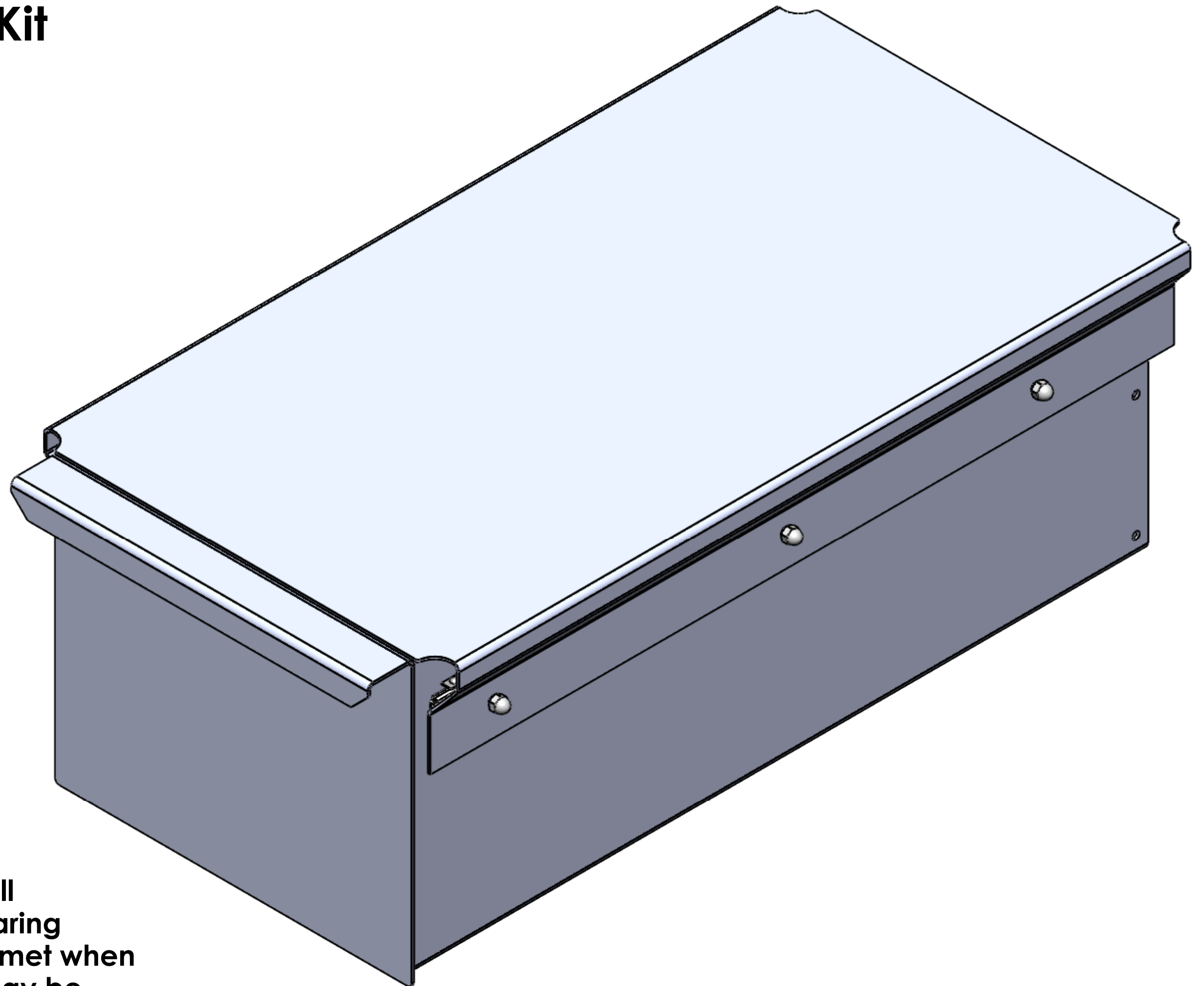


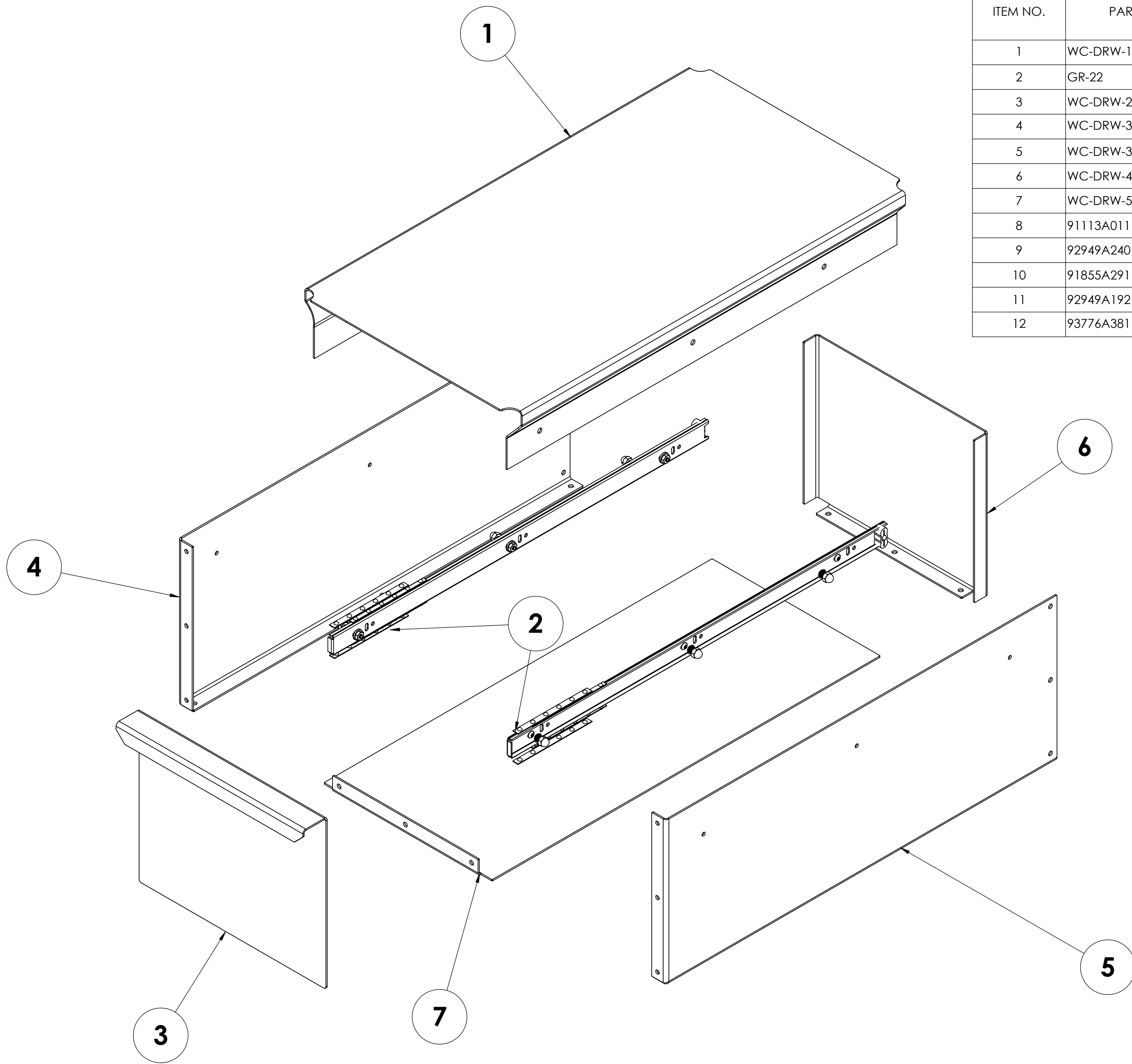
# Welding Cart Drawer Kit

## Instructions

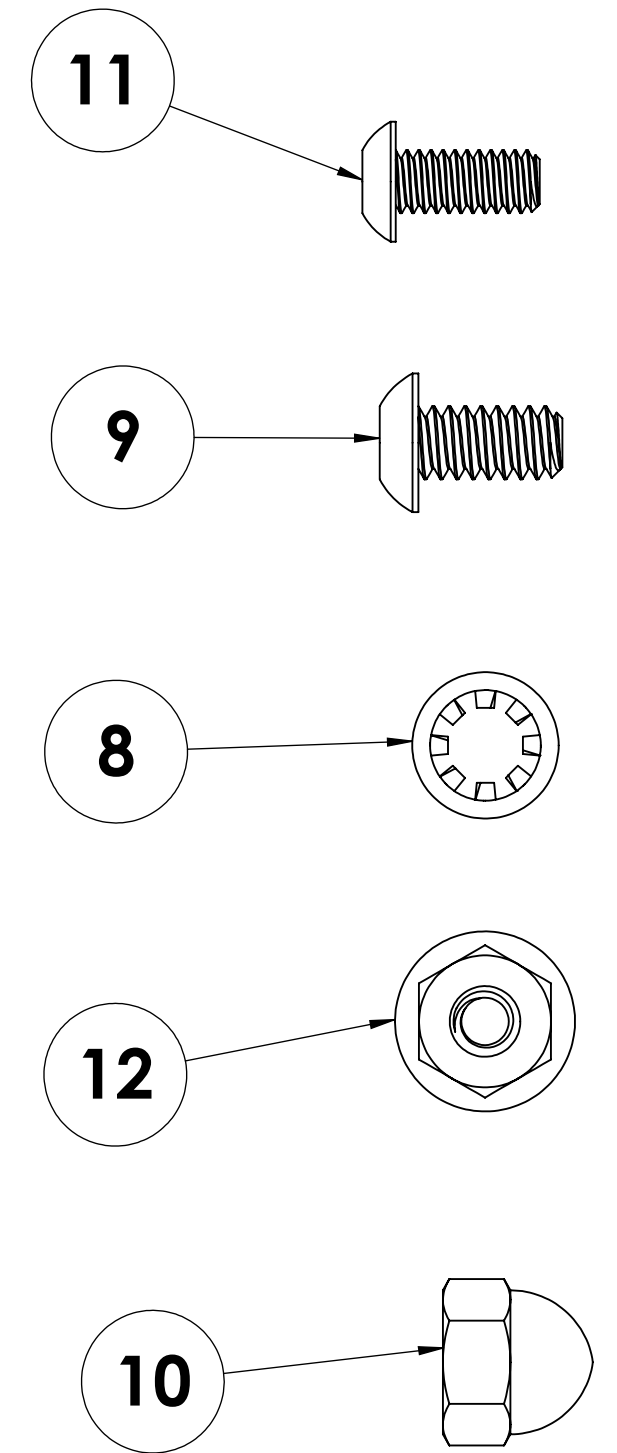


Proper PPE is recommended at all times. Safety glasses, gloves, hearing protection, and/or a welding helmet when necessary. Sheet metal edges may be sharp. Handle with caution.

Please read these instructions thoroughly before assembling the drawer kit. For further instruction or to view the 3D models please visit the "Instructions and 3D models" tab on [All-a-cart.com](http://All-a-cart.com).

