

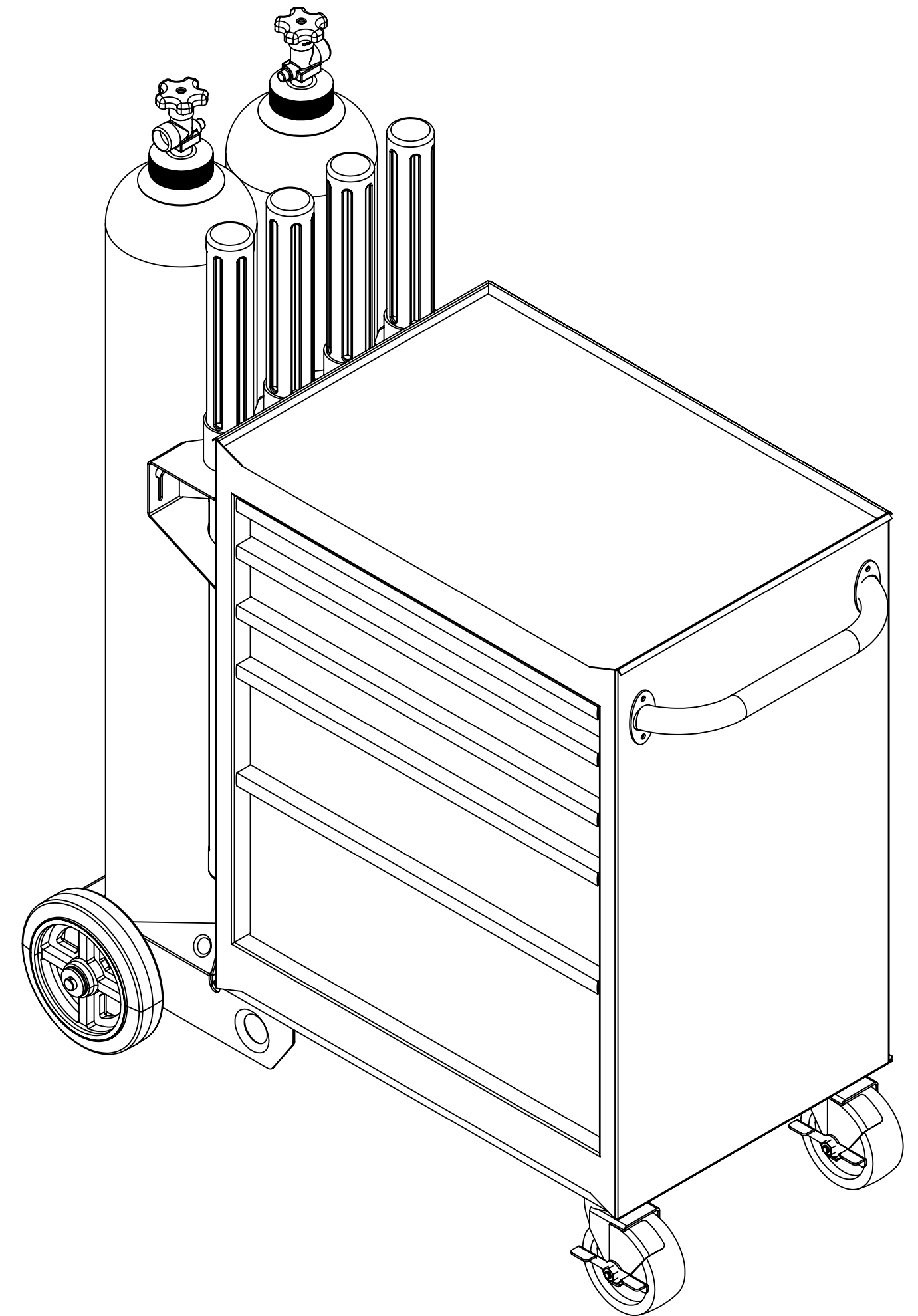


Toolbox Welding Cart Kit Instructions

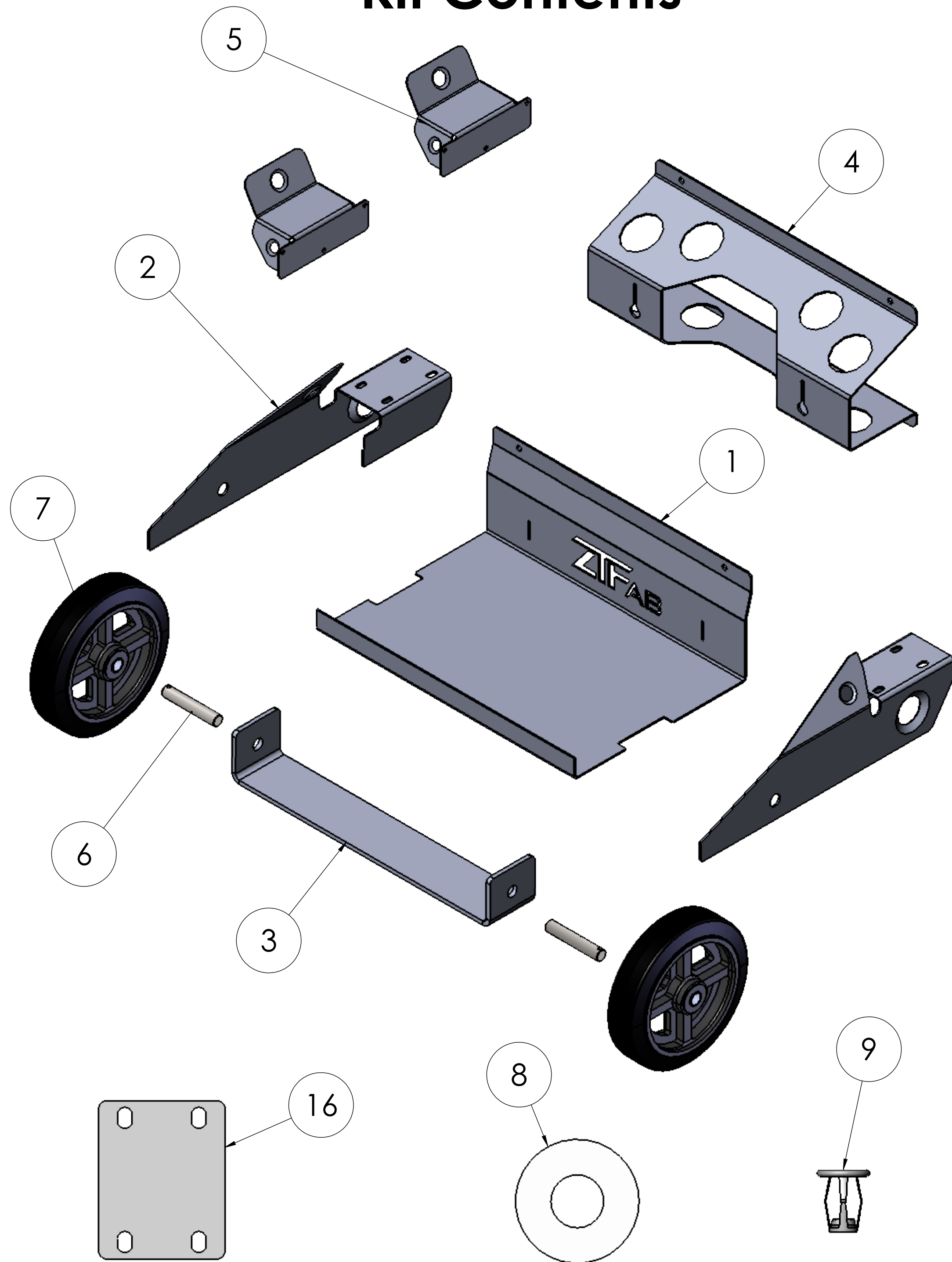
These instructions may apply to multiple models and/or manufacturers toolboxes and are to serve as a general guide for installing your ZTFab Welding Cart Kit. While we make every effort possible to ensure our products fit as suggested, ZTFab is not responsible for any changes, alterations, or omissions made by the manufacturers which may affect fit or function. For a complete list of applicable toolbox model numbers please visit our website at All-A-Cart.com

These kits require welding, drilling, and, painting or coating to prevent rust. Please, read, follow, and understand all directions before proceeding. Wearing of proper Safety Equipment is recommended at all times.

Installation of this kit may void your manufacturer's warranty. ZTFab will not be responsible for any toolbox manufacturer's defects or warranty claims that were not resolved prior to installing this kit or are denied after its installation. Installation of this kit does not allow the toolbox to exceed the manufacturer's suggested weight limits or capacities. Please follow all the manufacturer's procedures, cautions, and care instructions as outlined in your toolbox owner's manual. Install and use at your own risk.

