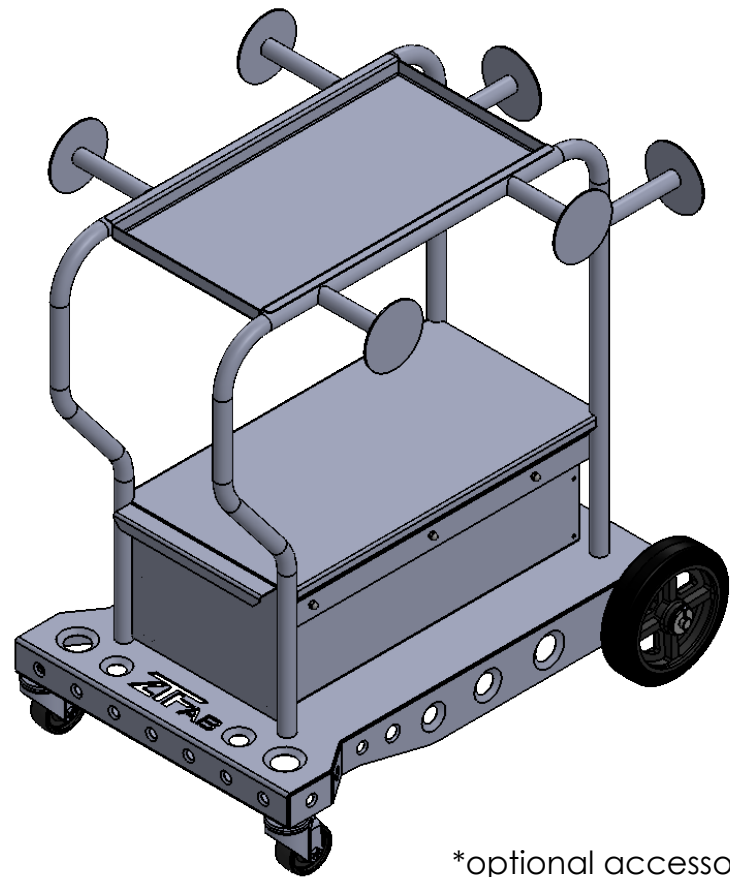


Plasma Cart Instructions.

Please read these instructions thoroughly before welding your cart. If you need further instruction you can download the 3D models by visiting the "Instructions and 3D models" page on All-a-cart.com

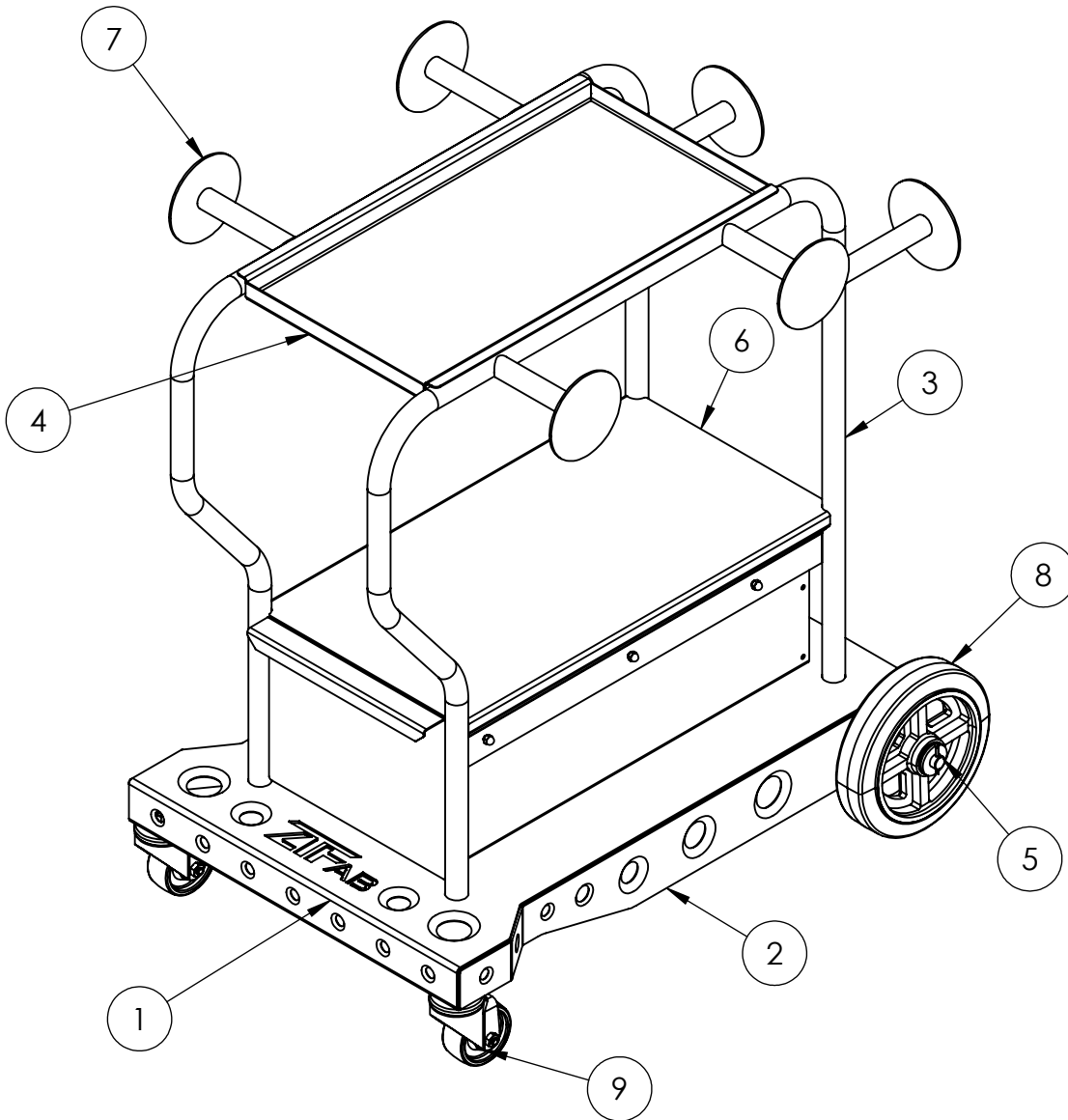
Proper PPE is recommended at all times. Safety glasses, gloves, hearing protection, and/or a welding helmet when necessary. Sheet metal edges may be sharp. Handle with caution.



