



PowerCart 330



APPLICATION: Welder Cart
PURCHASE DATE:
ACCESSORY SERIAL NUMBER:

Assembly and Use Information



Welders, Plasma Cutters, Multi-Process

www.everlastwelders.com
Need Parts? Need Technical Help? Call: 1-877-755-9353

380 Swift Ave. Unit 12 South San Francisco, CA 94080, USA

TABLE OF CONTENTS

SPECIAL NOTICE AND CALIFORNIA PROPOSITION 65 WARNING	3
CUSTOMER GREETING AND EXPLANATION OF PROCEDURES	4
WARRANTY AND CONTACT INFORMATION	5
SAFETY WARNINGS, DANGERS, CAUTIONS CONCERNING GENERAL WELDING	6
GETTING STARTED, UNPACKING CART FOR INSPECTION, ITEMS REQUIRED FOR ASSEMBLY	10
GENERAL CART SPECIFICATIONS	11
COMPONENT IDENTIFICATION AND BREAKDOWN	12
FASTENER KIT CONTENTS	13
UNDERCARRIAGE AND TRUCK ASSEMBLY	14
STANCHION (HANDLE) AND ACCESSORY FINAL ACCESSORY ASSEMBLY	17

NOTICE:

Product Specifications and features are subject to change without notice. While every attempt has been made to provide the most accurate and current information possible at the time of publication, this manual is intended to be a general guide and not intended to be exhaustive in its content regarding safety, welding, or the operation/maintenance of this unit. Due to multiple variables that exist in the welding field and the changing nature of it and of the Everlast product line, Everlast Power Equipment INC. does not guarantee the accuracy, completeness, authority or authenticity of the information contained within this manual or of any information offered during the course of conversation or business by any Everlast employee or subsidiary. The owner of this product assumes all liability for its use and maintenance. Everlast Power Equipment INC. does not warrant this product or this document for fitness for any particular purpose, for performance/accuracy or for suitability of application. Furthermore, Everlast Power Equipment INC. does not accept liability for injury or damages, consequential or incidental, resulting from the use of this product or resulting from the content found in this document or accept claims by a third party of such liability.

WARNING!

California Proposition 65 Warning:

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 et seq.)

 Warning: Cancer and/or Reproductive Harm

www.P65warnings.ca.gov

THANK YOU! We appreciate you as a valued customer and hope that you will enjoy years of use from your welder. We work to please the customer by providing a well supported, quality product. *To make sure that you receive the best quality ownership experience, please see below for important information and time sensitive details.*

What to do right now:

1. Print your receipt from your confirmation email that should have been sent to you after your purchase and put it up for safe keeping. If you do not have one, contact us at 1-877-755-9353 (US customers) or 1-905-570-1818 (Canadian Customers). You will need this if anything should ever happen for original owner verification (if bought as a gift, original receipt will still be needed, or explanation sent to Everlast).
2. Read this manual! A large number of tech and service calls are a result of not reading the manual from start to finish. Do not just scan or casually peruse this manual. There are different features and functions that you may not be familiar with, or that may operate differently than you expect. Even if you have expertise in the field of welding, you should not assume this unit operates like other brands or models you have used.
3. Carefully unpack and inspect all items immediately. Look for missing or damaged items. Please report any issues within 48 hours (72 hours on weekend or holidays) of receiving your product,. Take pictures if you are able and contact us at 1-877-755-9353, ext. 207 if any issue is discovered between 9 am and 5 pm Eastern Time M-F (US customers) or at 1-905-570-1818 (Canadian Customers) between 9am and 4 pm weekdays except on Fridays when hours are from 9 am to 12pm Eastern. If outside of the US or Canada, contact your in-country/or regional distributor direct at their service number.

What to do if you have are missing parts.

1. Within 24-48hours, (or by the next working business day) you must contact U.S. tech support at 1-877-755-9353 ext 206 (U.S. hours are 9 am to 5 pm Pacific). If you are in Canada contact 1-905-570-1818 (Canada hours are 9am to 4pm M-Th, 9am to 12pm Fri). Although phone contact is preferred to establish a missing parts claim, you may send an email to wh@everlastwelders.com (US) or mike@everlastwelders.ca (Canada) along with your contact information and brief explanation of the issue and ask for a follow up call. If you contact us via phone, and you do not reach a live person, please leave a brief message with the nature of your problem and your contact information. You should expect a call back within 24 hours. It is also a good idea to follow up the message with an email.
2. Be prepared with as much information as possible when you talk with us. **NOTE: A Proof-Of-Purchase (receipt) is required before missing parts can be sent to you.**
3. **What to do if you need setup help, or have general product assembly questions or issues.**

Call us at 877-755-9353 ext. 204. Or email performance@everlastwelders.com with the basic issue you are having.

