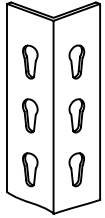


SPEEDI-BILT[®] ASSEMBLY INSTRUCTIONS

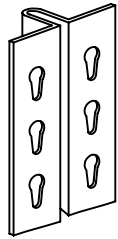
IMPORTANT

CHECK MATERIAL RECEIVED—NUMBER OF PACKAGES AND CONTENTS OF EACH PACKAGE. PLACE MATERIAL NEAR AREA TO BE INSTALLED. UNLESS REQUIRED FOR THE ASSEMBLY OF A SPECIFIC UNIT MODEL, ALL COMPONENTS MUST BE INSTALLED IN THE ORIENTATION AS SHOWN BELOW. READ ASSEMBLY INSTRUCTIONS COMPLETELY BEFORE STARTING.

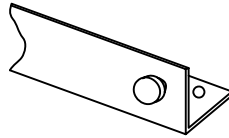
PART IDENTIFICATION



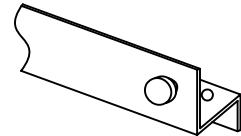
ANGLE POST
(HEAVY & SUPER DUTY)



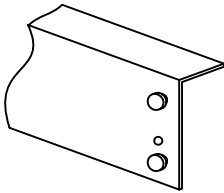
TEE POST



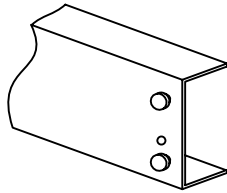
SINGLE RIVET BEAM



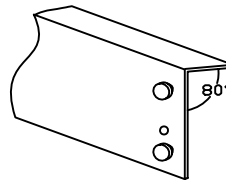
SINGLE RIVET BEAM
HEAVY DUTY



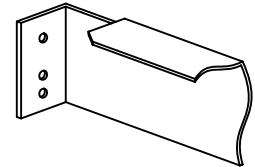
DOUBLE RIVET BEAM



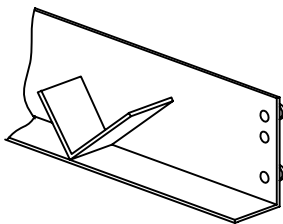
DOUBLE RIVET CHANNEL



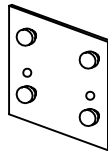
TIRE SUPPORT BEAM



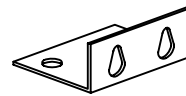
SUPPORT TIE (HOLES BOTH ENDS)
WALL TIE (RIVETS ONE END)
DOUBLE TIE (RIVETS BOTH ENDS)



REEL CRADLE
(SINGLE & DOUBLE)



TIE PLATE



UNIVERSAL
FOOT PLATE

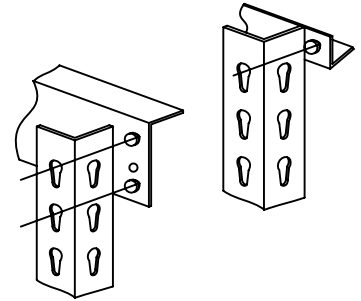
WARNING: Speedi-Bilt units are intended for use in hand-loaded applications only. Powered material handling equipment should never be used around Speedi-Bilt units without RGF approval.

SPEEDI-BILT[®]

BASIC CONNECTION DETAILS

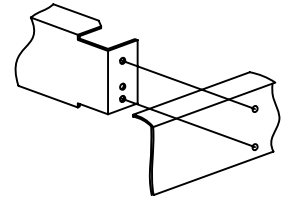
BEAM TO POST CONNECTION

1. Align rivets of beam with enlarged end of slots in the post.
2. Push rivet heads through post slots and downward to start rivet shoulder into narrow portion of post slots.
3. Using a rawhide or rubber mallet, tap top edge of beam until rivets are fully seated in slots. Beams must be oriented as shown on previous page.



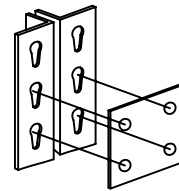
SUPPORT TIE TO DOUBLE RIVET BEAM OR CHANNEL BEAM

1. Align holes in end of support tie with holes in face of beam and attach each end with two (2) #10 x 1/2" bolts and nuts.



