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(ASSEMBLY MANUAL FOR MODULAR
WORK TABLES AND ACCESSORIES)

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NOTE TO ASSEMBLER / INSTALLER:

- ASSEMBLY MANUAL INCLUDES ALL OF THE UNITS THAT NEED TO BE ASSEMBLED FOR THE SOLUTIONS SERIES.
- WHEN ASSEMBLING YOUR SOLUTION SERIES FURNITURE FOLLOW THE ORDER OF THE TABLE OF CONTENTS AND SKIP THE STEPS THAT DO NOT PERTAIN TO YOUR ORDER

LEG INSERT PANEL ASSEMBLY INSTRUCTIONS

• **SKIP THIS STEP IF YOUR TABLES WERE PURCHASED WITHOUT LEG INSERT PANELS.**

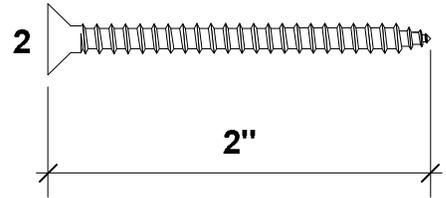
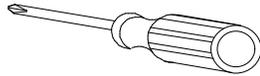
NOTES TO CUSTOMER:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.

LEG INSERT PANEL / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1	1	LEG INSERT PANEL	24 15/32	10 15/32	334310 (COLOR)
	1	HARDWARE PACK (PARTS LISTED BELOW)			90680000
2	4	#10 X 2 FLAT HEAD SCREW			60651655

TOOLS REQUIRED:
- Phillips Tip Screwdriver

Note: Power Driver can be used for the assembly of this unit.



1. Insert leg insert panel into leg assembly. (Caution: leg insert panel must be inserted evenly) Attach leg assembly to insert panel using #10 x 2" flat head screws (2). See figure 1.

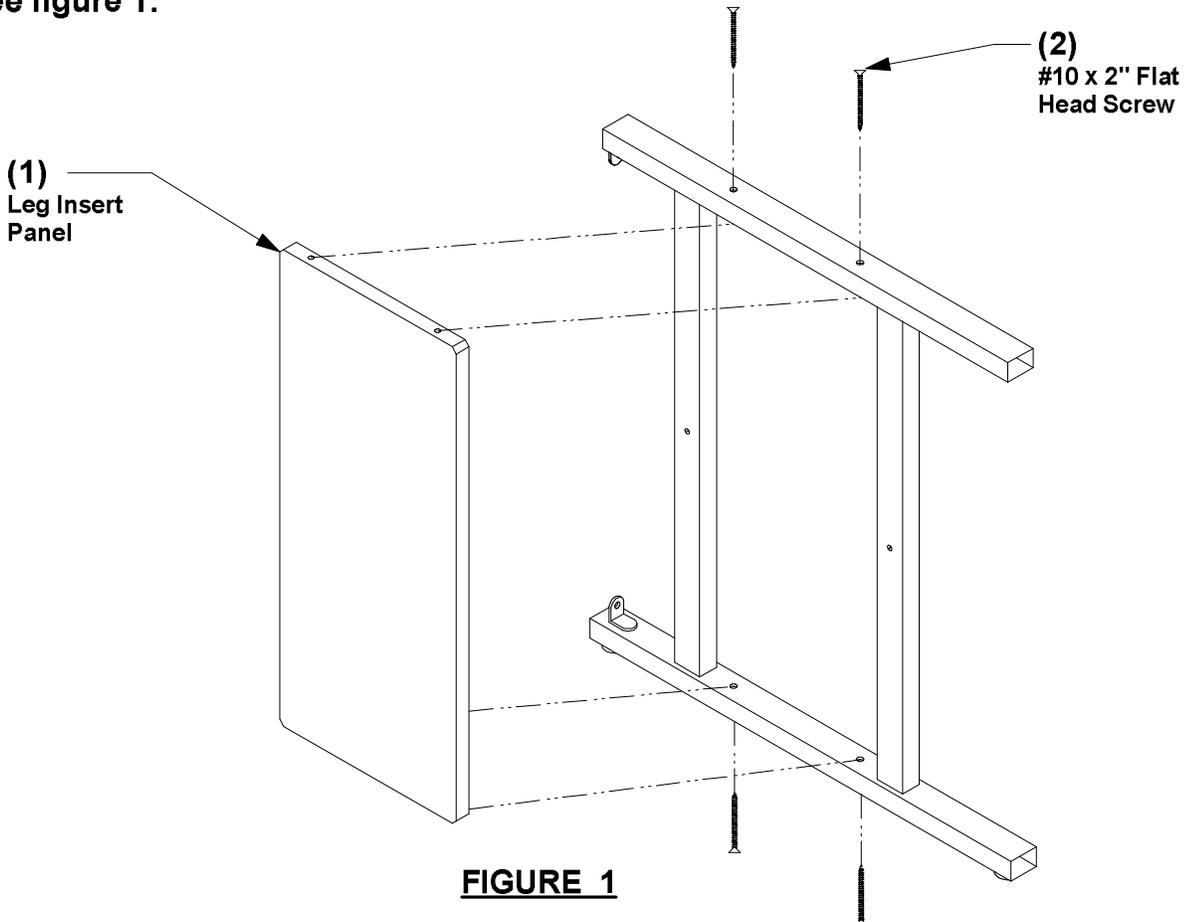
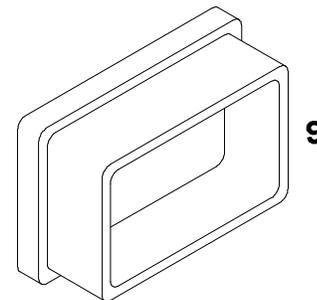
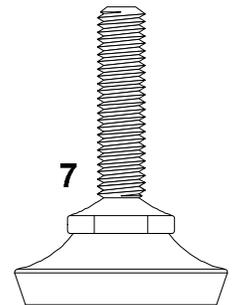
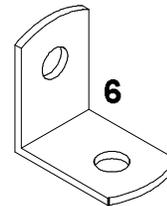
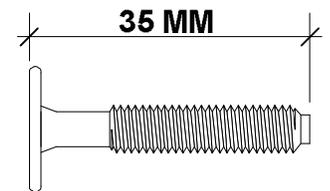
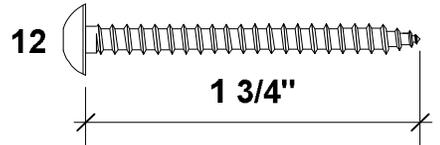
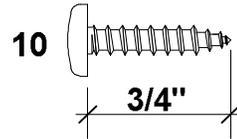
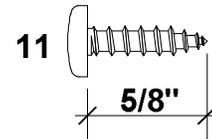


FIGURE 1

RECTANGULAR MODULAR WORK TABLES ASSEMBLY INSTRUCTIONS

NOTES TO CUSTOMERS:

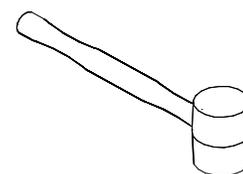
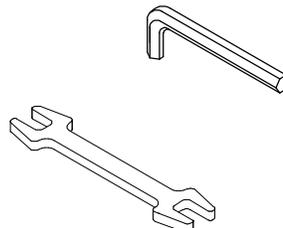
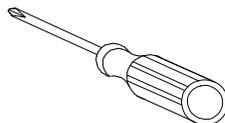
- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- EXTRA PARTS THAT MAY BE INCLUDED IN THE HARDWARE PACKS CAN BE IGNORED.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.
- PARTS LIST INCLUDES ALL SIZES OF TOPS, BACKS, AND TROUGHS FOR RECTANGULAR MODULAR WORK TABLES
- ILLUSTRATIONS IN THE ASSEMBLY INSTRUCTIONS MAY BE FOR A DIFFERENT SIZE TABLE, DEPENDING ON WHICH TABLE HAS BEEN ORDERED. (ALL SIZES OF TABLES USE THE SAME ASSEMBLY PROCEDURES)



RECTANGULAR MODULAR WORK TABLES / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1a	1	TOP	36	30	334090 (COLOR)
1b	1	TOP	42	30	334730 (COLOR)
1c	1	TOP	48	30	334100 (COLOR)
1d	1	TOP	60	30	334110 (COLOR)
2a	1	BACK	36	28 1/2	334130 (COLOR)
2b	1	BACK	36	40 1/2	334140 (COLOR)
2c	1	BACK	36	46 1/2	334150 (COLOR)
2d	1	BACK	42	28 1/2	334740 (COLOR)
2e	1	BACK	42	40 1/2	334750 (COLOR)
2f	1	BACK	42	46 1/2	334760 (COLOR)
2g	1	BACK	48	28 1/2	334160 (COLOR)
2h	1	BACK	48	40 1/2	334170 (COLOR)
2i	1	BACK	48	46 1/2	334180 (COLOR)
2j	1	BACK	60	28 1/2	334190 (COLOR)
2k	1	BACK	60	40 1/2	334200 (COLOR)
2l	1	BACK	60	46 1/2	334210 (COLOR)
3a	1	TROUGH	34		11609006
3b	1	TROUGH	40		11621006
3c	1	TROUGH	46		11610006
3d	1	TROUGH	58		11611006
4	2	LEG ASSEMBLY			90960006
	1	HARDWARE PACK (PARTS LISTED BELOW)			90678000
5	2	MENDING PLATE			11608006
6	5	ANGLE BRACKET			70745000
7	4	ADJUSTABLE GLIDE (1 1/8 DIA. X 3/8 X 1)			73464000
8	1	GROMMET (3" ROUND)			70785006
9	6	TUBE CAP (1 1/2 X 1) 16GA			73194006
10	4	#10 X 3/4 PAN HEAD SCREW			60650855
11	15	#10 X 5/8 PAN HEAD SCREW			60651555
12	6	#10 X 1 3/4 TRUSS HEAD SCREW			60652155
13	4	1/4-20 FLANGE LOCK NUT			60780755
14	4	1/4-20 X 35 MM BOLT			61261006

TOOLS REQUIRED:

- Phillips Tip Screwdriver
- 7/16" Wrench
- 5/32" Allen Wrench
- Rubber Mallet



Note: Power Driver can be used for the assembly of this unit.

1. Insert tube caps (9) into leg assemblies (4) (Note: 3 tube caps per leg assembly). Thread adjustable glides (7) into leg assemblies (4). See figure 1.
2. Place top (1) on a cushioned surface with face side down. Attach angle brackets (6) to rear edge of top (1) using #10 x 5/8" pan head screws (11). Attach leg assemblies (4) to top (1) using #10 x 1 3/4" truss head screws (12). See figure 1.

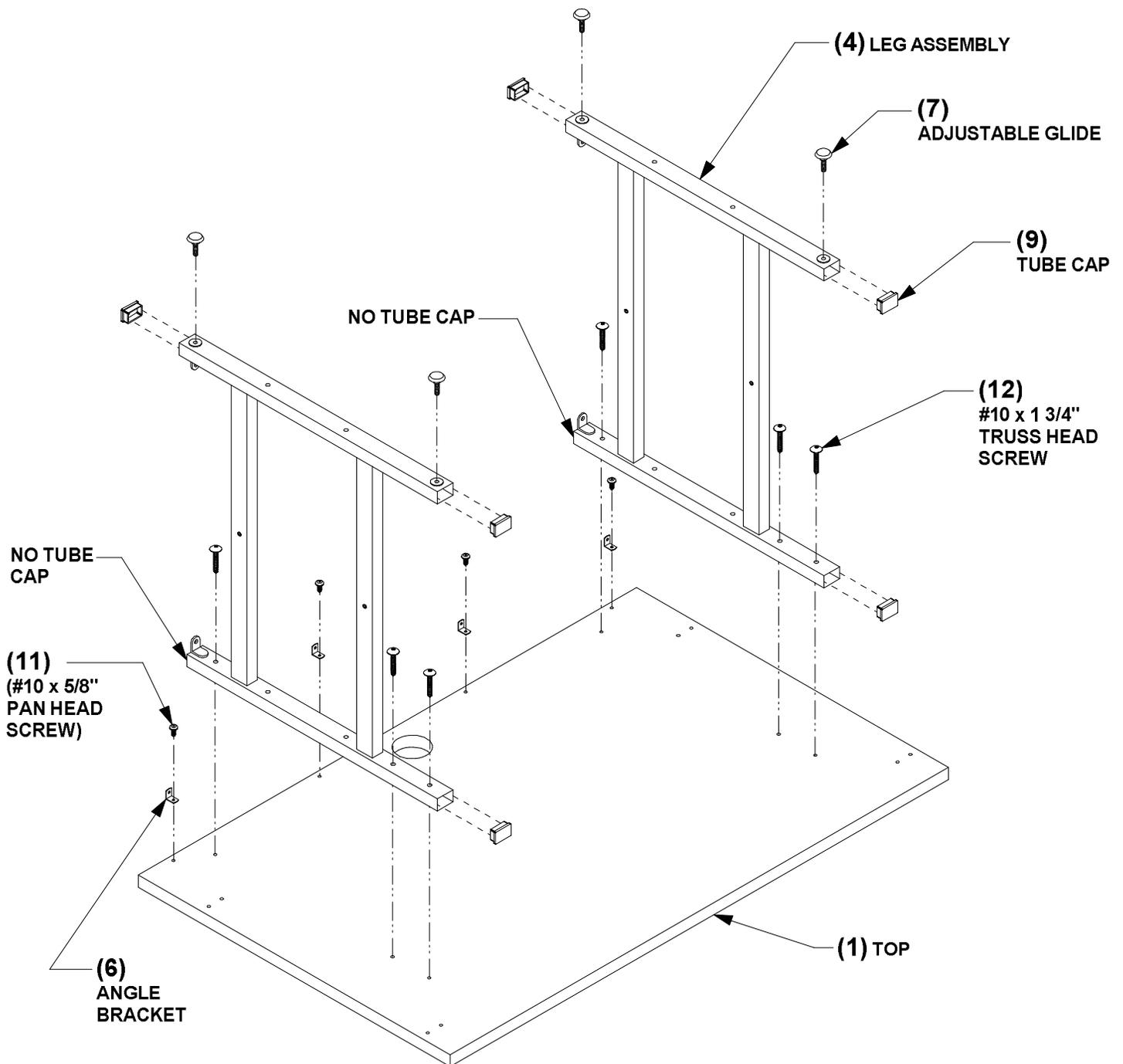


FIGURE 1

3. With two people upright this portion of the table. **Caution: DO NOT** move table until back has been installed. See figure 1A.

