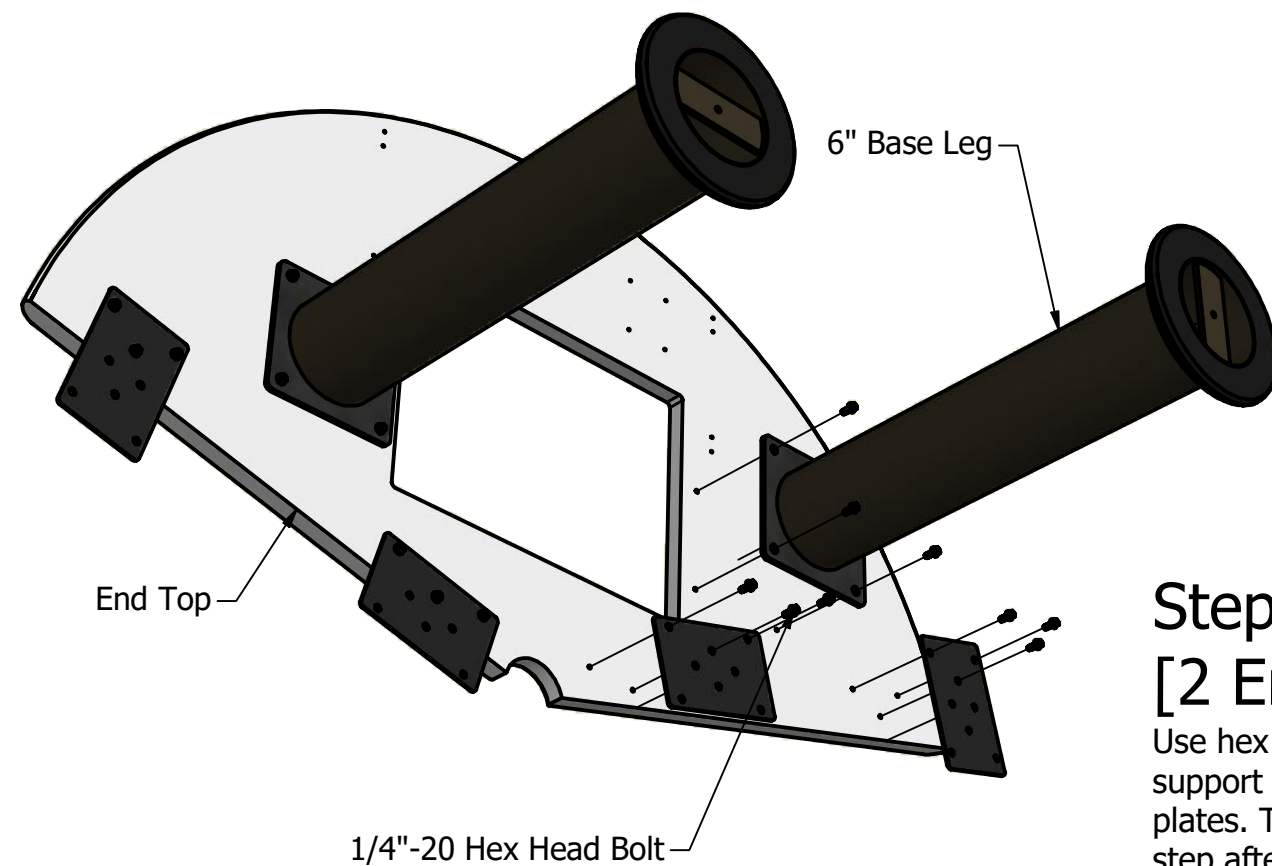


# Assembly Instructions

Refer to parts lists and Diagram of the assembled top to arrange the top sections in the place they will occupy when completed. Take care to pad the assembly area to protect the tops from damage. Keep hard metal objects away from this area. A stray screw, or a paper clip can ruin everything.