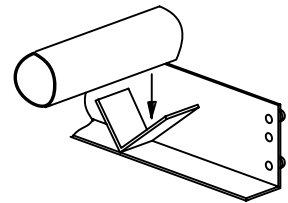
TIE PLATE TO POST

1. Align rivets in tie plate with slots in adjoining posts and assemble in the same manner as beam to post (Detail A).



REEL CRADLE AND REEL AXLE

1. Install reel cradle at the desired level in the same manner as beam to post (Detail A).
2. Load reel(s) onto reel axle.
3. Position both ends of the reel axle into the "V" shaped brackets in the reel cradles. If desired, drill a hole near each end of the reel axle thru the reel cradle and bolt the axle to the cradle to prevent movement.

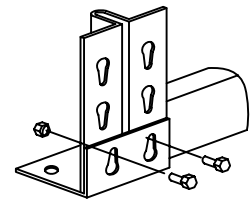


SPEEDI-BILT®

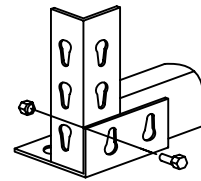
BASIC CONNECTION DETAILS (CONT'D.)

FOOT PLATE TO POST

1. Universal foot plates are used with single angle posts, double angle posts, or tee posts. Position foot plate under bottom of post(s) as shown with the enlarged portion of the keyhole slot clearing the rivet head in the bottom beam.
2. Attach foot plate to post(s) by inserting a #12 x 5/8" bolt thru smaller portion of keyhole slot in the foot plate and post and then thru the hole in the bottom beam. Install a #12 nut from the back side and tighten. Single angle posts require (1) bolt and nut. Double angle posts and tee posts require (2) bolts and nuts.
3. If required, bolt foot plate to floor with a suitable 1/2" diameter anchor (not normally included).



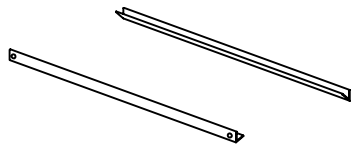
DOUBLE ANGLE
OR TEE
POST



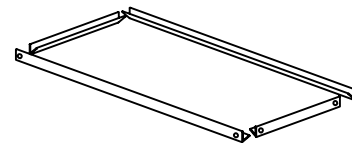
SINGLE ANGLE
POST

SHELF BEAM AND SHELF SUPPORT ARRANGEMENT

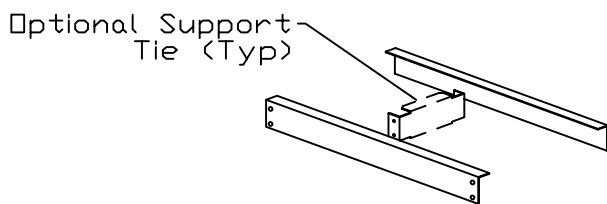
1. Beams (Single Rivet, Single Rivet Heavy Duty, "Z" , Double Rivet, Double Rivet Channel, and Double Rivet Channel Heavy Duty) and shelf supports (Support Tie and "Z" Beam Shelf Support) can be arranged in different quantities and locations to provide a wide range of shelf capacities. Make sure the proper beam/shelf support arrangement is installed to provide the desired shelf capacity.



Single Rivet Beam
Front & Rear
(Intermediate Shelf Only)

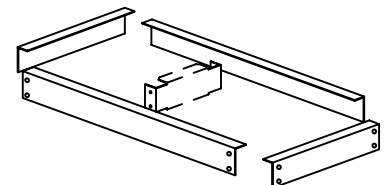


Single Rivet Beam
Four Sides
(Intermediate Shelf Only)



Optional Support
Tie (Typ)