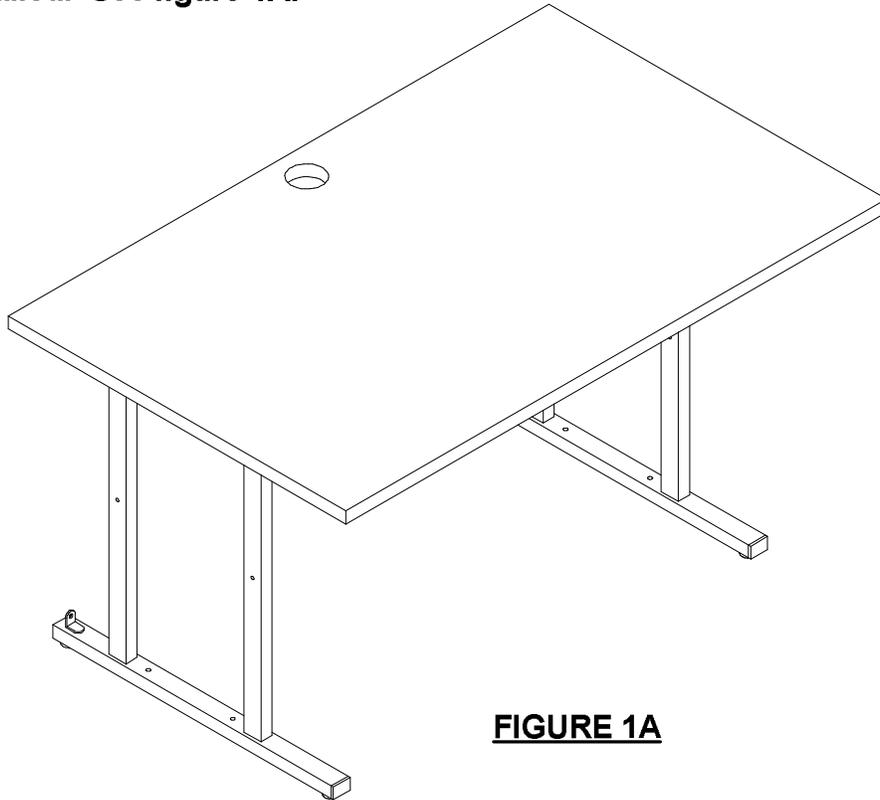


FIGURE 1A

4. Attach trough (3) to back (2) using #10 x 5/8" pan head screws (11). See figure 2.

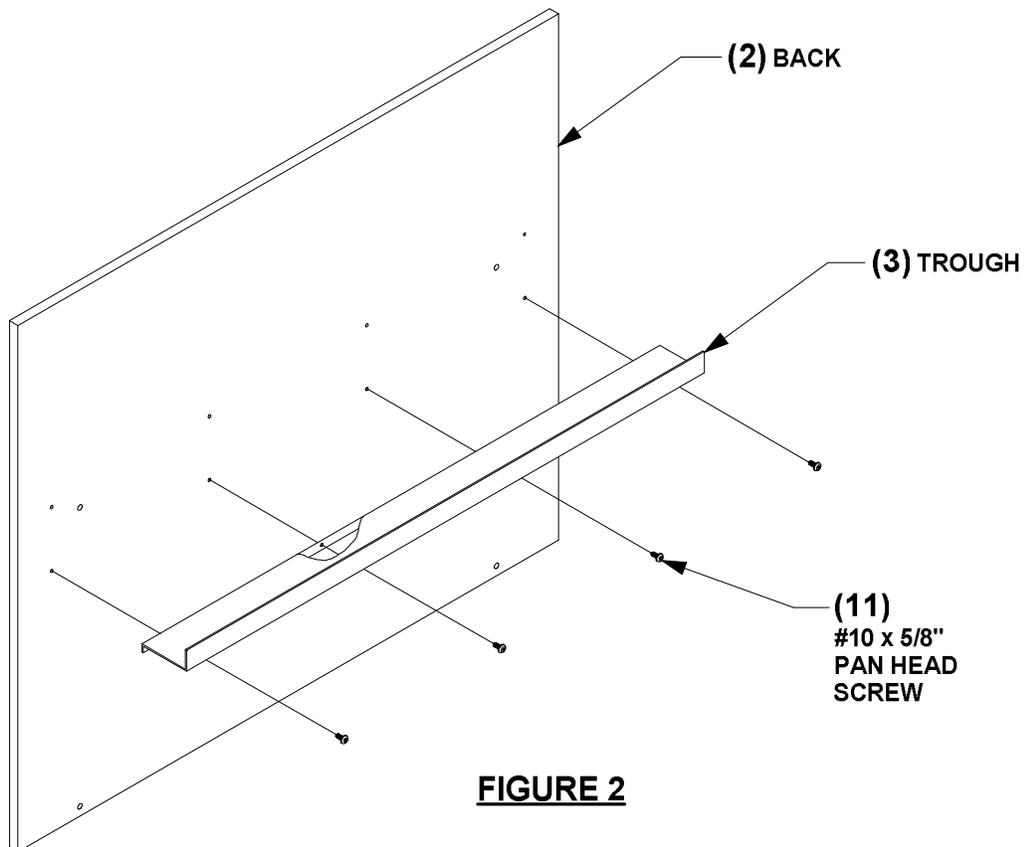


FIGURE 2

5. Attach back (2) to table using 1/4-20 x 35 mm bolts (14) and 1/4-20 flange lock nuts (13). See figure 3.

6. Attach angle brackets (6) to back (2) using #10 x 5/8" pan head screws (11).

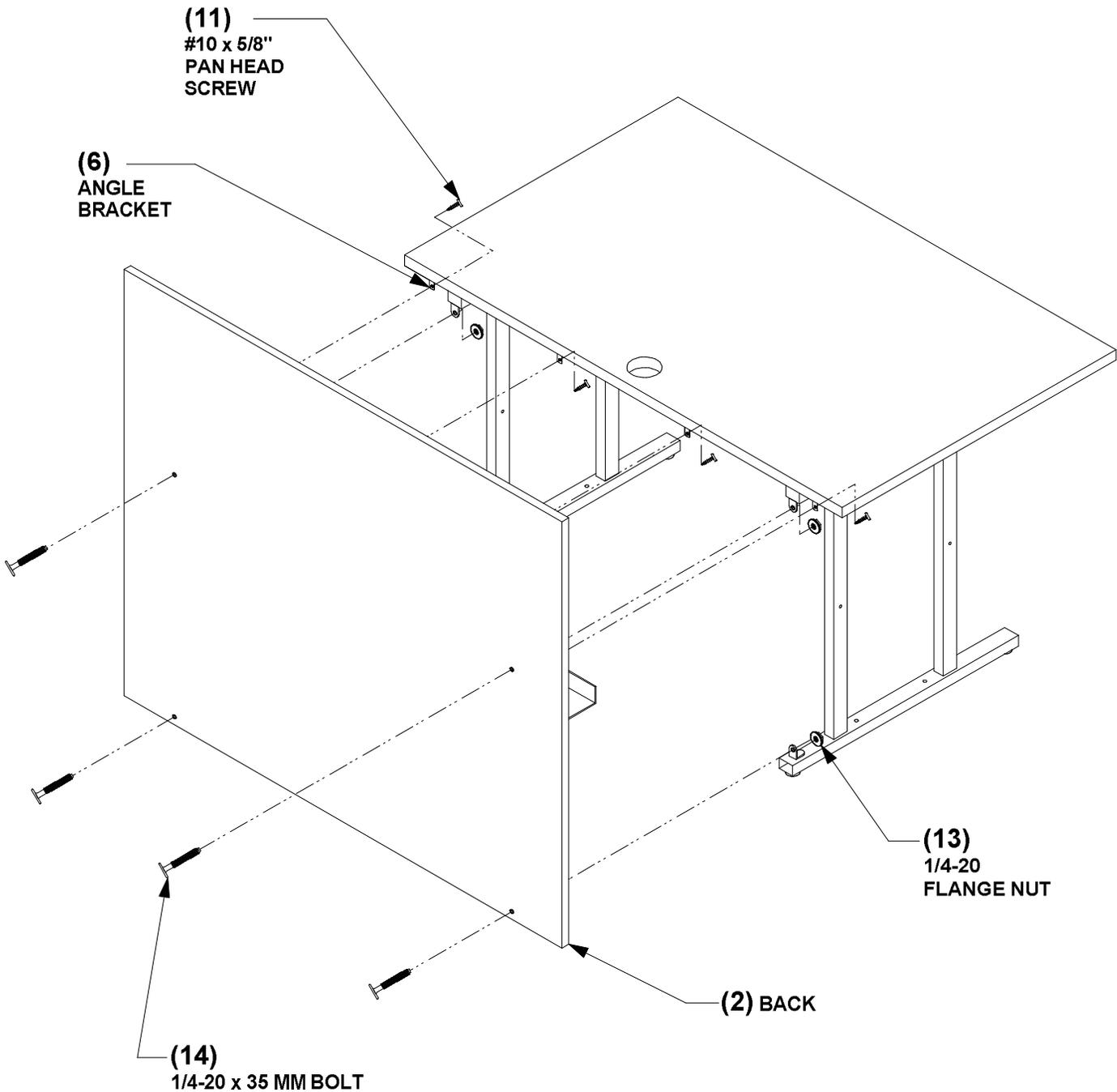


FIGURE 3

7. Insert grommet (8) into top (1). Level table with adjustable glide (7). See figure 4.

Skip the next step if your tables are not arranged together.

