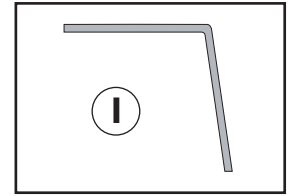
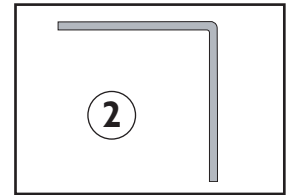


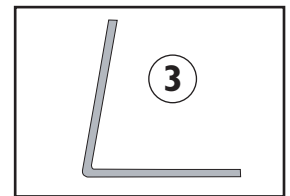
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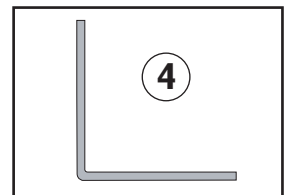
Upper Front Stretchers



Upper Side Stretchers



Lower Front Stretchers



Lower Side Stretchers

*Patent Pending

PARTS LIST

	Quantity		Quantity
1 Upper Front Stretchers (23 $\frac{3}{8}$ " L w/label)	2	8 Locking Swivel Casters	2
2 Upper Side Stretchers (11 $\frac{1}{8}$ " L)	2	9 Nuts for Swivel Casters	4
3 Lower Front Stretchers (23 $\frac{3}{8}$ " L)	2	10 5/16-18 Bolts	32
4 Lower Side Stretchers (29 $\frac{3}{8}$ " L)	2	11 5/16-18 Nuts	32
5 Left Legs (54 $\frac{1}{2}$ " L)	2	12 5/8" Clamp Rods	8
6 Right Legs (54 $\frac{1}{2}$ " L)	2	13 Retainer Pins	16
7 Non-Locking Swivel Casters	2	14 Shelf Hooks	4

TOOLS NEEDED

- 1/2" Box Wrench
- 1/2" Socket
- 3/4" Box Wrench (for Caster Nut)
- Carpenter's Square
- Sliding T-Bevel or Angle Finder

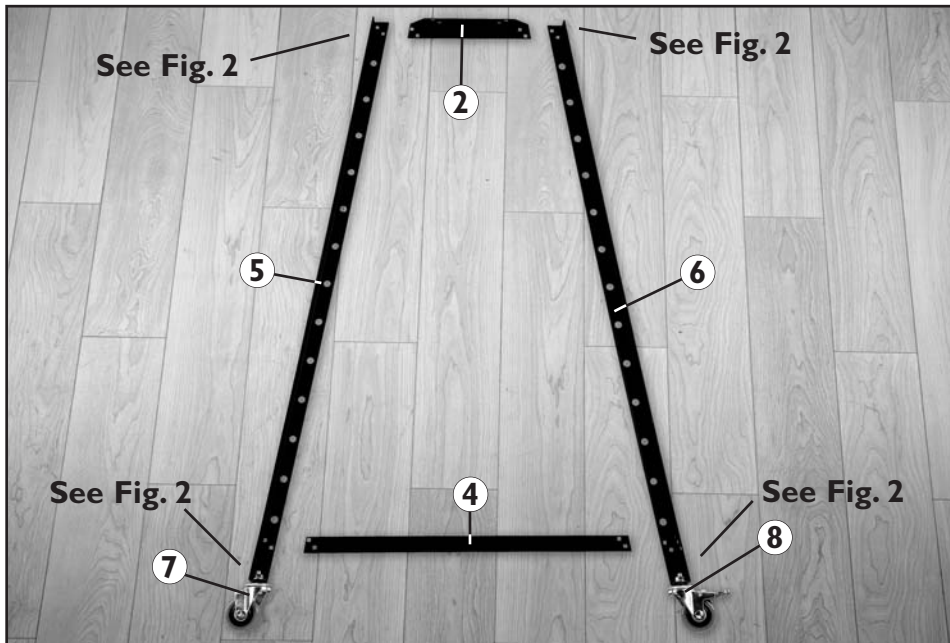


Fig. 1

Note: Only 1 bolt is needed per connection until the rack is completely assembled. Then the rack is squared up and the remaining bolts are installed.

1. On the floor or large workbench, layout 2 legs - one left (5) and one right leg (6) as well as one 11 $\frac{1}{8}$ " Upper Side Stretcher (2) and one 29 $\frac{3}{8}$ " Lower Side Stretcher (4). Attach one non locking caster (7) to the bottom of the left leg (5) and one locking caster (8) to the bottom of the right leg (6) using 3/4" caster nuts (9). **Fig. 1.**

