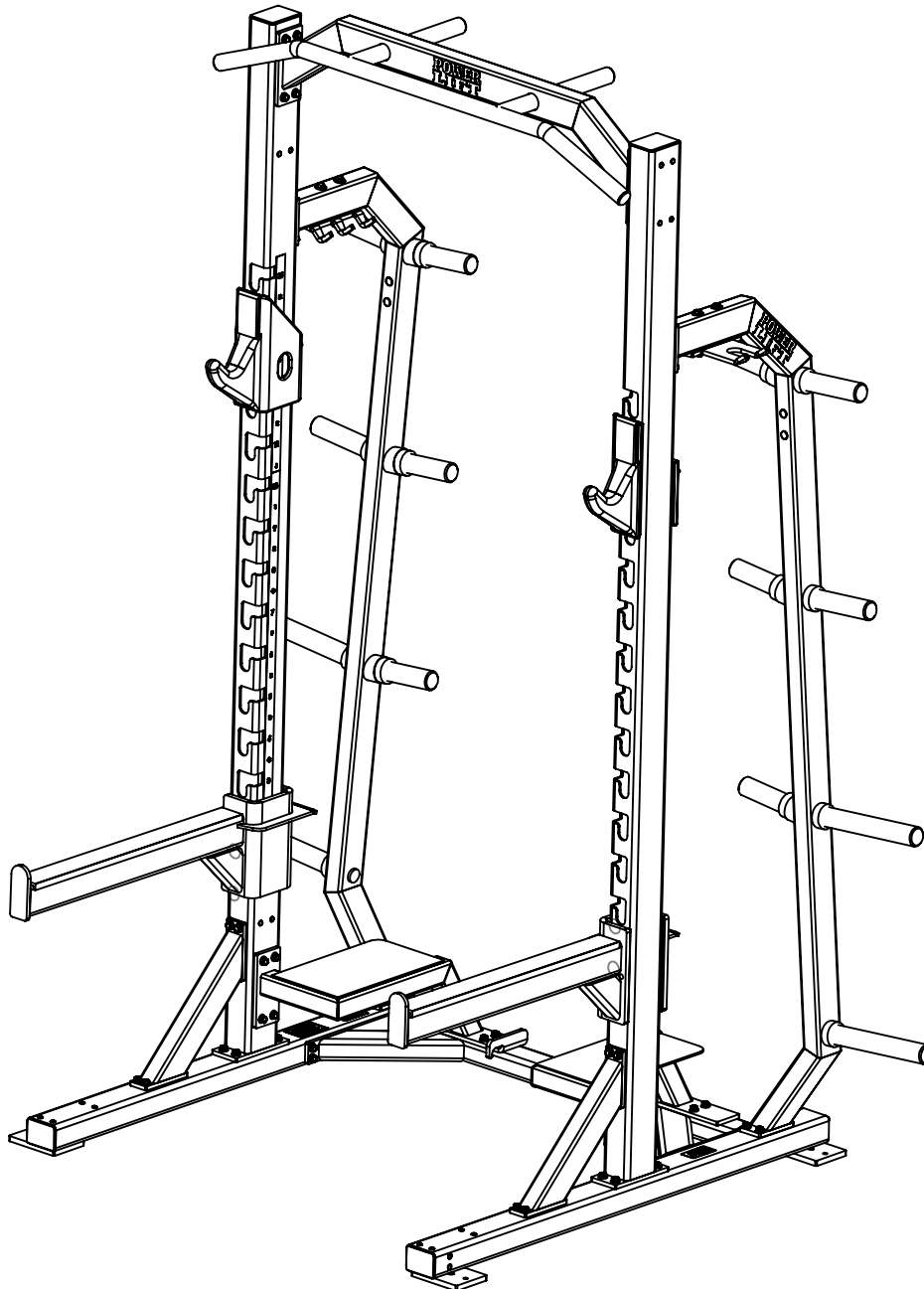


# Half Rack



## Assembly notes:

Fasteners provided to assemble machine:

(56) 3/8"X3/4" Flange Bolts

(4) 3/8"X4" Bolts

Tools required (Not Included):

- 9/16" Open-End Wrench
- 9/16" Socket
- 4 ft ladder (recommended)

**Note:** When assembling unit DO NOT tighten any fasteners until specified.

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**17032A-assembly cover**

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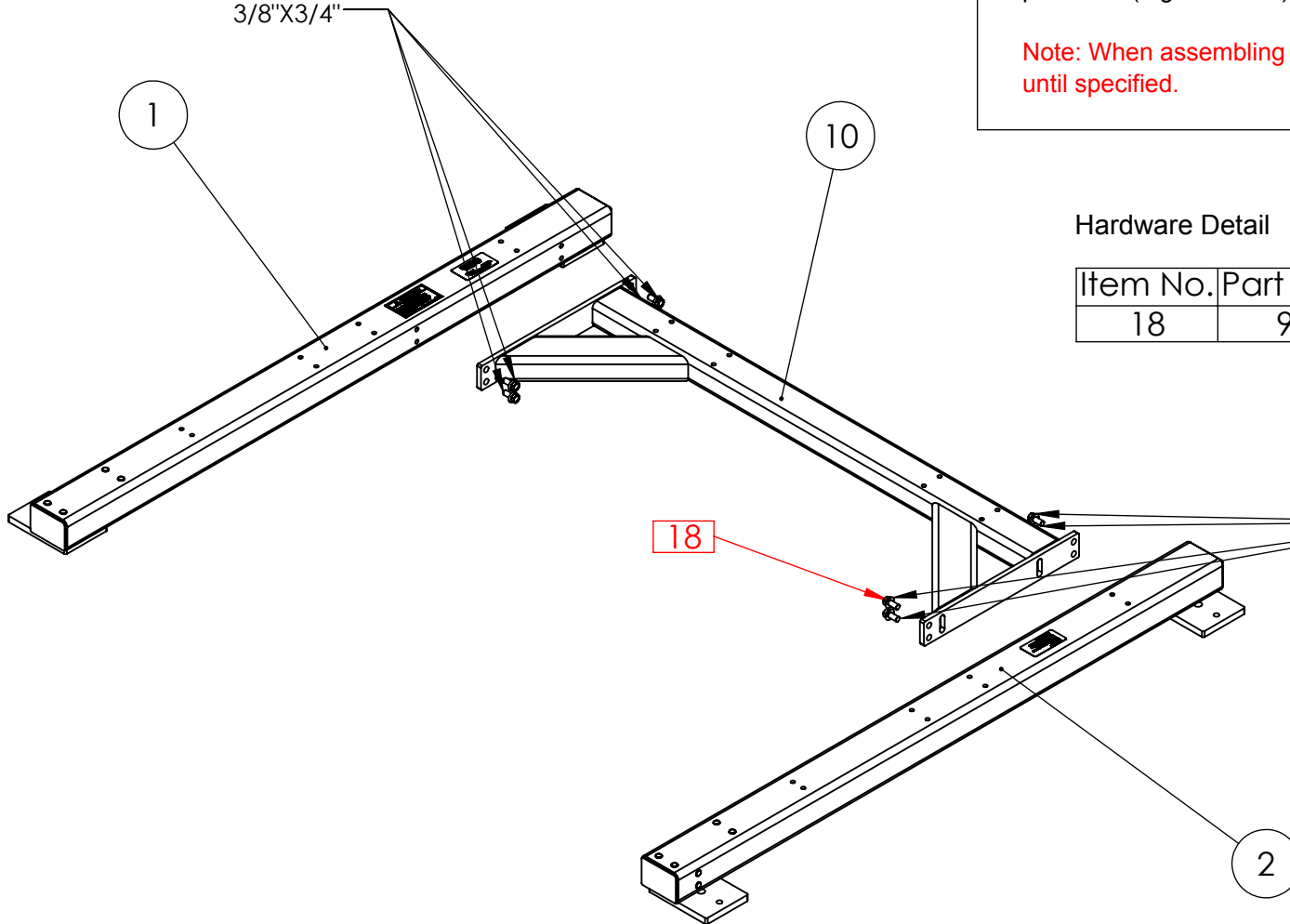
## Instructions