Hey...wait, what is my warranty?

Warranties and service policies and procedures vary from country to country and are maintained and supported by the regional or in country distributor of Everlast welding equipment.

USA/Canada Customers Only: Warranty is for defects in workmanship only.

Who do I contact?

USA Technical Support:

Email: tech@everlastwelders.com
1-877-755-9353 ext. 207
9am-5pm Eastern (Closed holidays)
Monday-Friday

USA Welding Support and General Product Information:

Email: performance@everlastwelders.com
1-877-755-9353 ext 204
9am-6:30 pm Eastern (Closed holidays)
Monday-Friday

USA Sales and Main Office:

Email: sales@everlastwelders.com
1-877-755-9353 ext 201

9am-5pm Pacific (Closed holidays)
Monday-Friday

Canada Technical Support:

Email: mike@everlastwelders.ca
905-570-1818
9am-4pm Eastern Monday-Thursday
9am-12pm Eastern Friday

Canada Sales and Main Office:

Email: sales@everlastwelders.ca
905-570-1818
9am-4pm Eastern Monday-Thursday
9am-12pm Eastern Friday

Other Countries and Regions:

Visit the U.S. Website @ www.everlastwelders.com and click on the flag of the country or region represented that is closest to you. If your country or region is not found, call the U.S. office at 1-650-588-8588 between the hours of 9am to 5pm Pacific, Monday through Friday.

Safety Warnings, Dangers, Cautions and Instructions



NOTICE. This unit manual is intended for users with basic knowledge and skillset in welding. It is your responsibility to make certain that the use of this welder is restricted to persons who have read, understand and follow the warnings and instructions in this manual. If you or the operator needs further instruction, contact Everlast welding support at 1-877 755-9353 ext. 204 or seek qualified professional advice and training.



WARNING! High Frequency (HF) energy can interfere with the operation of pacemakers and can damage pacemakers. Consult with your physician and pacemaker manufacturer *before* entering an area where welding and cutting equipment is in operation and *before* using welding equipment. Some pacemakers have limited shielding. Alert any users or customers of this potential problem.



WARNING! Use approved safety glasses with wrap around shields and sides while welding and working in the weld area or serious eye damage or loss of vision may result. Use a grinding shield in addition to the safety glasses during chipping and grinding operations.



WARNING! When welding always use an approved welding helmet or shielding device equipped with at least an equivalent of a shade 9 or greater. Increase the shade number rating as amperage increase over 100 amps. Inspect helmet for cracks in lenses and in the helmet. Keep lens covers in good condition and replace as necessary.



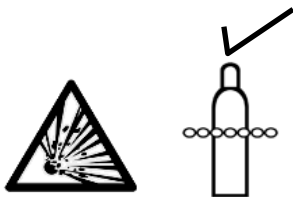
WARNING! Welding/cutting operations carry inherent risks which include but not limited to possible cuts burns, electrical shocks, lung damage, eye damage and even death. Take all appropriate measures to use proper Personal Protective Equipment (PPE). Always use leather welding gloves, closed toe (preferably reinforced or steel toe leather shoes, and long-sleeved flame resistant clothing (i.e. denim). Do not wear Poly/Nylon blend materials.



DANGER! Welding poses shock and electrocution risks. Keep this welding equipment dry. **Do not weld in the rain or where moisture accumulates.** Use dry, rubber soled shoes, gloves and clothing when welding. Do not rest or contact work clamp (ground) when welding. Keep all parts of the body insulated from the part being welded when possible. Do not touch both terminals or connections at the same time. Consider all welder parts to be “live” at all times even if no welding is being performed. Do not use frayed welding cables.



CAUTION! Fires are possible but also preventable while welding. Always remove flammable rags, papers, and other materials from the weld area. Keep rags stored in an approved flame proof canister. Keep a fully charged fire extinguisher at hand. Remove any fuels, oils, paint, pressurized spray cans, and chemicals from the weld area. Make sure any smoke/fire detectors are function properly. Do not weld on tanks, drums or barrels, especially if pressurized or sealed. Do not weld on any container that previously held fuel or chemicals. Make sure the weld area is clear of flammable materials such as grass or wood shavings solvents and fuels. Do not wear frayed or loose clothing. Visually inspect and recheck the work area after welding looking for smoldering debris or flames.



