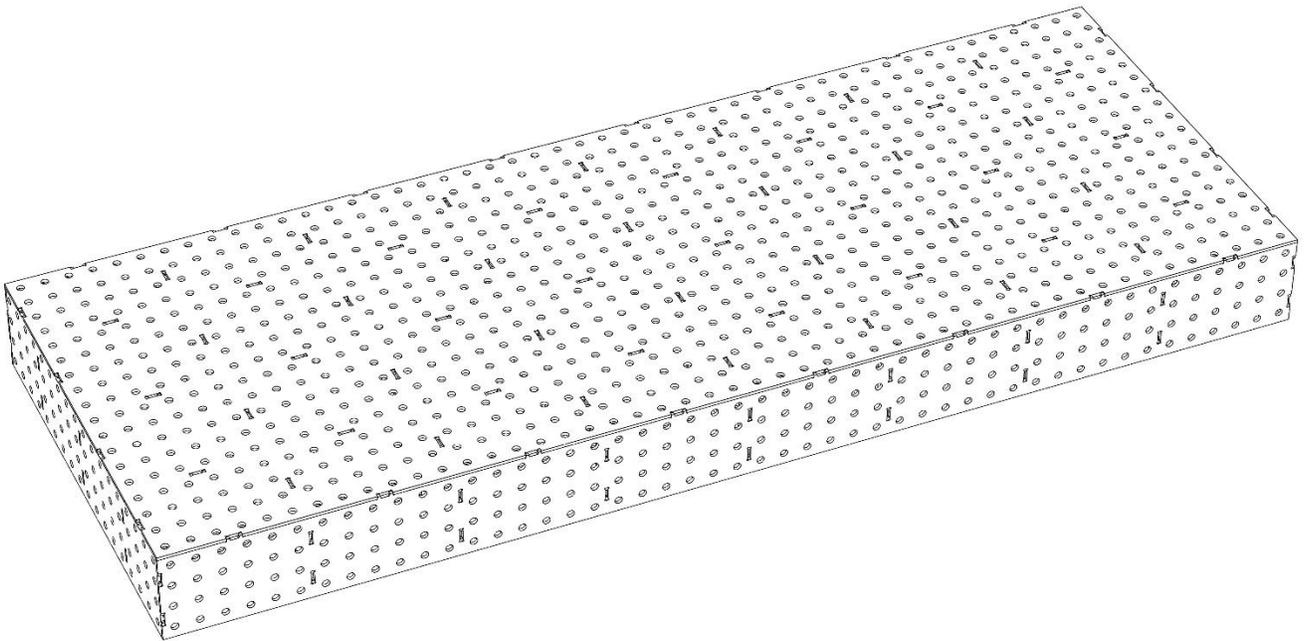




## 36" X 96" FIXTURE TABLE KIT INSTRUCTIONS

P/N: 082020181225

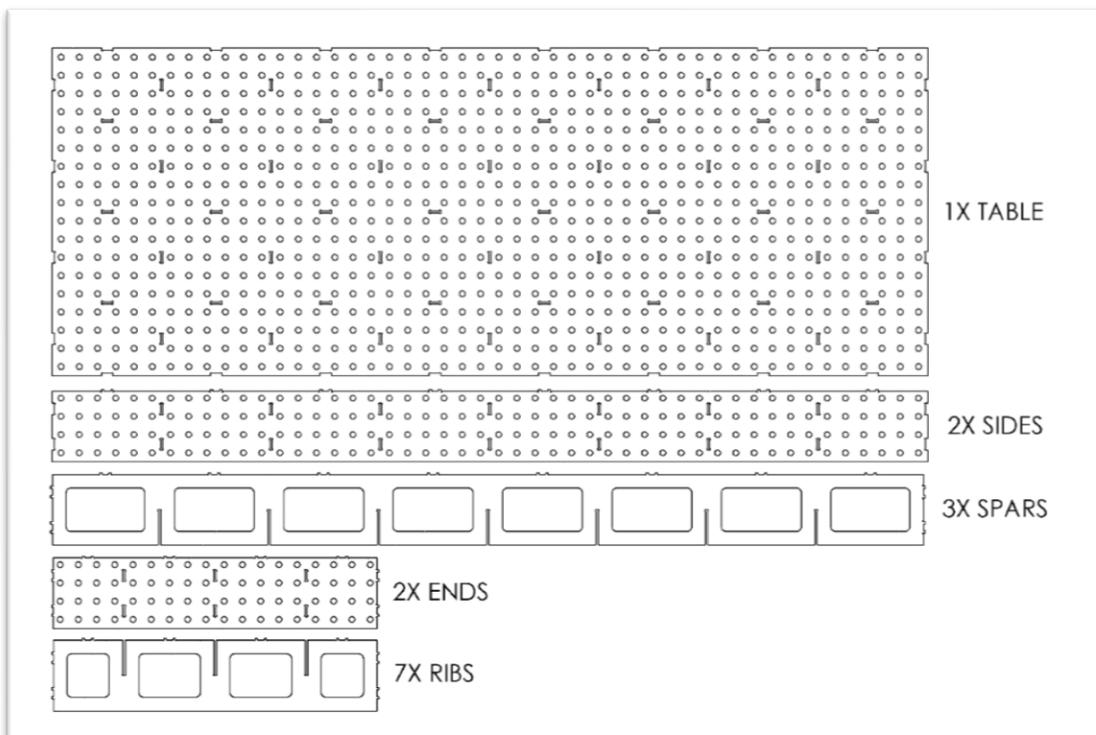


INITIAL RELEASE: August 21, 2018

## Thank you for purchasing the GSI 36" x 96" FIXTURE TABLE KIT!

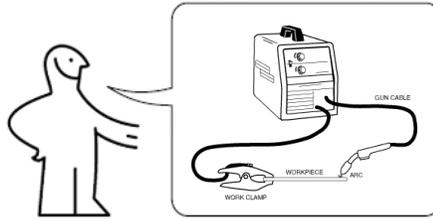
- This fixture table is made from ASTM A1011 ¼" thick steel.
- The supplied sheets weigh approximately 522 pounds.
- There are 1,392 5/8" laser cut holes on a 2" center to center grid.
- The edges of the table are 1" from center so multiple tables may be put together for larger projects.
- The entire assembly fits together using tab and slot positioning. It is nearly impossible to assemble it incorrectly.
- GSI has a multitude of accessories available to go with your table.

