



INSTALLATION OF PRECISION RACK FRONT DOOR

Parts List

<u>Description</u>	<u>Part Number</u>
Door	Varies
Spacer Bar	S16390-A
Door Latch (attached to spacer bracket)	S16630-A
Top Hinge Bracket (Fig. 1)	S15930-A
Bottom Hinge Bracket (Fig. 2)	S15911-A
Spacer Pad (Fig. 3)	S16941-A
Nylon Bushings	
Shoulder Bolts	
Large Metal Washers	
Small Metal Washers	
Acorn Nuts	
Rubber Bumpers	
10-24 x 1/2" Screws	



Figure 1
Top Hinge Bracket

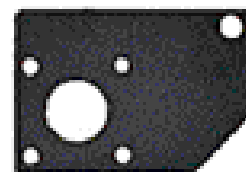


Figure 2
Bottom Hinge Bracket



Figure 3
Spacer Pad

Key Holder Kit (Key Holder, Handle Ring, Lock Washer, Plastic Nut, Keys)

Procedure

Step 1 – Remove standard spacer bar from Precision Rack and replace it with modified spacer bar.

Table 1 displays which spacer bar should be removed from which cabinet. There are two Phillips screws holding the spacer bar to the RETMA rail. Unscrew the two screws (marking the exact holes) and pull the spacer bar out. Before inserting the modified spacer bar, decide which side you would like the handle of the door to be on. The handle will connect to the Door Latch on the spacer bar. Place the spacer bar to connect to the door accordingly. Replace and tighten the two Phillips screws, using the holes you marked.

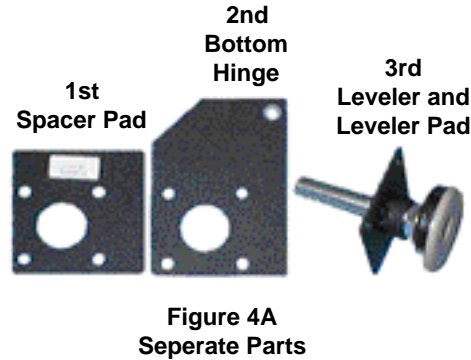
Precision Rack Model	Spacer Bar to Remove
Precision Rack 1000 or 1100	Bottom Spacer Bar
Precision Rack 2000	Second from Bottom
Precision Rack 3000	Third from Bottom

Step 2 – Position Precision Rack so the Bottom Panel is Exposed

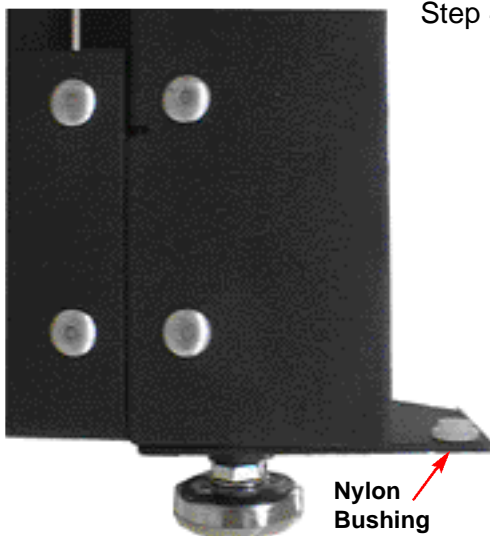
The Precision Rack must be positioned so that the bottom of the rack can be easily accessed. It is recommended that all system drawers be removed before positioning the Precision Rack.

Step 3 – Attach Hardware to Bottom of Precision Rack

- a. Remove leveler and leveler pad from the bottom of the Precision Rack. The leveler to be removed will be in the front and on the opposite side of where the handle will be. Therefore, check the spacer bar door latch position and remove the leveler that is on the opposite side of the latch. There are four Phillips screws holding the leveler in place. Save these screws.



- b. Stack the following parts in this order:
- c. With the Spacer Plate resting on the bottom of the Precision Rack, line up the three parts (in the order shown, with the extended end of the Bottom Hinge Bracket extending out the front). See Figures 4A and 4B. Use the four screws from Step 3– a. to attach these three parts to the bottom of the Precision Rack.
- d. Place a nylon bushing into the hole of the Bottom Hinge Bracket from the top. See Figure 5.



