



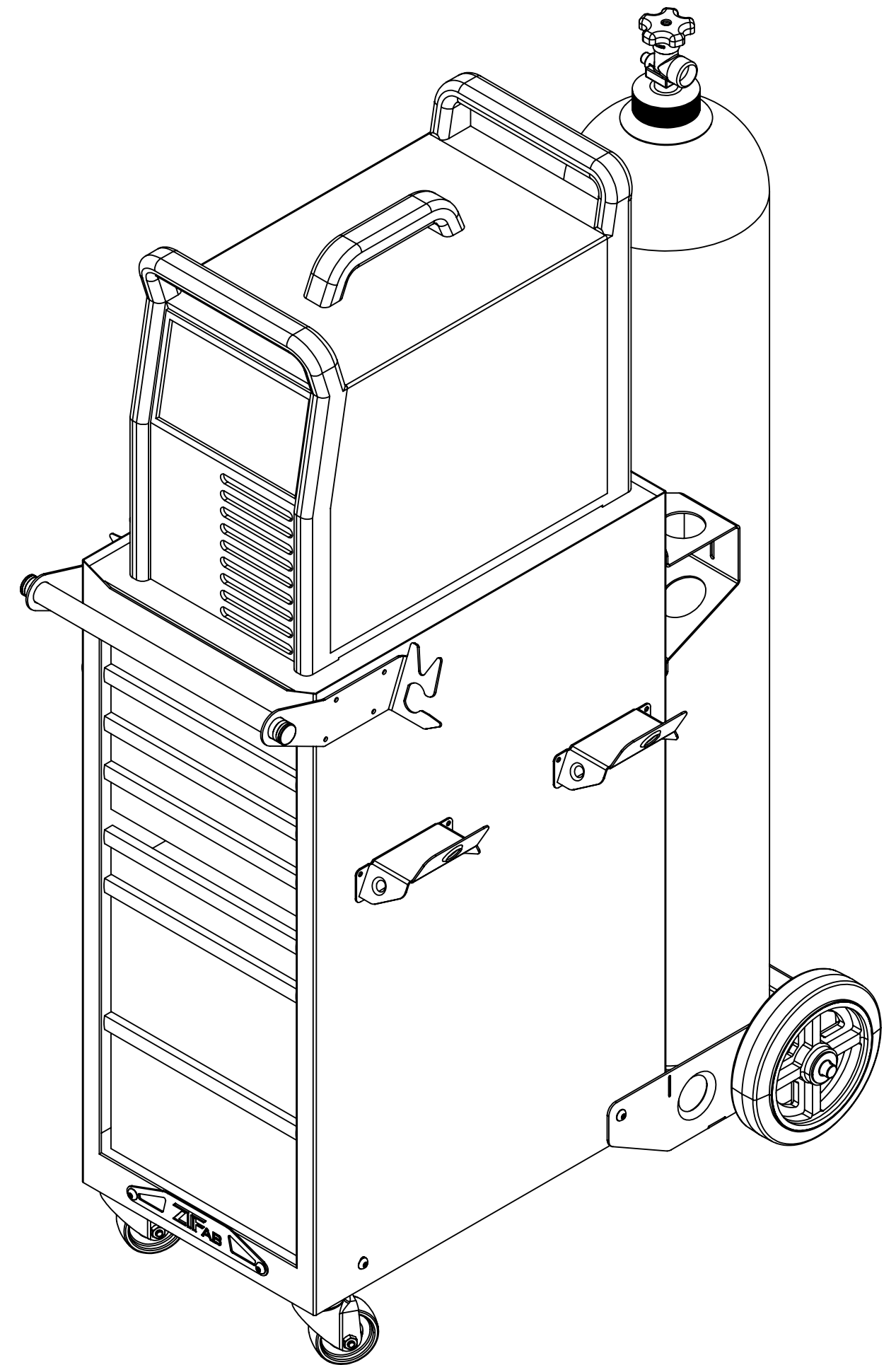
## US General End Cabinet Welding Cart Kit Instructions

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](http://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.

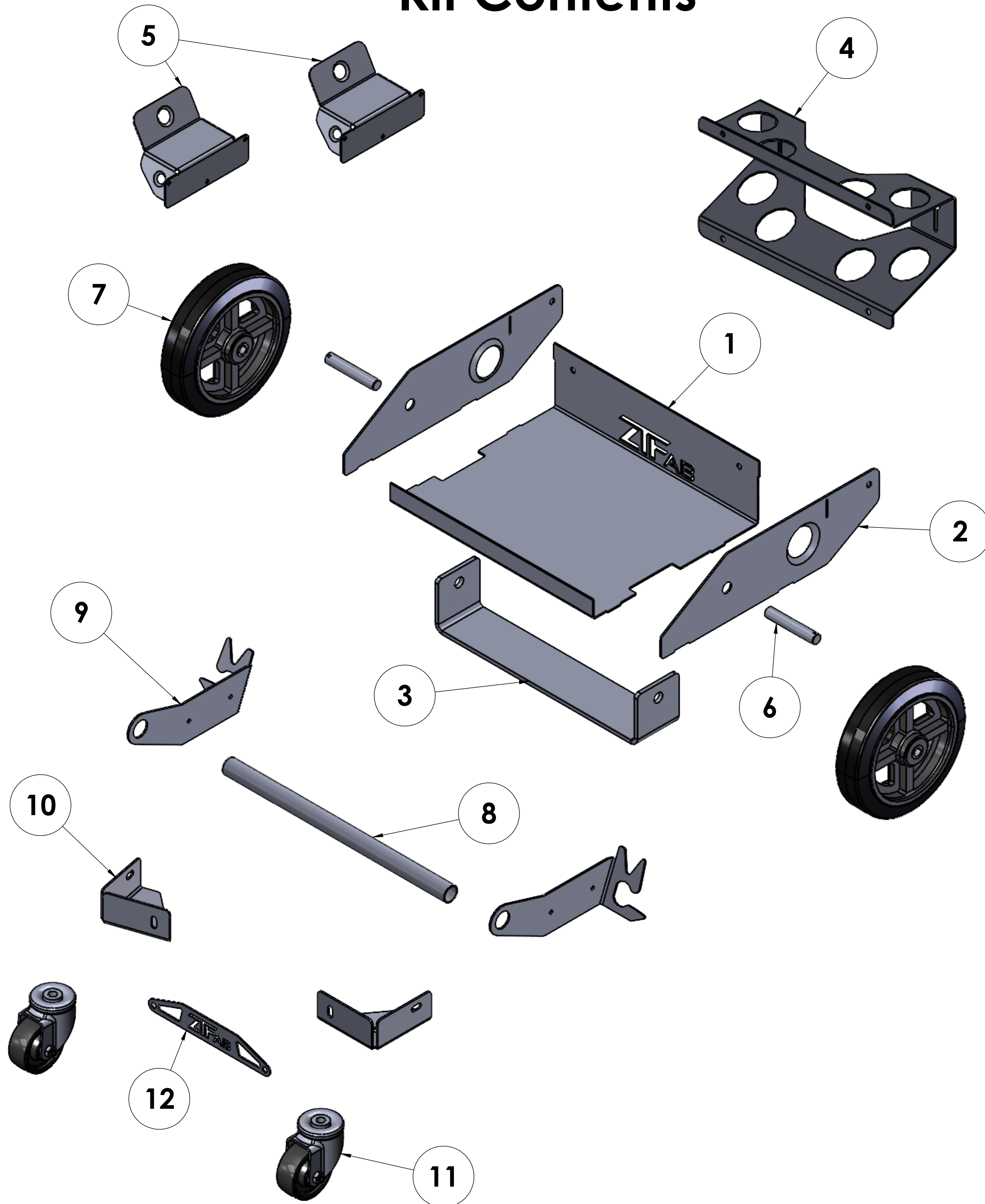
Installation of this kit may void your toolbox manufacturer's warranty.

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.



\*toolbox, welder, and  
gas bottle not included.