WARNING! Welding gas cylinders are under high pressure. Keep all gas cylinders upright and chained to a cart or held safely in a safety holding pen. Never transport gas cylinders in an enclosed car van or other vehicle. Transport gas cylinders securely. Keep all cylinders capped while not in use or during transport. Replace the cap on the cylinder when it is going to be more than 24 hours before use. Do not use or attempt to repair faulty regulators. Never weld on gas cylinders. Keep gas cylinders away from direct sparks.

Safety Warnings, Dangers, Cautions and Instructions



DANGER! Welding and cutting operations pose serious inhalation hazards. Some of these hazards are immediate while others are cumulative in their effect. **Do not weld in enclosed spaces or in areas without adequate ventilation.** Fumes and gases released in the welding and cutting operations can be toxic. Use fans or respiration equipment to insure adequate ventilation if you are welding in a shop or garage area. **Do not weld on galvanized metal under any circumstance. You may develop metal fume fever. Symptoms are similar to lu-like symptoms. Seek medical advice and treatment if you are exposed to galvanized welding fumes.**

If you experience any eye burning, nose or throat irritation while welding, these are signs that you need more ventilation.

If you feel these symptoms:

- Stop work immediately and relocate work area with better ventilation.
- Wash and clean your face and hands.
- Stop work completely and seek medical help if irritation persists



DANGER! Never use brake cleaner or any chlorinated solvent to clean or degrease metal scheduled to be welded or other related equipment in the area being welded. The heating of this cleaner and its residue will create highly toxic phosgene gas. Small amounts of this vapor are harmful and can lead to organ failure and death. If degreasing of a part is necessary, use Acetone or an approved pre-weld cleaner. Use the proper personal protective equipment (PPE) when handling any cleaners/solvents.








DANGER! People with pacemakers should consult a physician and pacemaker manufacturer before welding. There is a potential for damage or serious malfunction resulting in death. High Frequency energy (HF)/Electromagnetic Fields generated during welding can interfere with pacemaker signals, even permanently damaging it. Some pacemakers offer some shielding, but restrictions regarding amperage and HF starting of TIG arcs may be placed upon the individual. Warn all potential bystanders that they should exit the work area if they have a pacemaker or similar medical equipment before welding. Consult with a Physician if a pacemaker is expected to be implanted.



DANGER! Never defeat or modify any safety guards or shields. Keep all safety covers and shields in place.

Never place your fingers in or near a fan shroud or insert any object into the fan(s).

Safety Warnings, Dangers, Cautions and Instructions

	<p>CAUTION! Trip Hazards exist around welders. Cords, cables, welding leads and hoses pose a trip hazard. Be aware of their location and inform others of their location. Tape and secure them so they will stay out of high traffic areas.</p>
	<p>CAUTION! Welded metal can stay hot long after welding is completed. Burns may occur. Always wear gloves or use tongs/pliers when handling welded or cut metal. Remember the heat from the metal may catch other material on fire. Always have a fire-proof area ready to place welded components until they fully cool. Use soap stone or a metal marking marker to label the metal as “HOT” to serve as a reminder to all present in the area.</p>
	<p>CAUTION! Welding and cutting operations generate high levels of ultraviolet (UV) radiation which can burn and damage skin and eyes. The intensity is so high that exposed skin and eyes can burn in a few minutes of exposure. Minimize direct skin and eye exposure to this intense form of radiation by using proper PPE and sun screen where appropriate.</p>
	<p>CAUTION! Do not allow bystanders. Do not allow others without proper Personal Protection Equipment (PPE) suitable for welding to stand in the welding area or to observe welding and welding related activities. If protection is not readily available, use a welding screen to separate the welding area from the rest of the area. If no protection or screen is available, physically exclude them from the welding area by a wall or other solid divider. Keep all pets and young children away from the welding area.</p>
	<p>CAUTION! Electromagnetic Fields can be generated by this welder and radiate into the work place. The effect of EMF is not fully known. Exercise caution when welding by: NOT draping welding leads (guns/cables) over your shoulders or arms, NOT coiling them around your body, NOT inserting yourself directly between the cables, and by NOT contacting the unit while welding. DO keep the work clamp connected as close as possible to the area of the weld and directly to the object being welded whenever possible.</p>



Safe operation and proper maintenance is your responsibility.

Everlast is dedicated to keeping safety a top priority. While we have compiled this operator's manual to instruct you in basic safe operation and maintenance of your Everlast product, it is no substitute for observing safe welding practices and behavior. Safe welding and related cutting operations require basic knowledge, experience and ultimately the exercise of common sense. **Welding does significant hazards to your health and life! Exercise extreme caution and care in all activities related to welding or cutting. Your safety, health and even life depends upon it.**

WARNING! If you do not have proper knowledge or capability to safely operate this machine, do not use this machine until proper training has been received!

While accidents are never planned, preventing an accident requires careful planning. Stay alert!

