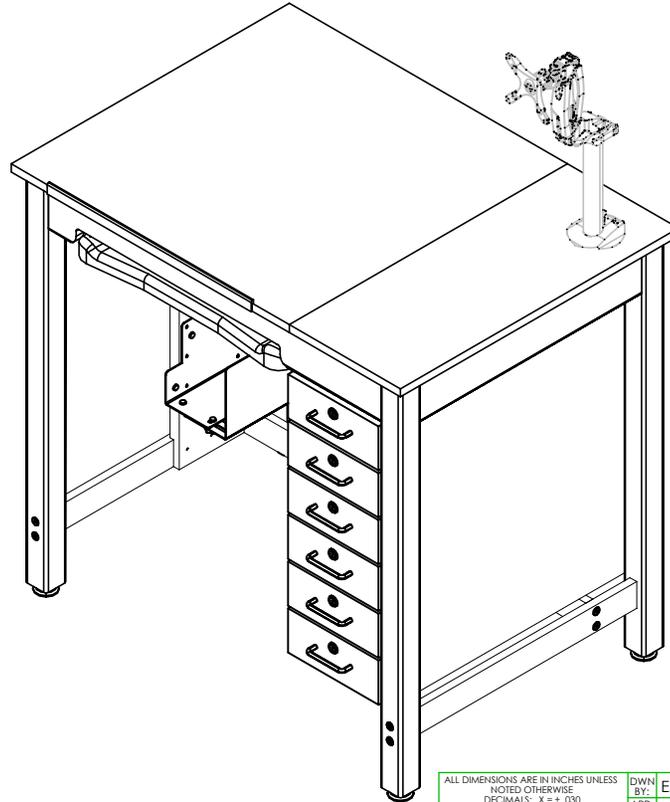


DRAWING TABLE SYSTEM

DT-31A, DT-61SA, & CDTC-71
ASSEMBLY INSTRUCTIONS



NOTE:

1. MODEL VIEWS MAY NOT REPRESENT EXACT MODEL PURCHASED

ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE	DWN BY:	EMR	DATE DWN:	1/13/15
DECIMALS: $\frac{X}{1000}$ = ± .000	APR BY:		DATE APR:	
XX = ± .020	APR BY:		DATE APR:	
XXX = ± .010	APR BY:		DATE APR:	
ANGLES: = ± 1°	APR BY:		DATE APR:	
CABINET SQUARENESS: = ± .0625	APR BY:		DATE APR:	

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TITLE:
DRAWING TABLE SYSTEM - DRAWERS
ASSEMBLY INSTRUCTIONS

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

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	1 OF 15	REV B

TOOLS REQUIRED

1/2" WRENCH
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
CABINET	N/A	CABINET - 10.625"W X 26.50"D X 27"H	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
BRACKETS - CABINET	100355	BRACKET,RAIL 1.25X1.25X4.25	3
SCREWS - BRACKET	100649	SCREW,#8X3/4 PHIL TRUSS HEAD SMS	12
PENCIL LEDGE	14-0027	PENCIL LEDGE - 22"	1
SCREWS -PENCIL LEDGE	236263	SCREW,#6X3/4 TRUSS HEAD,QUAD,BLACK	3
CPU SUPPORT	N/A	SUPPORT,CPU,EB4,1.00X7.00X32.50	1
SCREWS - CPU SUPPORT	100649	SCREW,#8X3/4 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, 1/8"THK X 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:

- **XX** INDICATES ITEMS ONLY USED FOR THE CDTC-71.

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 CABINET SQUARENESS = ± .0625

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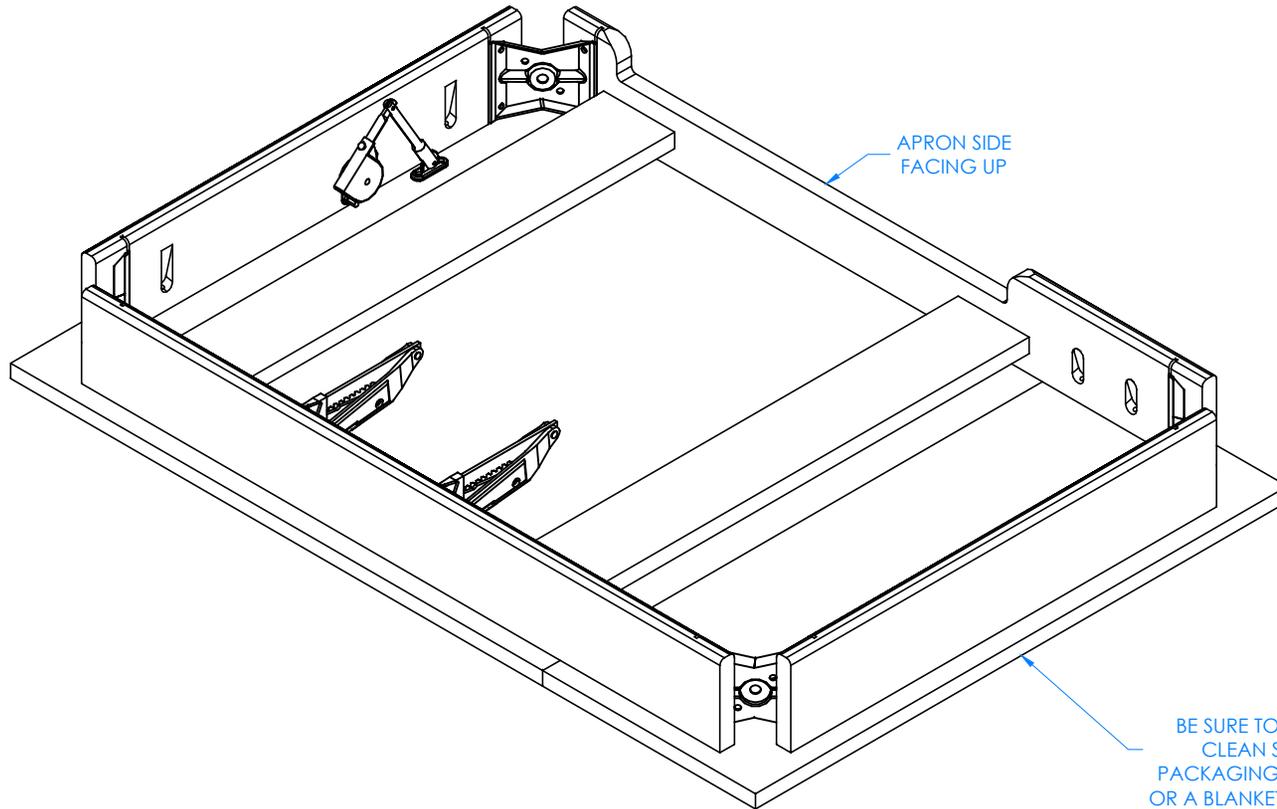