# Kit Contents

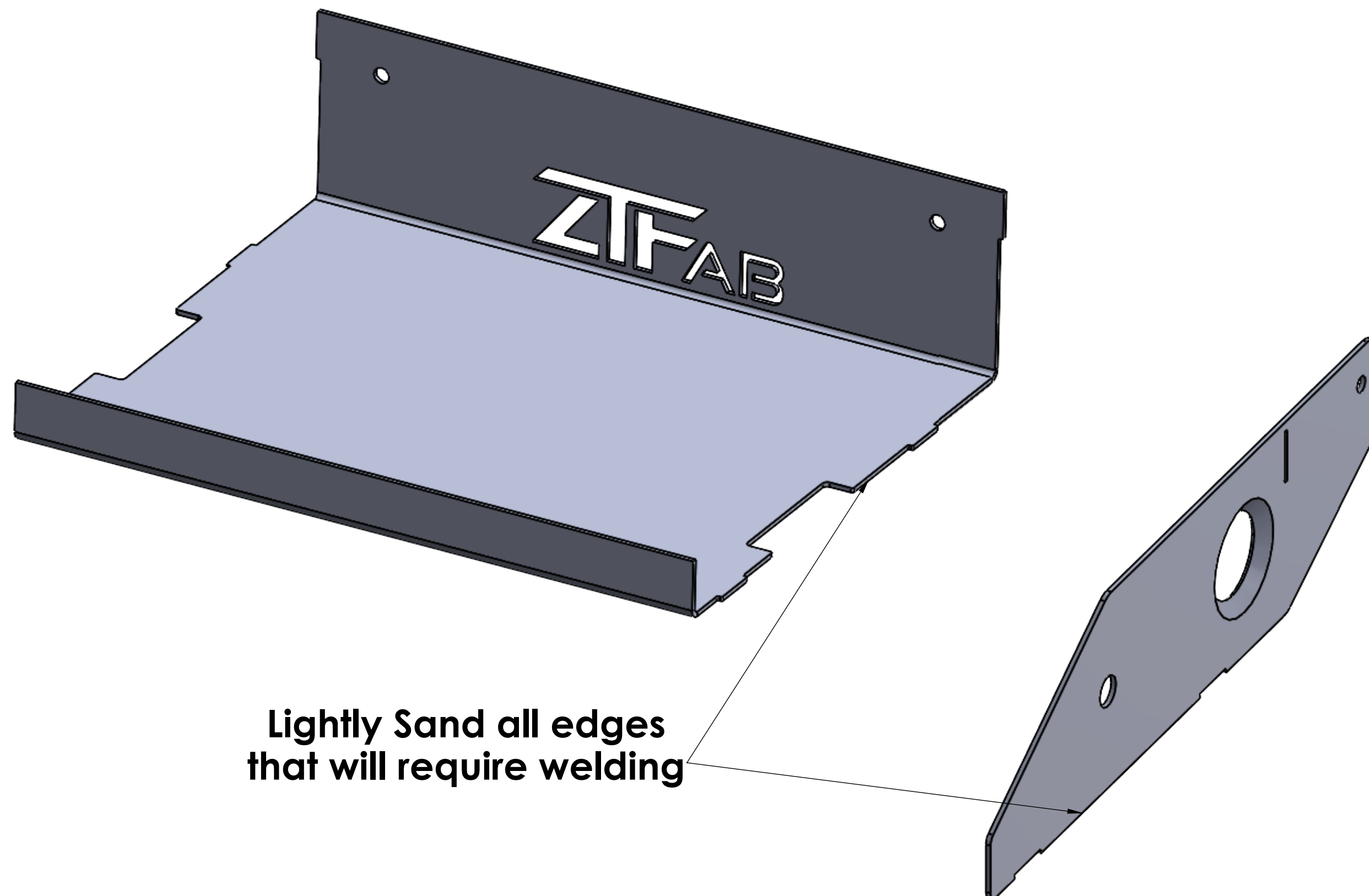


Part	Description	QTY
1	Bottle Base	1
2	Side Plates	2
3	Axle Bracket	1
4	Bottle Bracket	1
5	Cord Hangers	2*
6	Axle Shafts	2
7	Wheels	2
8	Handle Tube	1
9	Handle Tube Brackets	2
10	Caster Mounting Brackets	2
11	Casters	2
12	Front Badge	1

\* varies with selected options

# Step 1: Material Preparation

Your cart kit is made from high quality, 12gauge, CNC Laser 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 sandpaper. Be careful not to remove material beyond the oxide layer as this may affect fitment of the parts.

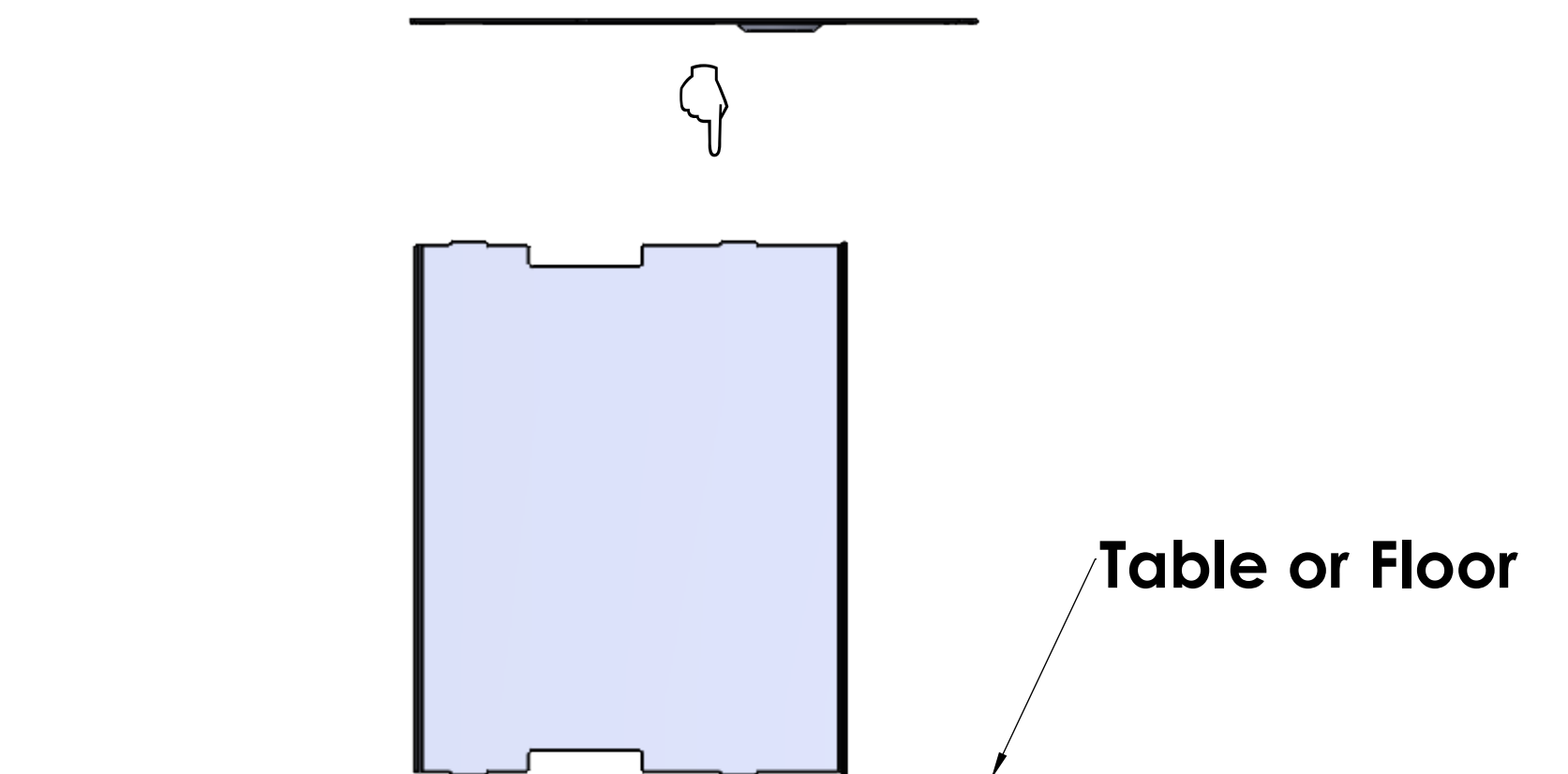
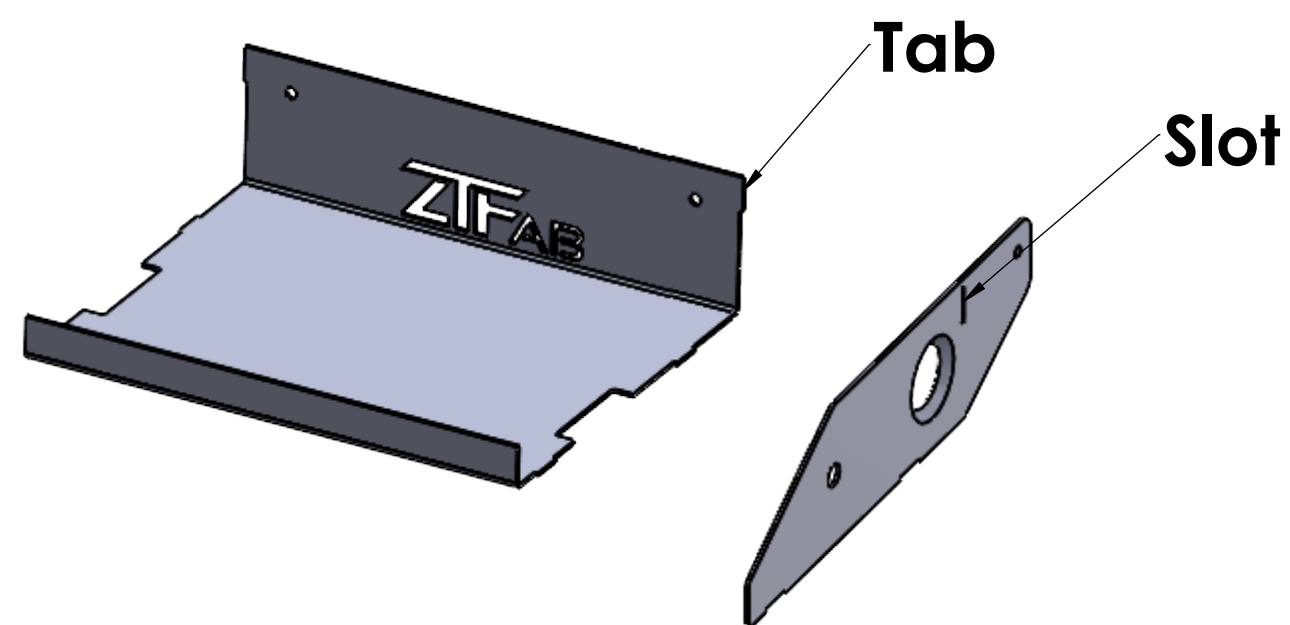


## Step 2: Bottle Base Assembly

Start with the Bottle Base and a Side Plate.

Turn the Bottle Base up on its edge and set the Side Plate on the side of the Bottle Base.

Align the Slots in the Side Plate with the Tabs on the Bottle Base so that it sits flat on the edge of the Bottle Base (See View 2-2).