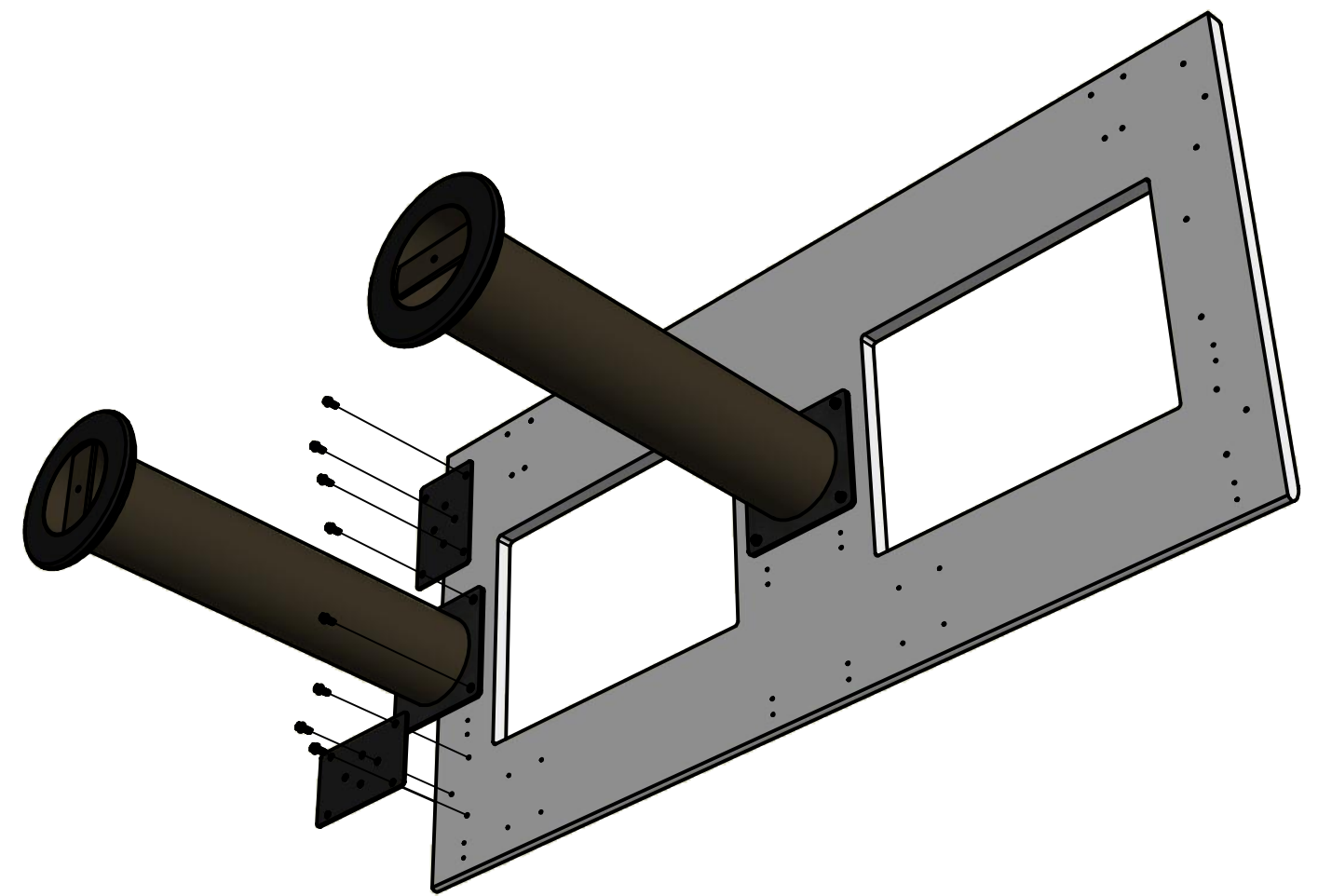
Make paper labels to indicate where the tops match up and where the bracket locations are.

Separate instructions are included for installing the flipIT units. These will be installed after the table is assembled.



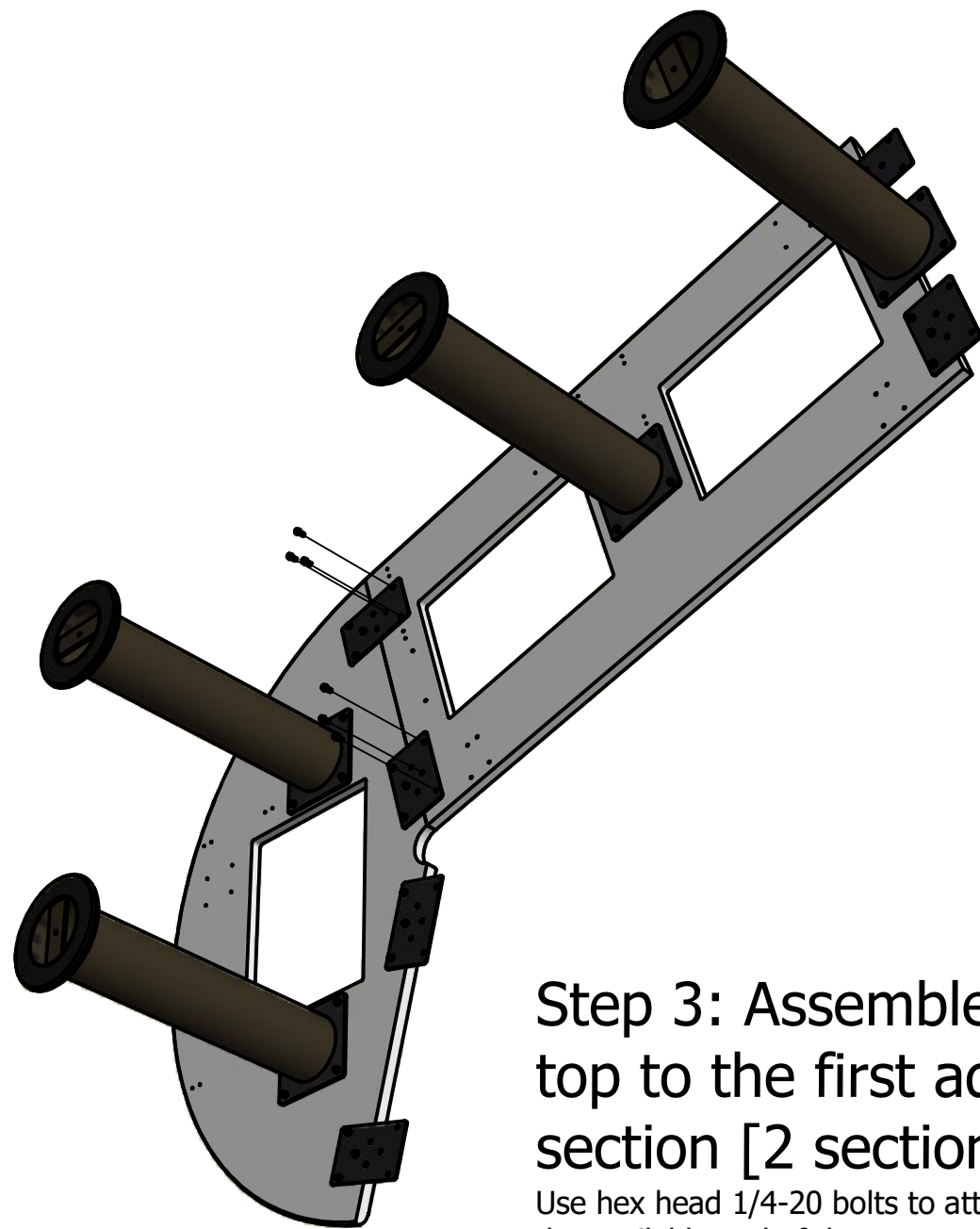
## Step 1: Assemble the end top [2 Ends].