*optional accessories shown

WC-HYP45X

Updated 5/19

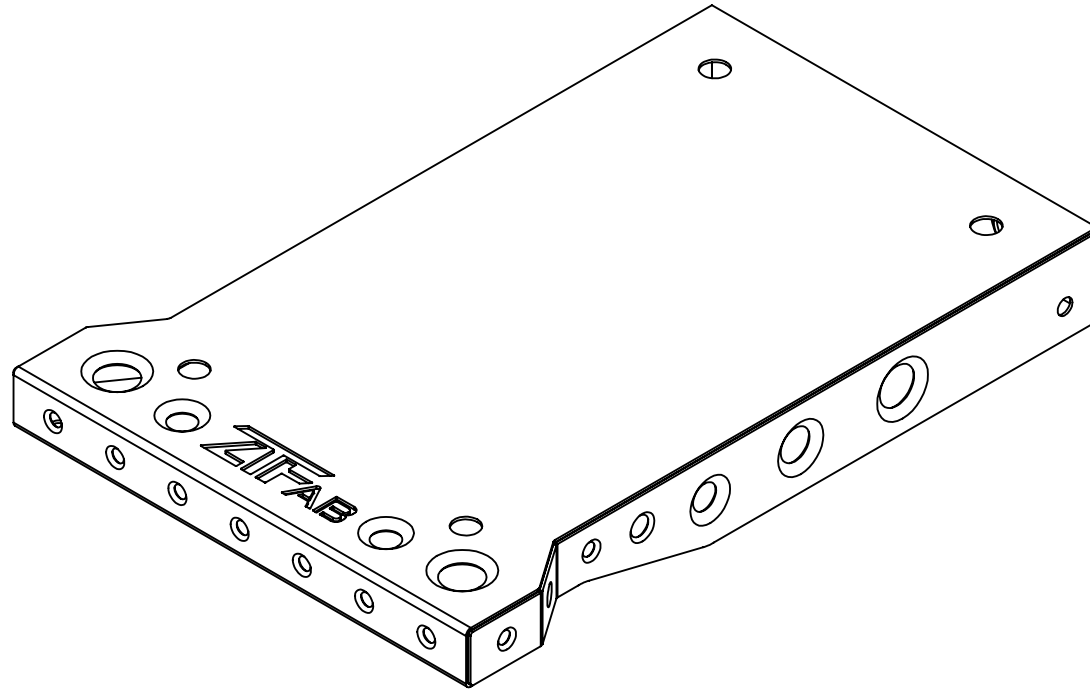


ITEM NO.	PART NUMBER	Default/Standard/Default/ QTY.
1	Base	1
2	Side Plates	2
3	Handle Tubes	2
4	Storage Tray	1
5	Axle Shaft	1
6	Drawer Kit	1
7	Cord Hangers	6
8	Wheels	2
9	Casters	2

NOTE: For optimal results it is recommended that all areas requiring welding be cleaned by lightly sanding with sand paper or scotch brite pads. Clean, shiny metal welds the best.

Step 1: Base Sides

Position Side plates onto cart base.
A square or 90* corner magnets will help in lining up the edges.

