



SGX04 Channel Stand Installation Procedure

Document: 389D002

Rev F

This procedure describes the proper assembly of the SGX04 basic channel stand and the correct installation underneath the cabinet. It provides step by step instructions for the channel stand installation in two instances:

1. **The Channel Stand Assembly Procedure** when the stands ships from the factory separately from the cabinet.
2. **The Channel Stand Leg Assembly Procedure** when the channels stand is factory attached to the bottom of the cabinet.

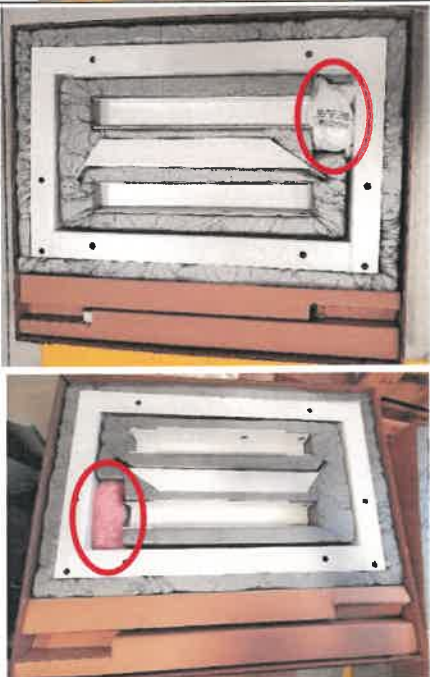
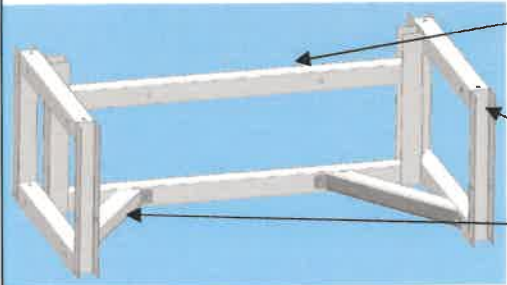
Tools required: $\frac{7}{16}$ " deep socket, $\frac{9}{16}$ " wrench or socket, $\frac{5}{8}$ " wrench or socket, and level.

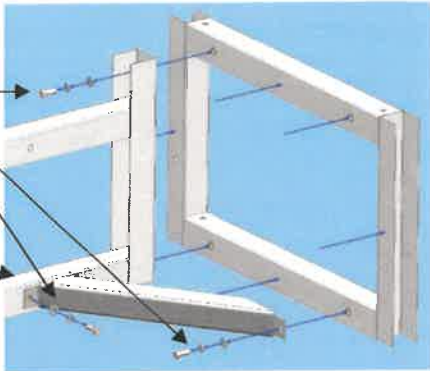
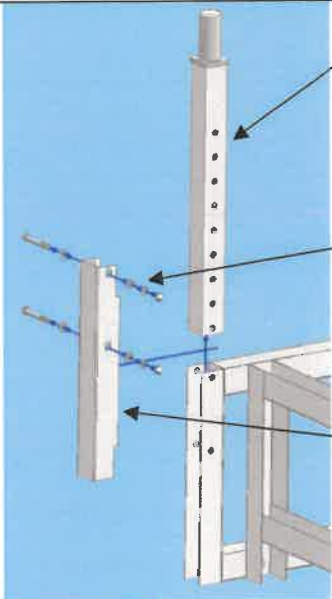
Parts List:

