

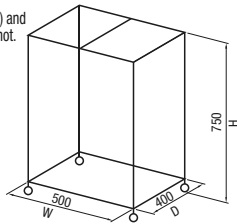
Selection Steps for Pipe Frame System

1. Selection Steps (Ex.) To assemble a "Cart" with plastic coated pipe frames and plastic joints (Excludes top plate)

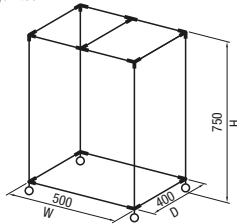
Procedure① Rough sketch of cart shape

- Determine the dimensions for width (W), depth (D) and height (H), and whether the casters are used or not.

EX. W500, D400,
H750, with 4 casters



Procedure② Mark positions for pipe frames to be joined.



Procedure③ Select joint parts.

Refer to "Selection of Plastic Joints" on P895

PJ001(P896)



PJ201C(P896)

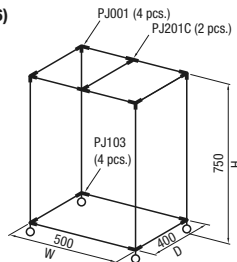


1 Direction Through

PJ103(P896)



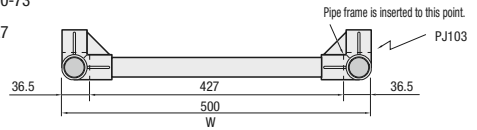
1 Direction Through



Procedure④ Calculate pipe frame length. (P912)

- Pipe Frame Length in W Direction (Pipe Frame Length between Two PJ001s and PJ103s)

$$\begin{aligned} &= W - 36.5 \times 2 \\ &= 500 - 73 \\ &= 427 \end{aligned}$$



- Pipe Frame Length in D Direction

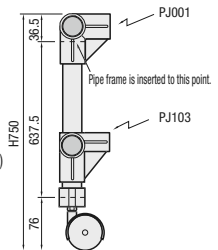
(Pipe Length between PJ001s and PJ103s or PJ201Cs.)

$$\begin{aligned} &= D - 36.5 \times 2 \\ &= 400 - 73 \\ &= 327 \end{aligned}$$

- Pipe Frame Length in H Direction

(Length between PJ001 and PJ103 minus Caster Height)

$$\begin{aligned} &= H - 76 - 36.5 \\ &= 750 - 112.5 = 637.5 = 637 \end{aligned}$$



Procedure⑤ Select color.

Select color for pipe frames and plastic joints. (Ex.) S (Dark Gray)

2. Make a list with the selected parts.

The above pipe frame cart is assembled with the following parts. Please place an order with the Part Numbers below.

Part Number	Qty.	Part Number	Qty.
PFS28-S-427	4	PJ201C-S	2
PFS28-S-327	5	PJ103-S	4
PFS28-S-637	4	(PFBONDN1000	1) If no adhesive is available at hand(P895)
PJ001-S	4		

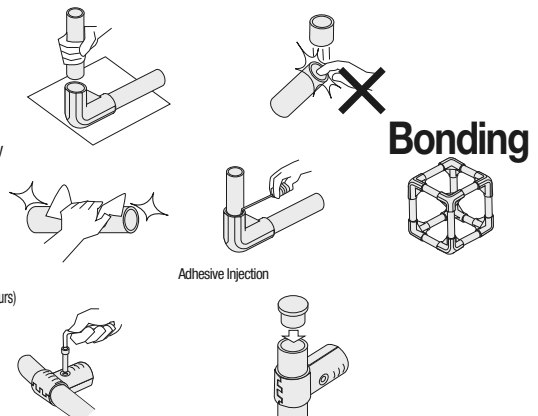
3. Notes for Assembly

(1) Temporary Assembly

- During the temporary assembly, fully insert the pipes.
- Be careful of cutting your hands on sharp ends of the cut frames.

(2) Plastic Joint

- Adhesive should be applied on Joints and Pipes after the temporary assembly, since they can't be separated once bonded.
- Clean the bonding surfaces before applying adhesive.
- Apply adhesive on a flat table.
- Apply adhesive twice to prevent application misses.
- Liquid adhesive should be injected evenly not to spill over.
- Do not move the joints and pipe frames shortly after the adhesive application. (Should remain stationary for 24 hours)



(3) Metal Joints

- Metal joints may be damaged if not clamped sufficiently.
- Tighten the screws with a hex wrench to fasten.
- Attach PJ503 (inner cap) on the frame ends with adhesive.