### WHAT YOU SHOULD HAVE:

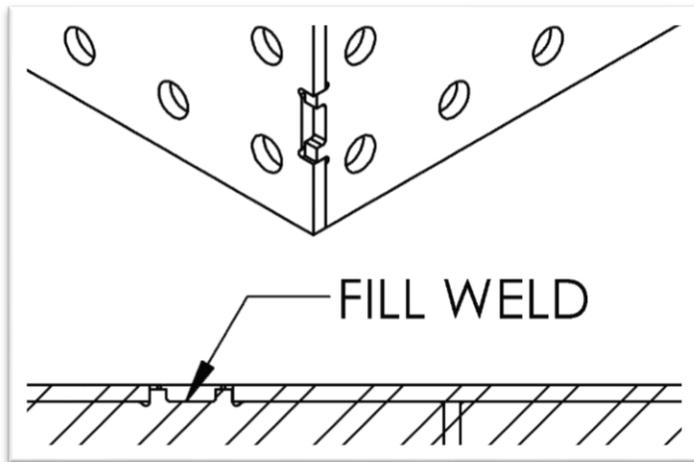


**NOTICE:**

**THIS KIT REQUIRES WELDING!**



WE HIGHLY SUGGEST THAT YOU **TIG** (TUNGSTEN INERT GAS) OR **MIG** (METAL INERT GAS) WITH **ER70S2** FILLER ROD/WIRE TO WELD THIS KIT. PLEASE BE COMPETENT IN WHICHEVER WELDING PROCESS YOU USE, AS FIXTURE TABLES ARE OFTEN SUBJECTED TO SEVERE CLAMPING AND THERMAL EXPANSION LOADS WHEN IN USE.



THROUGHOUT EVERY COMPONENT OF THE TABLE ARE TABS AND SLOTS. THE CENTER OF THE TABS HAS BEEN REMOVED TO PROVIDE A RECESSED AREA TO FILL OR TACK WITH WELD IF YOU CHOOSE.

**BEWARE!**

THAT BUILT UP WELD MAY BECOME HIGHER THAN THE SURFACE OF THE TABLE YOU ARE WORKING WITH AND MAY NEED TO BE **CAREFULLY GROUND DOWN**.

