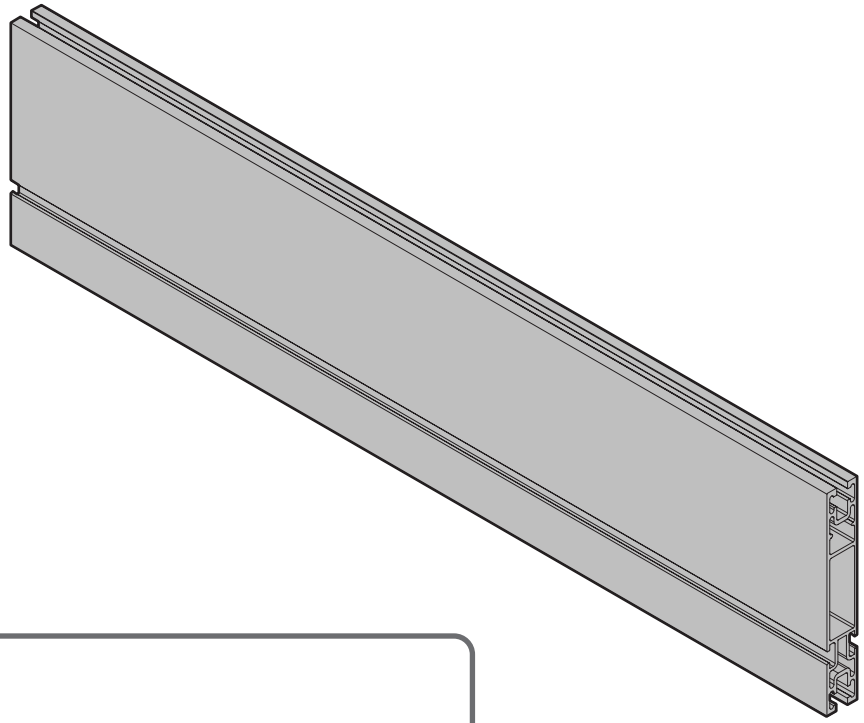
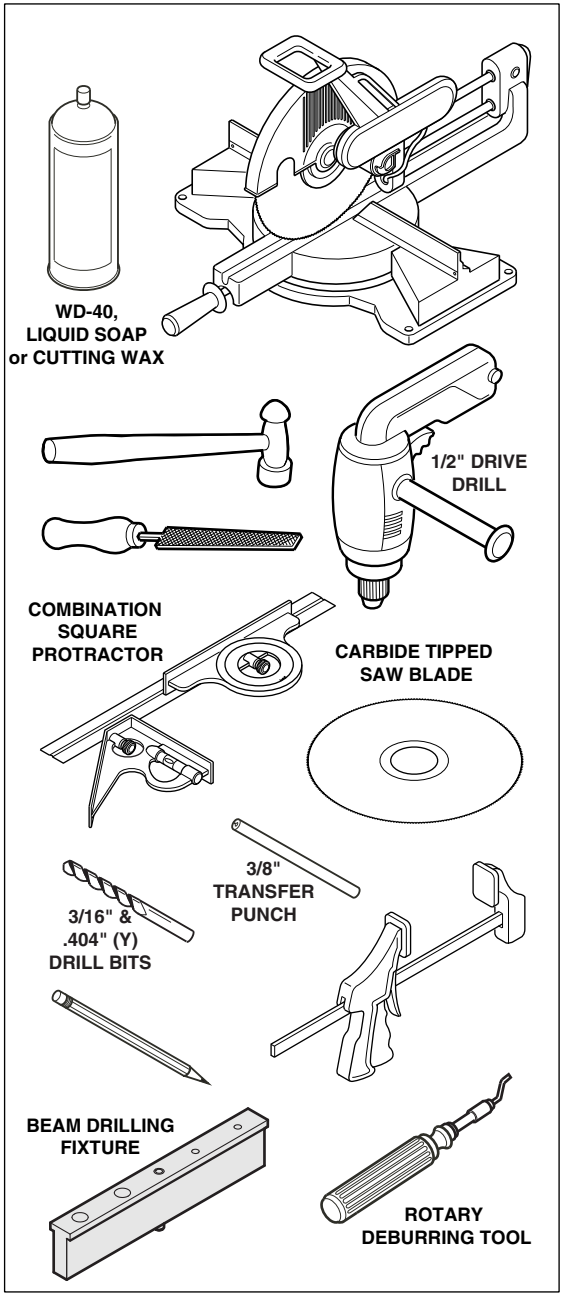
Beam and Fence - Field Cutting Procedure





Cut Tolerance

The beam cut length tolerance is +/- 1/32"
The beam cut angle tolerance is +/- 1/2 degree (30 minutes of a degree)
If cut doesn't fall within these tolerances, it should be rejected for use.