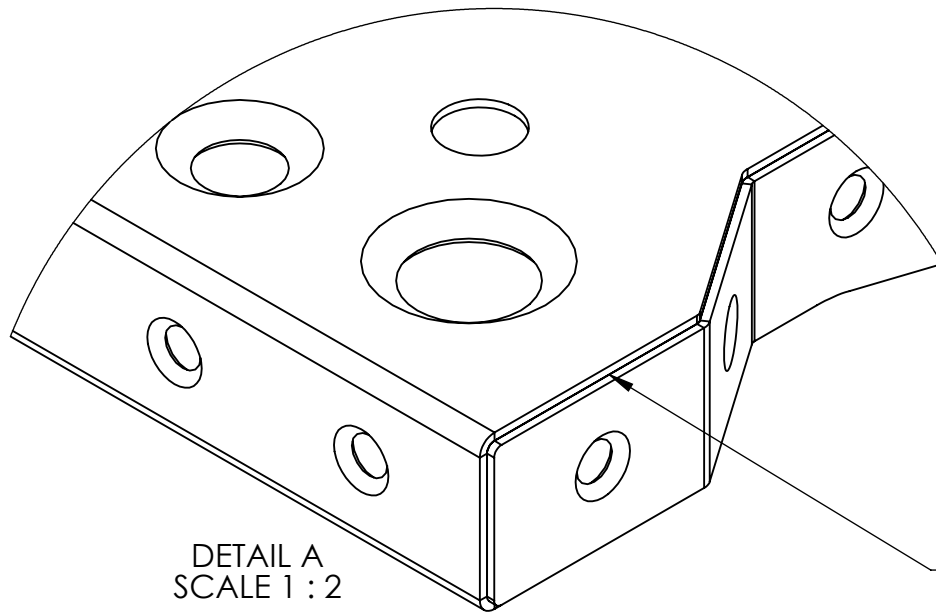
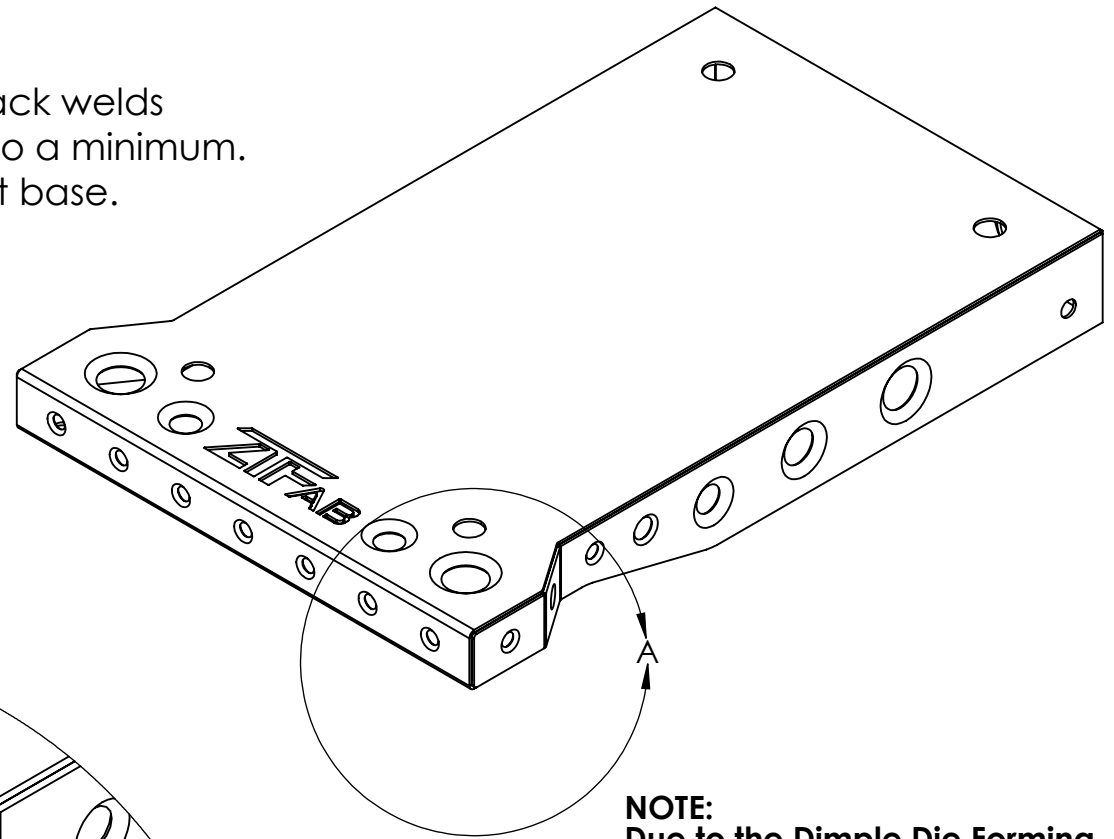


Note:

Lightly Sand all edges that need to be welded for best quality. Being careful not to remove excessive material.

Step 1A:

Tack weld sides to base incrementally to ensure proper corner fit-up. Position tack welds every 2-3 inches to help keep distortion to a minimum. Sides should be 90° to the top of the cart base.



