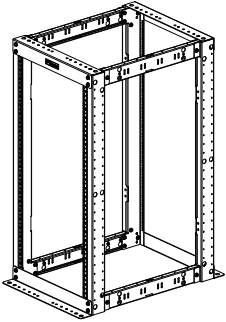


INSTRUCTIONS CM569B

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IAR4P48CN

The IAR4P48CN Industrial Automation Rack includes the following components:

- (2) Right-Hand Cage Nut Rails
- (2) Left-Hand Cage Nut Rails
- (4) Vertical Post Assemblies
- (4) Front-to-Back Beam Assemblies
- (4) Cross Members
- (25) #12-24 Cage Nuts
- (56) 5/16-18 X 1/2" Serrated Bolts
- (25) #12-24 X 1/2" Screws

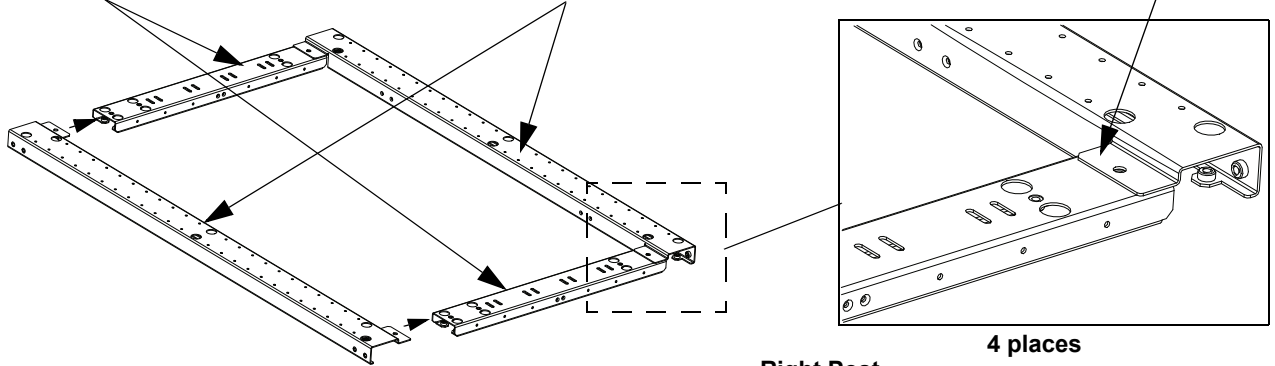
Step 1

Align (2) Vertical Post Assemblies with (2) Front-to-Back Beam Assemblies as shown. Be sure that the flanges from the Vertical Post Assemblies lie on top of the Front-to-Back Beam Assemblies in 4 places.

Front-to-Back Beam Assemblies

Vertical Post Assembly

Flange



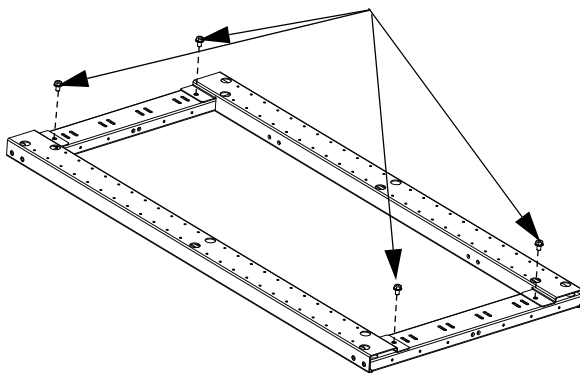
Right Post

4 places

Step 2

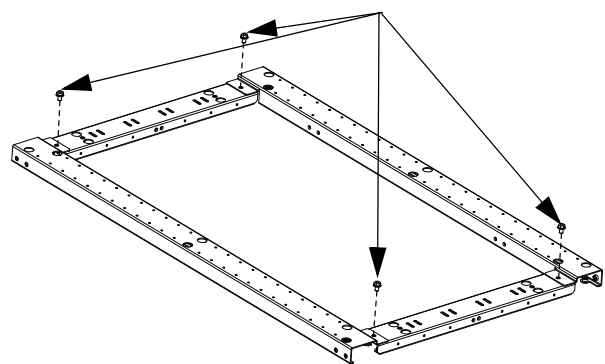
Secure components using (4) 5/16-18 X 1/2" Serrated Bolts, (2) on each Front-to-Back Beam Assembly. The IAR4PCN may be configured to 23" or 29" deep. Choosing which configuration shown below to assemble at this step will dictate which depth the finished IAR4PCN will be. **Do not torque down bolts until Step 10 of this instruction document.**

