

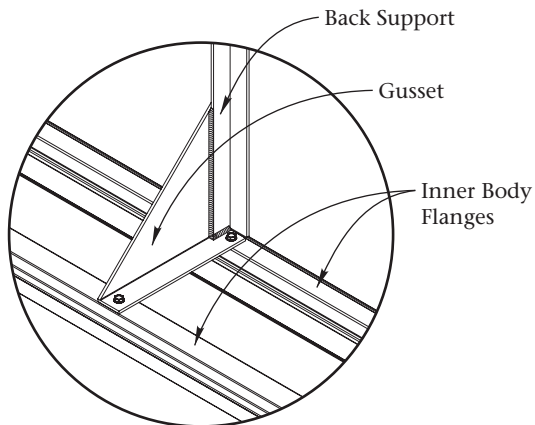


2Part Large Vandal System Assembly Instructions

3 Install Internal Support and Back

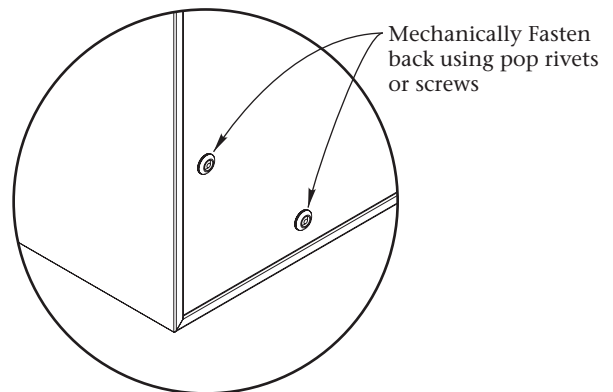
Install back support/s and gussets as necessary. Gussets can be mechanically fastened or welded to the Inner Body Flanges as shown in **Illus. 13**. Install back in recess. Back can be mechanically fastened using pop rivets or screws as shown in **Illus. 14**.

Note: Internal back supports, gussets, back and mounting hardware are not included with the kit.



Illus. 13

Back Support & Gusset Installation

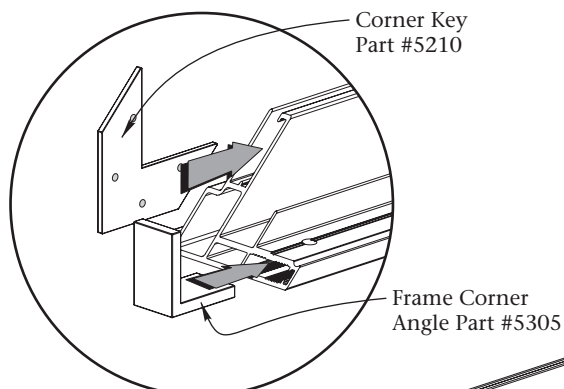


Illus. 14

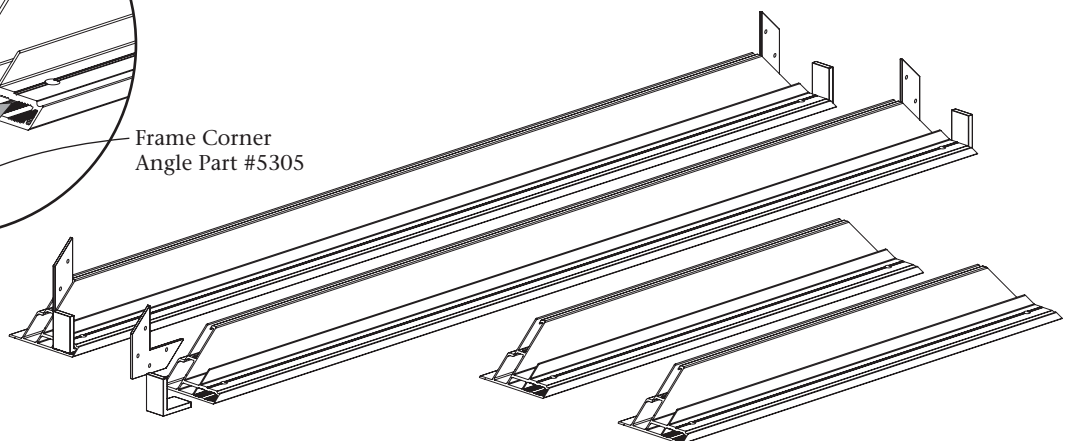
Back Installation

4 Inner Frame Assembly

Insert the Frame Corner Angles and Corner Keys into the Inner Frame in both the top and bottom sections. (**Illus. 15**)



Illus. 15



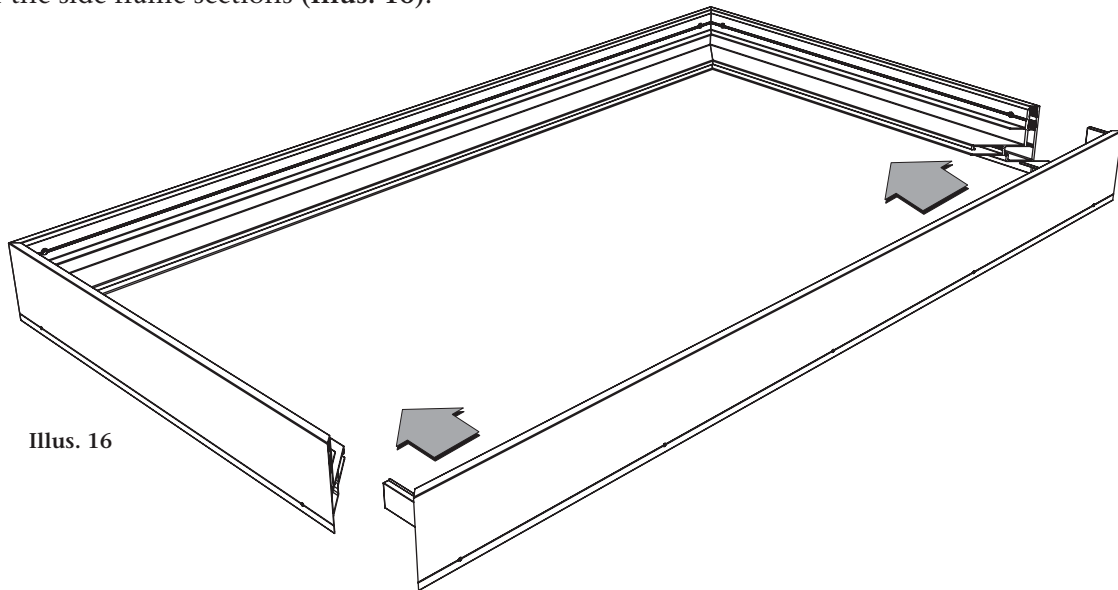
HINT: Clean the mitered edge of the body and frame with a file to remove any burrs prior to assembly.