View 2-1



Side Plate lined up on Base

View 2-2

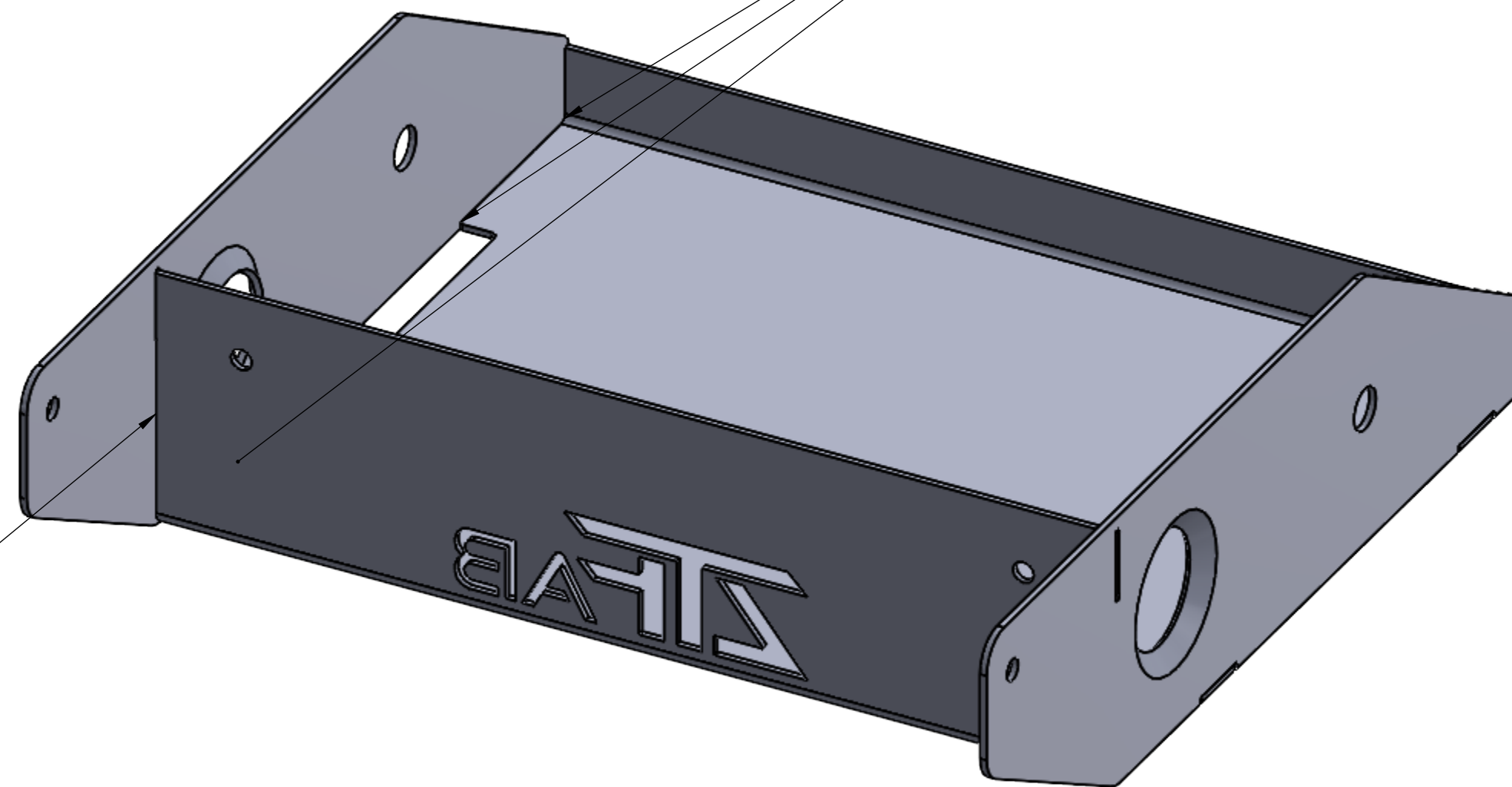
## Step 2A: Bottle Base Assembly

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.

Use a clamp if needed to close any gaps first.

NO WELDS HERE

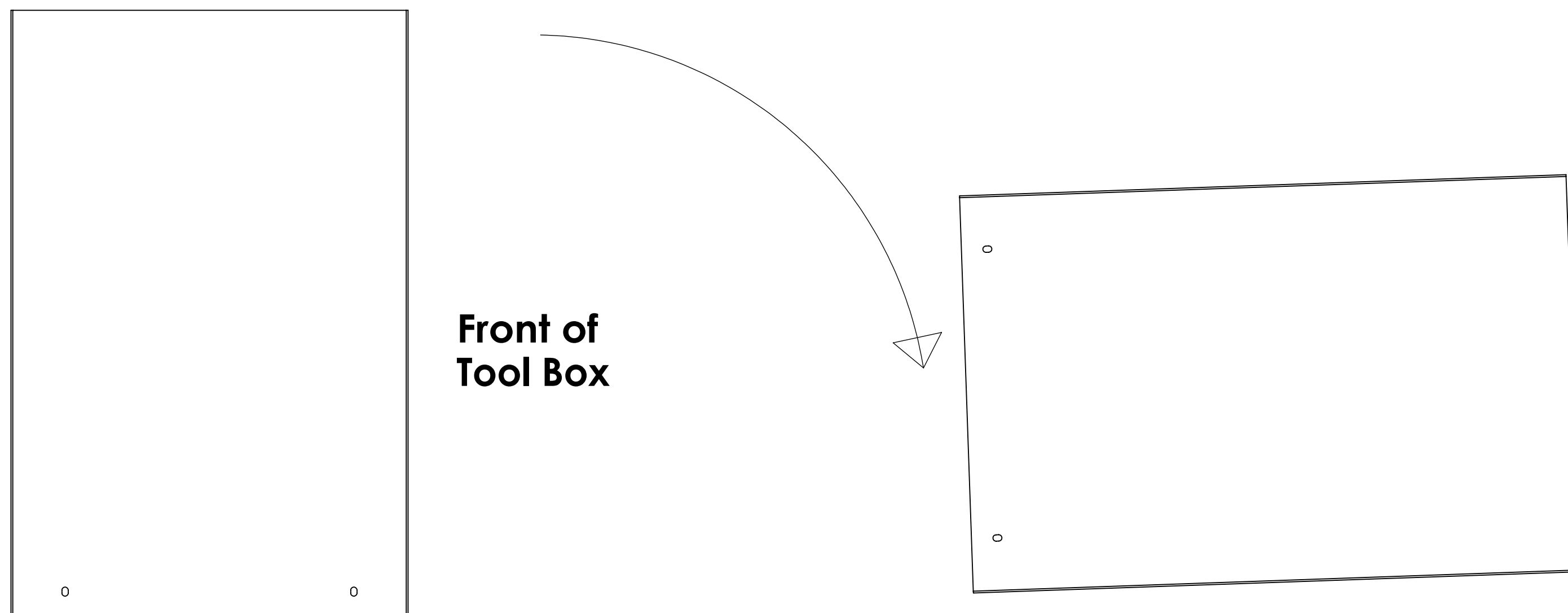
Tack Weld on Inside Edge



## 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.)

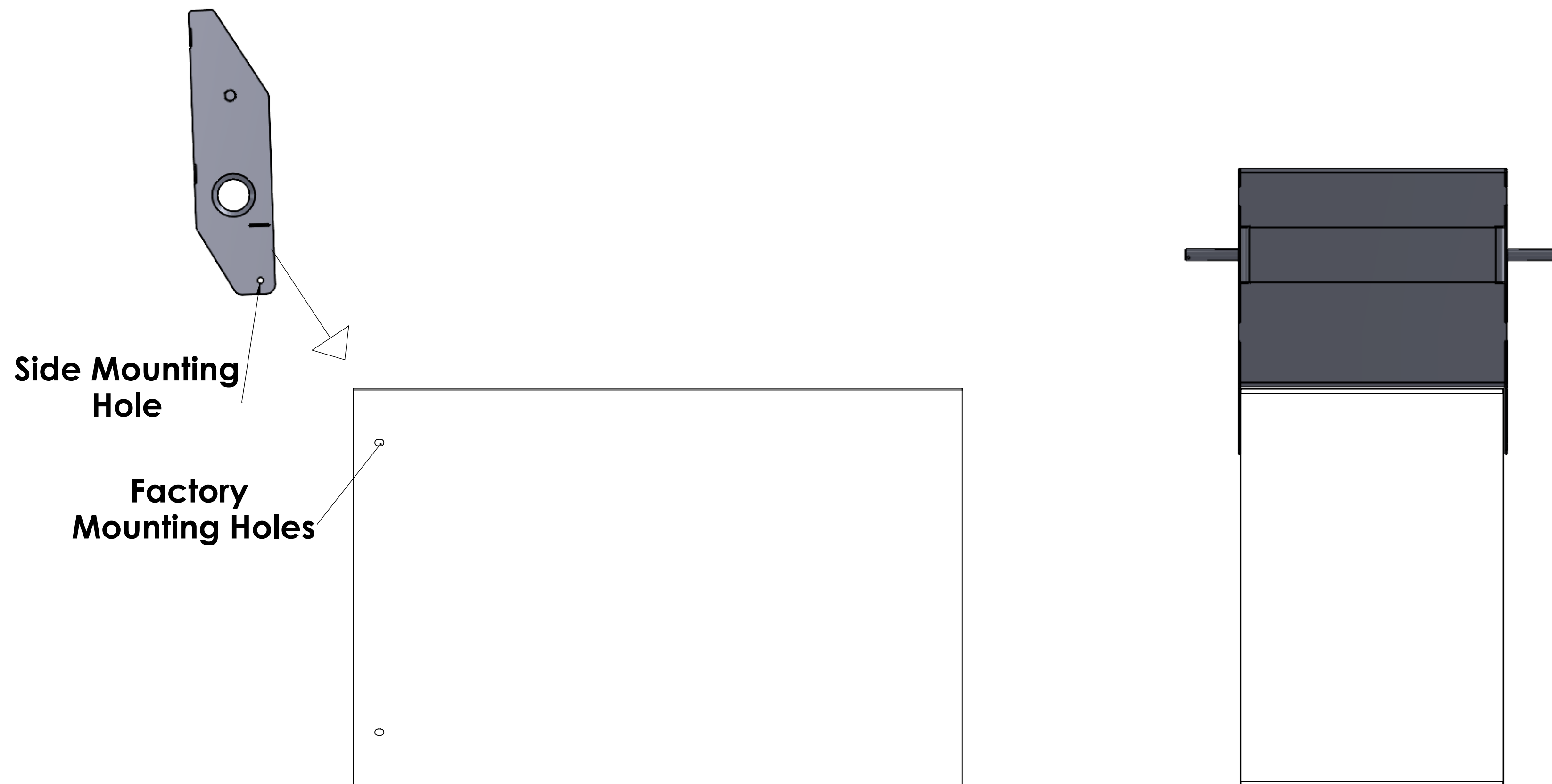
Carefully flip the toolbox on it's face so that the drawer fronts are on the bottom with the back facing up. Use a blanket, pad, or cardboard to protect the box from getting damaged.