Use hex head 1/4-20 bolts to install the two legs and four support plates as shown. Do not over-tighten these support plates. The support plates will be secured as at the final step after the tops are leveled in.



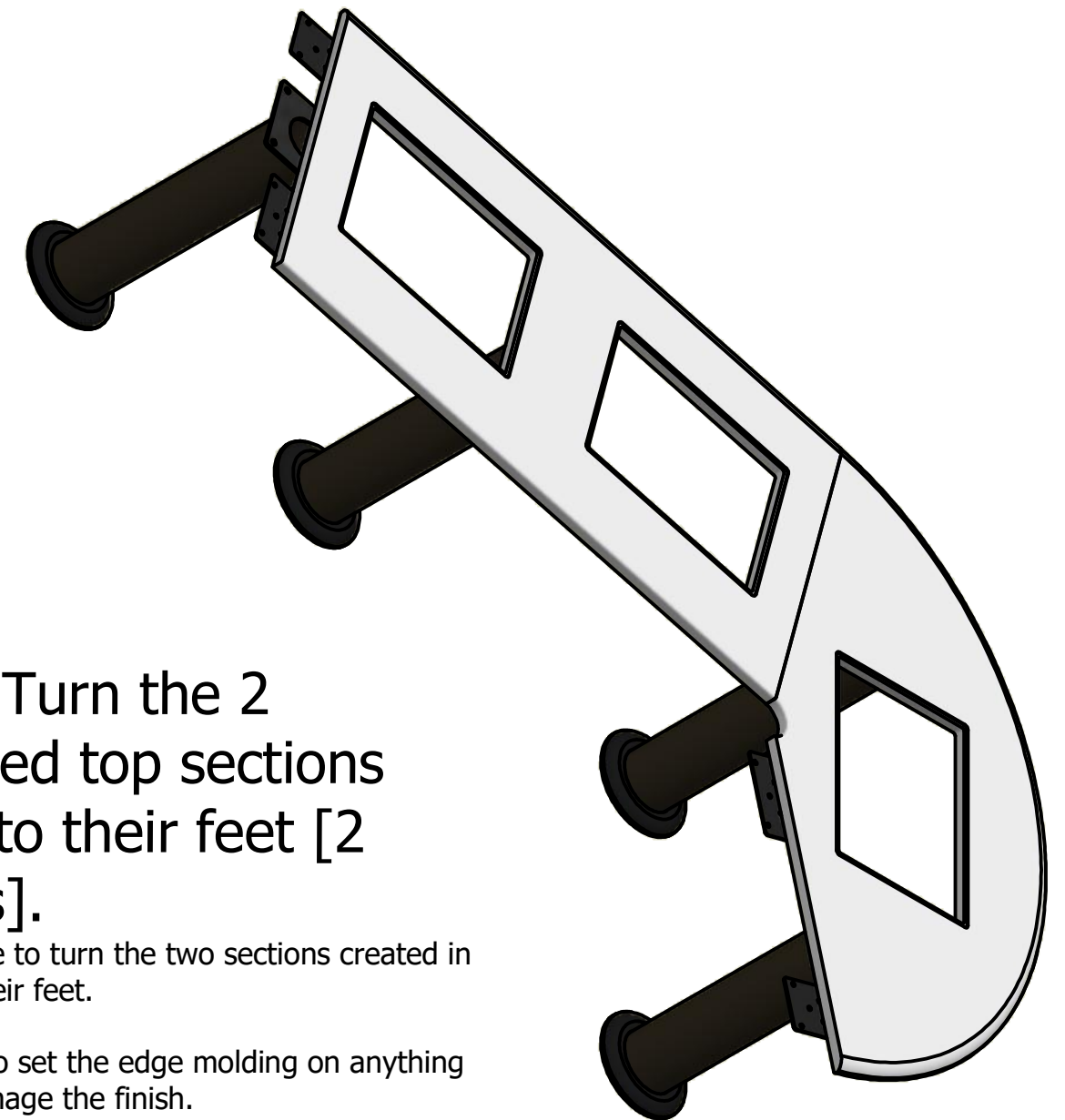
## Step 2: Subassemble the straight top [4 tops].

Use hex head 1/4-20 bolts to install the legs and two support plates on one end of the top. Two tops will be assembled on one end and two tops will be assembled on the opposite end.



### Step 3: Assemble the end top to the first adjoining top section [2 sections].

Use hex head 1/4-20 bolts to attach the end top to the available end of the top section from Step 2.