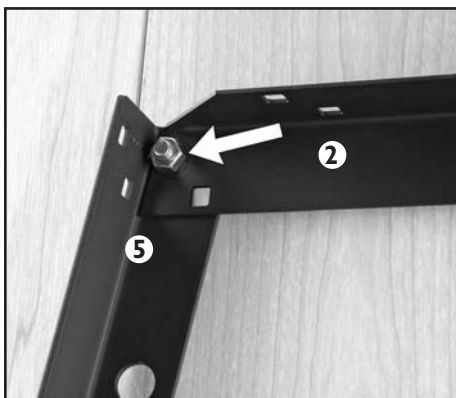


Fig. 2

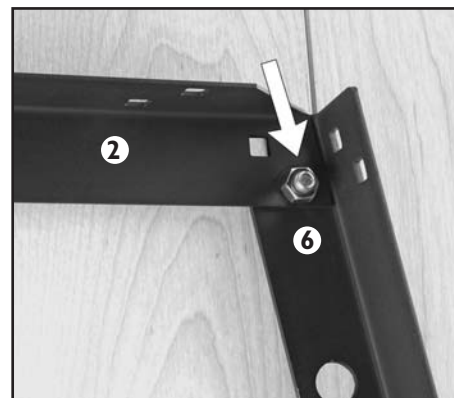


Fig. 3

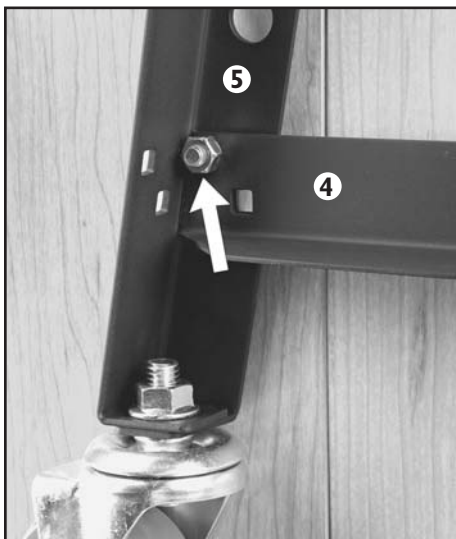


Fig. 4

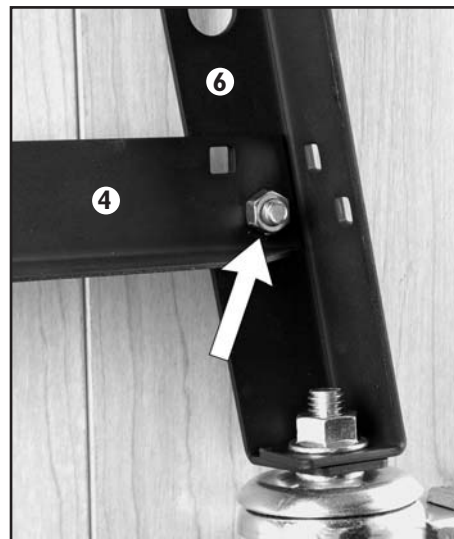


Fig. 5

2. Starting with the upper left corner, fasten the left leg (5) and the Upper Side Stretcher (2) with a 5/16-18 bolt (10) and nut (11). Use the hole closest to the inside corner of the leg as shown in **Fig. 2**. Leave the adjacent hole open at this time.
3. Move to the upper right side and fasten the right leg (6) and the Upper Side Stretcher (2) again using the 5/16-18 bolts (10) and nut (11) using the hole closest to the inside corner of the leg. **Fig. 3.**
4. Follow the same procedure as above to attach the left leg (5) and right leg (6) to the Lower Side Stretcher (4) using the bolt hole closest to the inside corners of the legs. **Fig 4 & 5.**

5. Leave this side assembly on your floor or bench to attach the 23 $\frac{3}{8}$ " Upper Front Stretchers (1) and 23 $\frac{3}{8}$ " Lower Front Stretchers (3).

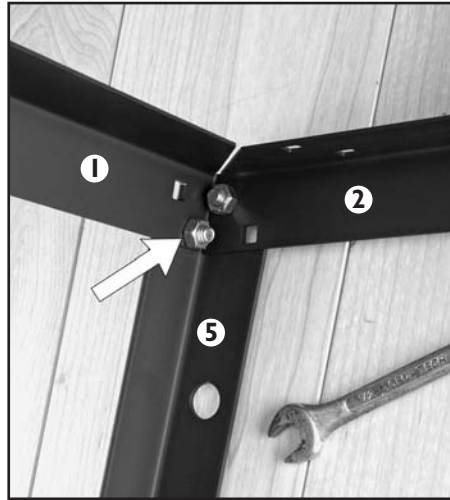


Fig. 6

6. Starting with the upper left corner, fasten the Upper Front Stretcher (with "Rockler" label) perpendicular to the left leg (5) using the hole closest to the inside corner of the leg. **Fig. 6.**