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TITLE:
 DRAWING TABLE SYSTEM - DRAWERS
 TOOLS AND ASSEMBLY COMPONENTS

DRAWING NUMBER: DT-31A, 61SA, & CDTC-71	SCALE: NTS	SHEET: 2 OF 15	REVISION: REV B
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REV.	DESCRIPTION	DATE	NAME	ECN No.
B	UPDATED KEYBOARD TRAY NUMBER	8/17/23	JRR	1396
A	CREATED ASSEMBLY INSTRUCTIONS	1/13/15	EMR	N/A
REVISION LEVEL				



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.

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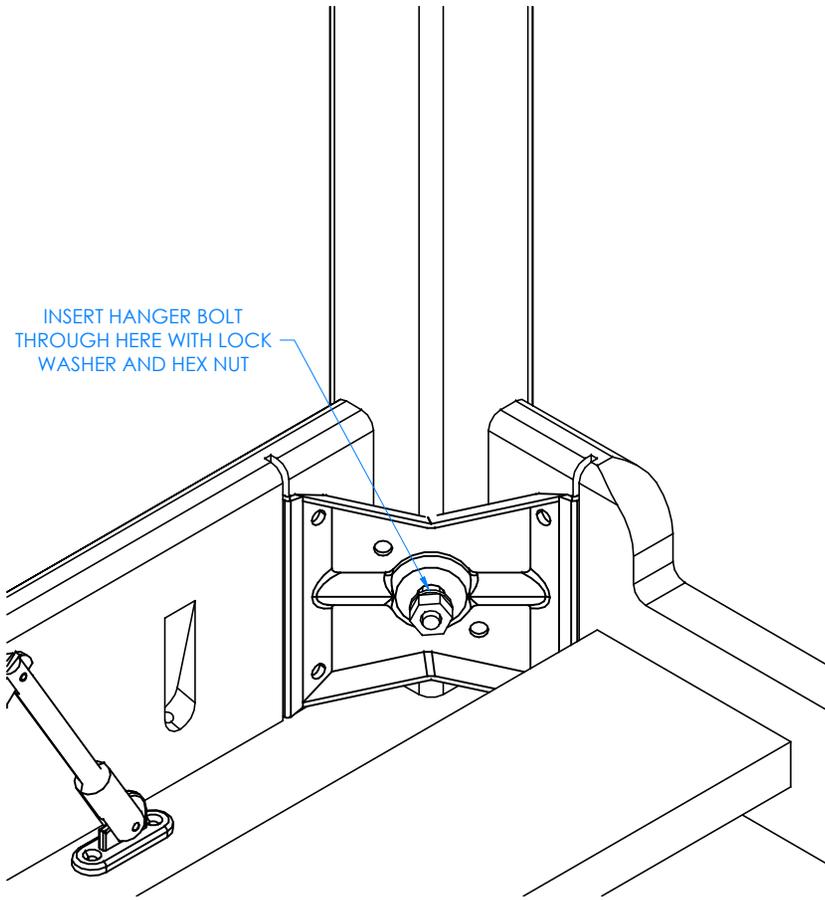


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TITLE:
DRAWING TABLE SYSTEM - DRAWERS
ASSEMBLY INSTRUCTIONS

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REVISION LEVEL				

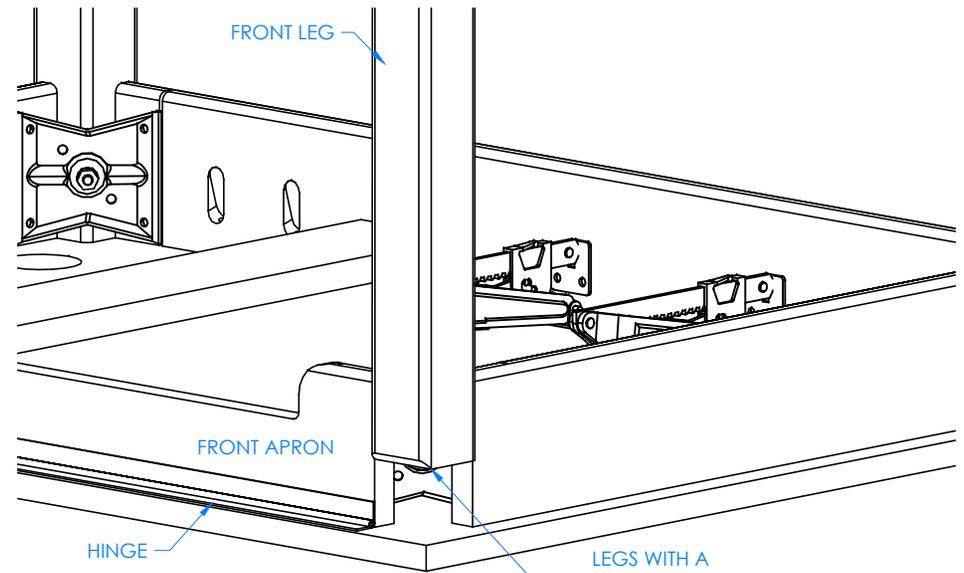
DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	3 OF 15	REV B



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 1/2" WRENCH OR 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.

