

ASSEMBLY INSTRUCTIONS
T375 TWIN TOWER 36", 48"
1/6/12

1. Place one assembled upright (with housings and dowel sockets), one unassembled upright, one cross tube, and one bottom cross tube on a table or floor making a rectangle as shown in view A.
2. Fasten one 1/4" x 2" long hex head bolt with one 1/4" flat washer and 1/4" keps hex nut at each top end of the frame as shown in view A. Tighten securely.
3. Repeat steps 1 and 2 with the other assembled upright, unassembled upright and cross tubes.
4. Fasten one foot to the bottom cross tubes and uprights using four 1/4" x 2" long hex head bolts with one 1/4" keps hex nut each (View A) making sure one assembled upright is diagonally across from the other assembled upright. Do not fasten tightly.
5. Repeat step 4 by fastening the other foot to the bottom cross tubes and uprights. Do not fasten tightly.
6. Place the frame on either upright side so that one assembled and one unassembled upright rest on the table or floor.
7. Insert a blade end into the slot of an installed arm attached to the assembled upright not resting on the floor. (View B, C).
8. After blade end has been inserted into an installed housing, attach an arm of a housing not yet installed to the other end of the blade. Rivet the housing to the opposite upright.
9. Repeat steps 7 and 8 for the three remaining blades and housings for that assembled upright.
10. Rotate the unit so the other assembled upright is now in the air. Repeat steps 7 and 8 for the four cutting stations without blades.
11. Fasten both ten inch support bars between uprights using four 1/4" x 2" long hex head bolts, 1/4" flat washers and 1/4" keps hex nuts.

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*The T375 Twin Tower is now complete. If casters are ordered as accessories, install now as shown in figure A.

Note: Steps 12-15 are only applicable when the T375 includes the M800/850 Bulman Measure-a-Roll.

12. The brace arms of the M800/850 must be attached using the same holes as the support bars with hex rod extrusions. Two persons are recommended for this area of assembly.
13. Fasten one support bar with hex nut extrusion between set of uprights using four 1/4" x 2" long hex head bolts, 1/4" flat washers and 1/4" keps hex nuts. Tighten securely.
14. Place roller bar around hex extrusion. (Some adjusting will be necessary in order to fully insert hex into roller).
15. Secure second support with hex extrusion inside roller bar again fastening with four 1/4" x 2" long hex head bolts, 1/4" flat washers and 1/4" keps hex nuts. Tighten securely.

Parts list:

<u>Description</u>	<u>Part No.</u>
Drive Rivet (32)	1013
Right Housing and Dowel Socket (8)	36910R
Left Housing and Dowel Socket (8)	36910L
1/4" x 2 Long Hex Head Bolt (20)	67070
1/4" Flat Washer (12)	1040
1/4" Keps Hex Nut (20)	11860
Regular Blade (8)	227_____*
Serrated Blade (8)	233_____*
Wood Dowel (8)	173_____**
Metal Dowel (8)	197_____**

