

LETTO BEDFRAME TWIN

(LETT-000-002)



Contents

WARNING..... 3

BILL OF MATERIALS..... 4

GLOSSARY..... 5

AWS SYMBOLS..... 6

ASSEMBLY INSTRUCTIONS..... 7

PART DRAWINGS 33

WARNING



SAFETY WARNING: WELDING INVOLVED

Before you begin the assembly process, it's crucial to understand the risks and necessary precautions associated with welding. Please read and adhere to the following safety guidelines:

- **Professional Supervision:** If you're inexperienced in welding, consider seeking guidance or supervision from a trained professional. A small error can have significant consequences on the durability and safety of your furniture.
- **Protective Gear:** Welding can produce intense UV light, sparks, and spatter. Always use a welding helmet with the correct shade of lens, wear flame-resistant clothing, leather gloves, and safety boots. Safety glasses should be worn underneath the helmet for added eye protection.
- **Work in a Safe Environment:** Welding can produce harmful fumes and gases. Always work in a well-ventilated space, preferably outdoors. Remove any flammable materials from the vicinity, and always have a fire extinguisher on hand.
- **Pre-welding Inspection:** Thoroughly inspect the metal parts for any signs of damage, rust, or contamination. Clean the areas to be welded to ensure there are no oils, paints, or other materials that might interfere with the weld.
- **Equipment Check:** Before you start, ensure your welding machine is in proper working condition. Check cables, connectors, and welding gun for any damage or wear.
- **Avoid Water:** Never weld in wet conditions or touch the welding equipment with wet hands or gloves. Water is a conductor of electricity and can increase the risk of shocks.
- **Grounding:** Ensure that the piece you're welding is correctly grounded. A proper ground connection is essential for safety and for producing quality welds.
- **Post-welding Protocol:** Once you finish welding, let the welded parts cool down gradually. Rapid cooling can lead to metal warpage or structural weaknesses.
- **Stay Informed:** Familiarize yourself with the Material Safety Data Sheet (MSDS) for the metals you're working with and the filler materials you're using.
- **First Aid:** Keep a first aid kit nearby. In case of minor burns, immediately hold the affected area under cold running water for at least 10 minutes.
- **Limit Distractions:** Ensure that your workspace is free from unnecessary distractions. Focus is critical when welding to maintain consistent quality and safety.
- **Store Equipment Safely:** After completion, store your welding equipment in a dry, safe place away from children's reach.

Remember, your safety and the quality of your work go hand in hand. Always prioritize safety precautions and never rush the welding process. If you're ever uncertain about a step or safety measure, seek guidance before proceeding.

Your safety is our top priority! No task justifies risking injury.

BILL OF MATERIALS

See page 33 for detailed drawings of each part.

| ITEM | PART NUMBER | DESCRIPTION | REV | MATERIAL | QTY. |
|------|--------------|---|-----|------------------------|------|
| 1 | 1000-000-008 | Steel Hex Head Screw - 1/2"-13 x 4" - Fully Threaded | A-1 | STEEL | 8 |
| 2 | 1000-010-002 | Phillips Round Head Self-Drilling Screw - #10-24 x 1/2" | A-1 | STEEL | 24 |
| 3 | 1001-000-002 | Steel Hex Nut - 1/2"-13 | A-1 | STEEL | 8 |
| 4 | 1001-010-003 | Projection Weld Nut - .5-13 | A-1 | STEEL | 4 |
| 5 | 1011-000-001 | Swivel Leveler - 2.875"_.375-16_Non-skid | A-1 | STEEL | 4 |
| 6 | 1020-000-003 | Outside Leveler Cap | A-1 | STEEL | 4 |
| 7 | 1020-001-003 | Leveler Caps 3 x 3 | A-1 | STEEL | 4 |
| 8 | LETT-050-000 | Headboard Leg | A-1 | SQ_A500_3x3_0.125T | 2 |
| 9 | LETT-051-000 | Footboard Leg | A-1 | SQ_A500_3x3_0.125T | 2 |
| 10 | LETT-052-003 | Horizontal Rail Twin Size | A-1 | SQ_A500_3x3_0.125T | 5 |
| 11 | LETT-053-001 | Side Rail Bracket Full and Twin | A-1 | SQ_A500_3x3_0.125T | 2 |
| 12 | LETT-054-003 | Twin Size Support Slat | A-1 | SQ_A500_1.5x1.5_0.125T | 9 |
| 13 | LETT-055-000 | Side Rail Bracket Left | A-1 | SM_A36_0.075T | 2 |
| 14 | LETT-055-001 | Side Rail Bracket Right | A-1 | SM_A36_0.075T | 2 |
| 15 | LETT-056-000 | Panel Vertical Bracket | A-1 | SM_A36_0.075T | 4 |
| 16 | LETT-057-003 | Twin Size Panel Horizontal Bracket | A-1 | SM_A36_0.1345T | 4 |
| 17 | LETT-058-003 | Twin Size - Solid Beauty Panels | A-1 | SM_A36_0.075T | 2 |

** ITEMS NOT PROVIDED

GLOSSARY

METAL TUBE

SQ_A500_2X2_0.065T

TYPE

MATERIAL

SIZE

MATERIAL
THICKNESS

SHEET METAL

SM_A36_0.065T

TYPE

MATERIAL

MATERIAL
THICKNESS

Type





SQ = Square tube profile
RT = Rectangle tube profile
RD = Circle tube profile
AG = Angle tube profile
SM = Sheet Metal

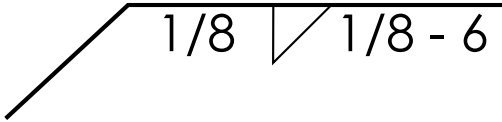
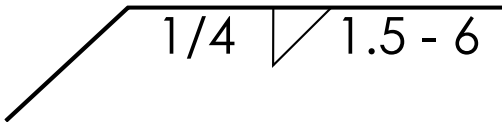
Material Thickness

10ga – 0.1345"
12ga – 0.1035"
14ga – 0.075"
16ga – 0.065"

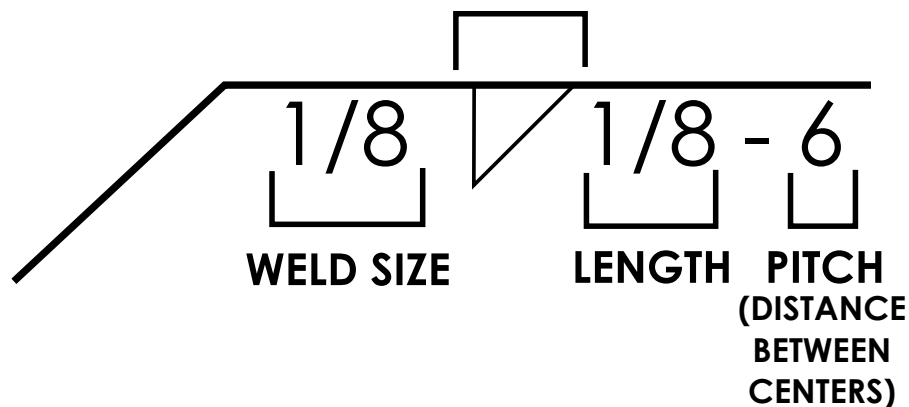
AWS SYMBOLS

The following are some of the common weld symbols you will encounter when reading our assembly instructions.

| AWS SYMBOL | NAME | DESCRIPTION |
|---|-------------|---|
|  | FILLET WELD | Triangular weld joining two surfaces at right angles; common in T-joints and lap joints. |
|  | SEAM WELD | Joins metal using a hole in the top piece, fusing with the bottom piece. |
|  | SPOT WELD | Used for fusing overlapping metals at discrete points; often used in sheet metal fabrication. |
|  | PLUG WELD | Process creating a consistent weld along overlapping materials; suitable for containers and cylindrical assemblies. |

| WELD INDICATION | DESCRIPTION |
|---|--|
|  | TACK WELD (Small and temporary weld that hold parts together ready for final welding.) |
|  | FULLY WELD (Last welding operation performed to complete a joint or structure, ensuring its integrity.) |