5/16-18 X 1/2" Serrated Bolts



23 inch deep configuration

5/16-18 X 1/2" Serrated Bolts

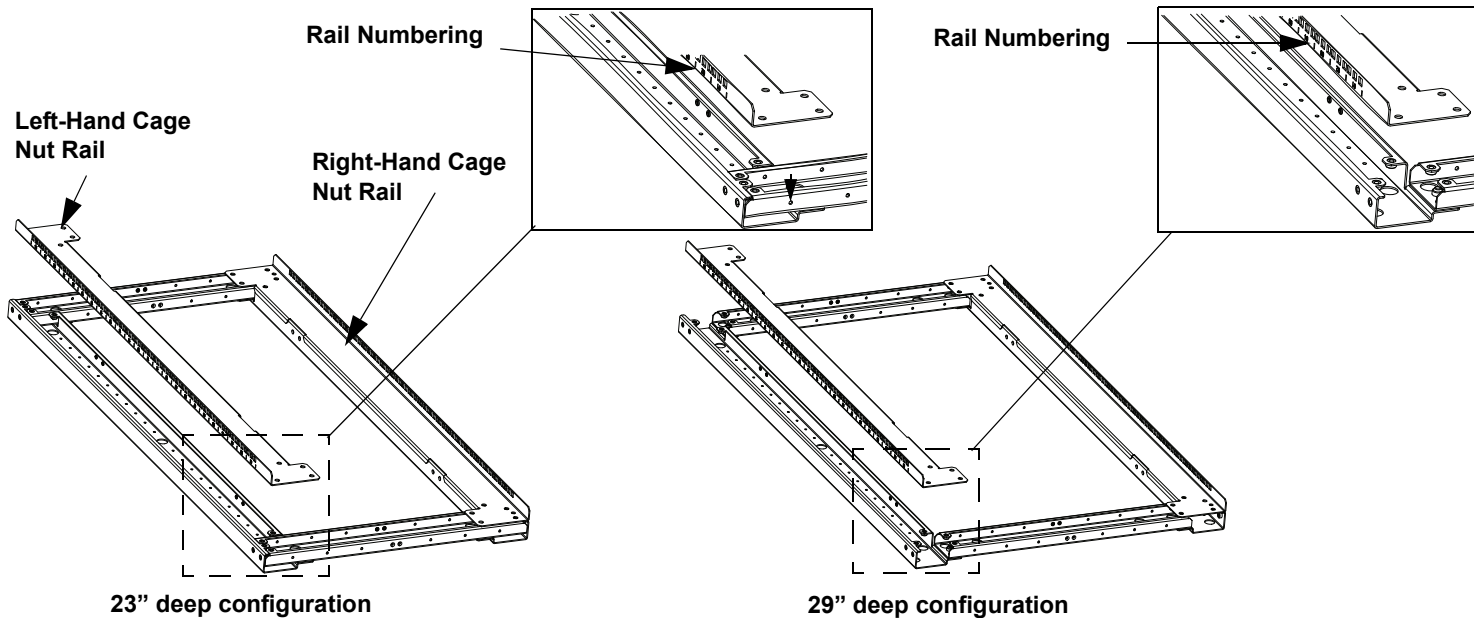


29 inch deep configuration

Step 3-Attaching Cage Nut Rails

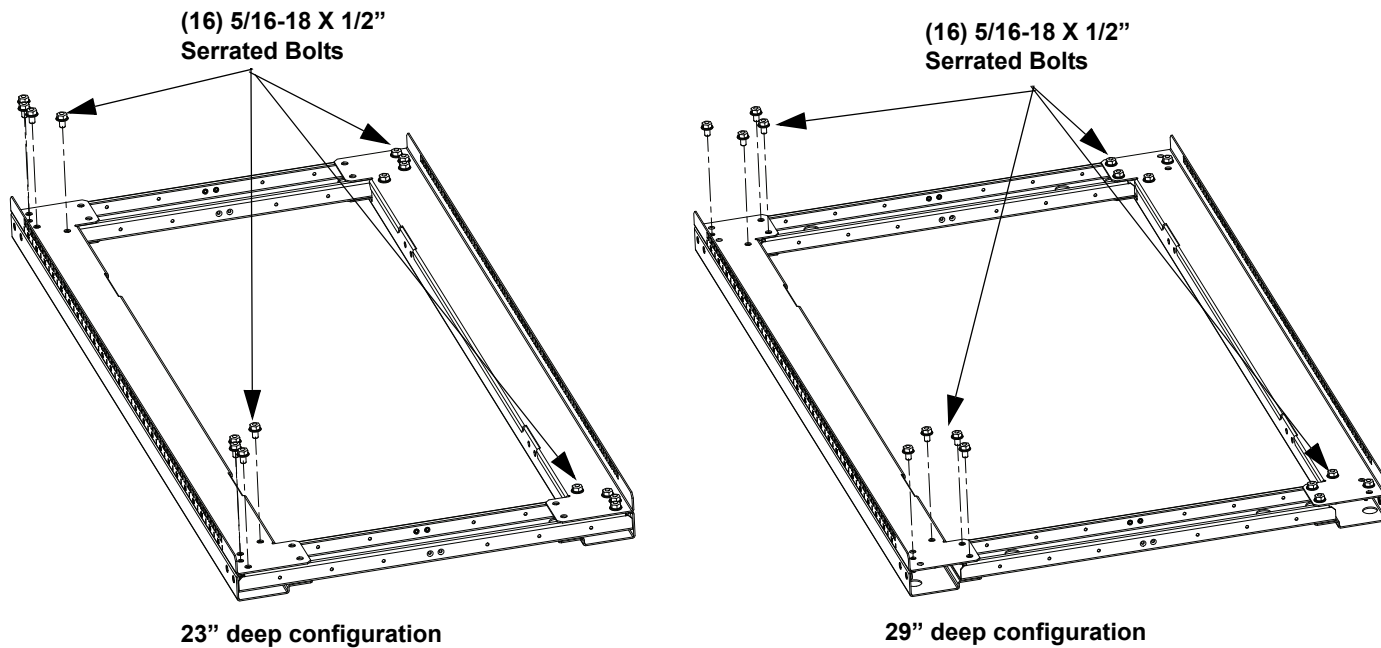
Turn assembly over. Place (1) Left-Hand Cage Nut Rail and (1) Right-Hand Cage Nut Rail Assembly such that the mounting holes on the Cage Nut Rails align with the mounting holes in the assembly created in Steps 1 and 2.

Note: The Cage Nut Rails are numbered "01" through "24". The rails may be installed with an upward numerical order or a downward numerical order. However, the numbering must be consistent on the front and back of the rack. See desired configuration below for hole alignment.



Step 4-Attaching Cage Nut Rails

Attach Cage Nut Rails to rest of assembly using a total of (16) 5/16-18 X 1/2" Serrated Bolts (4 in each corner). See configurations shown below for hole locations. **Do not torque down bolts until Step 10 of this instruction document.**



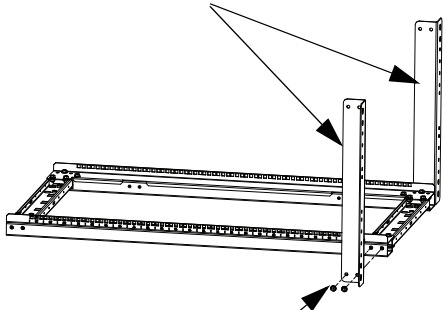
Step 5

Repeat Steps 1, 2, 3, and 4 to assemble a second side assembly.