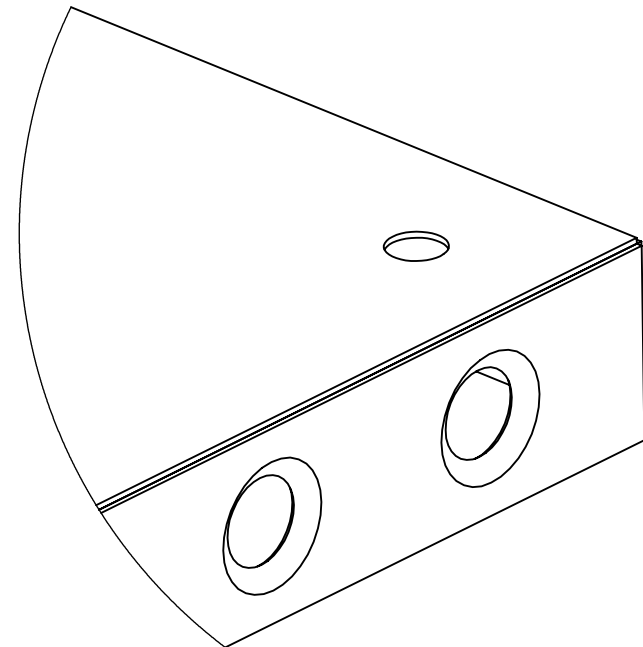
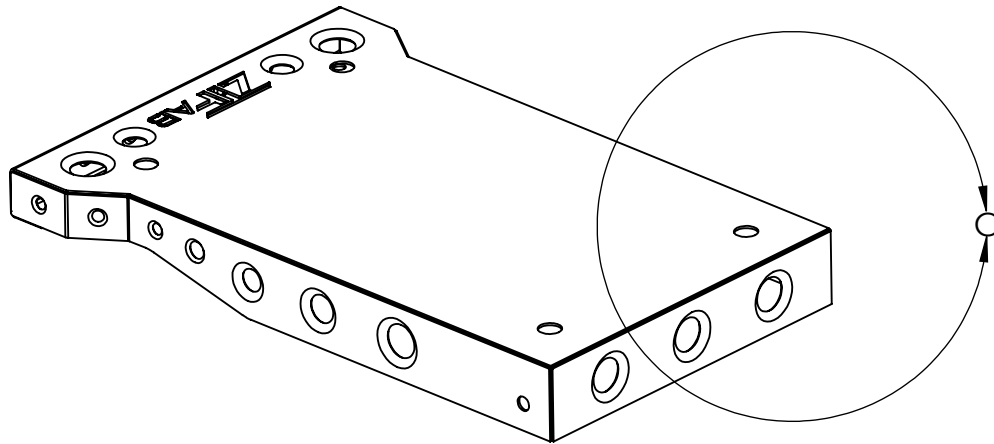
DETAIL A
SCALE 1 : 2

NOTE:
Due to the Dimple Die Forming of the side panels they may be slightly curved. It may be easiest to start with the front corner, position and tack weld it first, then use a large clamp or clamps and work your way to the back, aligning, fitting, and tacking along the way.

Fit-up should be an "Open Corner" joint.

Step 2: Back Plate

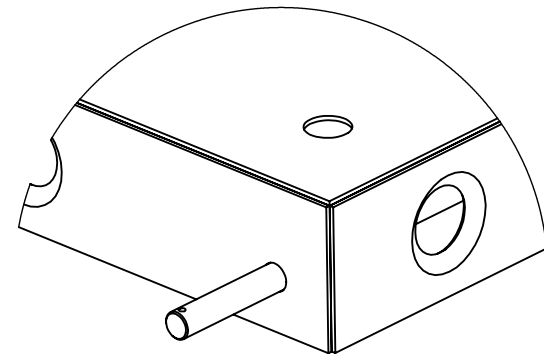
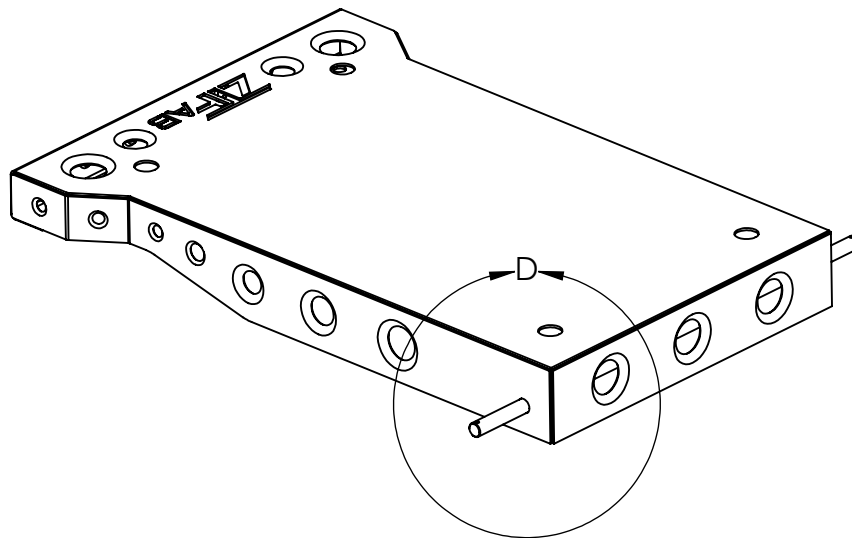
Fit the Back Plate to the sides and the cart base.
Tack weld once properly fit-up.