### Step 4: Turn the 2 connected top sections over onto their feet [2 sections].

Use two people to turn the two sections created in Step 3 onto their feet.

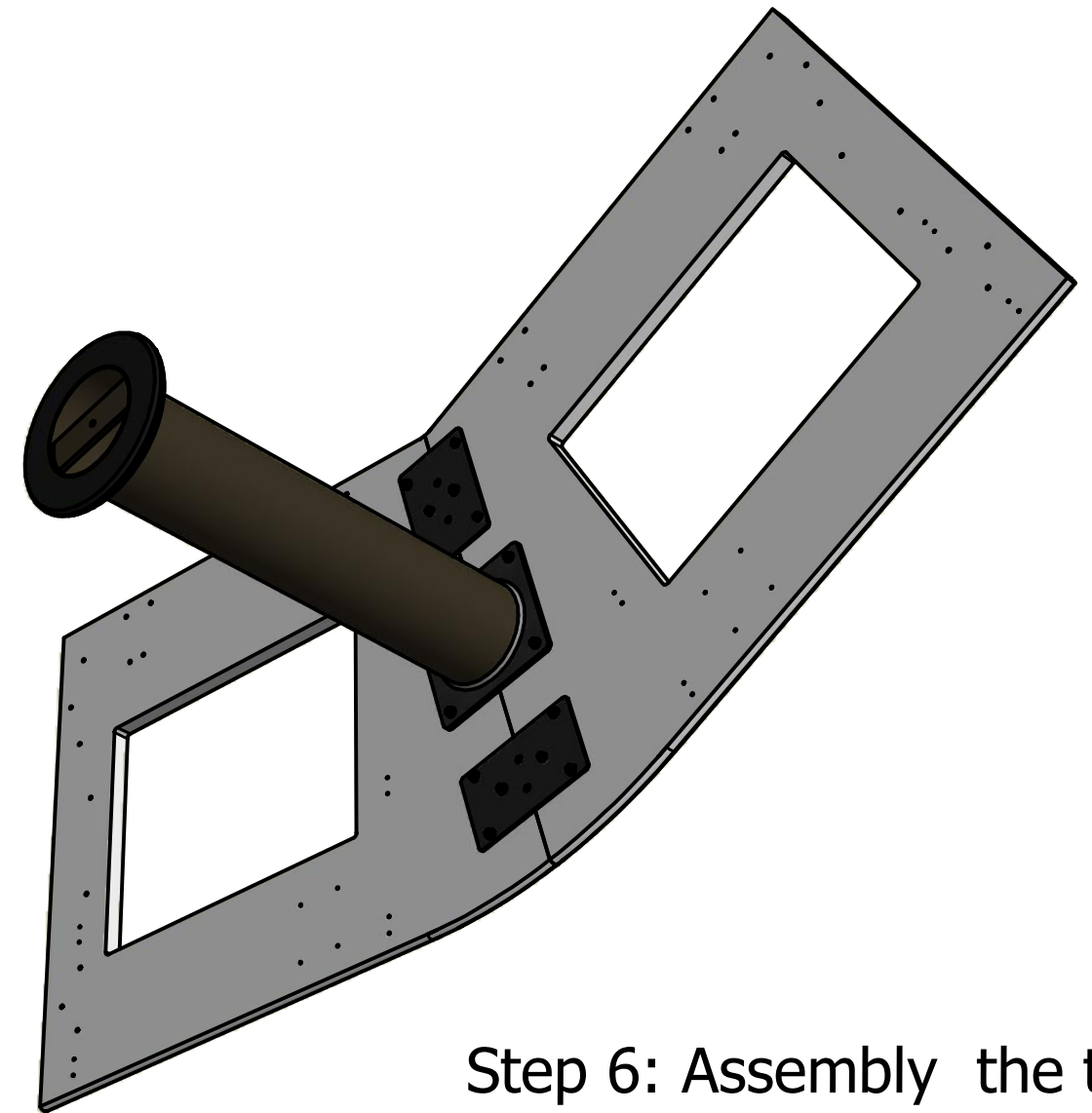
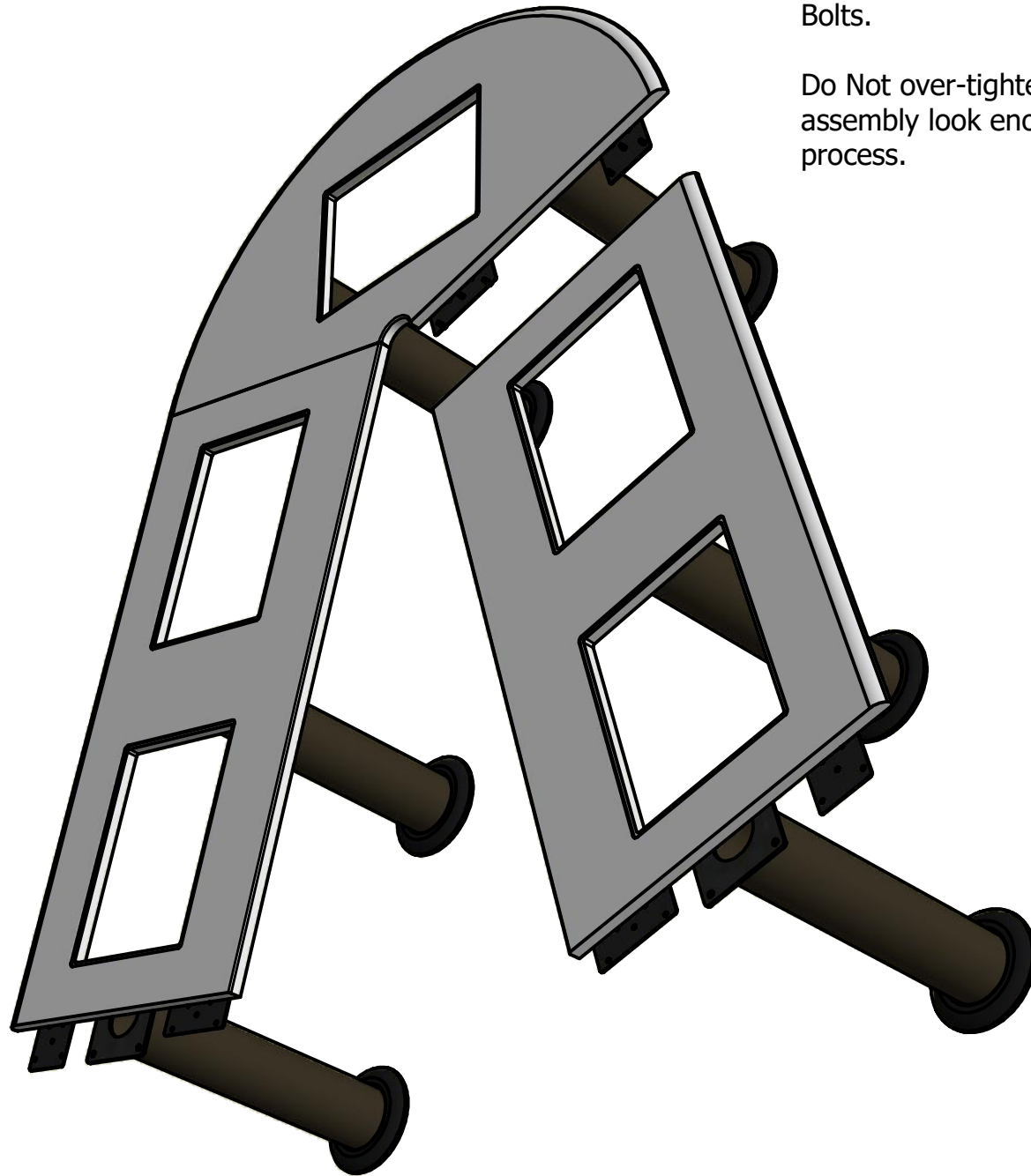
Take care not to set the edge molding on anything that might damage the finish.