Please carefully read this manual before you operate your Everlast unit.

The warranty does not cover damage or harm created by improper use, neglect of the machine or failure to follow safe operating practices.

DANGER!

Improper use and operation of this welding cart may result in cart overturn and can result in serious injury and death.. This may result in loss cylinder explosion if cylinder is uncapped. Never use this unit on unlevel, unstable ground or while overloaded. Do not modify the cart as change in center of gravity may occur. Always keep cylinders double chained tightly to the cart. Repair or replace any damaged parts immediately.

IMPORTANT!

After initial assembly and a short period of use, check and retighten all fasteners. Check and retighten all fasteners regularly. Regrease/lubricate wheels once a year or as needed with heavy gear oil, or axle grease.

Setup Guide

Getting Started

UNPACK YOUR CART.

Upon arrival, you will need to completely unpack your cart, and check things over. Lay the parts out in an orderly fashion on an old towel, or sheet on a floor or large flat surface. Make sure all parts are there. The sheet/towel will help protect the unit from scratching during assembly. You may need to arrange to have a helper to assist in assembly as some of the parts are large and cumbersome. However, it is not absolutely necessary if you have a wall or other fixed vertical surface to assist in assembly.

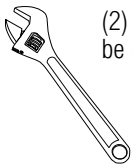
WHAT YOU WILL NEED TO PROVIDE.

You will need a limited amount of items to assemble this unit.

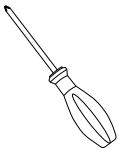
Make sure you have the following to assemble your cart:



- (2) 13mm or 1/2" Combination Wrenches.
- (1) 8mm or 5/16" Combination Wrench.
- (1) 9mm or 3/8" Combination Wrench.



- (2) 6" or 8" Adjustable Wrenches. Optional. (May be used if combination wrenches are not available.)



- (1) #2 Phillips head screw driver.
- (1) #3 Phillips head screw driver. Optional. (May be used if 13mm/1/2" combination wrench is not available due to hex head/screw driver slot combination design of bolts. Use adjustable wrench to hold the other side in this case.)



- 1 Fl Oz. of heavy oil or grease (axle grease) for lubricating rear axle bearings.

IMPORTANT!

If you have access to a cordless drill or impact driver, you are welcome to use it to expedite the assembly if you have the correct sizes. This can cut assembly time in half.

However, reduce the torque setting on the clutch to a low setting to prevent stripping of the prethreaded holes. Do not assemble in "drill" mode, or full impact mode. If you cannot regulate the torque on your drill/driver, do not use or screws or threads will be stripped.!

TIME REQUIRED:

If you do not have a helper, expect to devote up to 1.5 to 2 Hours for assembly and 15 minutes to read and review the manual. If you have a helper, expect to budget 1-1.25 hours for assembly.

MISSING/DAMAGED PARTS?

Contact Everlast at 1-877-755-9353 ext 206 in the USA to order missing or replacement parts for damaged items. If you are not in the USA, contact your regional or national distributor for replacement parts. During the shipping or assembly process, if your cart is severely scratched, you may touch up the paint with a Satin Black spray paint available in your local hardware or paint store.

Notice: Hardware such as fasteners and hitch pins are not available individually for replacement and should be sourced locally if needed. Usually fastener counts have enough or extra screws to complete assembly, and extra effort is taken to ensure the presence of all needed fasteners. However, in the regrettable event that a screw, nut, washer or pin is missing, please source one locally. Everlast does not stock individual fasteners for this cart. However, if the complete fastener bag is missing, contact Everlast for replacement.

IMPORTANT!

During assembly, leave all the screws and bolts loose until the sub assembly or major part being assembled is completely assembled. If you tighten as you go, you will have difficulty aligning some holes and making parts fit together correctly. Once the sub assembly or part has been completed, then you may proceed to tightening all related parts together. This will speed up the assembly process as well.

WARNING!

Never operate or use this cart without both safety chain in place securing the cylinders. Always disconnect regulators and cap cylinders when not in use for more than 24 hours or when traveling long distances with the cart.

DANGER!

Never use this welding cart on uneven ground, or on inclines. Overturn is possible. Severe injury or death can occur.