If you have a problem, question, or request, call your local dealer, or Steelcase Line 1 at **888.STEELCASE** (888.783.3522) for immediate action by people who want to help you.

(Outside the U.S.A., Canada, Mexico, Puerto Rico, and the U.S. Virgin Islands, call: 1.616.247.2500)
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Cut Beam to Length

NOTE: First cut a test piece using a 2" x 6" piece of wood to check for squareness of cut.

1. Inspect beam for damage to ends. Cut off damaged end, if present.

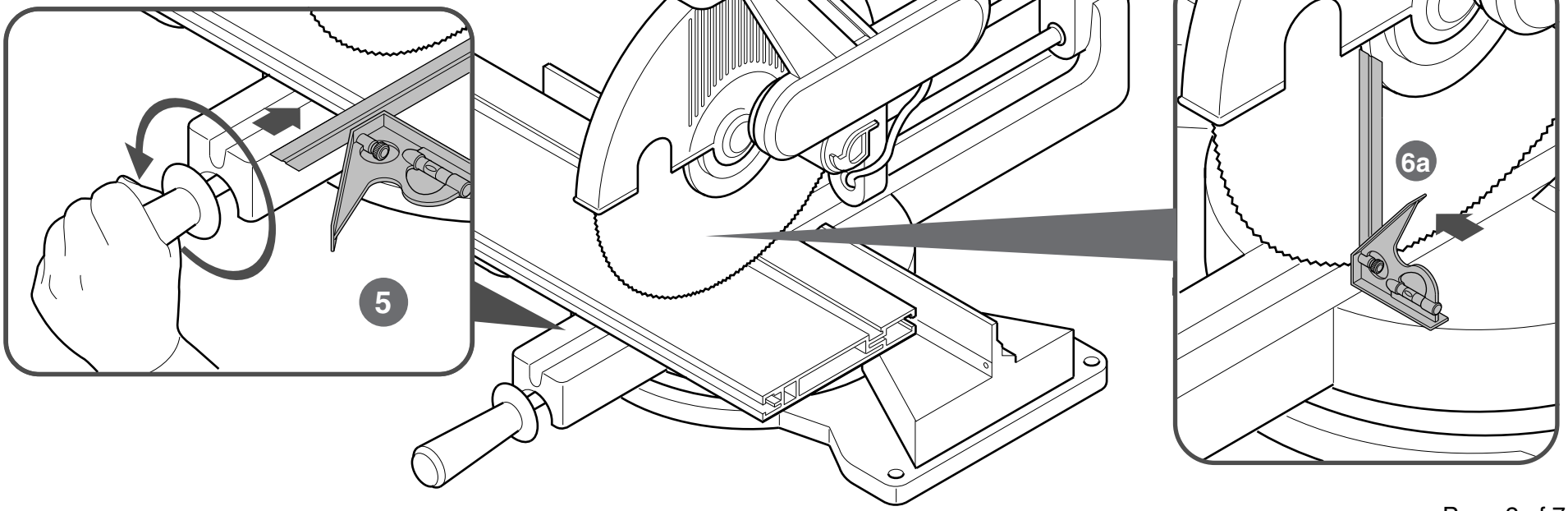
2. Measure and mark length of beam with a pencil. Proper beam length is 3.95 inches less than nominal center to center distance between posts.

3. Install aluminum-cutting blade in saw.

4. Install beam in saw and clamp down, making sure beam is snugly against saw fence.

5. Using the combination square, adjust carriage angle so that the blade is at 90 degrees to beam. Pre-set stops on carriage may not be accurate.

6. Using the combination square for indication, adjust blade angle such that it is 90 degrees to the surface of the beam. It is likely that the scale on the saw is inaccurate.



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Cut Beam to Length (continued)

7. Align blade edge with mark on the beam. Re-measure before cutting to make sure the saw kerf will fall on drop-off side of cut.