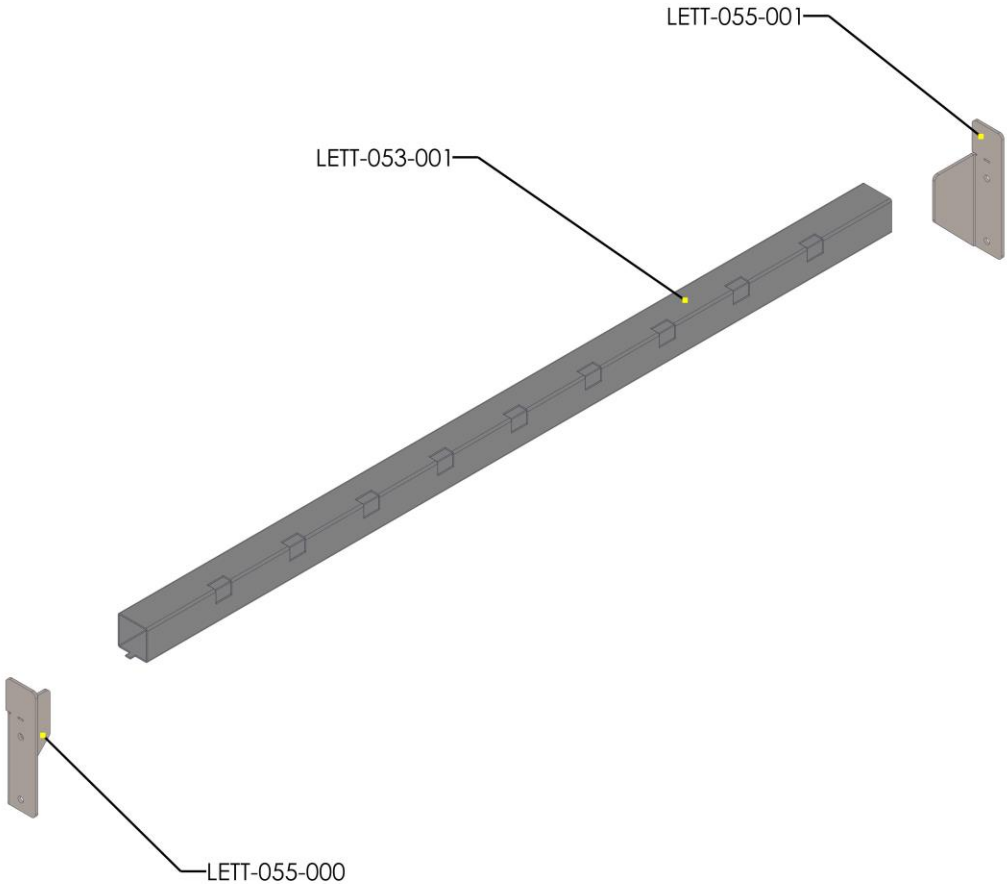
WELD SYMBOL



This symbol tells us to make a 1/8" high Fillet Weld, 1/8" long (a "tack"), and to do so along the seam every 6" (the pitch).

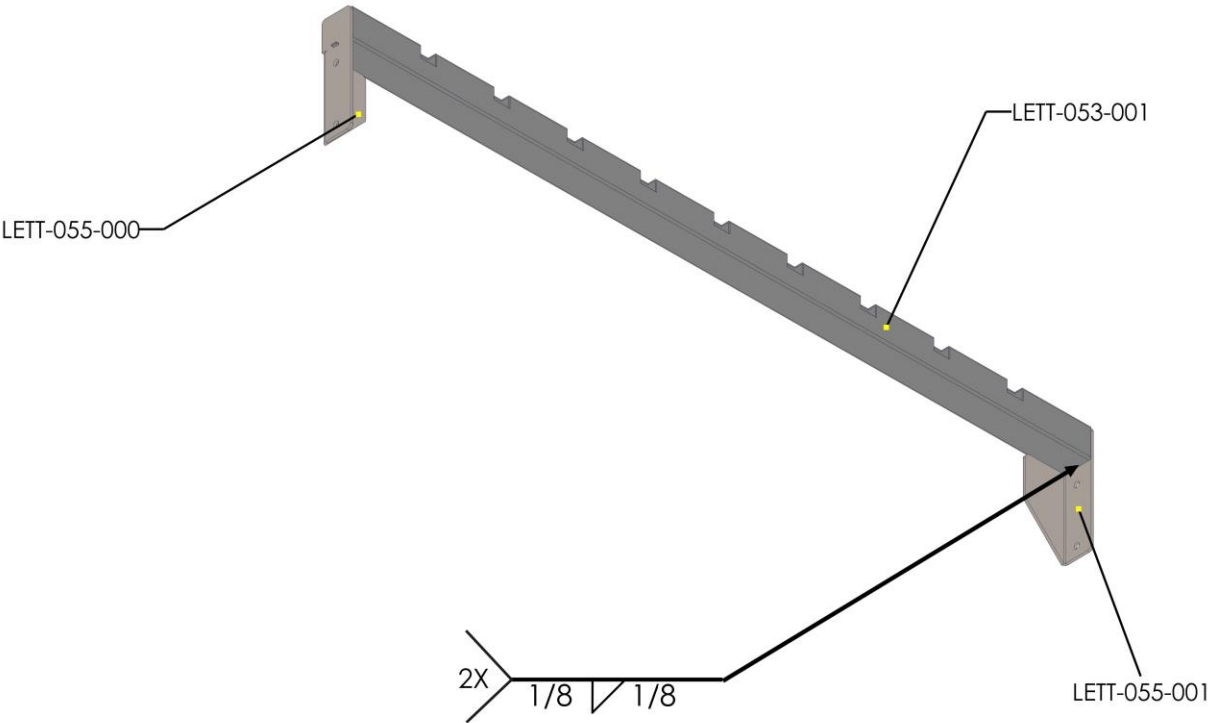
ASSEMBLY INSTRUCTIONS

1



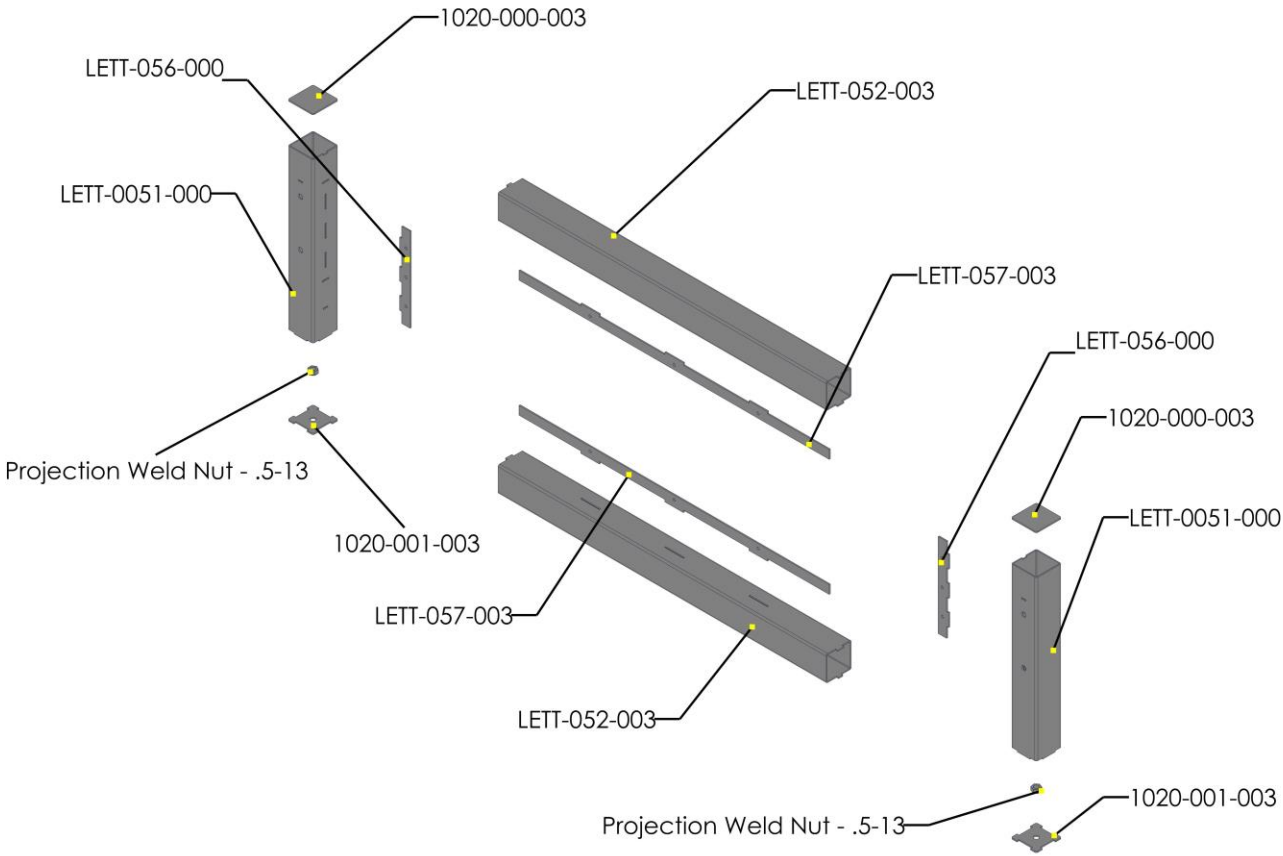
NOTES:

2



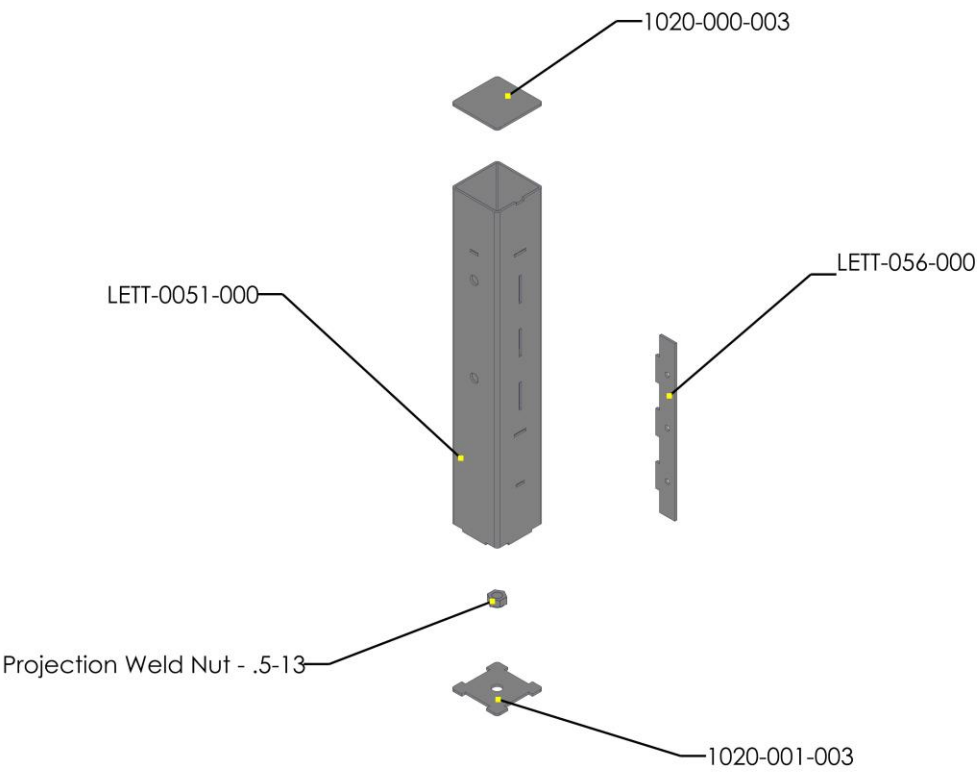
NOTES:

3



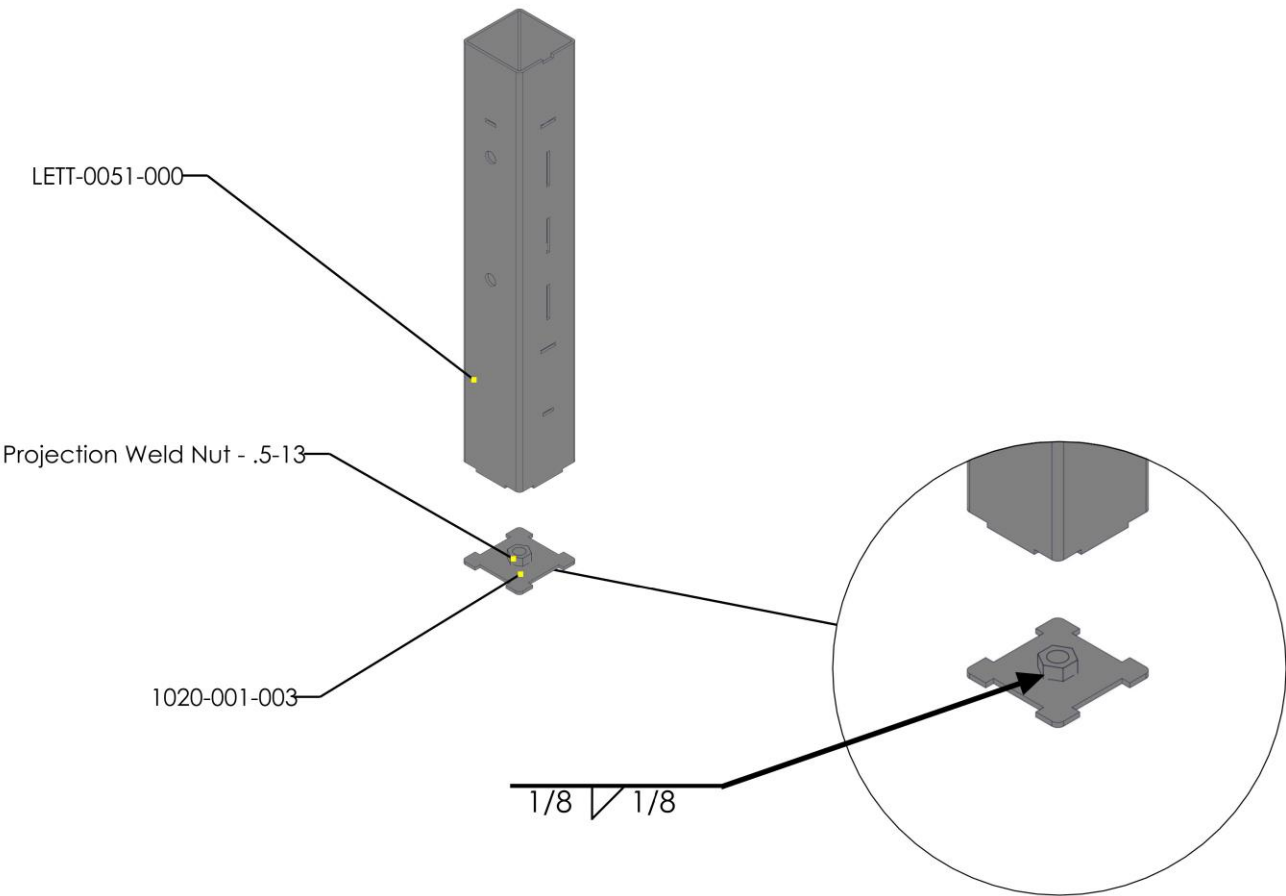
NOTES:

4



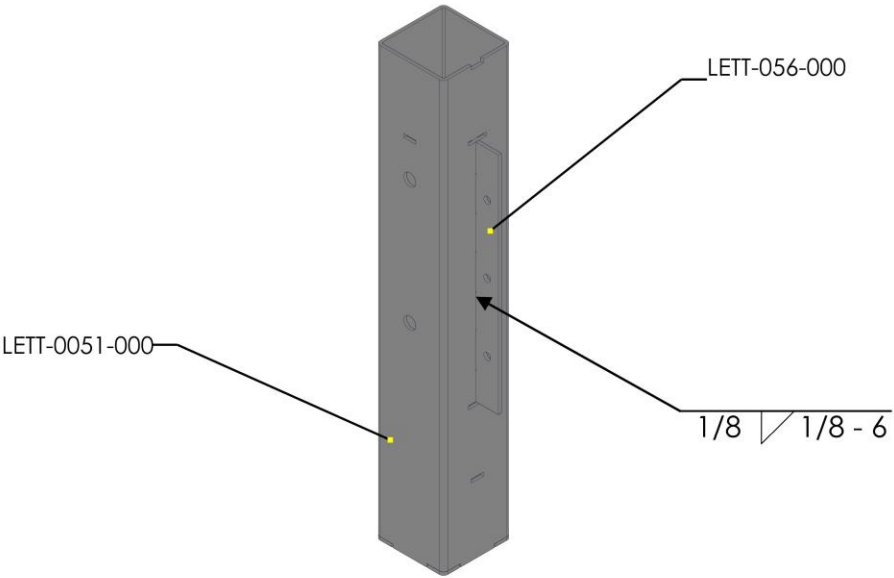
NOTES:

5

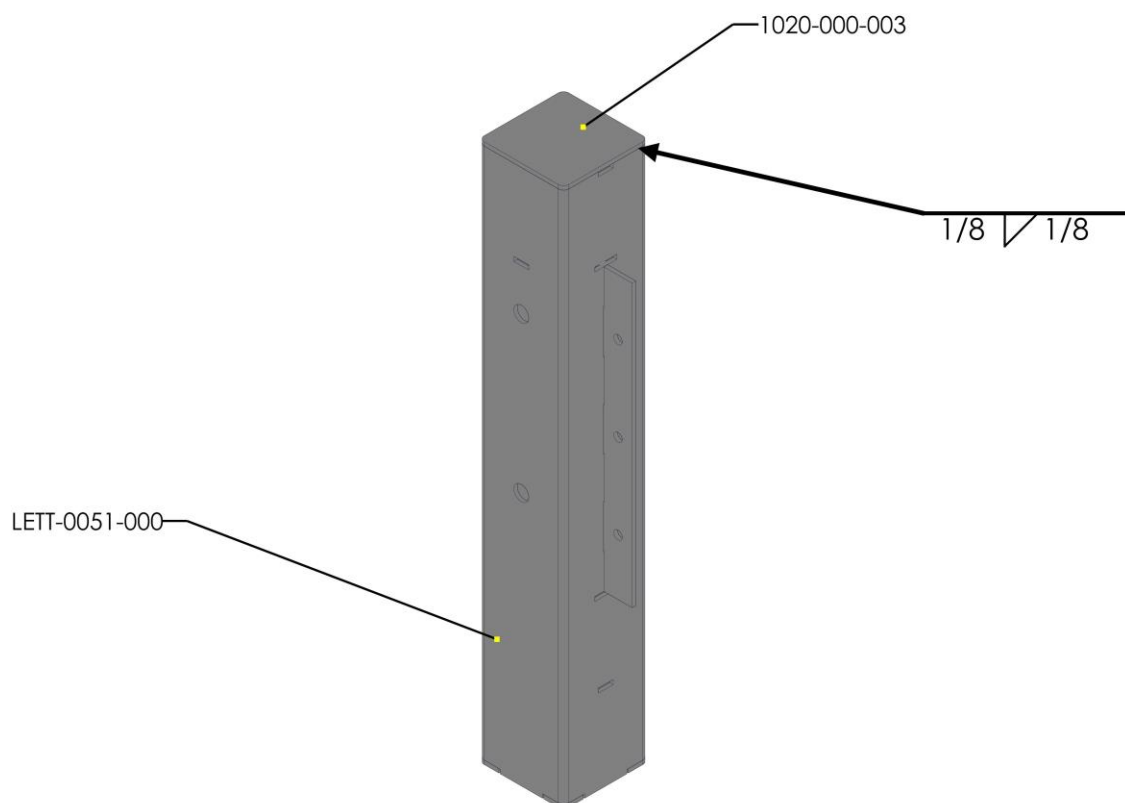


NOTES:

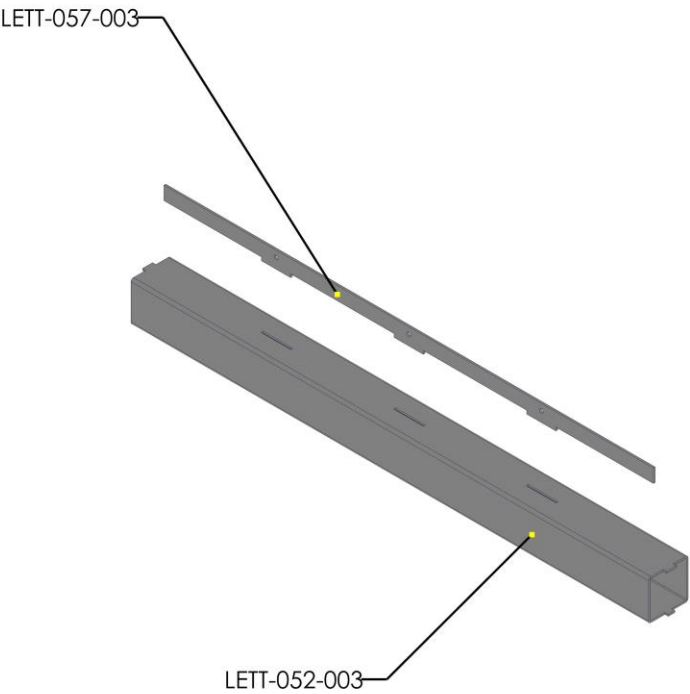
6



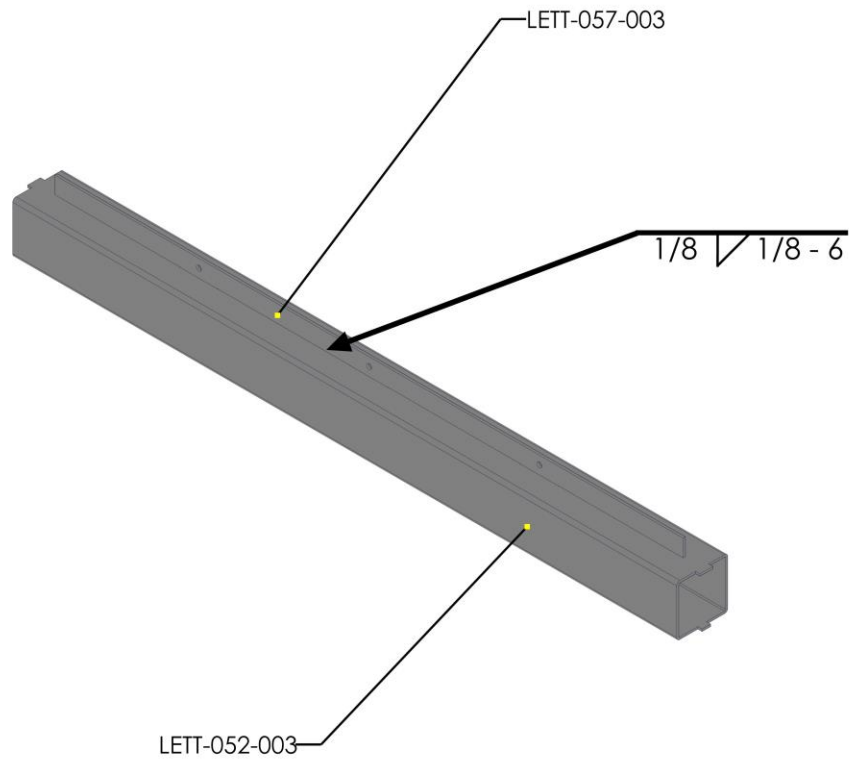
NOTES:

7**NOTES:****REPEAT STEPS 4 TRHU 7 FOR OTHER LEG**

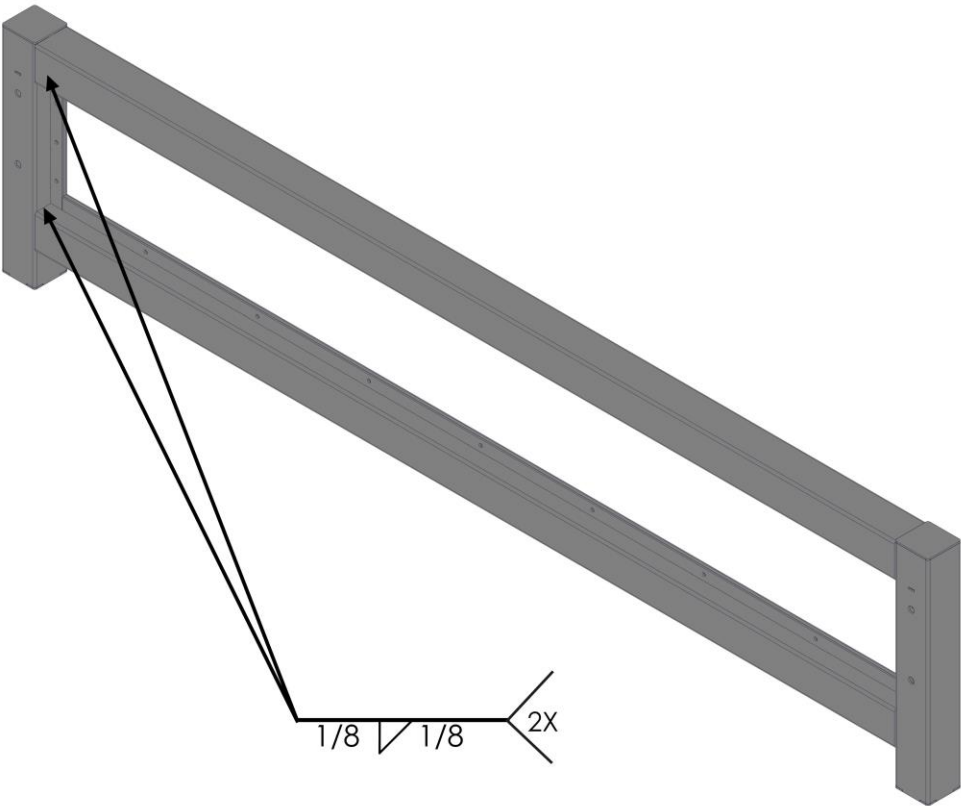
8



NOTES:

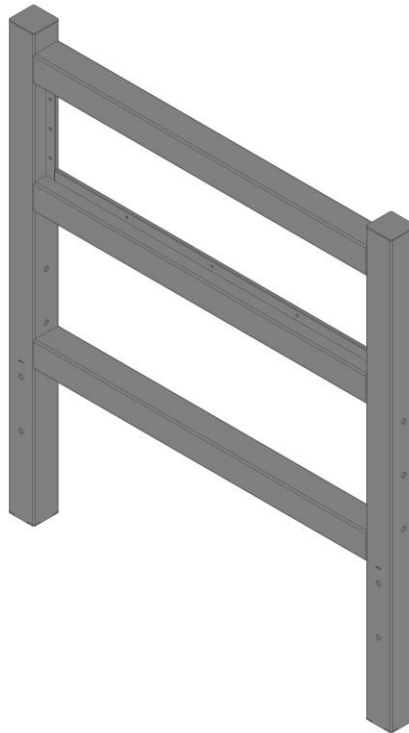
9**NOTES:****REPEAT STEPS 8 & 9 FOR OTHER STRETCHER**