- 1.) Assemble item 1 to item 10 using (4) 3/8"X3/4" flange bolts provided. (Tighten bolts)
- 2.) Then assemble item 2 to item 10 using (4) 3/8"X3/4" flange bolts provided. (Tighten bolts)

**Note:** When assembling unit DO NOT tighten any remaining fasteners until specified.

### STEP 1

Item #18  
3/8"X3/4"



### Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	8

### STEP 2

Item #18  
3/8"X3/4"

### Frame Detail

Item No.	Part Number	Part Name	Qty
1	15024	LEFT BASE	1
2	15022	RIGHT BASE	1
10	39565A	K BRACE	1

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## Instructions

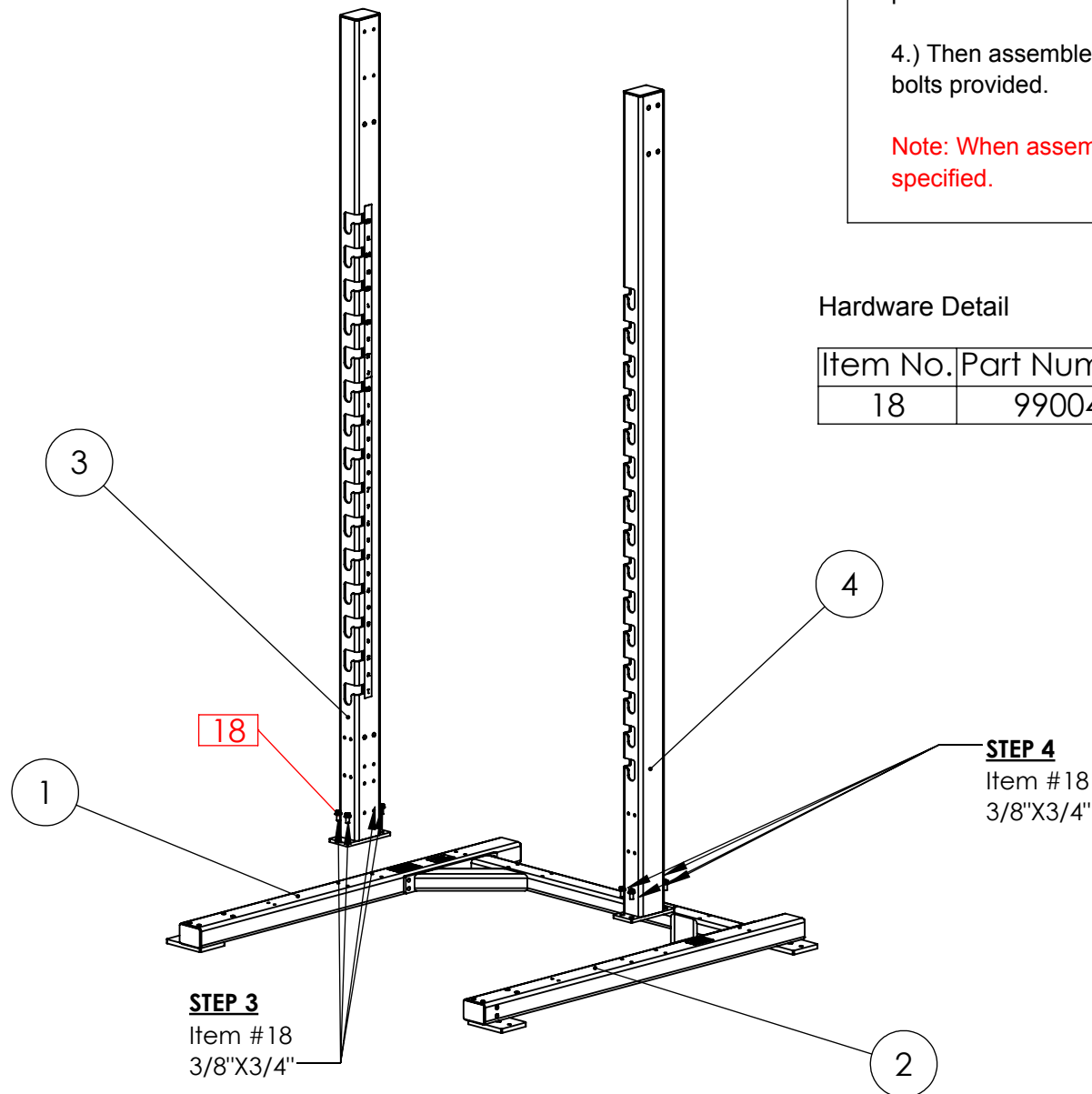
3.) Assemble item 3 to item 1 using (4) 3/8"X3/4" flange bolts provided.