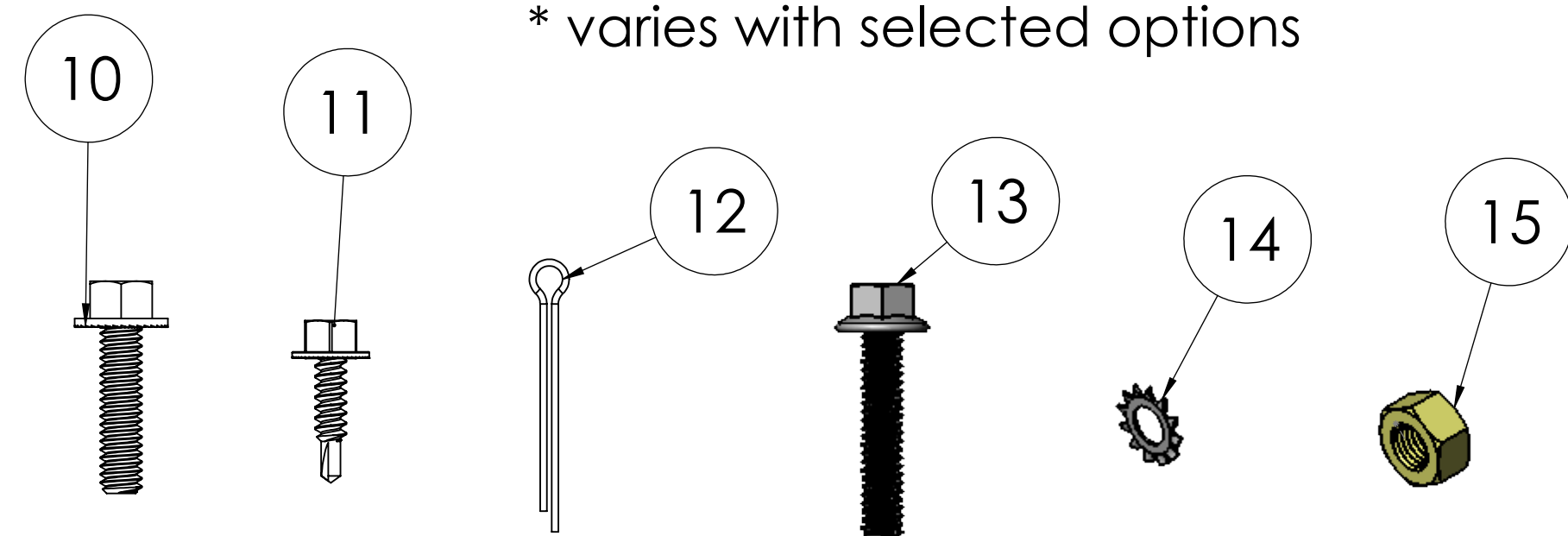


Kit Contents



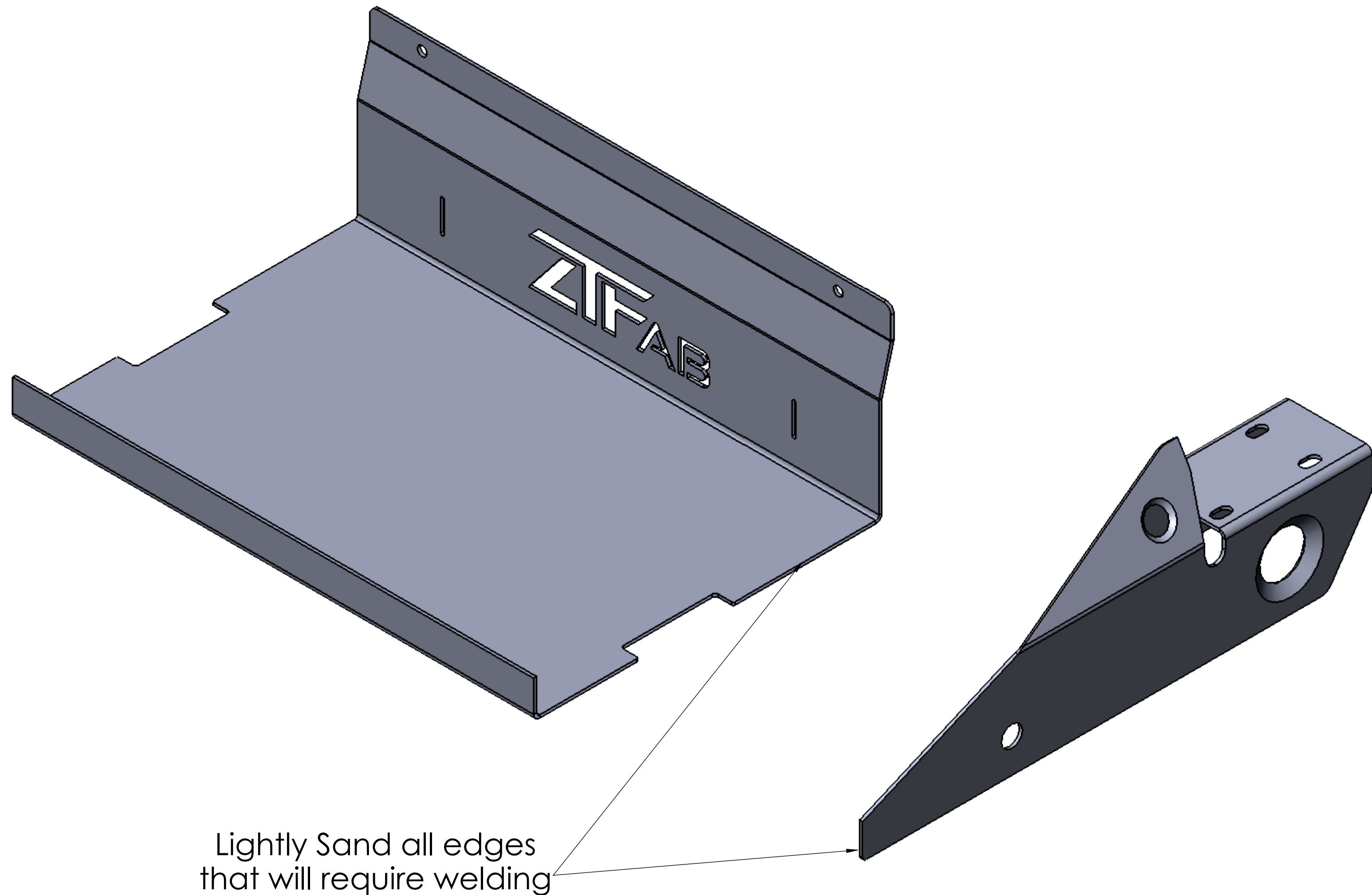
Part	Description	QTY
1	Bottle Base	1
2	Side Plates	2
3	Axle Bracket	1
4	Bottle Bracket*	1
5	Cord Hangers	2*
6	Axle Shafts	2
7	Wheels	2
8	Axle Washer	4
9	Jack Nut	7
10	1/4"-20 x 1" Serrated Flanged Head Bolt	6
11	#10x3/4" Sheet Metal Screw	6*
12	Cotter Pin	2
13	1/4"-20x1.25" Flanged Head Bolt	1
14	External tooth 1/4" Lock Washer	1
15	5/16"-24 Grade 8 Nut	1
16	Caster Spacers (Husky Only)	2

* varies with selected options



Step 1: Material Preparation

Your cart kit is made from high quality, 12gauge, CNC cut steel. During the cutting process an oxide layer is formed on the cut edge. While it is not absolutely necessary to clean this off before welding it is highly recommended for the best results. All edges that need welding can be easily cleaned by lightly sanding them with a fine grit paper. Be careful not to remove material beyond the oxide layer as this may affect fitment of the parts.

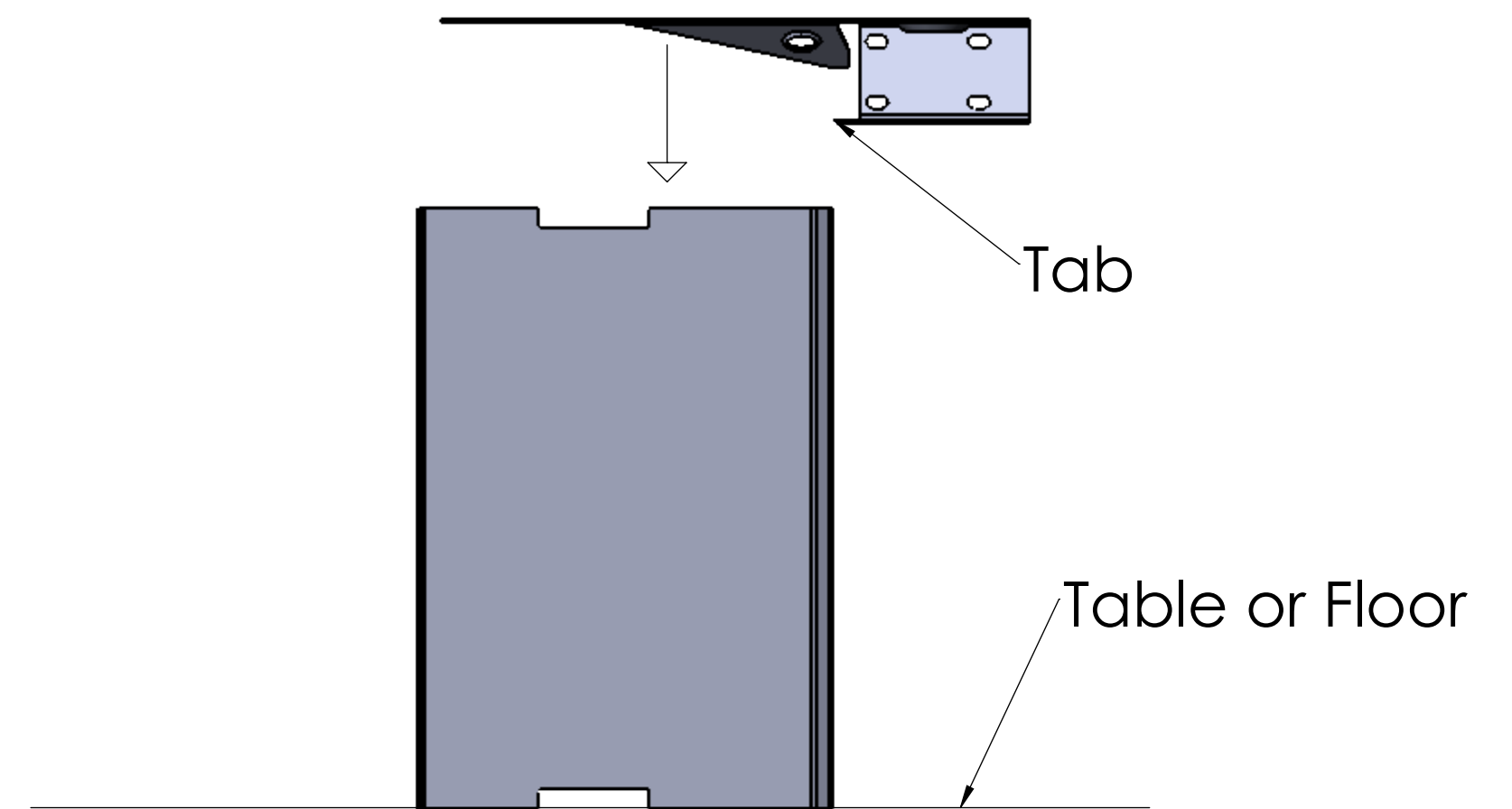
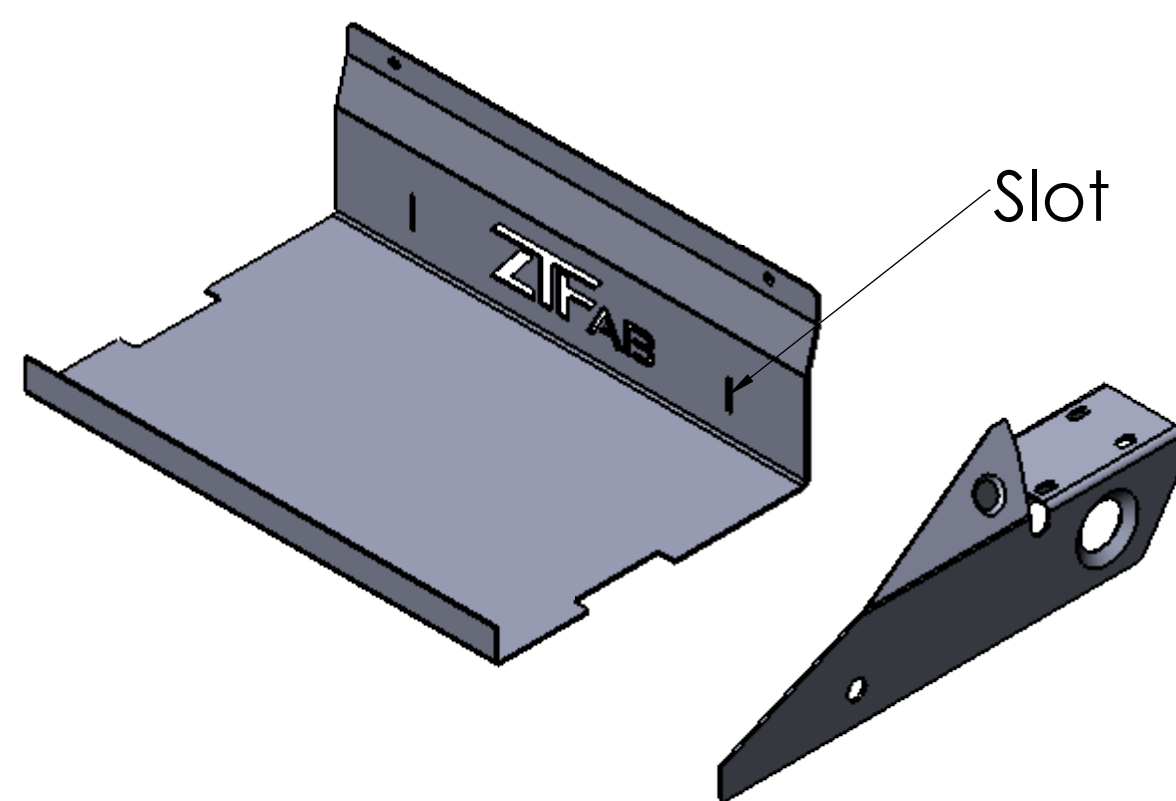


Step 2: Bottle Base Assembly

Start with the Bottle Base and the Right Side plate.

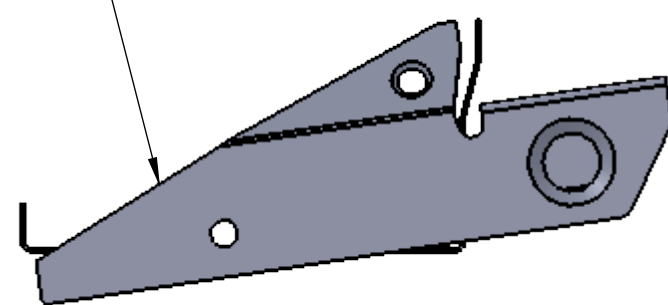
Turn the Bottle Base up on it's edge and set the side plate on the side of the Bottle Base.

Rotate the Side Plate counter-clockwise so that it sits flat on the edge of the Bottle Base (See View 2-2). Now rotate the Side Plate Clockwise and insert the tab on the inside leg into the slot on the Bottle Base. (View 2-3).



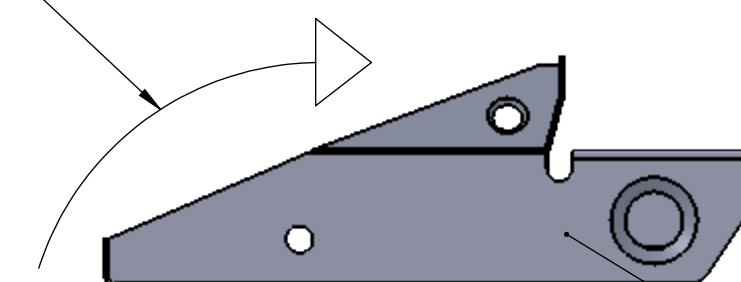
View 2-1

Set the Side plate on the Bottle Base edge at an angle.



View 2-2

Rotate the side plate clockwise while inserting the tab into the slot on the Bottle Base.

