

## INSTRUCTIONS FOR : LBPH-77 ASSEMBLY

VESTIL MFG. CO. / T&amp;S EQPT. CO.

PRODUCTS USED ON: LONG BAR PIGEON HOLE RACKS  
(LIST ALL KNOWN)

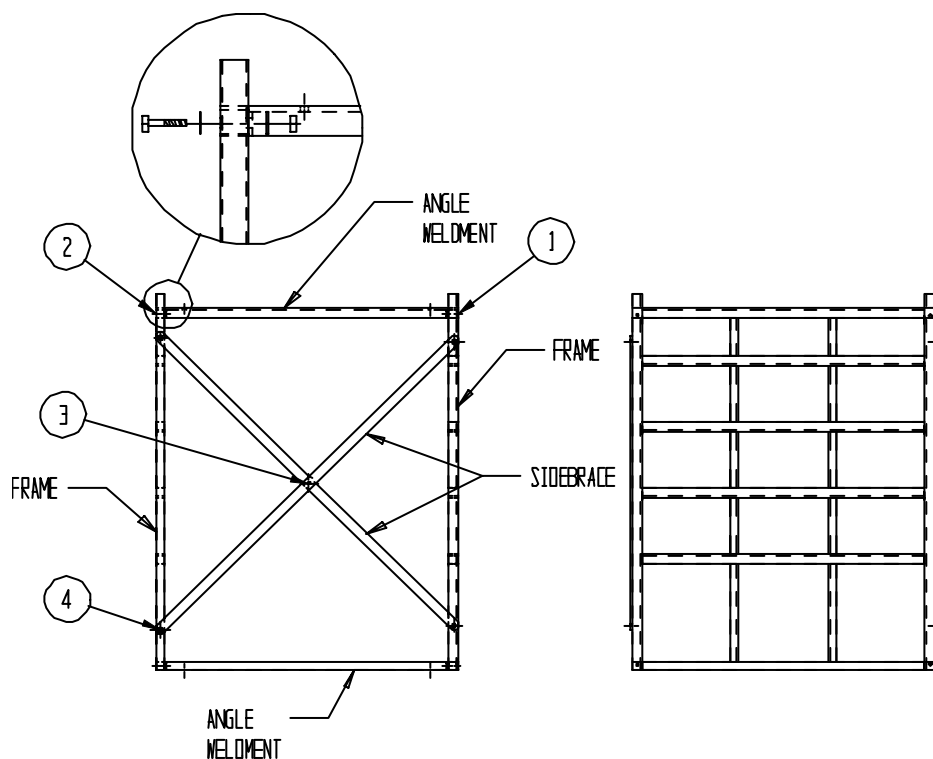
For assembly of long bar pigeon hole racks, follow these instructions.