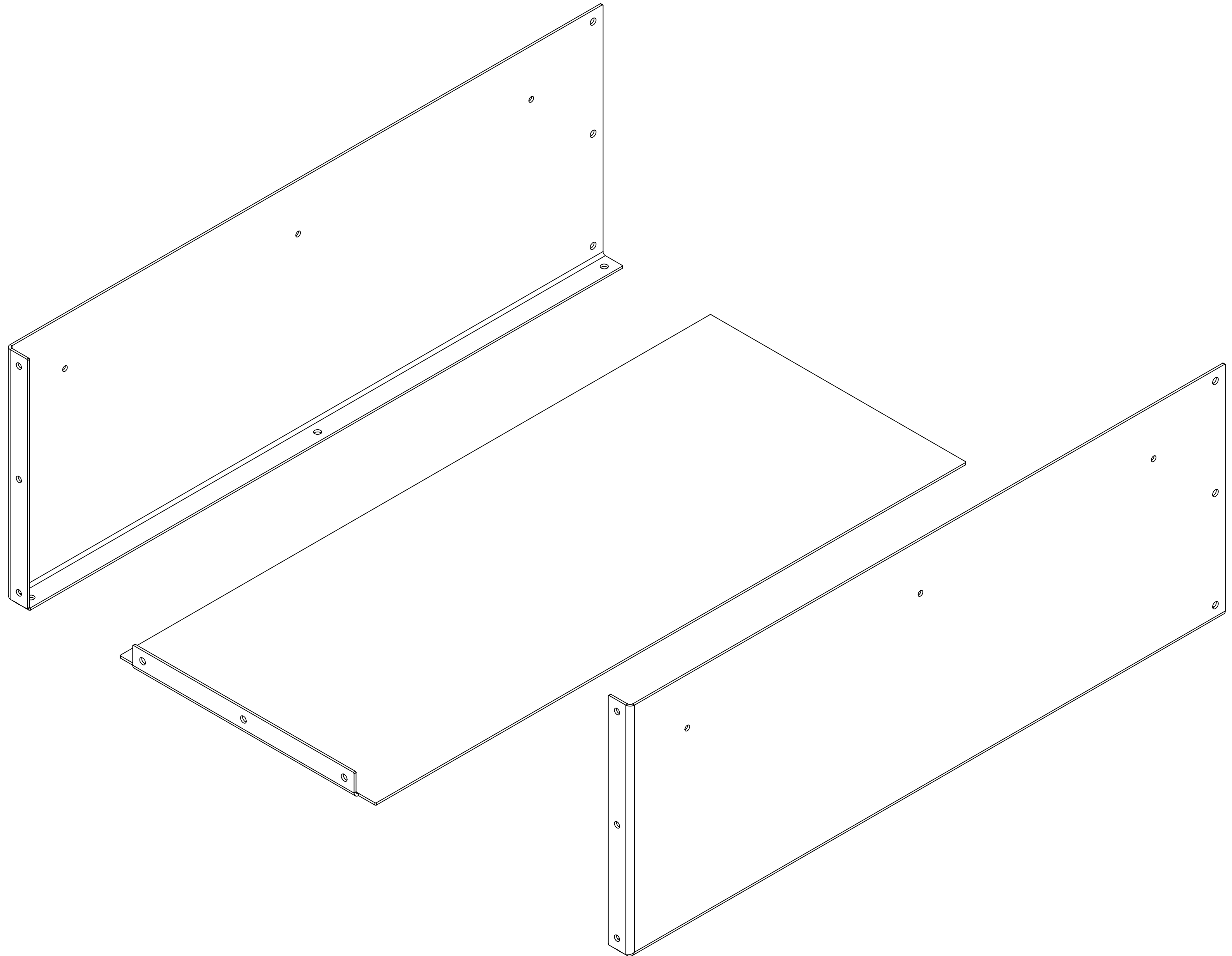


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	WC-DRW-1	Top Shelf	1
2	GR-22	Drawer Slide	2
3	WC-DRW-2	Drawer Front	1
4	WC-DRW-3R	Drawer Side_Right	1
5	WC-DRW-3L	Drawer Side_Left	1
6	WC-DRW-4	Drawer Back	1
7	WC-DRW-5	Drawer Bottom	1
8	91113A011	Lock Washer	6
9	92949A240	10-24 Stainless Steel Button-Head	6
10	91855A291	10-24 Stainless Acorn Nut	6
11	92949A192	8-32 Stainless Steel Button-Head	6
12	93776A381	8-32 Serrated Flange Nut	6