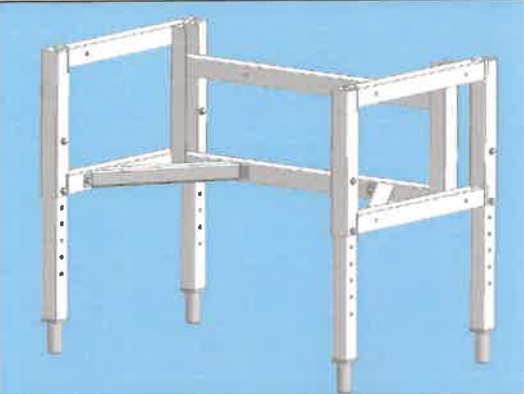
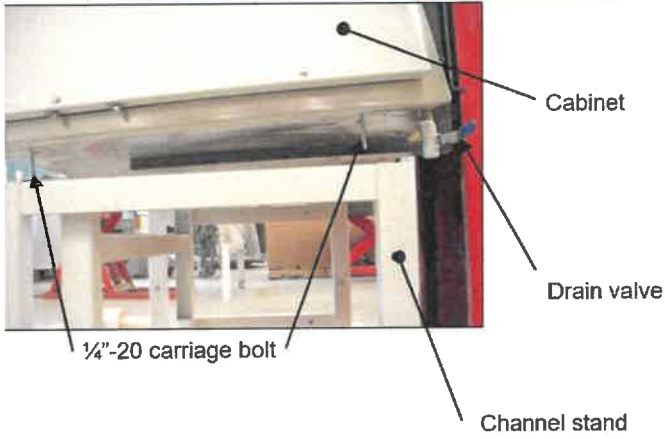
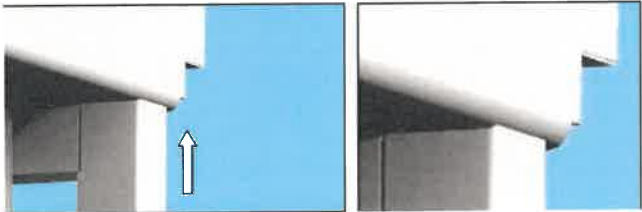
Item Number	Part Number	Description	Qty
1	389W401/390W401/365W401	Channel stand, brace	1
2	390W410	Channel stand, side	2
3	389P401	Channel stand, gusset	2
Channel Stand Hardware Kit (44255) includes items 4-12.			1
4	40273	Bolt, carriage, $\frac{1}{4}$ "-20 x 2" long	4
5	10392	Bolt, hex head, $\frac{3}{8}$ "-16 x 1" long	8
6	44208	Bolt, hex head, $\frac{3}{8}$ "-16 x 3" long	8
7	11283	Flat washer, $\frac{1}{4}$ "	4
8	44209	Flat washer, $\frac{3}{8}$ "	24
9	44210	Lock washer, $\frac{3}{8}$ "	16
10	10520	Hex lock nut, $\frac{1}{4}$ "	4
11	44207	Nut, Acorn, $\frac{3}{8}$ "-16	8
12	FASTENAL 0150422	Blue Loctite, 243 Threadlocker	1
13	390P406 with 43312 (390P416 with 43345/43346)	Adjustable leg with leg leveler (or optional castor)	4
14	390P414	Channel , cover	4
15	389G406	Kit, SGX04 leg plugs	1

NOTE: Caster stand option requires four modified leg assemblies (Not shown).

1. Channel Stand Assembly Procedure

	Step 1: Remove stand components from rear of cabinet skid if shipped as shown. If cabinet is factory shipped on channel stand, please see channels stand leg assembly procedure on page# 5.
	Step 2: Gather all stand components, hardware, and tools. The stand hardware will be found in one of the two stand boxes as shown. The ball valve will be found in a bubble wrapped bag in the other of the two stand boxes as shown.
 Channel Stand Brace Channel Stand Side Channel Stand, Gusset	Step 3: Place stand sides on a flat floor surface with a blanket or cardboard down to protect the stand parts from damage. Place the stand back between the sides so that the open part of the channel is facing down towards the floor. Place the braces as shown.

