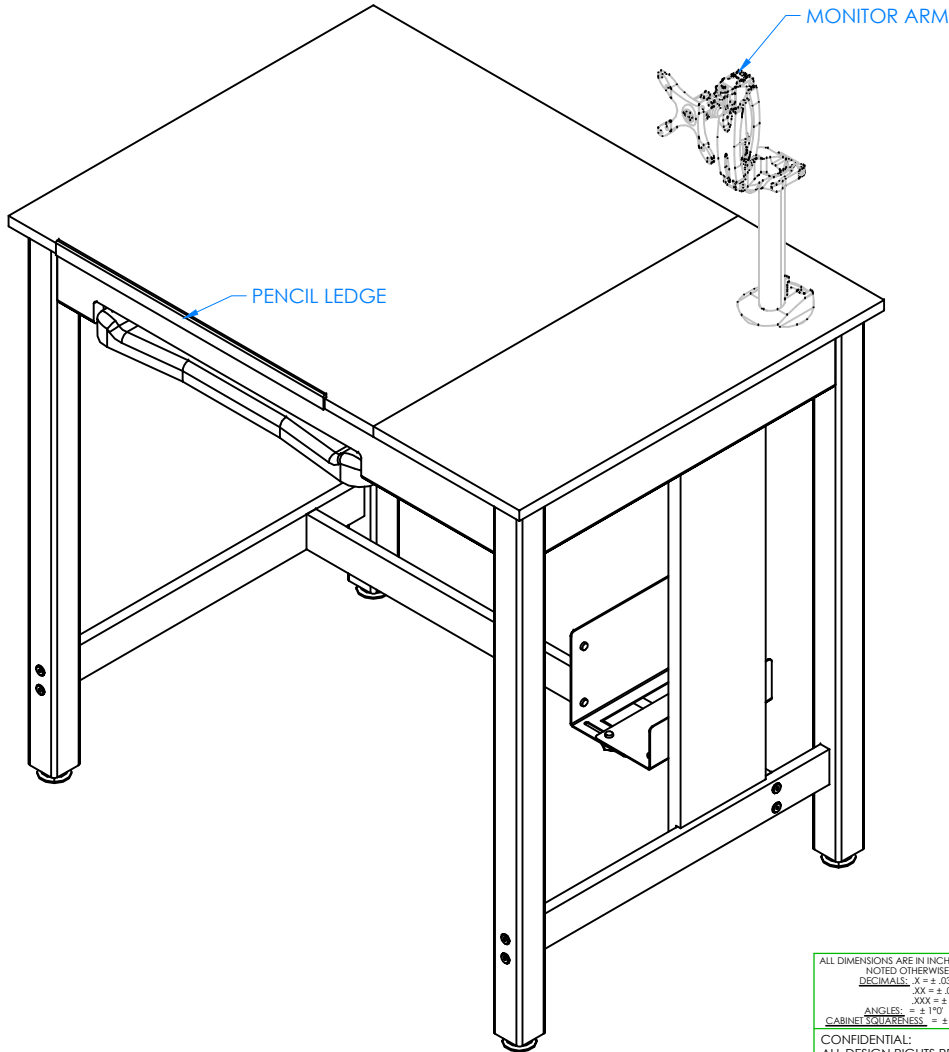
DATE DWN: 1/15/15  
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 DATE APR:



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 DRAWING TABLE SYSTEM - PLAIN  
 ASSEMBLY INSTRUCTIONS

DRAWING NUMBER: DT-30A, 60SA, & CDTC-70  
 SCALE: NTS  
 SHEET: 11 OF 12  
 REVISION: REV B



## STEP 10:

- LINE UP PENCIL LEDGE ON SIDE OF ADJUSTABLE TOP IN DESIRED LOCATION.
- PRE-DRILL HOLES IN TOP TO PREVENT SPLITTING.
- SCREW PENCIL LEDGE TO TOP USING HARDWARE PROVIDED.
- SET YOUR TABLE IN PLACE.
- ADJUST LEG LEVELERS TO LEVEL TABLE.
- INSTALL MONITOR ARM TO TOP USING APPROPRIATE HARDWARE FOR YOUR APPLICATION.

## NOTE:

1.

## COMPLETE UNIT SHOWN

B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
REV.	DESCRIPTION	DATE	NAME	ECN No.
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.XXX = ± .010	APR BY:		DATE APR:	
ANGLES: = ± 1°	APR BY:		DATE APR:	
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TITLE:  
DRAWING TABLE SYSTEM - PLAIN  
ASSEMBLY INSTRUCTIONS

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-30A, 60SA, & CDTC-70	NTS	12 OF 12	REV B