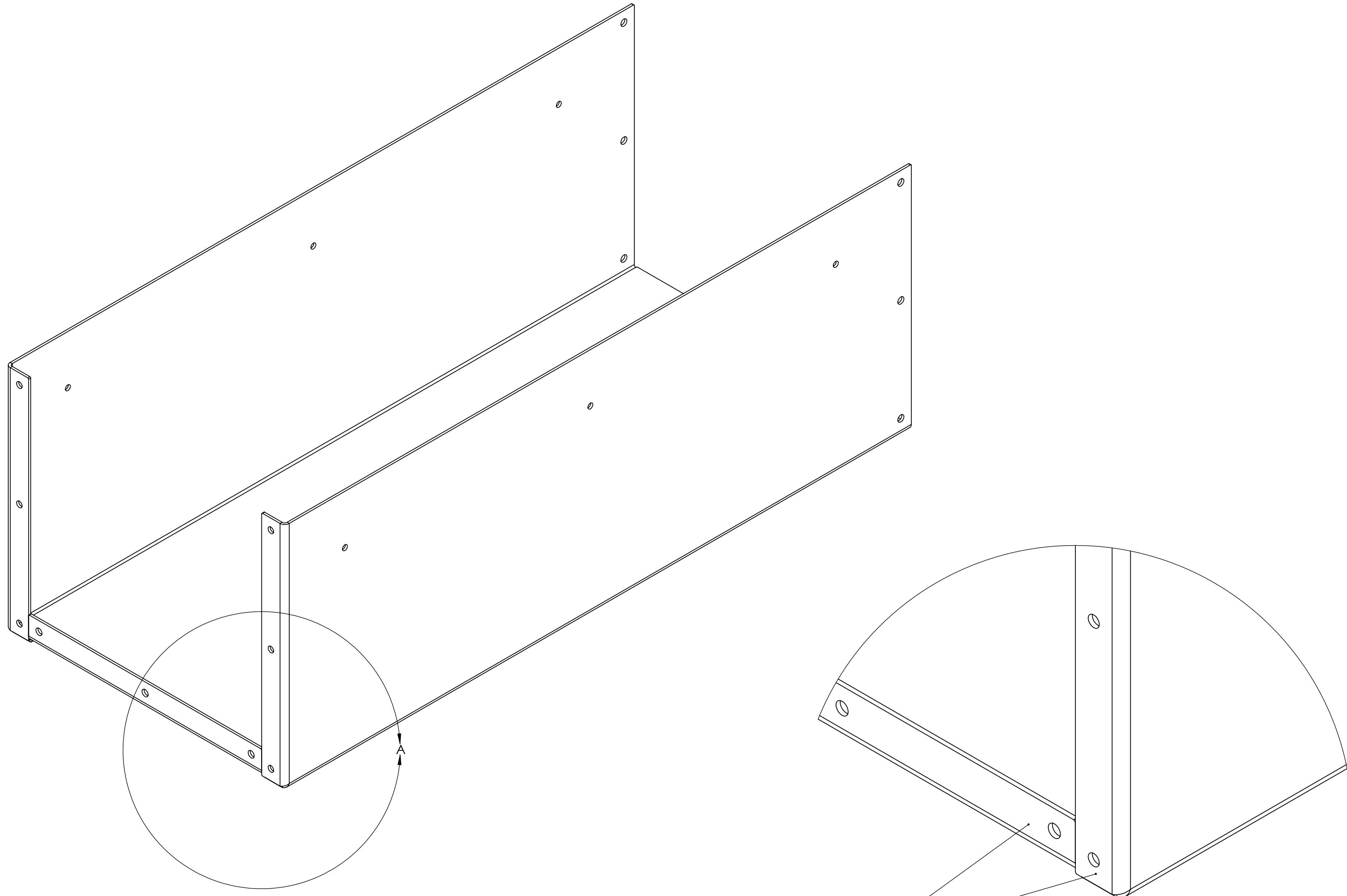
**STEP 1:**

**Start by placing the drawer bottom and the drawer sides together. The drawer bottom will sit on the bottom flanges of the drawer sides.**



**STEP 2:**

**Align the front flanges of the drawer bottom and the drawer sides. Use a clamp or clamps to hold the pieces in place temporarily.**