## 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. Align the Mounting Holes in the Side Plates with the Factory Mounting holes on the side of the toolbox. Make any necessary adjustments to achieve a proper fit.

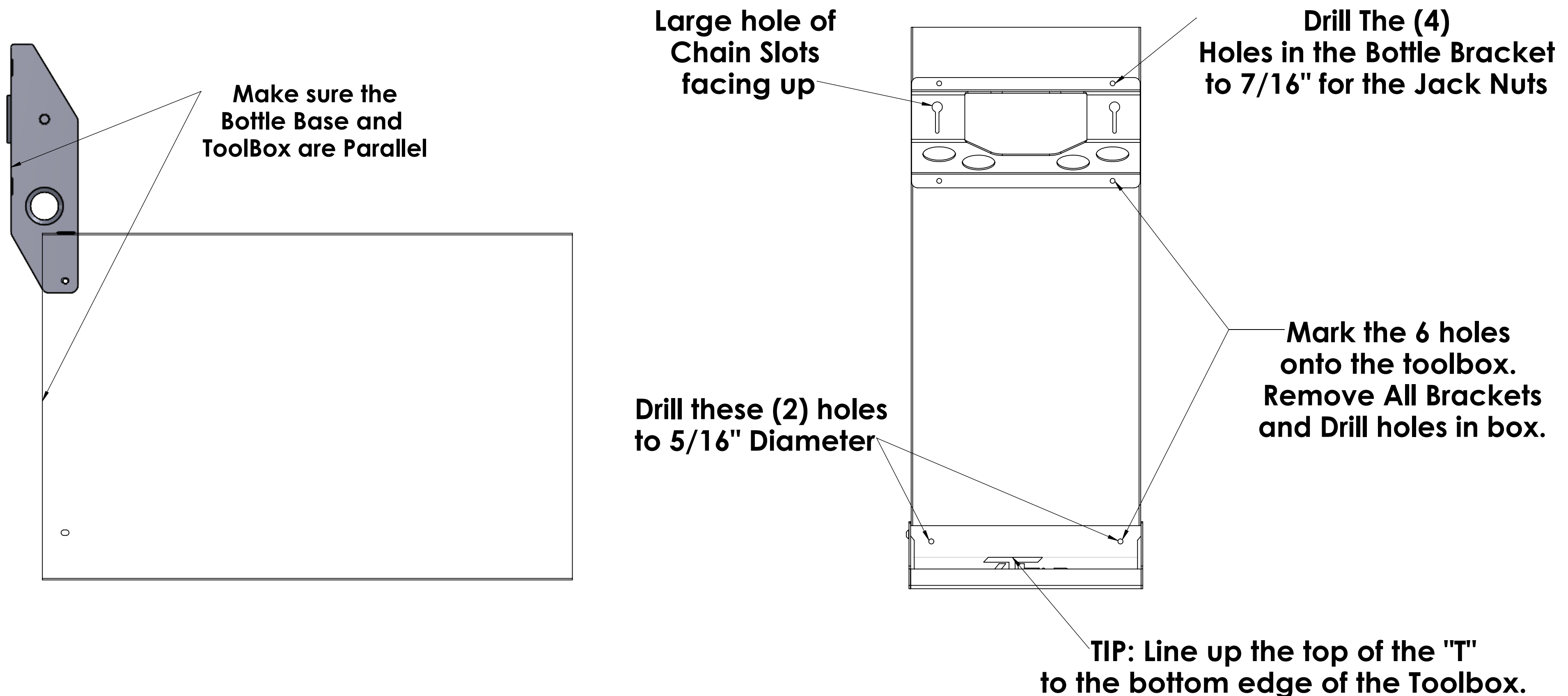
Use (2) of the supplied 5/16" Button Head Bolts and Nuts to secure the base to the box through these holes.



# Step 5: Marking and Drilling - Bottle Base and Bracket

With the toolbox still facing down and the Bottle Base attached to the (2) toolbox side holes, verify that the Bottle Base is parallel to the bottom of the toolbox. 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.

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 the proper size.

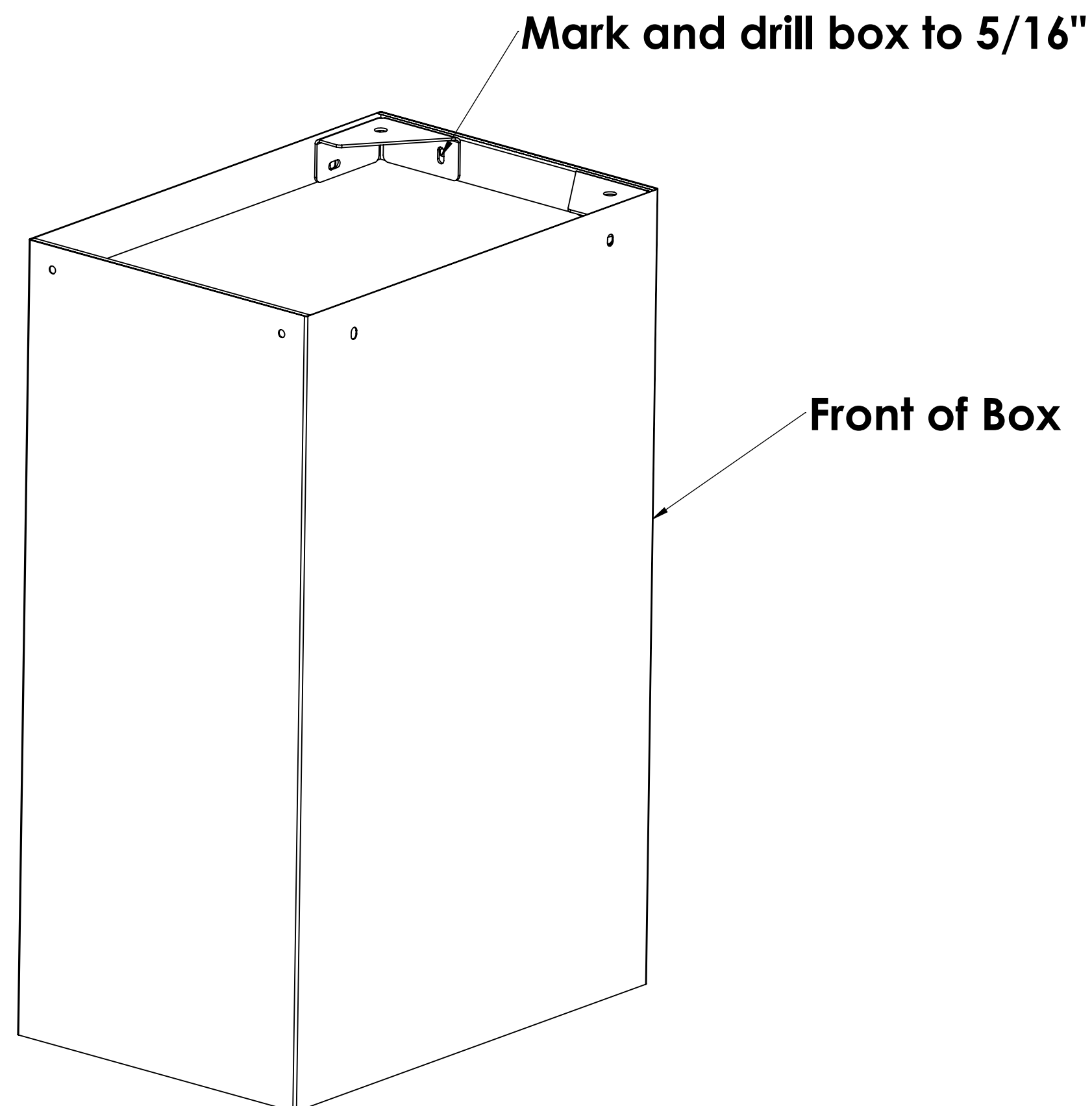




## **Step 5A: Marking and Drilling - Caster Mounts**

Turn the toolbox so the top is now facing down. Bolt the Caster Mounting Brackets to the factory bolt holes in the sides of the box. Note; the vertical slots in the Caster Mounts face the front of the box.

Mark the location of the holes on to the toolbox. TIP: Put a piece of masking tape on the toolbox first to make your marks clearer. Remove the Caster Mounts and center punch your marks, then drill out to 5/16".