4.) Then assemble item 4 to item 2 using (4) 3/8"X3/4" flange bolts provided.

**Note: When assembling unit DO NOT tighten any fasteners until specified.**

## Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	8



## Frame Detail

Item No.	Part Number	Part Name	Qty
1	15024	LEFT BASE	1
2	15022	RIGHT BASE	1
3	17510A	LEFT REAR UPRIGHT	1
4	17512A	RIGHT REAR UPRIGHT	1

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## Instructions

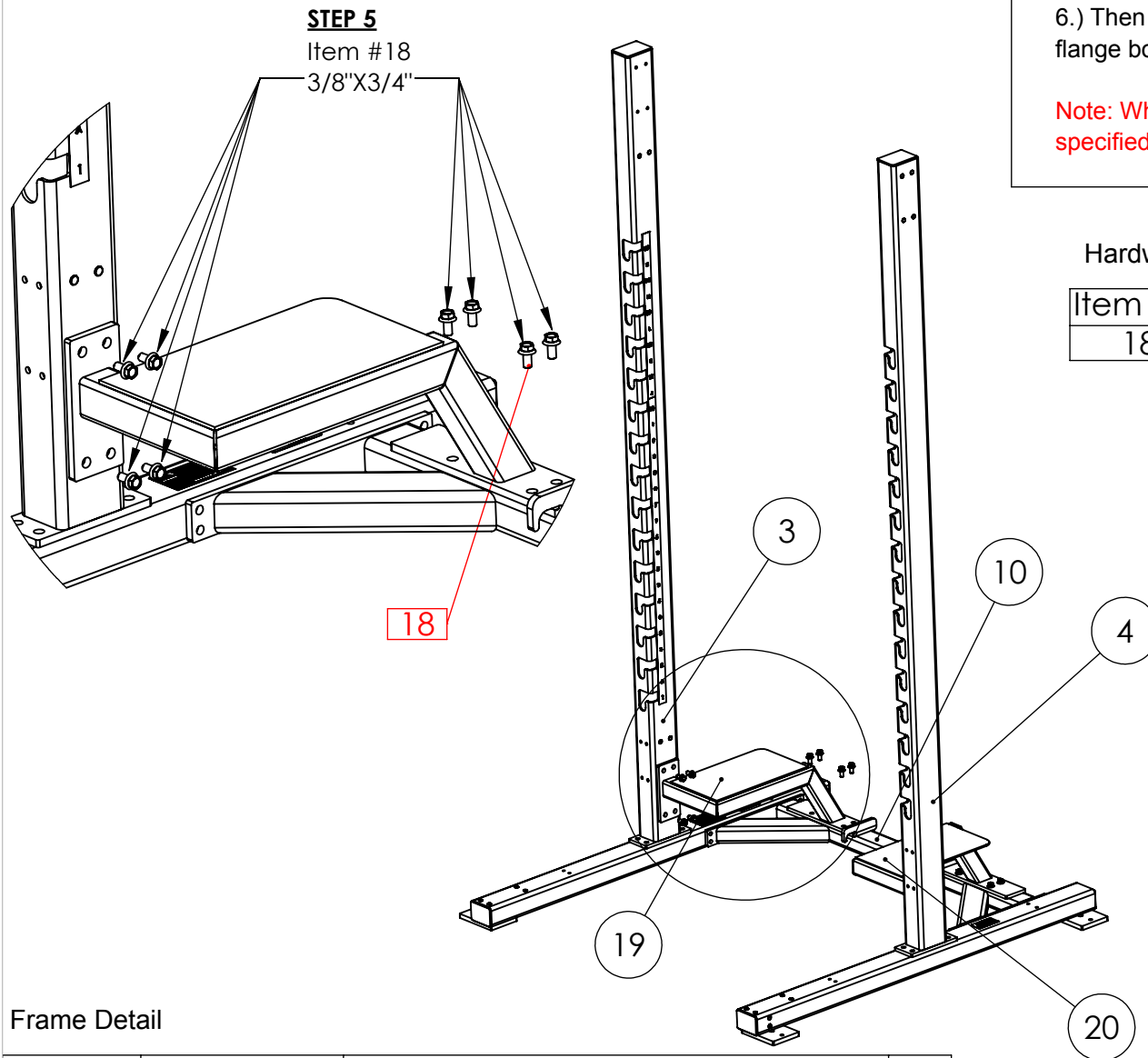
5.) Assemble item 19 to items 3 and 10 using (8) 3/8"X3/4" flange bolts provided.

6.) Then assemble item 20 to item 10 and 4 using (8) 3/8"X3/4" flange bolts provided.

**Note: When assembling unit DO NOT tighten any fasteners until specified.**

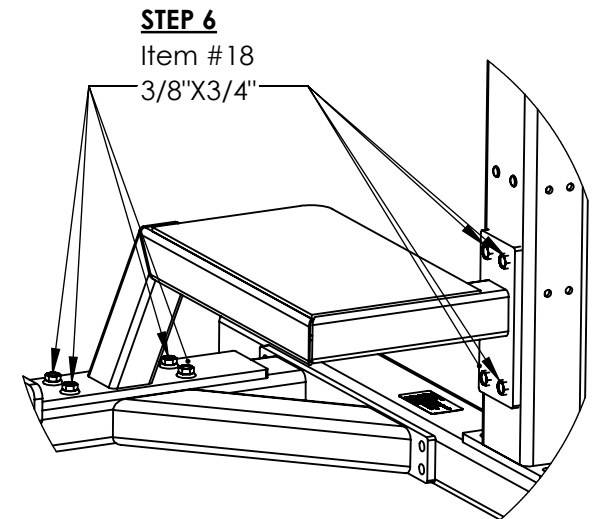
## Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	16



## Frame Detail

Item No.	Part Number	Part Name	Qty
3	17510A	LEFT REAR UPRIGHT	1
4	17512A	RIGHT REAR UPRIGHT	1
10	39565A	K BRACE	1
19	40101	LEFT SPOTTER	1
20	40103	RIGHT SPOTTER	1