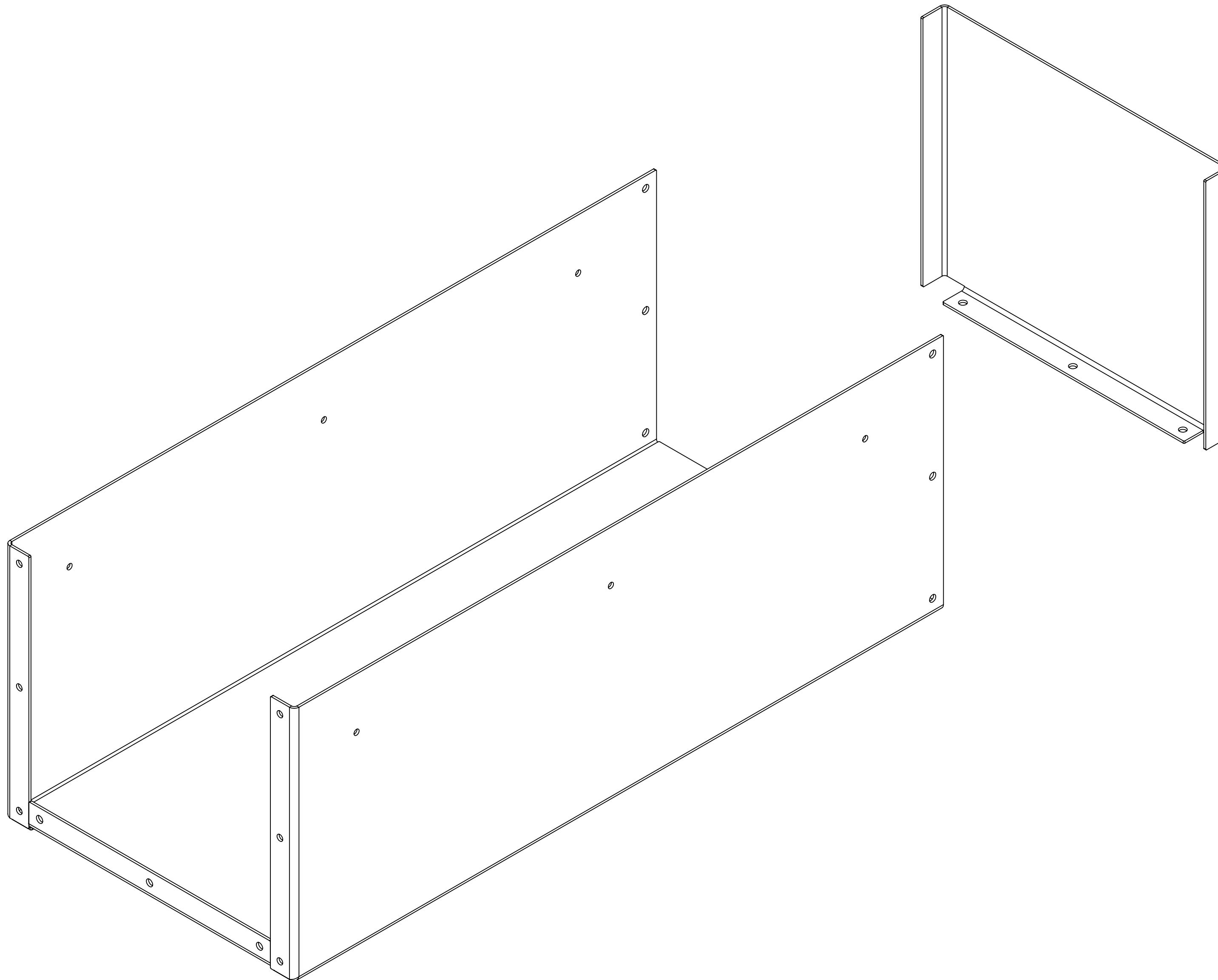


**Flanges should be flush to each other.**

DETAIL A  
SCALE 1 : 1

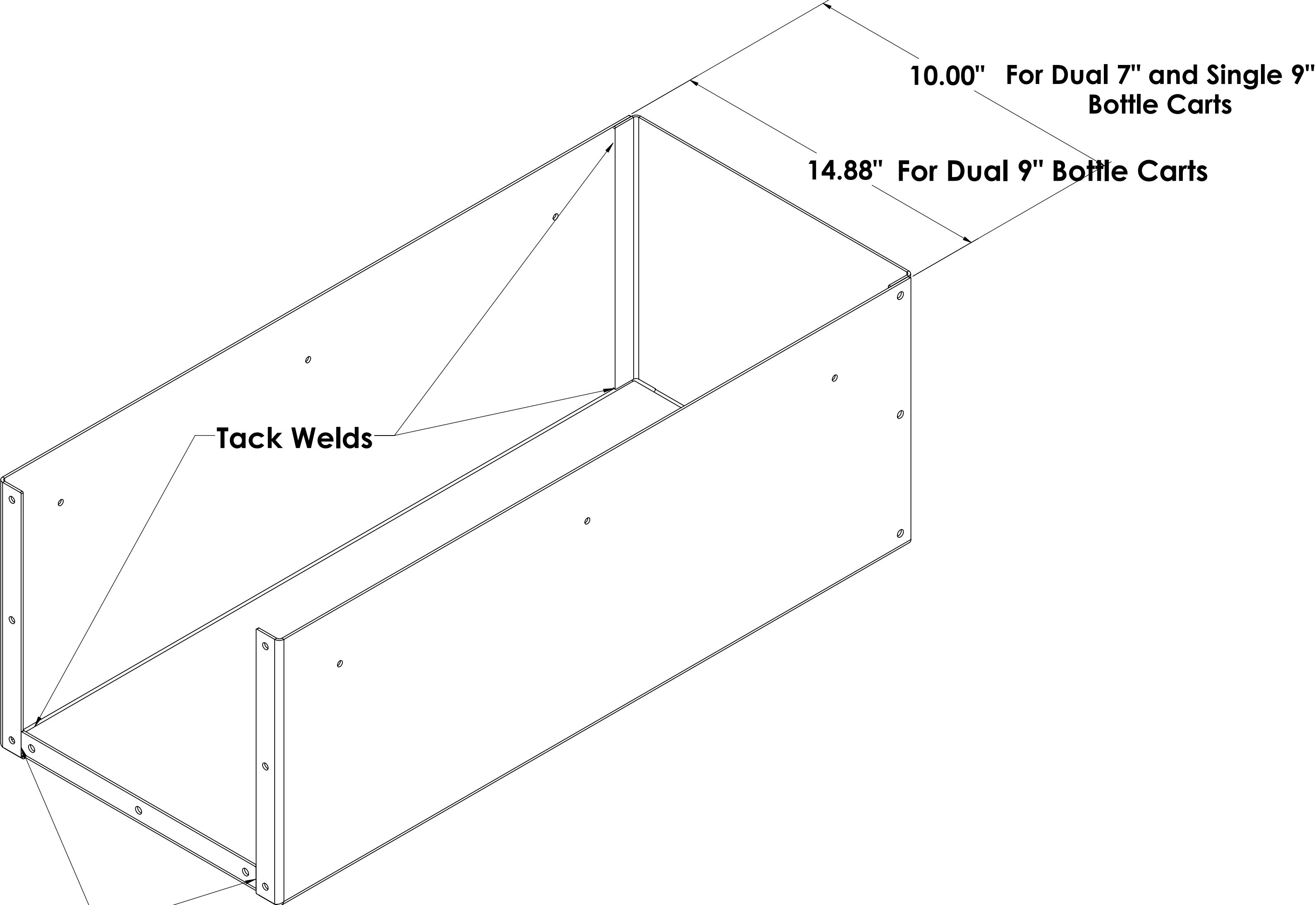
**STEP 3:**

**Place the Drawer Back into position by putting the bottom flange underneath the drawer bottom and the side flanges inside the drawer sides.**



**STEP 4:**

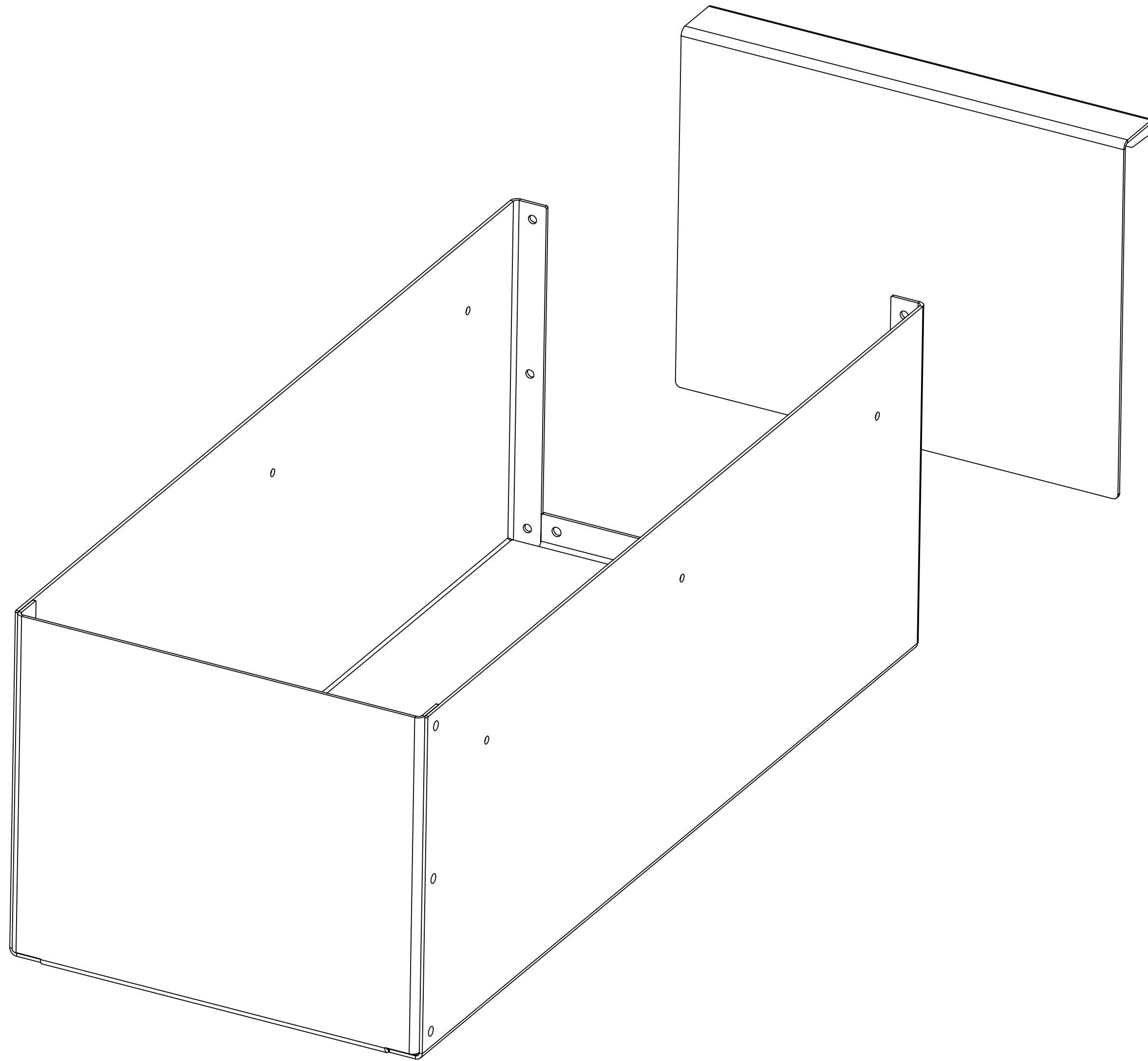
Use a clamp or clamps to keep the drawer back in place temporarily. Verify that the drawer measures 10" wide (outside) for Dual 7" and Single 9" Carts and 14.875" for Dual 9" Bottle Carts. Make sure that the sides are square to the bottom. Place tack welds to secure the sides to the drawer bottom and back.