8. Support free ends to ensure beam is not deflected and that cut pieces do not fall or interfere with the cut.

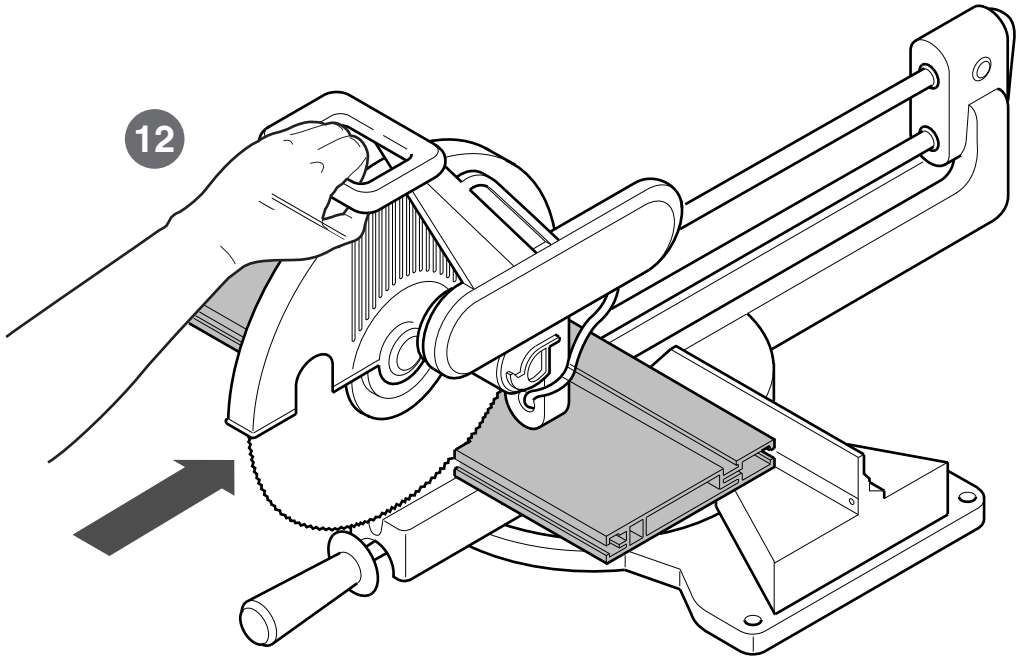
9. Clamp beam tightly to the saw bed and to fences and/or stops, making sure beam is snugly against stops and fence.

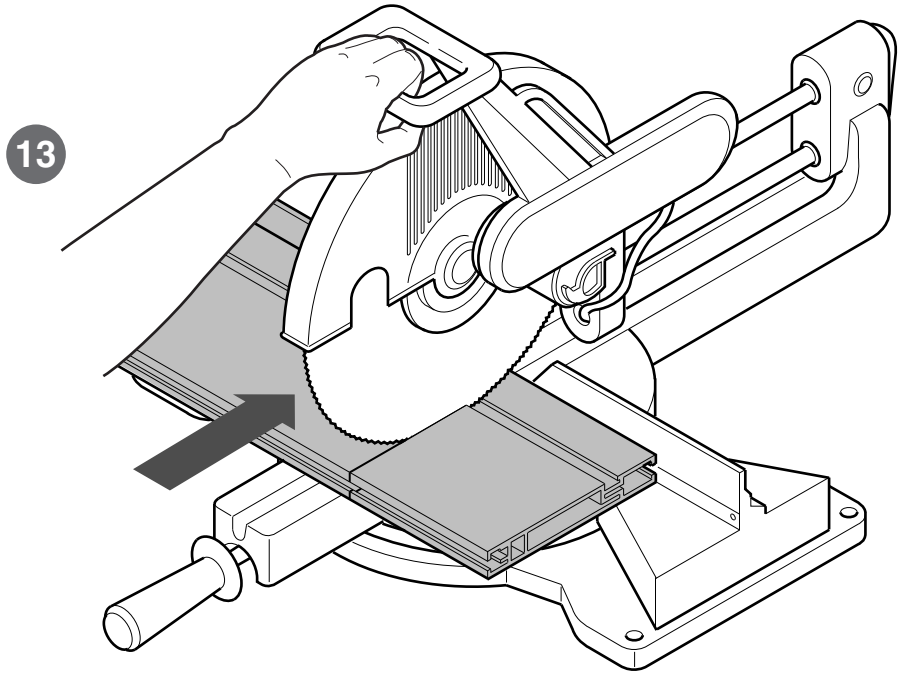
10. Spray beam with WD-40, liquid soap or cutting wax.