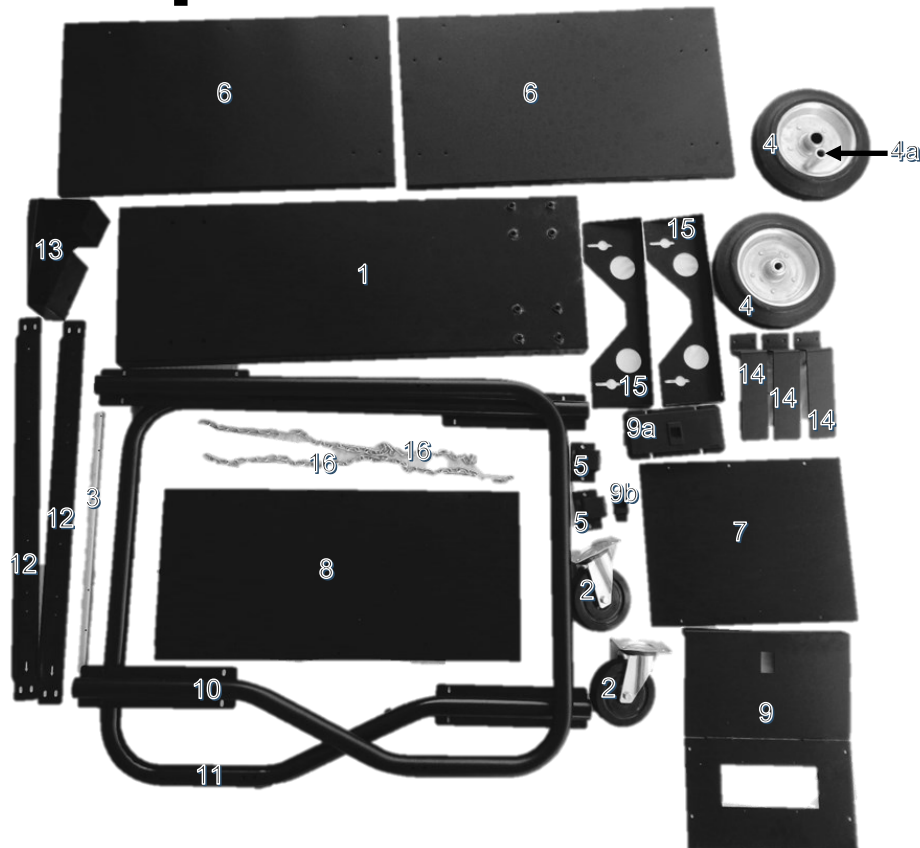
Specifications

Product Specifications

Construction Type	Steel
Designed to fit :PowerTIG 200DV, 210EXT, 250EX, PowerTIG 255EXT, PowerTIG 325EXT, PowerARC 300STi, PowerARC 280STH, PowerPlasma 62i, PowerPlasma 82i, PowerPlasma 102i.	
Total width with accessory holders installed	21.5"
Total width without accessory holder installed	18"
Width inside Stanchions (Clearance for Welder)	12.5"
Useable Platform Length (Welder Mounting Area)	26"
Total Height	44"
Ground Clearance	4.25" to bottom of axle support brackets.
Cargo Stowage Box Dimensions	12.75" W X 27.5"L X 16" High
Height above Cargo Stowage box to Top of Stanchions.	24"
Cylinder rack Capacity	80 Cu Ft. to 330 Cu. Foot Cylinder
Shipping Weight	112 lbs
Total Gross Carrying Capacity	500 lbs.

Setup Guide

Component Identification.



Item#	Qty.	Description
1	1	Main undercarriage base pan.
2	2	Front Caster.
3	1	Rear Axle.
4	2	Rear Wheel. Includes Needle bearing.
4a	2	Bushing Insert for Rear Wheel. May be installed in wheel hub already, or may be loose.
5	2	Rear Axle Support Bracket.
6	2	Gear Stowage Box Side Pan.
7	1	Gear Stowage Box Rear Plate.
8	1	Gear Stowage Box Top Pan.
9	1	Gear Stowage Box Front Door Assembly.
9a	1	Door Insert for Consumable Stowage. To be used on the door of the stowage box.
9b	1	Latch for Cargo Stowage Box Door. (May be located in 9a for packaging purposes)
10	1	Left Cart Stanchion. (Handle)
11	1	Right Cart Stanchion. (Handle)
12	2	C-Channel Cross Brace. (Used to attach accessory hooks and pedal holder)
13	1	Foot Pedal Accessory Holder.
14	3	Accessory and Gear Holding Hooks.
15	2	Cylinder Rack Safety Bracket with Filler Metal Tube Cut-Outs.
16	2	Cylinder Safety Chains. (For securing shielding gas cylinder to the cart.)
17	1	Fastener Kit. (Not Pictured, See next page for contents)

Setup Guide

Fastener Kit and Tools Required.