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**17032A\_page3**

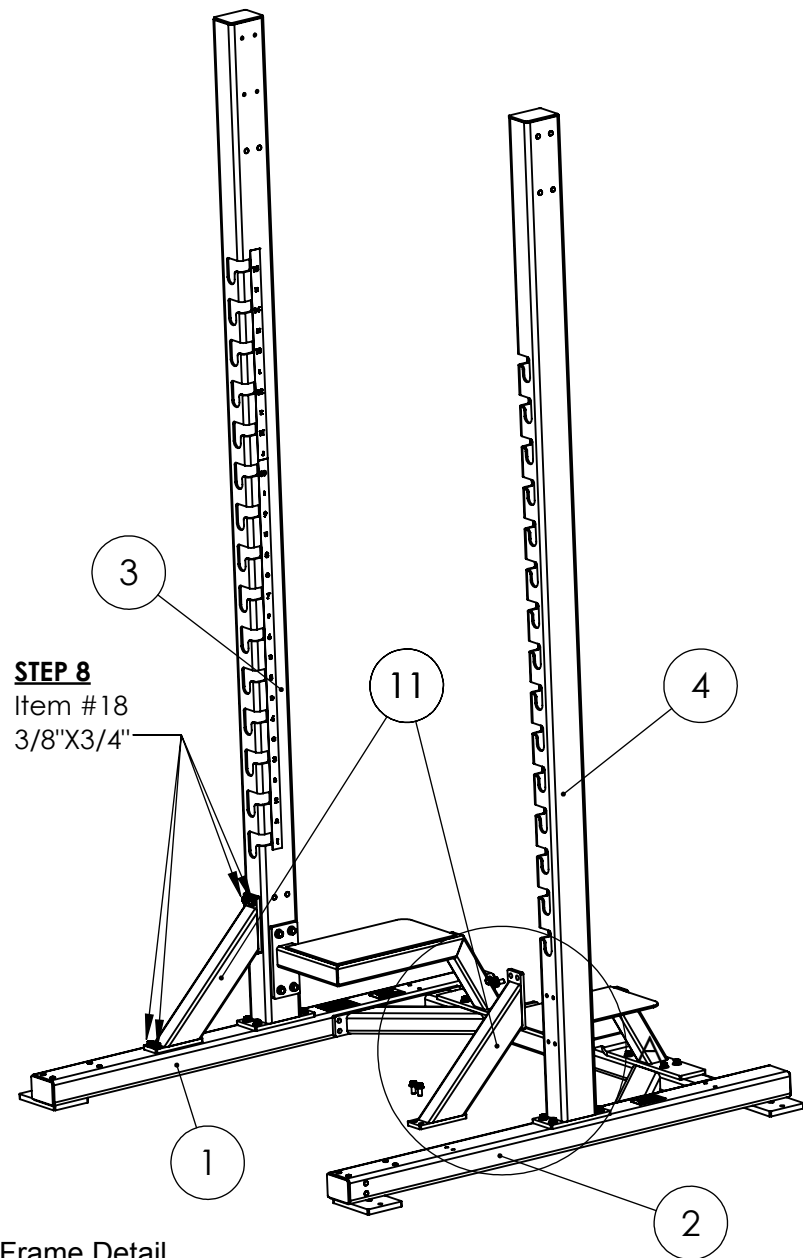
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**STEP 8**  
Item #18  
3/8"X3/4"

Frame Detail

Item No.	Part Number	Part Name	Qty
1	15024	LEFT BASE	1
2	15022	RIGHT BASE	1
3	17510A	LEFT REAR UPRIGHT	1
4	17512A	RIGHT REAR UPRIGHT	1
11	15550A	DIAGONAL BRACE	2

Instructions

7.) Assemble item 11 to items 2 and 4 using (4) 3/8"X3/4" flange bolts provided.

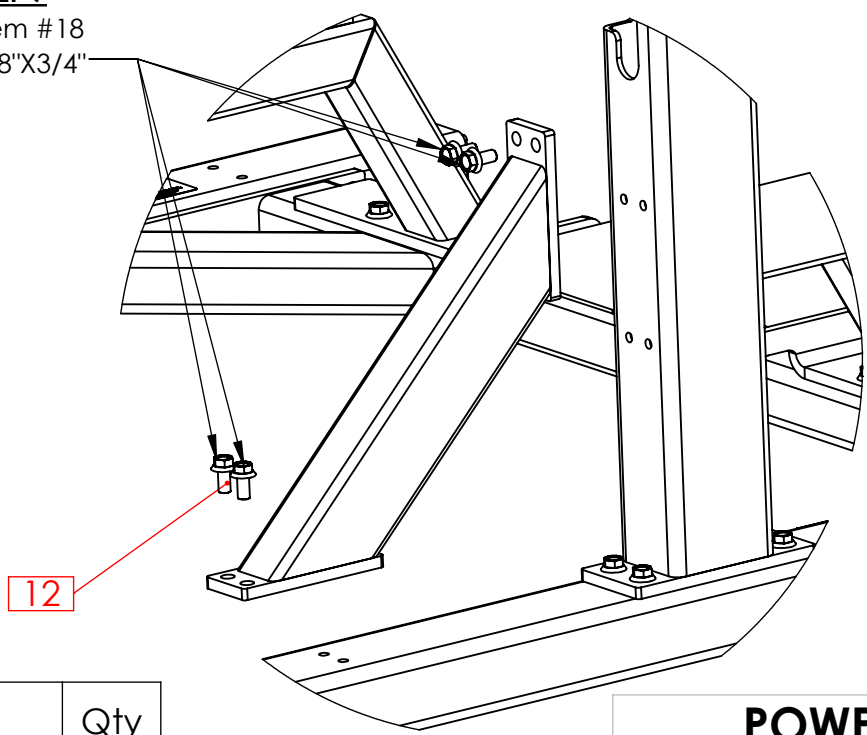
8.) Then assemble the other item 11 to item 1 and 3 using (4) 3/8"X3/4" flange bolts provided.

