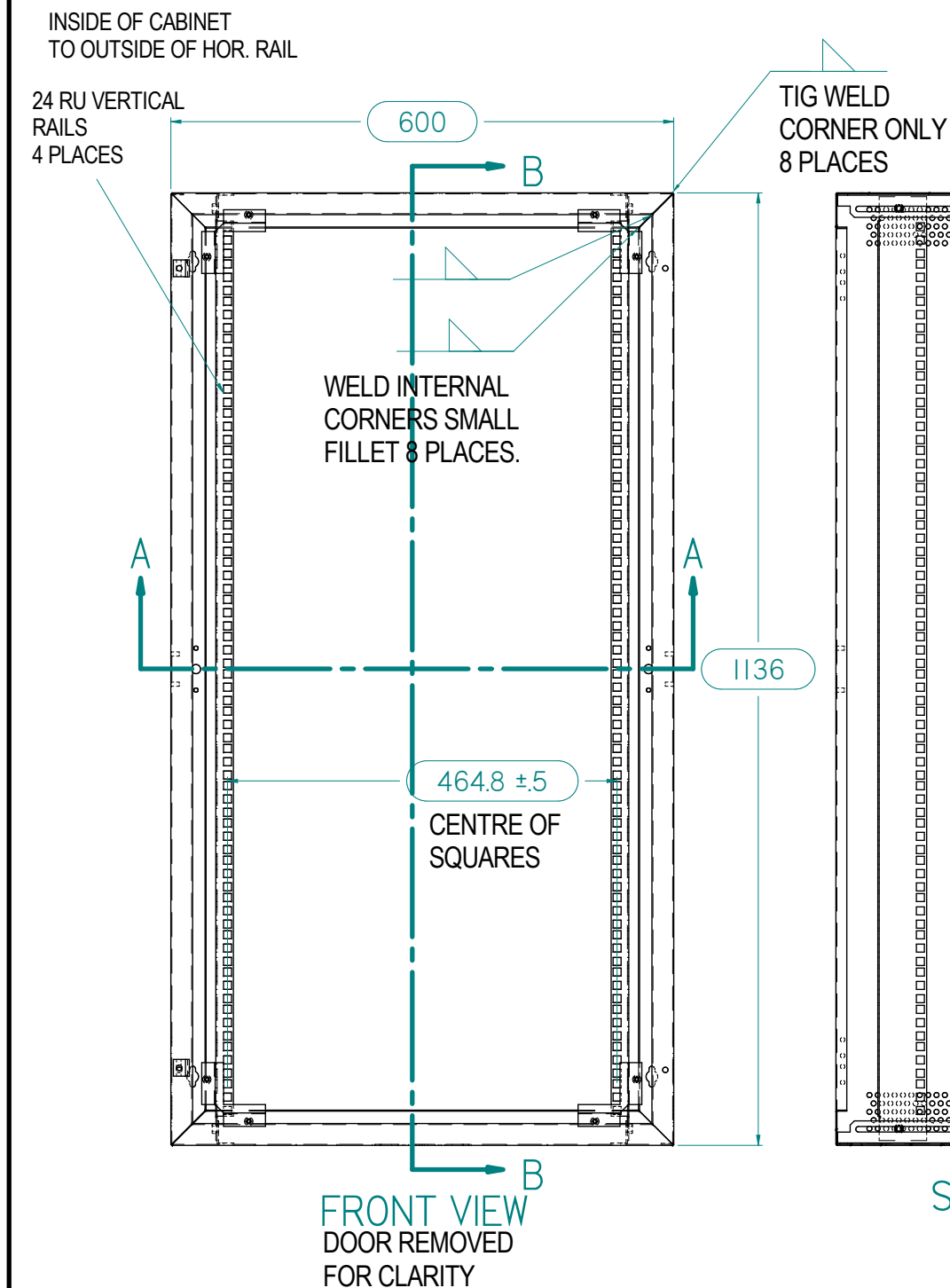


ASSEMBLY PROCEDURE -
 SPOTWELD HORIZONTAL RAILS TO BODY HALVES.
 TIGWELD BODY HALVES TOGETHER ON INNER CORNERS ONLY.
 CHECK SIZE 600mm OVERALL MINIMUM GAPS IN CORNERS
 SPOTWELD BODY HALVES TOGETHER, THEN FUSION WELD OUTER CORNERS.
 MASK THREADS
 POWDERCOAT BODY, THEN FIT V. RAILS AND DOOR