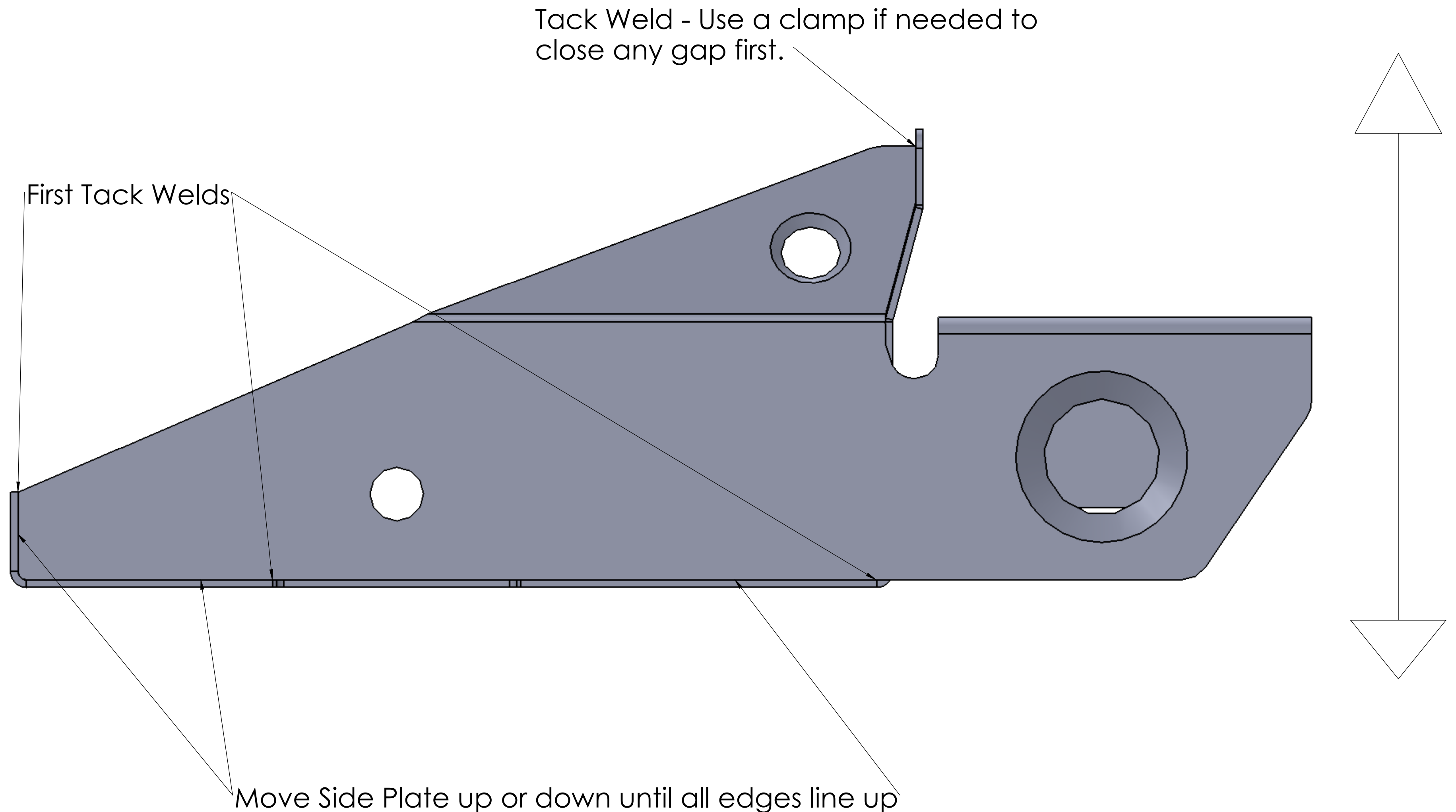


View 2-3

Tab and Slot on the inside leg

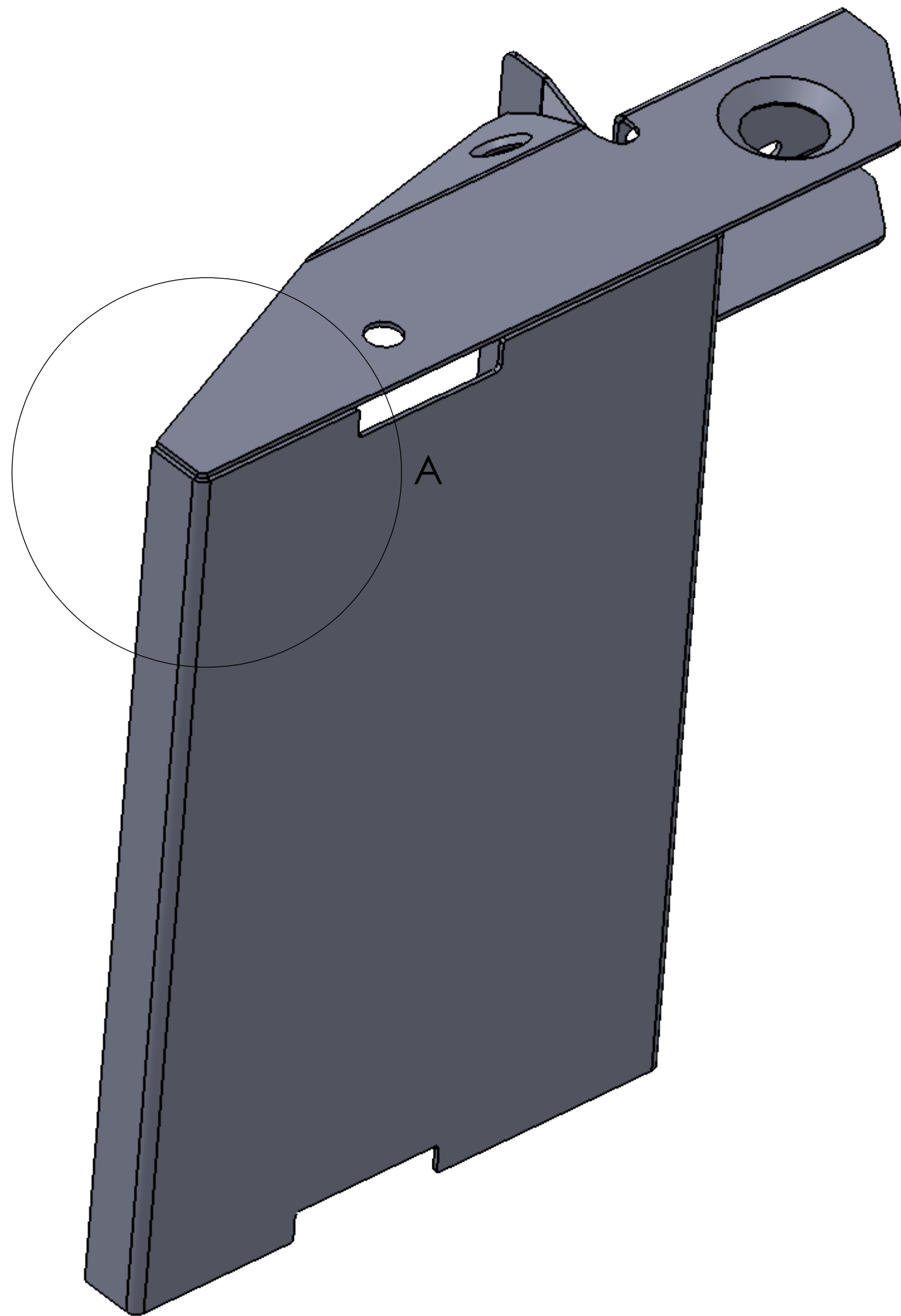
Step 2A: Bottle Base Assembly

With the tab inserted into the slot, adjust the side plate up or down until the edges of the Side Plate line up with the edges of the Bottle Base. Place the first 2-3 tack welds to keep the parts lined up. If necessary, use a clamp or slight hand pressure to ensure a tight fit at the top of the Bottle Base and place another tack weld.

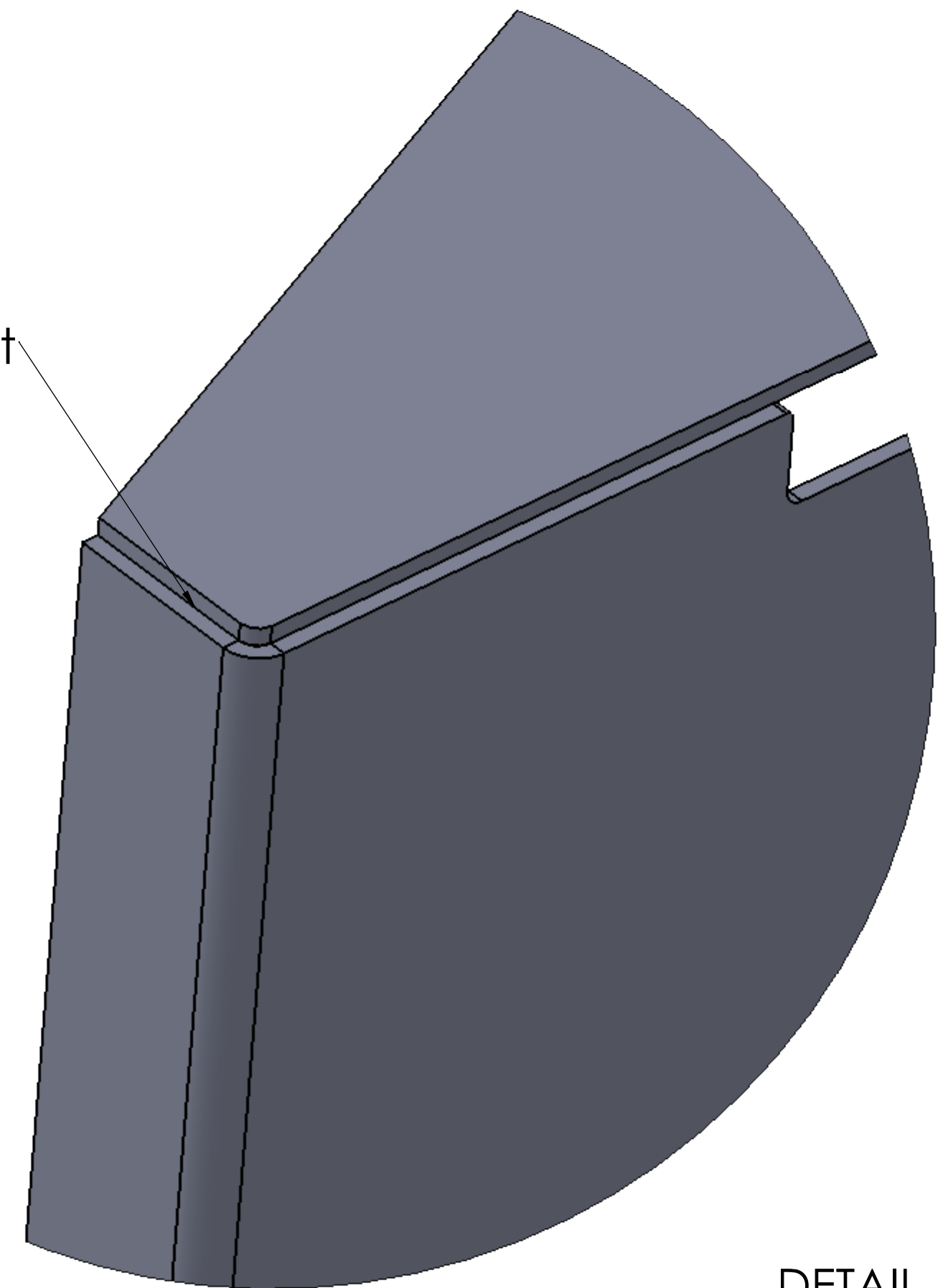


Step 2B: Bottle Base Assembly

Be sure that all the edges line up and form an "Open Corner" joint for welding. See Detailed View A.
Now, repeat the process for the Left side.