**Note: When assembling unit DO NOT tighten any fasteners until specified.**

Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	8

**STEP 7**  
Item #18  
3/8"X3/4"



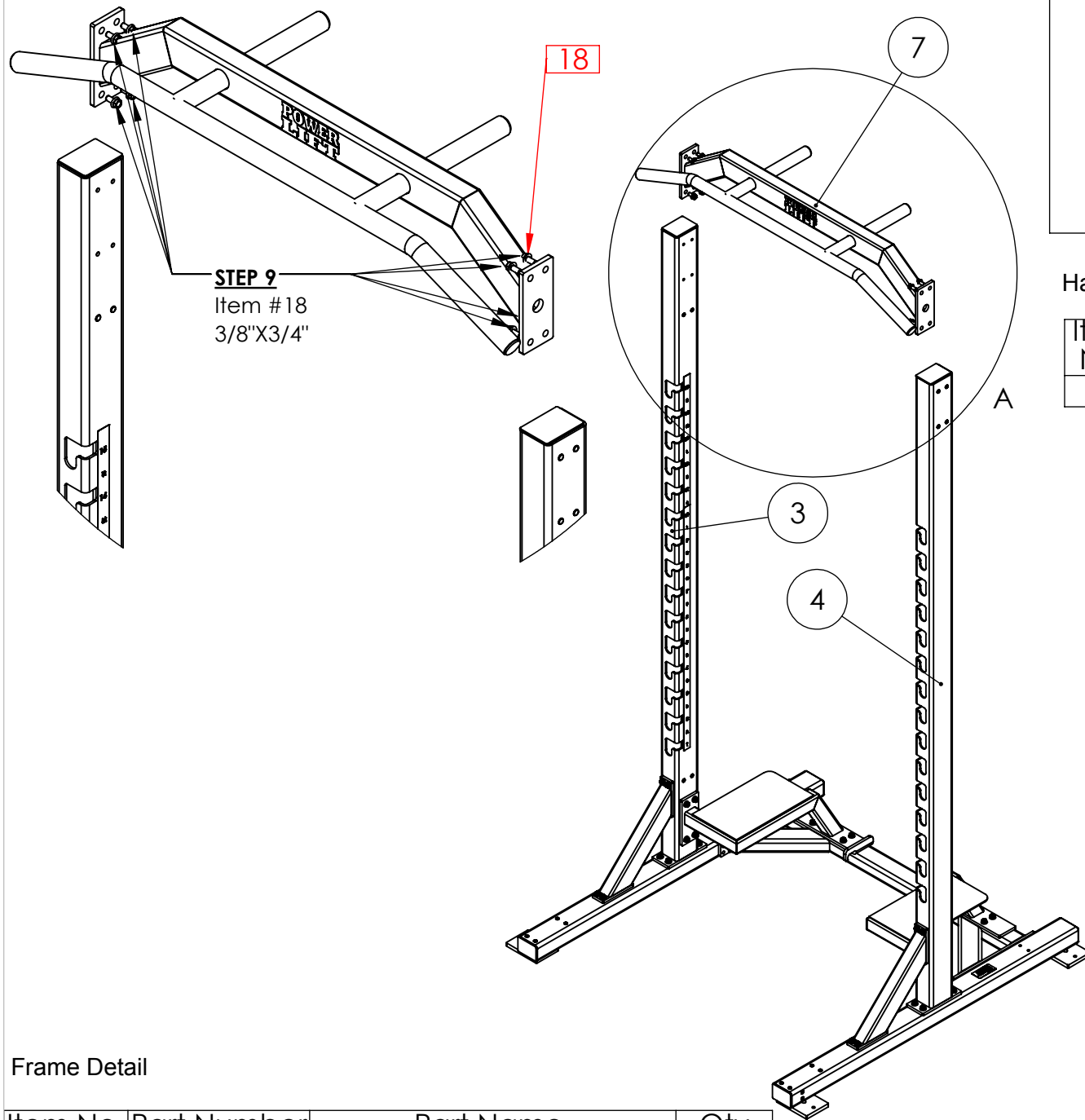
**12**

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## Instructions

9.) Assemble item 7 to items 3 and 4 using (8) 3/8"X3/4" flange bolts provided. (4' Ladder is very helpful with this part, along with second set of hands.)

**Note: When assembling unit DO NOT tighten any fasteners until specified.**

## Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	8

## Frame Detail

Item No.	Part Number	Part Name	Qty
3	17510A	LEFT REAR UPRIGHT	1
4	17512A	RIGHT REAR UPRIGHT	1
7	11595A	CHIN BAR	1

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**17032A\_page5**

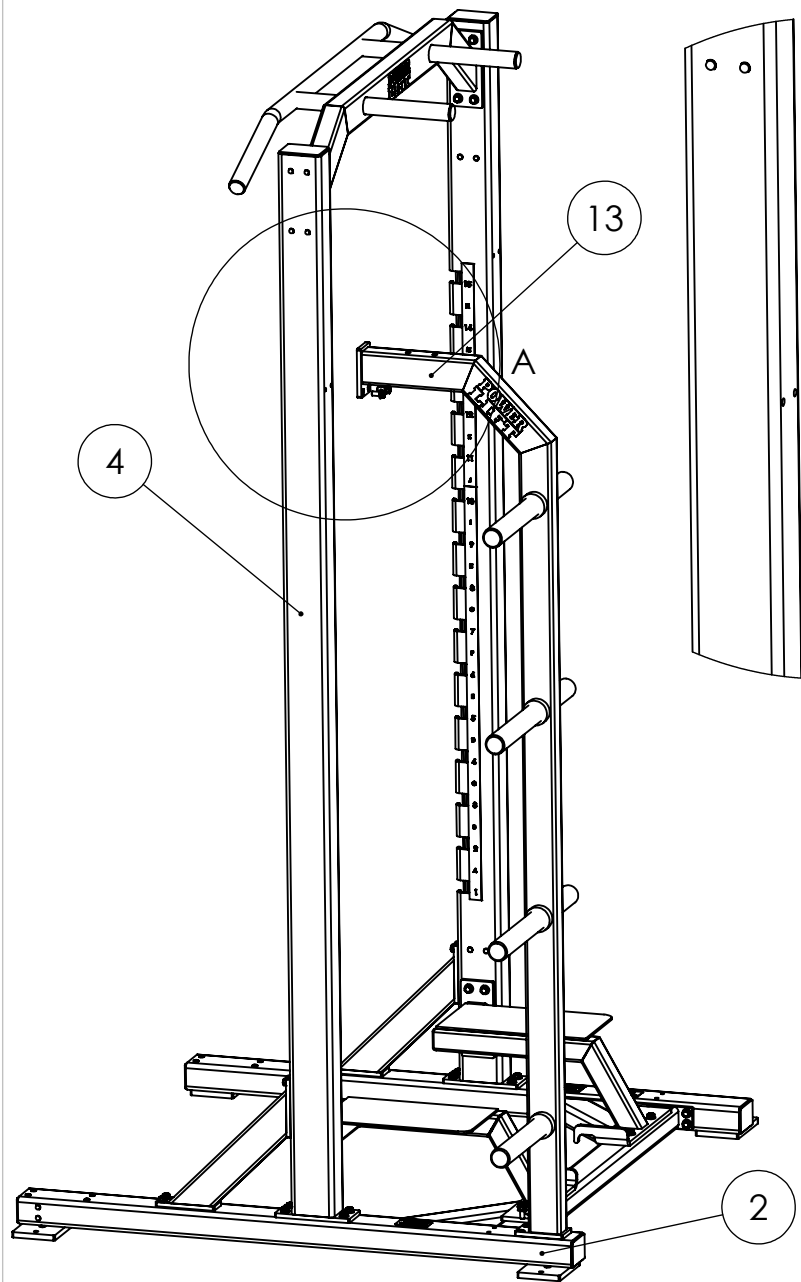
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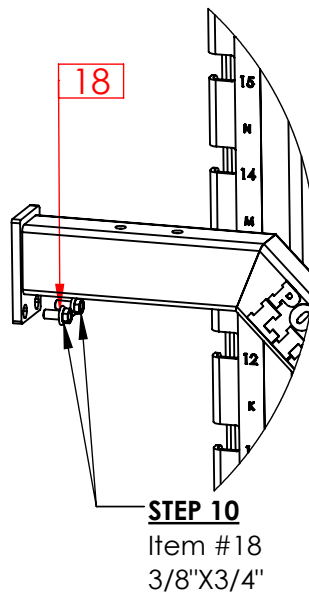
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Frame Detail