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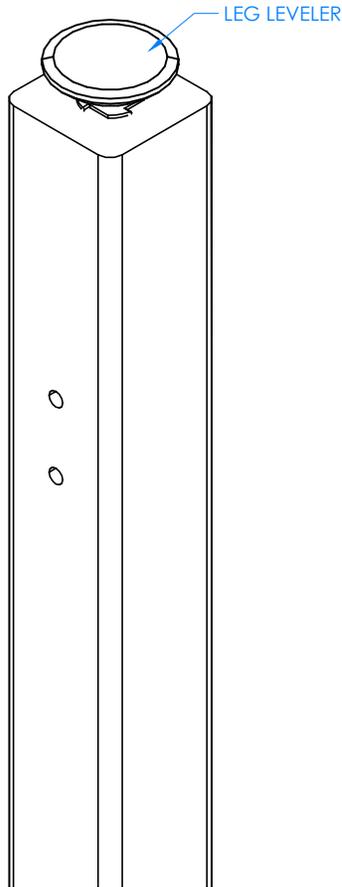
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REVISION LEVEL

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	4 OF 15	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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CABINET SQUARENESS: = $\pm .0625$	APR BY:		DATE APR:	

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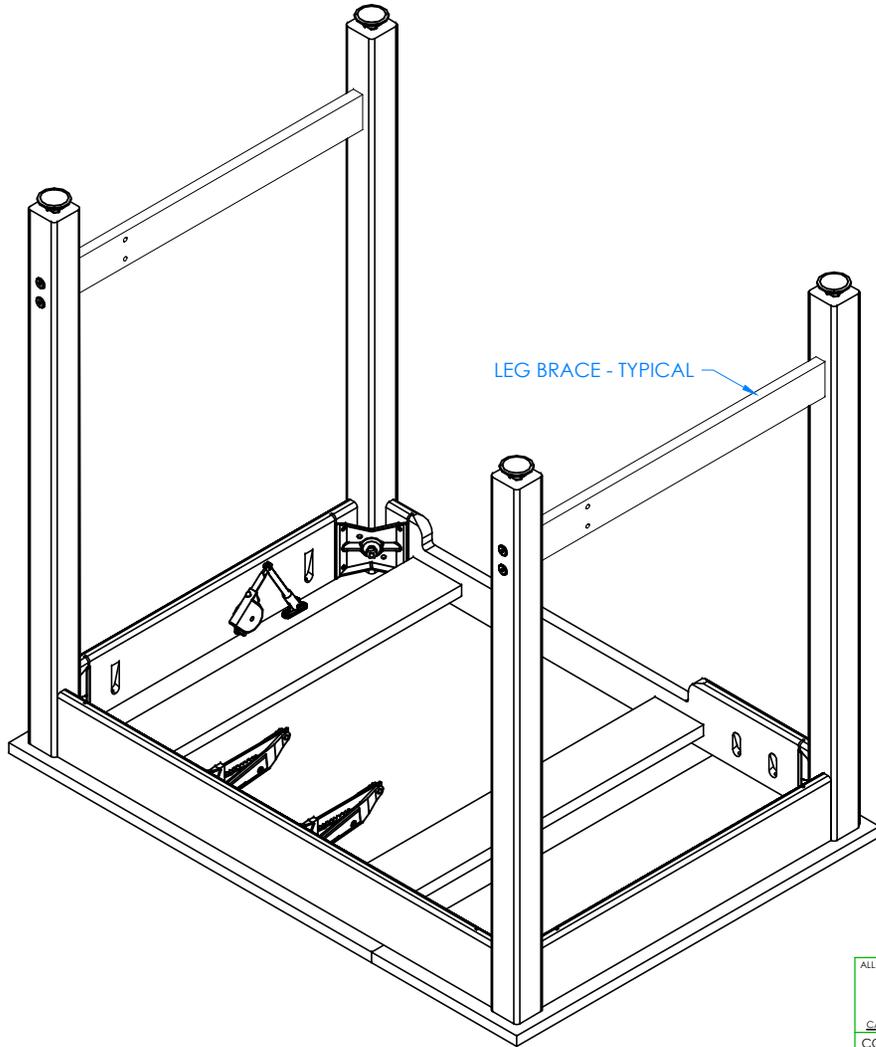


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 DRAWING TABLE SYSTEM - DRAWERS
 ASSEMBLY INSTRUCTIONS

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REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	5 OF 15	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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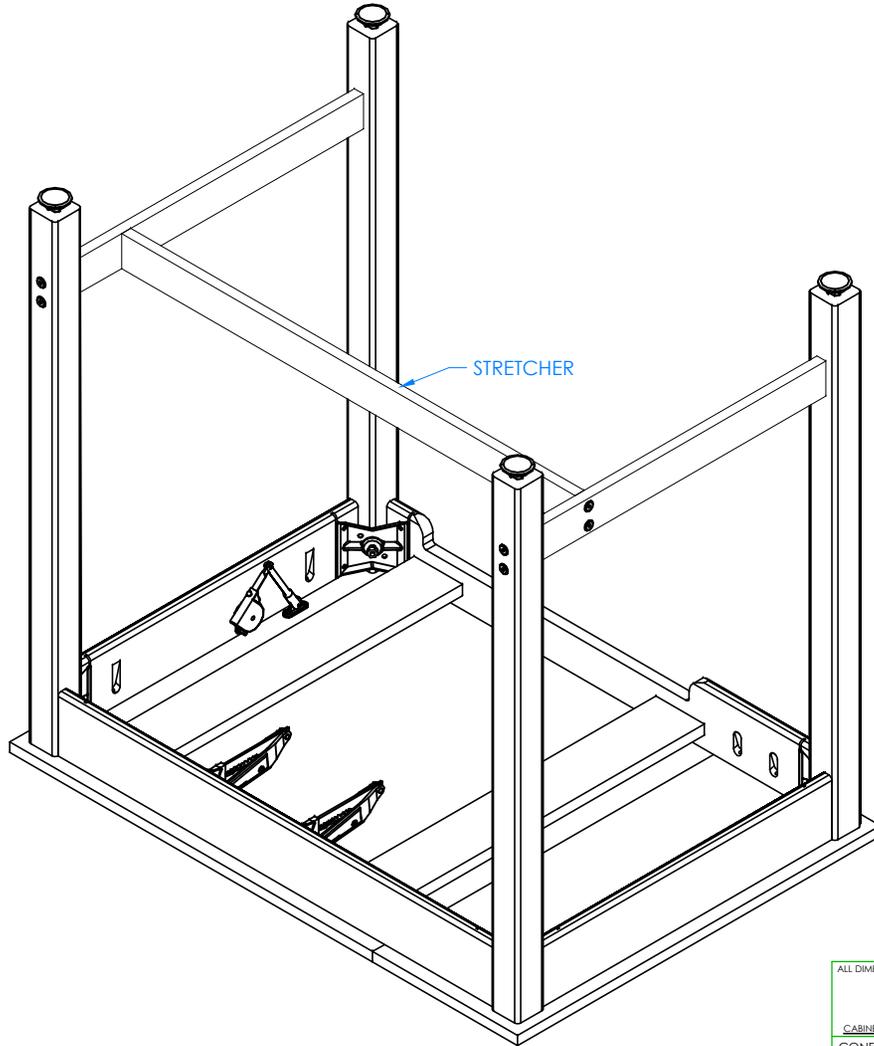


