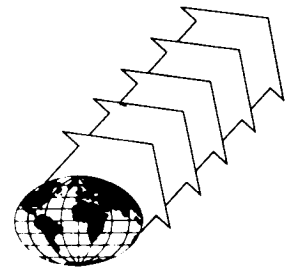


# Technical Bulletin



**TOMORROW'S  
 MANUFACTURING  
 LEADERSHIP  
 TODAY**

Bulletin Number: 416 Revision Number: R-01  
 Release Date: May 7, 1991 Revision Date: Nov. 18, 1992

**SUBJECT: CLINCHING GUSSET ASSEMBLY INSTRUCTIONS**

**MODELS:** All Williston built venders shipped prior to March 2, 1991 (Serialized 0001-6000 to 0001-6008)

**REASON:** This kit will secure loose clinch nuts and minimize possible leveling leg deflection.

**ORDER:** 491,010,300.04 Clinching Gusset Retrofit Kit

**KIT CONTENTS:**

ITEM#	NAME	PART#	QTY
1	W/A Clinching Gusset A	491,020,500.03	2
2	W/A Clinching Gusset B	491,020,600.03	2
3	1/4-20 Stack Bolt	900,301,730.21	2
4	5/16-18 Rib Neck Carriage Bolt	900,502,660.01	2
5	1/14-20 Blind Nut	900,800,830.01	2
6	5/16-18 Keps Nut	900,800,840.01	2

**TOOLS NEEDED**

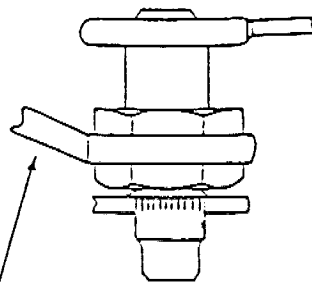
NAME	QTY
Safety Glasses	1
Dead Blow Hammer	1
Mandril (Alignment Tool)	1
Blind Nut Tool	1
1-1/2 Socket	1
Rachet	1
7/16" Socket	1
1/2" Socket	1
5/8 - 11 Tap	1
Vise Grip Pliers	1
9/16" Wrench	1

**READ INSTRUCTIONS THOROUGHLY BEFORE INSTALLING**

**WARNING: EXERCISE EXTREME CAUTION WHEN HANDLING VENDER. TILTING OR LAYING ON BACK CAN CAUSE SERIOUS INJURY.**

1. Vender should be empty of all product to allow it to be tilted or be laid on its back to install kit.
2. Remove shipping boards using a 1-1/2" socket and ratchet wrench.
3. Straighten existing clinch nuts if needed. This can be accomplished by threading leveling leg in to clinch nut and tapping side of leveling leg head. Once straight remove leveling leg.
4. Install blind nuts in tooling holes of base near the rear clinch nuts only. To install blind nuts use installation tool supplied and follow these steps:
  - A. Thread blind nut on to installation tool. See Figure 1.
  - B. Insert blind nut in to tooling hole in base from bottom underside.
  - C. Hold tool body with 9/16" wrench to prevent turning.
  - D. Attach 7/16" socket wrench to hex head cap screw. To install, torque the drive screw clockwise. See Figure 2 & 3.
  - E. Once installed, remove blind nut tool. To accomplish this, torque the drive screw counter clockwise.

FIGURE 1



TOOL BODY MUST BE HELD WITH WRENCH TO PREVENT TURNING.

FIGURE 2



TO INSTALL, TORQUE THE DRIVE SCREW CW. TO REMOVE, TORQUE CCW.

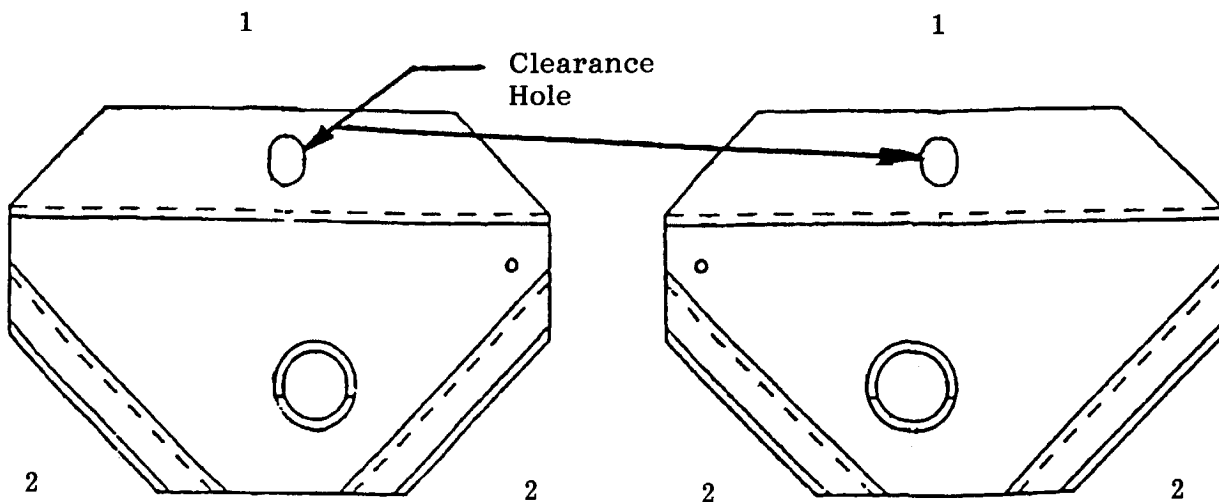


INSERT INSTALLED

FIGURE 3

5. Install w/a clinching gusset one corner at a time.  
**NOTE:** There is an "A" clinching gusset and a "B" clinching gusset.

FIGURE 4



CLINCHING GUSSET "A"

CLINCHING GUSSET "B"

**IF INCORRECT CLINCHING GUSSET IS USED, HOLE IN GUSSET WILL NOT ALIGN WITH BASE NUT.**

6. Install clinching gusset "A" on front of vender, hinge side (left) of cabinet. Place gusset so sides "2" (See Figure 4.) are under vender base flange and out of view. **Note: You may need to use dead blow hammer and make a slight adjustment of base flange.**
7. Align clearance hole (See Figure 4.) in clinching gusset with tooling hole in base. **Note: You may have to use dead blow hammer and/or mandril.** Insert mandril through clinching gusset and in to clinch nut. Tap sides of mandril with hammer to align clearance hole of gusset with tooling hole in base. Once aligned, install leveling legs and tighten all the way in to base install rib neck carriage bolt so head of bolt is on top of base and secure with keps nut on bottom side of base. Tighten securely.
8. Install clinching gusset "B" on front of vender, door roller side (right) of cabinet. Follow steps 6 and 7 for installation, alignment and securing.

9. Install clinching gusset "B" on back of vender, hinge side (left) of cabinet. Follow step 6 for installation.
10. Align clearance hole in clinching gusset with tooling hole (which has blind nut installed). **Note: You may have to use dead blow hammer and/or mandril.** Insert mandril through clinching gusset and in to clinch nut. Tap sides of mandril with hammer to align. Once aligned, install leveling legs and tighten all the way in to the base. If leveling legs are too tight to install by hand then alignment is not correct and should be adjusted. You may need to tap clinch nut at this time 5/8"-11 tap. Once leveling leg is all the way in to base install stack bolt. Tighten securely.
11. Install clinching gusset "A" on back of vender, door roller side (right) of cabinet. Follow step 6 for installation.
12. Follow step 10 for alignment and securing.