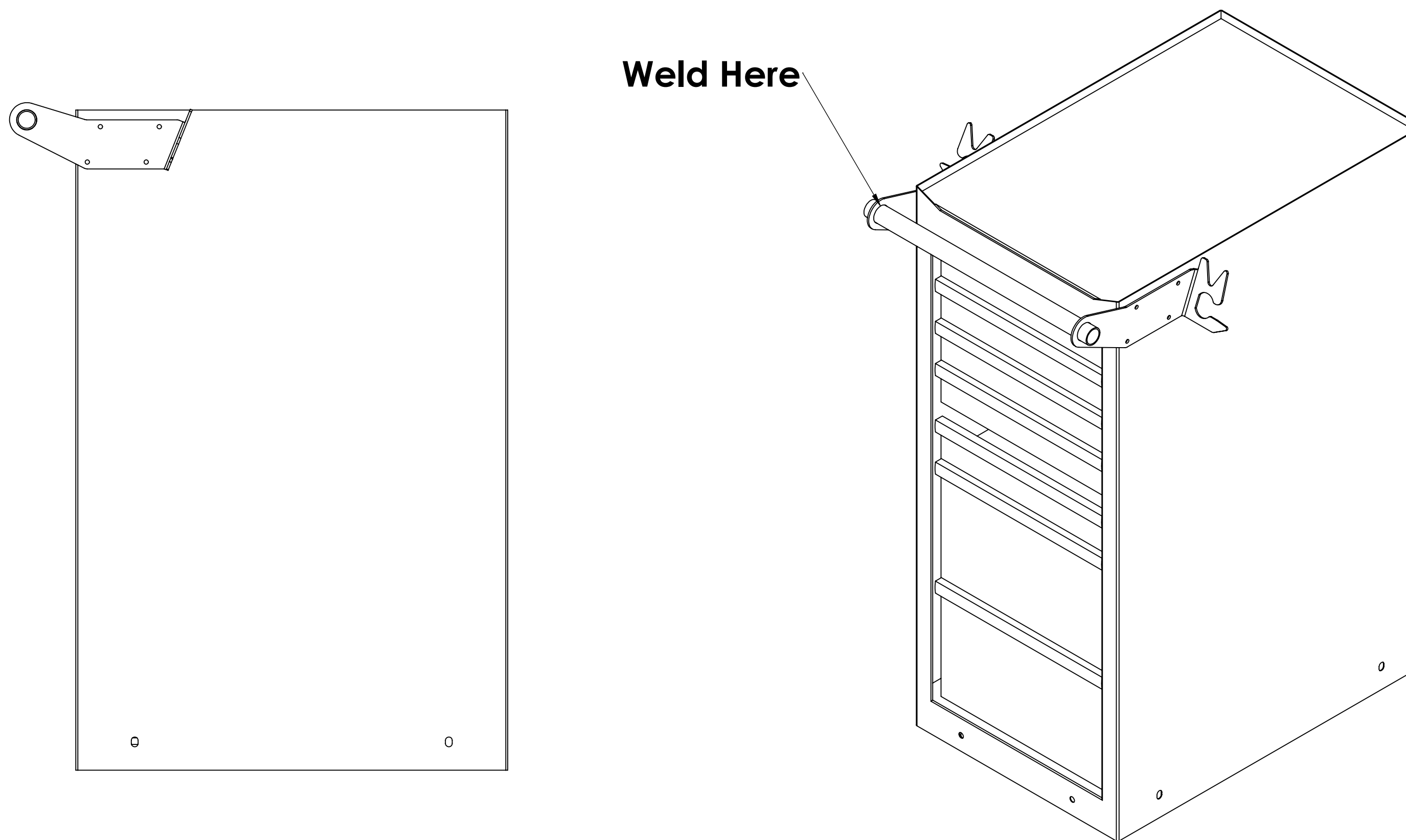


## Step 6: Handle

Locate the Handle Brackets and the Handle Tube. Position the Handle Brackets on the toolbox, placing them up high enough to allow the top drawer to open without interference. Clamp the brackets in place temporarily and insert the handle tube. Verify that the tube is level and parallel to the box and centered in the brackets.

Once the tube and brackets are in position, tack weld the tube to the brackets.

Remove the handle assembly and finish welding the tube to the brackets.

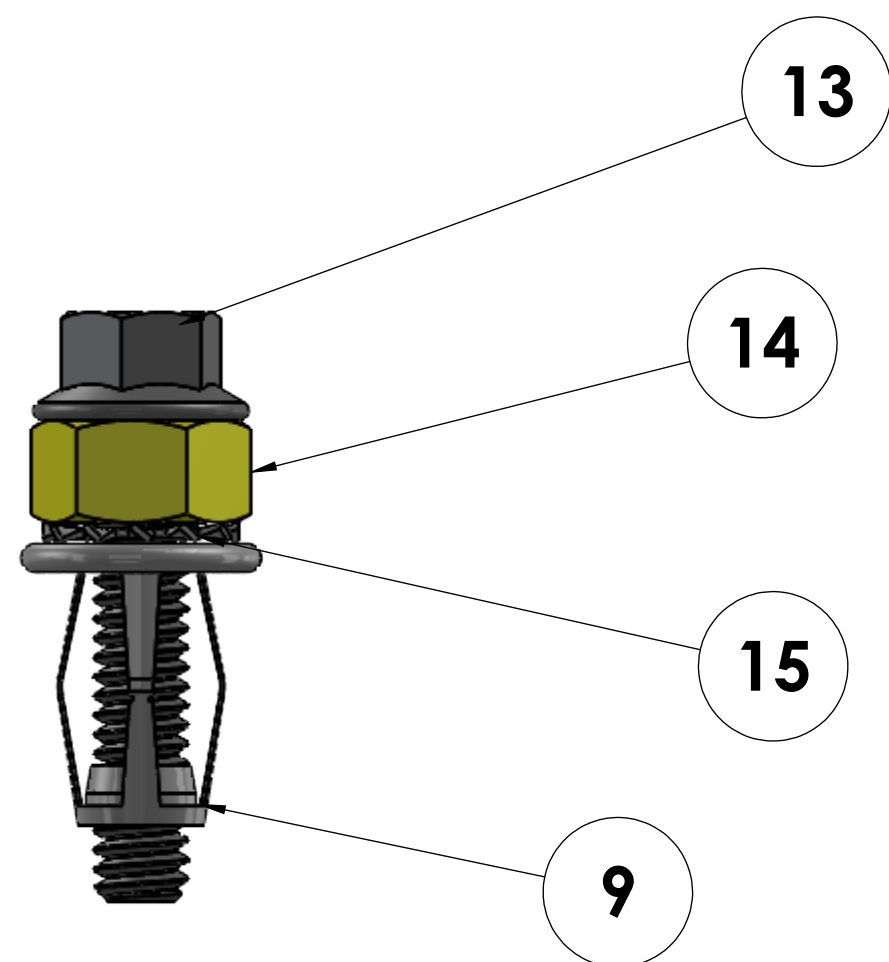


## Step 7: Jack Nut Installation

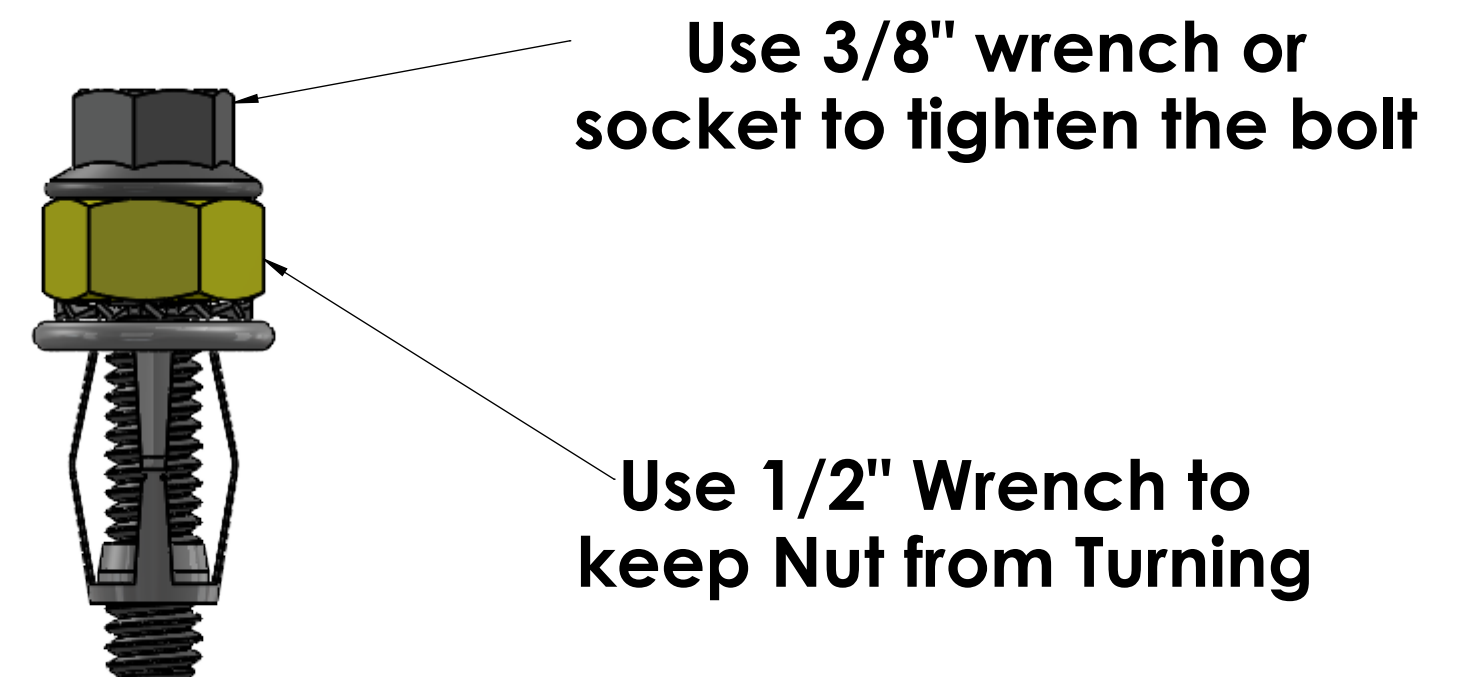
Your kit includes all the necessary hardware to install the Jack Nuts into your toolbox. Locate the Jack Nut installation tool that came in the hardware bag. The tool comes preloaded with an extra Jack Nut. We have included the extra Jack Nut in the kit for you in case you need it while assembling your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