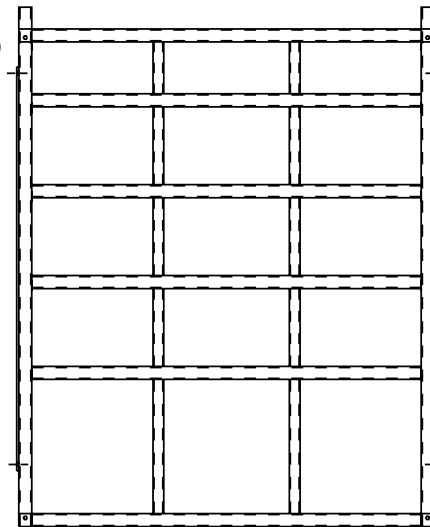
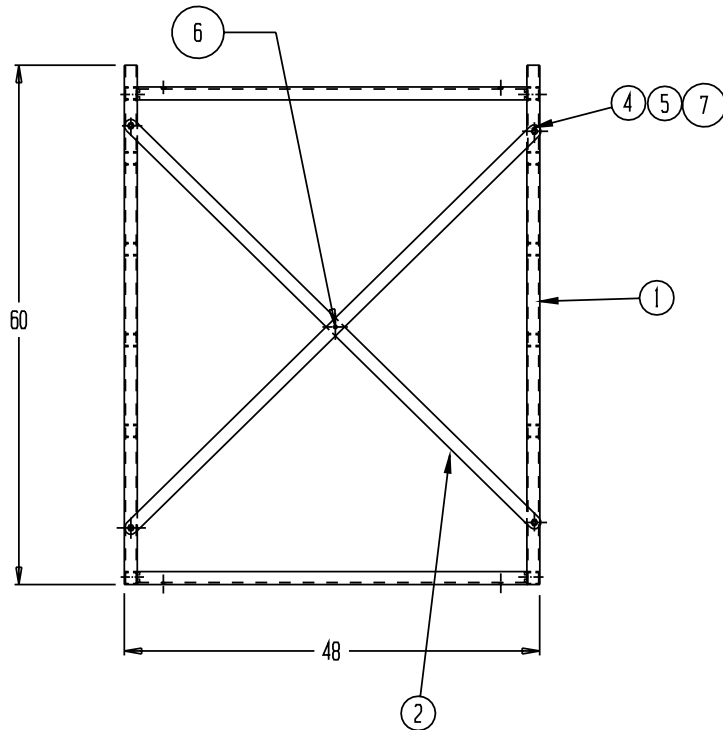
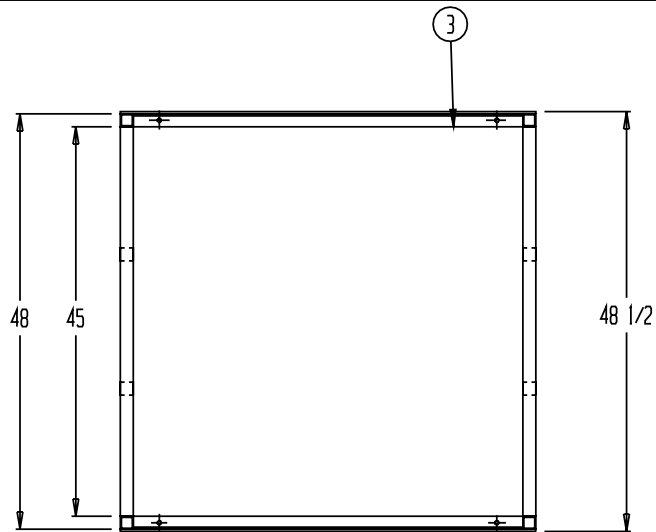
### **READ ALL INSTRUCTIONS BEFORE PROCEEDING!**

1. Bolt together one end of each angle weldment to one of the frames using the 3" long bolts, as shown below. The sides with the angle exposed should be pointed towards the center of the unit.
2. Bolt the other frame to the remaining ends of the angle weldments using the 3" long bolts.
3. Bolt the two side braces together through the center hole using the 1 ½" long bolts.
4. Bolt the side braces to the sides of the unit using the 3" long bolts. Repeat for the other side braces.

#### **Notes:**

- For each step, use one 3/8" flat washers and one 3/8" nylock nut.





REV.	QTY.	DATE	REVISIONS	INITIAL
B			31-001-014	
A		8/17/00	LONGER BOLTS ECR# 00-061	BB
B		9/13/07	ADDED FLAT WASHER INFO	PE

ITEM NO.	PART NO.	DESCRIPTION	QTY.
7	N/A	WASHER, FLAT, 3/8	18
6	N/A	BOLT, 3/8-16 UNC x 1 LG	2
5	N/A	NUT, NYLOCK, 3/8-16 UNC	18
4	N/A	BOLT, 3/8-16 UNC x 3 LG	16
3	31-514-015	FRAME, ANGLE WELDMENT LBPH-77	4
2	31-014-030	FRAME, SIDE BRACE, 1/4 x 1 1/2 x 66 7/8 LG	4
1	31-514-014	FRAME, SUB-ASSY. LONG BAR PIGEON HOLE RACK	2

*T & S EQUIPMENT COMPANY*

REMOVE ALL BURRS AND SHARP EDGES		
CONCENTRIC	.006 TIR	.060 TIR
ANGLES	1/4" 0" 30"	1/4" 1" 0"
DECIMALS	1/16" 1/32" 1/64"	1/8" 1/16" 1/32"
FRACTIONS	1/4" 1/32"	1/4" 1/16"
TOLERANCE	MACHINE	WELDMENT

SCALE: 1:16	APPROVED BY:	DRAWN BY: J GERHART
DATE: 9/18/97		SIZE: B
FINAL ASSY, W/O SHIPPING LBPH-77		
MATERIAL:	DRAWING NUMBER: 31-001-014	REV: B