

## PCT-7510 PLASMA CUTTING TABLE

Order Code W08602



Due to the weight of the table, it is highly recommended that you have a second person to assist during the build of the table, being made from steel it is heavy and help should be obtained to avoid any injuries. Always remember to wear the appropriate PPE when working with metal and welding equipment. Refer to your welder manufacturers recommendations for the correct settings for your welder to suit the material thickness.

### Suggestion of what you will need

Note - this assembly guide is merely a recommendation and should not be followed blindly, if you do not have the equipment or the experience necessary to complete this project you should consider seeking advice from a professional.

- 'G' Clamps (or alternative) with an opening of at least 100mm to secure the table in place during welding..
- MIG or TIG welder
- Angle grinder fitted with a fine flap disc
- Level and square to ensure all components are square before welding
- Engineers file, M6 & M8 hex keys, spanners or shifting spanner and a soft face hammer

**NOTE:** You may consider to use other methods and tools to help complete your project, the above list is just a suggestion. read through these instructions before starting the assembly process.

### Getting Started

Before starting the assembly ensure you have the correct tools & equipment to successfully assemble the table whilst making sure you are wearing the appropriate Safety PPE.

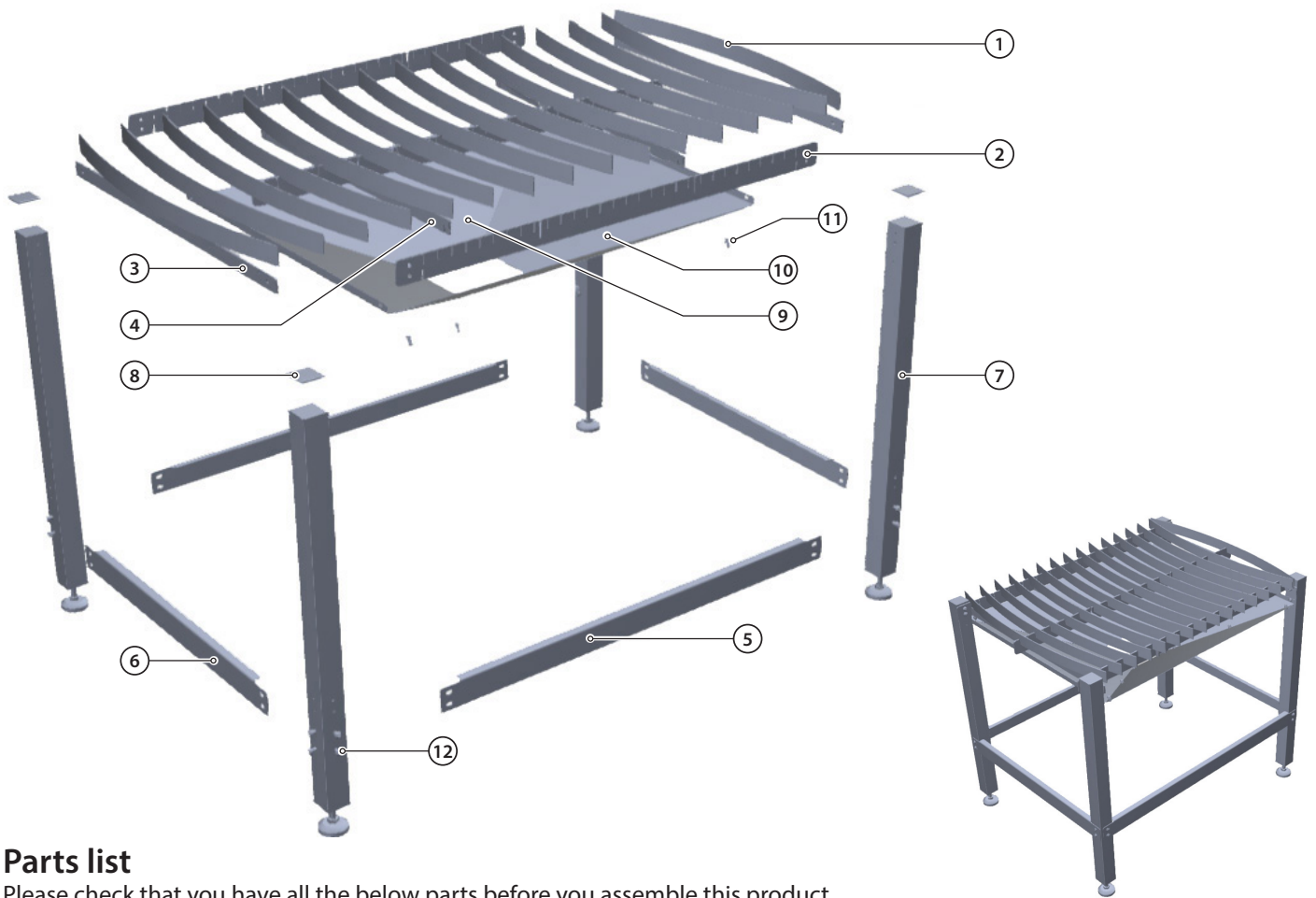


### Check for Burrs

It is normal for the components to have small burrs or minor imperfections as part of the laser cutting process. While wearing protective gloves, check the edges of the individual pieces and visually inspect them for any small burrs. If you do happen to find one, use a file to remove any burrs, being careful not to remove too much excess material as it may affect the end result.

### Clean Components

The components are supplied painted to protect it from rust, however, paint must be removed before any welding can take place.



## Parts list

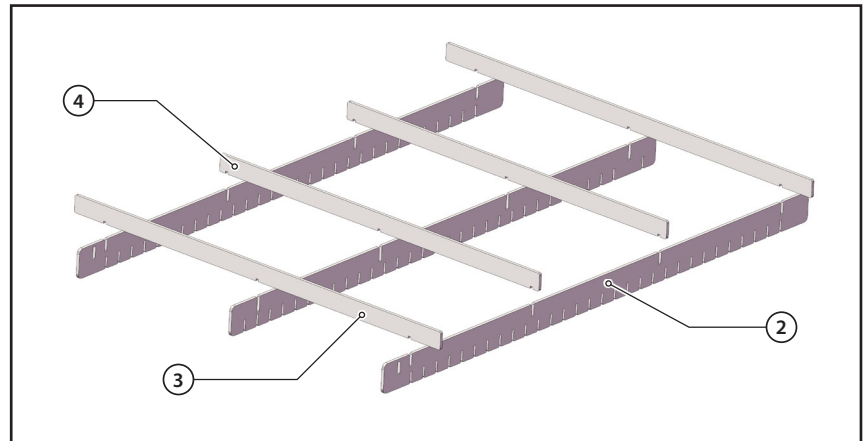
Please check that you have all the below parts before you assemble this product

Part	Image	Part	Image
<b>1.</b> Table Ribs Qty: 16		<b>7.</b> Legs Qty: 4	
<b>2.</b> Long Ribs Qty: 3		<b>8.</b> Leg Top Caps Qty: 4	
<b>3.</b> Cross Rib Ends Qty: 2		<b>9.</b> Long Chute Sides Qty: 2	
<b>4.</b> Cross Rib Centres Qty: 2		<b>10.</b> Short Chute Sides Qty: 2	
<b>5.</b> Long Leg Braces Qty: 2		<b>11.</b> M6 Screws & Dome Nuts Qty: 12	
<b>6.</b> Short Leg Braces Qty: 2		<b>12.</b> M8 Screws Qty: 20	

## Step 1

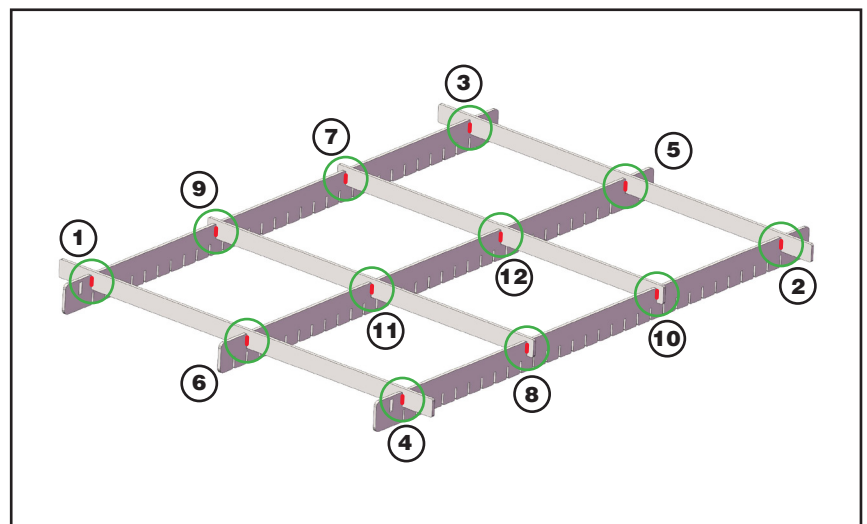
Assemble upside down on a flat level surface 3 x long ribs #2, 2 x cross ribs ends #3 & 2 x cross rib centres #4 together.