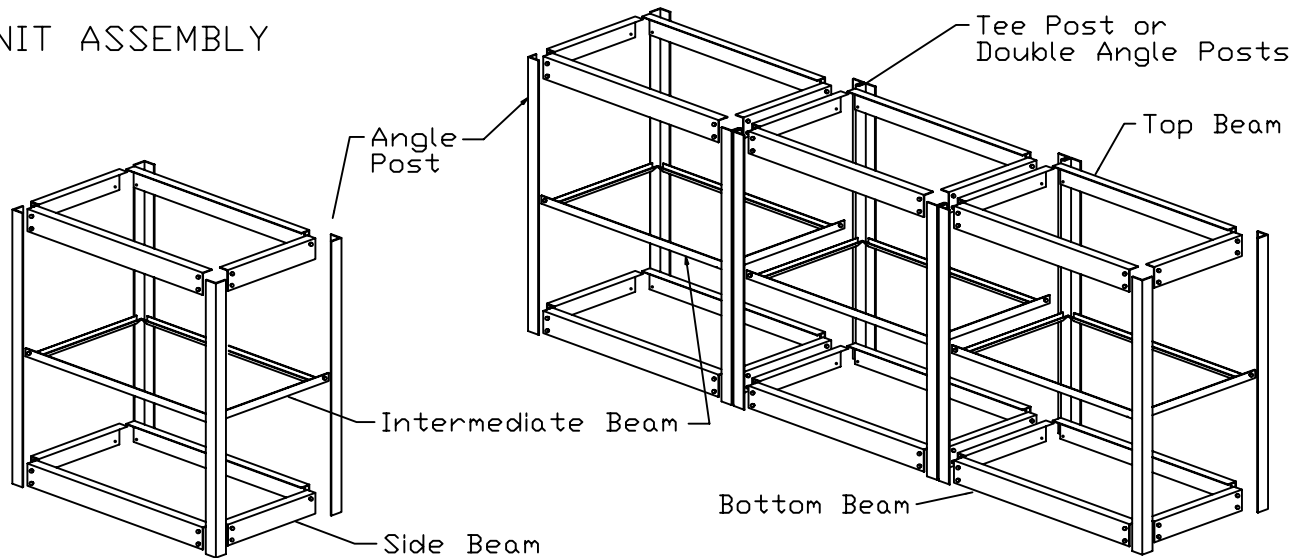
Double Rivet or Channel
Beam Front & Rear
(Intermediate Shelf Only)



Double Rivet or Channel
Beam Four Sides

SPEEDI-BILT®

UNIT ASSEMBLY



INDIVIDUAL UNIT

MULTIPLE UNITS IN A ROW

Individual Units require Angle Posts on all four corners. Multiple Units in a row require Angle Posts at the row ends and either Double Angle Posts connected with Tie Plates or Tee Posts at the intermediate upright locations. Beam type, and location as well as Support Tie/Shelf Support quantity and location varies to suit loading requirements. Make sure the proper beam type and arrangement as well as the proper Support Tie/Shelf Support quantity and arrangement are installed to provide the desired shelf load carrying capacity.

1. Construct a row end upright by laying two Angle Posts on the floor with the keyhole slots pointing in the same direction. Install the appropriate beam (with two rivets) at the top and bottom of both posts. Make sure beams are oriented properly and are fully seated (see Basic Connection Details).
2. For Individual Units, repeat Step #1 to construct a second row end upright. For Multiple Units in a row, repeat Step #1 using either double Angle Posts (connected by Tie Plates) or Tee Posts to construct an intermediate upright. If intermediate shelves have front and rear beams only, the double rivet side beams are required on one side of the intermediate upright only.
3. Lay the two uprights on edge and install the proper front beam at top and bottom of both posts. Turn unit over and repeat for the other side.
4. Stand the unit upright. For multiple units in a row, construct additional intermediate uprights as defined in Step #2 until all intermediate uprights are completed. Stand uprights vertically and install the proper front and rear beams at top and bottom of both uprights until all intermediate units are complete. Repeat Step #1 to construct a row end upright to finish the row of shelving and install front and rear beams at top and bottom of both uprights.
5. Install the appropriate intermediate beams at all required locations. Make sure beams are oriented properly and fully seated (see Basic Connection Details).
6. Install all Support Ties or Shelf Supports, if required. (see Basic Connection Details).
7. If required, install all foot plates and other accessories (i.e. hang bars, reel cradles, etc.). See Basic Connection Details for assembly instructions.
8. Install all shelf surfaces (not normally furnished by RGF MFG) such as 5/8" thick particle board which can be obtained from a local lumber source. The size of the shelf surface should equal the nominal unit size in width and depth.