DETAIL C
SCALE 1 : 3

Step 3: Axle Shaft

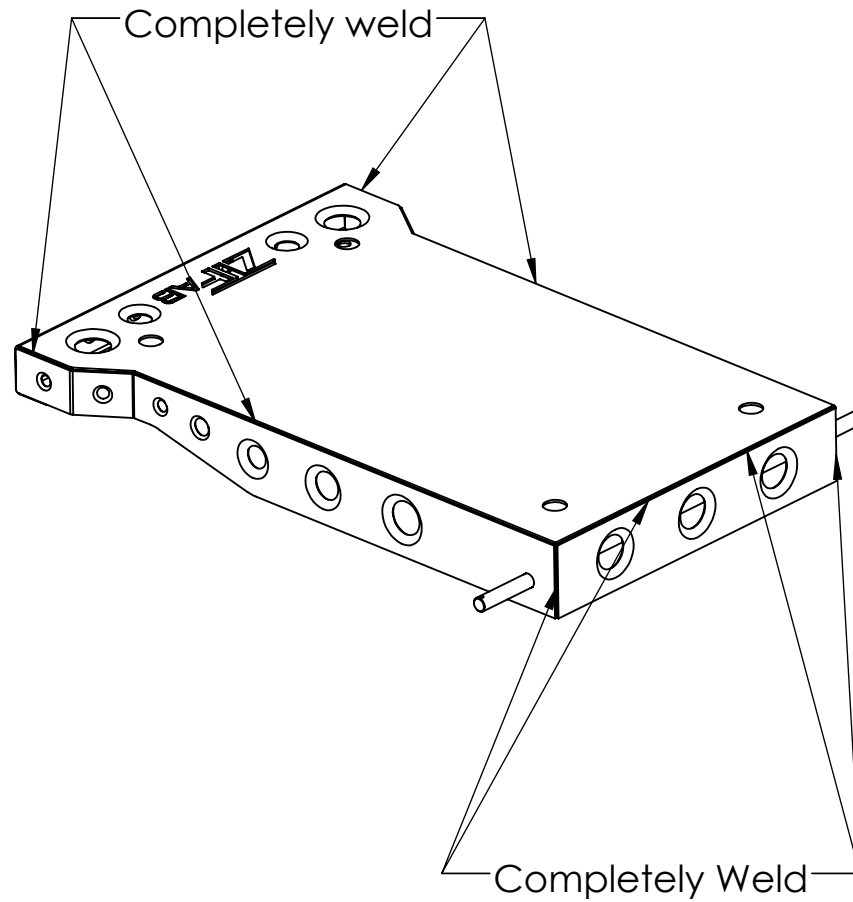
Position the axle shaft into the holes on the side plates and tack weld into place.
DO NOT place any welds on the outside of the axle shaft to the side plates. Only weld from the inside.
TIP: Install the spacer bushings from the wheels with the 4 washers and the cotter pins to help center the axle and make sure there is adequate room for the wheels.