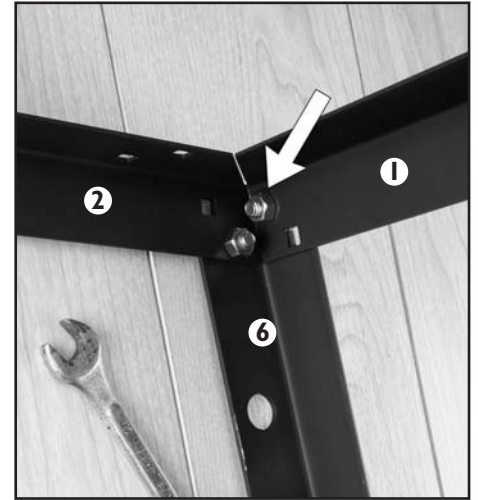


Fig. 7

7. Move to the upper right side and fasten the Upper Front Stretcher with label (1) to the right leg (6) using the hole closest to the inside corner of the leg. **Fig. 7.**

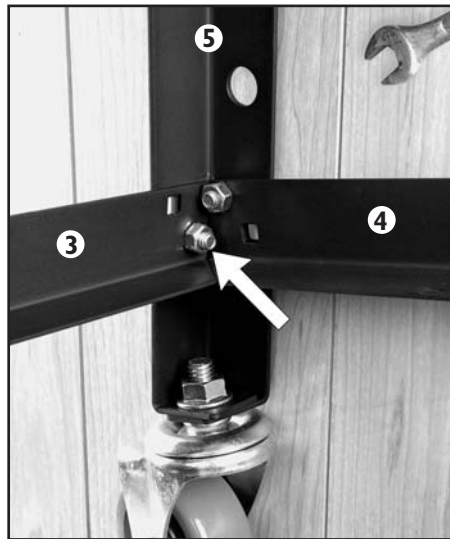


Fig. 8

8. Follow the same procedure as above to attach the Lower Front Stretchers (3) to the left and right leg - again, using the bolt hole closest to the inside corner of the legs. **Fig 8 & 9.**



Fig. 9

9. At this point your assembly should look like **Fig. 10.**

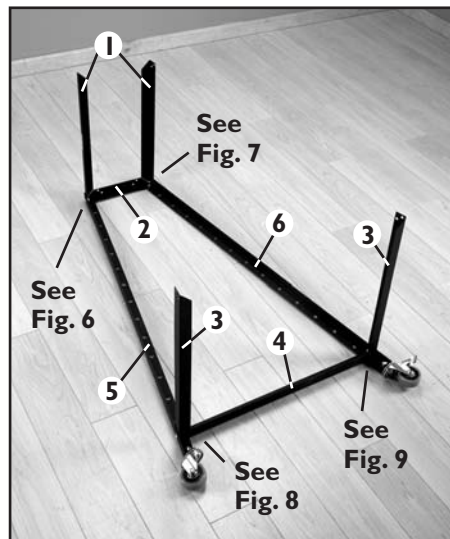


Fig. 10

10. Next, assemble the other side of the rack following the same steps as 1 - 4. Place the first assembly (with Upper and Lower Front Stretchers attached) over the new side assembly. **Fig. 11.** Follow the same steps to attach these two parts together as in steps 6 - 8.



Fig. 11



Fig. 12

11. At this point, bring the Pack Rack upright to square the assembly. Using a carpenter's square, lay it flat on the bottom inside ledge of the rack and adjust to square. Move to the opposite corner and repeat. **Fig. 12.**

Since there is only one bolt in all corners, the rack will be easy to adjust for flat and square.

12. Again, using the carpenter's square, align the top edge of the Lower Front Stretcher (3) with the bottom edge of the square. Now place the left edge of the square against the left edge of the Left Leg (5) and adjust as needed. **Fig. 13.**

Do this same procedure for the opposite corner.

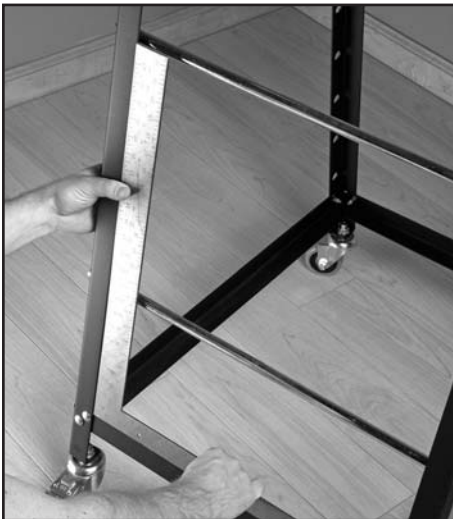


Fig. 13

13. Using a sliding T-bevel or adjustable angle finder, you can square the side of the rack. The upper angle should roughly measure 100° and the lower angle should roughly measure 80° . The important part is that the opposing angles are as close to each other as possible.



Fig. 14

14. Once the Rack is square, go around every corner and fasten all of the remaining nuts and bolts.



Fig. 15

15. The Shelf Hooks (14) are attached to the underside of a shop made shelf using #8 wood screws of a machine screw and nut for added stability. **Fig. 15.**



Fig. 16

16. The bottom of the Pack Rack is designed to accept a shop made shelf to be dropped into place. Note that you will need to chamfer the corners of the shelf to avoid hitting the fasteners. **Fig. 16.**