Use a soft-face hammer to lightly tap the components into place. If they do not fit correctly the first time, be sure to check for any small burrs and then try again. Use clamps etc to hold together making sure its all square. Ensure components are level and doesn't rock from side to side.



## Step 2

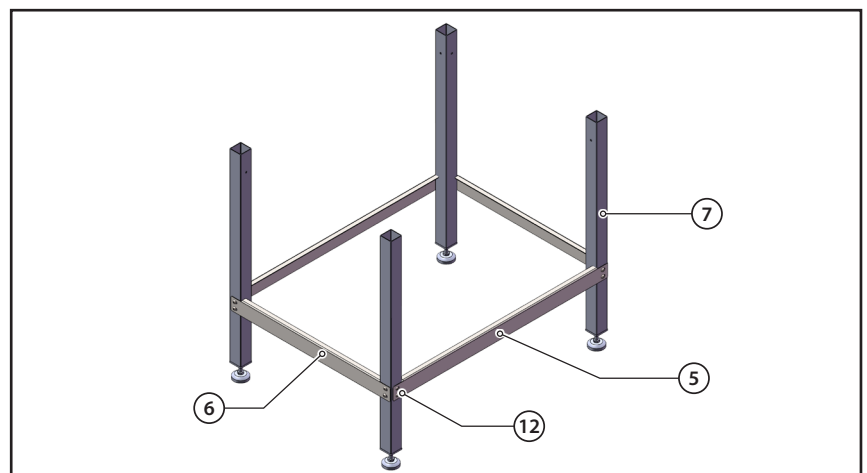
Once you are happy with the assembly and flatness, weld the areas highlighted in red in the sequence as indicated, and weld so that the two pieces fuse together correctly. Less is more when welding this table together. More welding means more heat and higher chances of warping the frame.



## Step 3

Assemble 4 x legs #7 and leg braces #5 & #6 together using 16 x M8 Screws #12 as shown. Adjust feet to ensure the legs are all the same height from ground and make sure its assembled on a flat level surface.

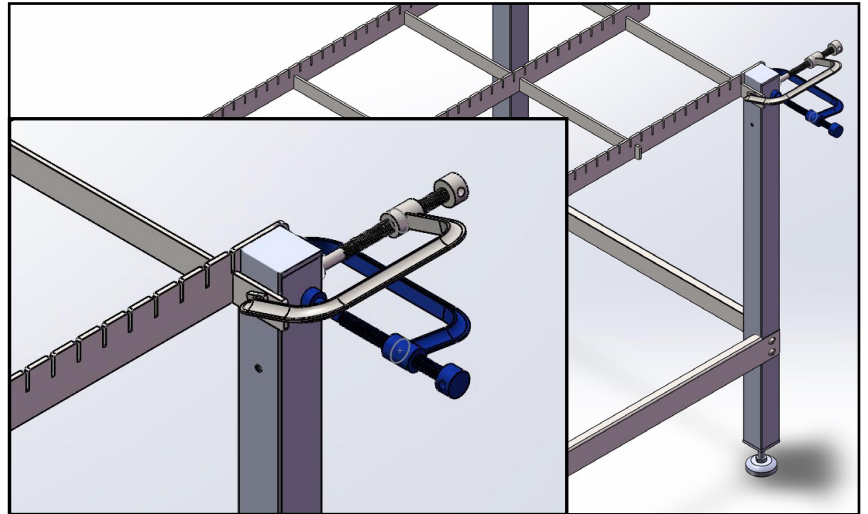
NOTE: Leave screws loose for now.