DETAIL D
SCALE 1 : 4

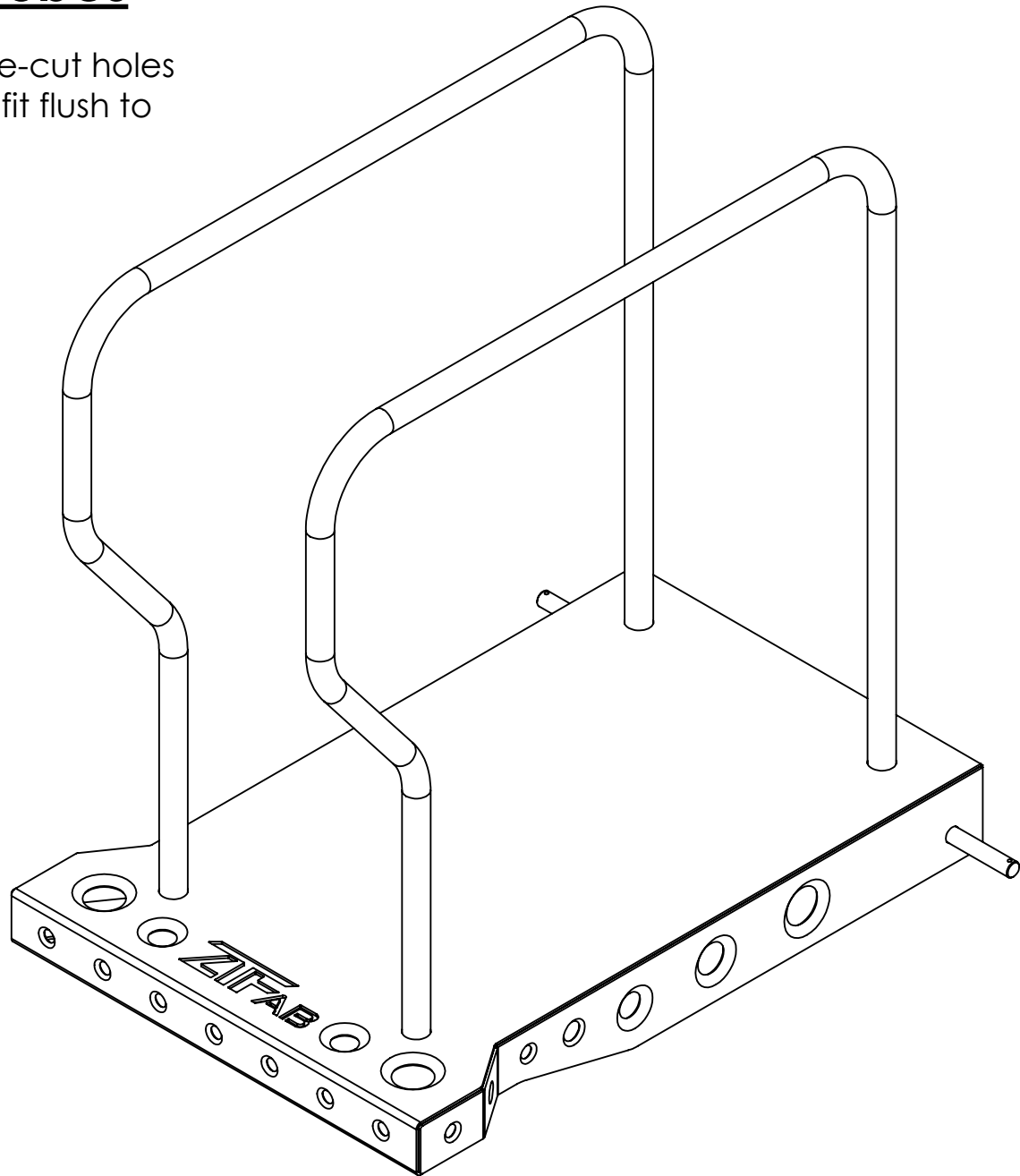
Step 4: Welding the Base

Weld the parts of the base together using your preferred method of welding. Alternate your welds to keep distortion to a minimum.



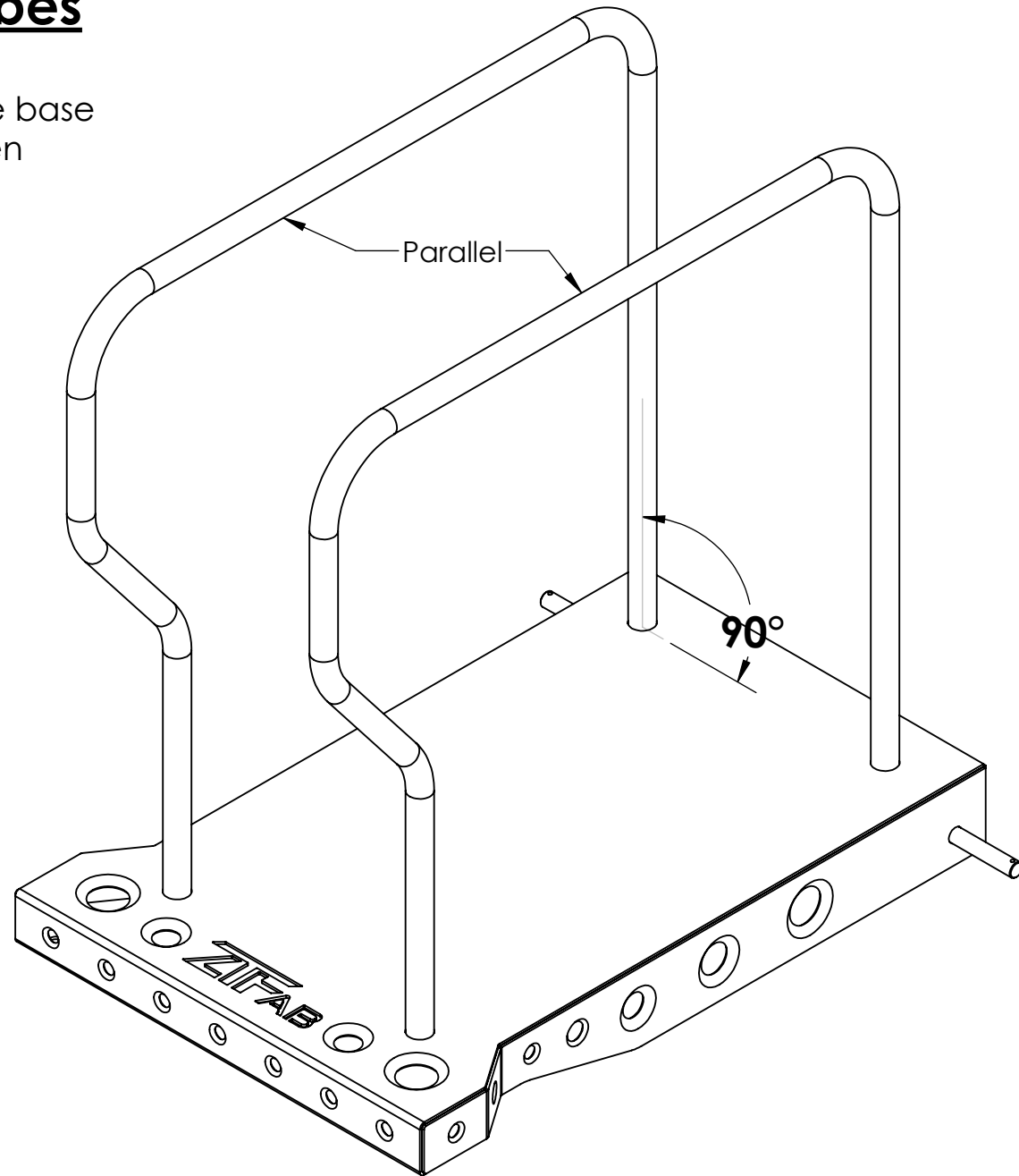
Step 5: Positioning Tubes

Insert Handle tubes into the pre-cut holes in the cart base. Tubes should fit flush to the bottom of the plate.