8. Connect tops (1) together using mending plates (5) and #10 x 3/4" pan head screws (10). See figure 4.

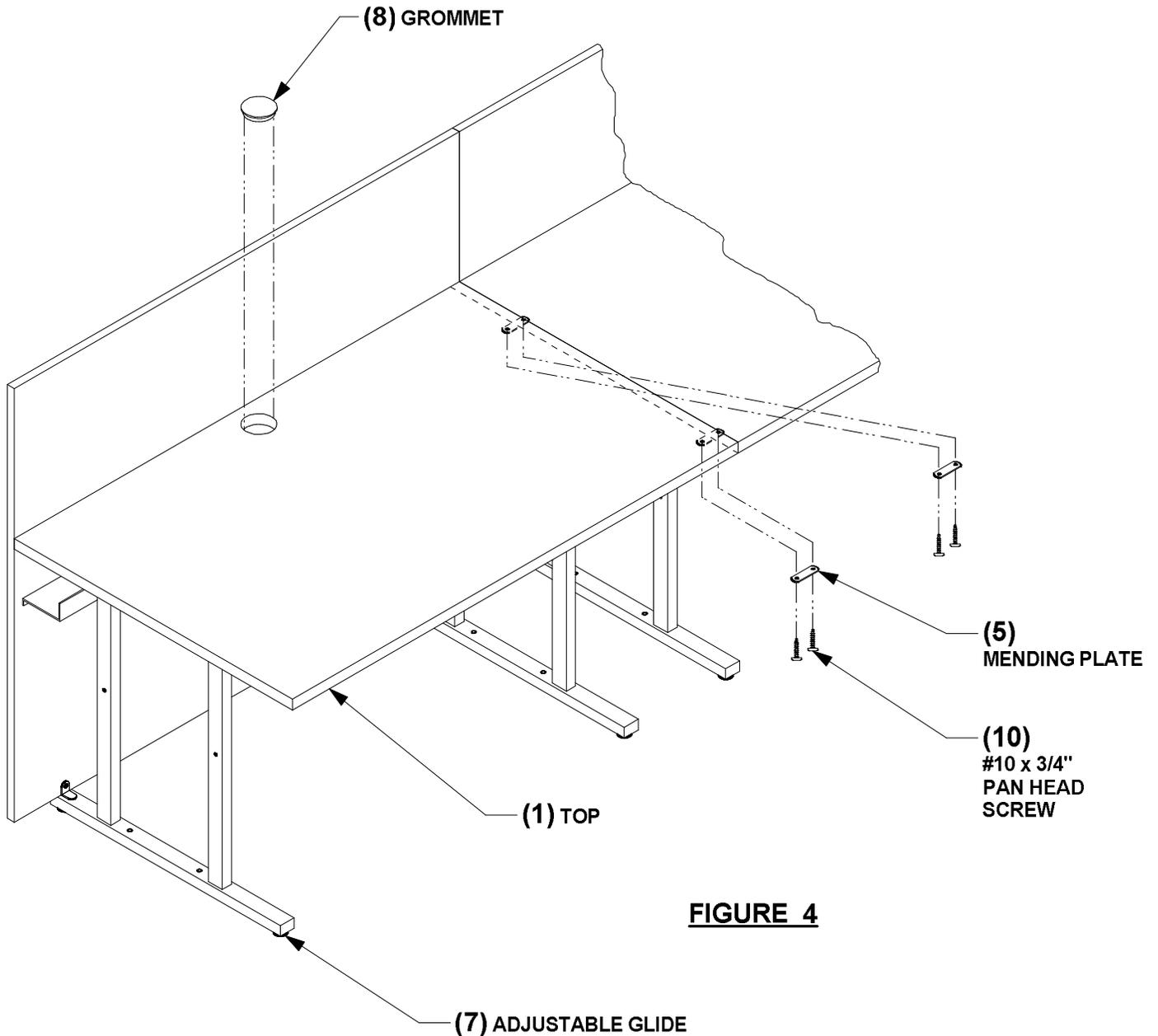
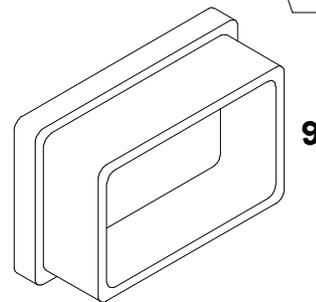
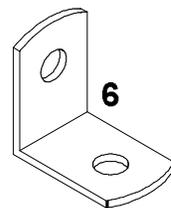
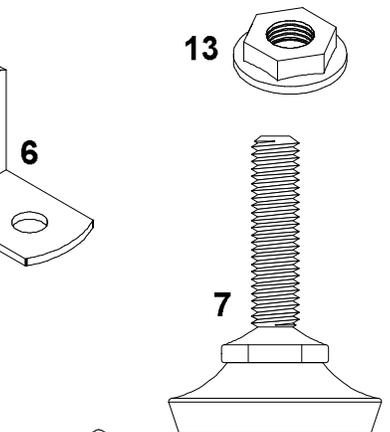
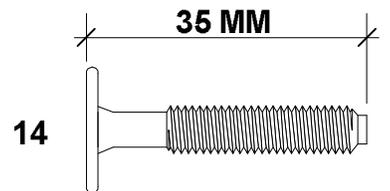
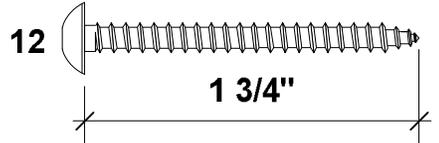
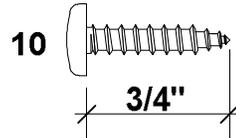
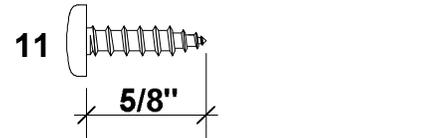


FIGURE 4

CORNER MODULAR WORK TABLES ASSEMBLY INSTRUCTIONS

NOTES TO CUSTOMERS:

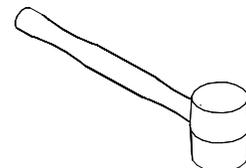
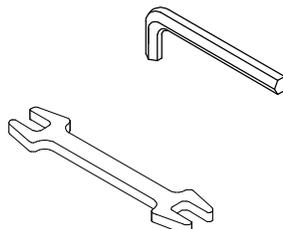
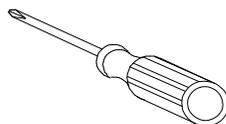
- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- EXTRA PARTS THAT MAY BE INCLUDED IN THE HARDWARE PACKS CAN BE IGNORED.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.
- PARTS LIST INCLUDES ALL SIZES OF BACKS FOR CORNER MODULAR WORK TABLES
- ILLUSTRATIONS IN THE ASSEMBLY INSTRUCTIONS MAY BE FOR A DIFFERENT SIZE TABLE, DEPENDING ON WHICH TABLE HAS BEEN ORDERED. (ALL SIZES OF TABLES USE THE SAME ASSEMBLY PROCEDURES)



CORNER MODULAR WORK TABLES / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1	1	TOP	47 1/4	47 1/4	334120 (COLOR)
2a	1	BACK (LH.)	47 5/16	28 1/2	334221 (COLOR)
2aa	1	BACK (RH.)	47 5/16	28 1/2	334222 (COLOR)
2b	1	BACK (LH.)	47 5/16	40 1/2	334231 (COLOR)
2bb	1	BACK (RH.)	47 5/16	40 1/2	334232 (COLOR)
2c	1	BACK (LH.)	47 5/16	46 1/2	334241 (COLOR)
2cc	1	BACK (RH.)	47 5/16	46 1/2	334242 (COLOR)
3	2	TROUGH	42		11612006
4a	2	LEG ASSEMBLY			90960006
4b	1	LEG ASSEMBLY (CORNER)			90961006
	1	HARDWARE PACK (PARTS LISTED BELOW)			90679000
5	2	MENDING PLATE			11608006
6	8	ANGLE BRACKET			70745000
7	6	ADJUSTABLE GLIDE (1 1/8 DIA. X 3/8 X 1)			73464000
8	2	GROMMET (3" ROUND)			70785006
9	8	TUBE CAP (1 1/2 X 1) 16GA			73194006
10	4	#10 X 3/4 PAN HEAD SCREW			60650855
11	24	#10 X 5/8 PAN HEAD SCREW			60651555
12	9	#10 X 1 3/4 TRUSS HEAD SCREW			60652155
13	8	1/4-20 FLANGE LOCK NUT			60780755
14	8	1/4-20 X 35 MM BOLT			61261006

TOOLS REQUIRED:

- Phillips Tip Screwdriver
- 7/16" Wrench
- 5/32" Allen Wrench
- Rubber Mallet



Note: Power Driver can be used for the assembly of this unit.

1. Insert tube caps (9) into leg assemblies (4a, 4b) (Note: 3 tube caps per leg assembly 4a, 2 tube caps per leg assembly 4b). Thread adjustable glides (7) into leg assemblies (4a, 4b). See figure 1.
2. Place top (1) on a cushioned surface with face side down. Attach angle brackets (6) to rear edges of top (1) using #10 x 5/8" pan head screws (11). Attach leg assemblies (4a, 4b) to top (1) using #10 x 1 3/4" truss head screws (12). See figure 1.

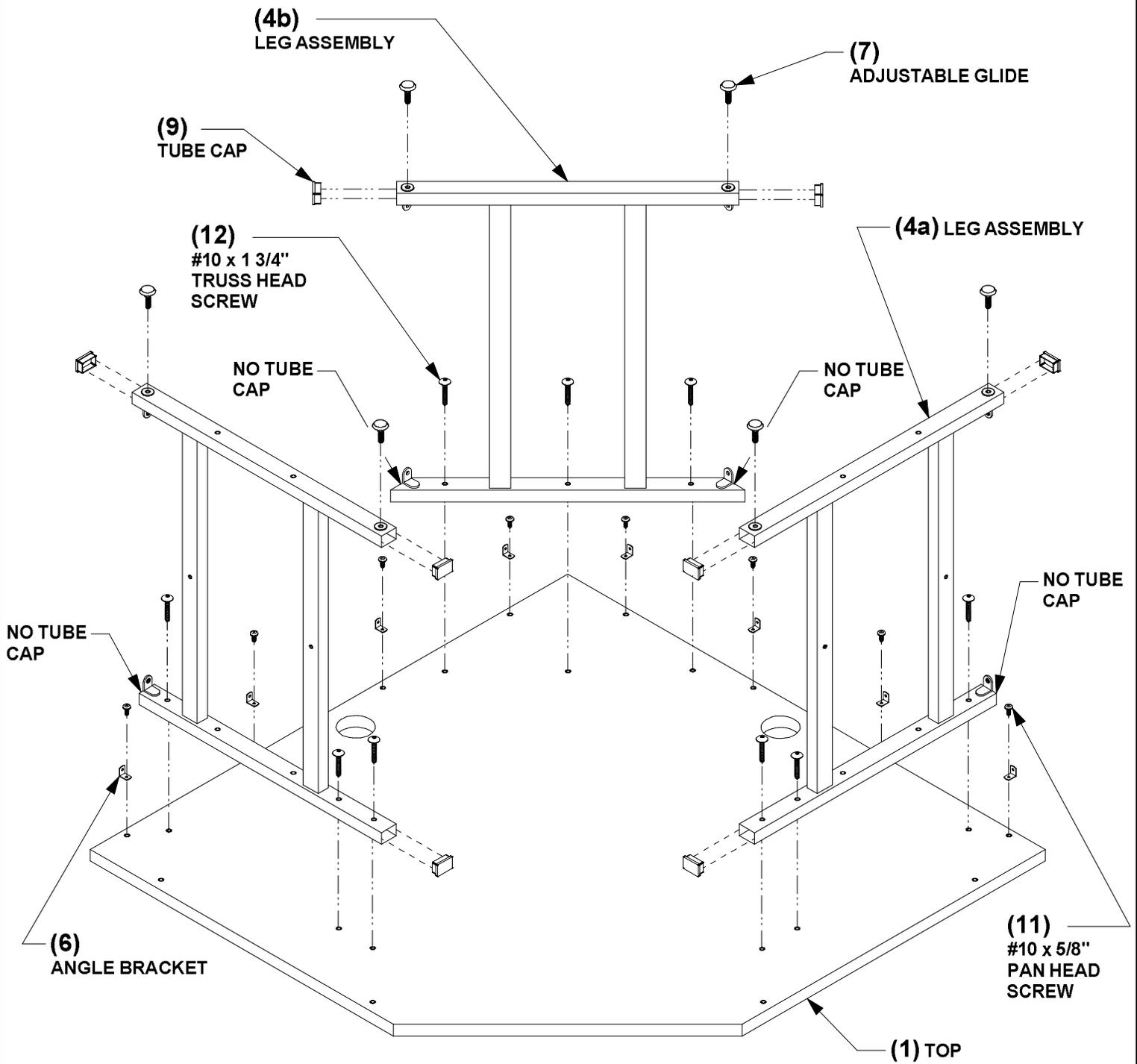


FIGURE 1

3. With two people upright this portion of the table. **Caution: DO NOT** move table until backs have been installed. See figure 1A.

