



IPC rack frame  
typical each side  
Note  
remove side panels  
before mounting  
support channels

Bottom channels are  
part of rack frame  
typical each side

**ASSEMBLY INSTRUCTIONS:**

**NOTE:**  
Assembly shown typical on both sides of IPC rack

PARTS LIST		
ITEM No.	DESCRIPTION	QTY
1	BASE INNER PANEL	1
2	TOP SUPPORT CHANNEL	2
3	TOP BRACKET (STRAIGHT)	2
4	BOTTOM BRACKET (OFFSET)	2
5	3/8 BOLT	4
6	3/8 LOCK WASHER	8
7	3/8 FLAT WASHER	8
8	3/8 NUT	4
9	3/8 SPRING NUT	4
10	1/4-20 SCREW	4

- A) Assemble top support channels (item 2) using holes provided in IPC rack frame secure with 1/4-20 screw and washer (item 10) thru frame into weldnuts on support channels. Ensure that notch on support channels are to the front and fit between front combination rails and frame.
- B) If holes are not provided then drill .312" (7.9mm) dia. holes thru frame 26.375" (670mm) from center of bottom "C" channel and dimension "A" for depth. Use holes in top support to mark dim. A centered on frame. Assemble as per step A
- C) Assemble top bracket straight (item 3) and bottom bracket offset (item 4) on top and bottom channels at desired depth using 3/8 bolt, lock washer, flat washer and spring nut (items 5, 6, 7 & 9).
- D) Secure base inner panel (item 1) onto studs of top and bottom brackets using 3/8 nut, lock washer, flat washer (items 6, 7, & 8).

**TOOL BOX**



3/8, 7/16, 9/16  
Socket Wrench



3/8, 7/16, 9/16



Center



Hammer



Electric Drill use  
.312(7.9mm) Bit



Tape  
Measure