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 ASSEMBLY INSTRUCTIONS

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DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	6 OF 15	REV B



STEP 5:

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

NOTE:

1.

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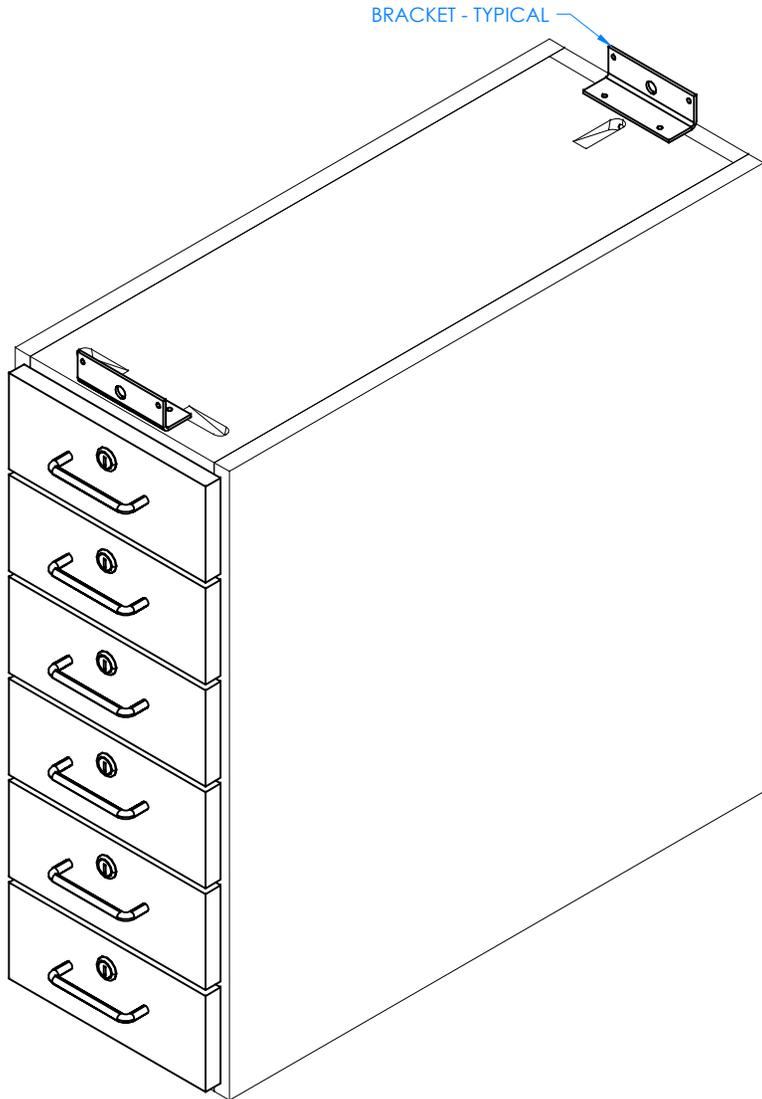


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DRAWING TABLE SYSTEM - DRAWERS
ASSEMBLY INSTRUCTIONS

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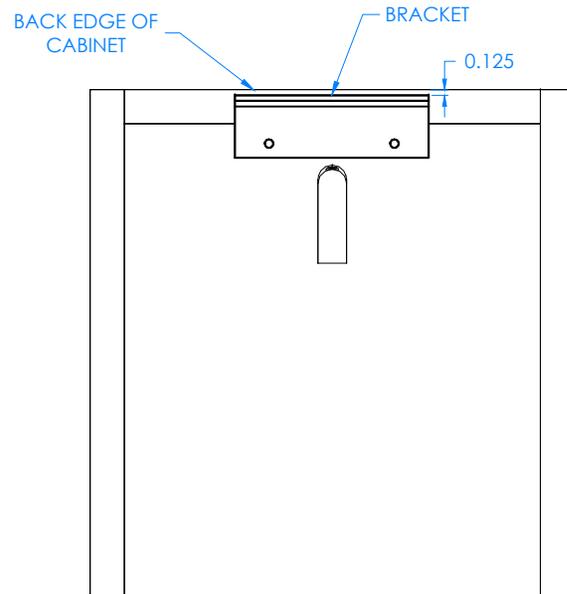
DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	7 OF 15	REV B



NOTE:
1.

STEP 6:

- ATTACH TWO BRACKETS TO TOP OF CABINET WITH HARDWARE PROVIDED.
- PLACE BRACKETS SLIGHTLY BACK FROM EDGE OF CASE.
- THIS WILL PREVENT BRACKETS FROM HITTING APRONS WHEN YOU LOWER CASE INTO PLACE.