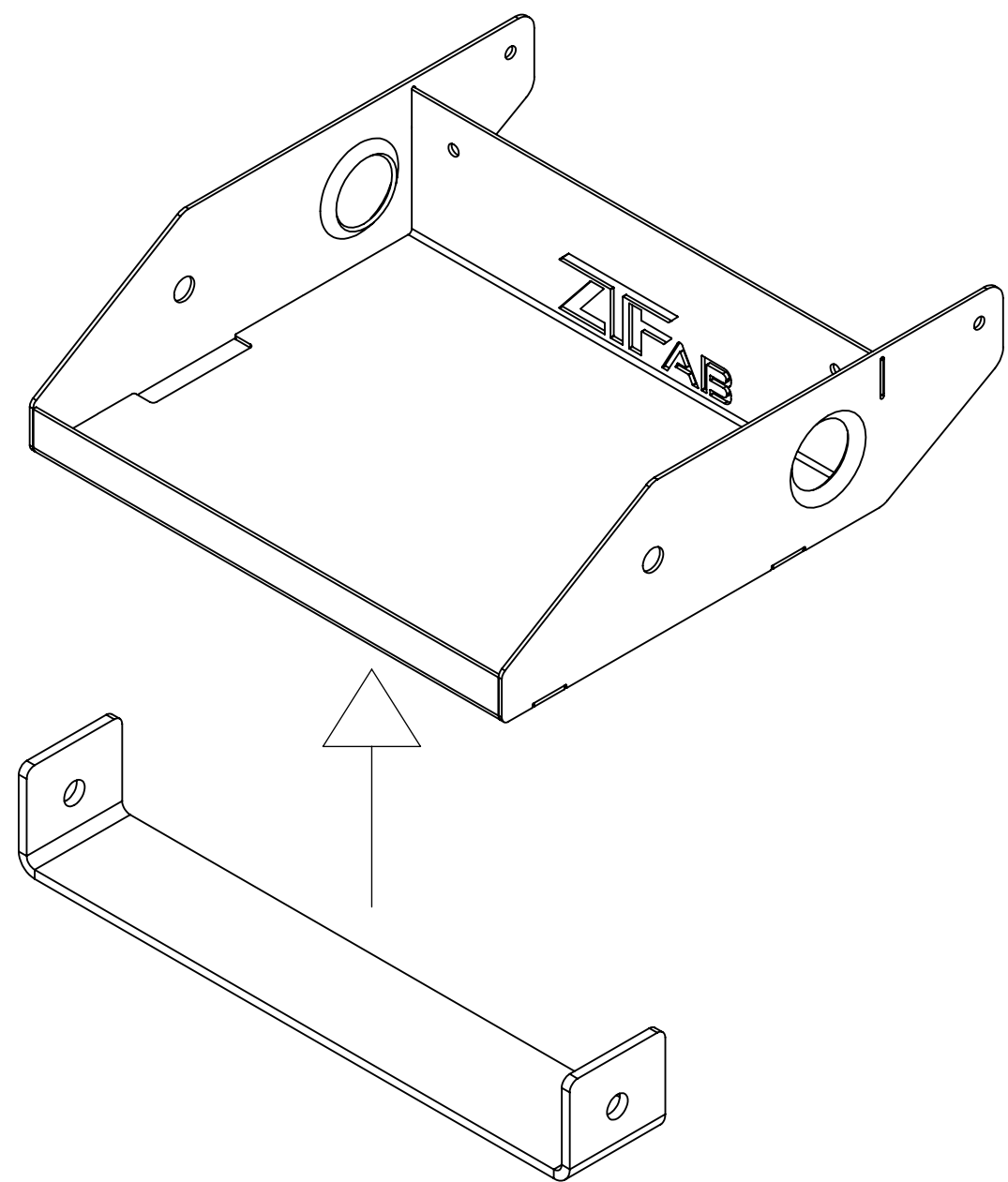


Jack Nut Installation Tool

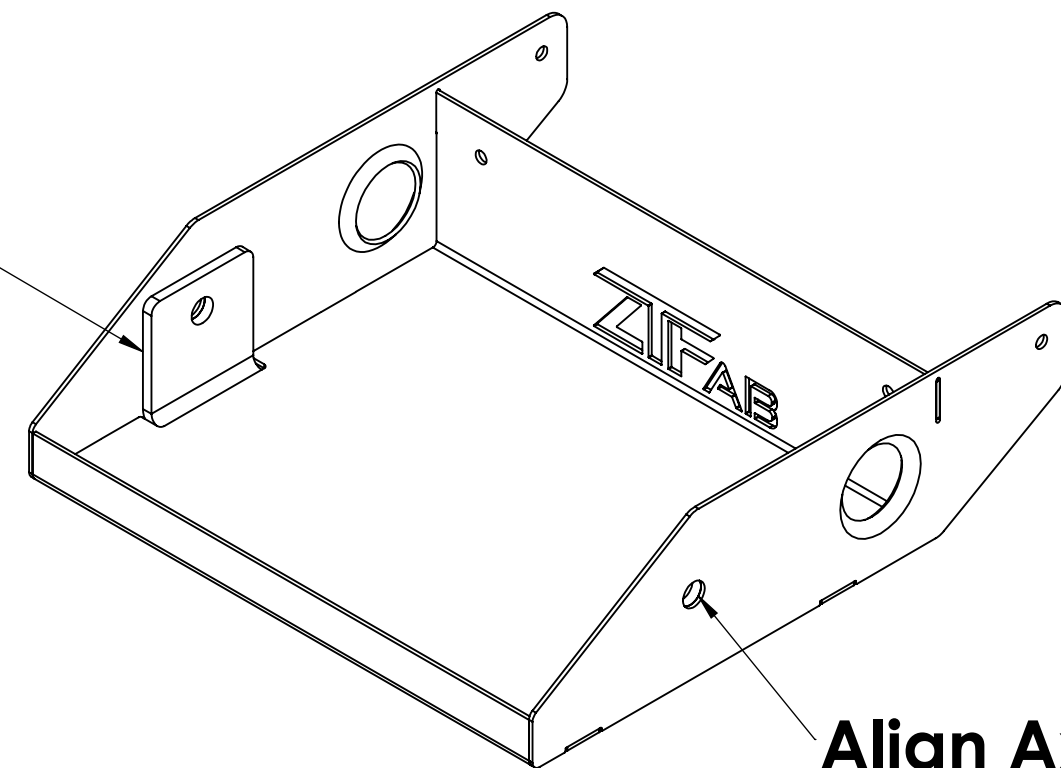


# Step 8: Axle Bracket

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.

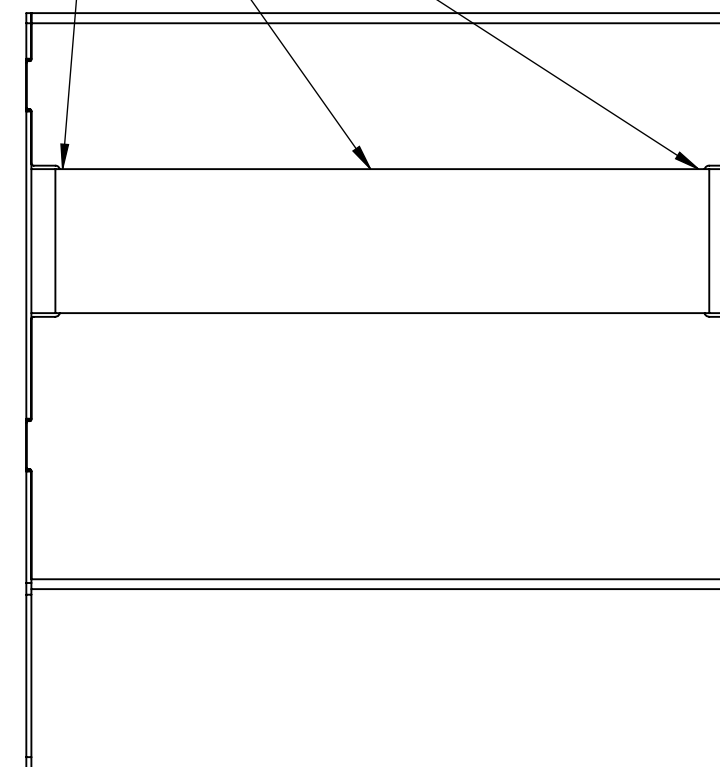


Tack Weld  
(Both Sides)