2Part Large Vandal System Assembly Instructions

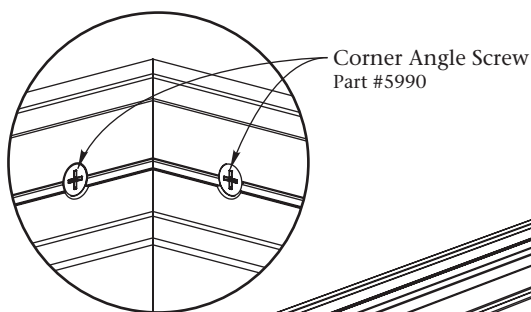
4 Inner Frame Assembly (Cont.)

Slide the frame sections with the inserted Corner Keys or Corner Angles into the slots located in the end of the side frame sections (Illus. 16).

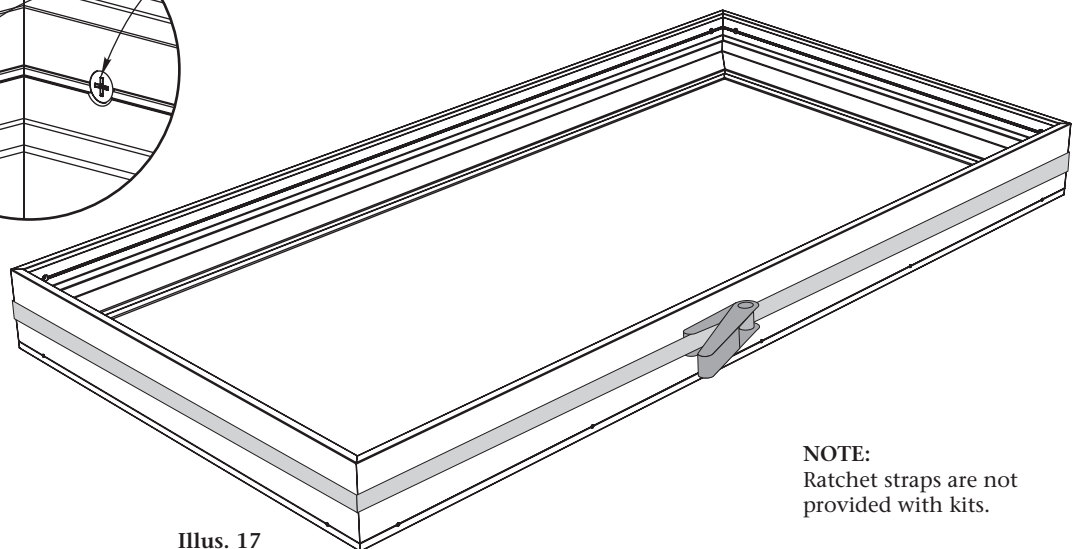


Illus. 16

It may be beneficial to run a ratchet strap around the Inner Frame to assist in squaring up the Inner Frame to ensure the corners are tight (Illus.17). Drill and counter sink pilot hole using 1/8" drill bit and counter sink bit. (*Note: Be sure not to drill through the outside of the Inner Frame.*) Fasten the corners together using the #8 x 3/8" counter sunk phillips head screws, two (2) per corner (Illus.18). *HINT: The use of bee's wax or similar lubricant will ease the insertion of the screws.*



Illus. 18



Illus. 17

NOTE:
Ratchet straps are not provided with kits.

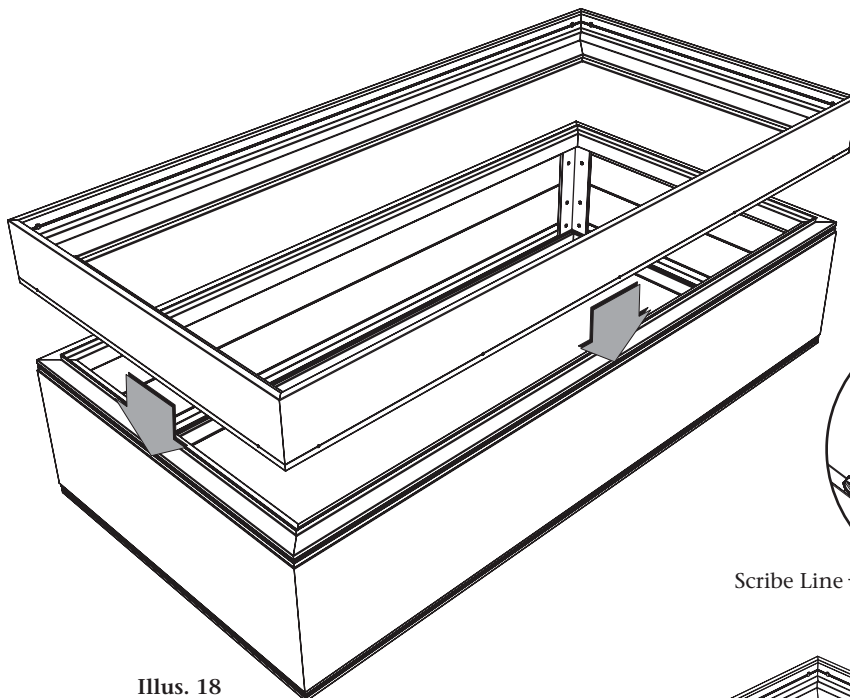
NOTE: Corner Angle Screws can be inserted on the outside corners.



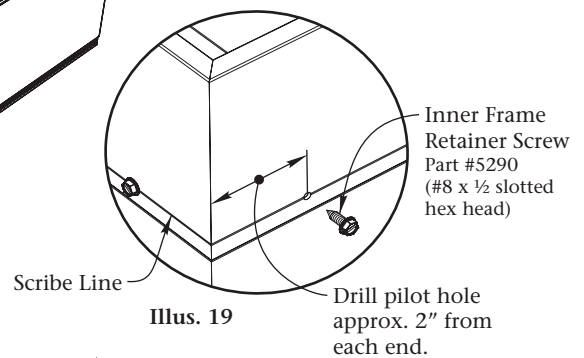
2Part Large Vandal System Assembly Instructions