Open Corner Joint

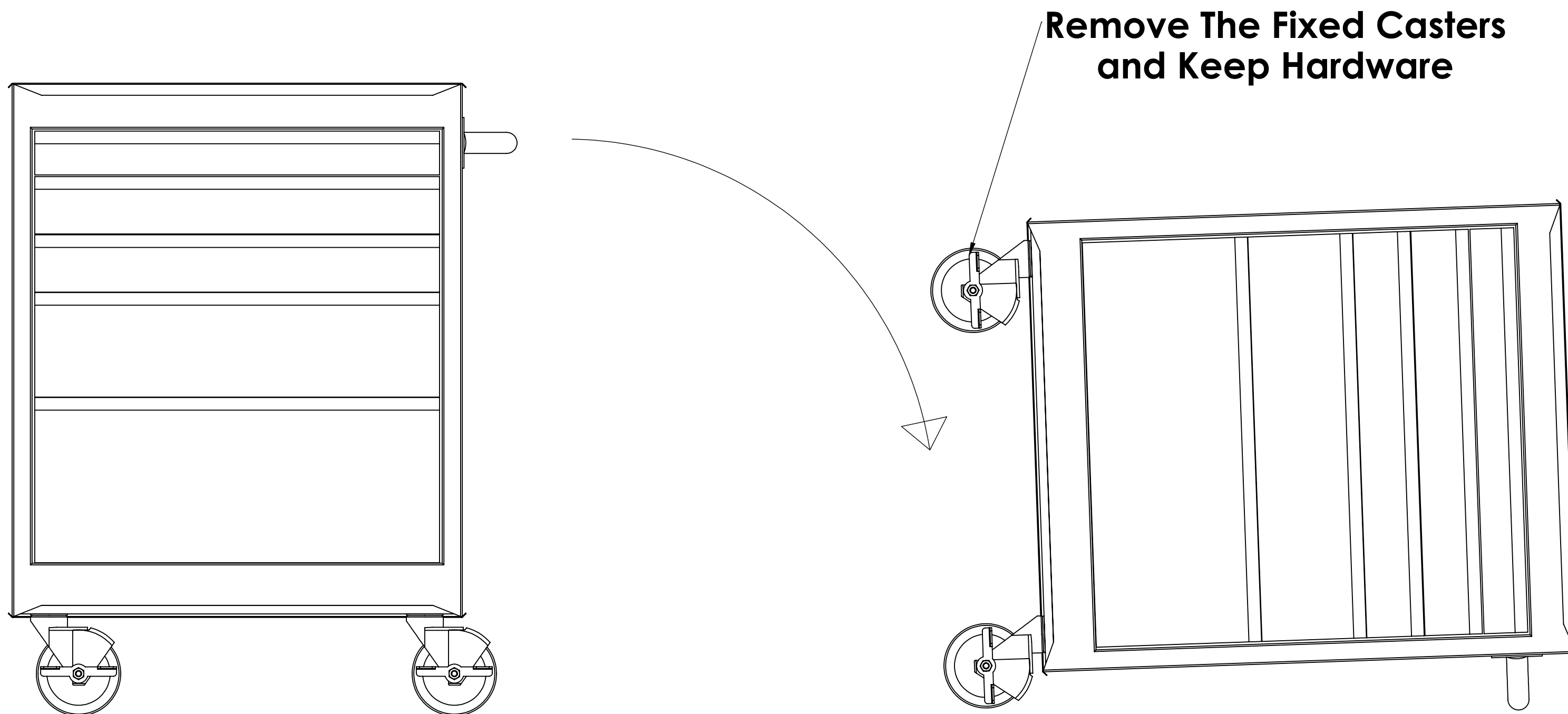


DETAIL A
SCALE 1.5 : 1

Step 3: Toolbox Preparation

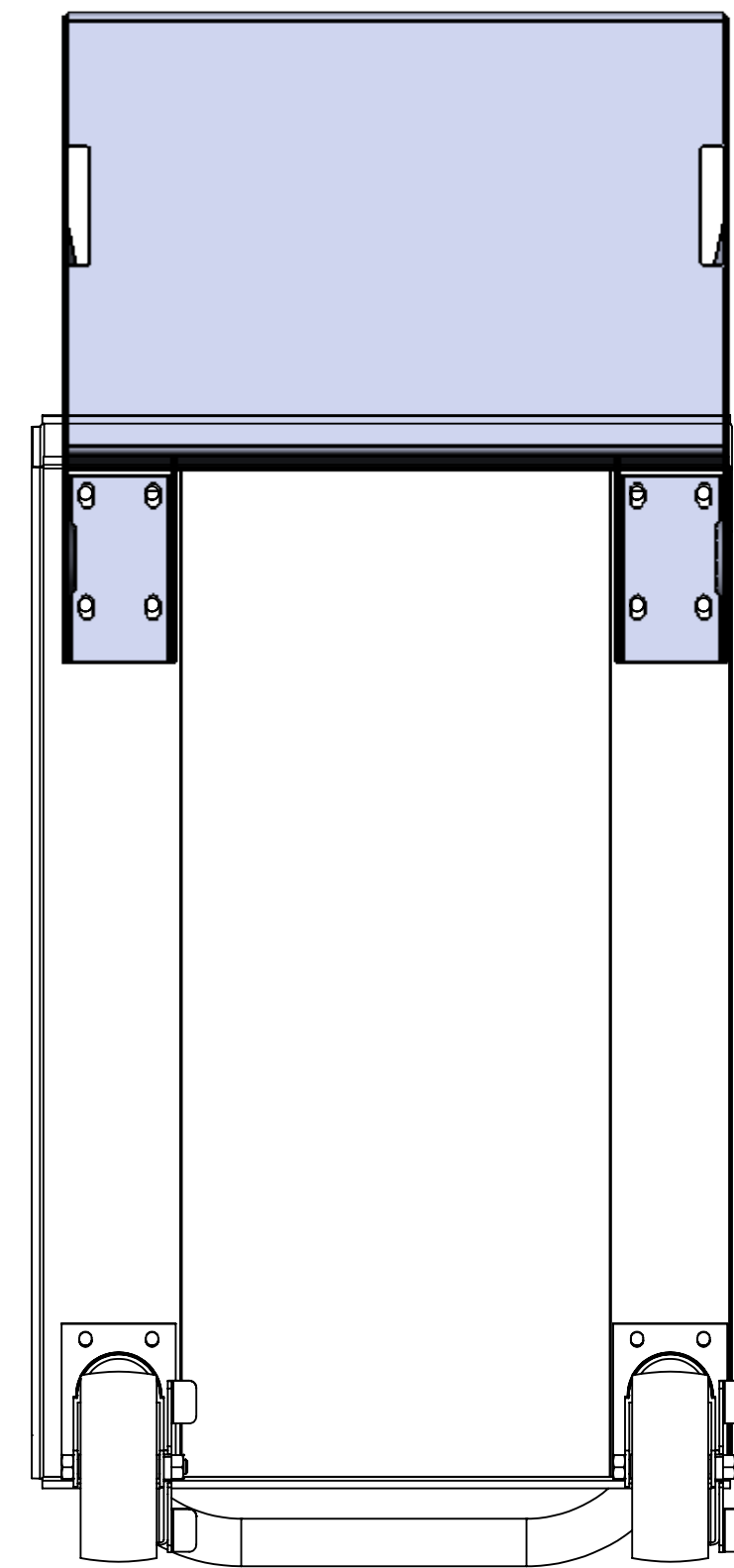
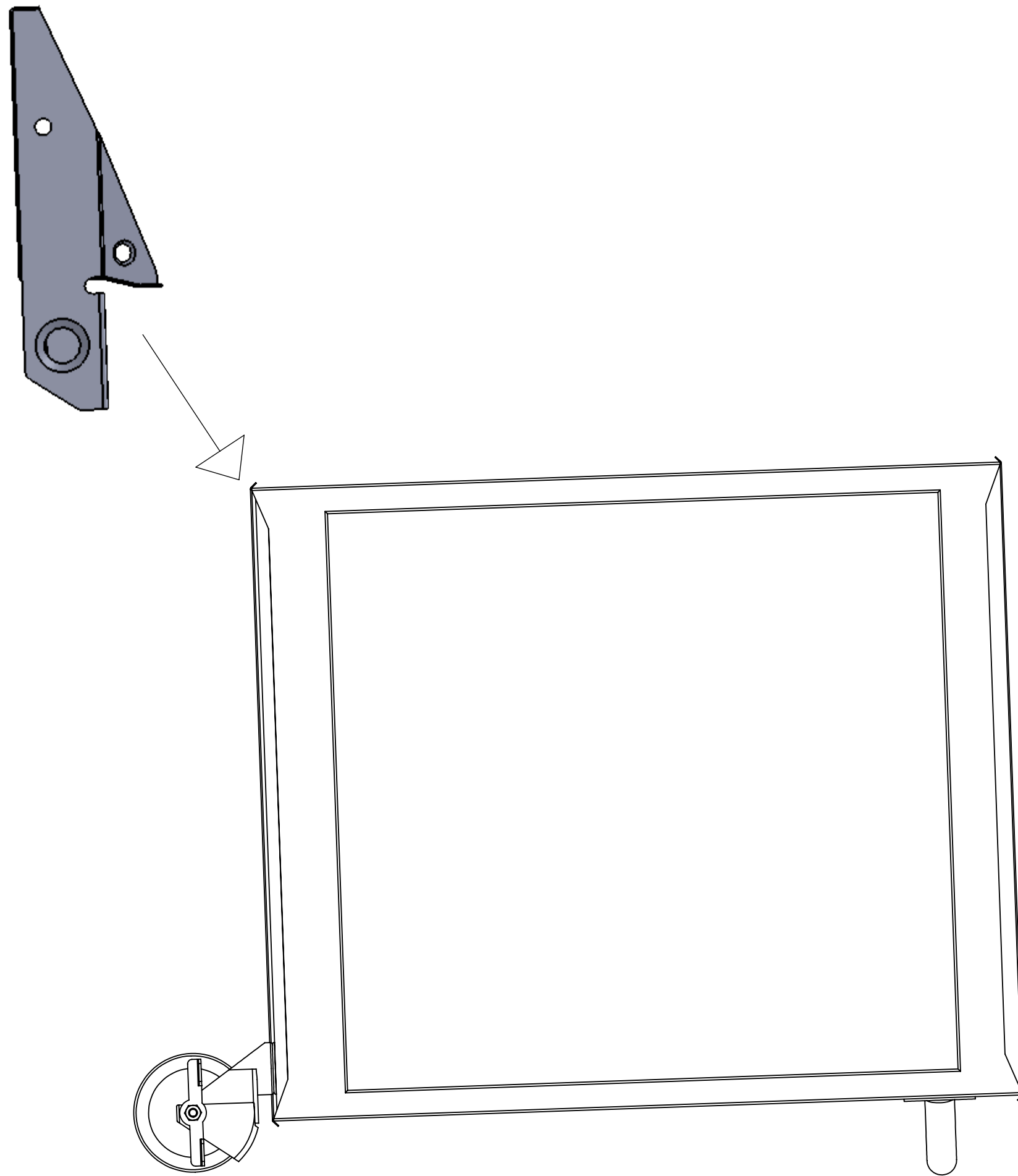
Make sure your toolbox is empty and that the drawers are either closed and locked or removed from the cabinet. (Removing the drawers is recommended in order to see possible obstructions and to clean the shavings from drilling. For instructions on how to remove and reinstall the drawers please consult your toolbox owner's manual.)

Carefully flip the toolbox on it's side so that the swivel casters are on the bottom and the handle is resting on the ground. Use a blanket, pad, or cardboard to protect the box from getting damaged. The fixed casters should now be towards the top. Remove the fixed casters and retain the factory hardware.



Step 4: Test Fitting

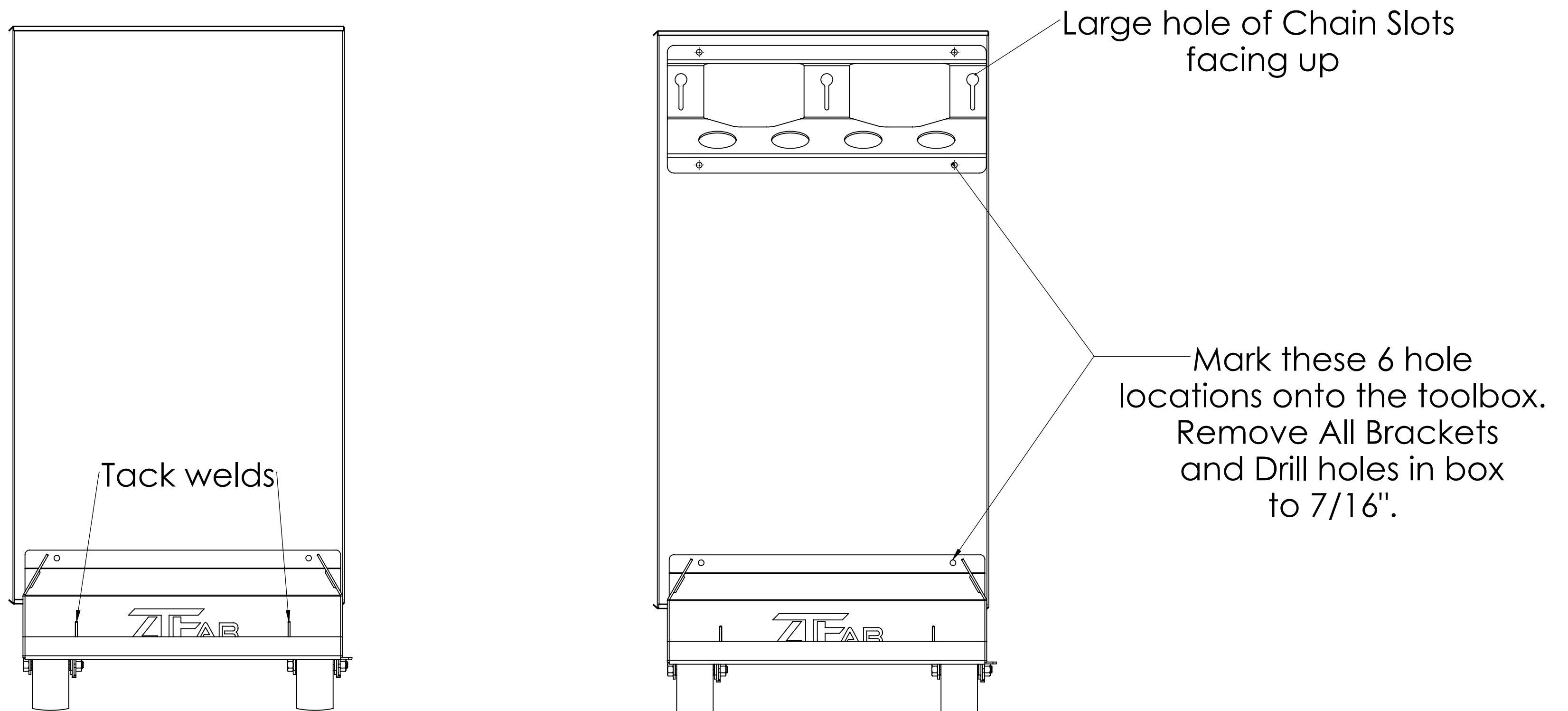
With both Side Plates fit and tack welded to the Bottle Base, place the assembly on the toolbox for test fitting. Use your factory caster hardware to secure the Bottle Bracket to the box. Make any necessary adjustments to achieve a proper fit. If your toolbox is new, please be sure to use all factory hardware as directed by the manufacturer. This may include stiffener brackets designed to mount between the casters and the toolbox. For Husky toolboxes with 5" casters, test fit the Bottle Base with the included Spacer Plates sandwiched between the bottom of the box and the Bottle Base.



