S1-27/D4-KIT/D7-KIT ASSEMBLY
For Mounting V-100 / D-1000 / E100 / E200

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1) Remove all parts from the box they were shipped in.

2) Assemble S1-27 base using (4) Vertical Rails and (4) Horizontal Rails.

3) Install and **Leave Loose**
   - (16) 5/16-18 x 1/2” Bolts
   - (8) 5/16-18 Double Nuts

4) Install a Wheel Bracket on each corner. **Leave Loose** for now.
   - (4) 5/16-18 x 1/2” Bolts
   - (2) 5/16-18 Double Nuts
   - (1) Wheel Bracket
5) Use a carpenters square or equivalent to hold verticals square to horizontals. 
Tighten ALL installed bolts with 1/2" or 13mm wrench while holding Vertical Square.

6) Install A wheel on each wheel bracket. 
Tighten well using 9/16" or 15mm wrench
   -(1) Wheel with Stud
   -(1) 3/8-16 Lock Nut

7) Install (4) upper Horizontal Rails 
Tighten Well using 9/16" or 15mm wrench.
   - (16) 5/16-18 x 1/2" Bolts
   - (8) 5/16-18 Double Nuts

8) Install Lower Dust Cover 
Tighten Well using Philips Head Screw Driver.
   - (6) #8 Philips Head Sheet Metal Screw
   - (1) Dust Cover
9) Install (1) Nutplate in each corner using (1) 5/16-18 x 1/2” bolt to hold each in place. (2) Nutplates should be installed on (2) Sides. See photos for orientation.

Optional 3 Drawer Upgrade

9a) Install (1) Flat Nutplate in each corner using (1) 5/16-18 x 1/2” bolt to hold each in place. (2) Flat Nutplates should be installed on (2) Sides.

10) Install Drawer Slides as shown. Fixed wheel must be positioned in front of assembly. Push Slide towards outside of assembly while tightening. Tighten well using 1/2” wrench -(2) 5/16-18 x 1/2” Bolt (each slide)

10a) Your drawer slides will be assembled from the factory. See below diagrams for reference.

11) Remove 5/16-18 bolt used for holding mount angle and install all remaining Drawer Slides.
12) Slide All Drawer Assemblies into assembly from the REAR of stand. Drawers have wheels preinstalled on rear from factory.

13) Install Tall Skins on 3 sides as shown. 
**Tighten well using 1/4” nut driver or flat blade screw driver**
- (2) Tall Skin w/ Screen Print 
- (1) Tall Skin, No Screen Print (rear) 
- (4) #8 Sheet Metal Screws (each skin)

14) Install front Short Skin 
**Tighten well using 1/4” nut driver or flat blade screw driver**
- (1) Short Skin 
- (2) #8 Sheet Metal Screws
15) Install Top Dust Cover

Tighten well using Philips Head screw driver

- (1) Dust Cover
- (6) #8 Philips Head Sheet Metal Screws

Optional 3 Drawer Upgrade

16) Install Lower Skins on 3 sides as shown.

Tighten well using 1/4” nut driver or flat blade screw driver

- (3) Lower Skin
- (4) #8 Sheet Metal Screws (each skin)
Assembly (V100 Mount)

1) Install Top Mount Panels
Tighten well using (2) 7/16” or 11mm wrenches
-(2) Top Mount Panels
-(10) 1/4”-20 x 1/2” Bolts
-(10) 1/4” Lock Nuts

Assembly (D1000 / E100 / E200 Mount)

1) Install Mount Angles
Tighten well using 1/2” or 13mm wrenches
-(2) Mount Angles
-(4) 5/16”-18 x 1/2” Bolts
-(4) 5/16”-18 Serrated Nuts

Angles face OUT for E-100/E-200

Angles face IN for D-1000