5 Inner Frame to Body Assembly

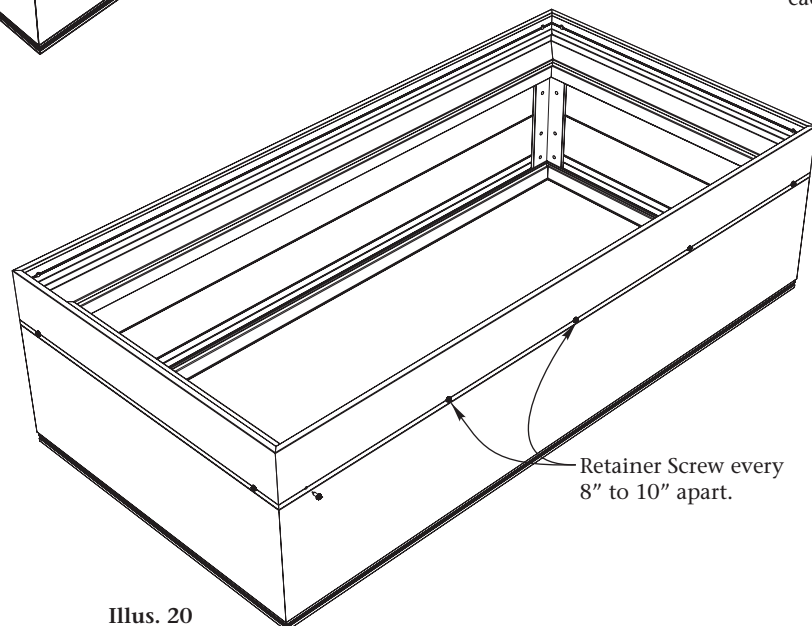
Place the Inner Frame over and down onto the body (Illus. 18). Using a 1/8" drill bit, pre-drill a pilot hole approximately 2" from each end on the scribe line of the Inner Frame (Illus 19). Along the remainder of the Inner Frame pre-drill pilot holes every 8" to 10" on center (Illus 20). Repeat the process on the three (3) remaining sides. Insert the #8 x 1/2" slotted hex head screws into the pre-drilled holes. (*Hint: The use of bee's wax or similar lubricant will ease the insertion of the screws.*)



Illus. 18



Illus. 19



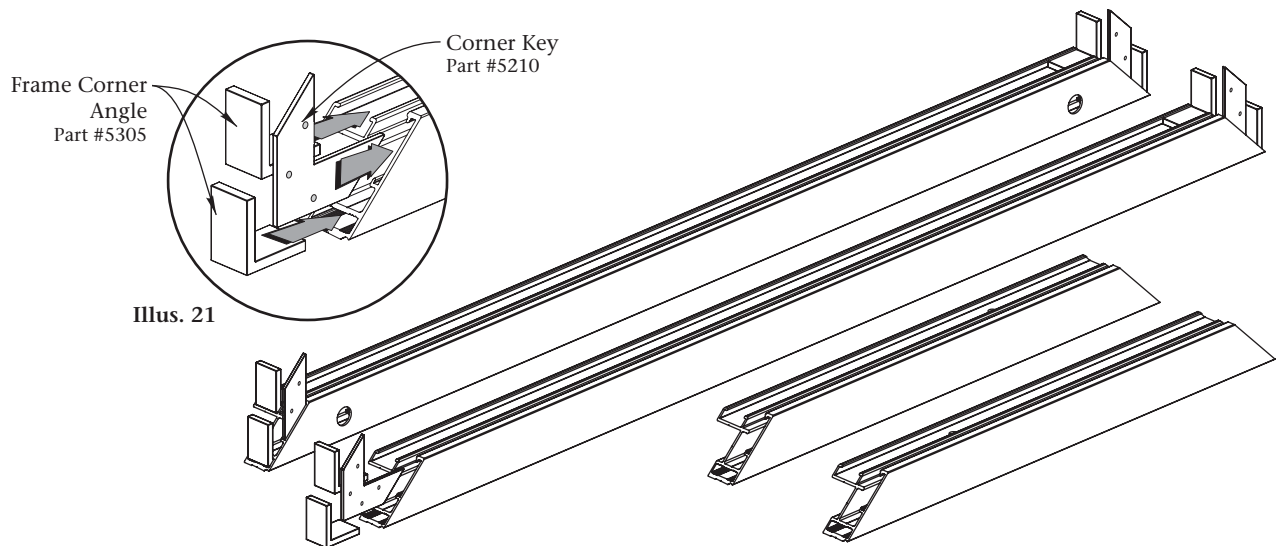
Illus. 20



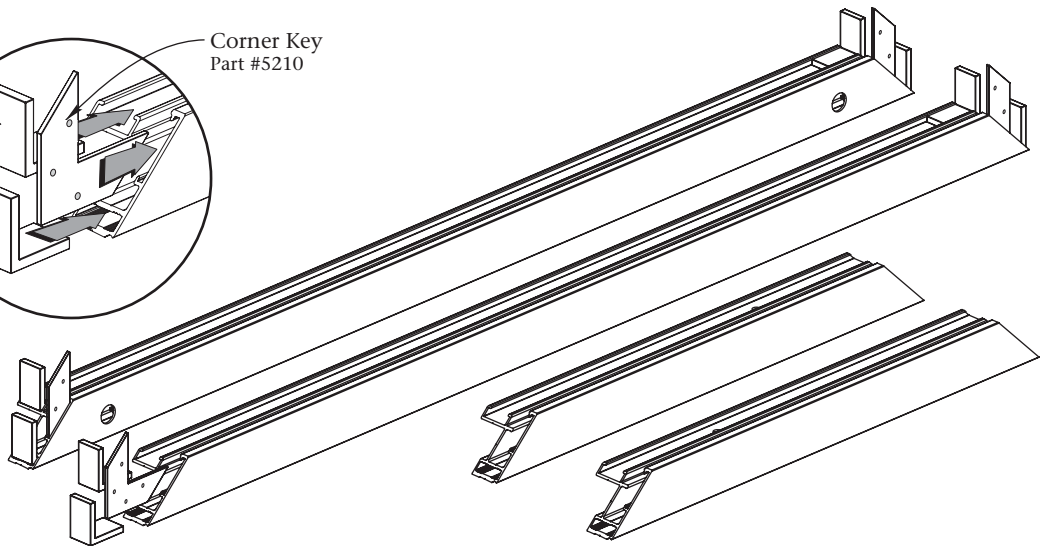
2Part Large Vandal System Assembly Instructions

6 Outer Frame Assembly

Insert the Frame Corner Angles and the Corner Keys into the Outer Frame. When inserting the Frame Corner Angles and the Corner Keys insert them in both top and bottom sections. (Illus. 21 & 22).