3/8" Hardware Flip the stand 90° to access lower hole Channel Stand, Brace 	Step 4: Using the 3/8"x 1" hex head bolts, lock washers, flat washers, and Blue Loctite [Items 5, 8, 9, & 12], attach the sides and back by inserting the bolts thru the (4) holes located in the channel stand back into the already installed rivnuts in the two sides. (2) bolts per side. Do not tighten any of these bolts until you have all (4) threaded in slightly. Tighten bolts after this is done.
 Adjustable leg with leveler 3/8" Hardware [Items 6, 8, 9, & 11] Channel, Cover  Cover exposed holes with plug, item 15	Step 5: With stand assembly complete, rotate stand upside down. Position the legs by inserting them into the side channels. The legs can now be adjusted to the desired height requirement. This is done by aligning the stand holes with the holes in each leg, then sliding the leg cover over the channel. Secure the leg assembly with 3/8" hardware. Do not tighten bolts yet, so the cover can slide up and down in the slots. (see step 9) Cover the exposed threaded holes in the legs with plug. NOTE: If the cabinet is not in its final room location you may want to perform the leg adjustment after assembling the cabinet to the stand and moving it to the room (see step 11). Total work surface height adjustment range: 27" to 38 5/8" [686 mm-981 mm]

	Step 6: Rotate the stand assembly to the upright position so that the leg levelers are now resting on the floor.
	Step 7: Lift the cabinet off the skid and high enough to allow clearance for the stand assembly to be positioned under it. Once the stand is positioned under the cabinet, install (4) 1/4" x 2" carriage bolts into the key way slots located under the cabinet in each of the (4) corners. The cabinet is now ready to be lowered onto the stand. There are (4) holes on the top of the stand which the bolts must be guided through. Be careful not to let the bolts drag on the edge of the holes while lowering as burrs may occur on the bolts and cause threading problems.
	Step 8: With the cabinet resting on top of the stand assembly, place a 1/4" flat washer, and hex lock nut onto each of the bolts. Then tighten all 1/4" hex lock nuts. A 7/16" deep socket is required for this.
	Step 9: With the cabinet secured on top of the stand and at the correct height, slide the channel covers up so the top edge will touch the drain pan. Tighten all 3/8" hex bolts.

Step 10:

If not already installed, attached the drain valve to the bottom of the drain pan by removing the handle and threading into the nipple using thread seal tape. Position the valve such that the handle will be facing the front of the cabinet (see picture in step 7). Attach the handle and secure with screw.

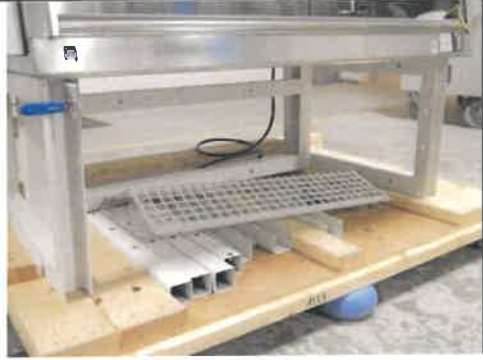
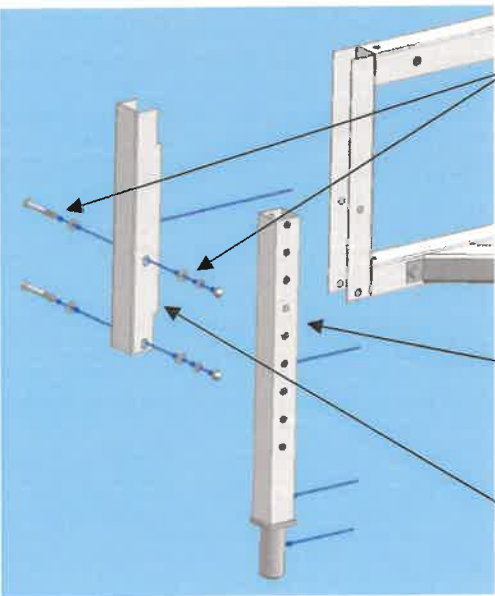
Step 11:

The lift device should be removed if not being used to move cabinet into position within the room. If the lift device is mobile it may be used to maneuver cabinet into the desired location. A blanket could also be placed under the leg levelers while sliding the cabinet to avoid scuffing the flooring.

Step 12:

Skip to Section 2, Step 6, to level the cabinet using the adjustable legs.