11. Turn on saw.

12. Pull blade to full extension and bring down through the nearest edge of beam. To maintain angle tolerance and beam end finish, **USE SEVERAL PARTIAL-DEPTH PASSES TO CUT THROUGH THE BEAM.** One full-depth pass will result in poor cut quality and likely cause rejection of the part.

13. Move saw blade slowly back through the beam with gentle pressure. Let the blade do the work.





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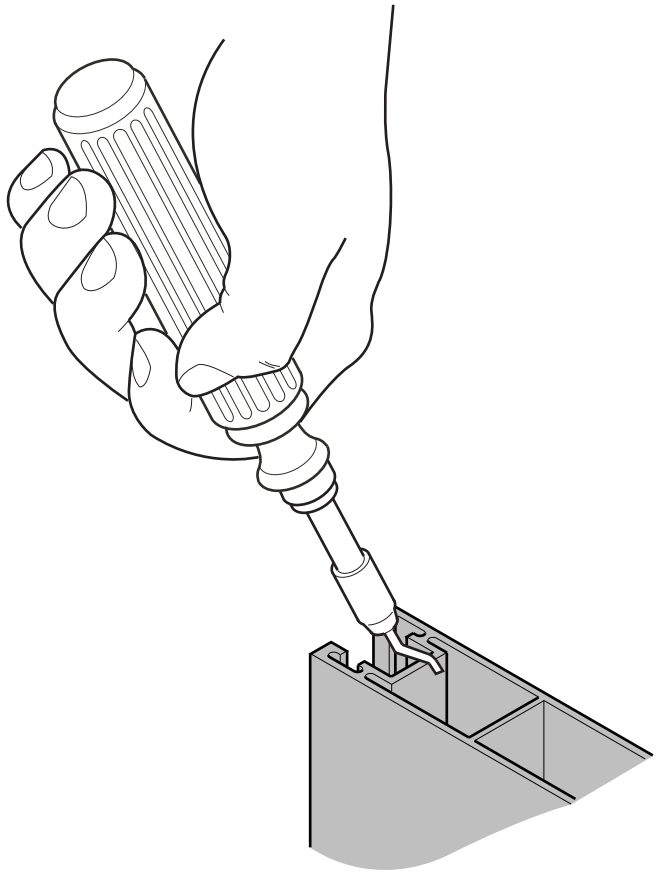
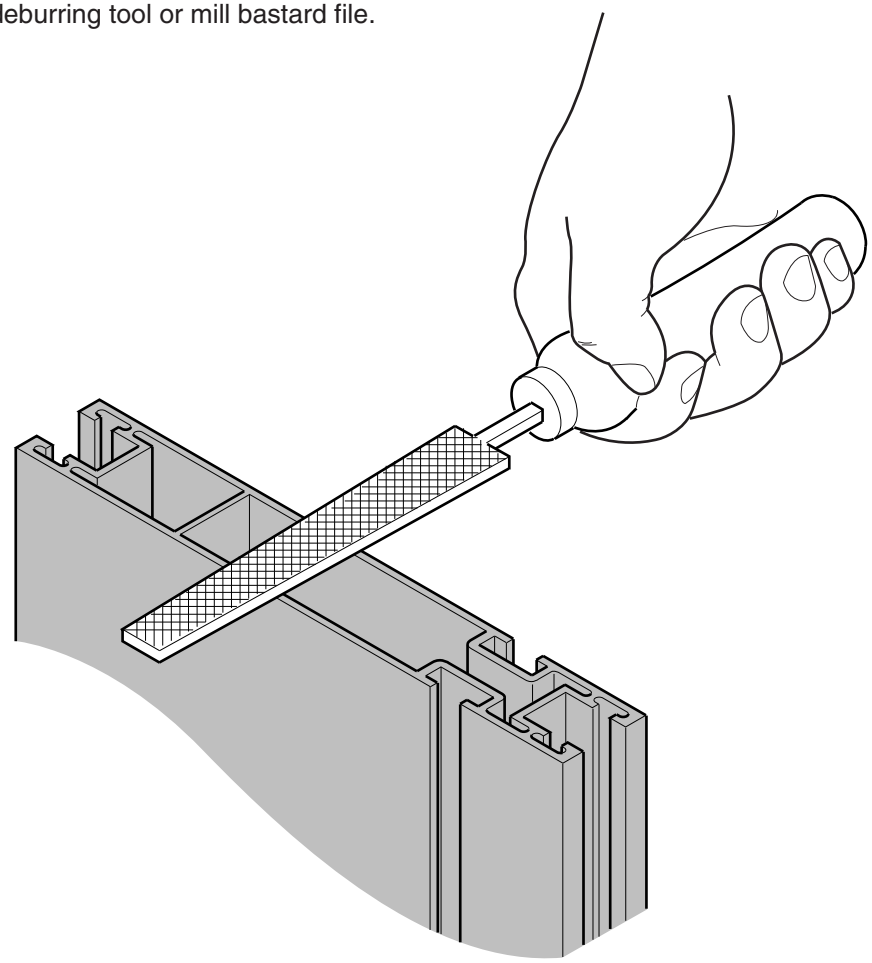
Cut Beam to Length (continued)