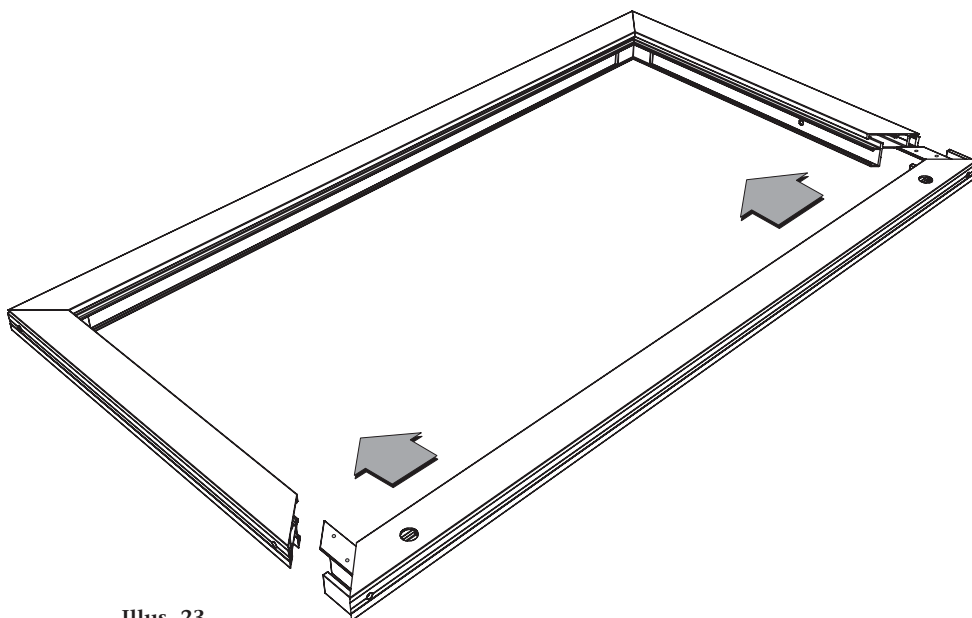
Illus. 21



Illus. 22

NOTE: Holes to accommodate the Locks and Gas Supports *do not* come pre-drilled. Drilling is required.

Slide the frame sections with the inserted Corner Keys and Corner Angles into the Corner Key and Corner Angle slots located in the end of the side frame sections (Illus. 23).



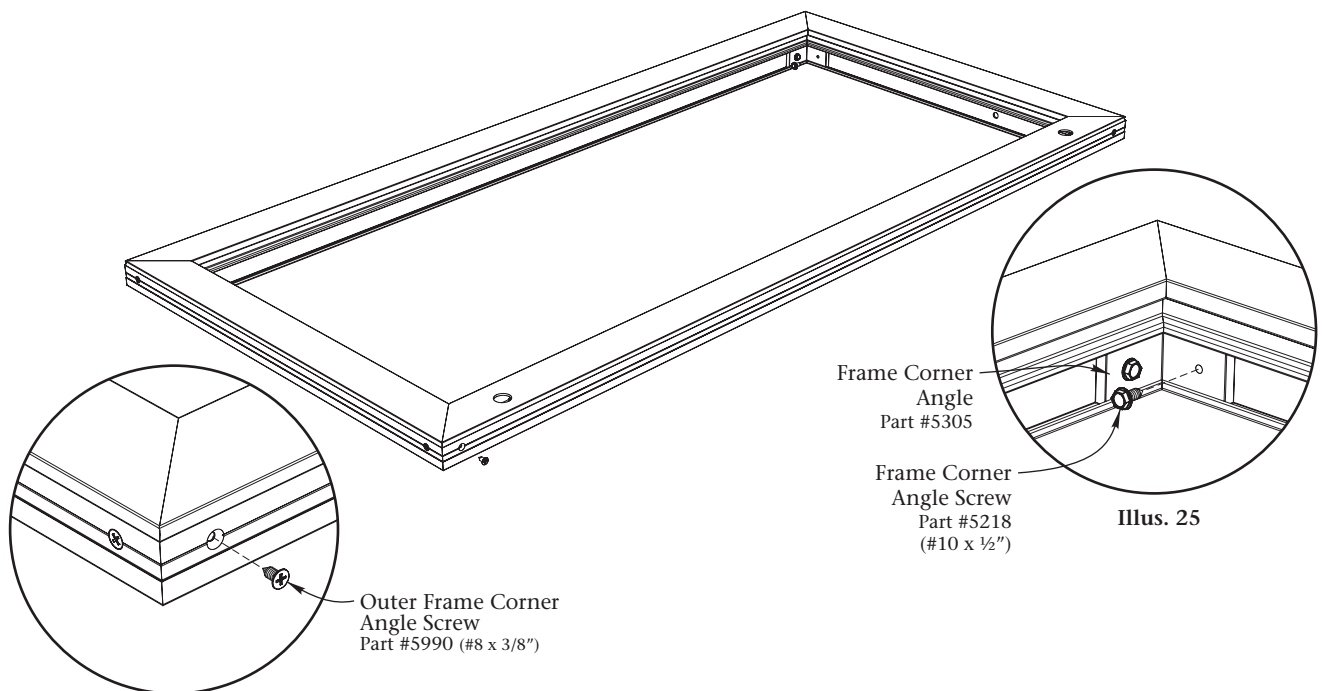
Illus. 23



2Part Large Vandal System Assembly Instructions

6 Outer Frame Assembly (Cont.)

It may be beneficial to run a ratchet strap around the Outer Frame to assist in squaring up the Outer Frame and to ensure the corners are tight (**Illus. 17**). Pre-drill and counter sink pilot holes in the outside corners using 1/8" drill bit and counter sink (**Illus. 24**). Fasten the outside corners together using the #8 x 3/8" counter sunk phillips head screws, two (2) per corner (**Illus. 24**). Pre-drill a pilot hole in the Frame Corner Angle using a 5/32" drill bit (**Illus. 25**). Fasten the inside corners together using the #10 x 1/2" hex head screws two (2) per corner (**Illus. 25**). *HINT: The use of bee's wax or similar lubricant will ease the insertion of the screws.*