TOP OF CABINET SHOWN

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DWN BY: EMR DATE DWN: 1/13/15
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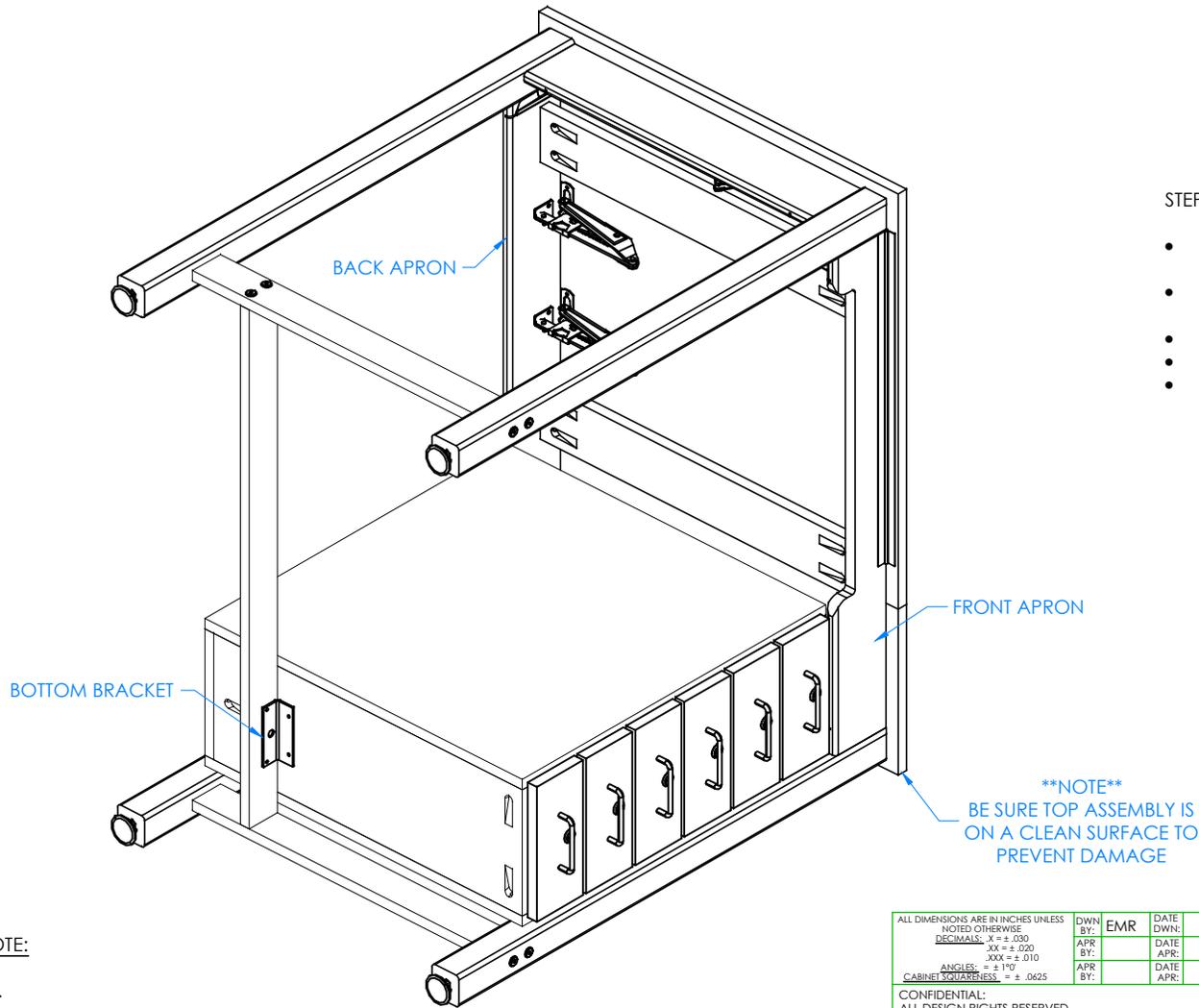
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TITLE: DRAWING TABLE SYSTEM - DRAWERS ASSEMBLY INSTRUCTIONS

DRAWING NUMBER: DT-31A, 61SA, & CDTC-71	SCALE: NTS	SHEET: 8 OF 15	REVISION: REV B
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STEP 7:

- WITH HELP FROM MULTIPLE PEOPLE, TIP TABLE ON ITS SIDE SO RIGHT SIDE OF TABLE IS ON FLOOR.
- FACE DRAWER FRONTS OF CABINET TO THE FRONT OF TABLE AND THE TWO TOP BRACKETS TOWARDS TABLE TOP.
- FIT BOTH BRACKETS INSIDE FRONT AND BACK APRONS.
- LOWER CABINET ONTO TABLE LEGS.
- SCREW THE LAST BRACKET ONTO STRETCHER AND BOTTOM OF CABINET WITH HARDWARE PROVIDED.

NOTE:

1.