Step 5: Final Tack Welds and Drilling

With the Bottle Base attached to the toolbox caster mounts, place 2 final tack welds on the tabs of the Side Plates that fit into the slots of the Bottle Base. Now Place your Bottle Bracket on the toolbox. Make sure the large hole on the chain slots is facing up. The height of the bracket will be determined by the size of your gas bottles. Make sure the bracket is centered with the Bottle Base and square to the box. (PLEASE NOTE: the factory caster mounts are offset front to back. Due to this, the Bottle Base will not be centered on the box.)

Now mark the location of the bolt holes from the Bottle Bracket and Bottle Base on to the toolbox. TIP: Put a piece of masking tape on the toolbox first to make your marks clearer. Remove the Bottle Bracket and Bottle Base Assembly and center punch your marks, then drill out to 7/16". If your toolbox has internal supports be sure not to drill through them, only drill through the outside sheet metal.

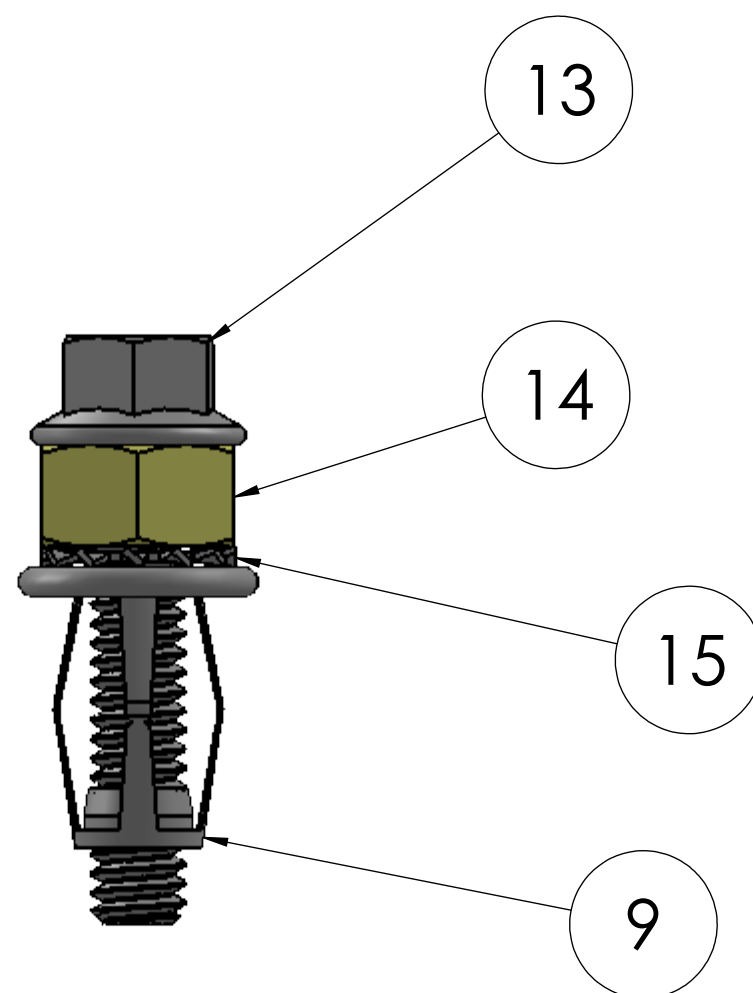


Step 6: Jack Nut Installation

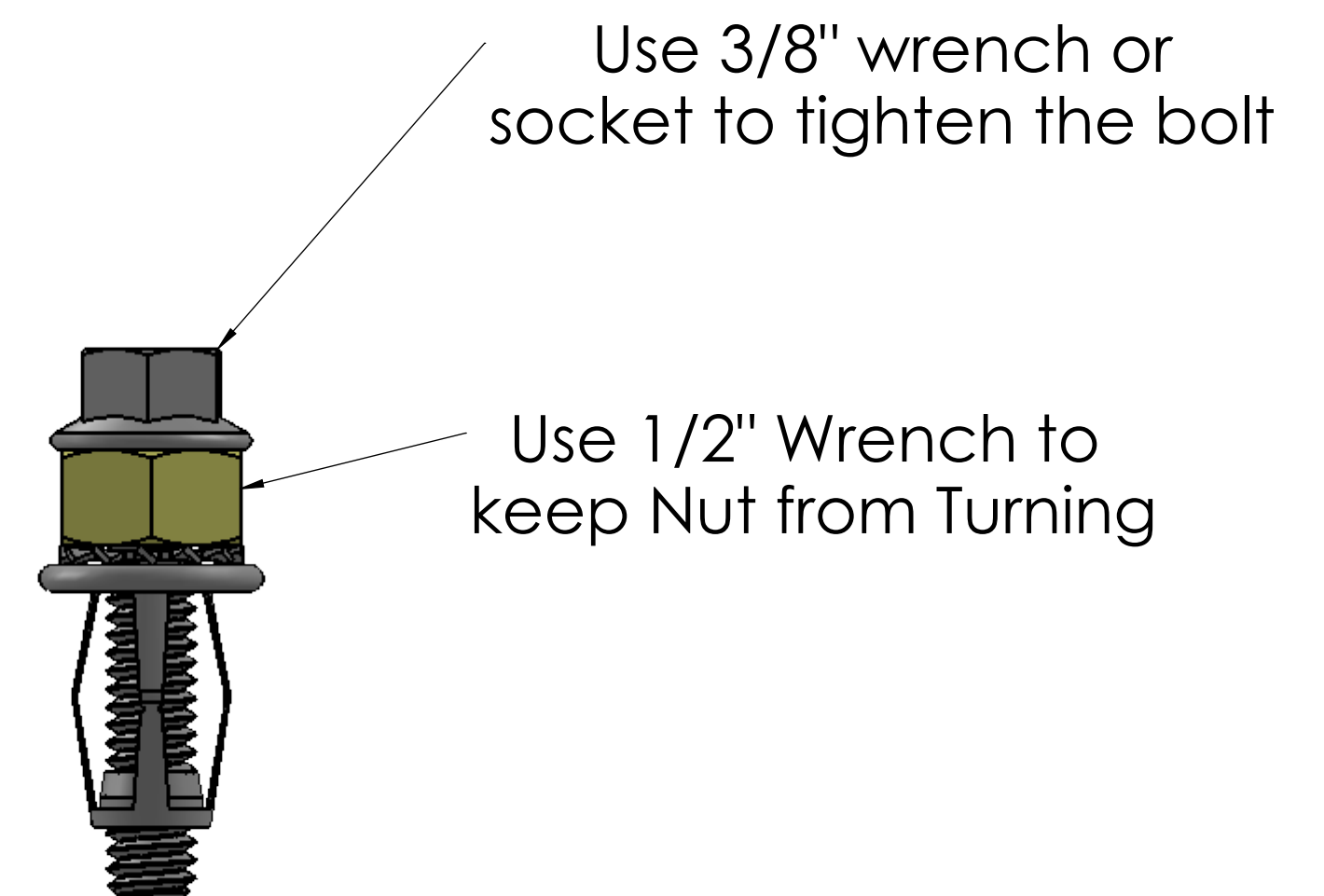
Your kit includes all the necessary hardware to install the Jack Nuts into your toolbox. Locate the Jack Nut installation tool that came in the hardware bag. The tool comes preloaded with an extra Jack Nut. We have included the extra Jack Nut in the kit for you in case you need it while assembling your cart.

You will need a 1/2" Open-End wrench and a 3/8" wrench or socket. Insert the Jack Nut into one of the 7/16" holes you drilled (It may be a little tight due to the flare of the Jack Nut. DO NOT collapse the Jack Nut. Use a round file to enlarge the hole if necessary). Using the 1/2" Open-end wrench, hold the 5/16" Nut (Item #14) to keep it from turning. Use your 3/8" wrench or socket to tighten the 1/4"-20 bolt (Item #13). The lock washer (Item #15) will tighten against the Jack Nut and allow the bolt draw the Jack nut up against the sheet metal of the toolbox as long as the 5/16" nut doesn't turn.

Once the Jack Nut has been drawn up to the sheet metal, loosen the 1/4"-20 bolt and remove the 5/16" nut and washer. Re-install them onto another Jack Nut and repeat the installation process for all 6 holes.