Item No.	Part Number	Part Name	Qty
2	15022	RIGHT BASE	1
4	17512A	RIGHT REAR UPRIGHT	1
13	11632A	RIGHT WEIGHT STORAGE	1



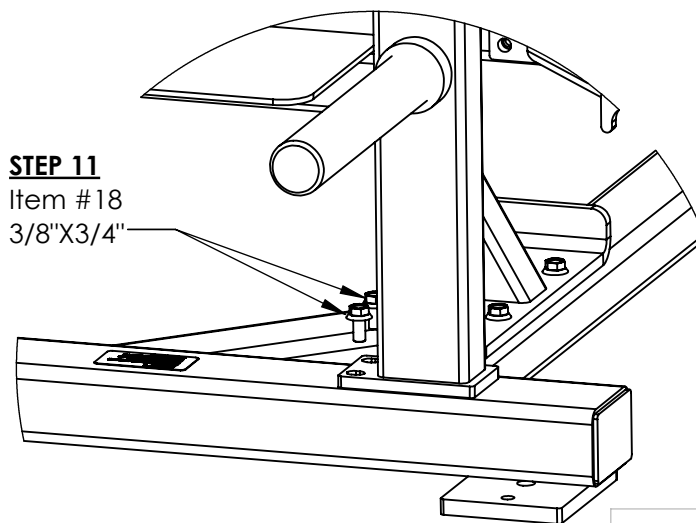
**Instructions**  
10.) Assemble item 13 to item 4 using (2) 3/8"X3/4" flange bolts provided.

11.) Then assemble item 13 to item 2 using (2) 3/8"X3/4" flange bolts provided.

**Note: When assembling unit DO NOT tighten any fasteners until specified.**

Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	4



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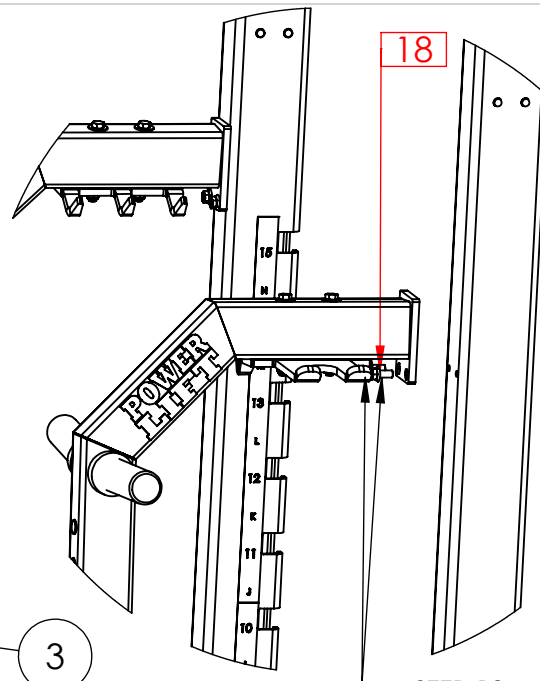
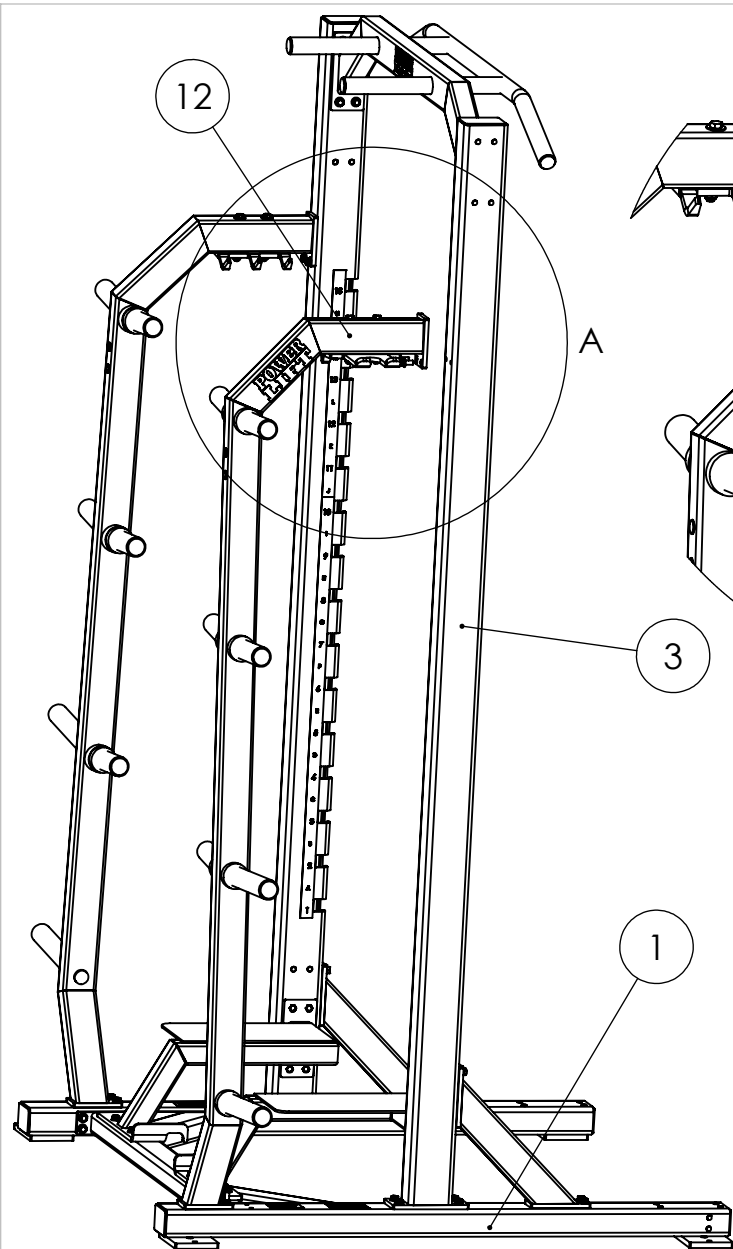
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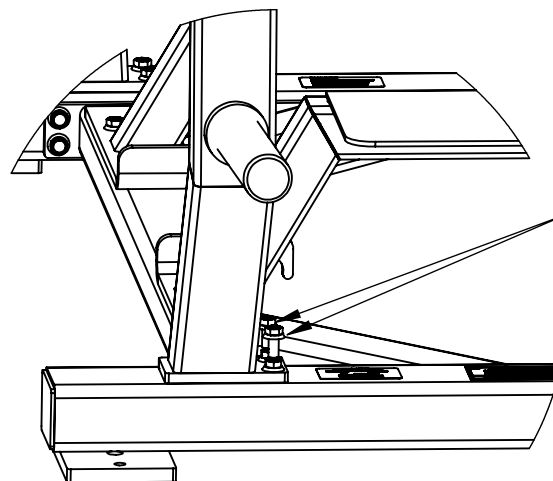
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**STEP 12**  
Item #18  
3/8"X3/4"