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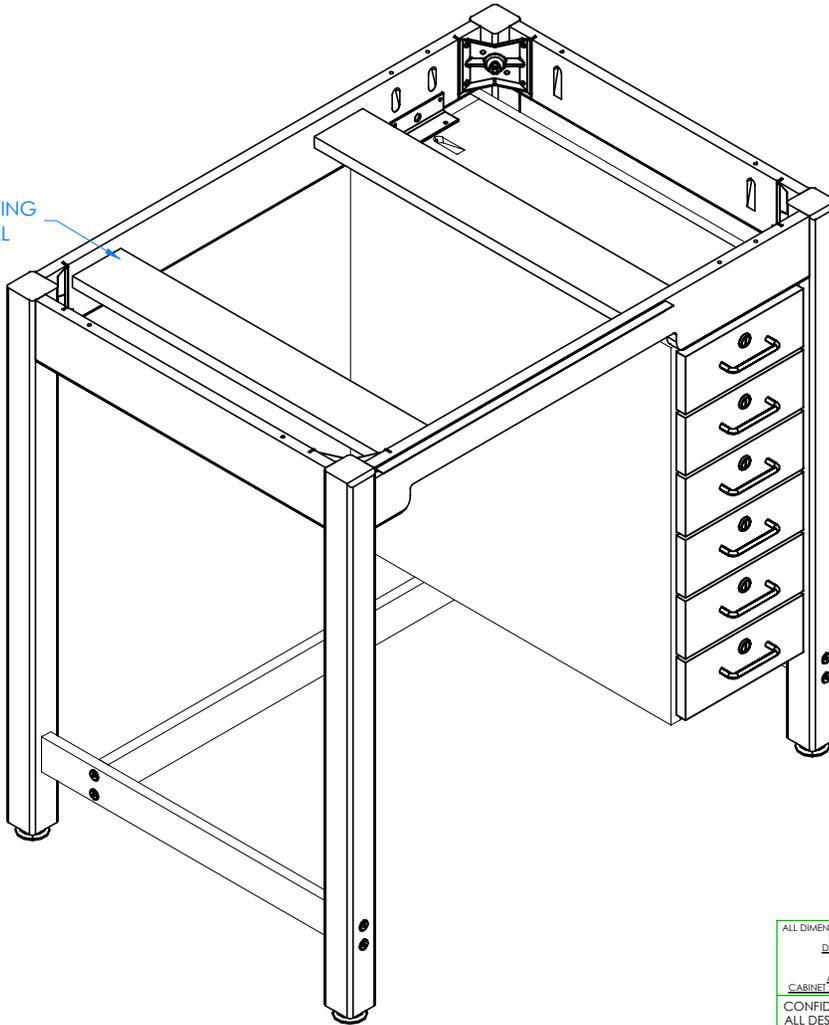
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REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	9 OF 15	REV B

KEYBOARD MOUNTING BOARD - TYPICAL



STEP 8:

- ATTACH TWO BRACKETS ON CABINET TO APRON ASSEMBLY.
- REMOVING ONE OF THE KEYBOARD MOUNTING BOARD WILL MAKE IT EASIER TO FASTEN BRACKETS TO APRON ASSEMBLY.
- HOLES NEED TO BE PRE-DRILLED BEFORE ATTACHING BRACKETS TO APRONS.

NOTE:

1.

TOPS REMOVED TO SHOW CLARITY

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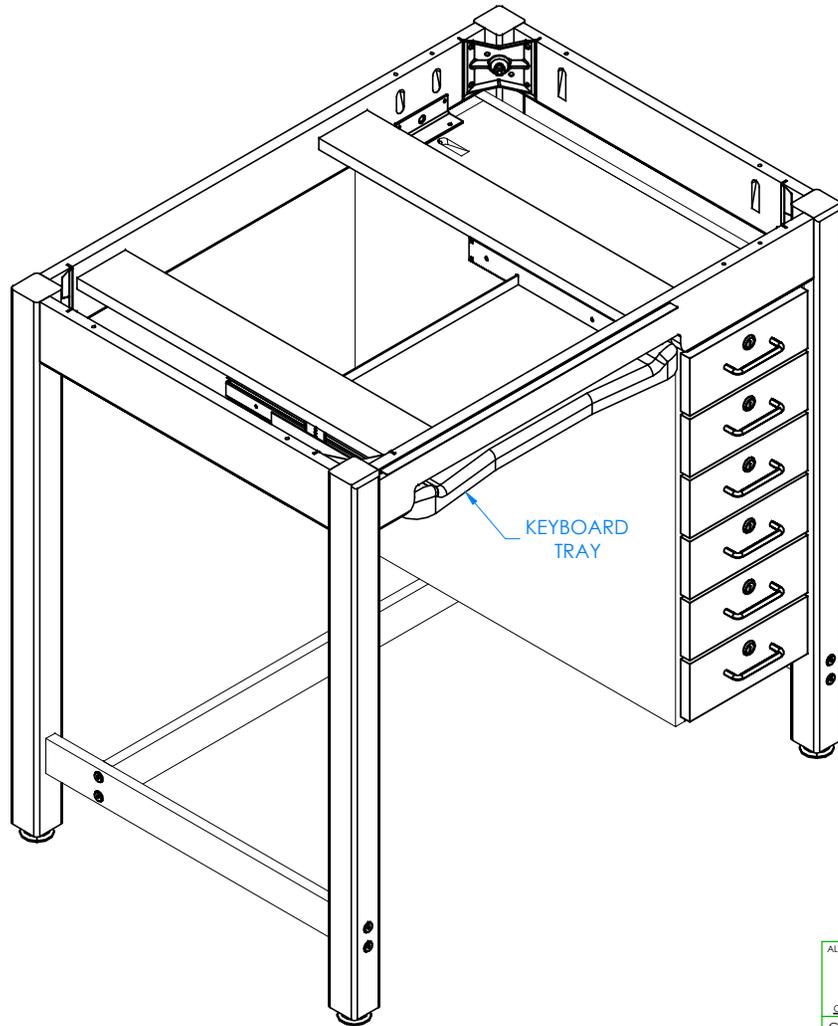


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REVISION LEVEL				

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	10 OF 15	REV B



STEP 9:

- IF YOUR TABLE DOES NOT HAVE A KEYBOARD TRAY OR A CPU SUPPORT, SKIP TO STEP 12.
- 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 TOP USING HARDWARE PROVIDED (NOT SHOWN).

NOTE:

- 1.