The three legs should support the top so additional top sections can be added.

## Step 5: Install the next section of top[2 sections].

Slide the assembled top from Step 2 into position and attach the plates to the top using 1/4"-20 Hex Head Bolts.

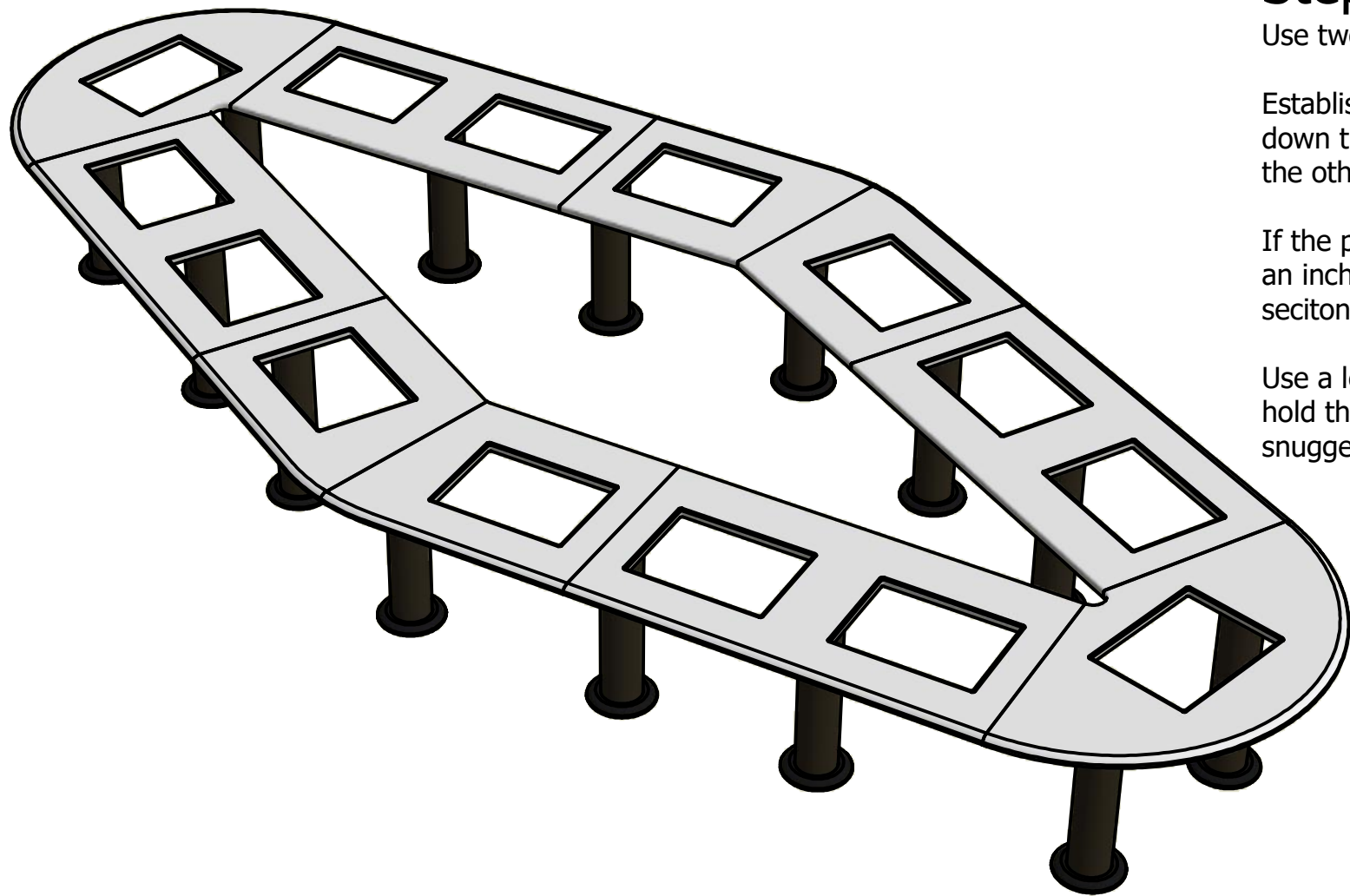
Do Not over-tighten the joinign plates. Keep the assembly look enough to adjust during the final leveling process.