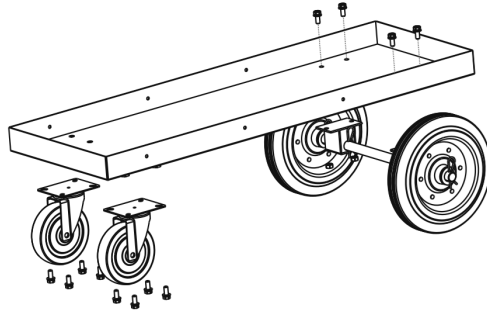
Size	Qty.	Fastener Kit Contents and Description
m4	4	Screw, short. Use with Cargo Stowage Insert
m6	8	Screw, long. Use with Phillips Head #2. Use with m6 locking nuts to secure accessory
m6	8	Locking nuts. Use with m4 long screws to secure accessory cross brace. Use 9mm wrench, or 3/8" wrench.
m5	50	Bolt, short, with washers installed. Used with pre-threaded parts. Use with 8mm wrench, 5/16" wrench or Phillips Head # 2.
m8	12	Bolt, short, with washers installed. Use with Front Casters and Rear Axle Assembly. Use with 13mm wrench, 1/2" wrench or Phillips Head # 3.
m8	4	Nut. Use to secure rear axle supports. Use with 13mm or 1/2" Wrench
m8	4	Washers.
	6	Hitch Pins for wheel attachment.
	4	Large Axle Washers

Setup Guide

Undercarriage and Truck Assembly.

NOTICE:

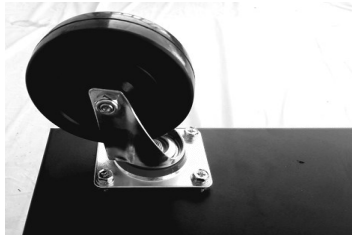
Use the Component Identification page to locate and identify the following parts.



1. Locate the main undercarriage base pan (#1). Flip it over (lip down) and locate the front caster mount nuts.



2. Locate the front casters (#2) and find the m8 bolts (largest ones) in the fastener bag. Using the 13mm (1/2") wrench, install the caster as depicted.



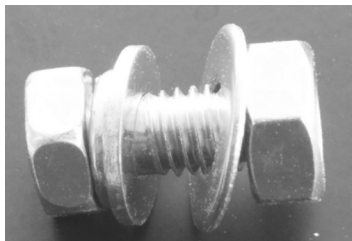
3. Install the second caster.



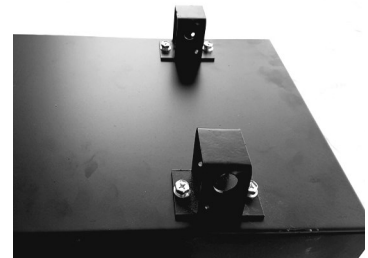
4. Locate the two rear axle support brackets (#5). Locate the m8 nuts, m8 washers and remaining m8 bolts. Align the bracket with the rear holes in the main undercarriage base pan.



5. During installation, the m8 bolts should have a m8 washer on either side of the undercarriage pan. The bracket and pan will be sandwiched between these two flat washers.



6. Use the two 13mm (1/2") bolts to secure the rear axle support brackets (#5) to the rear portion of the main undercarriage pan. The bolts may be inserted from either the top or bottom.



7. Locate the rear axle (#3) and insert it through the two rear axle support brackets (#5). The axle will have some play inside the bracket. This is normal.



8. Locate the hitch pins in the fastener bag as depicted.



9. Install four hitch pins on the axle (#3) as depicted. Locate them on either side of the axle support brackets (#5).

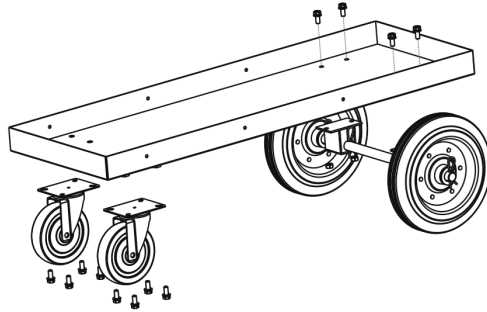


Setup Guide

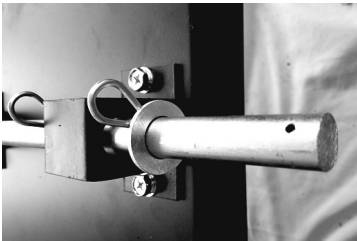
Undercarriage and Truck Assembly.

NOTICE:

Use the Component Identification page to locate and identify the following parts.



10. Locate the large axle washers in the fastener bag and install as depicted below on both sides.



11. Locate the Rear Wheels (#4). If not already removed, remove the bearing insert (#4a). Lubricate the bearings with heavy oil or axle grease.