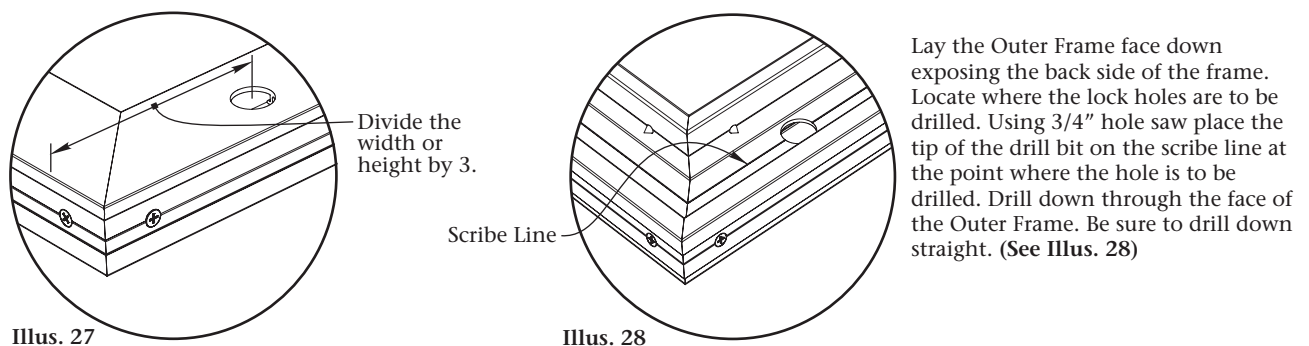


Illus. 24

Illus. 25

7 Lock Placement

The locks can be placed in the bottom section or side sections of the Outer Frame. The placement of the locks is recommended to be 1/3 of the over all width or height in from each side or up from the bottom (**Illus. 27**). (Example: If the cabinet is 96" in width, divide 96" by 3 which gives you a lock placement of 32" in from each end.)



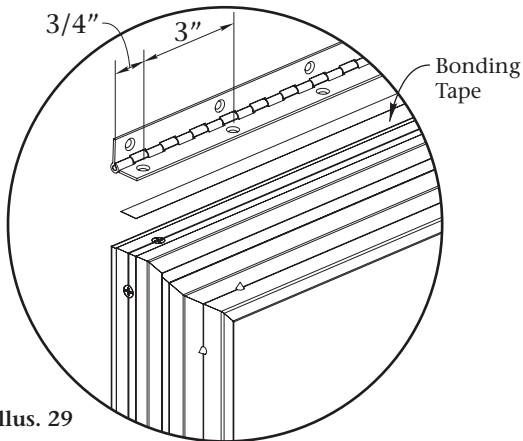
Illus. 27

Illus. 28



2Part Large Vandal System Assembly Instructions

8 Hinge Assembly

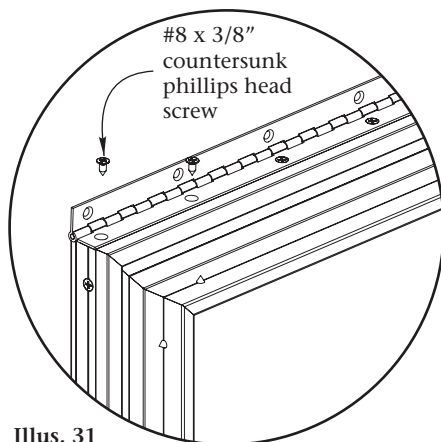


Illus. 29

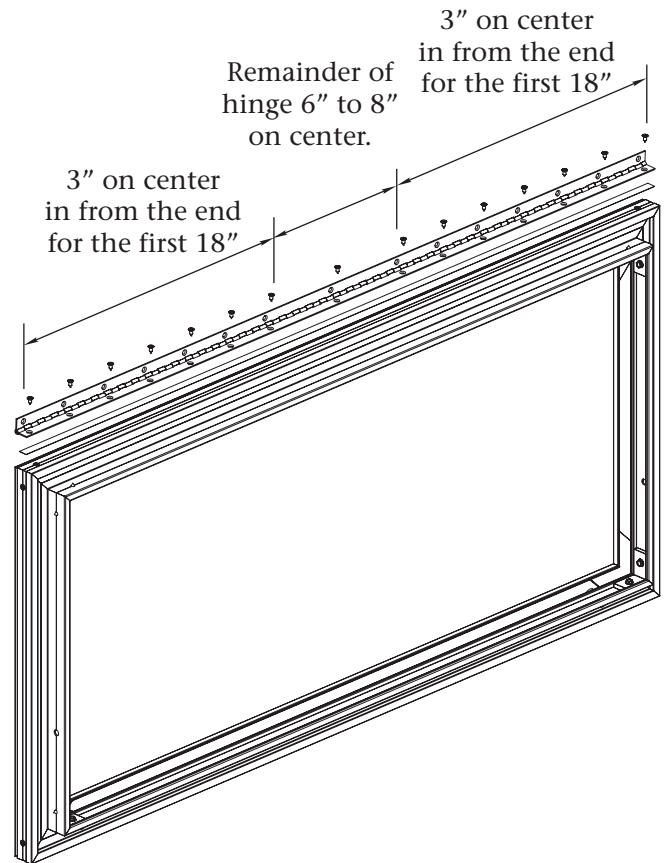
Align the hinge on the Outer Frame in the grooves provided for the correct placement of the hinge. Pre-drill approximately 3/4" in from each end, every 3" on center for the first 18" using a 1/8" drill bit. For the remainder of the hinge, pre-drill 6" to 8" on center. (Illus. 29 & 30) Using a counter sink bit, counter sink holes so that the head of the screw is flush with the hinge. Be careful not to counter sink the screw holes too deep. To do so may cause the hinge to fail.

Insert #8 x 3/8" screws to secure hinge into place. Be careful not to over tighten the screws. Just snug the screws tight. It is recommended to use bee's wax or similar lubricant to assist the insertion of the screws. (Illus. 31 & 32)

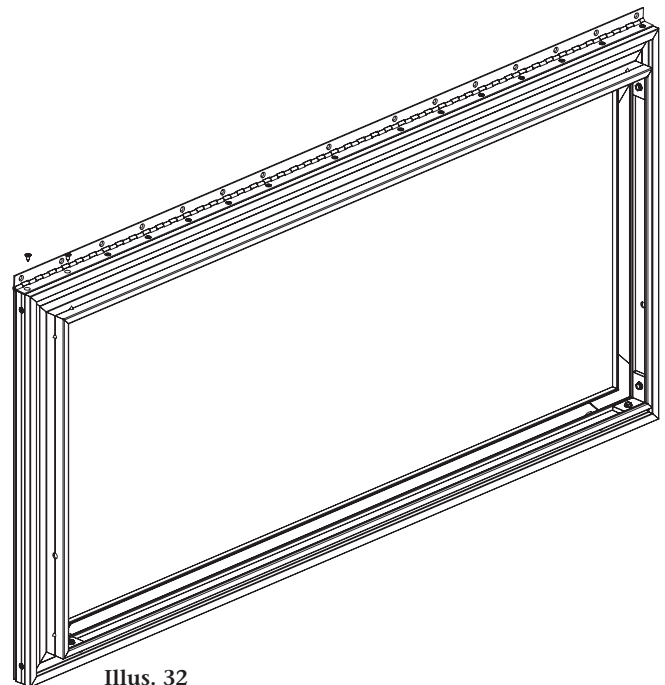
Tip: High bond tape or bonding agents can be used to help secure the hinge to the frame and assist in the installation of the hinge. Be careful not to get the tape on the barrel of the hinge. To do so may cause the hinge not to open properly.