**STEP 13**  
Item #18  
3/8"X3/4"

## Instructions

12.) Assemble item 12 to item 3 using (2) 3/8"X3/4" flange bolts provided.

13.) Then assemble item 12 to item 1 using (2) 3/8"X3/4" flange bolts provided.

14.) Once all components have been bolted together, you can now tighten all bolts from the bottom to the top.

## Hardware Detail

Item No.	Part Number	Part Name	Qty
18	99004	3/8"X3/4" FLANGE BOLT	4

## Frame Detail

Item No.	Part Number	Part Name	Qty
1	15024	LEFT BASE	1
3	17510A	LEFT REAR UPRIGHT	1
12	11631A	LEFT WEIGHT STORAGE	1

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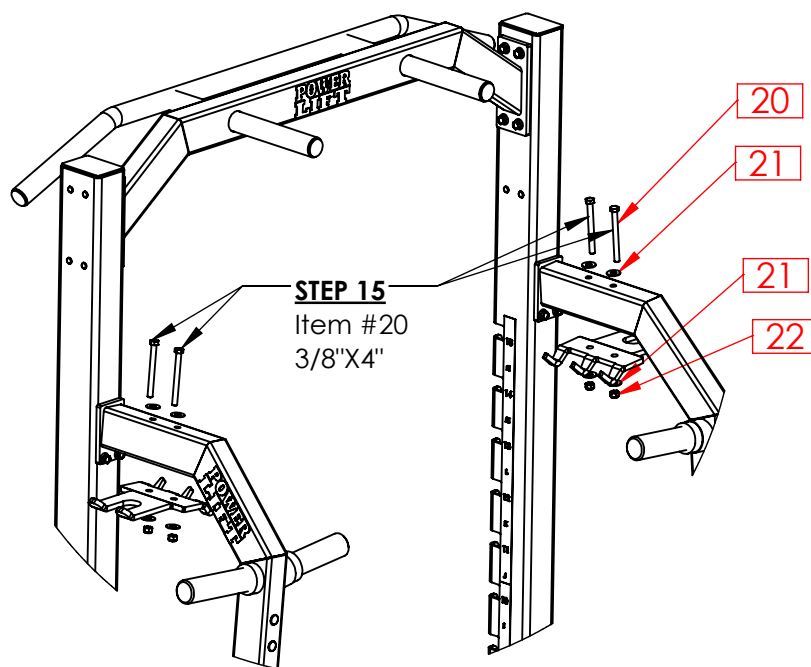
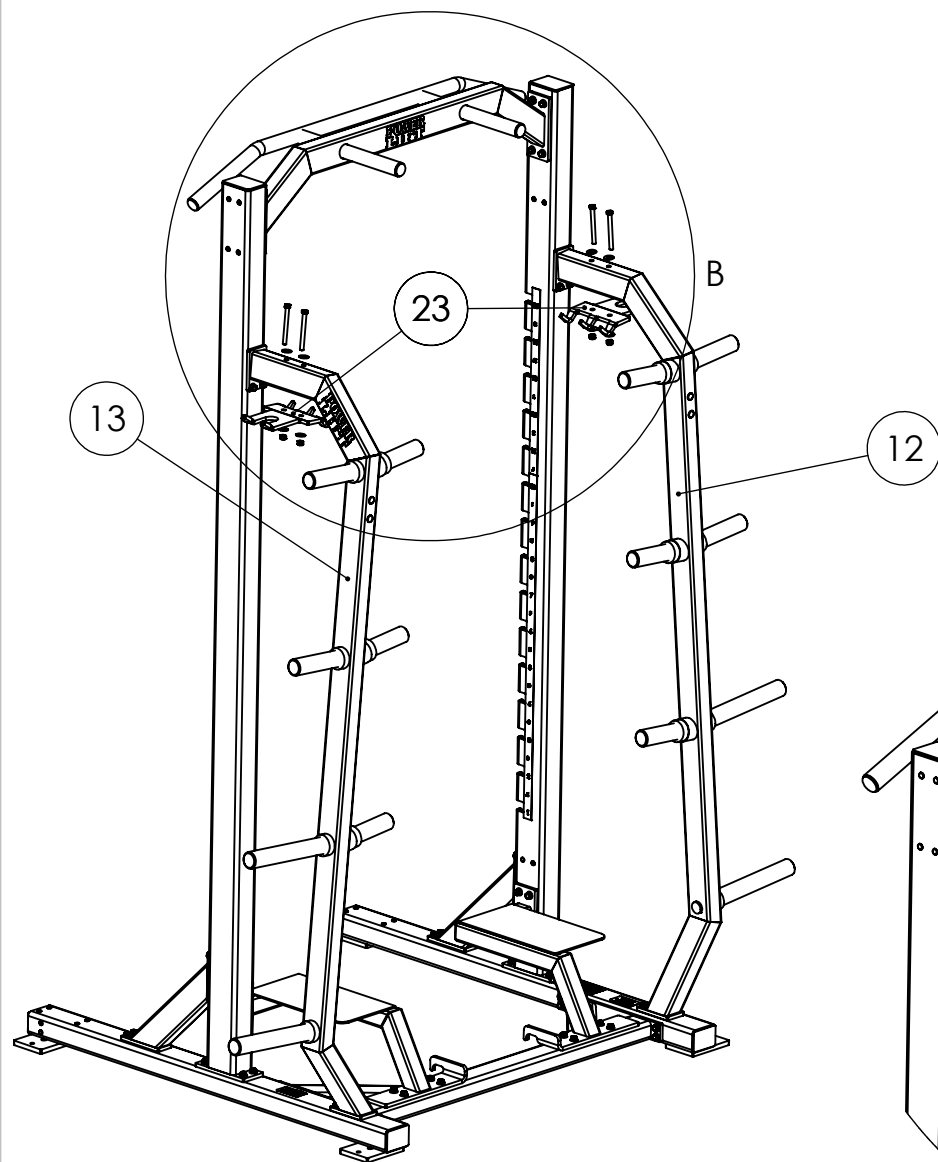
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## Instructions