12. Install the bearing insert spacer (#4a) back into the housing on the wheel (#4).



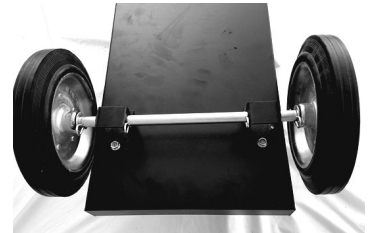
13. Install the two lubricated wheels (#4) onto the axle (#3).



14. Install the remaining axle washers and hitch pins.



15. Both wheels(#4) should be captured and held in place by the washers and hitch pins located on either side of the wheel.

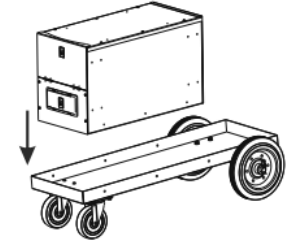
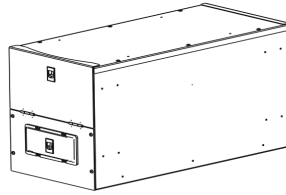
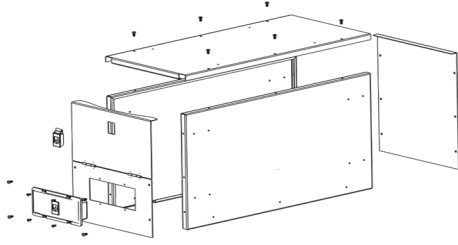


16. Flip the entire assembly over and test to see that it rolls smoothly.



Setup Guide

Gear Stowage Box Assembly



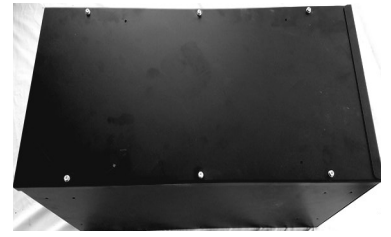
17. Locate the gear stowage box sides pans (#6) and top plate (#8). Assemble the top and sides as shown. You may need an assistant to help hold this together at this point. The cutouts in the sides face down.



18. Ensure that the holes in the top plate (#8) are aligned with the corresponding holes in the side pans(#6).



19. Locate the short m5 bolts. Use a 8mm or 5/16" wrench to install the screws into the holes along the top. Do not strip!



20. Turn the assembled parts on the end, with so that the lip on the top is facing down. This will position the sub assembly so that the gear stowage box back plate (#7) can be installed. The lip on the top must face down as the lip is used for the door latch catch.



21. Install the rear plate of the gear stowage box using the m5 bolts. The top lip of the back plate (#7) should protrude above the top of the box assembly.



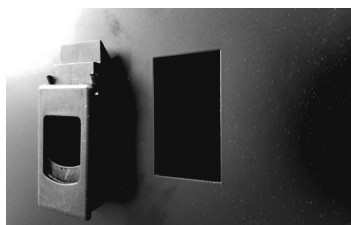
22. Flip the box over, again, on the other end to position the box so the front door assembly (9) can be installed. The end with the top lip should be facing up.



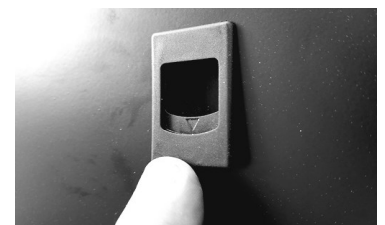
23. Install the front door assembly (#9) with the small rectangular cutout for the latch facing the top plate (#8). Use the short m5 bolts and 8mm (5/16") wrench to secure the front door assembly to the box assembly.



24. Locate the gear stowage door latch (#9b) and align it so the latch tab is facing the top of the box assembly.

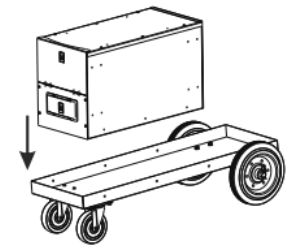
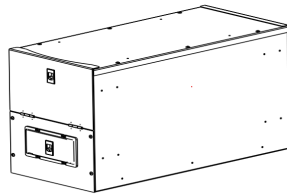
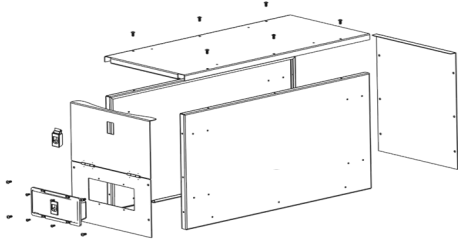


25. Tilt the latch top first into the latch hole and press down firmly on the bottom of the latch so that the latch snaps into place.