**NO welds on the face**

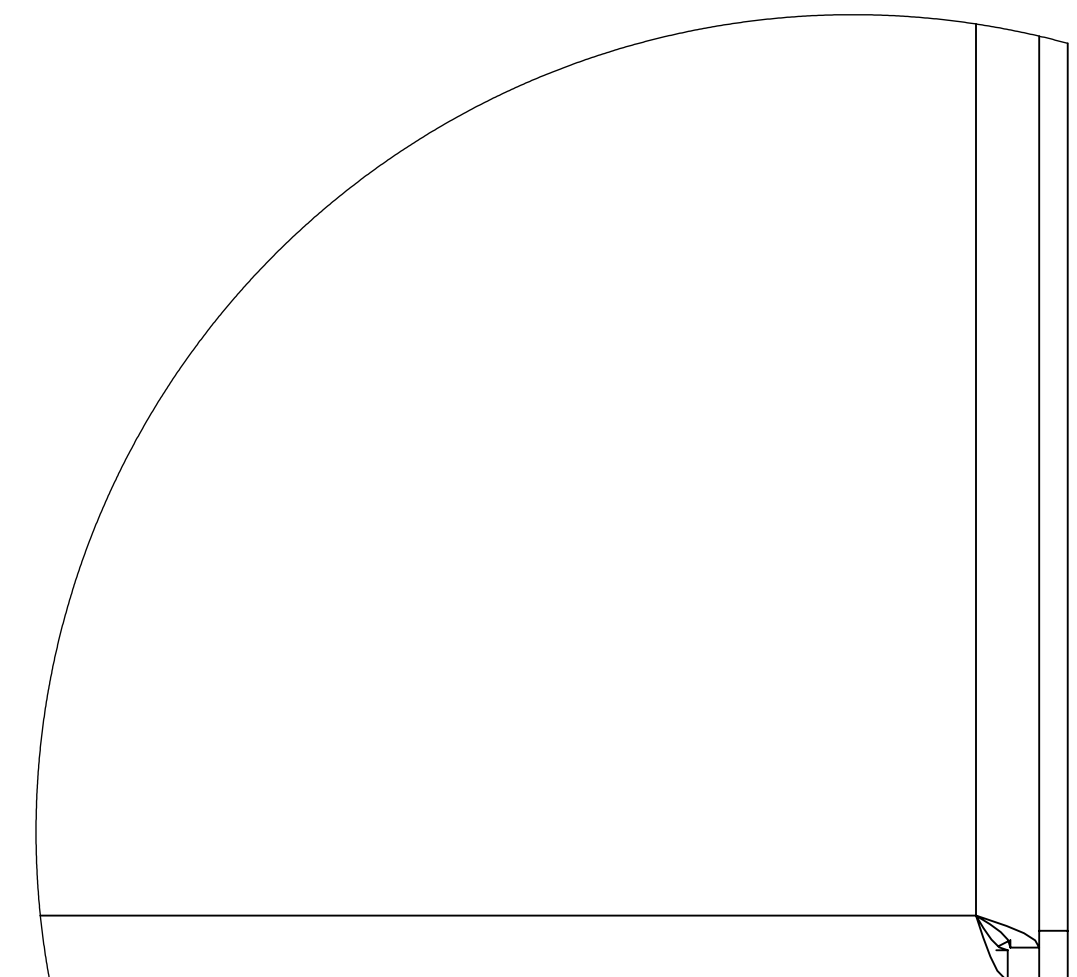
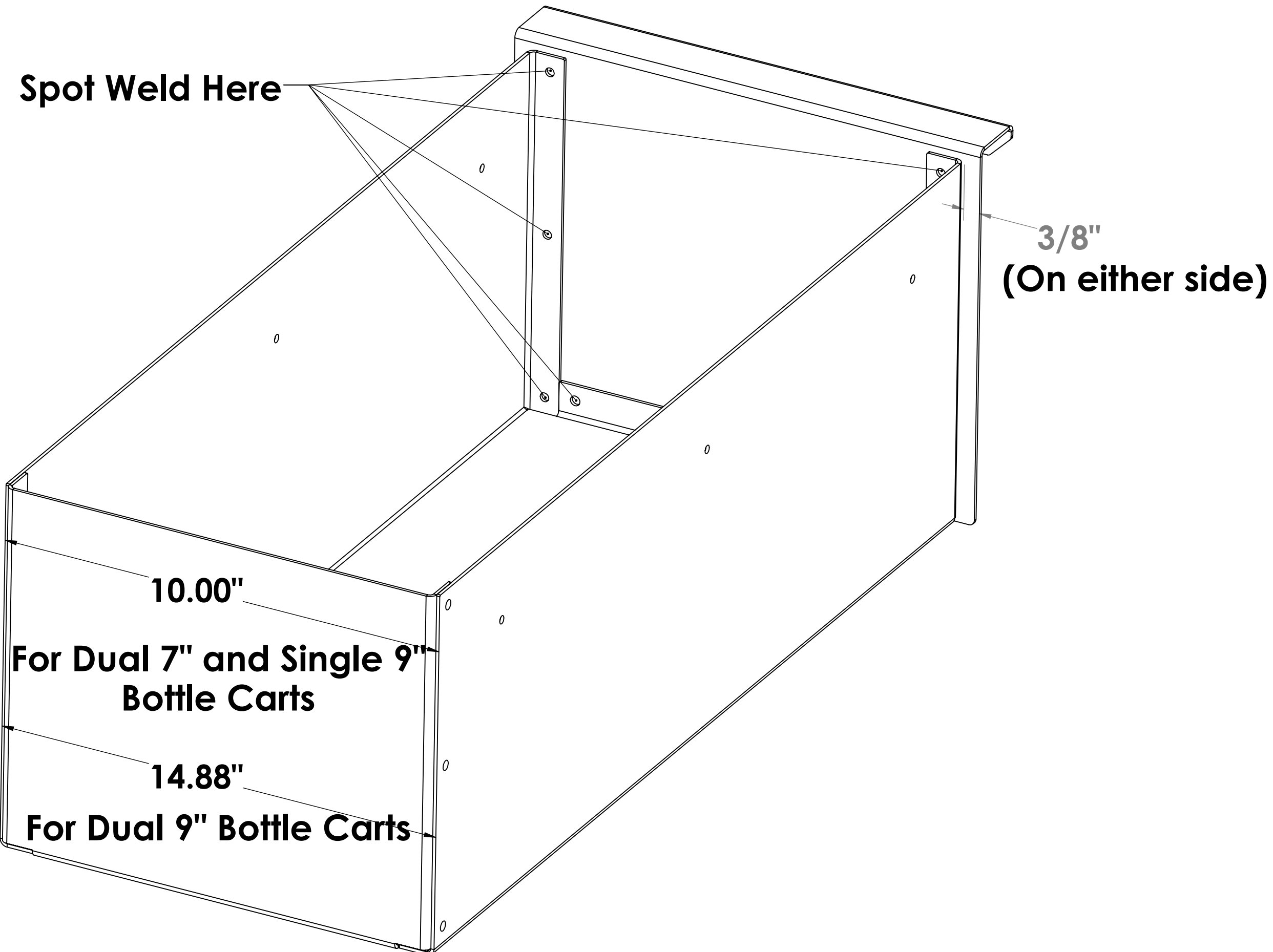
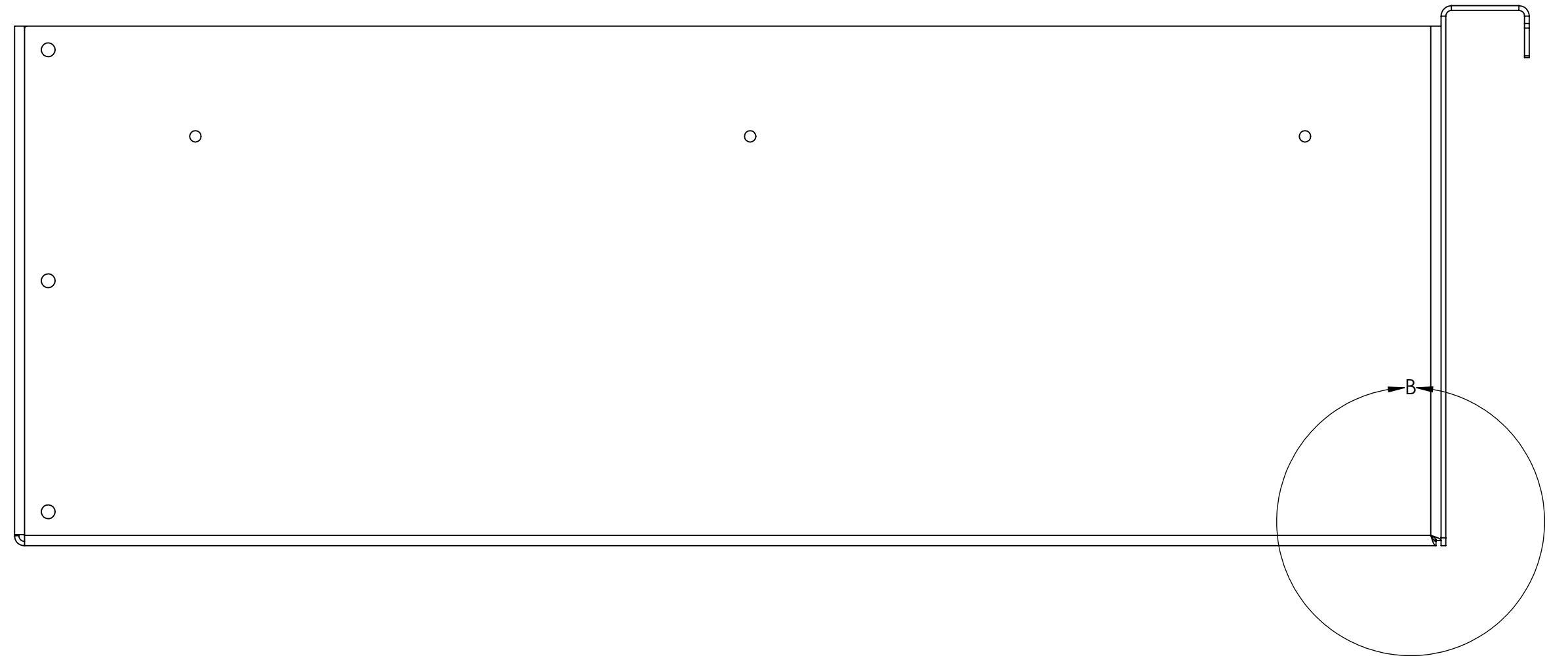
**STEP 5:**

**Place the Drawer Front against the 3 flanges. Make sure the bottom edge of the drawer front is flush to the Drawer bottom and does not hang below it.**