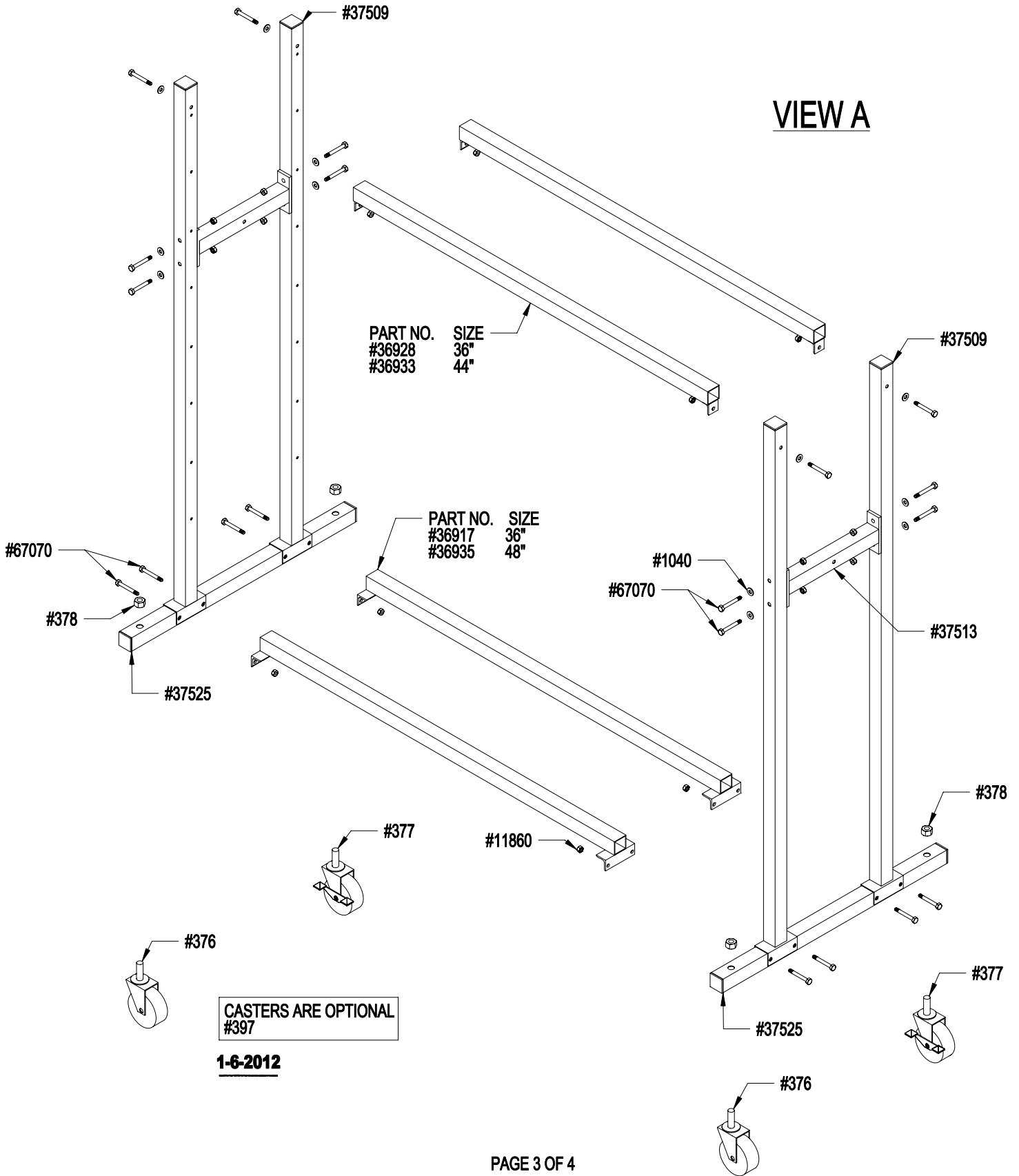
The keps hex nut is a hex nut with a free spinning lock washer attached.