## Step 6: Assembly the two corner tops[2 sections].

Assembly the two corner tops using 1/4"-20 Hex Head Bolts to install the two support plates and the leg base.

Do Not over-tighten the joinign plates. Keep the assembly look enough to adjust during the final leveling process.



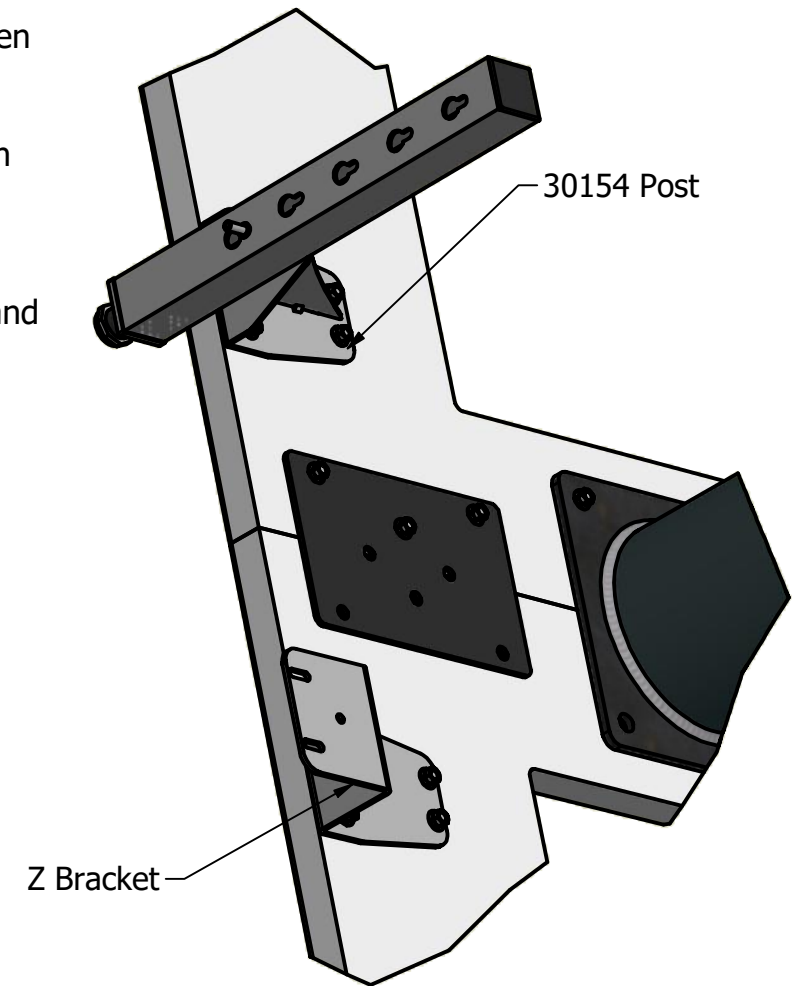
## Step 8: Level the table top.

Use two people to level the top.

Establish the end position first, and work your way down the line in mirror symmetry. First one side, then the other.

If the position of the table needs to move more than an inch, get more people to help support the other sections of the table.

Use a level on top, the leg levelers on the bottom, and hold the joints together as the joining plates are snugged in.



## Step 7: Assembly the table.

Assemble the two corner assemblies to the two end assemblies using the 1/4"-20 Hex Bolts to attach the support plates and leg bases to the adjacent top panel.

Do Not over-tighten the joinign plates. Keep the assembly look enough to adjust during the final leveling process.

## Step 9: Install the stansion brackets to support the lid and wire management pan.

Brackets 30154 have posts tops to support the lid in the closed position.

Brackets 30155 have hinged tops to be installed into the lid.