Illus. 31



Illus. 30



Illus. 32

NOTE: Repeat steps 6, 7 and 8 for opposite side.



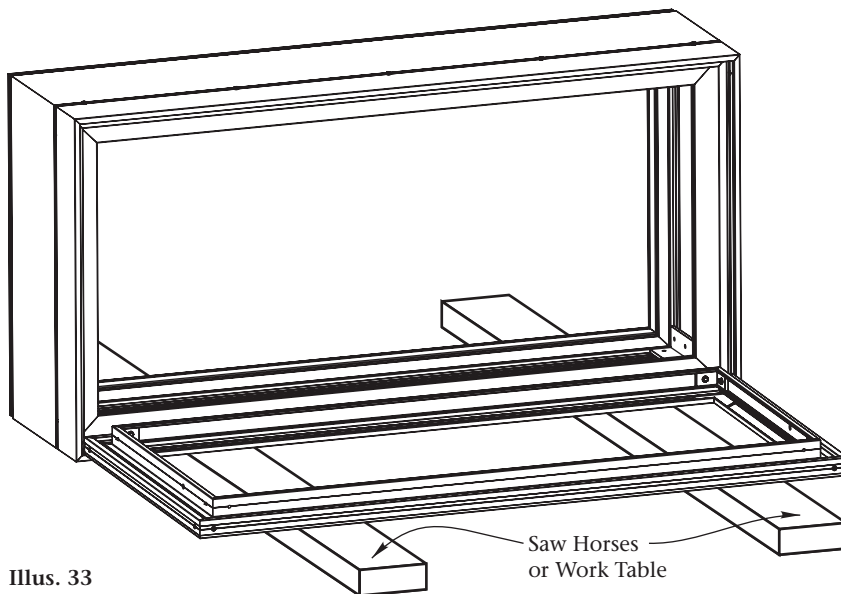
2Part Large Vandal System Assembly Instructions

8 Hinge Assembly (Cont.)

Place the cabinet on saw horses or a work table. (Note: If you use a work table place it close to the edge of the table). Place it on its top or side depending on where the hinge is to be attached. Lay the Outer Frame face down on the saw horses or work table. Place hinge on the Inner Frame in the groove provided (Illus. 33 & 34).

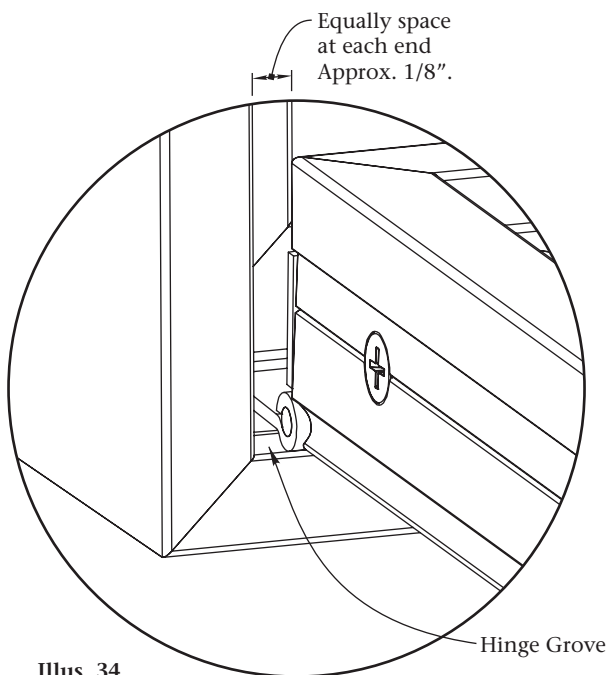
Repeat the process used to attach the hinge to the outer frame. (Illus. 29-32 & 35)

Tip: High bond tape or bonding agent can be used to help secure the hinge to the frame to assist in the installation of the hinge. Be careful not to get the tape on the barrel of the hinge. To do so may cause the hinge not to open properly.



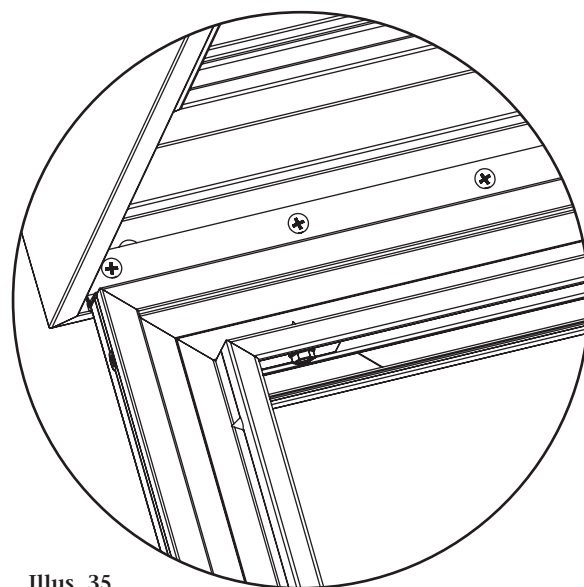
Illus. 33

Start in from each end approximately 3/4" and pre-drill using 1/8" drill bit. Drill every 3" on center for the first 18" in from each end. Drill the remainder of the hinge 6" to 8" on center.



Illus. 34

Equally space the Outer Frame within Inner Frame opening. (Approx. 1/8" at each end.)



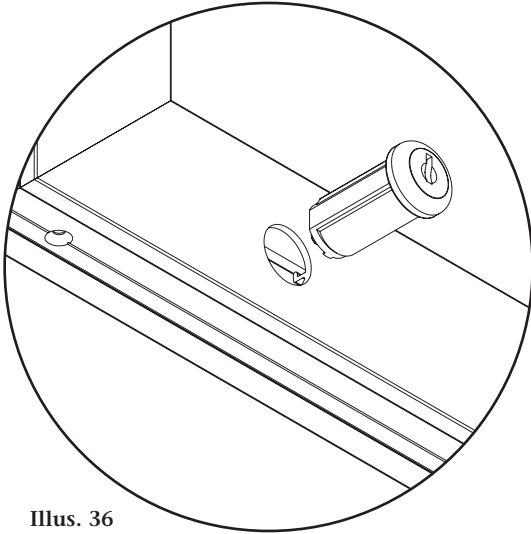
Illus. 35

Insert #8 x 3/8" screws to secure hinge into place. Be careful not to over tighten the screws. Just snug them tight. It is recommended to use bee's wax or similar lubricant to assist the insertion of the screws.



