

All ESP Frame System knockdown kits can be assembled by using mechanical fasteners, or with recommended adhesives, or by welding. Special tools are not required to assemble ESP knockdown kits. Proper structural techniques should be used during fabrication.

**STEP 1 - FRAME, RETAINER, AND RACEWAY ASSEMBLY See page 16.****STEP 2 - FABRIC SIZE REQUIREMENTS**

On standard and hinged faced systems:

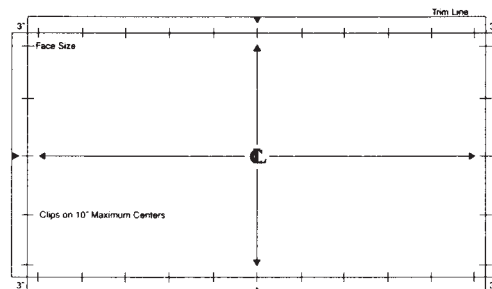
- Add 3"-4" of face material to each dimension or 6"-8" total to the length and width of the cabinet.
- Subtract 1/8" per 3' of face material not to exceed 1" from either dimension for tension factor.

On retro fit frame system:

- Add 2-1/2"-3-1/2" of face material to each dimension or 5"-7" total to the length and width of the cabinet.
- Subtract 1/8" per 3' of face material not to exceed 1" from either dimension for tension factor.

**STEP 3 - CLIP PLACEMENT**

First notch a 3"-4" square from each corner of trimmed flex face material. With the face material facing up, fold approximately 2-1/2" of material over the aluminum bar. Slide and center clip over face material and bar, bolt side up. Clip spacing should be 6"-8" but should not exceed 10" on center around the perimeter of the tensioning system. At the start of each corner, place a clip 3"-4" from the end for best result.

**STEP 4 - BRACING REQUIREMENTS**

Vertical bracing should be used once the face size is larger than 4' tall and 8' long.

The Flex Frame or Retro-Fit brace should be used at a maximum of 3' on center.

Horizontal bracing may be required on 4' centers for larger hinged faces. Vertical and horizontal struts should be welded or double bolted to the frame braces. (Struts not included.)

Size and wall thickness of the struts should be determined based on cabinet size and structural needs.