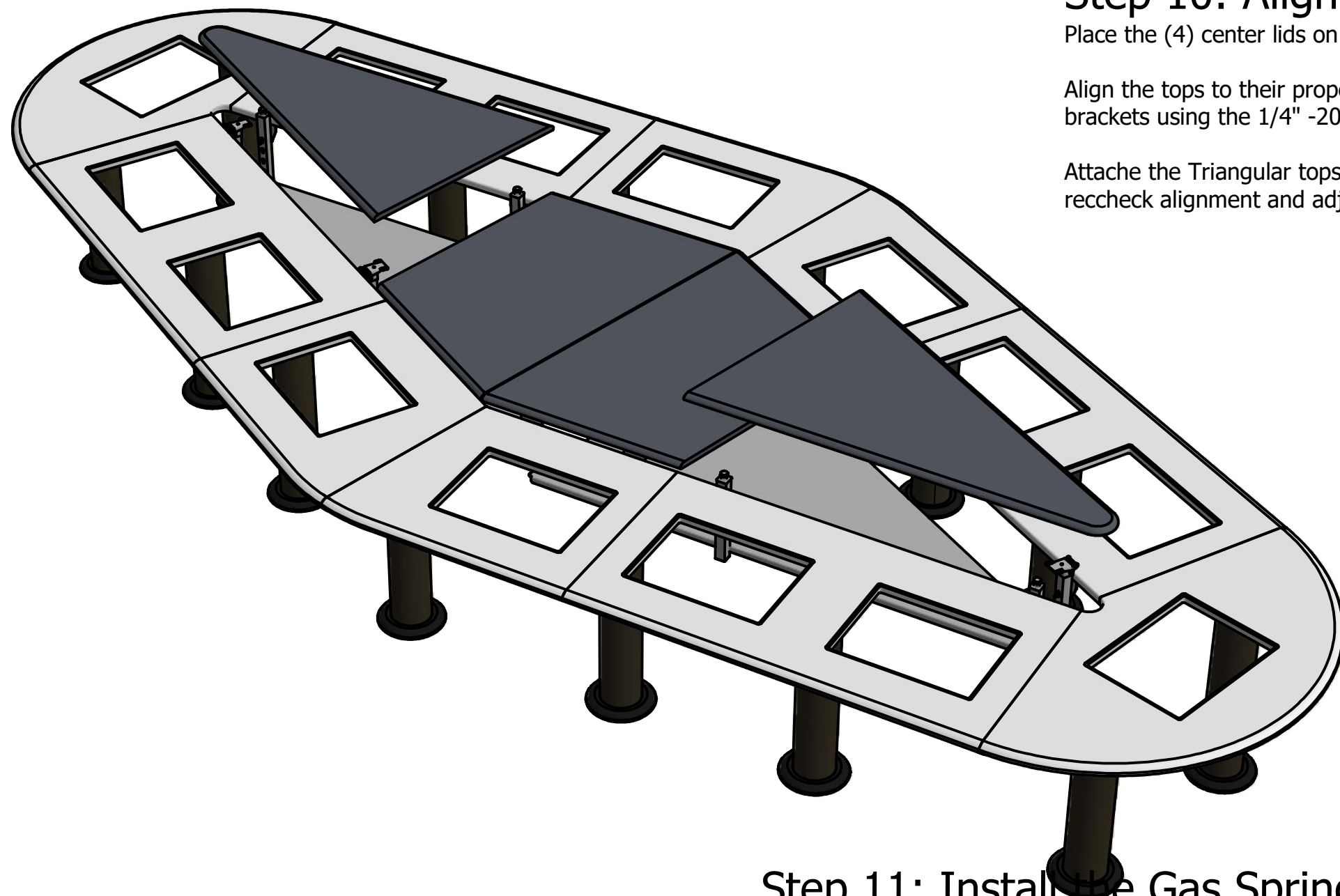
The corner tops will use Z Brackets to attach the center lid to the table.

To duoble check this, note the pilot hole drilling pattern in the lid that is ready to accept the hinges. That will be your guide in getting it right.

Install standion brackets with 1/4"-20 Hex Head Bolts.

Reference Assembly Drawing for correct locations, and install the triangluar center lids to the stansion bracket hinges and Z brackets.



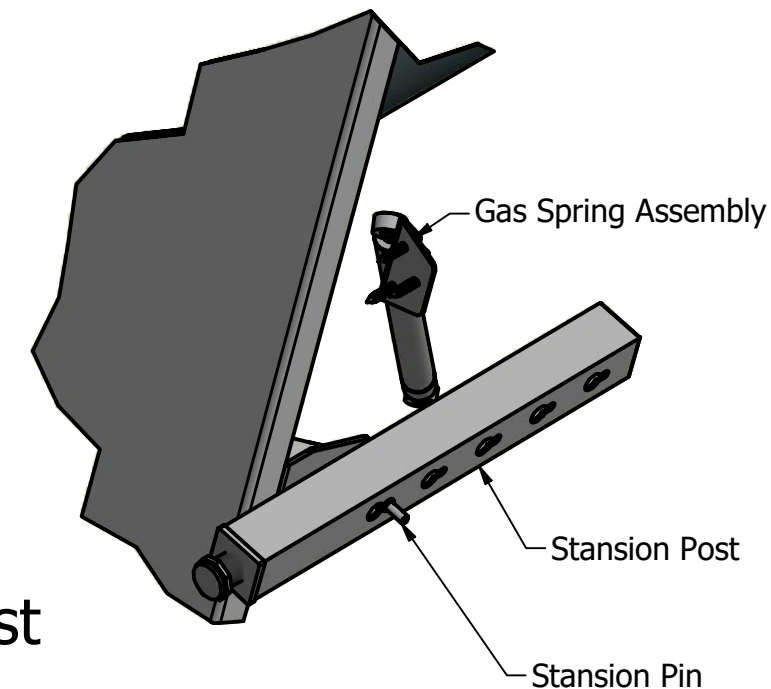


## Step 10: Align and install the center lids

Place the (4) center lids on top of the stansions and space the gaps at each top at 1/8".

