STRUCTURAL HOLDING, F150 TOOL BOARD, AND CART ASSEMBLY
F150 Structural Holding Tool Board Cart

Step 1: Caster Assembly.

A.) Assemble 5” Casters using (4) M8 x 1.25 x 16mm Lg. HHCS and (4) M8 x 1.25 Hex Lock Nuts.

---

Step 2: Cart Tower Assembly.

A.) Assemble the Left and Right Cart Tower Assembly supports using (2) M8 x 1.25 x 16mm Lg. HHCS and (2) M8 x 1.25 Hex Lock Nuts.
Step 3: Rear Cart Support Assembly.

A.) Assemble the Rear Cart Support using (4) M8 x 1.25 x 16mm Lg. HHCS and (4) M8 x 1.25 Hex Lock Nuts.

Step 4: Cart Disk and Hairpin Cotter Pin.

A.) Install the (2) Cart Disk followed by (2) Hairpin Cotter Pins.

Step 5: Board Assembly “A”.

A.) Assemble Board Assembly “A” to the Cart Tower Supports using (8) Phillips Pancake Head Self Drilling Screws. For driving screws, use #2 Square Drive Power Bit, 619295 provided (Do Not attempt using Phillips Drive).
Step 6: Board Assembly “B”.

A.) Assemble Board Assembly “B” to the Cart Tower Supports using (8) Phillips Pancake Head Self Drilling Screws. For driving screws, use #2 Square Drive Power Bit, 619295 provided (Do Not attempt using Phillips Drive).

Step 7: Attaching Board Assemblies.

A.) Attach Anchor Board “A” and Anchor Board “B” together using (1) M8 x 1.25 x 16mm Lg. HHCS and (1) M8 x 1.25 Hex Lock Nut.
Step 8: Board Assembly “C”.

A.) Assemble Board Assembly “C” to the Cart Tower Supports using (8) Phillips Pancake Head Self Drilling Screws. For driving screws, use #2 Square Drive Power Bit, 619295 provided (Do Not attempt using Phillips Drive).
Step 9: Bolt Tray and Long Tool Board Hangers (Tool Board “A”).

A.) Attach the Bolt Tray using (4) Long Tool Board Hangers and (8) 1/4”-20NC Hex Lock Nuts.

B.) Assemble the remaining Long Tool Board Hangers using (2) 1/4”-20NC Hex Lock Nuts.

Step 10: Bolt Tray Hangers (Tool Board “A”).

A.) Assemble the Straight Tool Board Hangers to the Bolt Tray using (2) 1/4”-20NC Hex Lock Nuts.
Step 11: Tool Board Hangers (Tool Board “B”).


B.) Assemble the remaining Long Tool Board Hangers to Tool Board “B” using 1/4”-20NC Hex Lock Nuts.
Step 12: Bolt Tray and Long Tool Board Hangers (Tool Board “C”).

A.) Attach the Bolt Tray to Tool Board “C” using (2) 1/4”-20NC x 1/2” Lg. Hex Head Bolts and (2) 1/4”-20NC Hex Lock Nuts.

B.) Assemble the remaining Long Tool Board Hangers using (2) 1/4”-20NC Hex Lock Nuts.

Step 13: Bolt Tray Hangers (Tool Board “C”).

A.) Assemble the Straight Tool Board Hangers to the Bolt Tray using (2) 1/4”-20NC Hex Lock Nuts.
Step 14: Tool Board “A”.

A.) Assemble Tools to Long Tool Board Hangers.
Step 15: Tool Tray (Tool Board “A”).

A.) Assemble Hardware to Straight Tool Board Hangers.
Step 16: Tool Board “B”.

A.) Assemble Tools to Long Tool Board Hangers.

B.) Assemble Tools to Straight Tool Board Hangers.

- Release Pin #502058
- 4" Extension Tube #502016
- 10" Extension Tube #502061
- Angle Adapter Clamp #502026
- Short Vertical Fixture #502000
- Large Horizontal Fixture #502005
- Tall Tube Base Stand #502063
- Base Plate #502042
- 3/4" Flat Washer #41021
- Fastening Bar #606860
- Structural Holding Base #502047
- M20 x 2.5 x 140mm Hex Bolt #539008
- Adapter #502039
- Tall Vertical Fixture #502008
- Tall Horizontal Fixture #502019
- Short Tube Base Stand #502055
Step 17: Tool Board “C”.

A.) Assemble Tools to Long Tool Board Hangers.
Step 18: Tool Tray (Tool Board “C”).

A.) Assemble Hardware to Straight Tool Board Hangers.