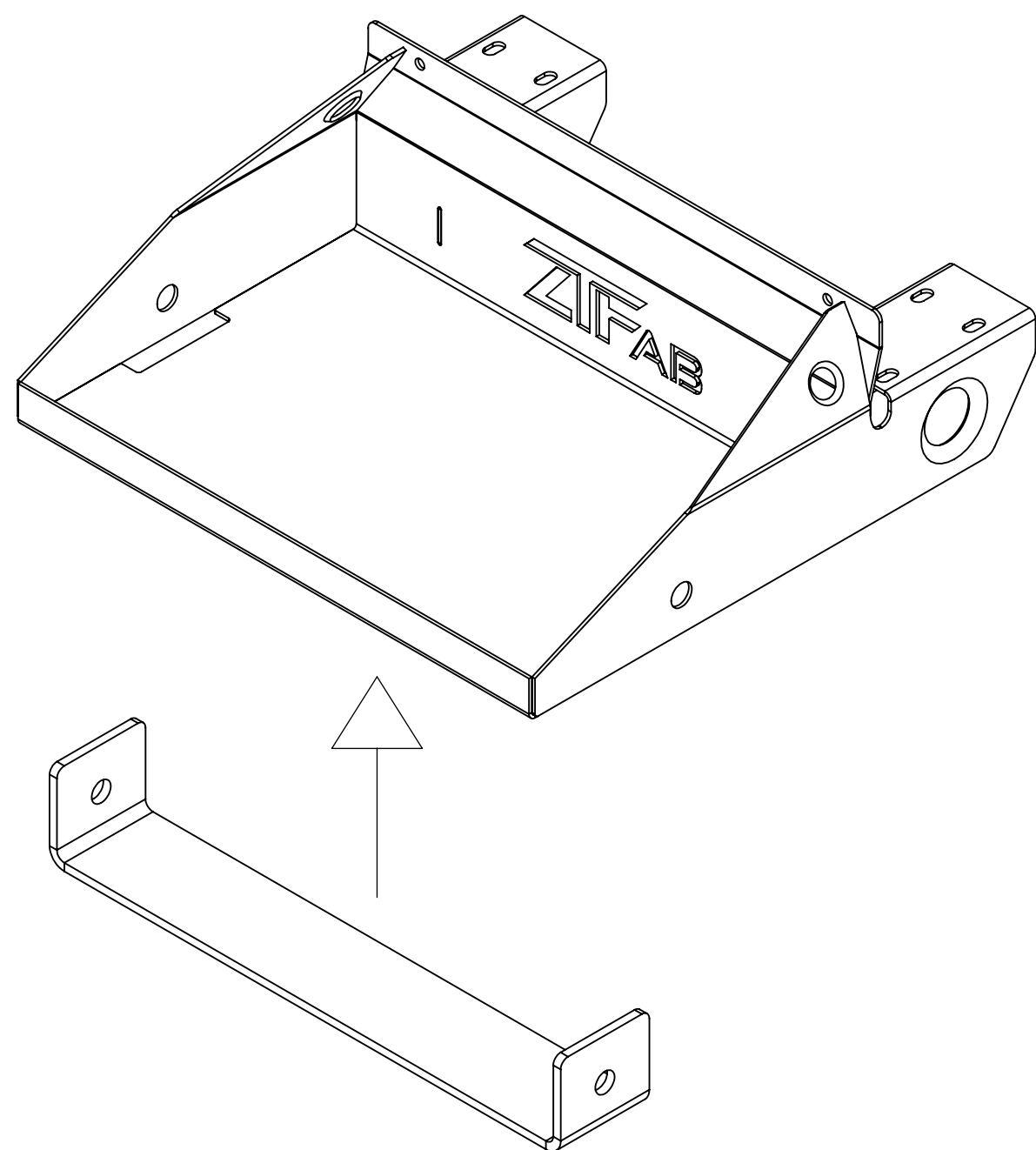


Jack Nut Installation Tool

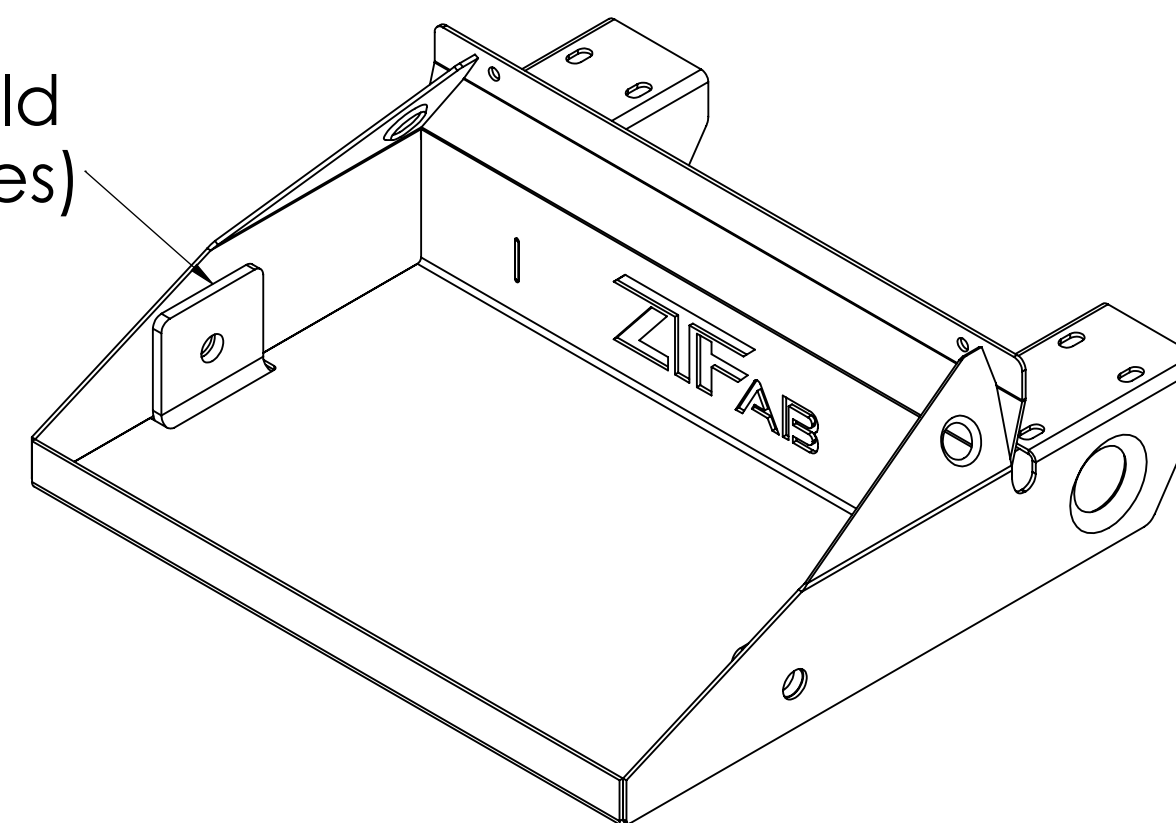


Step 7: Axle Bracket

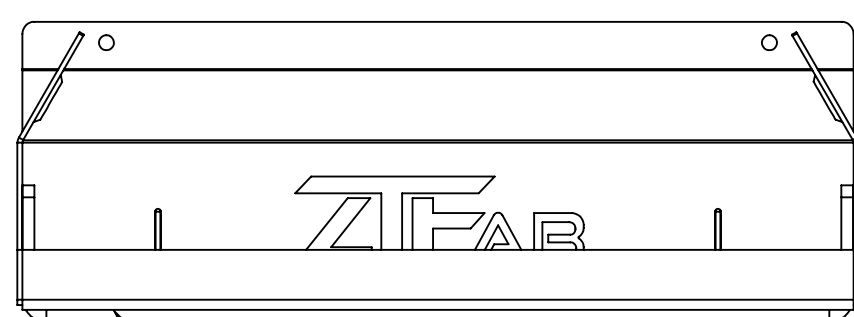
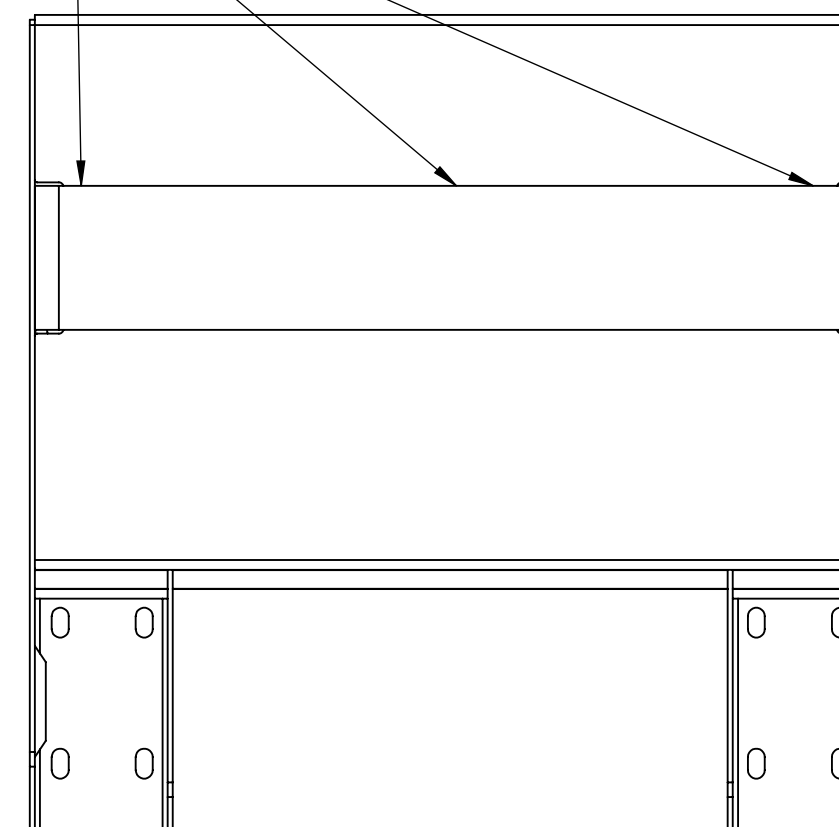
Locate the Axle Bracket that came with the kit. Place the axle bracket into the Bottle Base Assembly from the bottom. Line up the holes in the Axle Bracket with the holes in the Side Plates. The Axle Bracket should sit flush with the bottom of the Bottle Base. Tack weld the Axle Bracket to the Side Plates and the Bottle Base.



Tack Weld
(Both Sides)



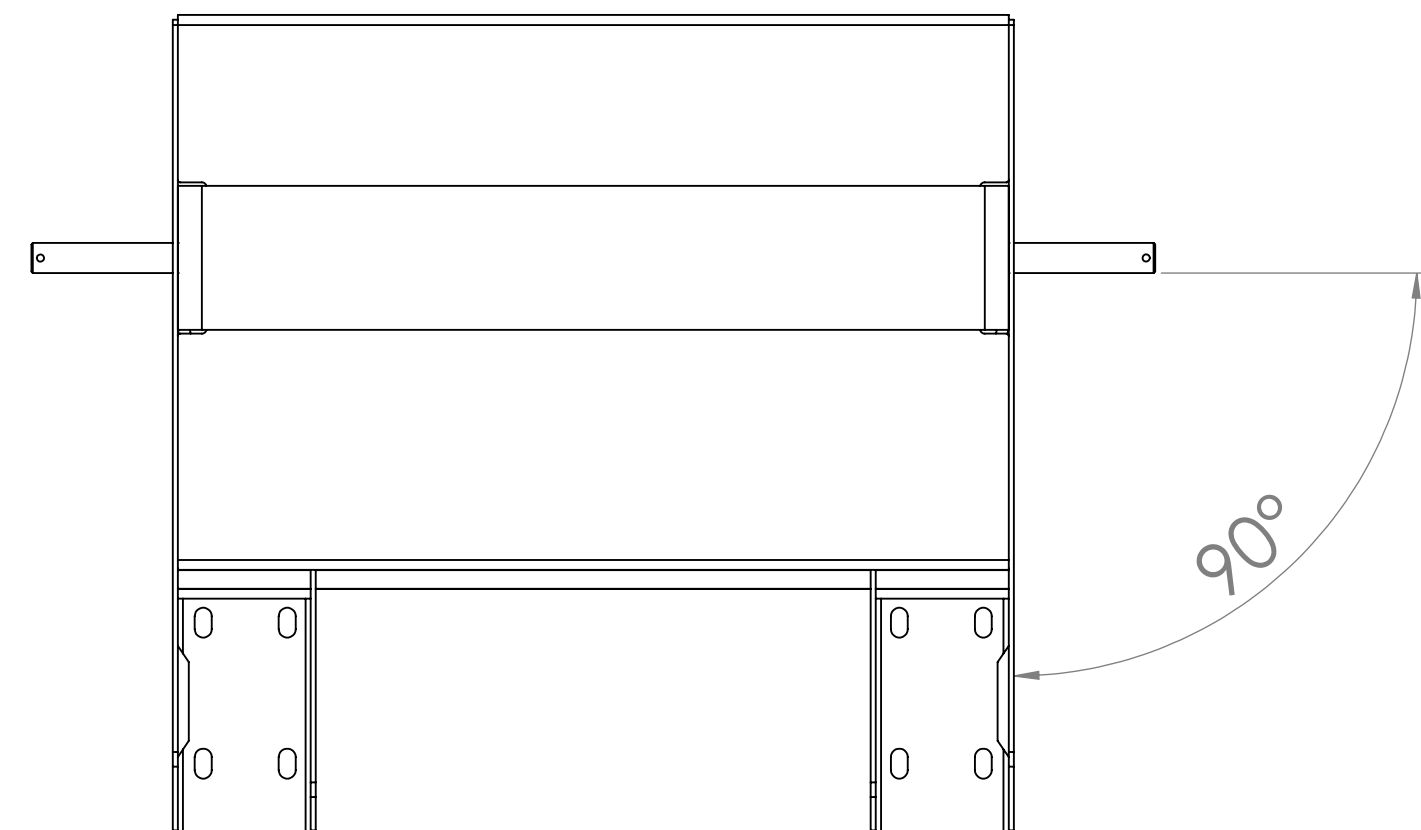
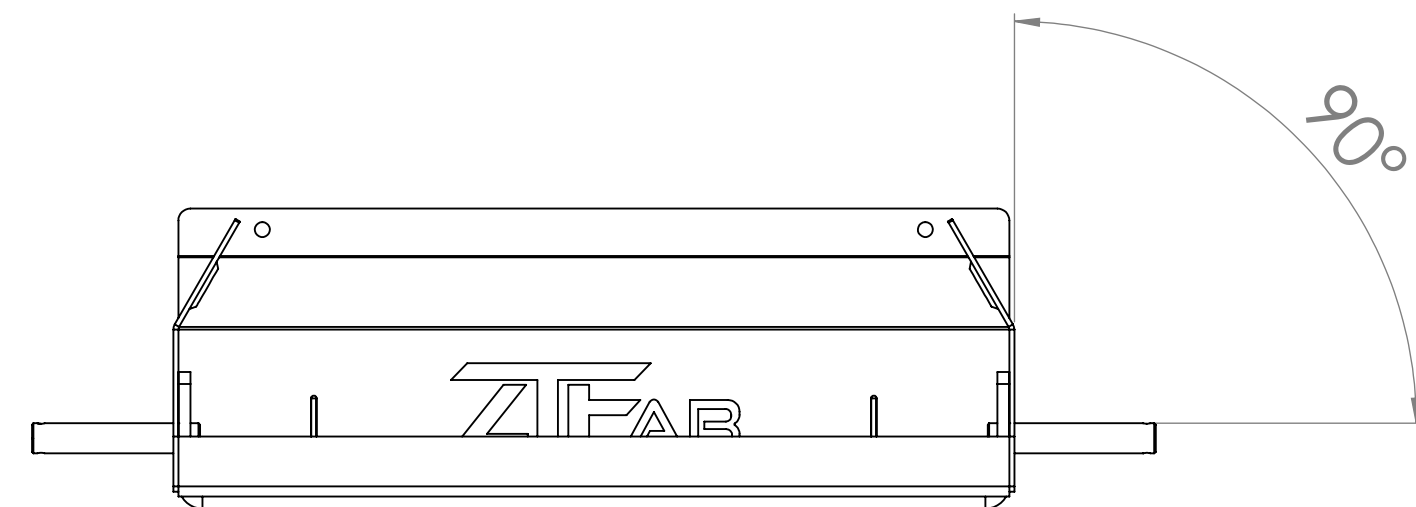
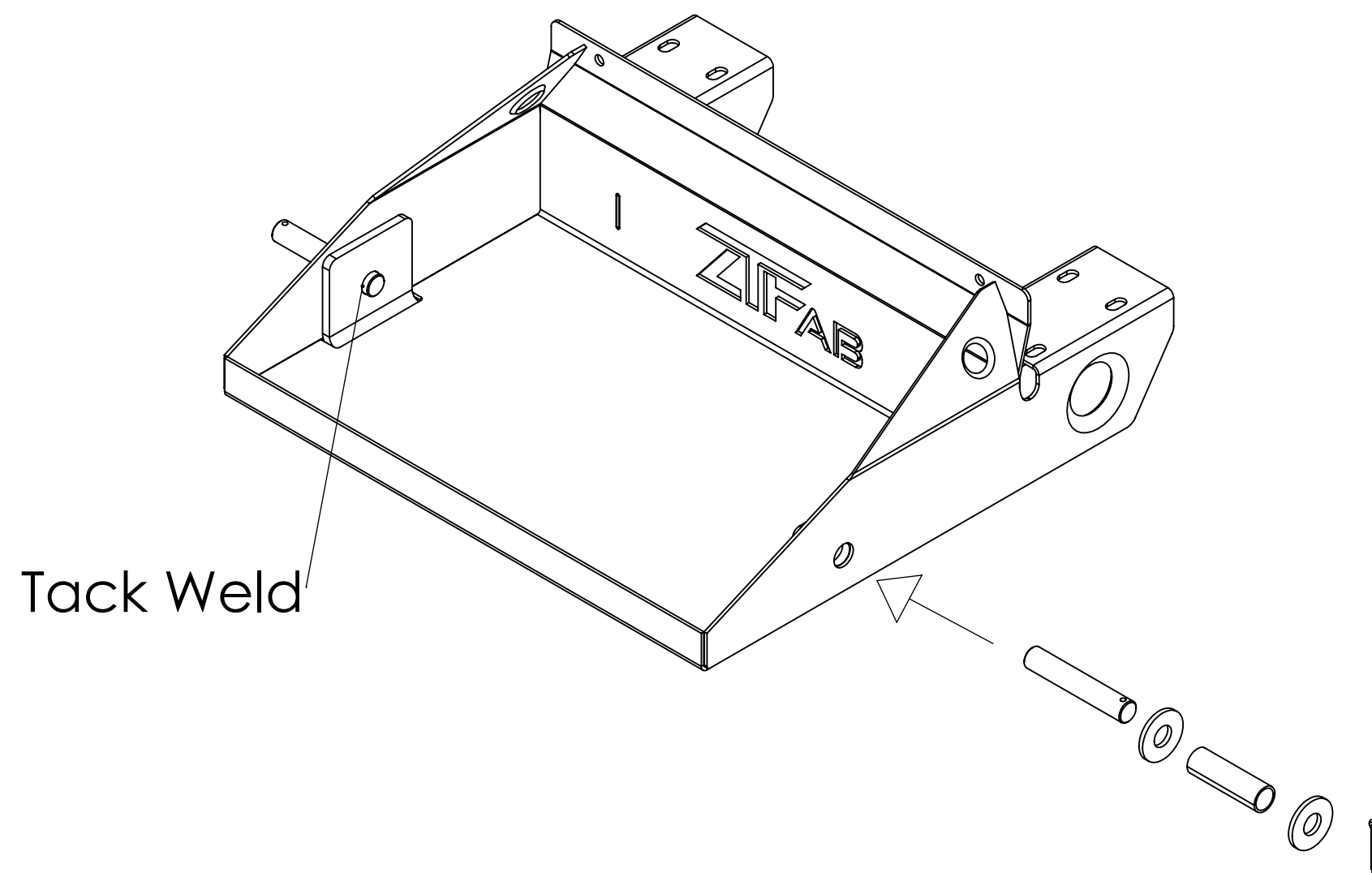
Tack Weld
(Both Sides)