14. Remove chips from inside of end beam.



15. Deburr exposed edges of the beam with deburring tool or mill bastard file.



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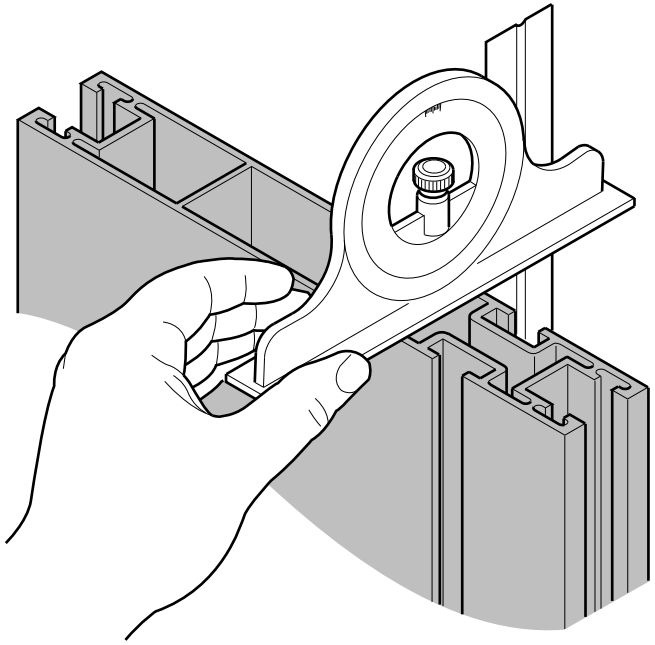
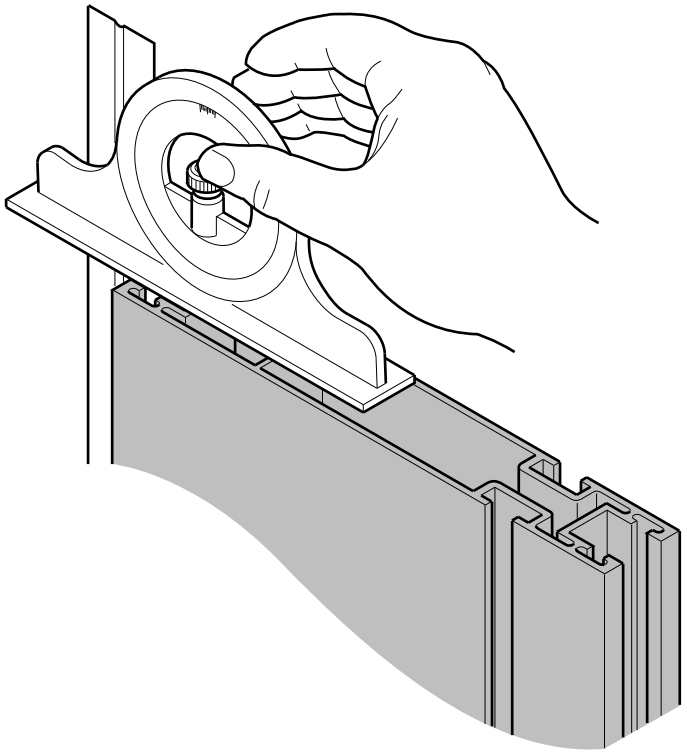
Cut Beam to Length (continued)