Align Axle Shaft Holes  
Before Tacking

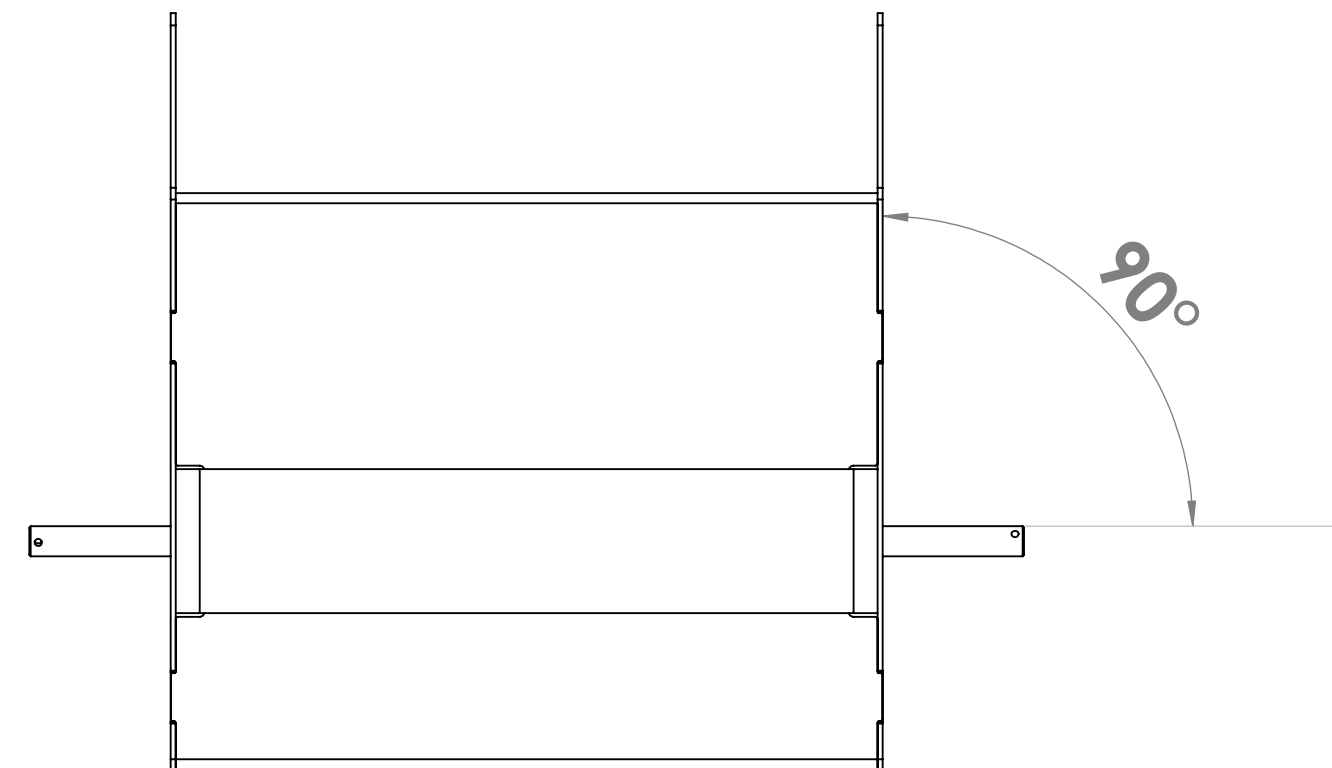
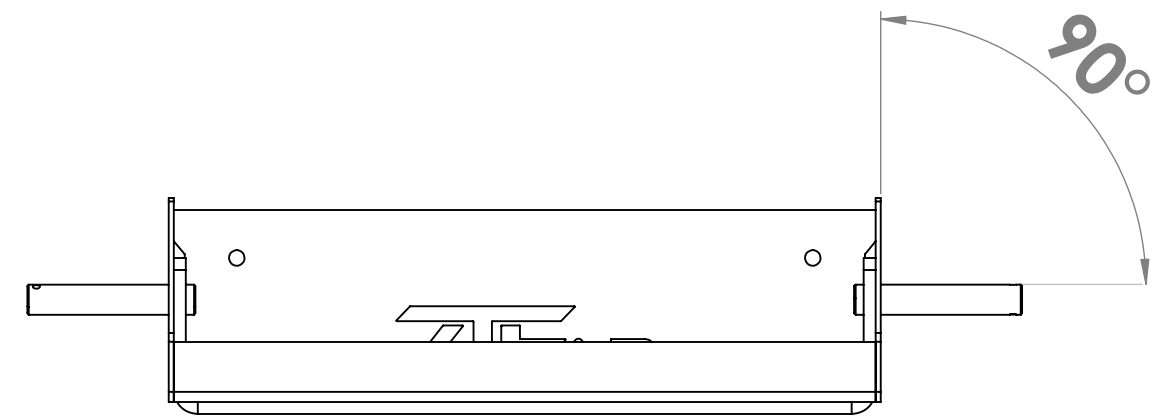
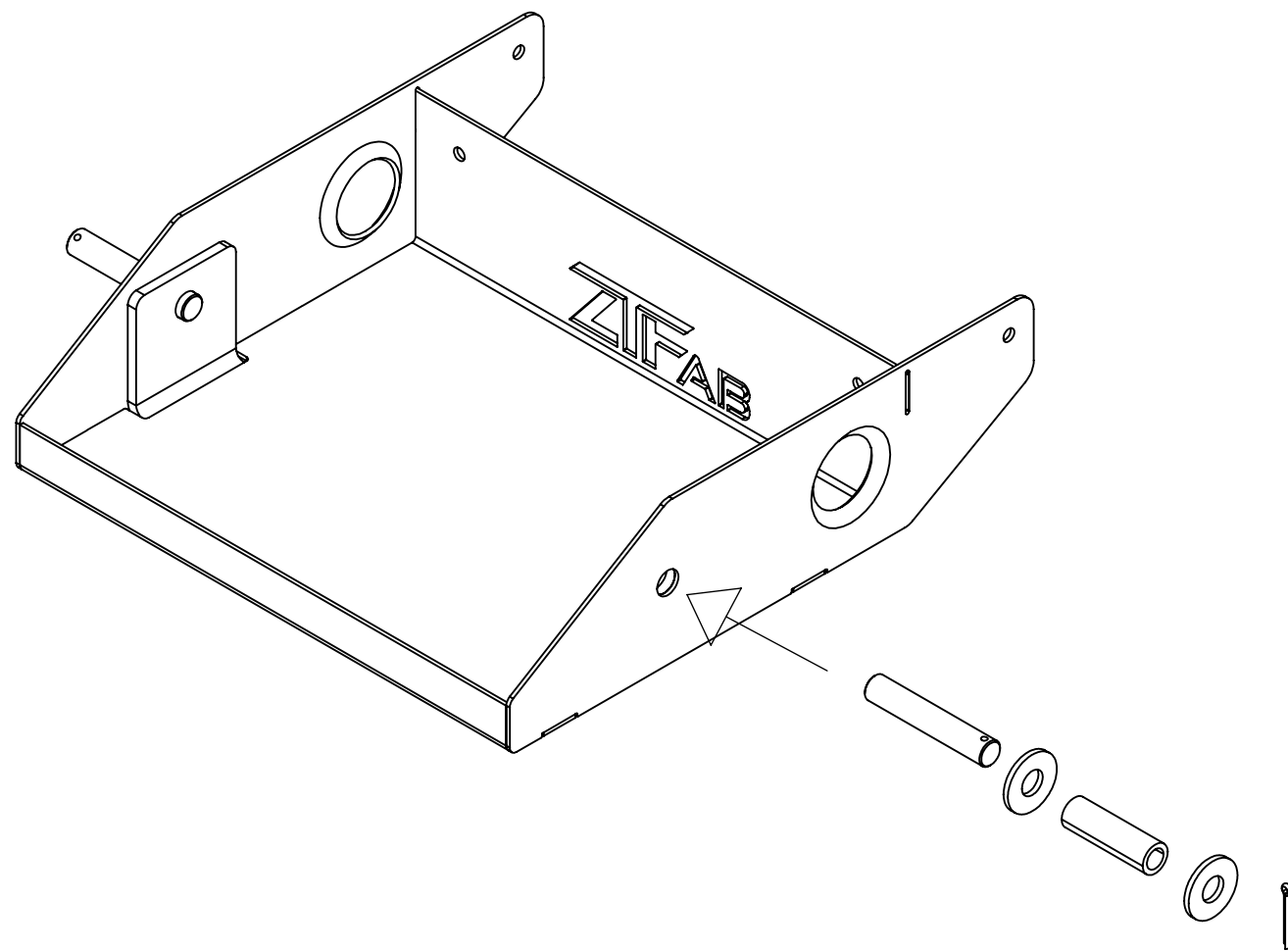
Tack Weld  
(Both Sides)



Axle Bracket Flush to Bottle Base

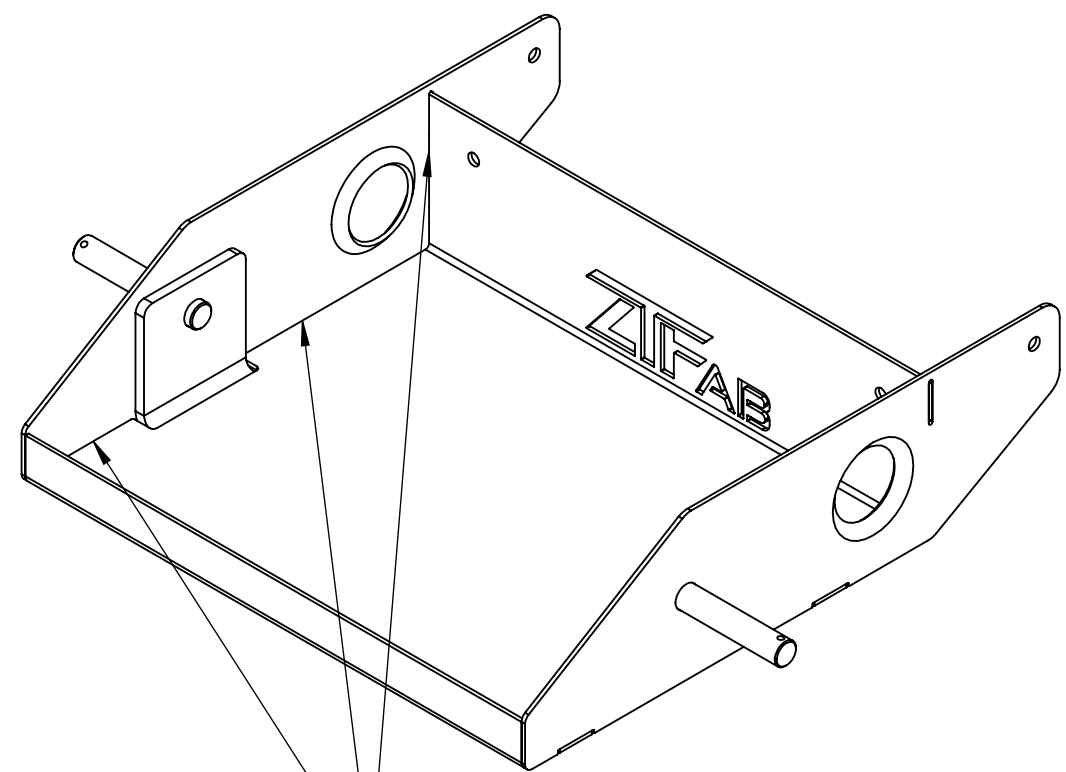
## Step 9: Axle Shafts

Locate the Axle Shafts, axle sleeves, 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.