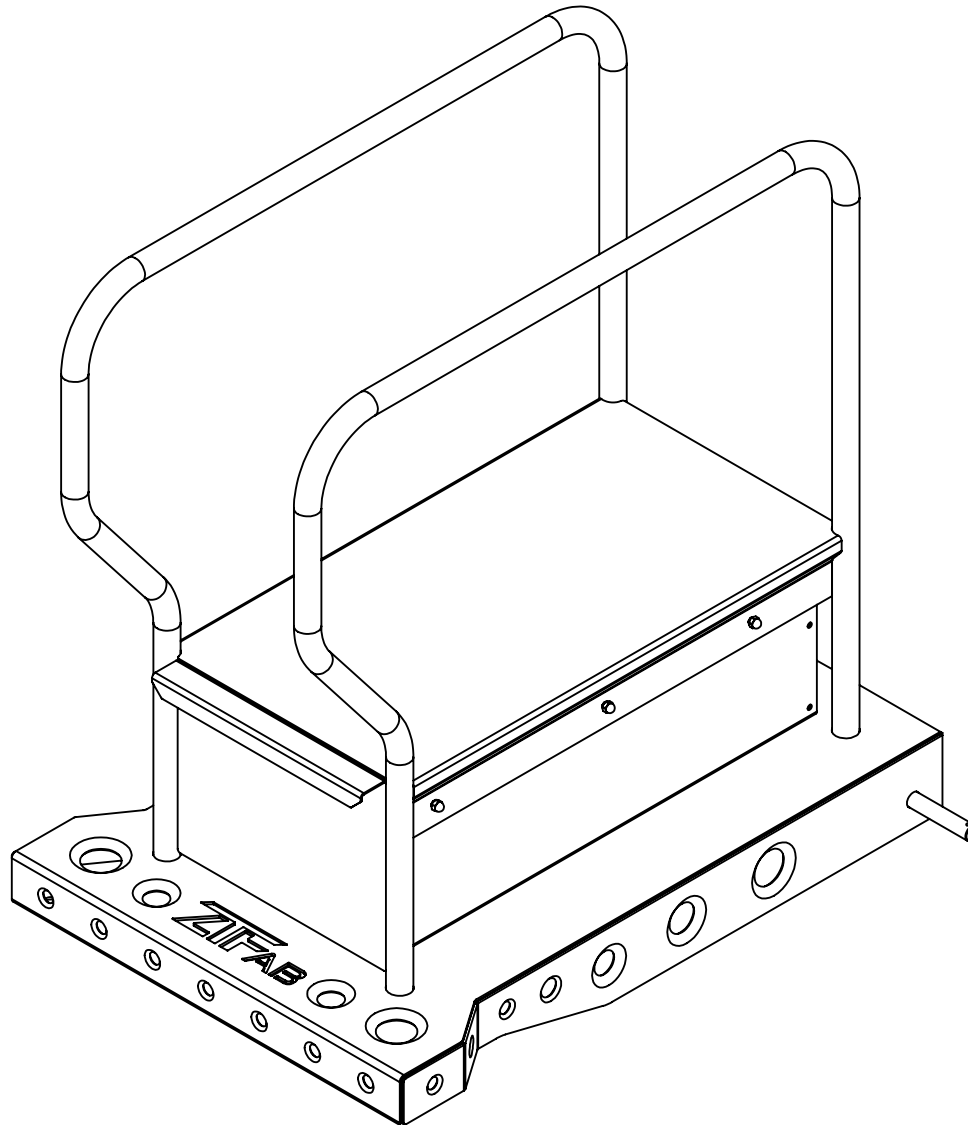
Step 5A: Tacking Tubes

Ensure that tubes are 90° to the base and parallel to each other. Then tack weld into position.



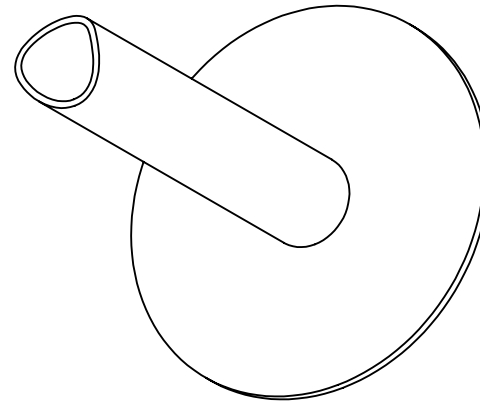
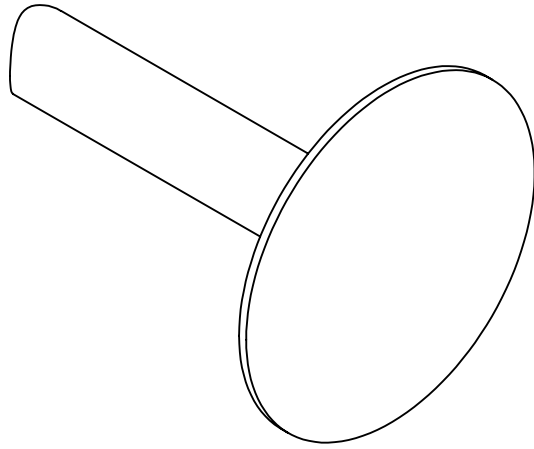
Step 6: Drawer Kit