Axle Bracket Flush to Bottle Base

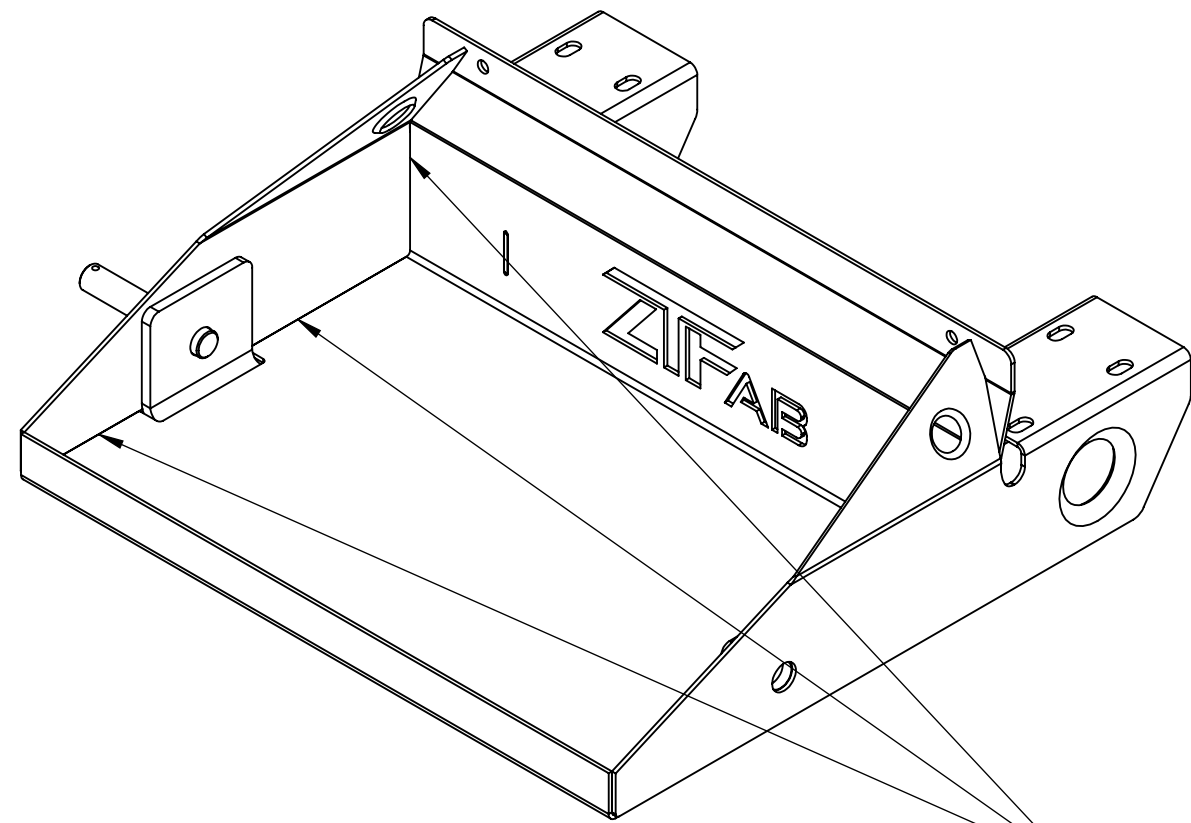
Step 8: Axle Shafts

Locate the Axle Shafts and wheels that came with the kit. Cut the Zip ties on the wheels and remove the axle bushing from the center. Next, locate the 4 large washers and cotter pins that came in the kit. Insert the axle shaft into the side plate and axle bracket. Install a washer, then the bushing, then another washer. Place the cotter pin in the drilled hole of the axle shaft to keep everything in place. Use a clamp or hand pressure to push the axle in against the washers and bushing. Tack weld the axle to the axle bracket. Make sure the Axle is 90 deg to the side plate in both directions.

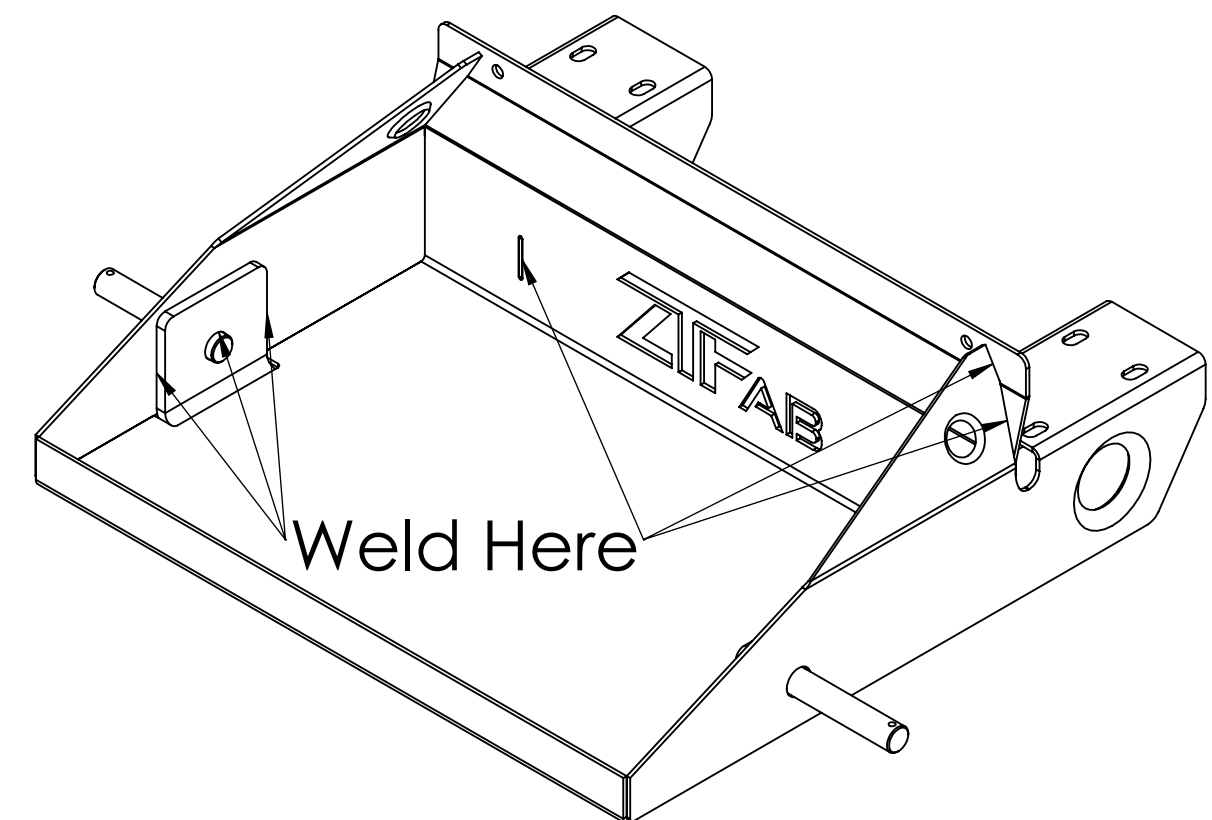


Step 9: Final Welding

Now the final welding can be completed. If you are not comfortable with welding the outside "Open Corner" joint you can weld the kit on the inside as a fillet weld. Weld both Left and Right side plates to the Bottle Base and the Axle Bracket to the Bottle Base and Side Plates. Weld the Axle shaft on the INSIDE only. DO NOT put any weld on the outside of the axle shafts or your wheels won't fit.