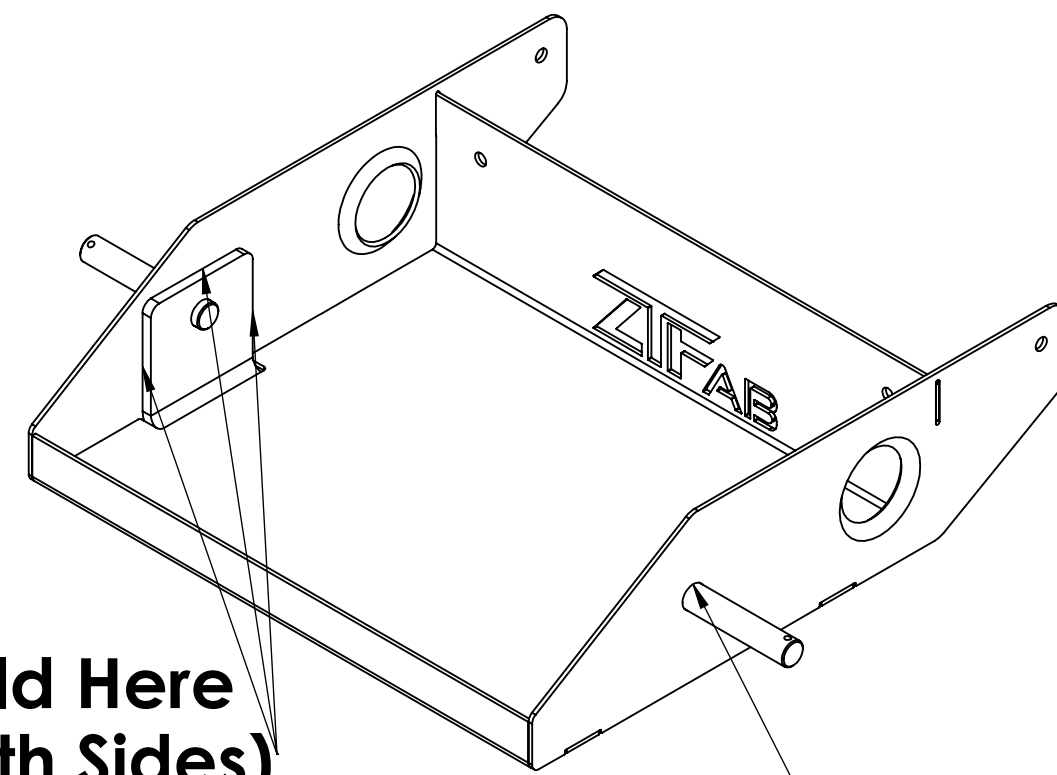


# Step 10: Welding

Now the final welding can be completed. 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.

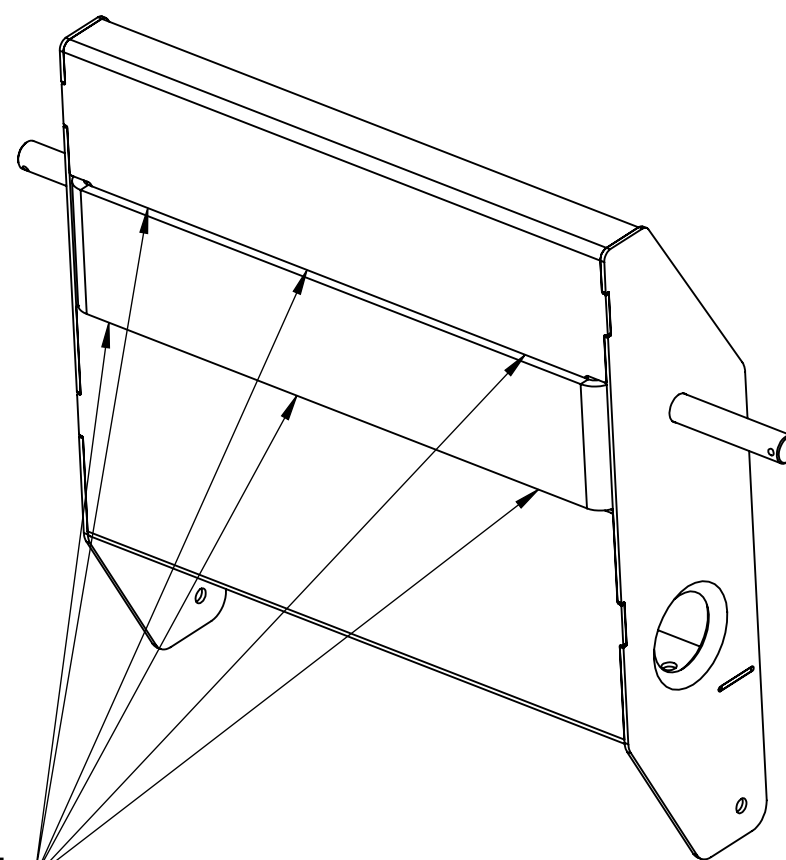


**Weld Here  
along the inside edges**



**Weld Here  
(Both Sides)**

**No welding**



**Weld Here  
3 welds per side  
about 2" long each**

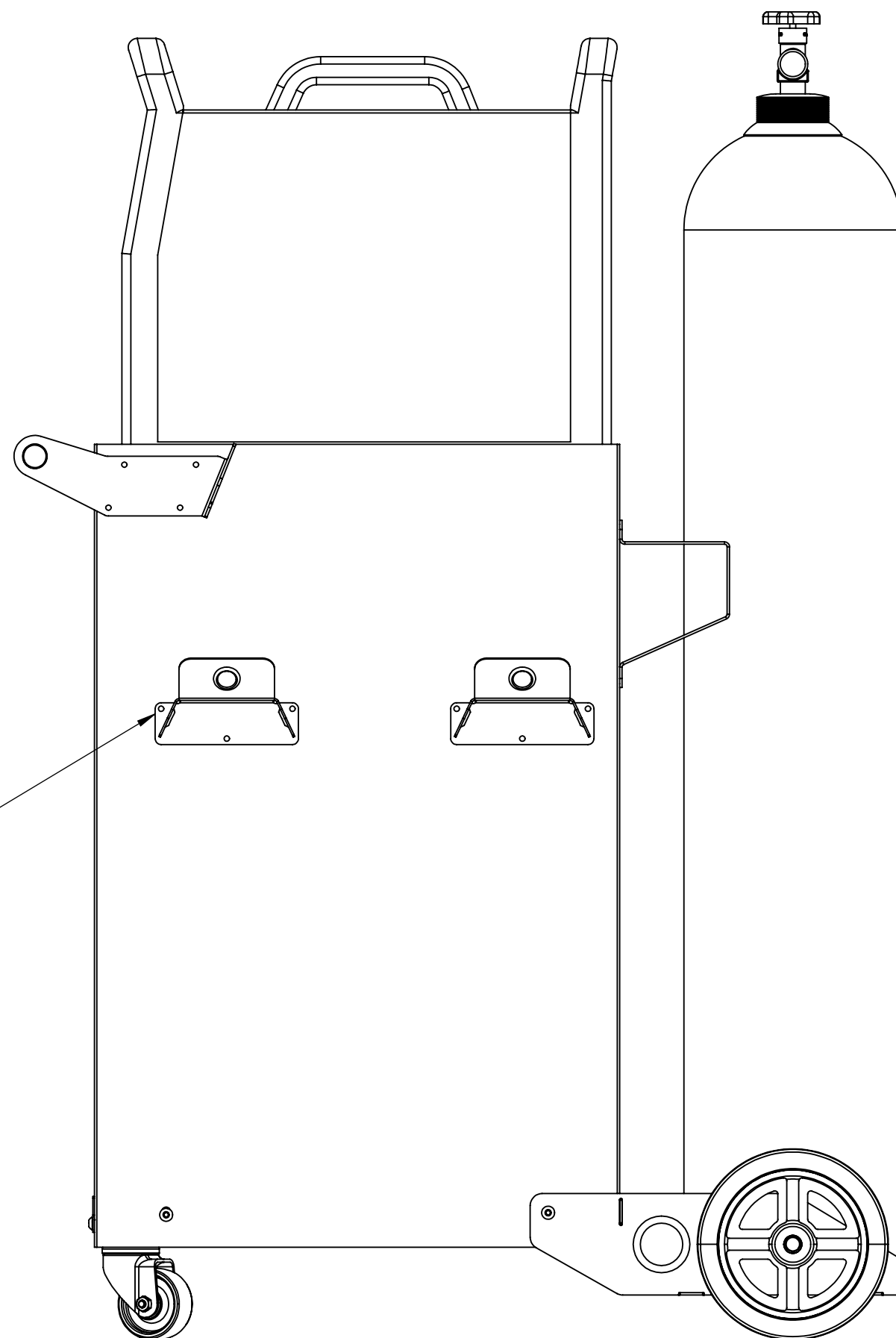
## Step 11: Final Fitting and Cord Hangers

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. Install the handle tube assembly using the same screws. 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 12: Final Assembly**

After you have painted or powdercoated the parts, you can now install the kit for the final time.

Turn the toolbox over onto its top. Bolt the Bottle Base Assembly on the toolbox using (4) of the supplied 5/16" Allen head bolts and nuts.

Bolt the Caster Mounting Brackets in place using (4) of the supplied 5/16" Allen head bolts and nuts. Bolt the casters to the plates using the (2) supplied 1/2" bolts and Nyloc nuts.

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 and handle assembly 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 (if they were removed), 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](mailto:sales@all-a-cart.com)  
or on social media @ZTFab on Instagram and Facebook.