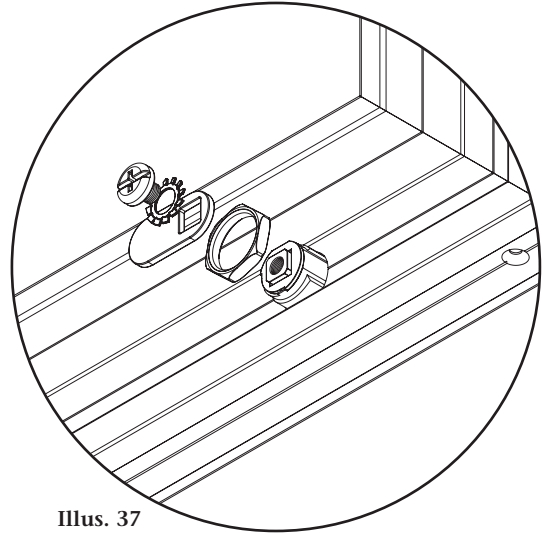
2Part Large Vandal System Assembly Instructions

9 Lock Installation



Illus. 36

Insert the lock into hole and rotate to the desired position.



Illus. 37

Place the nut onto the lock cylinder and tighten the nut down. **Hint:** Be sure not to over tighten the nut. Place the locking cam onto the lock. Insert the screw into the lock washer and screw down into the lock cylinder tightly. Make sure the locking cam is sitting down on the lock cylinder flush.

TIP: Installation of the lock can be accomplished after the cabinet is painted and faces are inserted.

10 Gas Support Selection

Poundage per Gas Support in lbs. (2 Gas Supports per door)

Height	Width									
	36	48	60	72	84	96	108	120	132	144
24	30	30	40	40	50	50	50	60	60	70
30	30	30	30	40	40	40	50	50	50	60
36	30	30	40	50	50	60	60	70	70	70
42	40	50	50	60	60	70	80	80	90	90
48	50	60	60	70	80	90	90	100	110	110
54	60	70	80	80	90	100	110	120	130	140
60	70	80	90	100	110	120	130	140	160	170
66	80	90	100	120	130	140	150	170	180	110
72	90	100	120	130	150	160	180	110	110	120
78	60	70	80	80	90	100	110	120	130	140
84	60	70	80	90	100	120	130	140	150	160

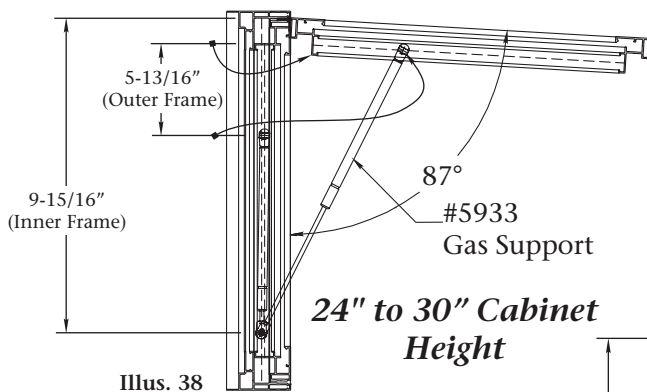
- Placement "A" #5900 Gas Support (Special Order Only) } Illus. 38
- Placement "B" #5934 Gas Support (Stock Item) }
- Placement "B" #5900 Gas Support (Special Order Only) } Illus. 39
- Placement "C" #5934 Gas Support (Stock Item) }
- Placement "C" #5900 Gas Support (Special Order Only) } Illus. 40

Locate the height and width of the vandal system. Follow height and width to where they intersect. This will give the poundage required for the vandal system. **Note:** the shade associated with the poundage refers to the shade chart for placement of the gas supports. (Example: A cabinet that is 48" x 96" requires two 90# gas supports at placement "B".) For placement dimensions and diagrams see Step 11 Gas Support Placement.



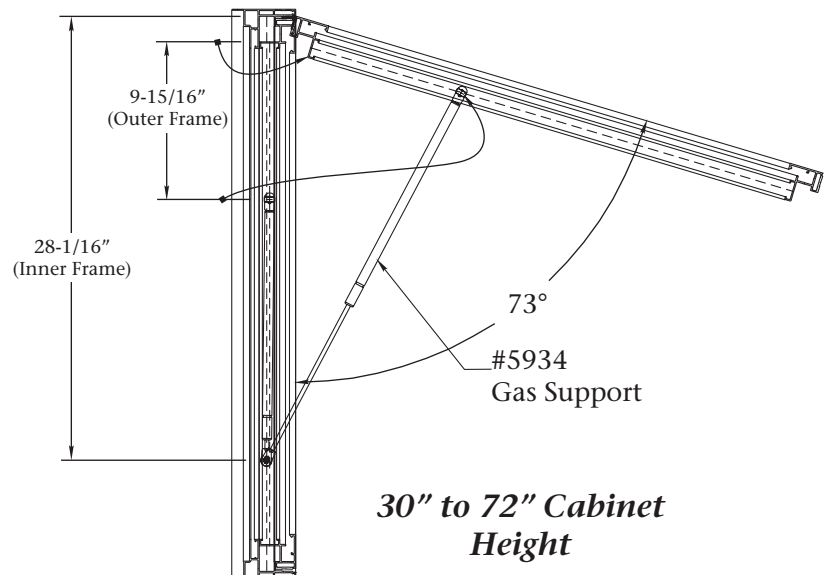
2Part Large Vandal System Assembly Instructions