## Step 4

Once the frame has cooled, turn the frame over with the rib slots facing up. With the assistance of a second person, insert the frame to the assembled legs. Clamp all external corners of the frame to the tube legs as shown using your G-clamps ensuring the top cap #8 is level with the long rib #2. Check that the legs and frame are square and level with a builders level or straight edge.

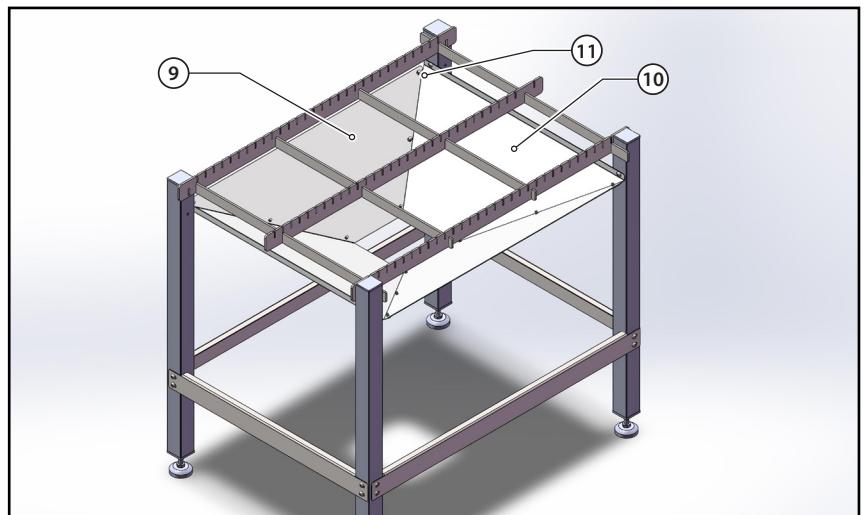
Note: Prior to welding ensure you remove a small amount of the powder coat finish in the area to be welded.



## Step 5

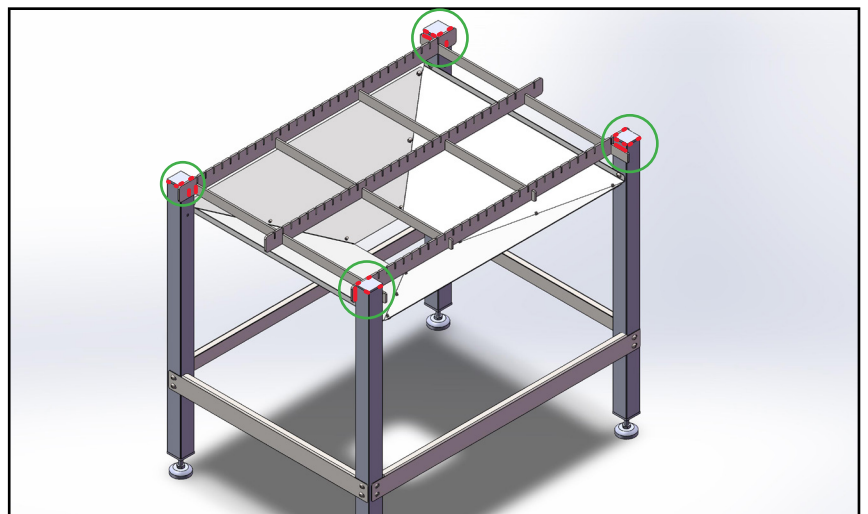
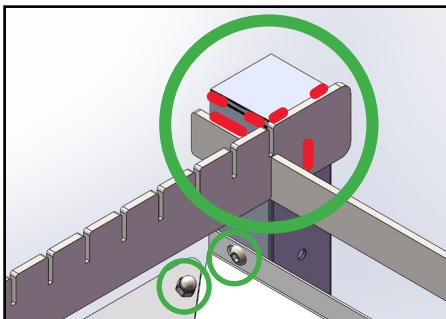
Assemble the chute using 12 x M6 screws & dome nuts #11 and use 4 x M8 screws #12 to attach to the plasma cutting table as shown.

NOTE: Leave screws loose for now.



## Step 6

Then proceed to weld long ribs #2 flush with top caps #8 and cross rib ends #3 as shown below. Once finished welding, tighten all screws.



## Step 7

Insert all 16 x table ribs #1 into the long rib #2 slots and if necessary use a soft face hammer to tap in flush as shown.

Your plasma cutting table is now ready for use.