**STEP 6:**

**Double check that the drawer is still the correct outside width and that the drawer front is centered. Use a clamp or clamps to keep the drawer front in place and spot weld the drawer front using the provided holes**



DETAIL B  
SCALE 2 : 1

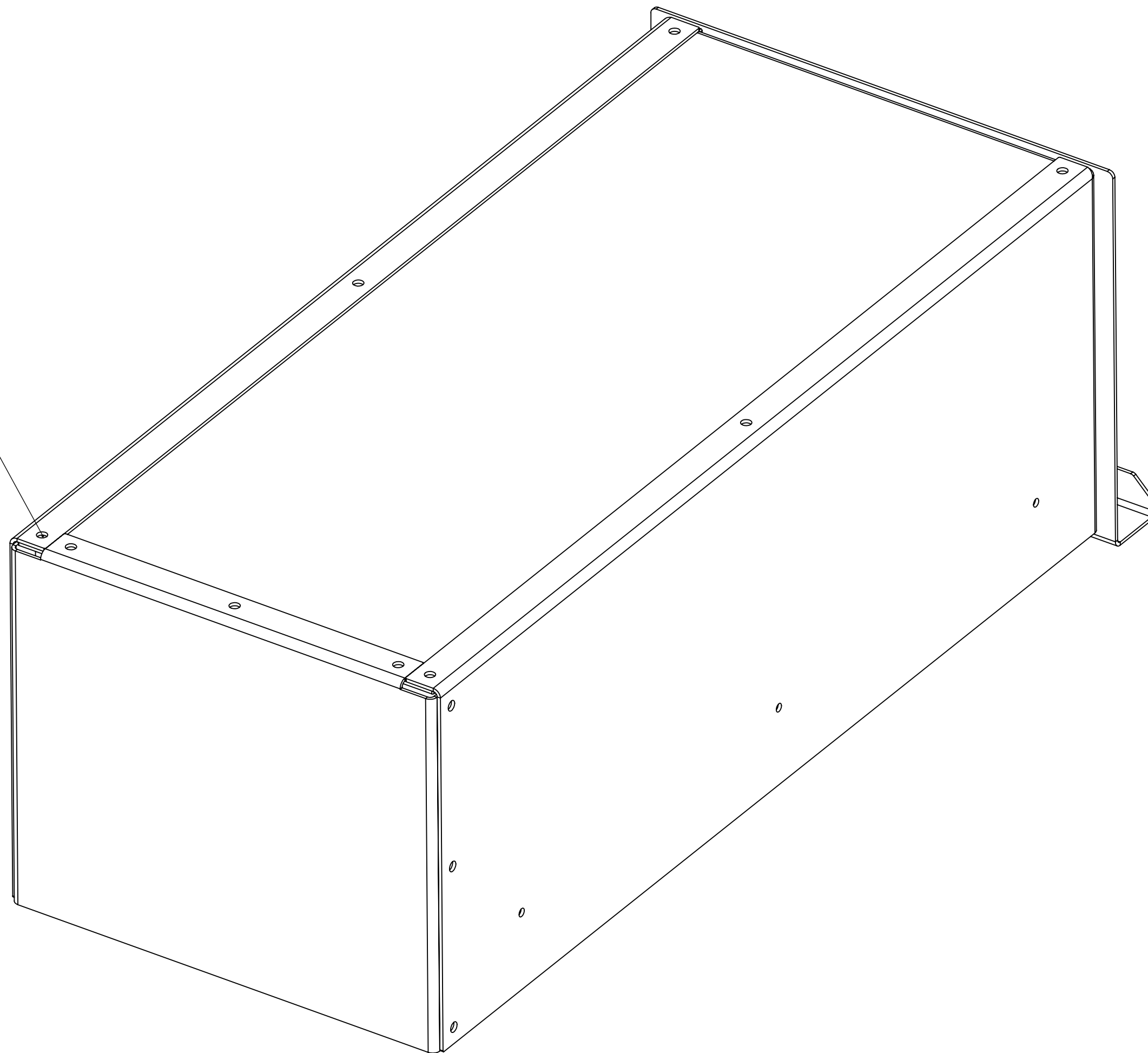
**Flush to bottom**



**STEP 7:**

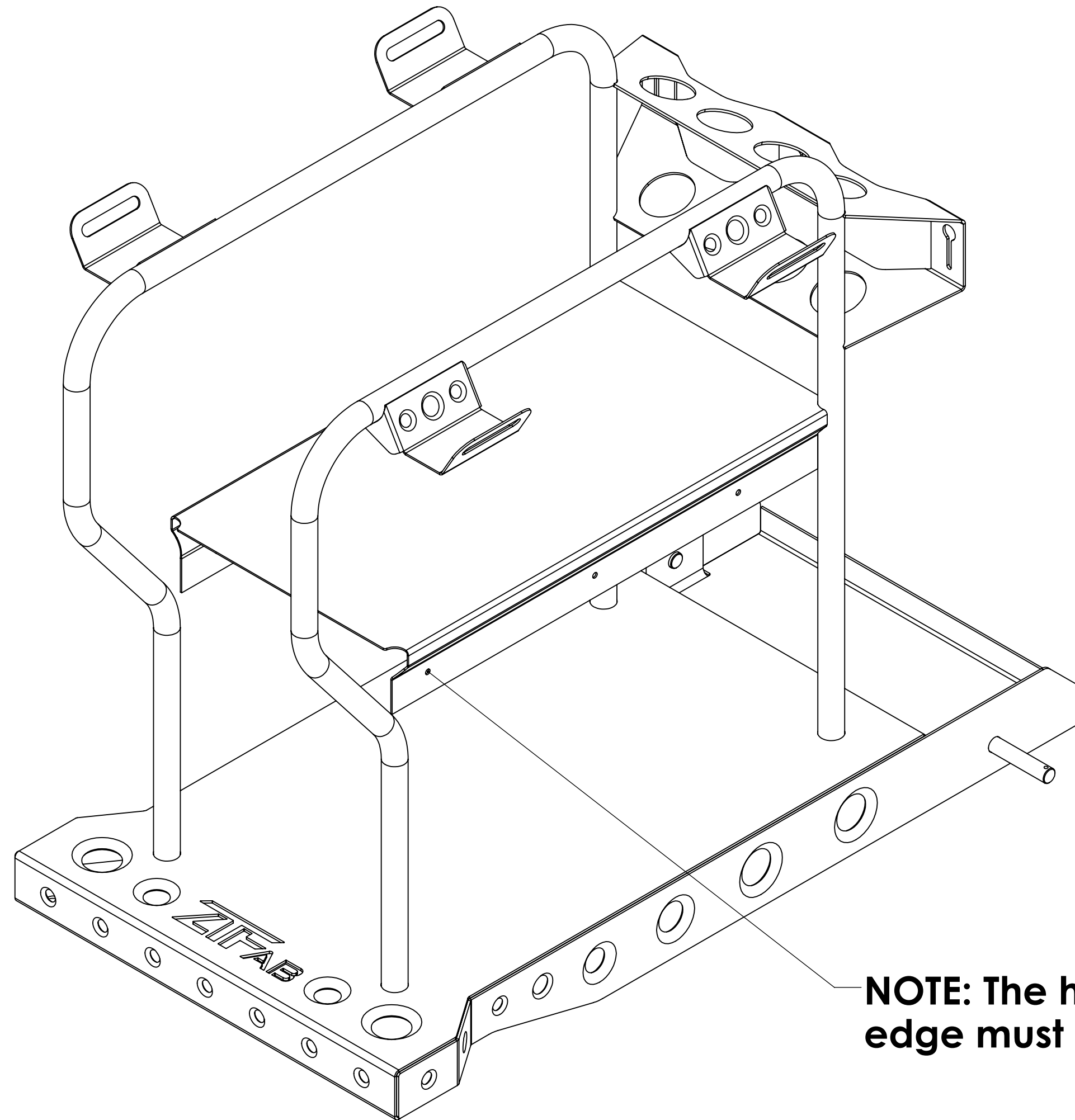
**Turn the drawer upside down and spot weld all the panels through the provided holes. Make sure all panels are butted up tight against the flanges with spot weld holes before welding.**

