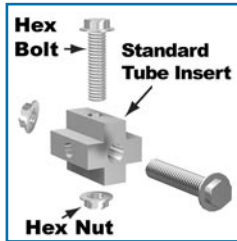


Standard Insert

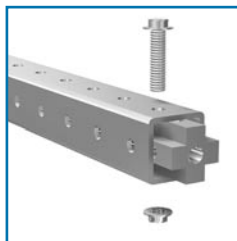
(Using the Hex Bolt Fastener Assembly)



Step #1

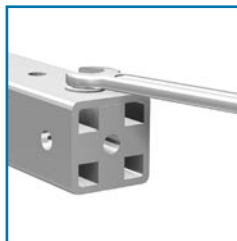
HT Series™ Standard Tube assemblies are composed of three elements.

The Standard Tube Insert, two hex bolts and hex nuts.



Step #2

Slide the Standard Tube Insert into the profile with the mounting hole in the proper orientation. Slip the hex bolt through the profile and insert.



Step #3

Tighten the hex bolt until the Standard Tube Insert is securely in place.



Step #4

Align the mating profile flush in front of the tube insert. Thread the second hex bolt through the mating profile and screw it into the end of the tube insert finger tight.

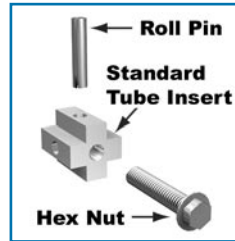


Step #5

Square and align the mating extrusion. Using a wrench tighten the hex bolt until the connection is secure.

Standard Insert

(Using the Roll Pin Fastener Assembly)



Step #1

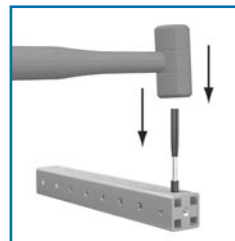
HT Series™ Standard Tube Insert assemblies are composed of three elements.

The Standard Tube Insert, one hex bolt, and one roll pin.



Step #2

Slide the Standard Tube Insert into the profile with the mounting hole in the proper orientation. Place the roll pin into the profile hole and Standard Insert hole.



Step #3

Using a Roll Pin Punch and Soft Face Mallet, hammer the roll pin into the tube insert until the roll pin is flush with the profile face.



Step #4

Align the mating profile flush in front of the tube insert. Thread the hex bolt through the mating profile and screw it into the end of the tube insert finger tight.

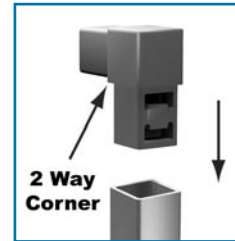


Step #5

Square and align the mating extrusion. Using a wrench tighten the hex bolt until the connection is secure.

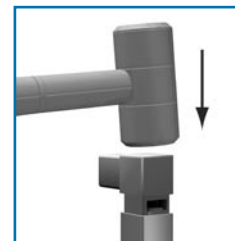
Quick Frame

(Quick Frame Standard Connector)



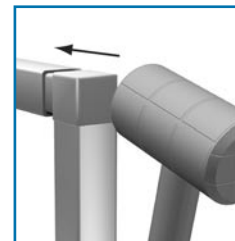
Step #1

Align the connector with the open face of the Quick Frame profile.



Step #2

Using a Soft Face Mallet begin to tap the connector completely into the Quick Frame profile. **Note:** The grooves inside the Quick Frame profile will hold the connector in place.



Step #3

Align the connector with the open face of the other Quick Frame profile. Using a Soft Face Mallet begin to tap the connector completely into the Quick Frame profile.

To view the 80/20 product assembly animations, visit the Training Center on our web site.

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The Industrial Erector Set®



Basic Assembly

80/20 Modular Framing Systems
Standard Fastening Methods

T-Slotted Assembly Methods

- Anchor Fasteners
- End Fasteners
- Joining Plates
- Corner Connectors

HT Series™ Assembly Methods

- HT Roll Pin Inserts
- HT Hex Bolt Inserts

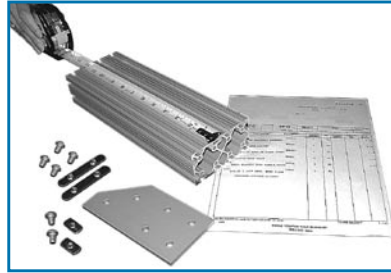
Quick Frame Assembly

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Before You Start!

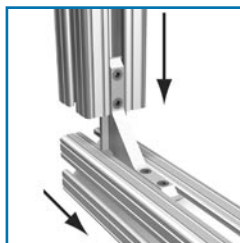
We have taken great strides to ensure that the products you order are the products you receive. Please follow these tips to help make your assembly go smooth.