11 Gas Support Placement



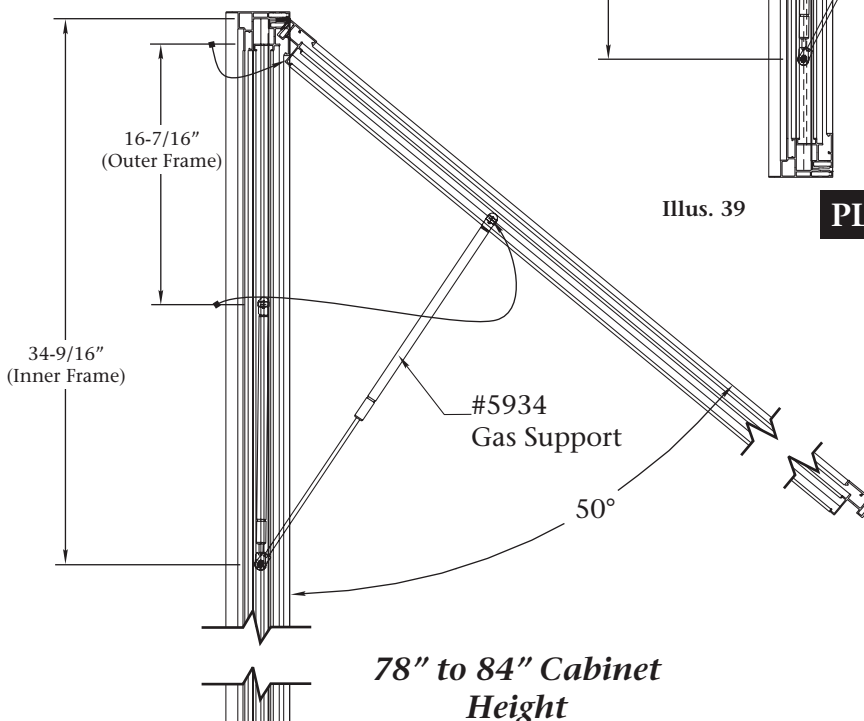
Illus. 38

PLACEMENT "A"



Illus. 39

PLACEMENT "B"



Illus. 40

PLACEMENT "C"

NOTE:

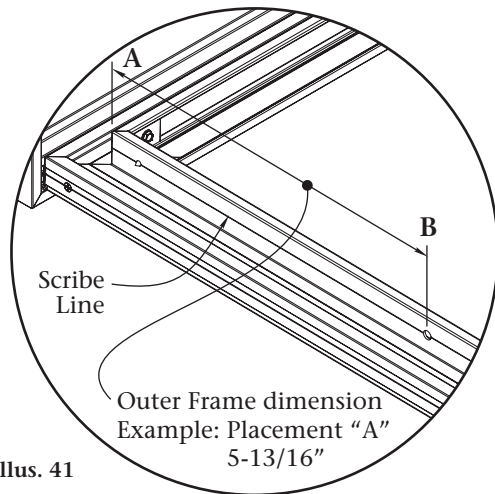
Correct placement of the gas support is essential to the operation and should not be varied. If the placement of the gas support is altered it may affect the operation of the gas support and may not work properly.

It is also important to install the hinge as outlined in **Step 8- Hinge Installation**. Failure to do so may result in damage to the hinge caused by the amount of pressure that is applied to the hinge from the gas support.



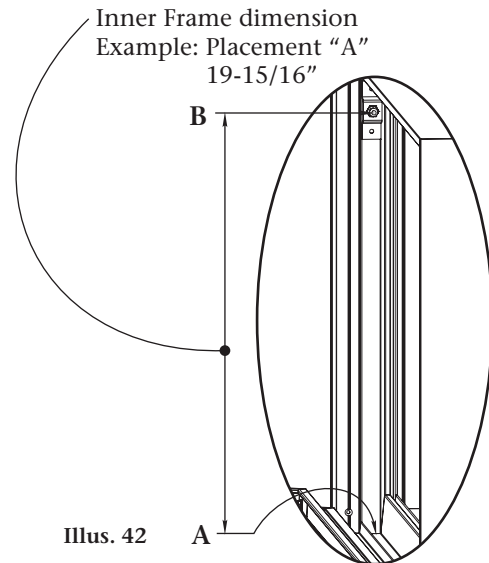
2Part Large Vandal System Assembly Instructions

12 Ball Stud Assembly



Illus. 41

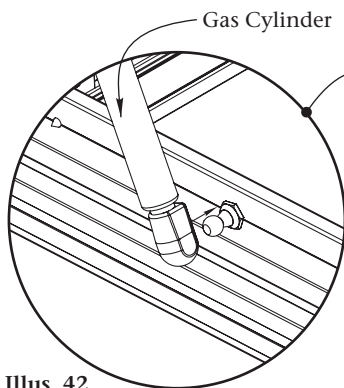
Place a measuring tape on inside corner of the Outer Frame "A". Measure along the side to determine location "B". (Example if you are using "Placement A" measure 5-13/16".) Using a 11/32" drill bit, drill a 5/16" hole for the ball stud placement. (Note: align the hole on scribe line.) Insert the ball stud in the hole, slide the lock washer onto the stud, thread the nut onto the stud and tighten down securely.



Illus. 42

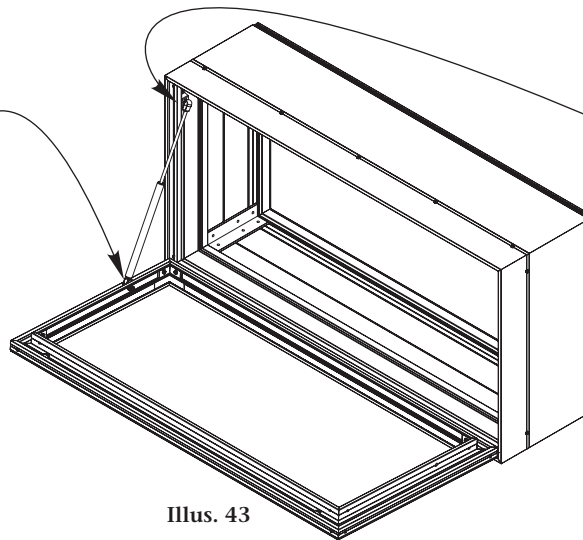
Place a measuring tape on the inside corner of the Inner Frame "A". Measure along the inside to determine location "B". (Example if you are using "Placement A" measure up 19-15/16".) Assemble and position the ball stud onto the mounting bracket. Insert the bracket with the ball stud into the Inner Frame so that the ball of the ball stud is centered on the mark. Mark the mounting holes and pre-drill the holes using a 1/8" drill bit. Place the bracket with the ball stud on the Inner Frame and secure the bracket with the ball stud using two (2) #8 x 1/2" hex head screws. Pre-drill pilot holes using 1/8" drill bit.

13 Gas Support Assembly

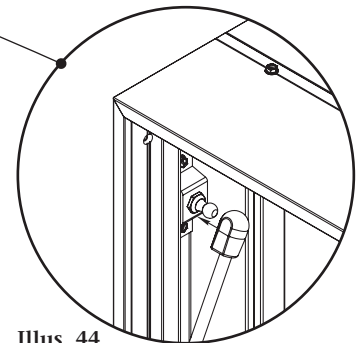


Illus. 42

Snap the large end of the gas cylinder onto the ball stud located on the outer frame



Illus. 43



Illus. 44

Snap the remaining end onto the ball stud located on the Inner Frame section.

14 Inner and Outer Frame Assembly (Opposite side)

Repeat Steps 4-13 for assembly of the remaining Inner and Outer Frame for opposite side.