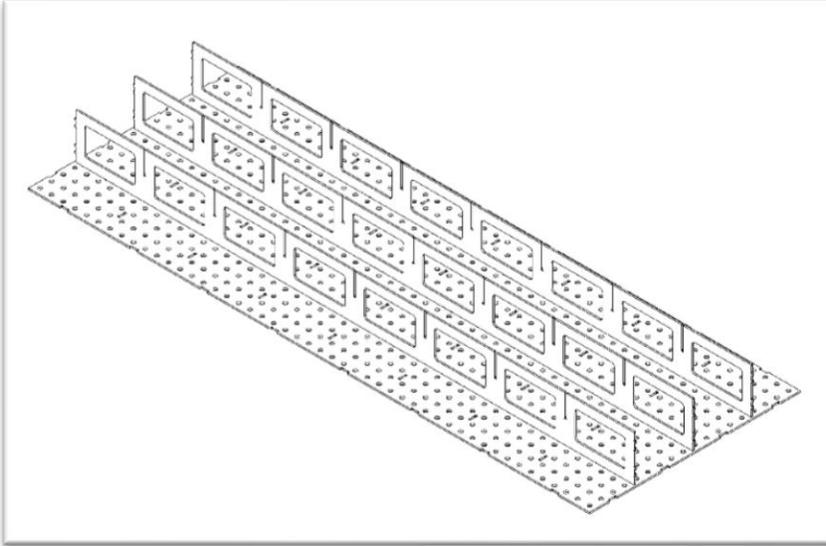
MOST OF THE CONSTRUCTION OF THE TABLE WILL BE DONE WITH TACK WELDS AND FILLET STITCH WELDS ON THE "INTERNAL" SURFACES OF THE TABLE. AS IT IS BUILT "FACE DOWN".

THERE IS NO NEED TO "FULLY WELD" THE TABLE AS THIS WOULD ONLY CREATE WARPING FROM EXCESSIVE HEAT.

WE SUGGEST INTERMITTENT (STITCH) WELDS ABOUT 1" LONG, SPACED EVER 3 -5 INCHES AS REQUIRED.

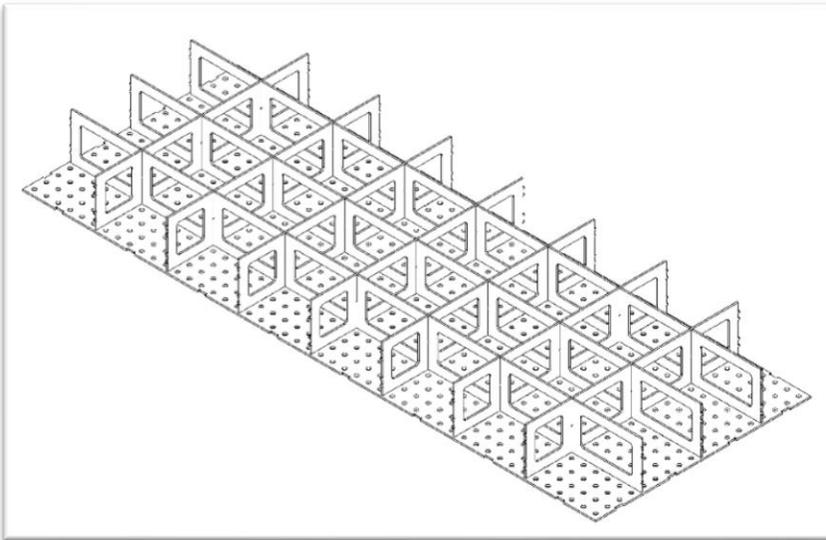
## ASSEMBLY

1. FIND A FLAT HEAT RESISTANT SURFACE TO WORK ON. WE SUGGEST A FLAT CONCRETE SLAB WITHOUT CRACKS OR OTHER DEFORMATIONS.
2. LAY THE TABLE "TOP SIDE DOWN"... AT THIS POINT IT SHOULDN'T MATTER WHICH SIDE IS UP, BUT YOU MAY HAVE A PREFERENCE ONCE YOU GET YOUR PARTS.
3. PLACE THE **3X SPARS** INTO THE TABLE AS SHOWN:

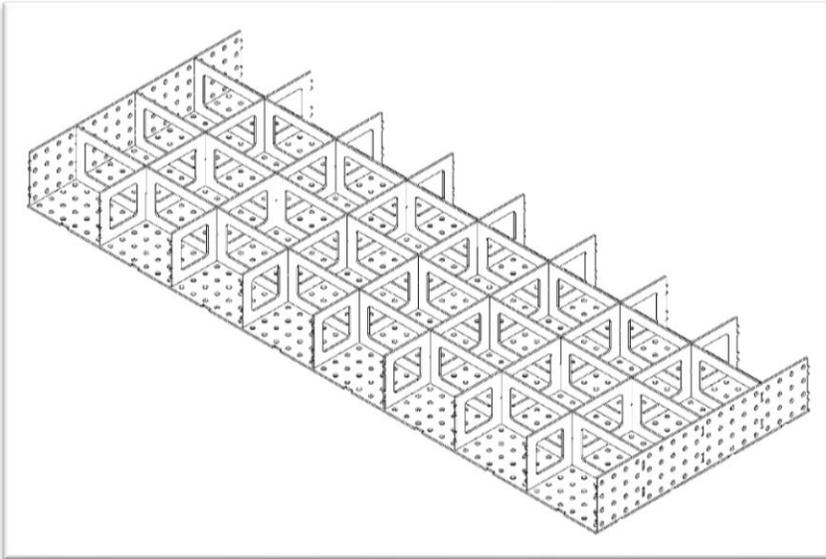


THE JUDICIOUS USE OF A SOFT FACE Mallet MAY BE NEEDED GETTING THE TABS INTO THEIR SLOTS, HOWEVER IF THE SPARS DO NOT FIT INTO THE **TABLE** SLOTS, THIS MAY INDICATE THAT THE **TABLE** IS NOT TRULY FLAT.

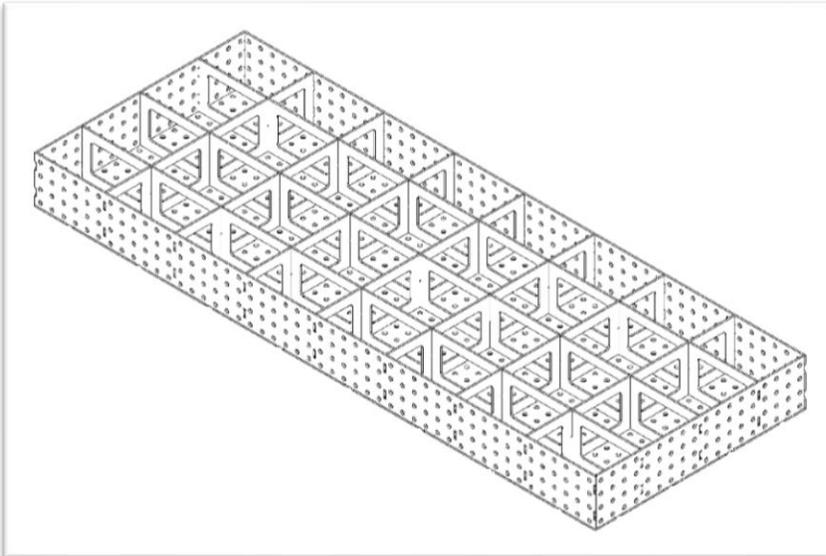
4. SLIDE THE **RIBS** INTO THE SLOTS ON THE SPARS AND AGAIN LIGHTLY TAP WITH A Mallet IF NEEDED TO SEAT THE TABS INTO THEIR SLOTS INTO THE **TABLE**.



5. PLACE THE **ENDS**, AGAIN CAREFULLY ASSESSING FLATNESS OF THE SURFACE YOU ARE WORKING ON AND INSERTING THE TABS INTO THEIR SLOTS.



6. FINALLY PLACE THE **SIDES**.



7. ONCE ALL OF THE PARTS ARE PLACED TOGETHER, USE CARE IN CLAMPING AND KEEPING EVERYTHING SQUARE.
8. DOUBLE CHECK THAT EVERYTHING IS SQUARE!
9. BEGIN TACK WELDING ALL OF THE COMPONENTS TOGETHER, IN SUCH A MANNER THAT THE TACK WELDS MAY BE EASILY GROUND OFF IF NEEDED.
10. TRIPLE CHECK THAT ALL COMPONENTS ARE SQUARE.
11. BEGIN TO FINAL WELD. AGAIN WE SUGGEST INTERMITTENT (STITCH) WELDS ABOUT 1" LONG, SPACED EVER 3-5 INCHES AS REQUIRED.