Please see the separate Drawer Kit instructions



Step 7: Cord and Accessory hangers

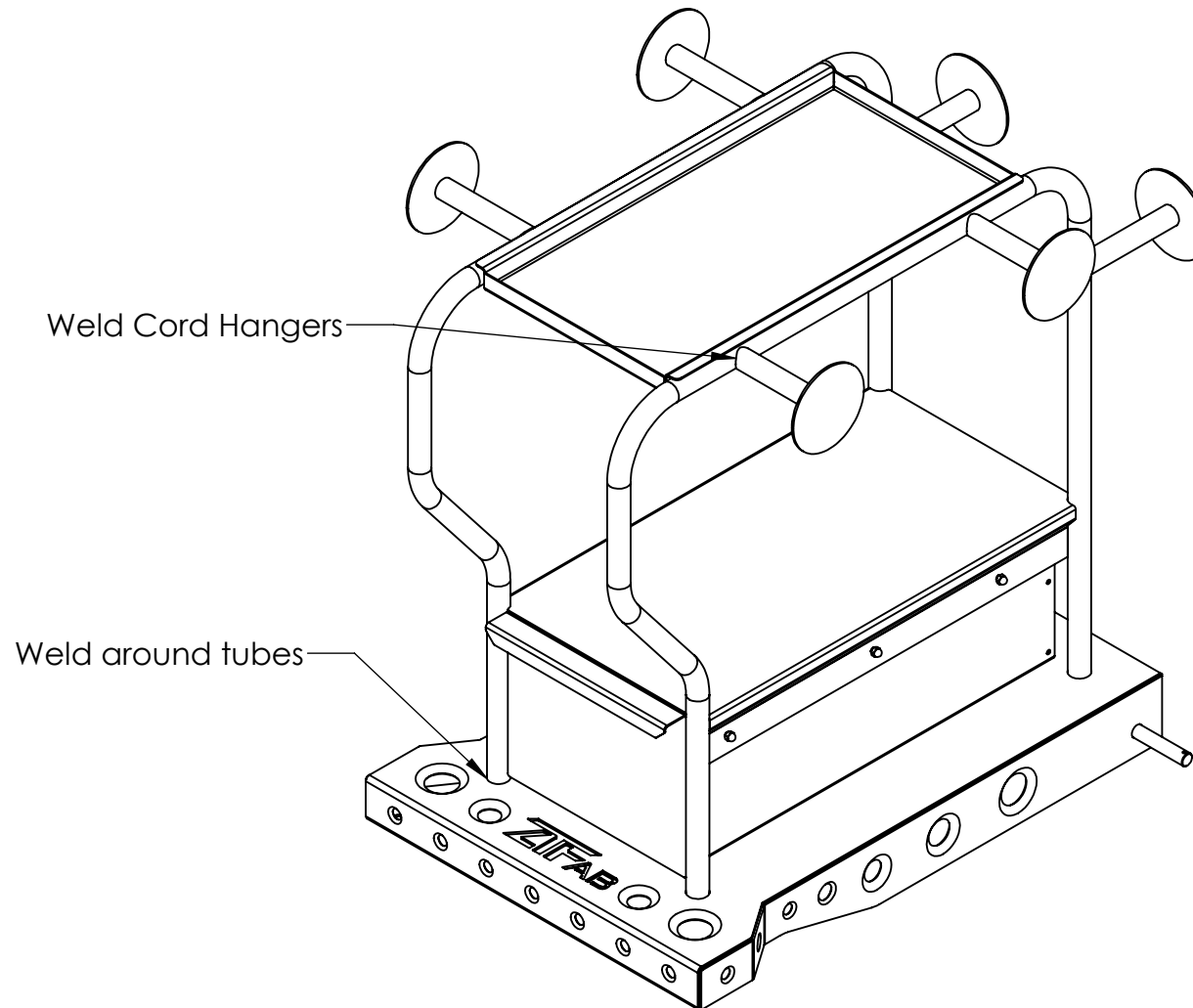
Position the pre-notched tubes for the cord hangers on the end plates. The placement of these items is completely to your preference. You can position them directly in the center or bias the plates more to the top to help hold additional cords. Once positioned properly, tack weld, then fully weld the tubes to the plates.



Step 8: Final Welding

Place the cord hangers around the cart where you would like them. You can choose to weld the storage tray in place or you can leave it removable.

Ensure that all brackets, tabs, and parts are securely tack welded in their proper locations. Complete all welds as necessary.



Step 9: Assembly

After you have test fit everything and applied your preferred method of protection (i.e., paint, powder coat, etc) install the front casters and rear wheels with the supplied hardware.