15.) Assemble item 23 to item 12 and 13 using (4) 3/8"X4" bolts provided. ( Make sure that the 3 hooks on item 23 face inside.)

## Hardware Detail

Item No.	Part Number	Part Name	Qty
20	99549	3/8"X4" BOLT	4
21	99531	3/8" FLATWASHER	8
22	99540	3/8" NUT	4



## Frame Detail

Item No.	Part Number	Part Name	Qty
12	11631A	LEFT WEIGHT STORAGE	1
13	11632A	RIGHT WIEGHT STORAGE	1
23	32192	BAR STORAGE BRACKET	2

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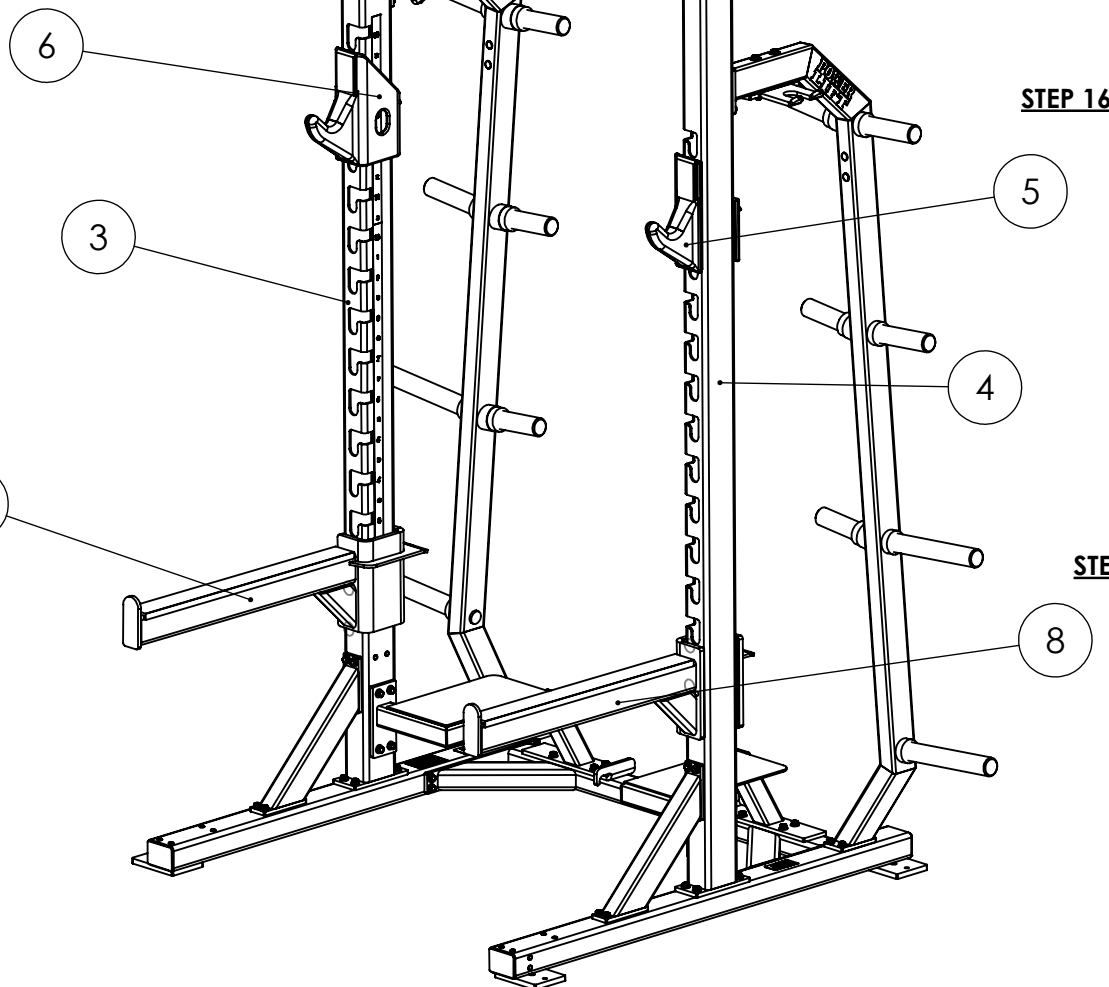
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# Instructions

16.) Attach item 5 onto 4 and attach item 6 onto 3.

17.) Attach item 8 onto 4 and attach item 9 onto 3.

## STEP 16



## STEP 16

## STEP 17

## STEP 17

## Frame Detail

Item No.	Part Number	Part Name	Qty
3	17510A	LEFT REAR UPRIGHT	1
4	17512A	RIGHT REAR UPRIGHT	1
5	11527A	RIGHT BAR CATCH	1
6	11528A	LEFT BAR CATCH	1
8	18000B	RIGHT SAFETY ARM	1
9	18001B	LEFT SAFETY ARM	1

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