Align the tops to their proper position and then screw down the two trapezoid tops to the z brackets using the 1/4" -20 Hex Head Bolts.

Attache the Triangular tops to the hinged stansions using 1/4"-20 Hex Head Bolts and reccheck alignment and adjust as needed.



## Step 11: Install the Gas Spring Strut and adjust stansion pins

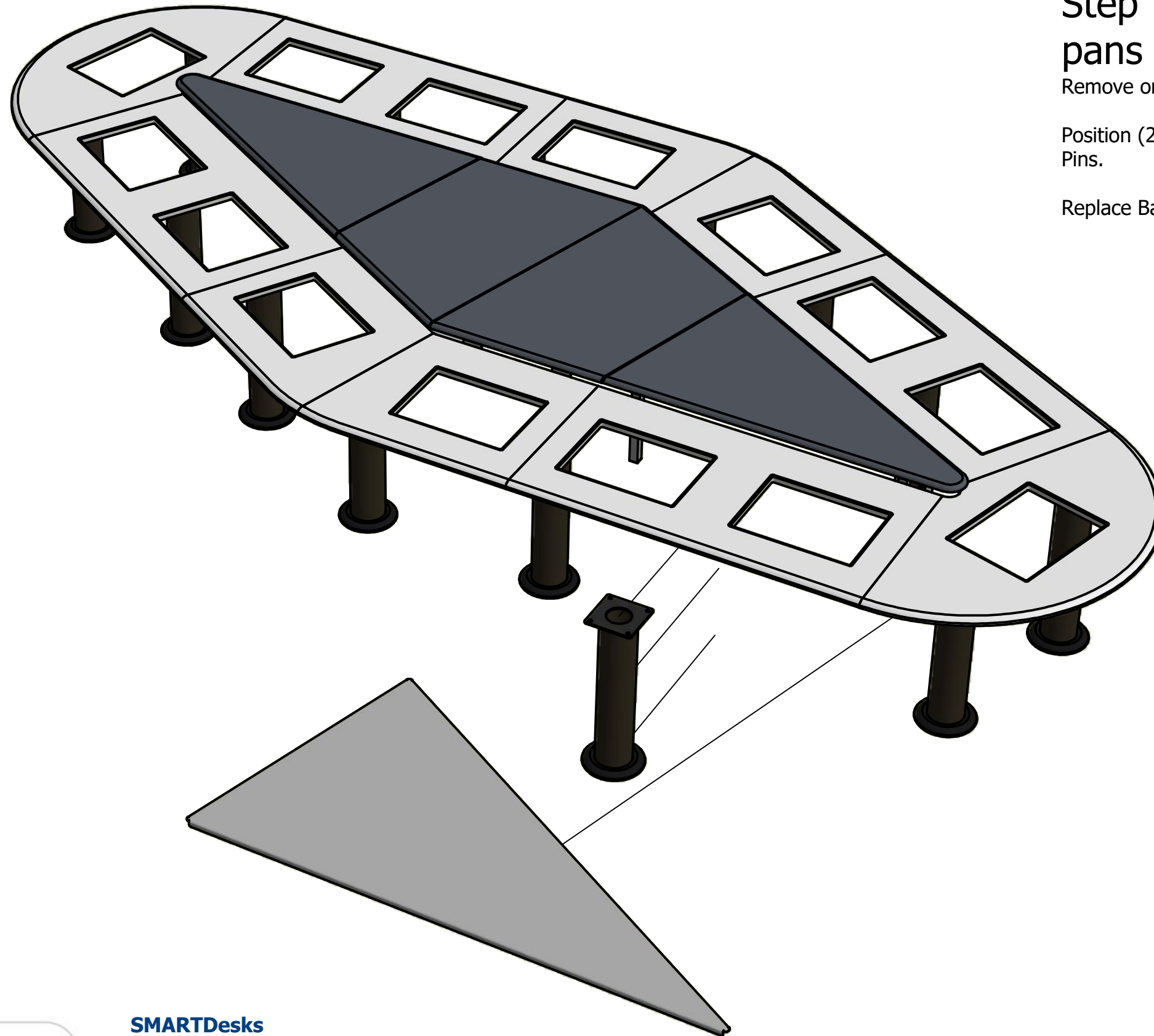
Press the silver shaft end of the gass spring strut onto the ball stud on the stansion.

Raise the lid and prop it open with a seat cushion or box so that the lid is raised about 18 inches (457mm). Position the ball stuf bracktt for making pilot holes.

Drill 1/8" pilot holes 1/2" deep into the bottom side of the lid and install the bracket with #12 pan head wood screws.

Press the gas strut onto the ball stud and test the operation.

Select the desired depth of the wire mmanagement pan. Insert the dual headed pegs provided with the stansions into the keyholes at the height desired on all stansions.



## Step 12: Install wire management pans

Remove one side base leg to allow access to inner storage area.

Position (2) wire management pans at either side of table on Stansion Pins.

Replace Base Leg and inspect table for necessary adjustments.