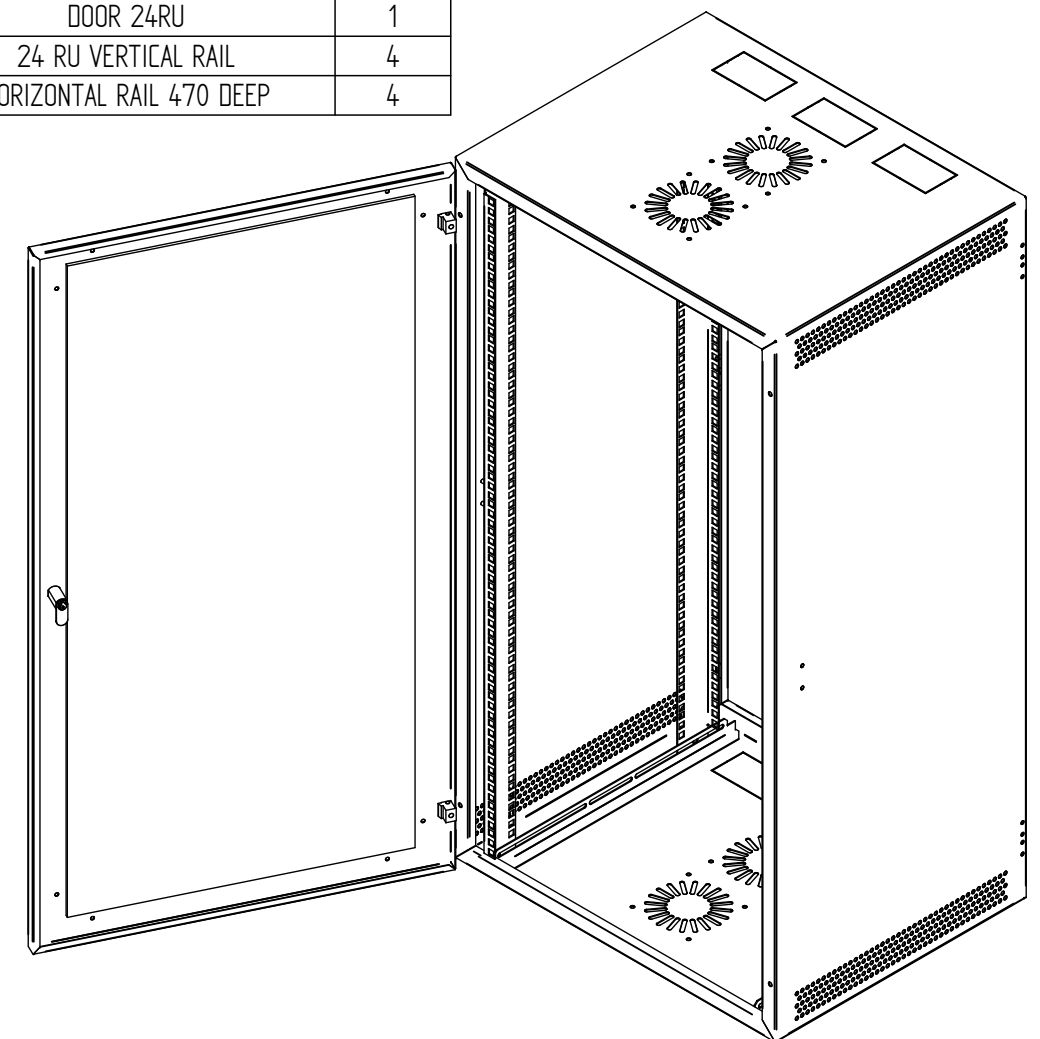
REV.	REVISION HISTORY	DATE
0	FIRST PRODUCTION RELEASE	10/03/2014
1	HINGE HOLES CHANGED FOR CN HINGE	20/11/2007
2	KEYHOLE CUTOUTS AND DETAIL "C" ADDED	5/12/2007
3	EXTRA FAN CUTOUTS ADDED	13/12/2012

ADDITIONAL FASTENERS AND HARDWARE REQUIRED FOR COMPLETION
 2 OFF DOOR HINGES PT. NO. EMKA- 1110-U3 (OR CL-230-2)
 4 OFF M5 SERRATED FLANGE HEX NUTS (HINGE TO DOOR)&(ROD MOUNT BKTS TO CABINET)
 2 OFF M5 X 10 HEX SCREW (HINGE TO CABINET)
 4 OFF M6 X 14 THUMB SCREW BLACK AND INTERNAL SHAKEPROOF WASHER (V. RAILS TO H. RAILS)

Item Number	Document Number	Revision	Title	Quantity
1	24-470-001	3	1/2 Box Body 24 RU	2
2	24-DR-007	3	DOOR 24RU	1
3	24-VR-002	1	24 RU VERTICAL RAIL	4
4	470-HR-003	2	HORIZONTAL RAIL 470 DEEP	4



SECTION B-B



FLAT PATTERN DISCLAIMER AS INDIVIDUAL MANUFACTURERS TOOLING MAY VARY WIDELY IT IS THE MANUFACTURERS RESPONSIBILITY TO DETERMINE CORRECT FLAT SIZES OR WHETHER THE SUPPLIED FLAT DIMENSIONS ARE ACCURATE	DRAWN BY: INITIAL	TOLERANCES TOLERANCES SET BY NUMBER OF DECIMAL PLACES. ie: 1 decimal - 0.0 = +/- 0.5mm 2 decimals - 0.00 = +/- 0.15mm ANGLES +/- 0.5 deg. ○ DENOTES CRITICAL DIMENSION	MATERIAL FINISH
	CHECKED BY: INITIAL		PROJECT WALL MOUNT CABINET
SHEET 1 OF 1 AS 1100	DRAWING NO. 24-470-000	FILENAME: 24-470-000.asm	A3
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