

Suggested Assembly Instructions:

What is needed: $\frac{3}{4}$ inch wrench, $\frac{3}{4}$ inch socket, $\frac{1}{2}$ inch wrench, $\frac{1}{2}$ inch socket, tape measure



1. Measure your keyboard from end to end down the middle.



Note: if you have a vibraphone, make sure the long cross piece has the hole for the pedal assembly and it is facing up.

2. Connect the short cross pieces to the bass and treble end bottoms using the long bolts. Tighten the bolts until the spring washer is flattened.

3. Insert the short cross pieces into the long cross piece so that the exposed short cross pieces are the same measurement. The measurement from the outside of the bottom end pieces should match the length of your keyboard. Snug, but do not tighten the medium bolts holding the cross pieces together. Do not tighten the lock nut.



3. Attach the casters using the caster bolts. Insert bolts from the bottom (caster side) so the washer, lock washer, and nut are on top.



4. Add the top end pieces and secure them to the bottom pieces with the medium bolts. Ensure both are set at the same height.

5. Assemble the remaining cross pieces. They should measure $\frac{1}{4}$ " shorter than the bottom cross pieces. This may seem too long or short, this is normal because of the variations in the steel. Use the short bolts to connect the assembled cross pieces to the top end pieces.



6. At this point, the slats and end frame of the keyboard should be installed. Now is the time to adjust the cross pieces and make sure they are tight to the slat frame so it cannot move side to side. Once tight, tighten all 8 bolts on the cross pieces and tighten the locking nut as well.

7. Ensure all the nuts and bolts are tight. Add resonators, bars, and pedal assembly and enjoy your new frame!



Caster Hardware: $\frac{1}{2}$ inch wrench/socket



4x Long, 12x Medium, 4x Short
Hardware: $\frac{3}{4}$ inch wrench/socket

