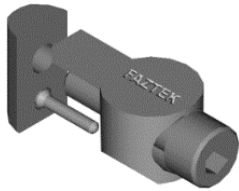


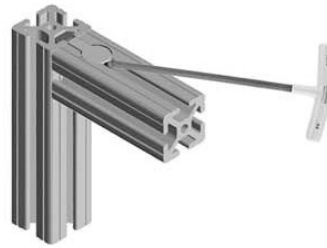
## General Assembly Instructions

The following instructions are to assist you in assembling your projects. Below you will find detailed information on how to assemble each type of fastening and method and basic accessories. Additional you find helpful hints, tips, and basic order of operation when assembling your project.

To see similar type applications in the completed state, go to [www.Faztek.net](http://www.Faztek.net). For any questions or additional information, contact the Faztek Inside Sales Team at 260-482-7544 or send an email to [insidesales@faztek.net](mailto:insidesales@faztek.net).



**Anchor Fastener:** Barrel fastener to be used in conjunction with the counterbore machining service.

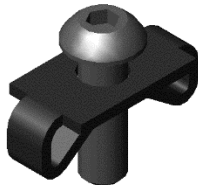


### Assembly instructions using anchor fasteners:

1. Align the two extrusions at a 90° angle
2. Drop the anchor into the counterbore on one extrusion and the connected t-nut in the slot of the other extrusion
3. Position extrusions and tighten fasteners

### Tools needed:

1. 15 series: 13TL1202 - 1/4" ball end t-handle allen wrench
2. 10 series: 13TL1201 - 3/16" ball end t-handle allen wrench



**End Fastener:** Screw & butterfly clip combination used to create a non-rotating 90° connection. To be used in conjunction with tapping and access hole machining services.

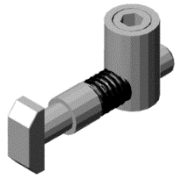


Assembly instructions using end fasteners:

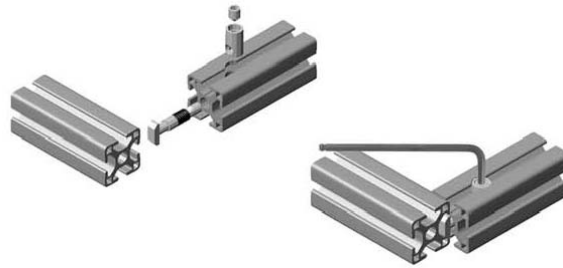
1. Put the bolt thru the clip and thread into the tapped extrusion
2. Join the two extrusions by sliding the end fastener into the T-Slot of the mating extrusion
  - a. Be sure the access hole is aligned with the bolt head to allow access for the tool
3. Tighten fastener with tool thru the access hole

Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end t-handle allen wrench
  2. 10 series: 13TL1203 - 5/32" ball end t-handle allen wrench
- 



**T-Anchor Fastener:** Barrel fastener to be used in conjunction with the counterbore machining service for "SM" type material only.

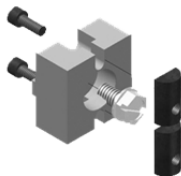


Assembly instructions using t-anchor fasteners:

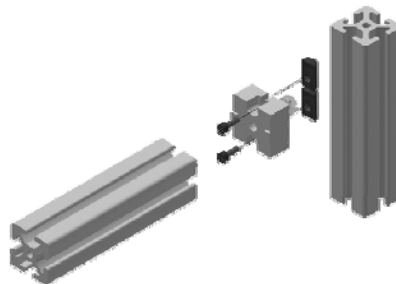
1. Insert barrel into the counterbore of one extrusion
2. Insert the "T" bar w/ spring into the extrusion hole
3. Position extrusions and tighten fasteners

Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end L-handle allen wrench
- 



**Machiningless Fastener:** A mating block to allow two extrusions to be joined with machining.

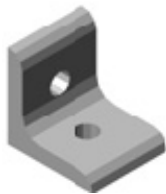


Assembly instructions using a machiningless fastener block:

1. Align the two extrusions at a 90 ° angle
2. Drop the anchor into the counterbore on one extrusion and the connected t-nut in the slot of the other extrusion
3. Position extrusions and tighten fasteners

Tools needed:

1. 13TL1201 - 3/16" ball end t-handle allen wrench
2. 13TL1203 – 5/32" ball end t-handle allen wrench
3. 3/8" drive socket wrench w/ 1/2" socket



**Corner Brackets / Gussets:** Machined bracket to join two extrusions in the corner of the profiles.

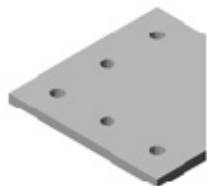


Assembly instructions using corner brackets:

1. Insert screw thru bracket and thread slightly into t-nut
2. Slide bracket with loaded hardware into the slot of the extrusion
3. Align to desired position and tighten fasteners

Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end t-handle allen wrench
2. 10 series: 13TL1203 - 5/32" ball end t-handle allen wrench



**Joining Plates:** Machined plate to join two extrusions on the face of the profiles.

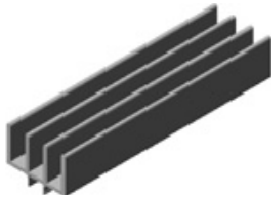


Assembly instructions using joining plates:

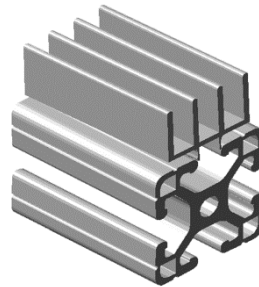
1. Insert screw thru bracket and thread slightly into t-nut
2. Slide bracket with loaded hardware into the slot of the extrusion
3. Align to desired position and tighten fasteners

Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end t-handle allen wrench
  2. 10 series: 13TL1203 - 5/32" ball end t-handle allen wrench
- 



**Door Track:** A profile that snaps into an extrusion T-Slot creating mini-slots for sliding doors.

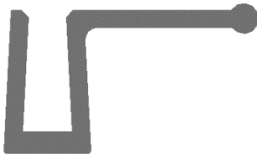


Assembly instructions using door track:

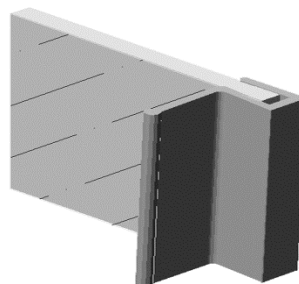
1. Set the track over the T-Slot of the desired extrusion
  - a. Door track with bumps in the track are lower and the track without bumps is the upper
2. Start from one end and pound in with a rubber mallet

Tools needed:

1. Rubber mallet
- 



**Panel Stiffener:** An aluminum profile that snaps on the edge of a plastic panel to improve the rigidity, as well as an option for a built in handle.

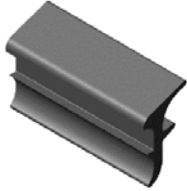


Assembly instructions using panel stiffener:

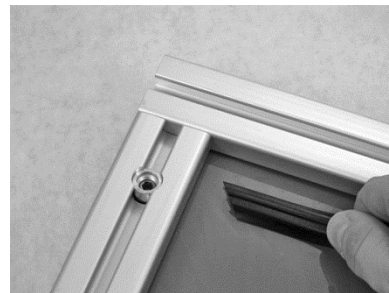
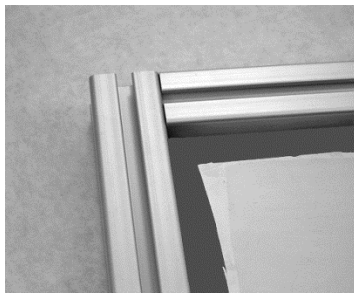
1. Set the stiffener over the edge of the panel
2. Start from one end and pound onto the panel with a rubber mallet

Tools needed:

1. Rubber mallet



**Panel Gasket:** Molded rubber used to wedge the plastic panel against the T-Slot to prevent rattling.

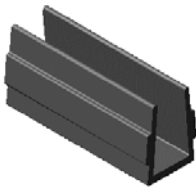


Assembly instructions using rubber panel gasket:

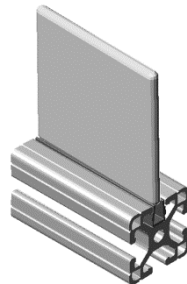
1. Set the small section of the gasket and press it into the start of one side of the panel with the top of the gasket angled up against the panel.
  - a. Gasket is to be installed on the outside of the guard
2. Press the gasket in all the way along the side
3. Snip the back of the gasket to turn the corner and continue along the remaining sides

Tools needed:

1. Cutter



**U-Shape Panel Gasket:** Molded plastic used to wedge the plastic panel in the T-Slot to prevent rattling.



Assembly instructions using U-shaped panel gasket:

1. Cut the gasket to the length of the given extrusion
2. Press into the T-Slot of the extrusion

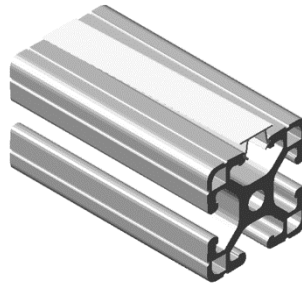
3. Set panel over the gasket and pound in with a rubber mallet

Tools needed:

1. Cutter
2. Rubber mallet



**T-Slot Cover:** Molded plastic used to cover the T-Slot to keep dirt out or to give a clean, smooth look.



Assembly instructions using anchor fasteners:

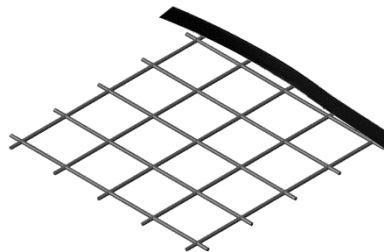
1. Cut the cover to the length of the given extrusion
2. Press into one side of the T-Slot of the extrusion
3. Press or pound the cover all the way to the other end of the profile

Tools needed:

1. Rubber mallet
2. Cutter



**Wire Edging:** A rubber coated metal used to form on the edge of a sharp edge of a plastic or wire panel.

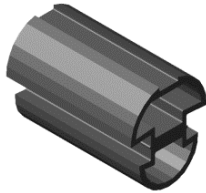


Assembly instructions using wire edging:

1. Cut the wire edging to the length of the panel or the opening being edged
2. Press onto one end of the panel or the opening being edged
3. Press the edging on the rest of the panel or the opening being edged

Tools needed:

1. Cutter
- 



**Door Seal:** Molded rubber used to create a seal between a door and the door jams.

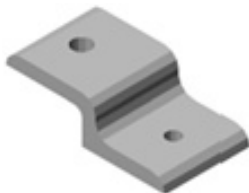


Assembly instructions using door seal:

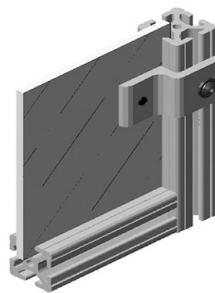
1. Cut the seal to the length of the given extrusion
2. Press into one side of the T-Slot of the extrusion
3. Press the seal all the way to the other end of the profile

Tools needed:

1. Cutter
- 



**Panel Retainers:** “S” shaped bracket used to add additional stiffness and security to a plastic panel.

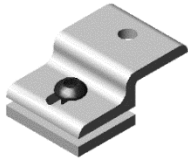


Assembly instructions using panel retainers:

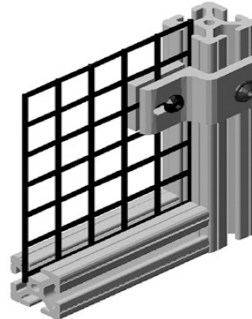
1. Insert screw thru hole of upper hole in bracket and thread slightly into t-nut
2. Slide bracket with loaded hardware into the T-Slot of the extrusion
3. Position tapped hole of retainer with the access hole in the plastic panel
4. Insert bolt thru the plastic panel and thread into the retainer

Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end t-handle allen wrench
2. 10 series: 13TL1203 - 5/32" ball end t-handle allen wrench



**Mesh Retainers:** "S" shaped bracket used to add additional stiffness and security to a mesh panel.



Assembly instructions using mesh retainers:

1. Insert screw thru hole of upper hole in bracket and thread slightly into t-nut
2. Slide bracket with loaded hardware into the T-Slot of the extrusion
3. Position slotted hole of retainer with an open square in the wire panel
4. While holding the backing plate against the back of the mesh panel, insert bolt thru the slotted hole of the retainer and thread into the backing plate

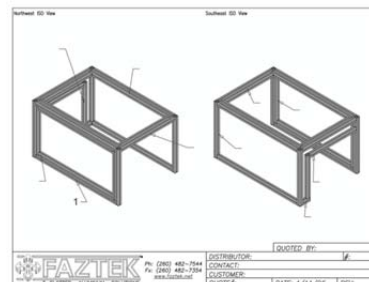
Tools needed:

1. 15 series: 13TL1201 - 3/16" ball end t-handle allen wrench
2. 10 series: 13TL1203 - 5/32" ball end t-handle allen wrench

### Basic Order of Operation

1. Print and organize drawings and bill of materials

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PHONE: <input type="text"/>		PHONE: <input type="text"/>	
EMAIL ADDRESS: <input type="text"/>		EMAIL ADDRESS: <input type="text"/>	
DATE: 4/11/2018	REV: <input type="text"/>	QUOTED BY: <input type="text"/>	REFERENCE: <input type="text"/>
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1.5	1.5	1.5	1.5
1.6	1.6	1.6	1.6
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1.8	1.8	1.8	1.8
1.9	1.9	1.9	1.9
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1.98	1.98	1.98	1.98
1.99	1.99	1.99	1.99
1.100	1.100	1.100	1.100



1. Unpack project
2. Organize product:
  - a. Bars in order according to the tag numbers
  - b. Panels in order according to the tag numbers



c. Parts grouped by part type



4. Pre-load all brackets and plates

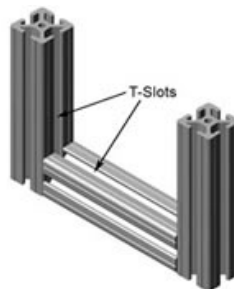


5. Begin assembling.

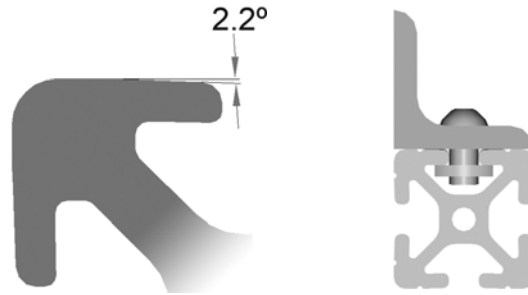
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### Additional Assembly Tips

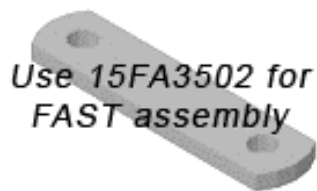
1. Captive T-Slots are extrusion T-Slots which have been closed off on each side due to the addition of other extrusions, accessories, or any other components. It is important that you think through when assembling your project to avoid closing a T-Slot which must be open to accept additional fasteners and components. This is especially important when using t-nuts other than the drop-in style, which can be added to a captive T-Slot.



2. Drop-lock feature
  - a. Faztek's T-Slotted Aluminum Extrusion profiles contain a slight taper from the extrusion face to the T-Slot center. This taper, called "drop-lock", allows the extrusion to be drawn up to the mating surface causing it to act as a lock washer.



1. Double & Triple T-nuts: When possible, use double or triple t-nuts to save time and increase efficiency.



1. Ball End Allen Wrench: When assembling extrusions using anchor fasteners, use a ball end allen wrench to allow tightening at an angle.