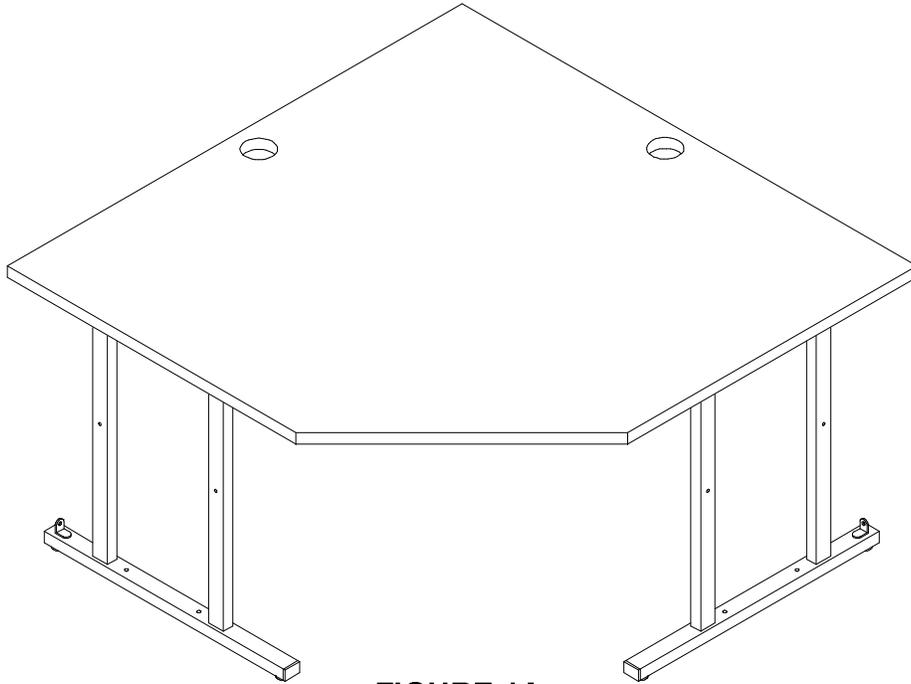


FIGURE 1A

4. Attach troughs (3) to backs (2LH., 2RH.) using #10 x 5/8" pan head screws (11). See figure 2.

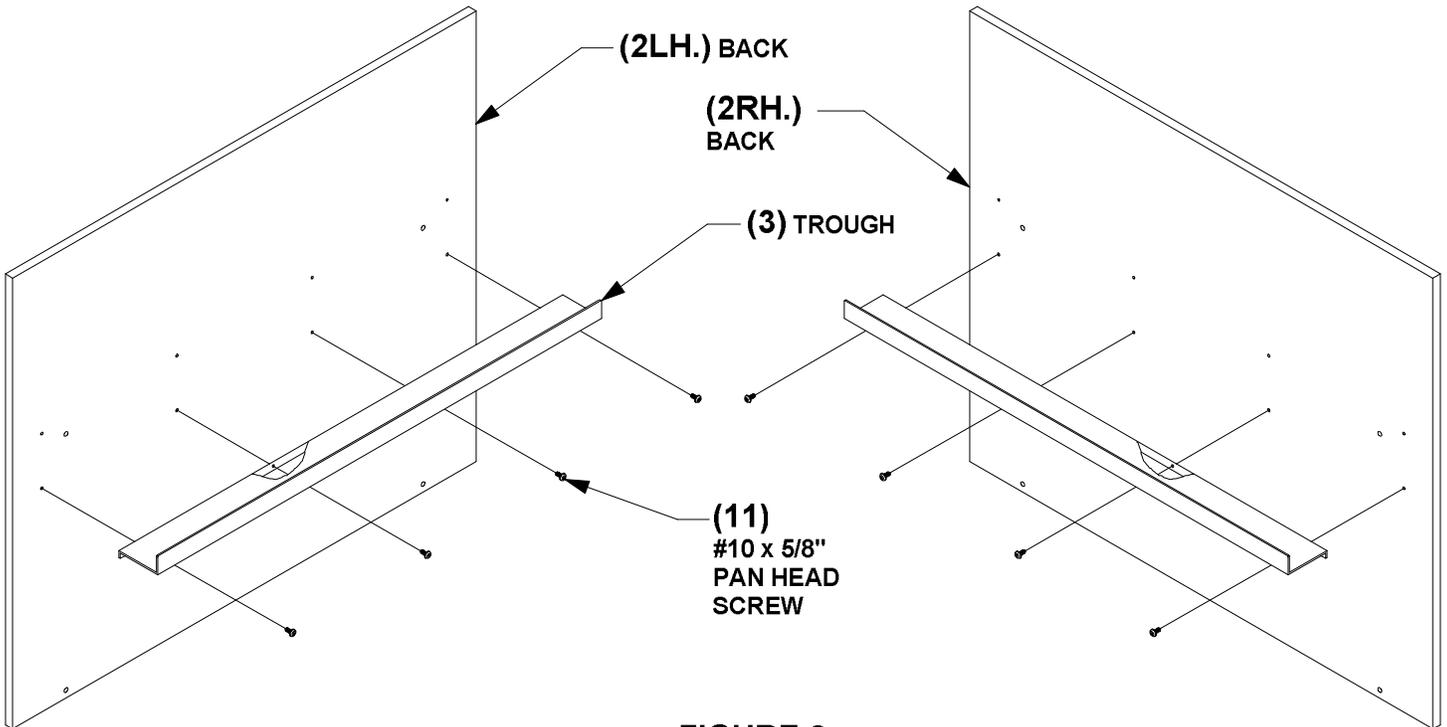


FIGURE 2

5. Attach backs (2LH., 2RH.) to table using 1/4-20 x 35 mm bolts (14) and 1/4-20 flange lock nuts (13). See figure 3.

6. Attach angle brackets (6) to backs (2LH., 2RH.) using #10 x 5/8" pan head screws (11).

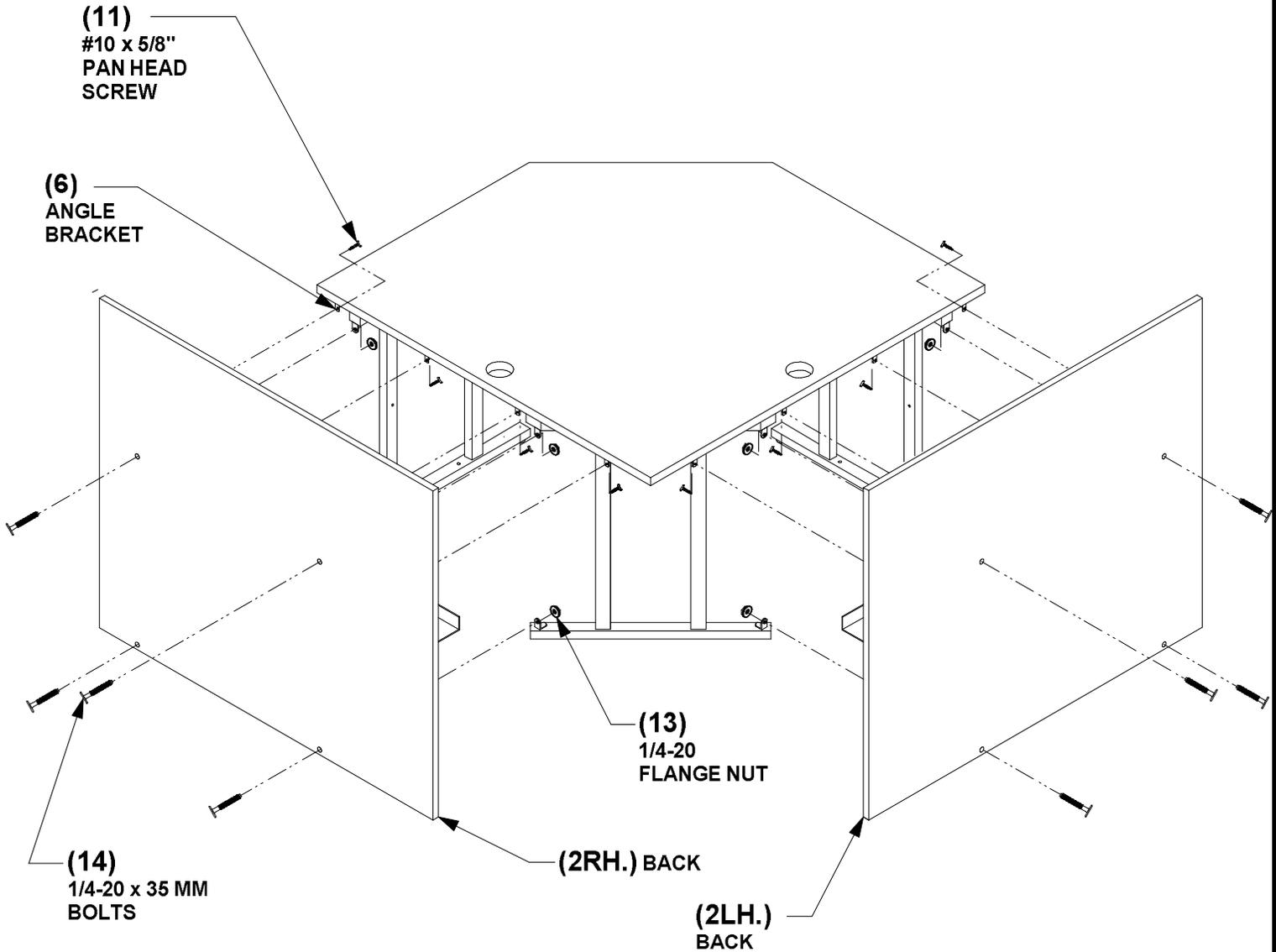


FIGURE 3

STORAGE SHELVES ASSEMBLY INSTRUCTIONS

• **SKIP THIS STEP IF YOUR TABLES WERE PURCHASED WITHOUT STORAGE SHELVES.**

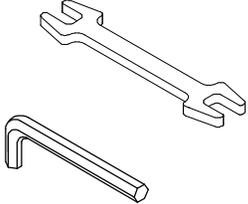
NOTES TO CUSTOMERS:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- PARTS LIST INCLUDES ALL SIZES OF SHELVES FOR RECTANGULAR MODULAR WORK TABLES.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.

SHELF (STORAGE) / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	WIDTH	DEPTH	PART NUMBER
1a	1	SHELF	23 15/16	13 1/4	11616006
1b	1	SHELF	29 15/16	13 1/4	11620006
1c	1	SHELF	35 15/16	13 1/4	11617006
1d	1	SHELF	47 15/16	13 1/4	11618006
	1	HARDWARE PACK (PARTS LISTED BELOW)			90681000
2	4	1/4-20 FLANGE LOCK NUT			60780755
3	4	1/4-20 X 40 MM BOLT			61261106

TOOLS REQUIRED:

- 7/16" Wrench
- 5/32" Allen Wrench



1. Insert 1/4-20 x 40 mm bolts (3) into rear holes of leg assemblies and thread 1/4-20 flange lock nuts (2) onto bolts. Note: Do not tighten. Place the shelf (1) onto the rear bolts. Insert 1/4-20 x 40 mm bolts into the front holes of leg assemblies and shelf, thread 1/4-20 flange lock nuts onto bolts. Now tighten front and rear flange lock nuts. (See Figure 1)

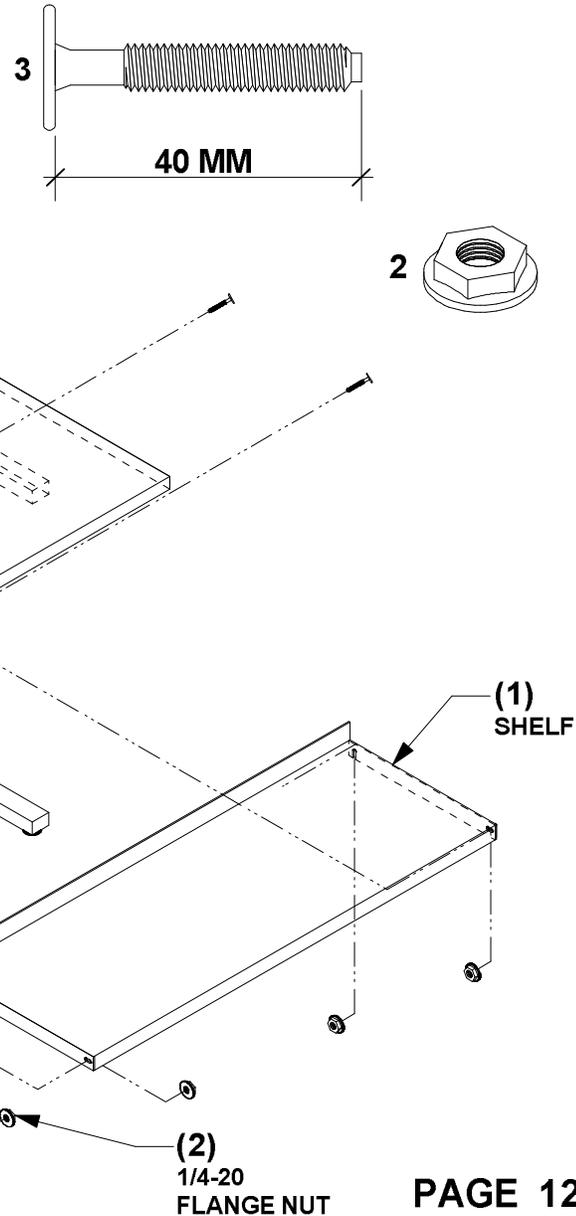


FIGURE 1

CPU SHELF ASSEMBLY INSTRUCTIONS

• **SKIP THIS STEP IF YOUR TABLES WERE PURCHASED WITHOUT A CPU SHELF.**

NOTES TO CUSTOMERS:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.