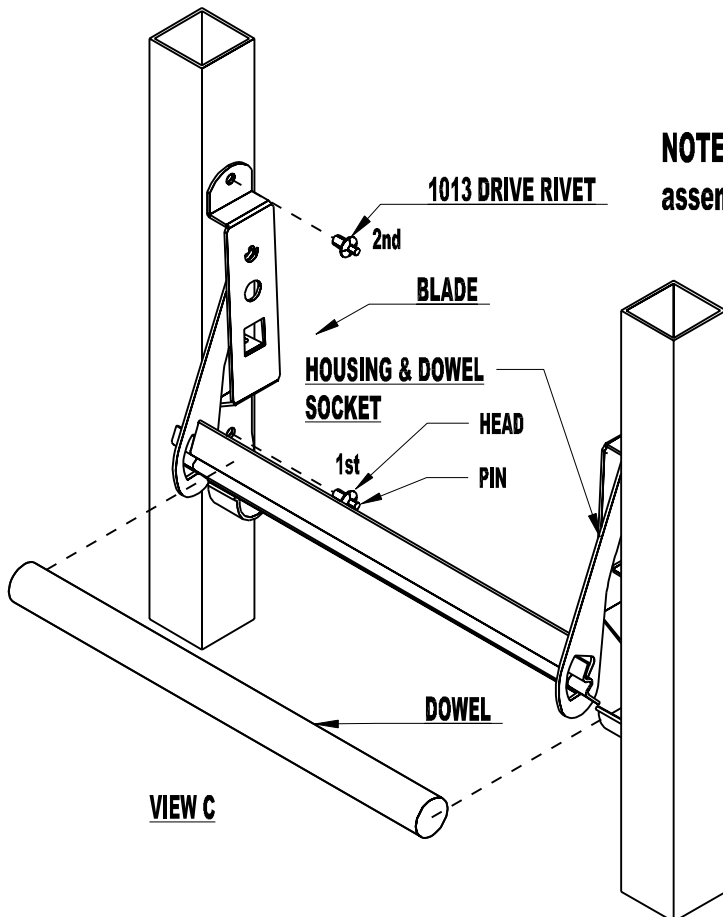
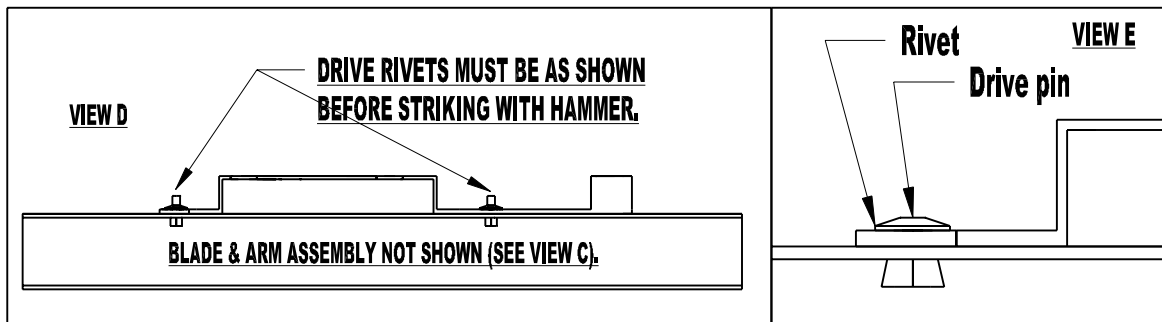
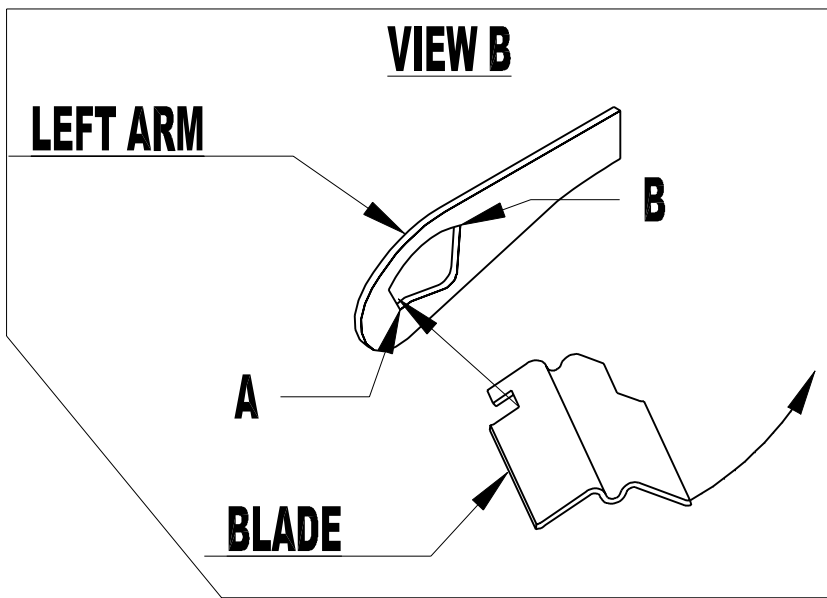
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NOTE: Do not open the arm on the housing assembly prior to mounting the housing assembly.

1. Put both rivets thru holes in housing and square tubing as shown.
2. Hold 2nd rivet and housing with one hand. Hit the 1st rivet with a hammer until the pin is flush with the head of the rivet.
3. Hold the housing with one hand and hit the 2nd rivet with a hammer until the pin is flush with the head of the rivet.

NOTE: THE DOWEL RESTS IN THE DOWEL SOCKETS NOT ON THE TEAR OFF BAR.

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