- Check your order with your packing list.
- Measure profiles & confirm all accessories.
- Have assembly tools ready and at hand.
- Begin by pre-assembling all fasteners.

90° Inside Corner Connector

(NO Machining Required)



Step #1

Slide the connector into the T-slot of one profile. (Do **NOT** fully tighten)

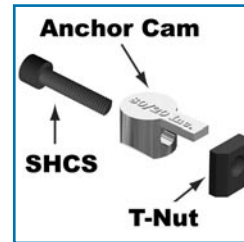


Step #2

Slide the mating T-slotted profile onto the connector, square and align both profiles. Using a T-handle Hex Wrench tighten all of the bolts until the connection is secure.

Anchor Fastener

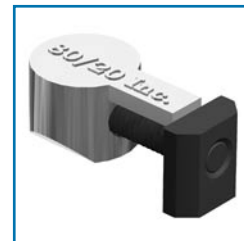
(Counterbore Machining Required)



Step #1

Anchor Fasteners are composed of three parts:

The Socket Head Cap Screw, the Anchor Cam, and the T-Nut.



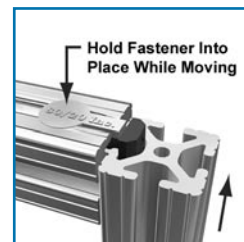
Step #2

Your Anchor Fasteners should ship pre-assembled. If assembly is needed refer to the photo on the left. (Note: offset tapped hole in T-Nut)



Step #3

Load the assembled Anchor Fastener into the counterbore hole. Be sure to position the T-Nut with the offset hole oriented toward the top of the fastener. (See Photo Step #2)



Step #4

While holding the Anchor Fastener into the counterbore hole, slide the mating extrusion into place.



Step #5

Square and align the mating profile. Using a T-handle Hex Wrench tighten the screw in a clockwise motion until the profiles are securely affixed.

End Fastener

(Access Hole & End Tap Required)



Step #1

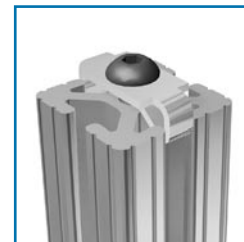
End Fasteners are composed of two parts:

The Button Head Socket Cap Screw (BHSCS) and a Wing Clip.



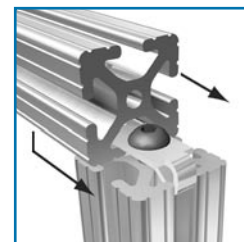
Step #2

Pre-assembly of End Fasteners is a quick process. Simply place the BHSCS through the hole in the Wing Clip as shown in the photo on the left.



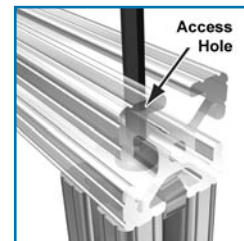
Step #3

Orient the Wing Clip in the direction of the mating profile's T-slot. Begin to screw the BHSCS into the tapped hole of the mounting profile. (Do **NOT** fully tighten)



Step #4

With the End Fastener slightly tightened slide the mating profile into place. When aligned, the access hole on the mating profile should align with the BHSCS.

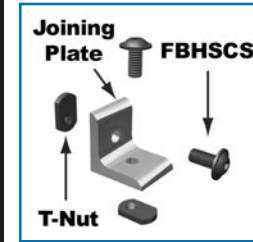


Step #5

To tighten the connection, place a T-handle Hex Wrench into the access hole until the wrench head inserts into the BHSCS. Tighten clockwise until secure.

Joining Plates

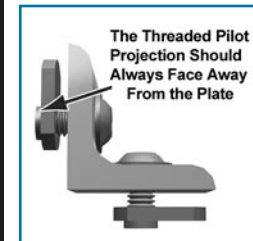
(NO Machining Required)



Step #1

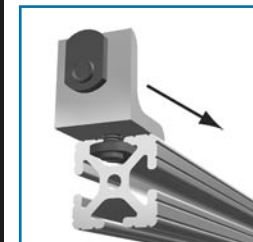
Joining plates require three main components:

The Joining Plate, Flanged Button Head Socket Cap Screws, as well as T-nuts.



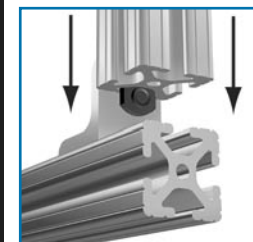
Step #2

Pre-assembly of Joining Plates will make the entire assembly process much easier. Simply place the screws through the plate holes and screw into the T-nuts.



Step #3

Slide the Joining Plate into the T-slots of one profile. (Do **NOT** fully tighten)



Step #4

Slide the mating profile onto the Joining Plate, square and align both profiles.



Step #5

Using a T-handle Hex Wrench tighten all screws until the connection is secure.