10



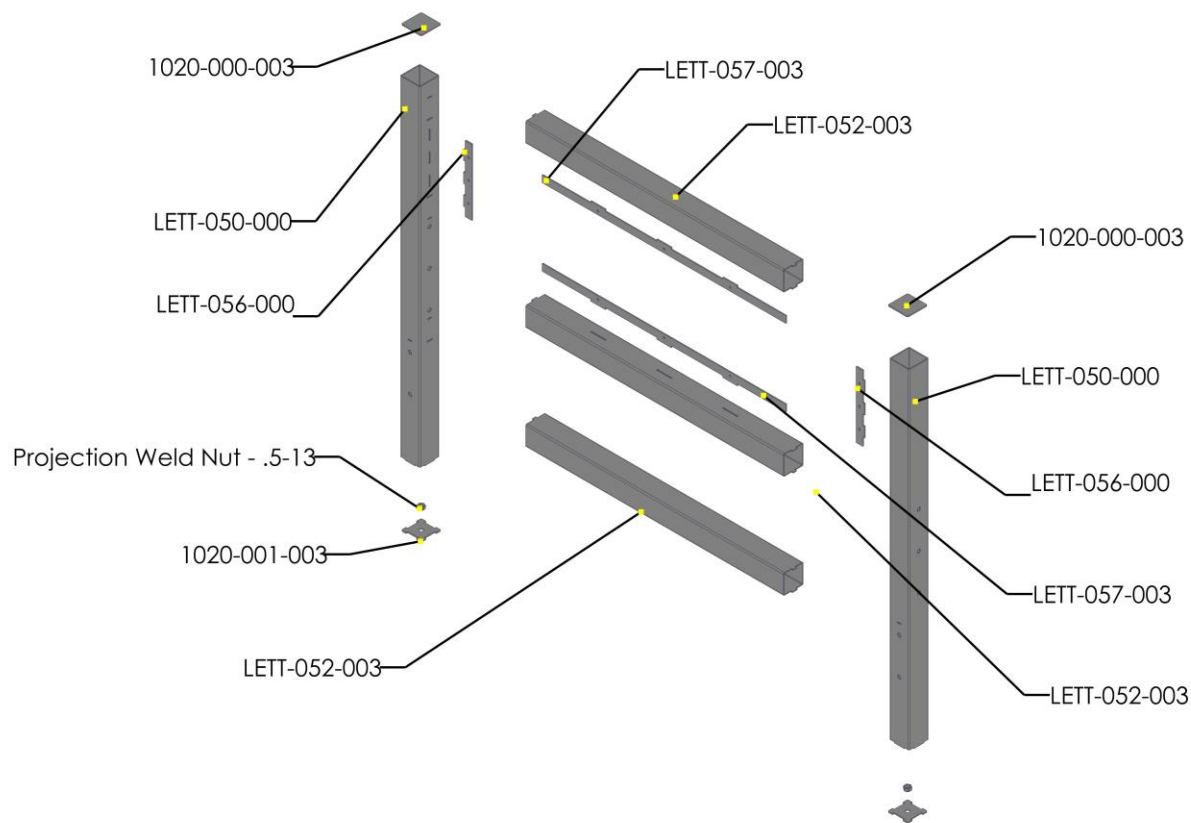
NOTES:

11



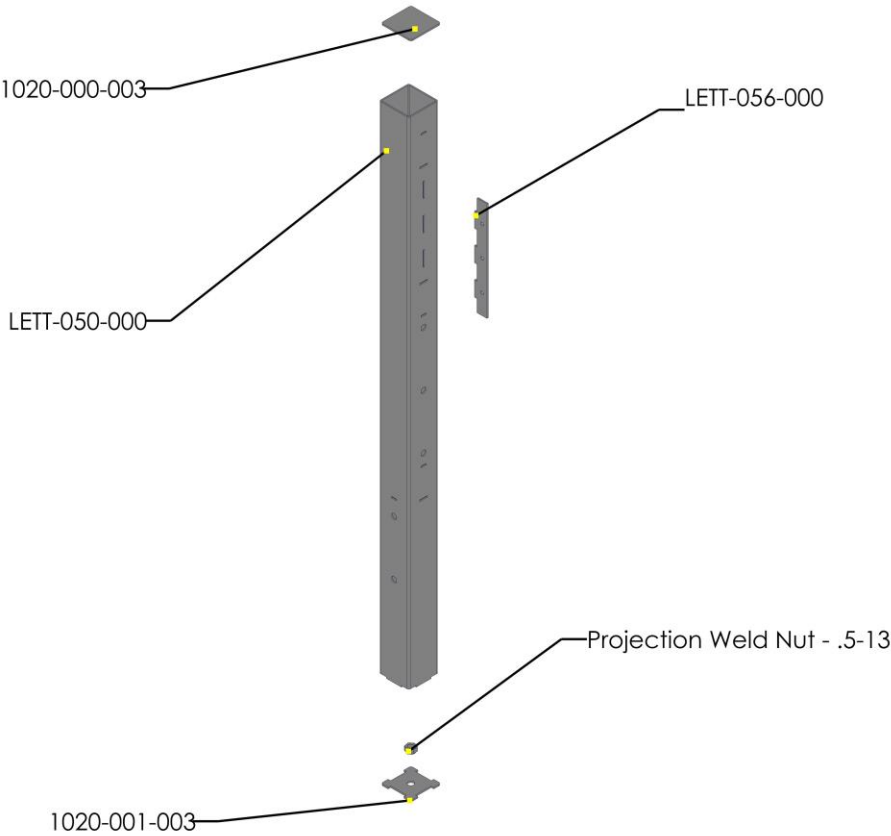
NOTES:

12



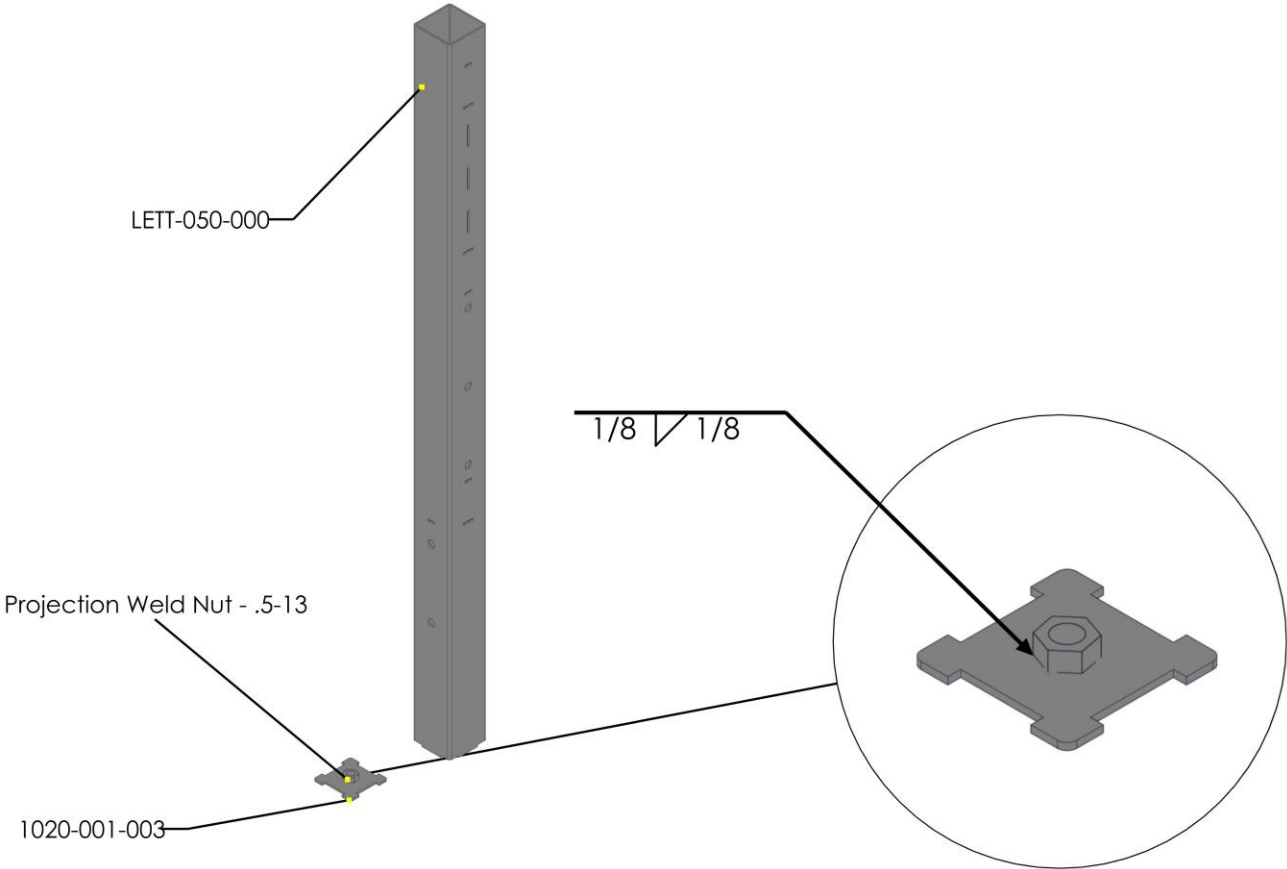
NOTES:

13



NOTES:

14



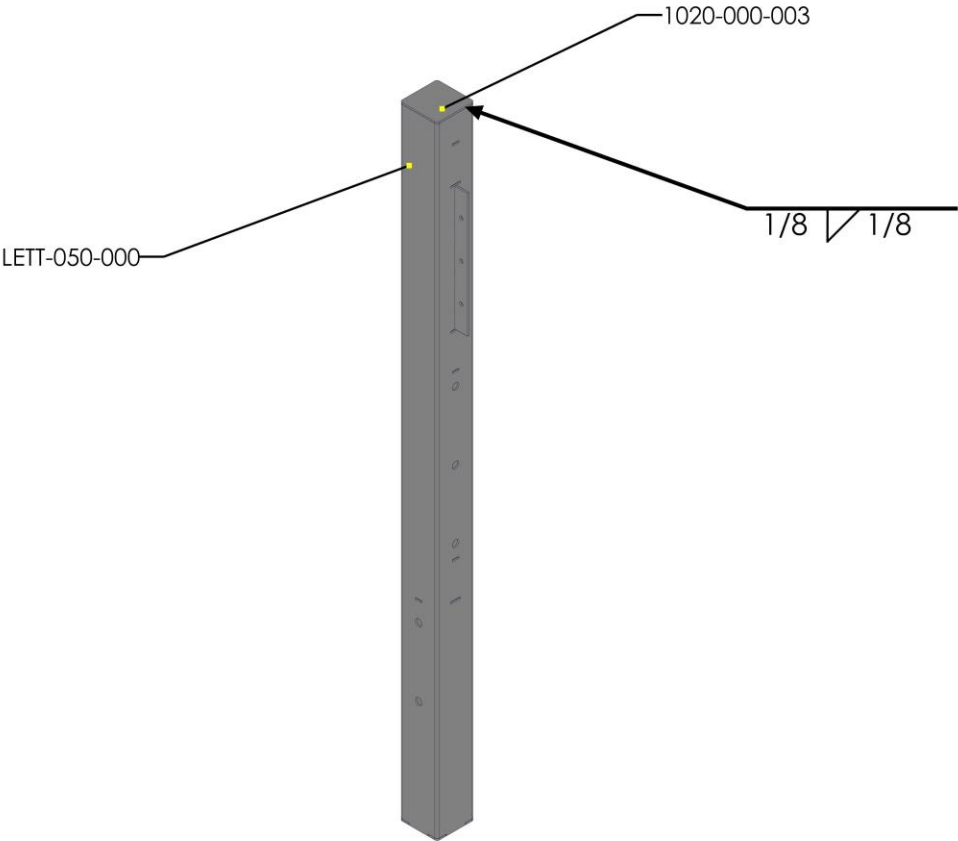
NOTES:

Technical drawing of a vertical post assembly. The drawing shows a vertical post with a flange at the top. Callouts indicate the following components and dimensions:

- LETT-050-000**: Points to the top flange.
- LETT-056-000**: Points to the main vertical post.
- 1/8**: Dimension indicating the thickness of the post.

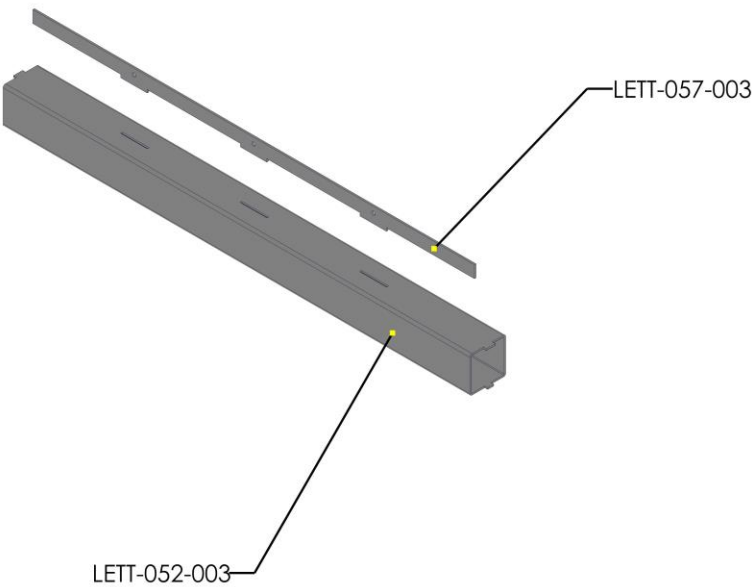
Page 21 of 33

16



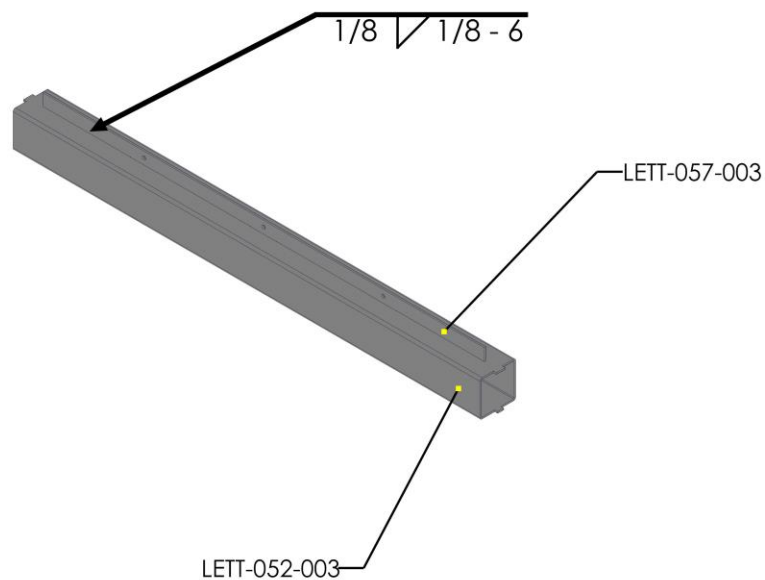
NOTES:
REPEAT STEPS 13 TRHU 16 FOR OTHER LEG

17



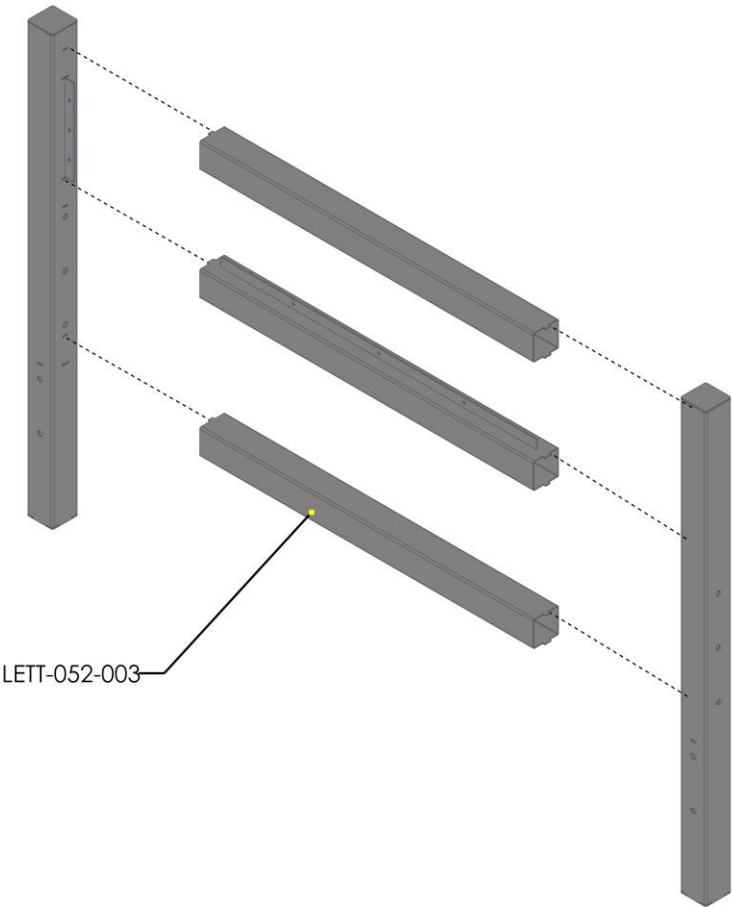
NOTES:

18

**NOTES:**

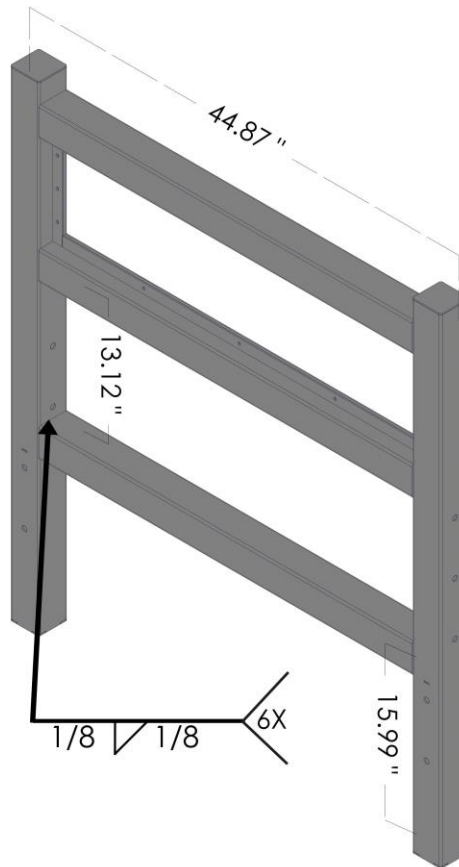
REPEAT STEPS 17 & 18 FOR OTHER STRETCHER

19



NOTES:

20

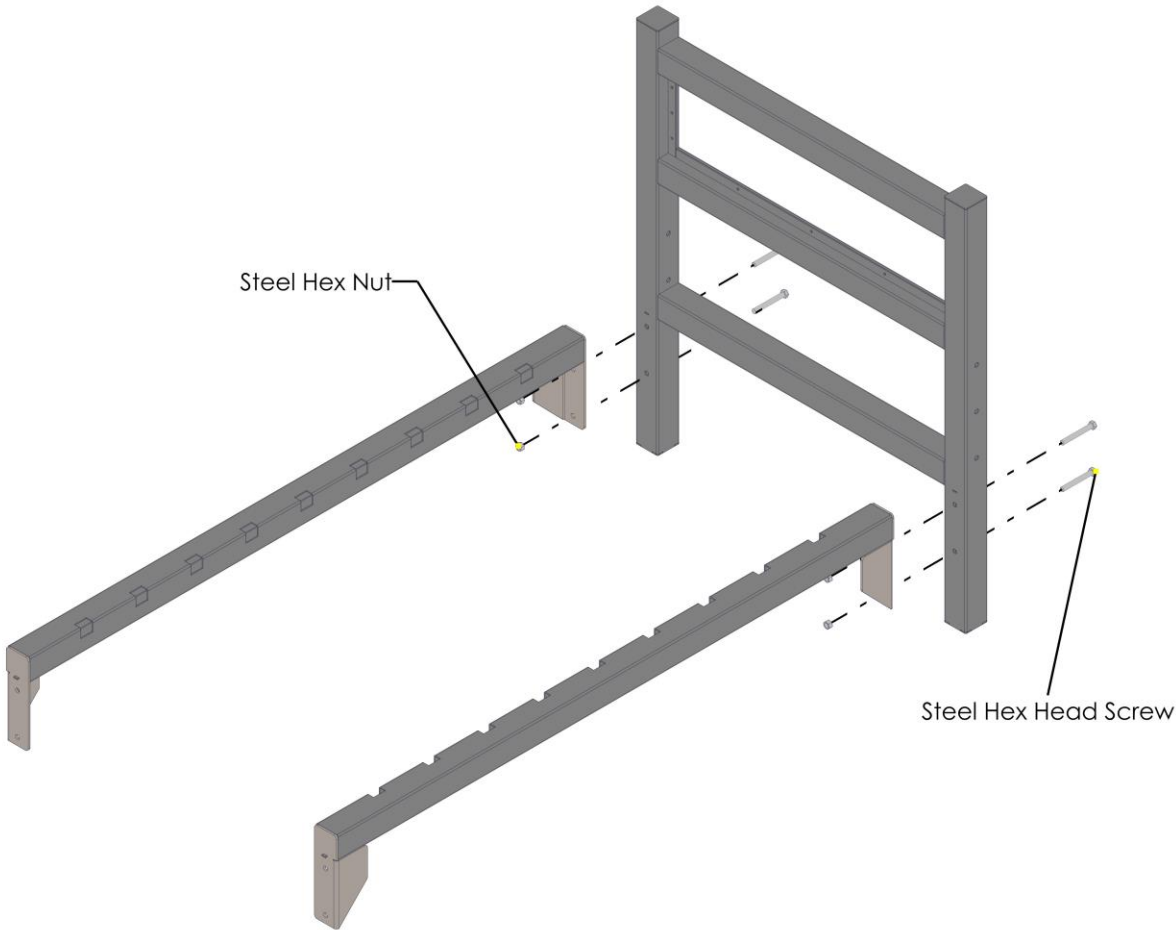


NOTES:

NOW IS THE PERFECT TIME TO GO BACK AND FINISH WELDING ALL THE PREVIOUS TACK WELDS

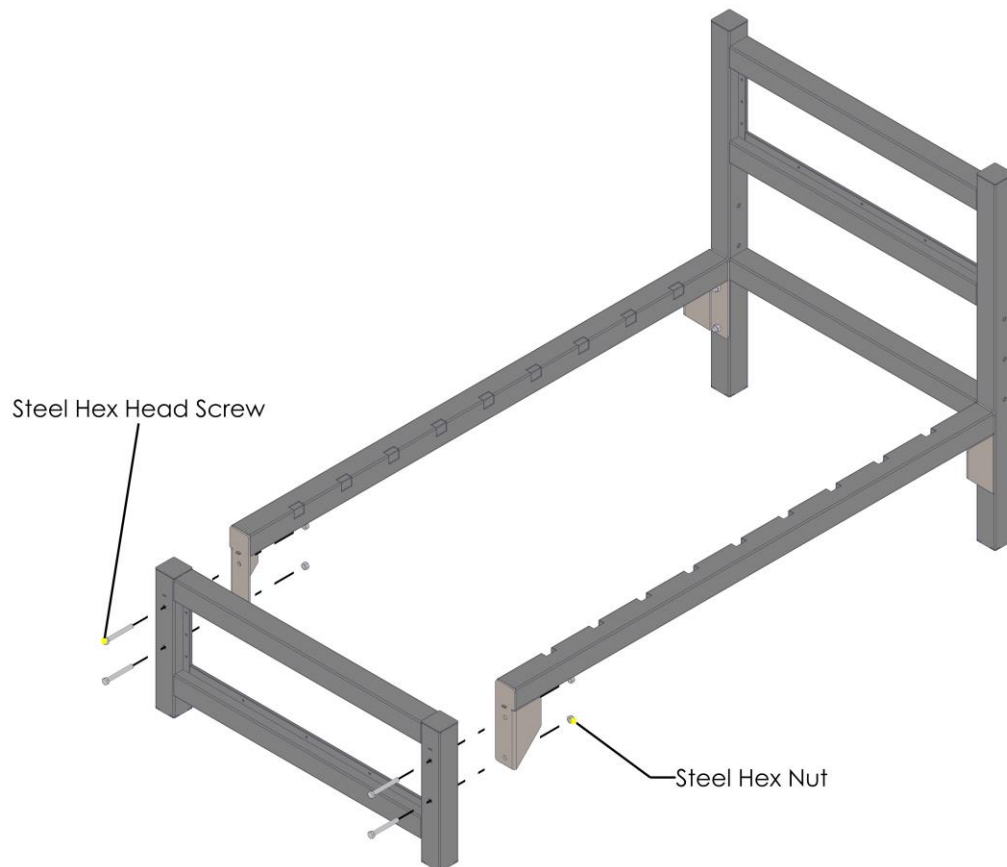
WE RECOMMEND A 0.25" HIGH FILLET WELD, 1.5" LONG