Step 6-Attaching Bottom Cross Members

Attach (2) Cross Members (1 to each side of assembled frame) with unmounted flange facing outward using a total of (4) 5/16-1 X 1/2" Serrated Bolts. **Do not torque down bolts until Step 10 of this instruction document.**

Cross Members
(flanges facing outward)

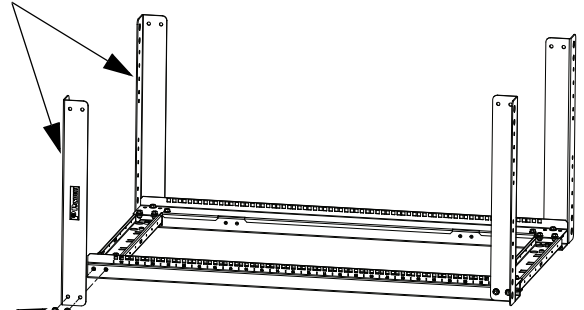


5/16-18 X 1/2" Serrated Bolts
(2) for each Cross Member

Step 7-Attaching Top Cross Members

Attach (2) Cross Members (1 to each side of assembled frame) with unmounted flange facing inward using a total of (4) 5/16-1 X 1/2" Serrated Bolts. **Do not torque down bolts until Step 10 of this instruction document.**

Cross Members
(flanges facing inward)

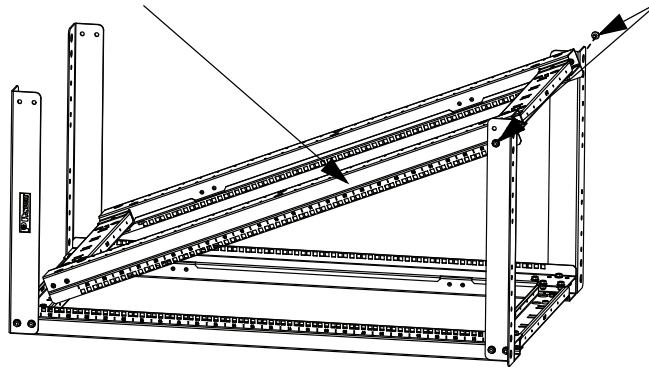


5/16-18 X 1/2" Serrated Bolts
(2) for each Cross Member

Step 8-Attaching Second Assembled Frame

Attach second assembled frame to assembly using (1) 5/16-18-16 X 1/2" Serrated Bolt on each side of the assembly at the lowest hole location only. **DO NOT TIGHTEN.**

Second Assembled Frame

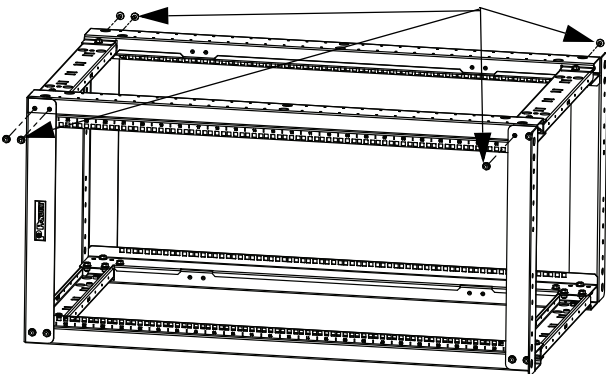


5/16-18 X 1/2"
Serrated Bolts

Step 9-Securing Second Assembled Frame

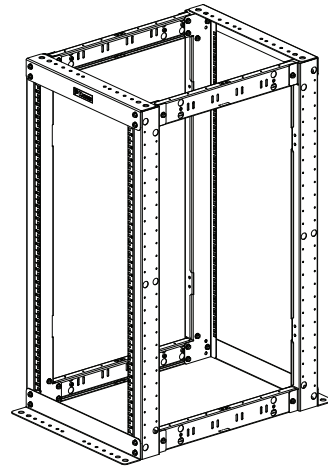
Secure second assembled frame to assembly using (6) additional 5/16-18 X 1/2" Serrated Bolts (3 on each side of the assembly). **Do not torque down bolts until Step 10 of this instruction document.**

5/16-18 X 1/2"
Serrated Bolts



Step 10 Finishing Assembly

Place rack in the upright position. **Tighten ALL bolts to at least 14.0 ft-lbs. of torque.**



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