2. Channel Stand Leg Assembly Procedure:

	Step 1: If cabinet is factory shipped on channel stand remove components 4-15 that are separately shipped with cabinet.
	Step 2: Lift cabinet off the skid and high enough to allow clearance for the adjustable legs to be assembled to the front and rear of the channel stand sides. Total work surface height adjustment range: 27" to 385/8" [686 mm-981 mm] Attach channel cover, align slots with holes and use 3/8" hardware to secure legs. Slide the channel covers up so the top edge will touch the drain pan before tightening hardware.

Step 3:

If lifting of the complete cabinet is not possible, carefully slide the cabinet off the skid onto a moving blanket or similar protective material in order to protect floor finish.
Slide the cabinet into its final destination prior to assembly of the adjustable legs.



Step 4:

Carefully lift up one end of the cabinet by at least 6" [150 mm] and block into position using a safe and secure method.

Insert adjustable leg into channel on front and rear side of cabinet and secure it as described in **Step 2**. Repeat this step at the other side of the cabinet

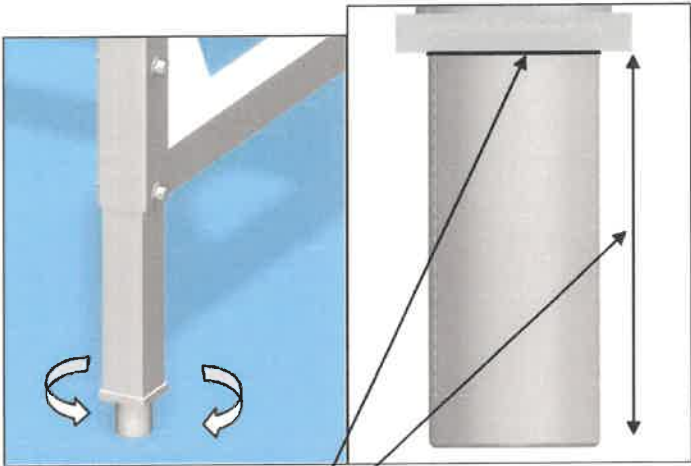
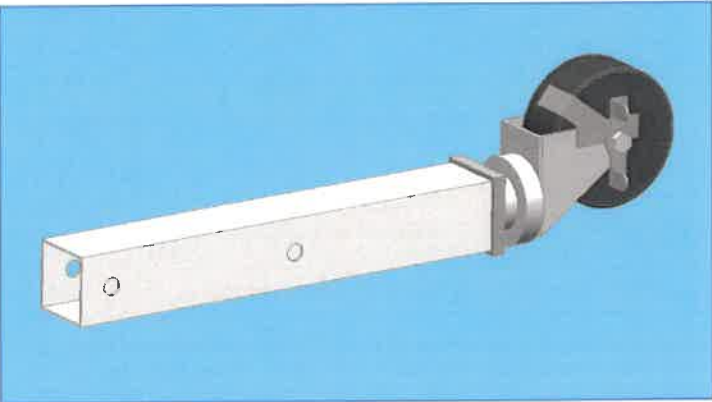
Warning: if caster option is provided make sure to chock the wheels before lifting the other side.



Step 5:

If the work surface height needs to be raised higher the legs have holes that are spaced 2" [50 mm] apart. Lift up one end of the cabinet again by another 3" to 6" [75 mm to 150 mm] and unscrew the 3/8" leg bolts on each leg and slide down the leg until the holes in the leg are aligned with the holes in the channel. Secure legs with the hardware. Repeat this step at the other side of the cabinet.

Repeat this process as needed to get desired height.

 3 3/4" maximum extension	Step 6: Use a level and level the cabinet by turning the leg leveler feet on each adjustable leg. Warning: do not extend the leveler feet beyond the maximum extension. Insert plugs to all exposed threaded holes in the legs.
	Step 6a: Applies to caster option only. Caster extension is only intended for leveling purposes. WARNING: Maximum allowed extension is 1/2".