CPU SHELF / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	WIDTH	DEPTH	PART NUMBER
1	1	CPU SHELF	12 7/8	23	11619006

1. To install CPU SHELF (1), tip sideways when placing in between legs. Make sure CPU SHELF (1) is properly seated before using. (see figure 1)

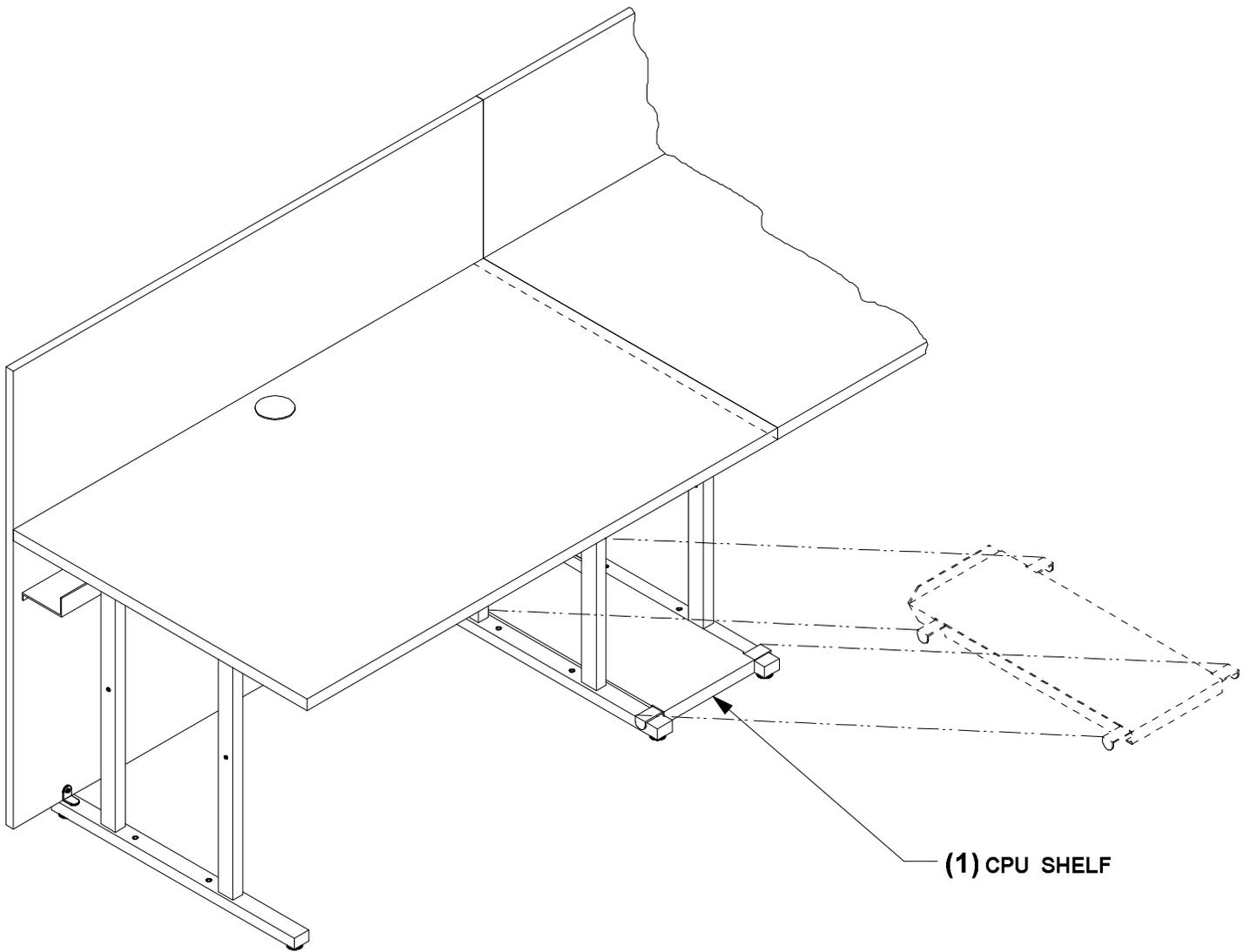


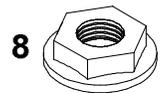
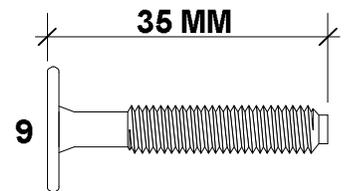
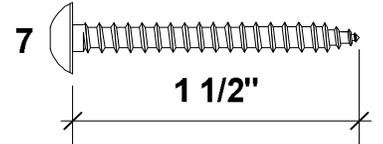
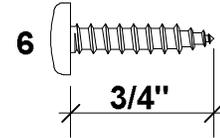
FIGURE 1

END PANELS ASSEMBLY INSTRUCTIONS

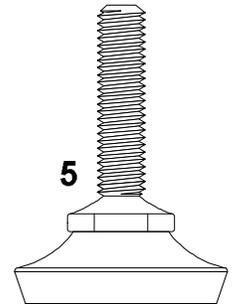
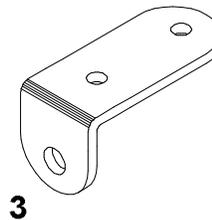
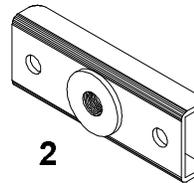
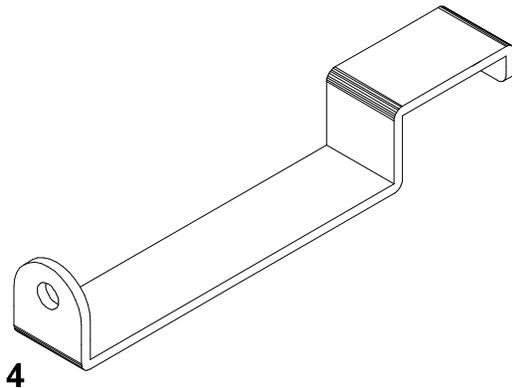
• **SKIP THIS STEP IF YOUR TABLES WERE PURCHASED WITHOUT END PANELS.**

NOTES TO CUSTOMERS:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.
- PARTS LIST INCLUDES ALL SIZES OF END PANELS FOR MODULAR WORK TABLES
- ILLUSTRATIONS IN THE ASSEMBLY INSTRUCTIONS MAY BE FOR A DIFFERENT SIZE END PANEL, DEPENDING ON WHICH END PANEL HAS BEEN ORDERED. (ALL SIZES OF END PANELS USE THE SAME ASSEMBLY PROCEDURES)

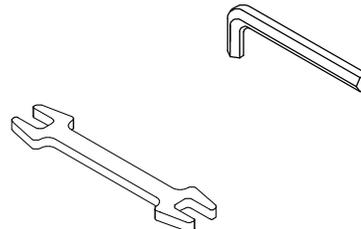
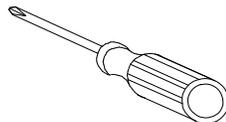


END PANELS / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1a	1	END PANEL	29 7/16	31	334940 (COLOR)
1b	1	END PANEL	41 7/16	31	334780 (COLOR)
1c	1	END PANEL	47 7/16	31	334790 (COLOR)
	1	HARDWARE PACK (PARTS LISTED BELOW)			90684000
2	2	ADJUSTABLE GLIDE BRACKET			11622006
3	2	TOP BRACKET			11623006
4	2	LEG BASE BRACKET			11624006
5	2	ADJUSTABLE GLIDE (1 1/8 DIA. X 3/8 X 1)			73464000
6	4	#10 X 3/4 PAN HEAD SCREW			60650855
7	4	#10 X 1 1/2 TRUSS HEAD SCREW			60652455
8	4	1/4-20 FLANGE LOCK NUT			60780755
9	4	1/4-20 X 35 MM BOLT			61261006



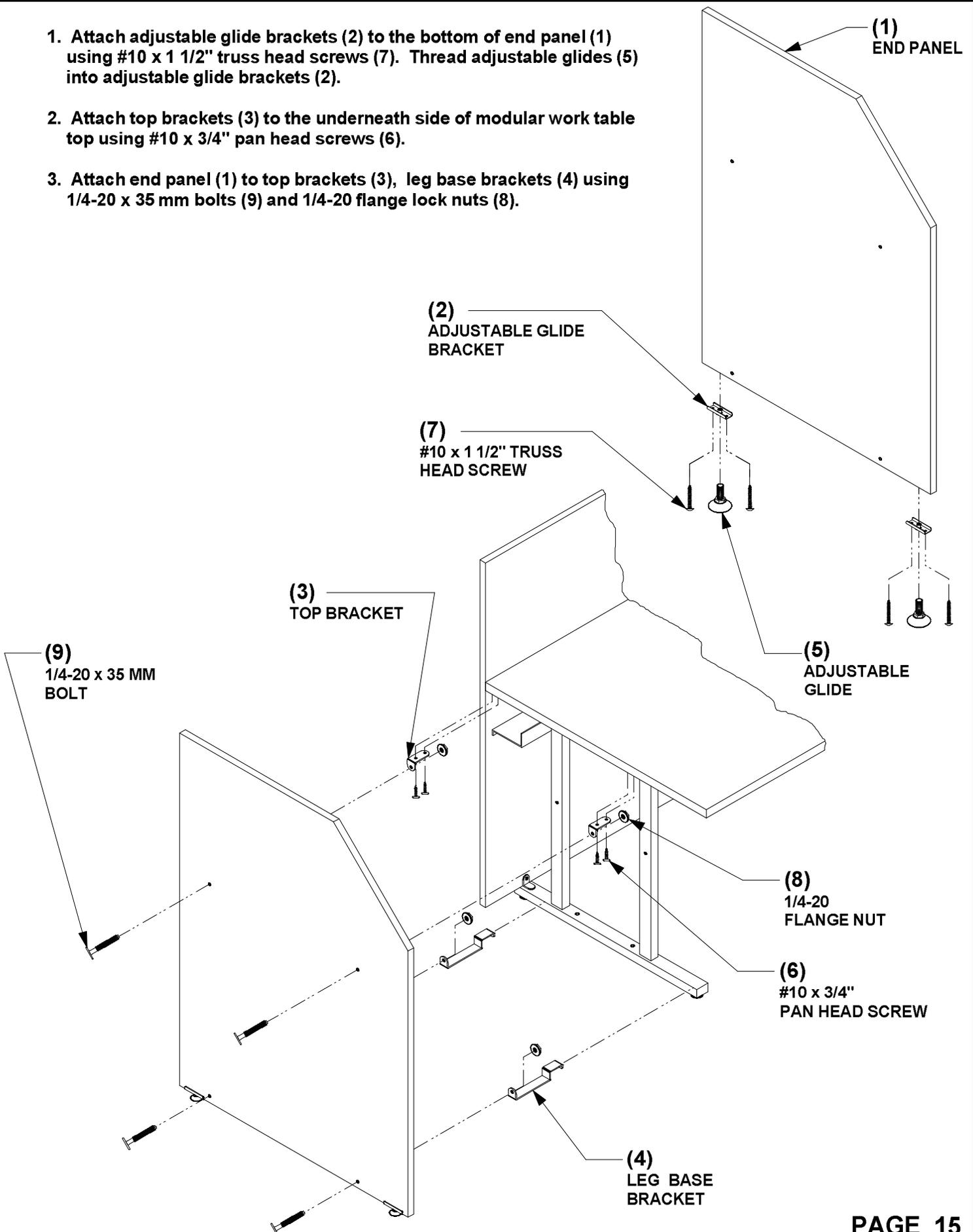
TOOLS REQUIRED:

- Phillips Tip Screwdriver
- 7/16" Wrench
- 5/32" Allen Wrench



Note: Power Driver can be used for the assembly of this unit.

1. Attach adjustable glide brackets (2) to the bottom of end panel (1) using #10 x 1 1/2" truss head screws (7). Thread adjustable glides (5) into adjustable glide brackets (2).
2. Attach top brackets (3) to the underneath side of modular work table top using #10 x 3/4" pan head screws (6).
3. Attach end panel (1) to top brackets (3), leg base brackets (4) using 1/4-20 x 35 mm bolts (9) and 1/4-20 flange lock nuts (8).