16. Measure beam length to determine whether it falls within length tolerances.



17. Inspect beam cut angle with bevel protractor-inspect both axes of cut angle.



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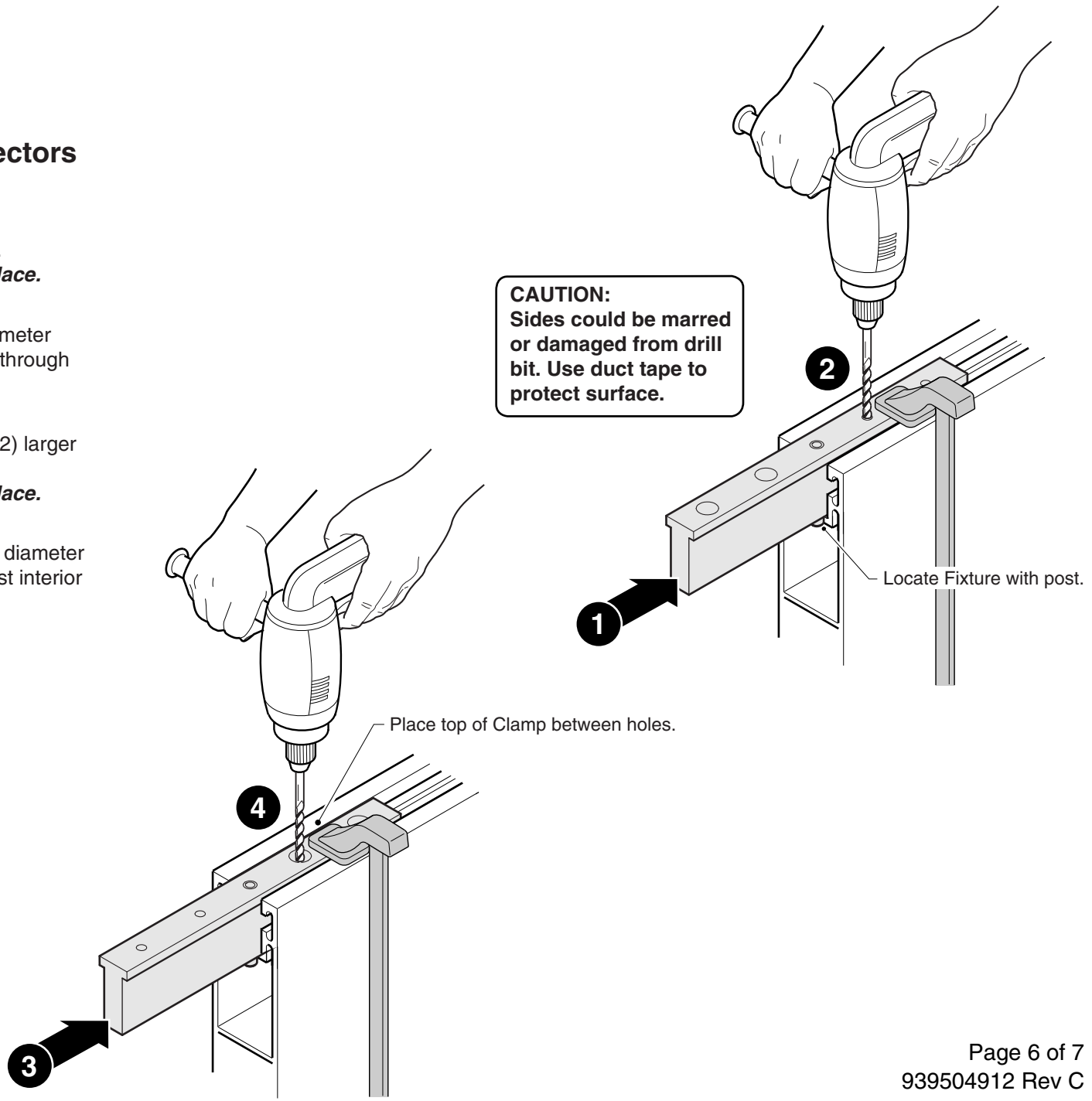
Drill Beam to Receive Connectors

1. Insert drilling fixture into end of beam with the (2) smaller holes above the beam.
NOTE: Use clamp to secure fixture in place.

2. Using a 1/2" drive drill and a 3/16" diameter drill bit, drill (2) clearance holes into beam through first interior wall on near side.

3. Flip drilling fixture around so that the (2) larger holes are above the beam.
NOTE: Use clamp to secure fixture in place.

4. Using a 1/2" drive drill and a .404" (Y) diameter drill bit, drill (2) holes into beam through first interior wall on near side.



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Drill Beam to Receive Connectors (continued)

5. Flip beam over and repeat drilling procedure on opposite side of beam profile.

6. Remove chips from inside the end of the beam.

7. Deburr holes in channels that receive beam to post connectors to ensure proper fit of anchor blocks.