TOPS REMOVED TO SHOW CLARITY

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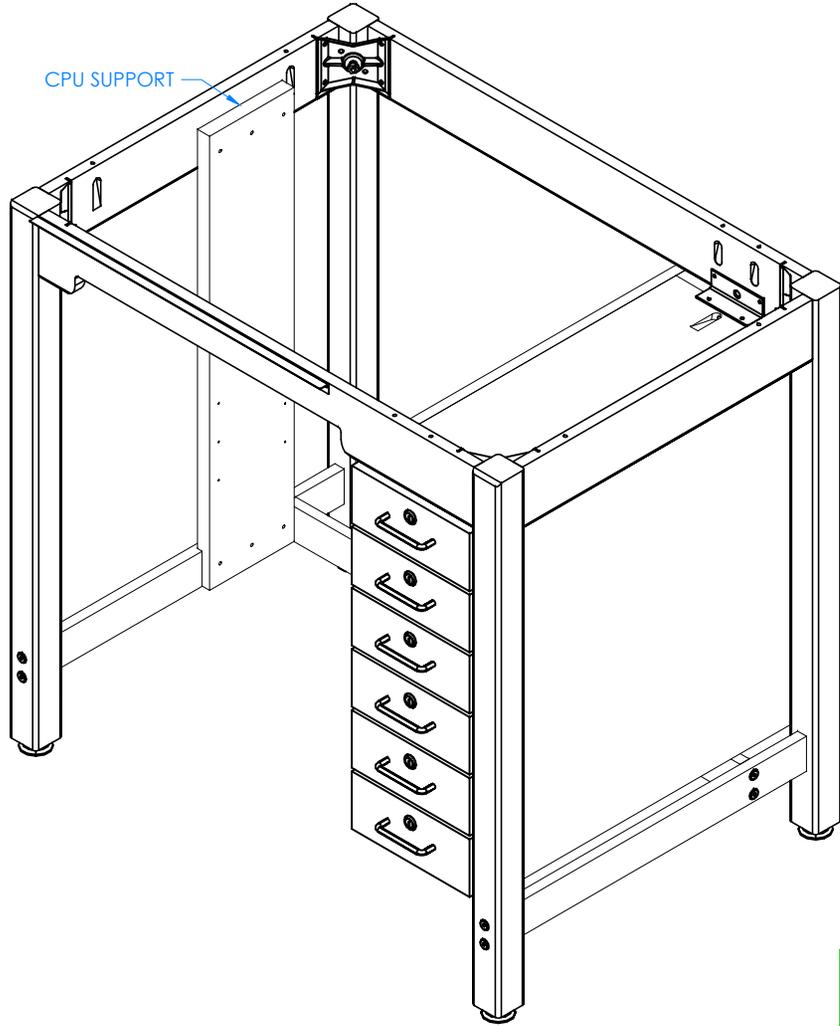


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REVISION LEVEL				

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DT-31A, 61SA, & CDTC-71	NTS	11 OF 15	REV B



STEP 10:

- 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

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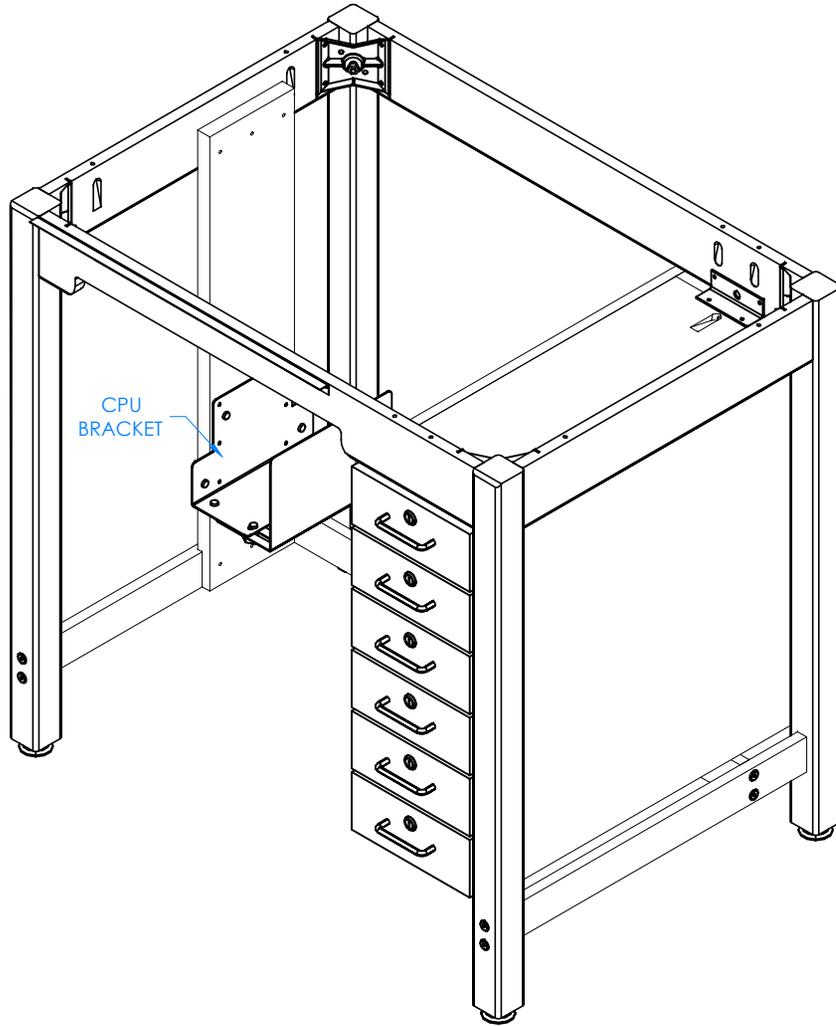


300 South Krueger Street
Suring, WI 54174
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TITLE:
DRAWING TABLE SYSTEM - DRAWERS
ASSEMBLY INSTRUCTIONS

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

DRAWING NUMBER:	SCALE:	SHEET:	REVISION:
DT-31A, 61SA, & CDTC-71	NTS	12 OF 15	REV B



CPU BRACKET

STEP 11:

- INSTALL CPU BRACKETS TO SUPPORTS USING APPROPRIATE HARDWARE FOR YOUR APPLICATION.
- SEE STEP 12 FOR DETAILED INSTRUCTIONS ON HOW TO INSTALL CPU BRACKET.

NOTE:

1.