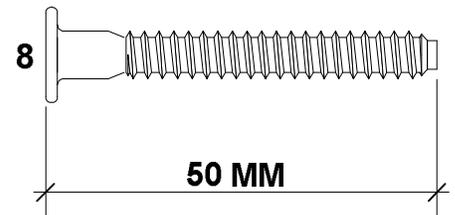
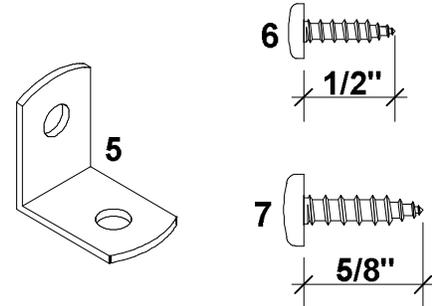
RISER SHELVES (RECTANGULAR TABLES) ASSEMBLY INSTRUCTIONS

• SKIP THIS STEP IF YOUR TABLES WERE PURCHASED WITHOUT RISER SHELVES.

NOTES TO CUSTOMERS:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.
- PARTS LIST INCLUDES ALL SIZES OF RISER SHELVES FOR RECTANGULAR MODULAR WORK TABLES
- ILLUSTRATIONS IN THE ASSEMBLY INSTRUCTIONS MAY BE FOR A DIFFERENT SIZE RISER SHELF, DEPENDING ON WHICH RISER SHELF HAS BEEN ORDERED. (ALL SIZES OF RISER SHELVES USE THE SAME ASSEMBLY PROCEDURES)

MODULAR WORK TABLE RISER SHELF / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1	1	END (LH)	7 1/2	12	335051 (COLOR)
2	1	END (RH)	7 1/2	12	335052 (COLOR)
3	2	PARTITION	6 1/2	9 1/4	335060 (COLOR)
4a	1	SHELF	34 3/16	11 1/4	335070 (COLOR)
4b	1	SHELF	40 3/16	11 1/4	335080 (COLOR)
4c	1	SHELF	46 3/16	11 1/4	335090 (COLOR)
4d	1	SHELF	58 3/16	11 1/4	335100 (COLOR)
	1	HARDWARE PACK (PARTS LISTED BELOW)			90683000
5	10	ANGLE BRACKET			70745000
6	8	#8 X 1/2 PAN HEAD SCREW			60550255
7	12	#10 X 5/8 PAN HEAD SCREW			60651555
8	4	50 MM SCREW			61260406



1. Attach angle brackets (5) to both sides of partitions (3) using #8 x 1/2" pan head screws (6). See figure 1.

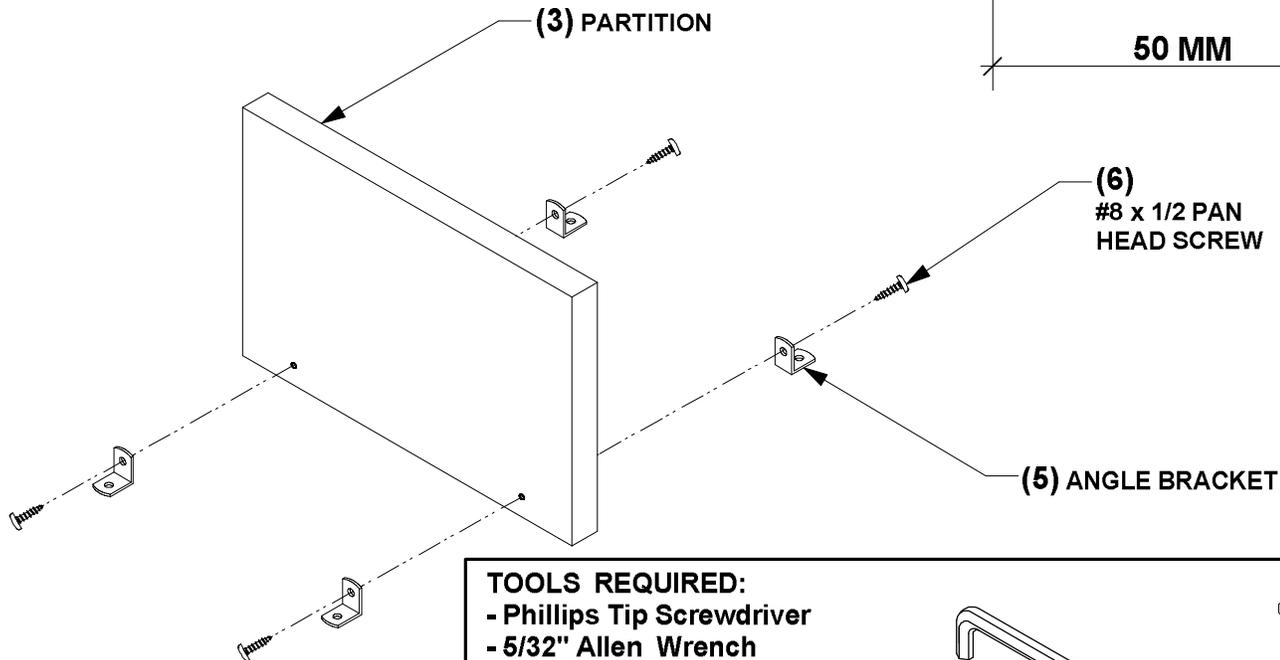
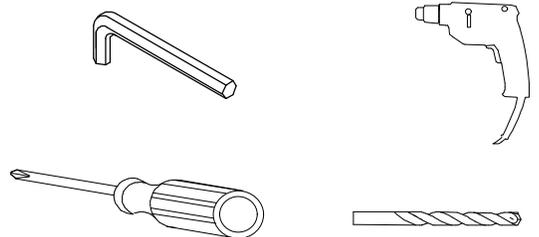


FIGURE 1

TOOLS REQUIRED:

- Phillips Tip Screwdriver
- 5/32" Allen Wrench
- Drill
- 9/64" Drill Bit

Note: Power Driver can be used for the assembly of this unit.



2. Attach angle brackets (5) to lower rear edge of ends (1, 2) using #10 x 5/8" pan head screws (7). See figure 2.

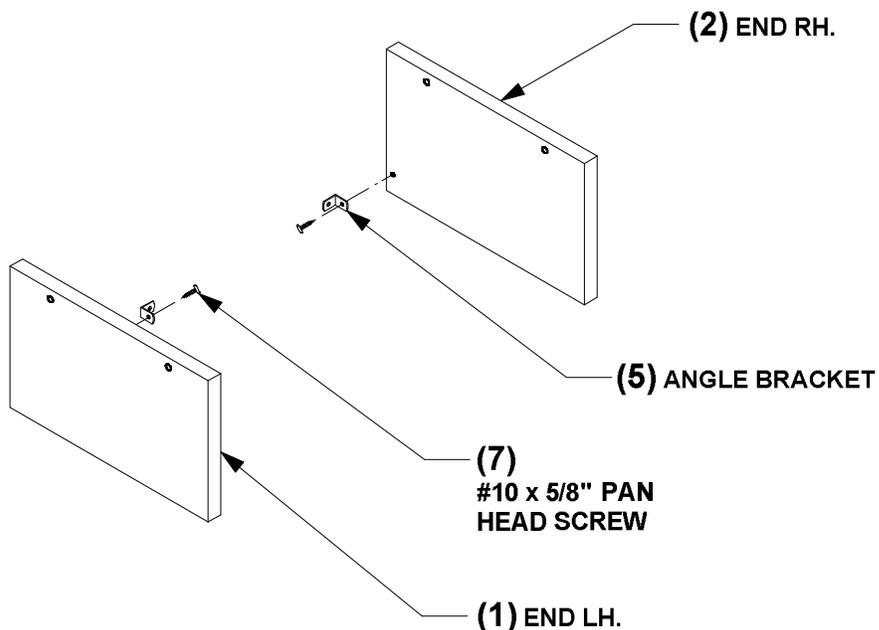


FIGURE 2

3. Attach partitions (3) with pre-mounted angle brackets (5) to shelf (4) using #10 x 5/8" pan head screws (7). See figure 3.