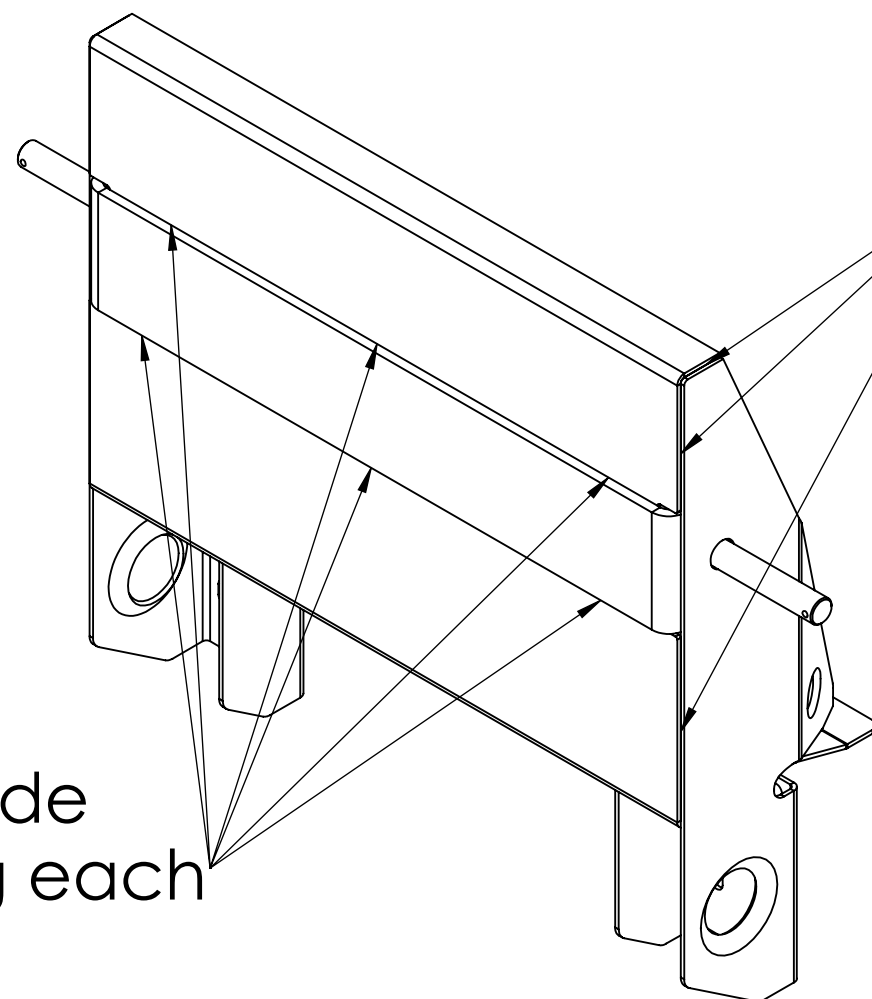


Weld Here (Option 1)
along the entire edge

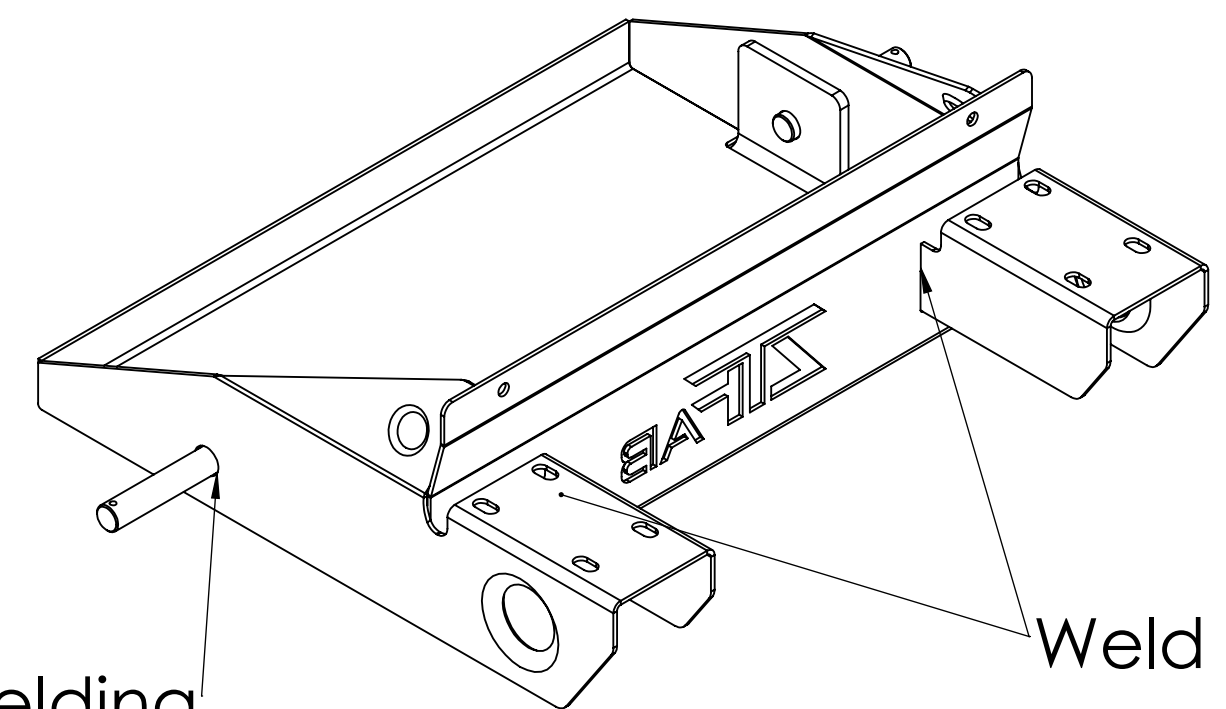


OR

Weld Here (Option 2)
along the entire edge



Weld Here
3 welds per side
about 2" long each



No welding

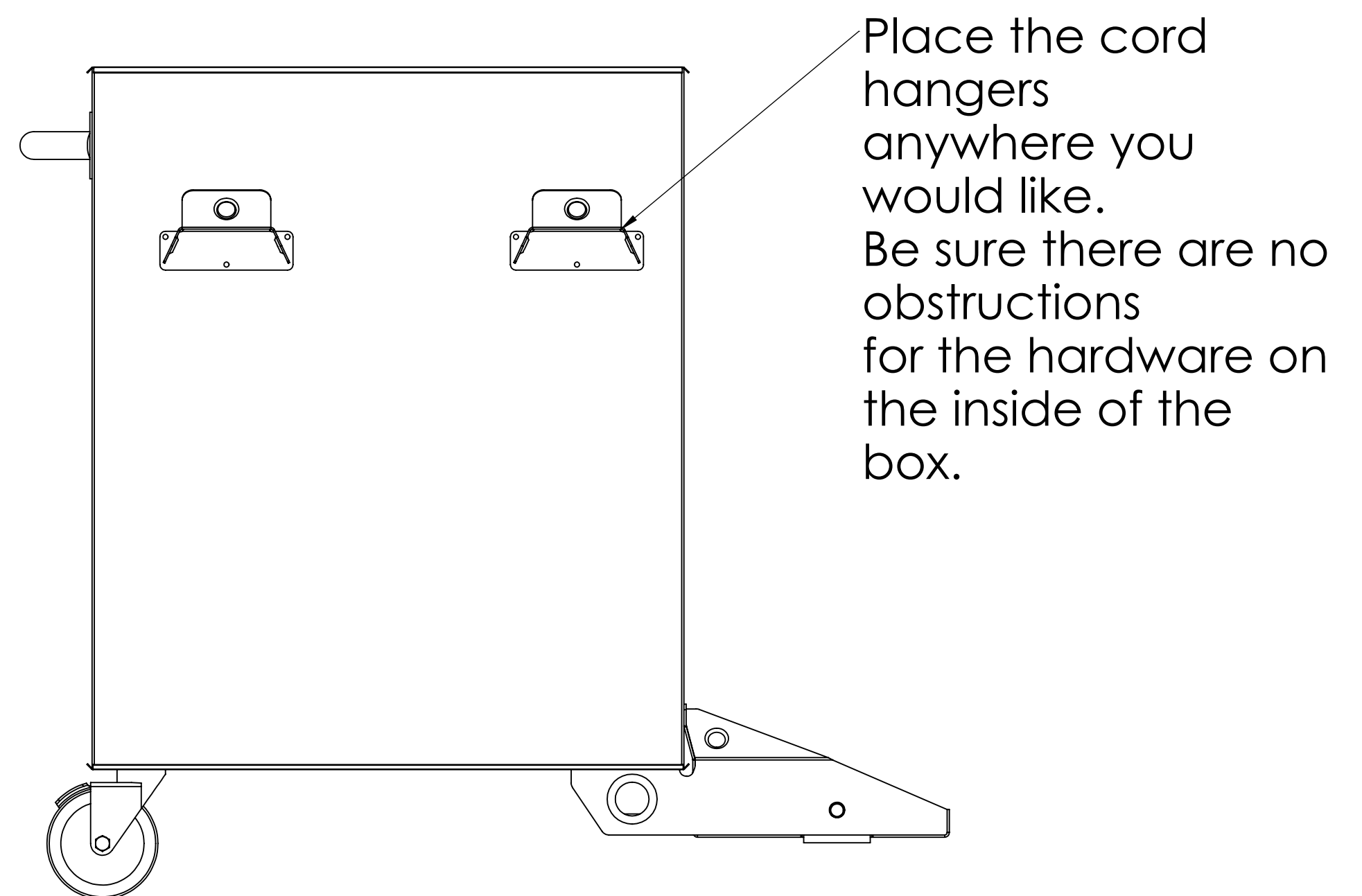
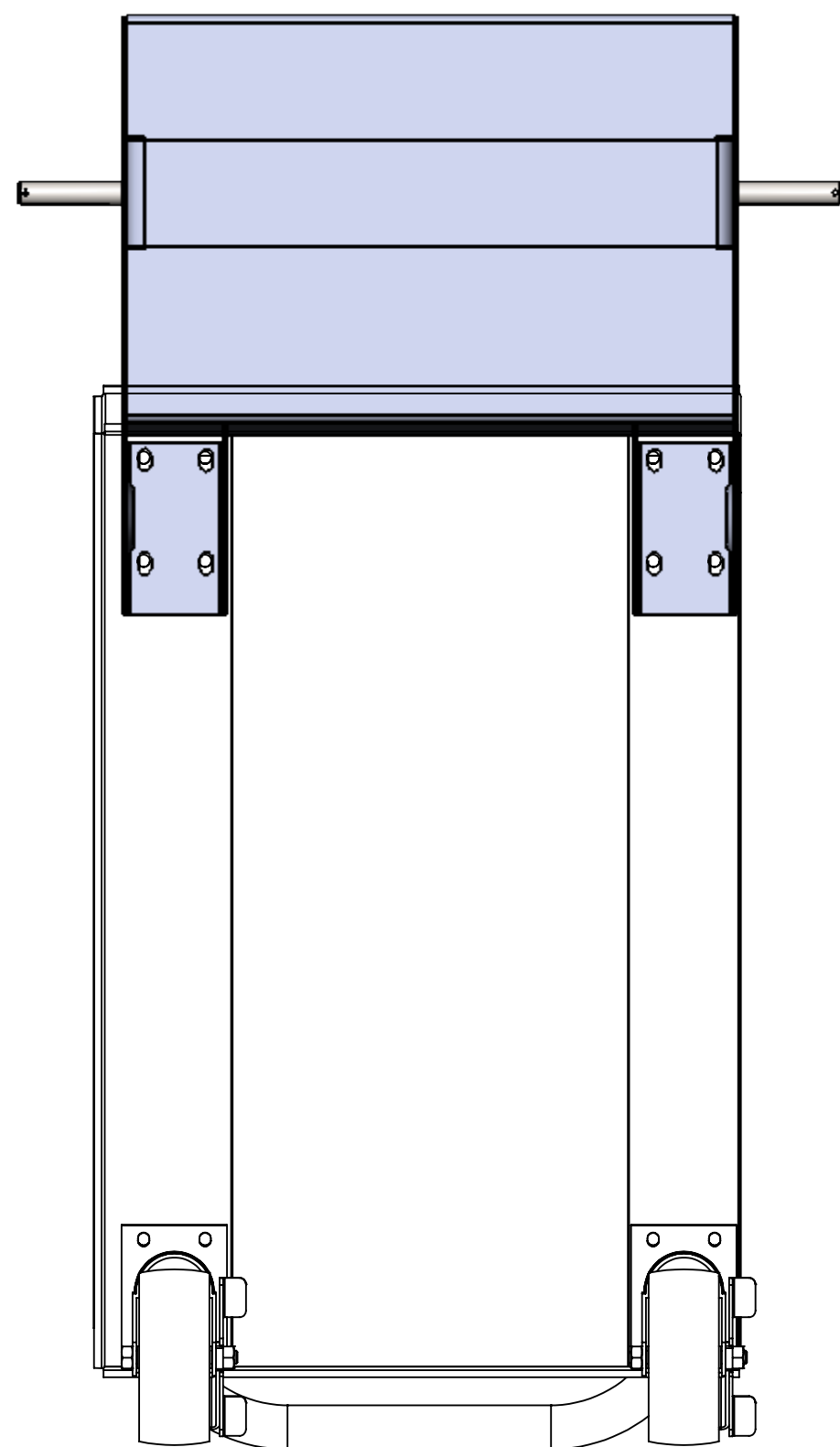
Weld Here

Step 10: Final Fitting and Cord Hangers

It is highly recommended that you do a final fit check of your cart kit after welding. Welding can and will distort material. Place the welded assembly back on the toolbox after it has cooled down. Ensure that all holes still line up and that the hardware fits.

Locate the Cord Hangers and #10 Sheet metal screws that came in the kit. Find a suitable location for the cord hangers based on your preference. Ensure that there are no obstructions on the inside of the toolbox for the area where you want to place them. Once satisfied, use the #10 sheet metal screws to secure the cord hangers to the cart. Be sure not to overtighten the screws as it will strip the sheet metal.

After final fitting you can paint or powdercoat the raw steel. If you choose not to the kit will begin to rust.



Place the cord hangers anywhere you would like. Be sure there are no obstructions for the hardware on the inside of the box.

Step 11: Final Assembly

You can now install the kit for the last time. Be sure to follow your toolbox manufacturers recommended torque values for the caster hardware. Also, follow their periodic maintenance guide to checking fasteners for correct torque.

Place the Bottle Base Assembly on the toolbox using the factory caster hardware and (2) of the supplied 1/4"20-x1" serrated flanged head bolts.

For HUSKY brand toolboxes the included spacers will be used as following; For models with 4.5" wheels, place the spacers under your front, swivel casters. For models with 5" wheels, place the spacers under the Bottle Base Assembly. This will ensure the cart is level after installation. Tighten all hardware.

Place a large washer on an axle shaft, then the wheel assembly, then another large washer. Retain the wheel with the supplied cotter pin. Be sure to bend the legs of the cotter pin over to make sure it stays in place. Repeat for the other side.

You can now carefully flip the toolbox back on to it's wheels.

Place the bottle Bracket on the box using the supplied 1/4"-20x1" Serrated Flange head bolts. Screw them into the previously installed Jack Nuts and tighten bolts. Install all cord hangers with the supplied #10 sheet metal screws being careful not to overtighten them or they will strip.

Clean out any metal shavings from the inside of the toolbox then re-install the drawers, following your toolbox owner's manual instructions.

Place your welder and gas bottles on the cart. Use the supplied chains to secure your bottles to the bottle bracket.

**Thank you for purchasing a ZTFab product!! We hope you enjoy it.
Should you have any problems or questions you can reach us at sales@all-a-cart.com
or on social media @ZTFab on Instagram and Facebook.**