



NOTE: CIRCLED NUMBERS REPRESENT SEQUENCE OF BENDS

Layout Procedures

Using the plan above layout all bends, holes, and cuts as indicated using a sharpie, ruler and square.

Assembly Procedures

1. Cut sheet metal on solid lines to match pattern.
2. Punch holes at the 5 markings indicated on the plan.
3. Fold all dashed lines in ordered number as indicated below:
 - a. Folds 1-3 should use the large sheet metal brake to fold the following bends:
 - i. Fold 1=90 degree bend
 - ii. Fold 2=90 degree bend
 - iii. Fold 3=90 degree bend
 - b. Folds 4-7 should use the brake on the sheet metal machine to fold the following bends:
 - i. Folds 4 and 5 should be bent 90 degrees on the brake and then use the hand seamer and mallet to hem them.
 - ii. Folds 6 and 7 should use the brake to bend 90 degree angles.
4. Using a file (not a rasp), file off all rough edges and corners where sheet metal was cut and bent. Leave no sharp edges where someone could get cut.
5. Use alcohol to remove sharpie marks from the shelf.
6. If painting—wipe metal surfaces with vinegar to remove all oils, paint with primer, let dry then paint to desired color..