Setup Guide

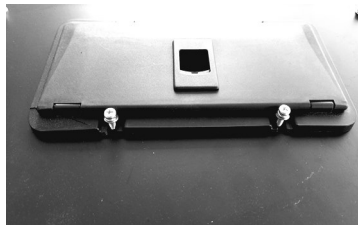
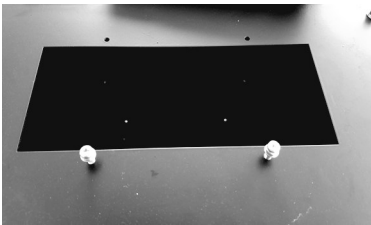
Gear Stowage Box Assembly



26. Locate the small m4 screws in the fastener bag. Install two m4 screws using a #2 Phillips head screw driver into the bottom of the large cutout on the front door assembly. Do not tighten.

27. Install the consumable box insert (#9a) into the hole by sliding the slots in the consumable box under the heads of the loose screws.

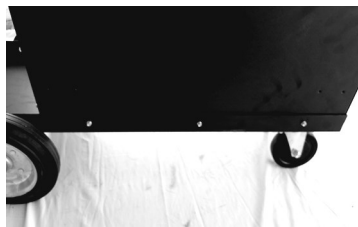
28. Make sure the consumable box door opens and closes. Install the remaining m4 screws.



29. Install assembled cargo stowage box onto the under carriage assembly, with the front door facing the small caster end. Carefully align holes in the cargo stowage box with the holes in the lip of the undercarriage. **The box must be seated fully down and fully forward on the cart for the holes to align.**

30. Using the 8mm (5/16") wrench, install the m5 bolts loosely. Leave all bolts loose until all bolts have been started into their holes.

31. Flip the box over, again, on the other end to position the box so the front door assembly (9) can be installed. The end with the top lip should be facing up.

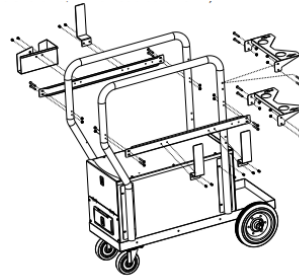
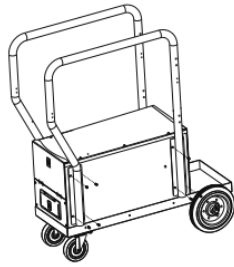


32. Install the front door assembly (#9) with the small rectangular cutout for the latch facing the top plate (#8). Use the short m5 bolts and 8mm (5/16") wrench to secure the front door assembly to the box assembly.

33. Locate the gear stowage door latch (#9b) and align it so the latch tab is facing the top of the box assembly.

Setup Guide

Stanchion and Accessory Final Assembly



35. Locate the left and right stanchions (handles) (#10 and #11). Lay the cart on its right side to install the left stanchion (#10) with the curve in the handle facing to the front of the cart. Use the m5 bolts and the m8/(5/16") wrench to install.

36. Flip the cart over on its other side and repeat the process.

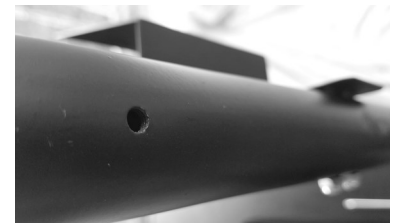
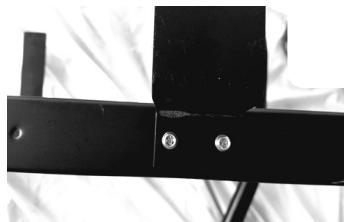
37. Locate the two C-channel cross braces (#12) and long m6 screws and m6 lock nuts. Using a #2 Phillips screw driver and 9mm wrench attach the cross braces with the lips of the channel facing the inside and the arrow facing the front.



38. Install both sides and retighten all bolts securely up to this point. Be careful and do not strip the threads by over tightening.

39. Locate and install the accessory hooks (#14) and foot pedal accessory bracket onto the C-Channel Cross braces (#12) using m5 screws and a #2 Phillips screw driver. Two hooks will be used on one side. The other will be used on the other side with the foot pedal bracket. Exact location and side is customer preference. Several combination possibilities exist.

40. Locate the two cylinder rack safety brackets (#15) and install both on the rear of the cart using the m5 screws and the 8mm/(5/16") wrench. The rear stanchion will have predrilled and tapped holes to mount the brackets onto. **It is important that both brackets be mounted and used for safety.**



41. Install Cylinder safety chains (#16) as shown. These are designed to keep the cylinder upright. **Always use both, if the cylinder is tall enough.**



