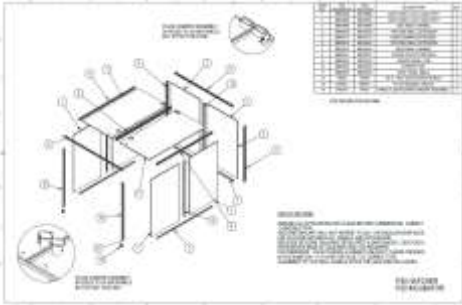


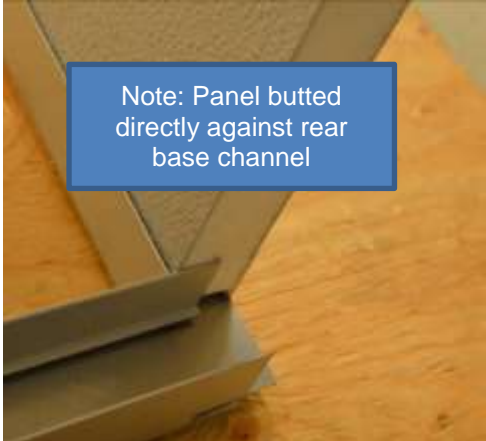



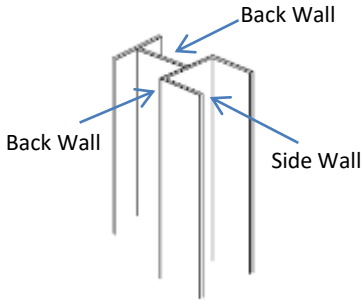

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
OP100016 Step 1	<p>Start Wall Panel assembly on the center machine in a bank.</p> <p>This way, any deviations from level and plumb in the base channel and wall panels will only be amplified over half the length of the bank.</p> <p>Note: Do not start the wall panel assembly on a machine unless you can finish all the walls of that cabinet the same day. Ideally you will finish the entire bank the same day.</p> <p>Note: The room, all materials and the silicone must be at a minimum of 65°F (18.3°C) to begin. DO NOT begin wall assembly until the area and all materials have had at least 24 hours to reach this temperature.</p>		Throughout: Safety Shoes Safety Glasses Hearing protection as required Additional equipment as required by the site
OP100016 Step 2 	<p>Refer to the assembly drawing for the specific machine type you are building.</p> <p>Check the dimensions of all panels and extrusions before beginning. Consult the Platinum Critical Dimensions file.</p>	Measuring tape	



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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 3</p>   <p>Note: Panel butted directly against rear base channel</p>	<p>Start with the rear side wall of one machine.</p> <p>Silicone the inside of the base channel.</p> <p>Lay the rear side wall panel in the base channel.</p> <p>Refer to JIC-CS-F-0xxx Silicone Application Procedure for additional details on the application of the silicone.</p> <p>Note: Ensure the panel is tucked directly into the corner on the side base channel, butted against the rear base channel.</p> <div data-bbox="587 981 1050 1615" style="background-color: #e0e0e0; padding: 10px;"> <p>USE OF SILICONE</p>  <p>Silicone is applied to both inside sides of the base channel or extrusion.</p> <p>Ensure that the base channels and extrusions are clean before commencing cabinet construction. Silicone sealant will not adhere to oily or unclean surfaces.</p> <p>Use silicone between all panels and extrusions or channels.</p> <p>Because the silicone caulking develops a skin very quickly, give each extrusion a bead of caulking only as required.</p> <p>Furthermore, do not begin a cabinet unless it can be finished in the same day. It is very difficult to correct the alignment of the wall panels and extrusions after the silicone has cured.</p> </div>	<p>Caulking gun Rubber mallet</p>	



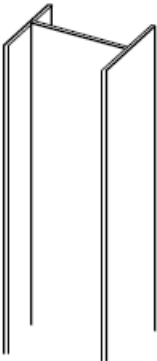

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 4</p> 	<p>Silicone the side wall channel of the rear corner extrusion and slide it in place against the panel already inserted.</p> <p>Start at the bottom, ensuring it is tight to the first panel, and then angle it up to meet the rest of the panel.</p> 	<p>Caulking gun Rubber mallet</p>	
<p>OP100016 Step 5</p> 	<p>Silicone the back wall channel on the vertical rear corner extrusion and the base channel and add the back wall panel to make the corner.</p>	<p>Caulking gun Rubber mallet</p>	





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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 6</p> 	<p>Use a rubber mallet to ensure the panels are both seated fully into the base channel.</p> <p>The extrusion should be approximately 1-1/8" shorter than the panels.</p> <p>The tops of the panels should be flush and level to each other. If this is not the case, the panels should be removed and the base channel re-checked for level and the panels re-checked for size.</p>	<p>Rubber mallet</p>	
<p>OP100016 Step 7</p> 	<p>Use a 4-foot level to ensure the cabinet corner is plumb on all surfaces.</p> <p>Use a rubber mallet where necessary to adjust the position of the panels.</p>	<p>4-foot level Rubber mallet</p>	



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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
OP100016 Step 8 	Use 2 - P6200 screws to stabilize the panels to the extrusion, one in each side of the corner extrusion at the top.	Drill #2 Phillips driver bit	
OP100016 Step 9 	Silicone and then insert an H extrusion (PB5611) on the opposite side of the panel at the back wall. 	Caulking gun Rubber mallet	
OP100016 Step 10 	Place a bead of silicone on both sides of the H channel and base channel, then insert the next panel.	Caulking gun Rubber mallet	