**Spot Weld  
All Holes**



**STEP 8:**

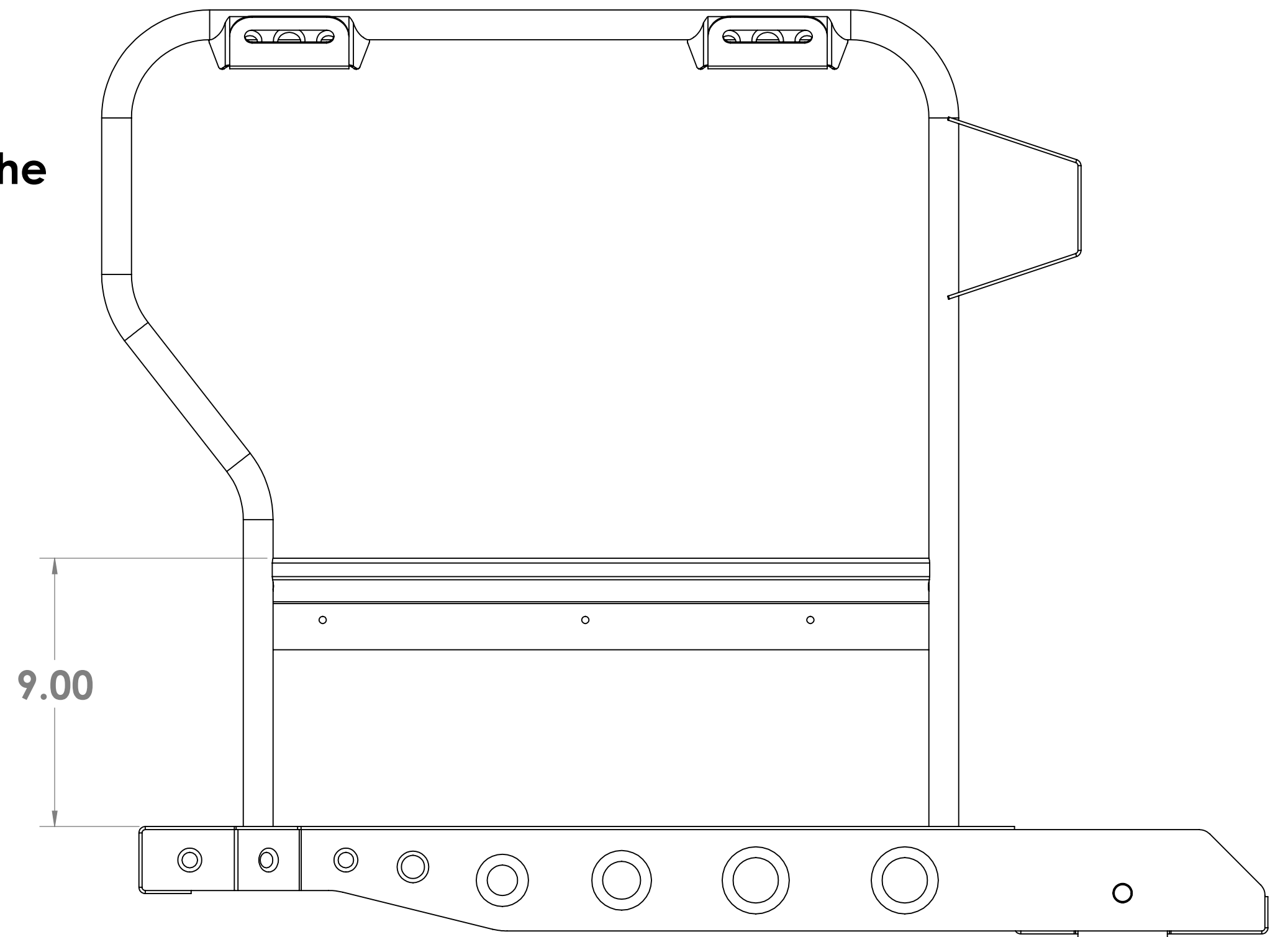
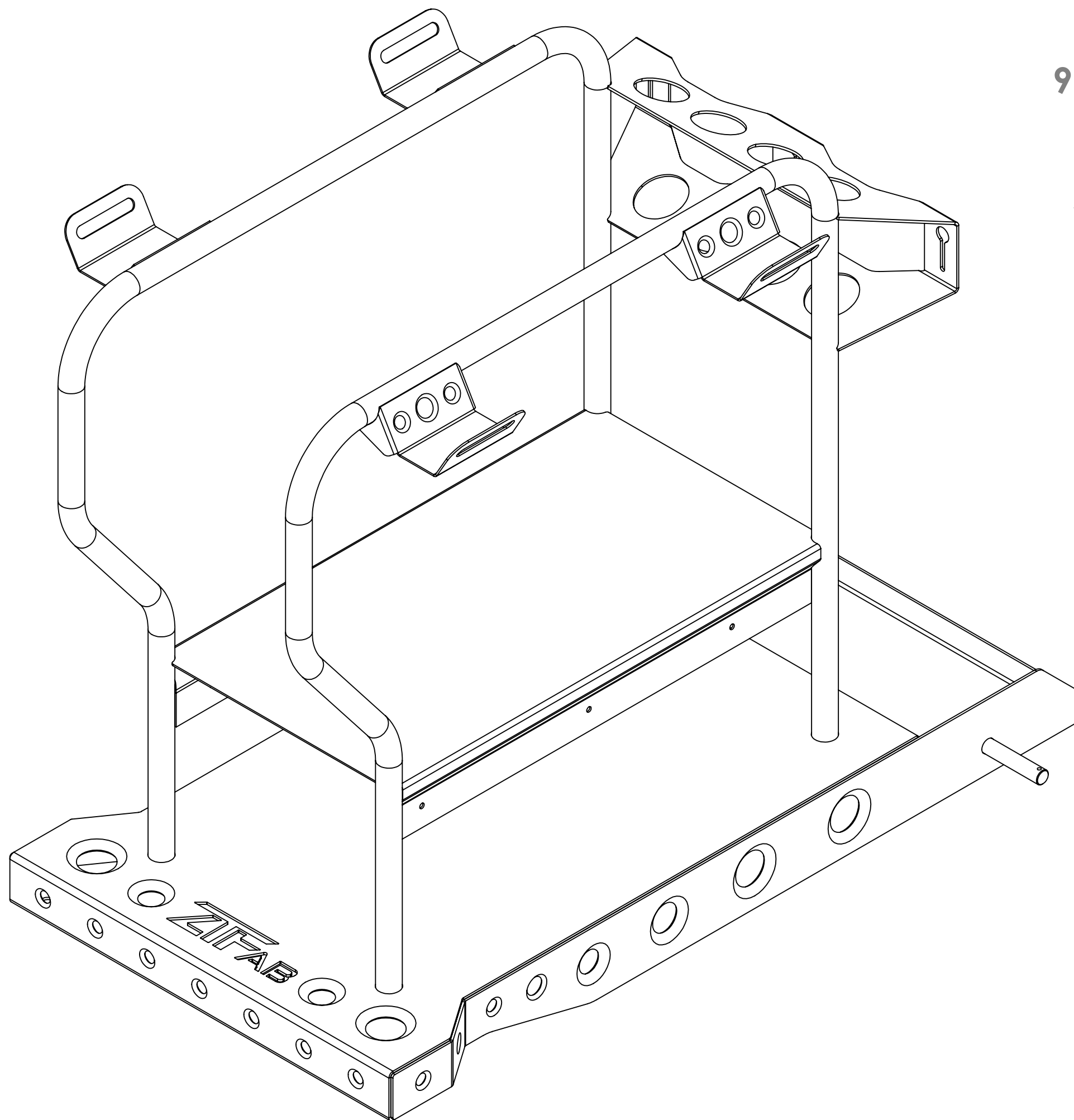
**Place the Top Shelf on your welding cart. Pay attention to the drawer slide mounting holes and position the holes closest to the edge towards the front. The shelf will sit 9" above the base of your cart.**