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

ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE	DWN BY:	EMR	DATE DWN:	1/13/15
DECIMALS: X = ± .030	APR BY:		DATE APR:	
XX = ± .020	APR BY:		DATE APR:	
XXX = ± .010	APR BY:		DATE APR:	
ANGLES: = ± 1°	APR BY:		DATE APR:	
CABINET SQUARENESS: = ± .0625	APR BY:		DATE APR:	

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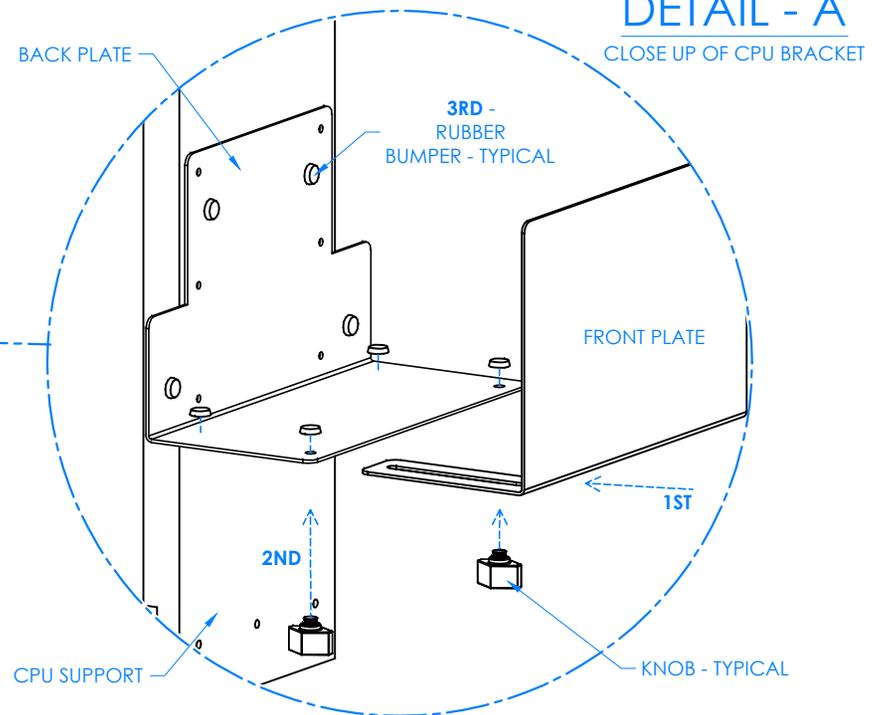
STEP 12:

- 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

SEE DETAIL - A FOR CPU BRACKET INSTALLATION



NOTE:

1.

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DECIMALS: $\frac{1}{16} = \pm .030$	APR BY:		DATE APR:	
XX = $\pm .020$	APR BY:		DATE APR:	
XXX = $\pm .010$	APR BY:		DATE APR:	
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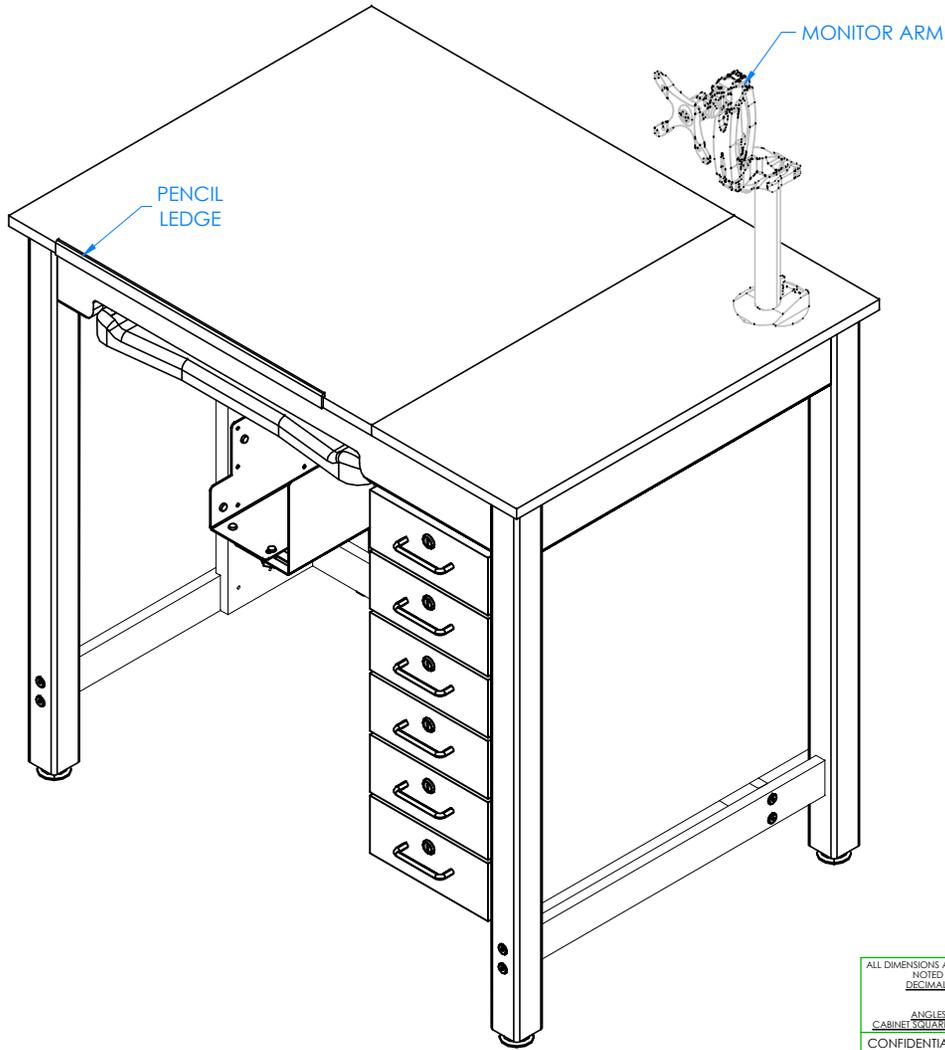


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STEP 13:

- 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

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