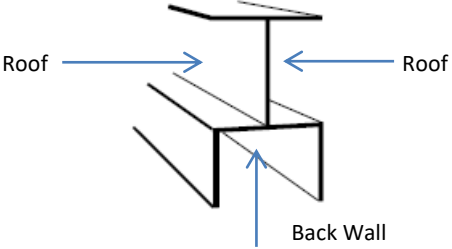

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 11</p>  	<p>Continue inserting panels and extrusions with silicone until the rear wall has been completed. Make the next corner using the corner extrusion and side wall panel. Screw the corner extrusion in place to the panels after it has been confirmed to be plumb, using P6200 screws, at the top.</p> <p>Ensure the panels and extrusions are properly and fully seated.</p> <p>All extrusions should be approximately 1-1/8" shorter than the panels.</p> <p>All panels should be flush across the top.</p>	<p>Caulking gun Rubber mallet Drill #2 Phillips driver bit 4-foot Level</p>	
<p>OP100016 Step 12</p>  	<p>Fit the rear top wall extrusion on, without silicone.</p> <p>You should just be able to see the beveled edge at both corners.</p> <p>Make any adjustments necessary, while ensuring the walls remain plumb.</p> <p>Note: You may need to remove the screws placed in the corner extrusions to adjust.</p>	<p>4-foot level</p>	

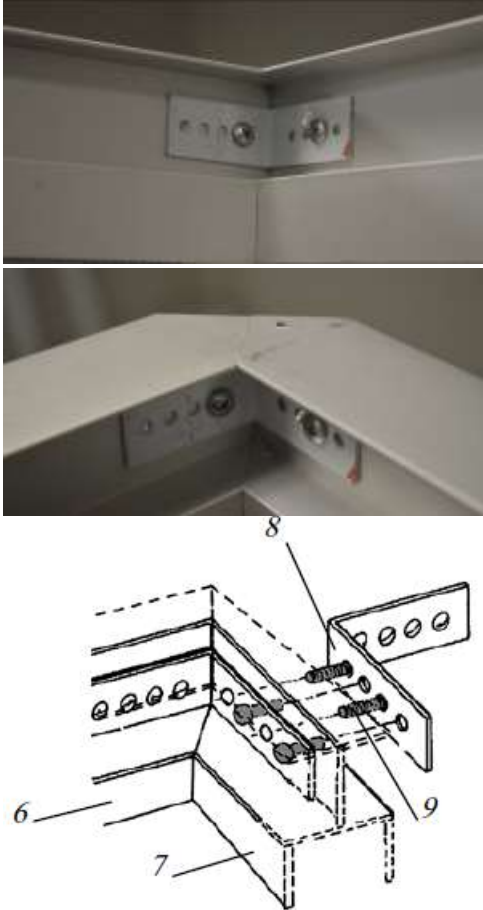

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 13</p> 	<p>Continue with the side walls in the same manner.</p> <p>Be sure to check for plumb and level panels throughout and to ensure the panels are flush to each other across the top. If they are not flush, you may need to re-inspect the base channel for level or re-check the dimensions on the panels.</p> <p>Tap the side wall panels at the front to ensure they are properly seated into the H extrusion and are level.</p>	<p>Caulking gun Rubber mallet 4-foot Level</p>	
<p>OP100016 Step 14</p> 	<p>Test fit the side top wall extrusions without applying silicone.</p> <p>The side top wall extrusion and rear top wall extrusions should meet tightly, producing a 90° angle.</p> <p>The panel edge and the side top wall extrusion should meet evenly, with neither protruding past the other.</p> <p>The panel will extend beyond the limits of the side base channel by 1-1/8" maximum.</p> <p>Test all the top wall extrusions on a bank at the same time to ensure they meet cleanly.</p>		



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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
OP100016 Step 15 	Continue installing panels and extrusions throughout the bank. Once the panels are all installed, check plumb and level throughout.	4-foot level	
OP100016 Step 16 	Remove the rear top wall extrusion. Apply silicone to inside the back wall channel, and install on top of the wall.	Caulking gun	
OP100016 Step 17 	Apply silicone to the wall channel of the side top wall extrusion and install. They should meet the rear extrusion cleanly. Tap in with a rubber mallet if necessary. Check that the top wall extrusion is level. Check that the panel is plumb. The side wall panel cannot extend past the end of the side top wall extrusion. Tap it in using a rubber mallet.	Caulking gun Rubber mallet 4-foot level	
OP100016 Step 18	Test fit the corner post, and ensure it is plumb. If it is OK, remove and store until required.		

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100016 Step 19</p> 	<p>Secure the top wall extrusions together at the rear corners with MB16208 corner brackets and 4 x P6200 screws.</p> <p>Note: If the machine is a SAO, be certain to use the opposite holes on the MB16208 corner angle from on the other side of the extrusion.</p> <p>Note: the corner bracket should be centered vertically on the extrusion. You may use two base channel corner brackets stacked on top of each other to hold the bracket while you attach it.</p>	<p>Drill #2 Phillips driver bit</p>	
<p>OP100016 Step 20</p> 	<p>Check the overall cabinet to ensure it is square, plumb and level.</p>	<p>4-foot level</p>	

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
OP100016 Step 21 	Continue building the rest of the machines across the bank.		
OP100016 Step 22 	Once the bank is complete, check that the entire bank is square, plumb and level. It is recommended to stabilize the bank by supporting at side and rear walls temporarily overnight while the silicone dries if necessary.	4-foot level	
OP100016 Step 23	Wait at least overnight for the silicone to cure before proceeding to install the roof panels. Note: The room must remain above 65°F (18.3°C) for the duration of the curing process overnight.		