

# Assembly Instructions for Trolley

## Assembly Instructions

- Step 1. Attach Cylinder Guardrail (B) to the rear-end of Bottom Shelf (A) using 5 Bolts M6×16 (Bolt screwing in half of distance, while not tighten).
- Step 2. Attach the Cylinder Side Support Shelf (C) to the Cylinder Guardrail (B) using 4 Bolts M6×16, flat washers, nuts. (Bolt screwing in half of distance, while not tighten).
- Step 3. Attach the Cylinder Side Support Shelf (C) to Bottom Shelf (A) using 4 Bolts M6×16 (Bolt screwing in half of distance, while not tighten).
- Step 4. Tighten the bolts securely with wrench according to the sequence: Step 1, Step3 and Step 2.
- Step 5. Put the water-cooling unit and power source on trolley.
- Step 6. Insert the 2 pieces of pressing plates to the grooves which are located on front and back ends of the water-cooling unit.
- Step 7. Fit Beam (D) using 2 Bolts M8×20, flat washers, spring washers, to the Beam Support.
- Step 8. Slightly adjust the power source and water cooling unit on the trolley, and fasten the beam using 4 Bolts M6×16 to Cylinder Guardrail.
- Step 9. Attach the pressing plate (E) to the Bottom Shelf using 4 Bolts M10×25, Flat Washer, and fasten with 4 flat washers, spring washers and nuts.
- Step 10. Put the wire feeder on Beam (D).
- Step 11. Tie the steel cylinder to the guardrail with 2 pieces of strapping (F) as the figure provided in this instruction.

Component List		
Item	Qty (pc)	
Bolt, M6×16	17	
Flat washer, Φ6	4	
Nut, M6	4	
Bolt, M8×20	2	
Flat washer, Φ8	2	
Spring washer, Φ8	2	
Bolt, M10×25	4	
Flat washer, Φ10	8	
Spring washer, Φ10	4	
Nut, M10	4	

Parts List		
Legend	Item	Qty (pc)
A	Bottom Shelf	1
B	Guardrail for Cylinder	1
C	Side Support Shelf	2
D	Beam	1
E	Pressing Plate	2
F	Strapping	2