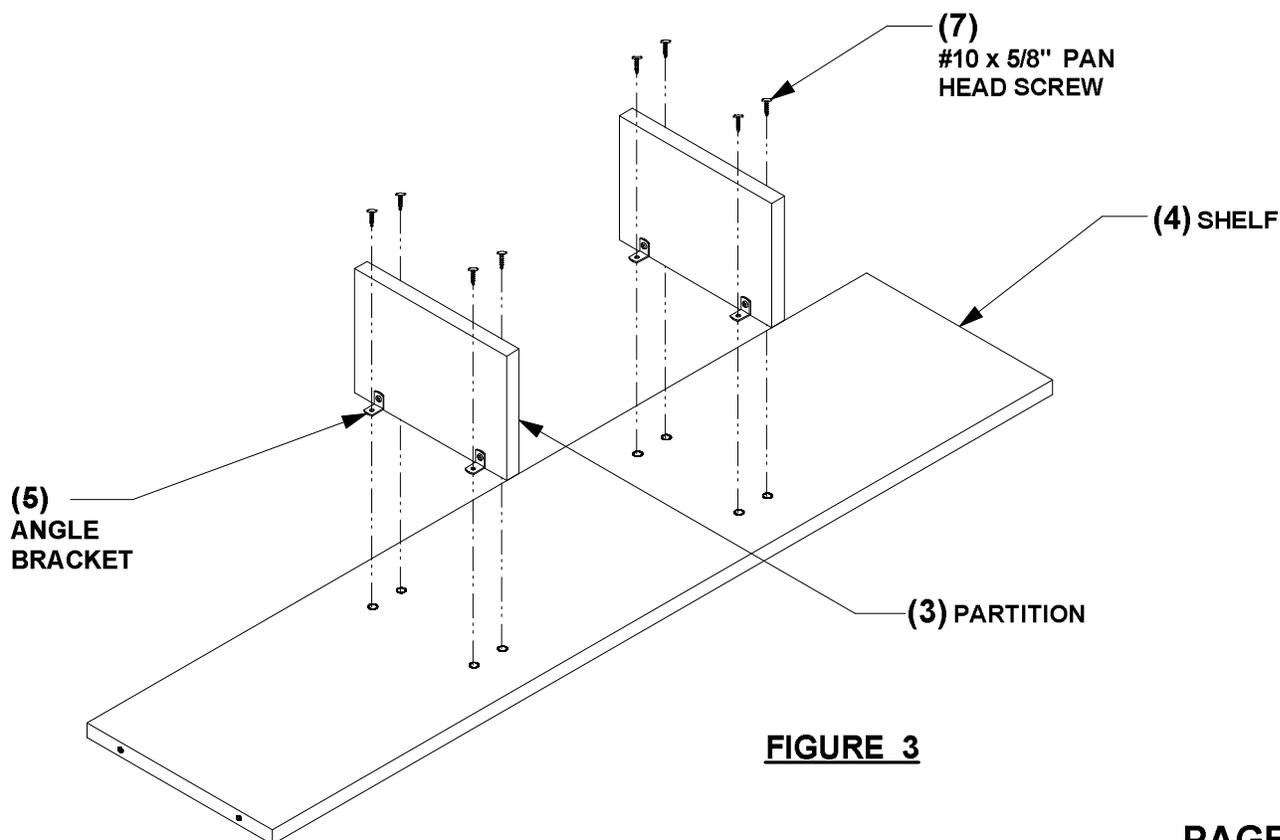


FIGURE 3

4. Upright this portion of the shelf and attach ends (1, 2) using 50 mm screws (8). See Figure 4.

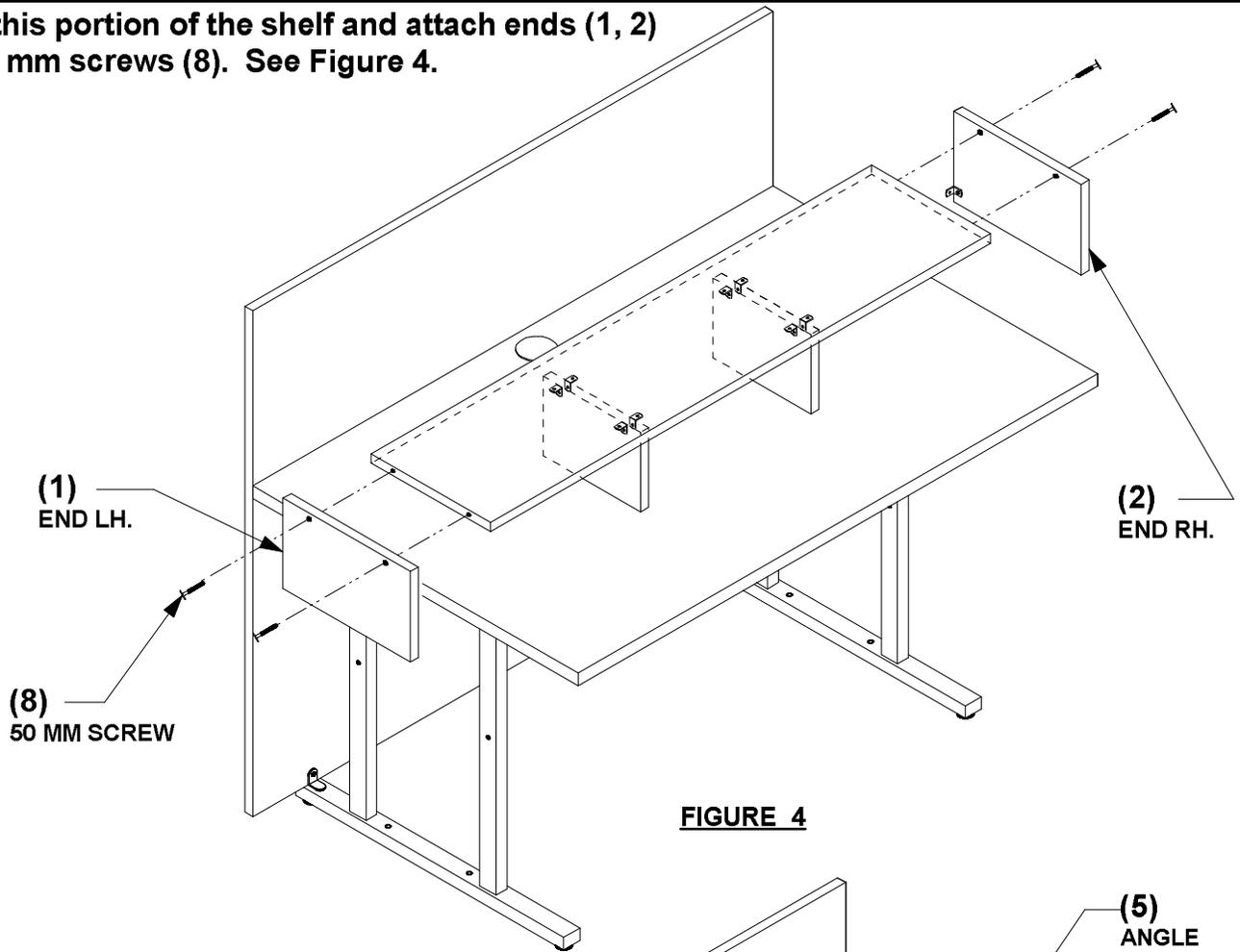


FIGURE 4

5. Attach shelf with pre-mounted angle brackets (5) to back panel of work table using #10 x 5/8" pan head screws (7). Note: Pilot holes need to be drilled into back panel of work table before attaching shelf. (use a 9/64" drill bit and drill holes 1/2" deep) See figure 5.

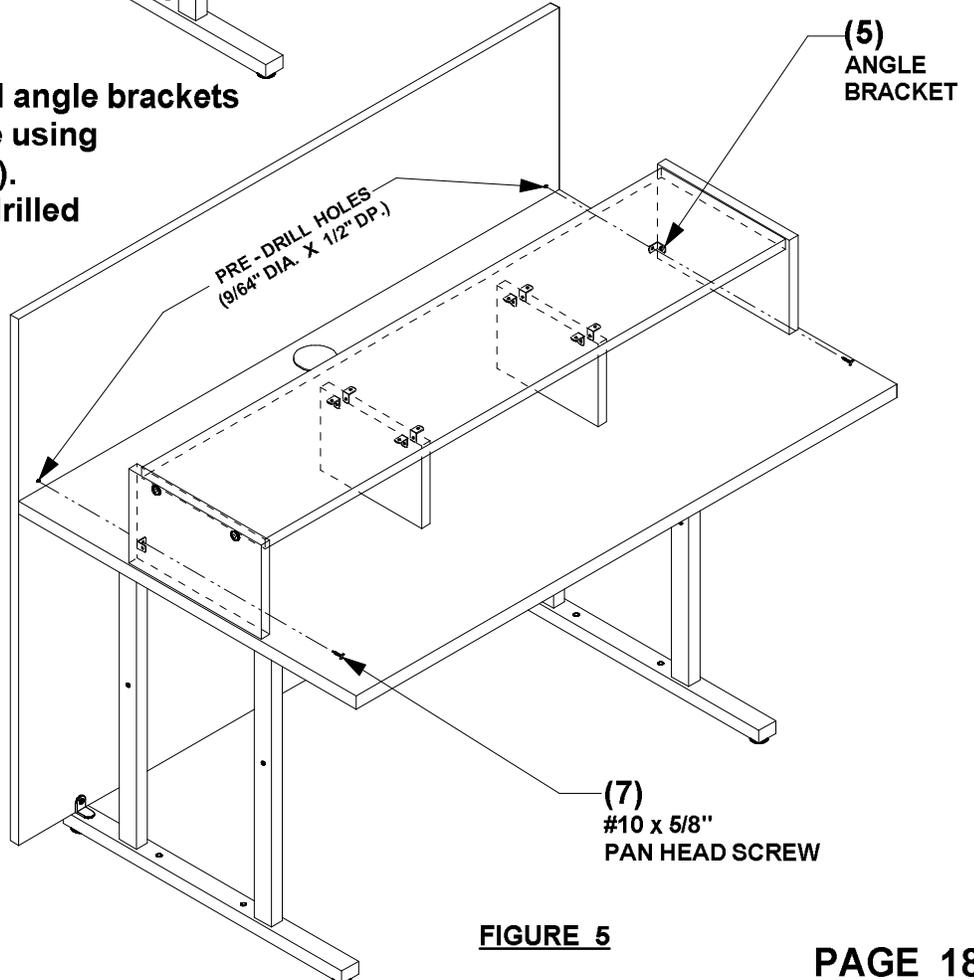


FIGURE 5

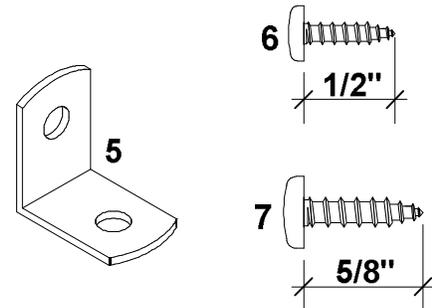
RISER SHELF (CORNER TABLE) ASSEMBLY INSTRUCTIONS

• SKIP THIS STEP IF YOUR TABLE WERE PURCHASED WITHOUT RISER SHELVES.

NOTES TO CUSTOMERS:

- ASSEMBLE PRODUCT AWAY FROM YOUNG CHILDREN. THE SMALL PARTS IN THE ENCLOSED PACKAGES COULD BE SWALLOWED AND CAUSE CHOKING OR OTHER INJURY.
- ASSEMBLE PRODUCTS ON A CUSHIONED AND CLEAN SURFACE TO PREVENT DAMAGE TO SURFACE FINISHES.
- THE NUMBERS IN PARENTHESIS IN THE INSTRUCTION TEXT REFER TO THE CORRESPONDING NUMBER IN THE PARTS LIST.

MODULAR WORK TABLE RISER SHELF / PARTS LIST					
NO.	QTY.	PART DESCRIPTION	LENGTH	WIDTH	PART NUMBER
1	1	END (LH)	7 1/2	12	335051 (COLOR)
2	1	END (RH)	7 1/2	12	335052 (COLOR)
3	2	PARTITION	6 1/2	16 1/2	334330 (COLOR)
4	1	SHELF	46 1/16	46 1/16	335110 (COLOR)
	1	HARDWARE PACK (PARTS LISTED BELOW)			90682000
5	14	ANGLE BRACKET			70745000
6	12	#8 X 1/2 PAN HEAD SCREW			60550255
7	16	#10 X 5/8 PAN HEAD SCREW			60651555
8	4	50 MM SCREW			61260406



1. Attach angle brackets (5) to both sides of partitions (3) using #8 x 1/2" pan head screws (6). See figure 1.

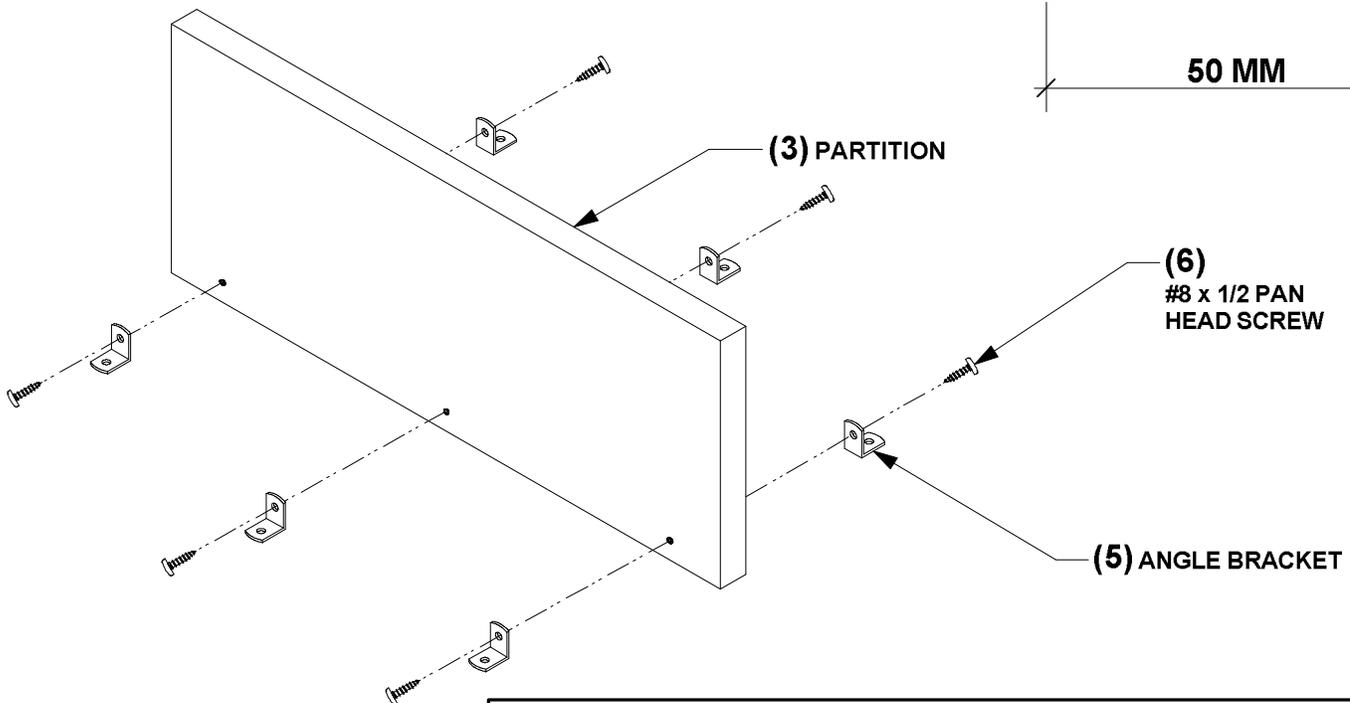
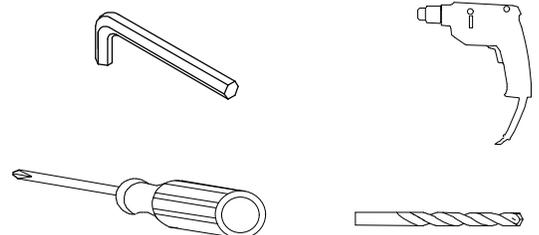


FIGURE 1

TOOLS REQUIRED:

- Phillips Tip Screwdriver
- 5/32" Allen Wrench
- Drill
- 9/64" Drill Bit

Note: Power Driver can be used for the assembly of this unit.



2. Attach angle brackets (5) to lower rear edge of ends (1, 2) using #10 x 5/8" pan head screws (7). See figure 2.

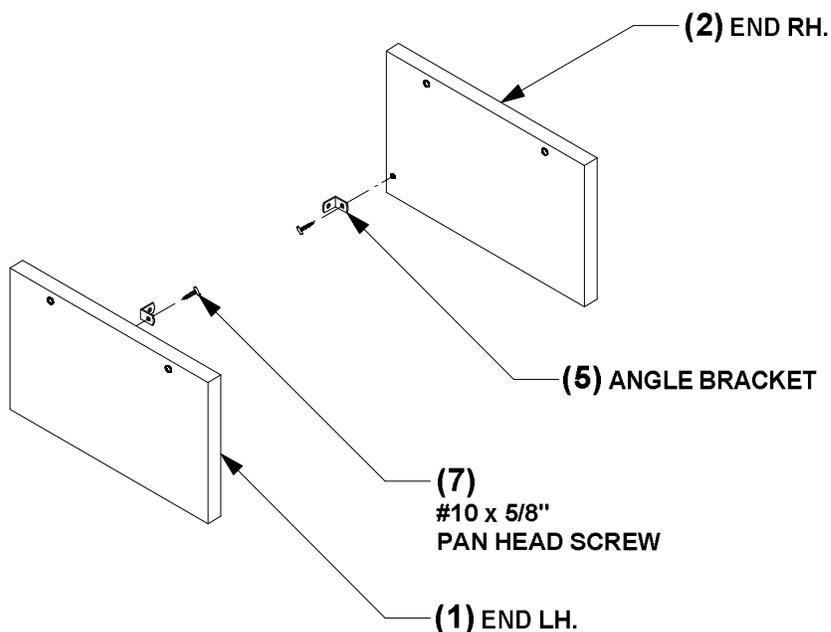


FIGURE 2

3. Attach partitions (3) with pre-mounted angle brackets (5) to shelf using #10 x 5/8" pan head screws (7). See figure 3.