**NOTE: The hole closest to the edge must be in the front.**

**STEP 9:**

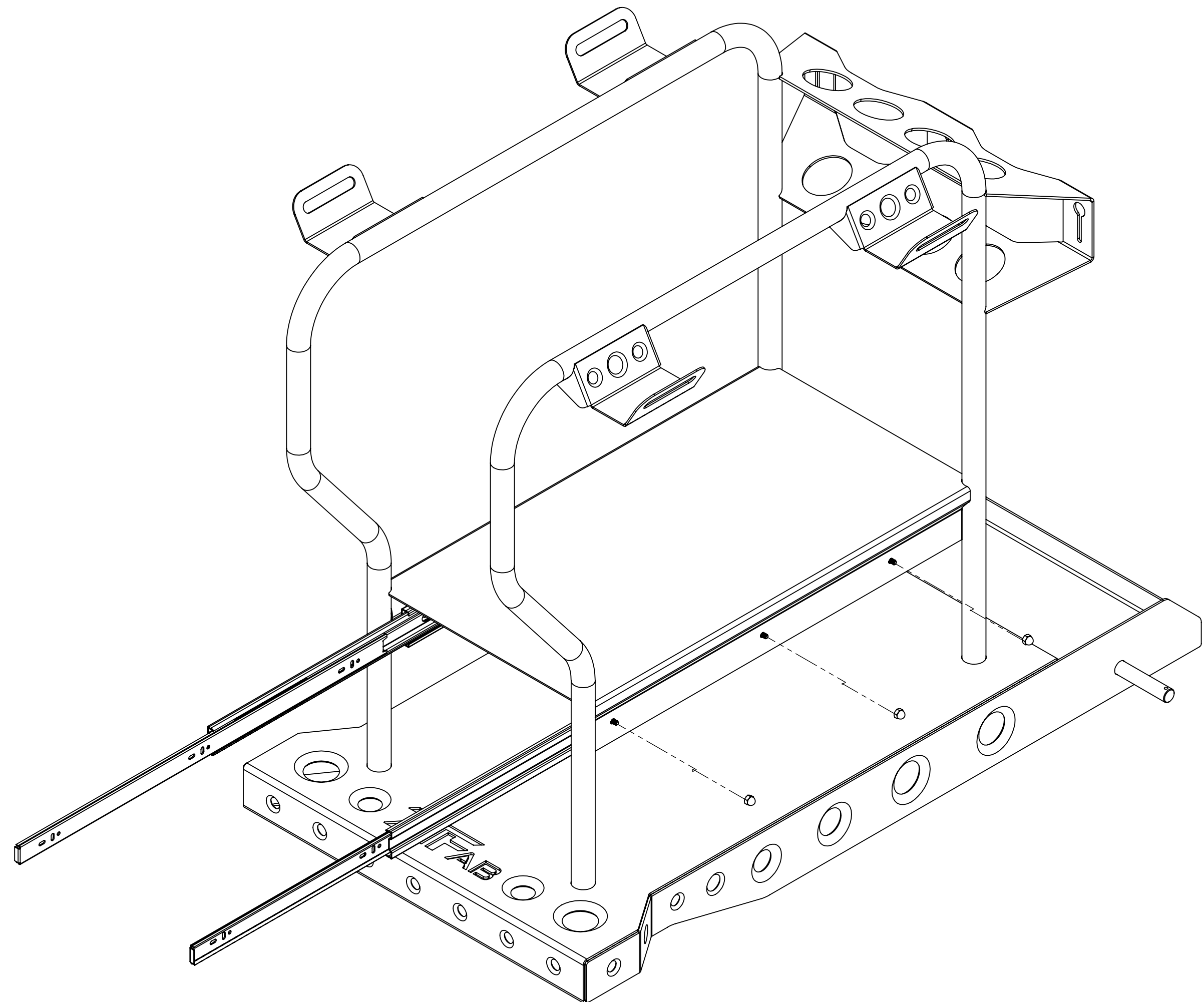
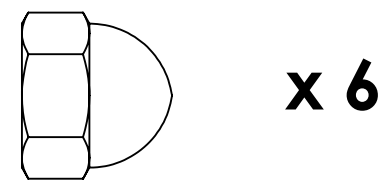
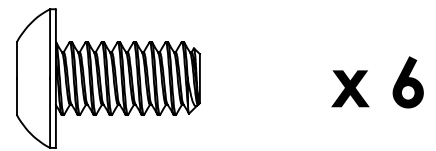
**Measure from the top of the base to the top of the shelf. Move the shelf until it is at 9" and level.**



**Use clamps or spacers to keep the shelf in position. Tack weld the shelf to the tubes.**

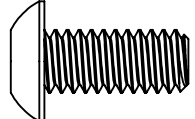
**STEP 10:**

**Test fit the drawer in the shelf by installing the drawer slides. Use the supplied 10-24 Stainless Steel bolts, Lock washers, and Acorn nuts to secure the drawer slide to the shelf. Place the lockwasher on the bolt then put bolt through the drawer slide and then through the shelf. Screw on the acorn nut and tighten once all bolts are in place.**

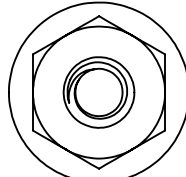


**STEP 11:**

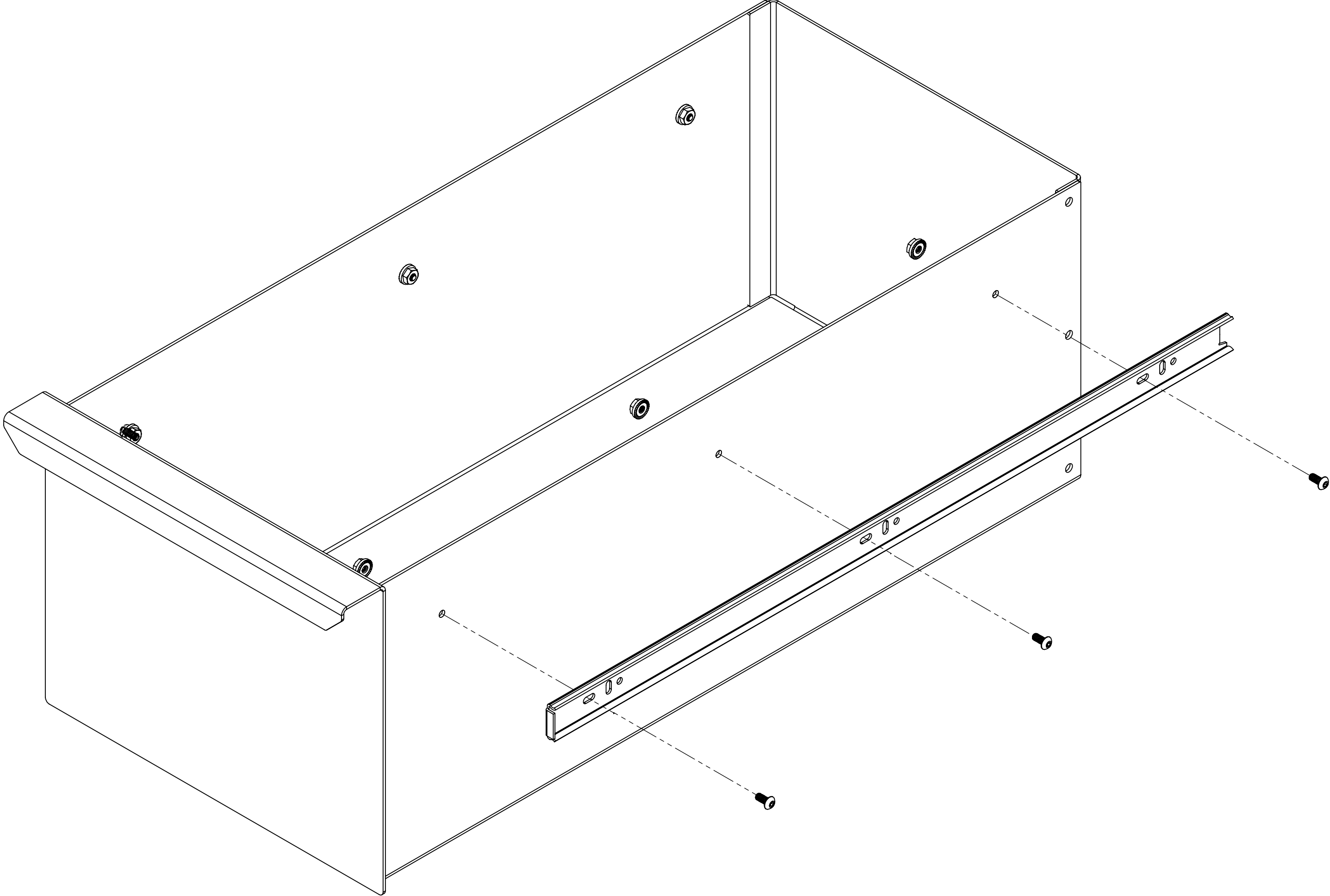
**With the drawer slides open, locate the black plastic release lever on the slide. Move the lever to release the drawer mount. Bolt the drawer mount to the drawer with the supplied 8-32 Stainless Steel Bolts and Flange Nuts.**



**x 6**



**x 6**



**STEP 12:**

**Insert the drawer into the drawer slides and check fitment. Adjust the drawer mounts if necessary. Remove the drawer and slides in the reverse order and finish weld the shelf to the tubes.**