Step 4 – Attach Hardware to Top of Precision Rack Door

- a. From the same side as where the leveler was removed, remove the three corner screws from the top of the Precision Rack using a Phillips screwdriver. See Figure 6. Discard these screws.



- b. Place a nylon bushing in the outer hole of the Top Hinge Bracket. See Figures 7 and 8 for bushing placement. Use a mallet or hammer to push the bushing firmly through.
- c. Place the Top Hinge Bracket on the top of the Precision Rack Door. The nylon bushing will fit into the hole at the top of the door (refer to Figures 9 and 10).
- d. Remove a Shoulder Bolt from the package. Place a large washer over the Shoulder Bolt. Insert the Shoulder Bolt into the nylon bushing. Secure the Top Hinge Bracket via the Nylon Bushing by placing a small washer over the end of the Shoulder Bolt and the Acorn Nut on the end of the Shoulder Bolt (see Figure 10). Tighten.

**Door Hinge Placed
On Right Side**

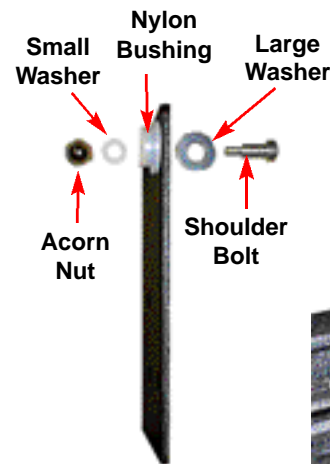


**Figure 7
Bushings Placement in Top Hinge Plate**

**Door Hinge Placed
On Left Side**



**Figure 8
Bushings Placement in Top Hinge Plate**



**Figure 9
Shoulder Bolt
Assembly**



**Figure 10
Acorn Nut Placement
(Mounted on Top Right of Door)**

Step 5 – Install Precision Rack Door

- a. To install the Precision Rack door, find the only hole on the bottom edge of the door. Lift the door and align the hole over the nylon bushing which is on the Bottom Hinge Bracket, already attached to the Precision Rack. Align the three holes in the Top Hinge Bracket over the three corner holes in the top of the Precision Rack. Using the three Phillips 10-24 x 1/2" screws supplied in the packaged parts, attach the Top Hinge Bracket to the Precision Rack.
- b. Remove a Shoulder Bolt from the package. Place a large washer over the Shoulder Bolt. Insert the Shoulder Bolt and washer into the nylon bushing in the Bottom Hinge Bracket - *from the bottom*. On the end of the Shoulder Bolt, place a small washer and an Acorn Nut. Tighten.

Step 6 – Attach Key Holder and Rubber Bumpers

- a. Take the handle Ring and place it over the Key Holder (see Figure 11). Insert these two parts through the door hole, making sure the latch is on the same side as the door frame.



**Figure 11
Key Holder and Handle Ring**

- b. From the backside of the door, place the Lock Washer over the end of the Key Holder.
- c. Place the Plastic Nut Screw over the Lock Washer (see Figures 12 & 13) and tighten.
- d. Remove the backing from one of the Rubber Bumpers and place it on the top of the inside rail of the door frame, sticky end down. (The bumpers provide cushioning between the door and the rail.)
- e. Remove the backing from the other Rubber Bumper and place it on the bottom inside rail of the door frame, sticky end down.

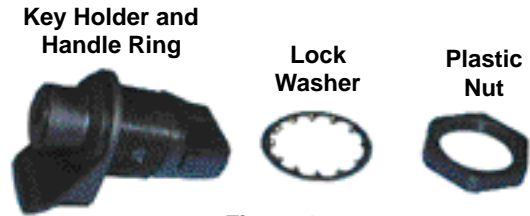


Figure 12
Key Holder Assembly

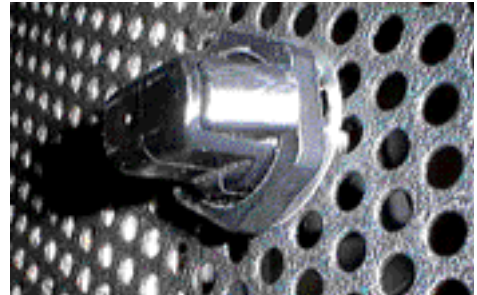


Figure 13
Lock Washer and Plastic Nut
(View From Inside of door)

If you have any questions, please contact our customer service department. Contact information is listed below.

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