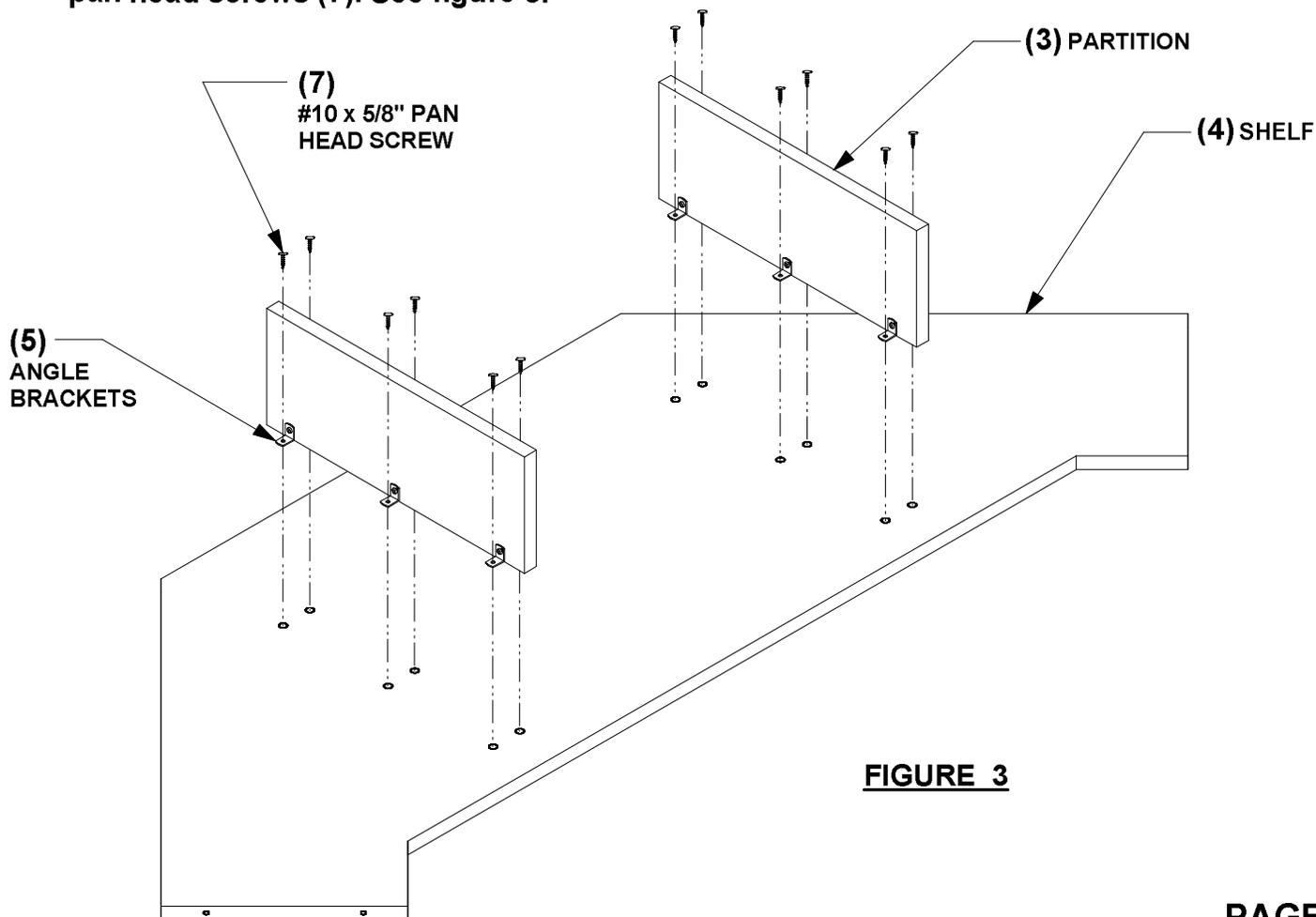


FIGURE 3

4. Upright this portion of the shelf and attach ends (1, 2) using 50 mm screws (8). See Figure 4.

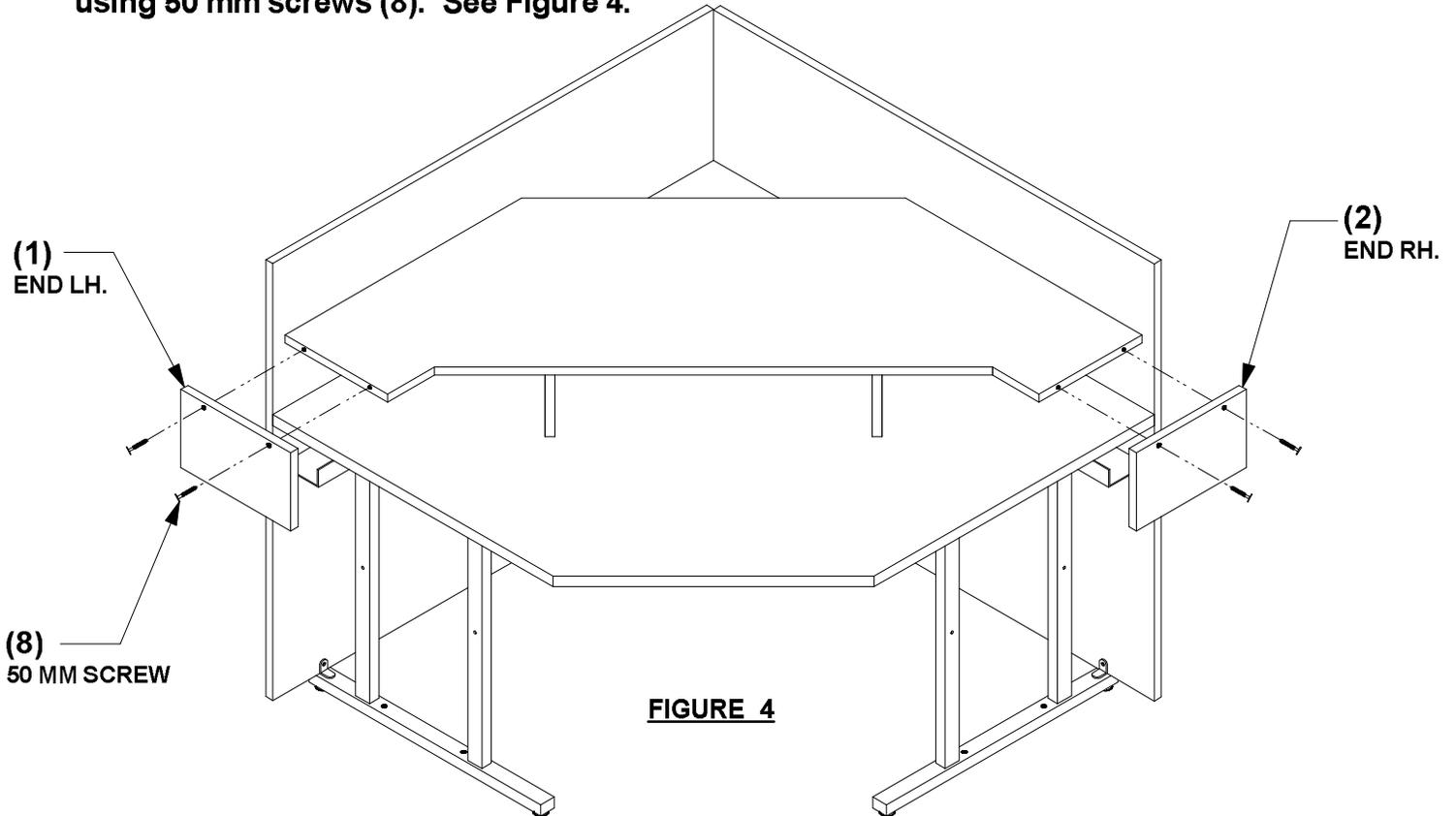


FIGURE 4

5. Attach shelf with pre-mounted angle brackets (5) to back panel of work table using #10 x 5/8" pan head screws (7). Note: Pilot holes need to be drilled into back panel of work table before attaching shelf. (use a 9/64" drill bit and drill holes 1/2" deep) See figure 5.

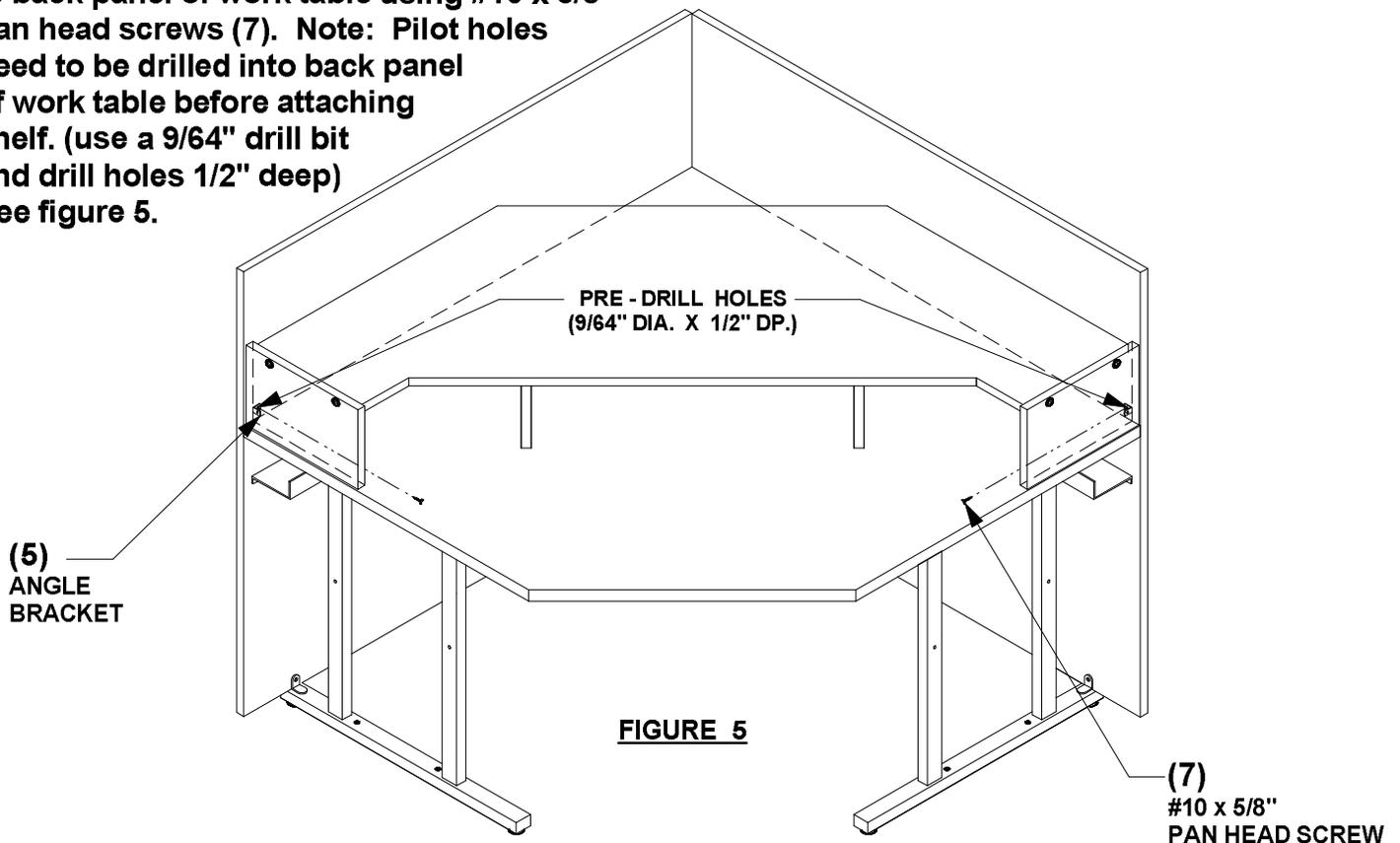


FIGURE 5