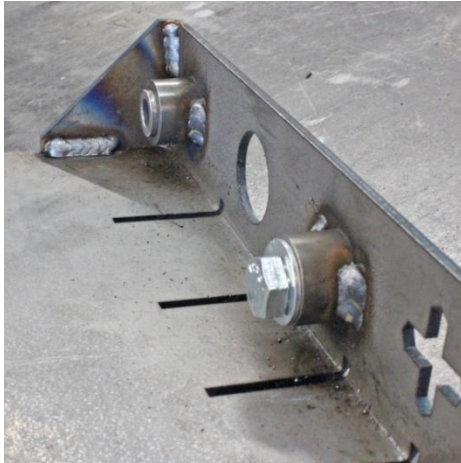


30"x16" Plasma Table Roll Around – Conversion instructions

Note: read instructions completely before assembling.
Verify your roll around measures 29.25" x 15.375" I.D. or a little less & bolt pattern matches.

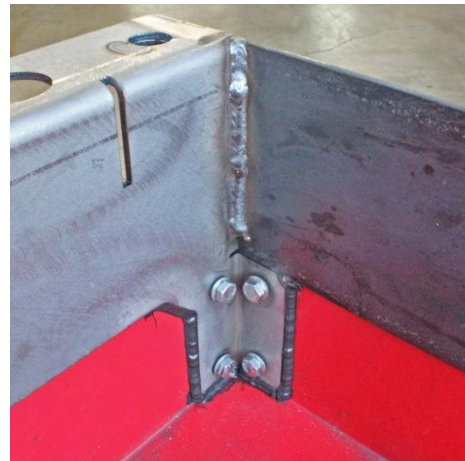
Step 1 – Weld gussets & 5/8 tubes - Left pic. below - Start by tacking and welding gussets on the end pieces, use anti-spatter spray. For those with fixture/weld table clamp, proceed with welding included tubes, otherwise skip to next step. We include a bolt and sleeve that you assemble on the table to locate and hold the tubes (bottom of the left pic.). Install hand tight then tack on each side, remove bolt/sleeve and move to next hole. Once all tubes are tacked, then weld.

Step 2 – Assemble table - Right pic. below - Place ends upside down on a flat work table and use a magnetic square to hold 4" flat bar. Butt end of flat bar to the face of the end pieces, make sure flat bar is touching end pieces and flush to outside. Table will be 29 1/8" long. Tack toward top, then remove square, align and place second tack toward middle, give spacing for three stitch welds. Repeat on all four sides and tack bent leg to flat bar as shown at bottom of pic.



Step 3 – Install on cart – left pic. below - Remove all bolts from top shelf, clean corners and start four new bolts from the outside of each end. Apply generous bead of silicone in corner and near bolts on bottom. Drop one side of the plasma table in, slide through bolts and start a couple nuts as shown in. Then move to the other side, remove bolts and lift up shelf to spread sides and slide over plasma table, then drop assembly down and align bolts with vertical supports.

Step 4 – Seal and secure - right pic. below - Now install all bolts with sealing washers on inside and flat washers on outside. Evenly snug down bolts about halfway, making sure to leave a little gap on the inside between table and shelf. Now apply a nice bead of silicone around the table corners and remove any excess. Finally tighten all bolts evenly to 5-10 ft. lbs.



Step 5 – Drain plug - Top of left pic. below - Drill ½” hole with stepper bit, remove any burrs and install drain plug. We recommend about three inches from one end and toward the middle, but not centered.

Step 6 – Install hooks - Put your plasma cutter on the cart if desired and figure out where you would like the hooks to go.

Step 7 – Painting - You can easily mask just under the rolled edge of the top shelf. After painting use a little sandpaper to remove paint where cutting slats contact table, this ensures the cutting slats will be grounded with plasma table. If you want to paint a different color you should do so before attaching it to the cart.

Step 8 – Wave breaks – Left pic. below - Install wave breaks and fill with water, check for leaks. Keep a bucket handy in case you need to drain the water. If you have a leak try tightening the bolts a little more, or remove water and add second layer of silicone if necessary.



This is a new product and we would like to hear how the Plasma Table works for you!

911 Motorsports, LLC Warranty Information (Please read before use of product)

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