21



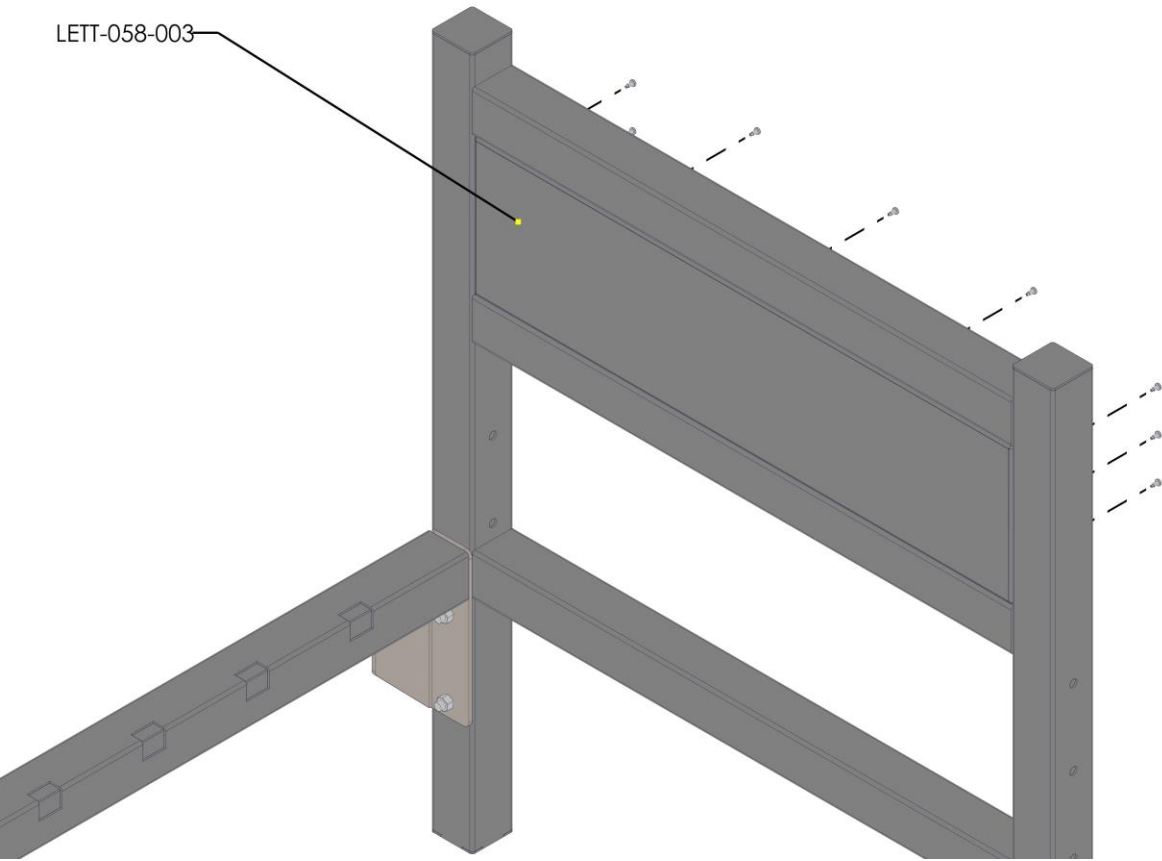
NOTES:

22



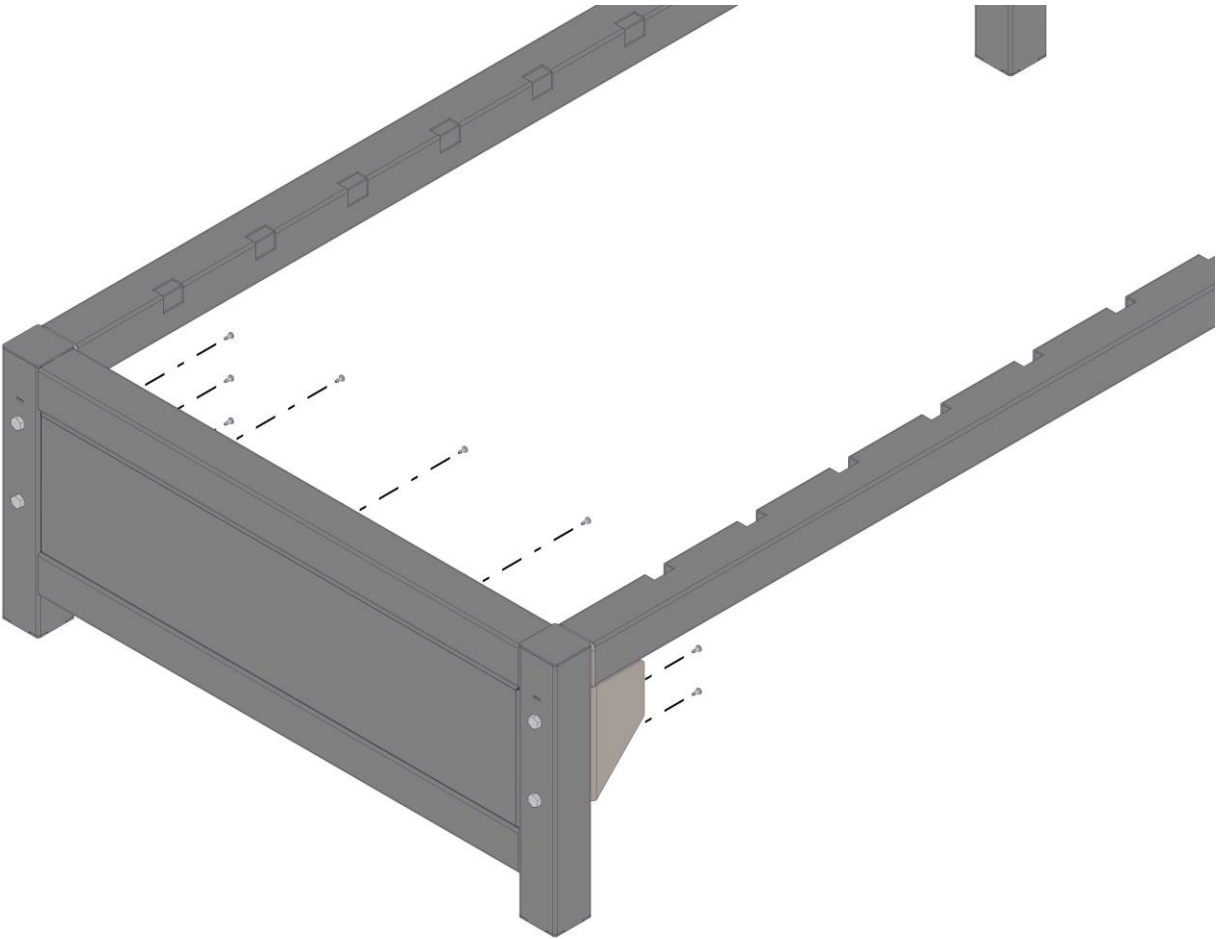
NOTES:

23



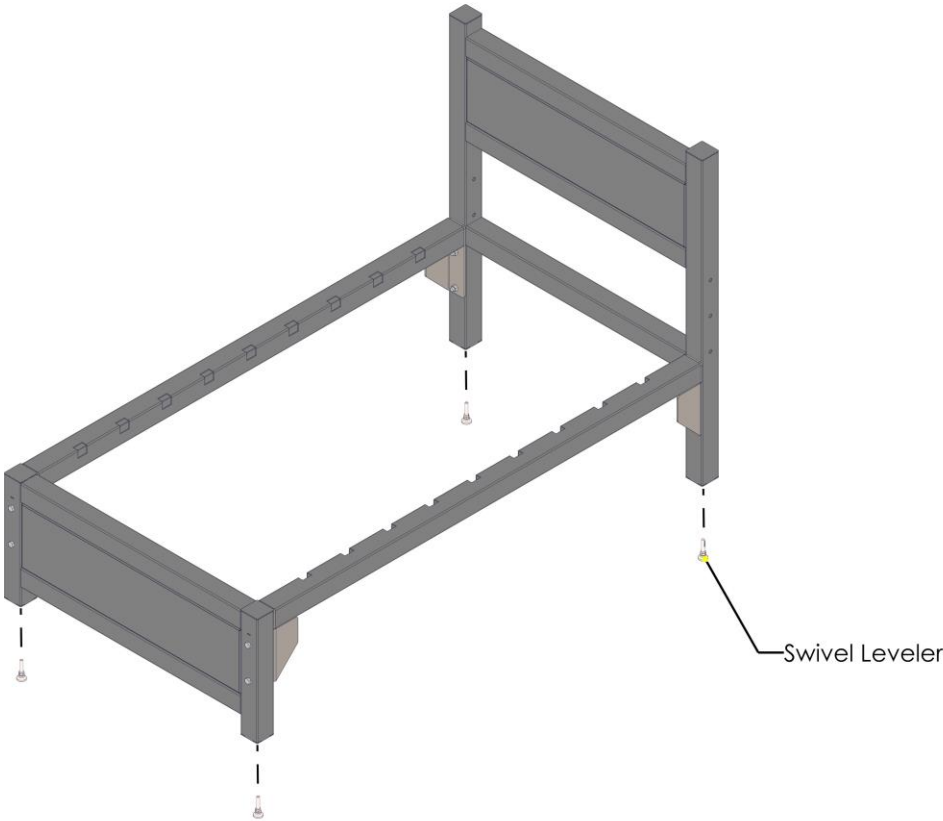
NOTES:

24



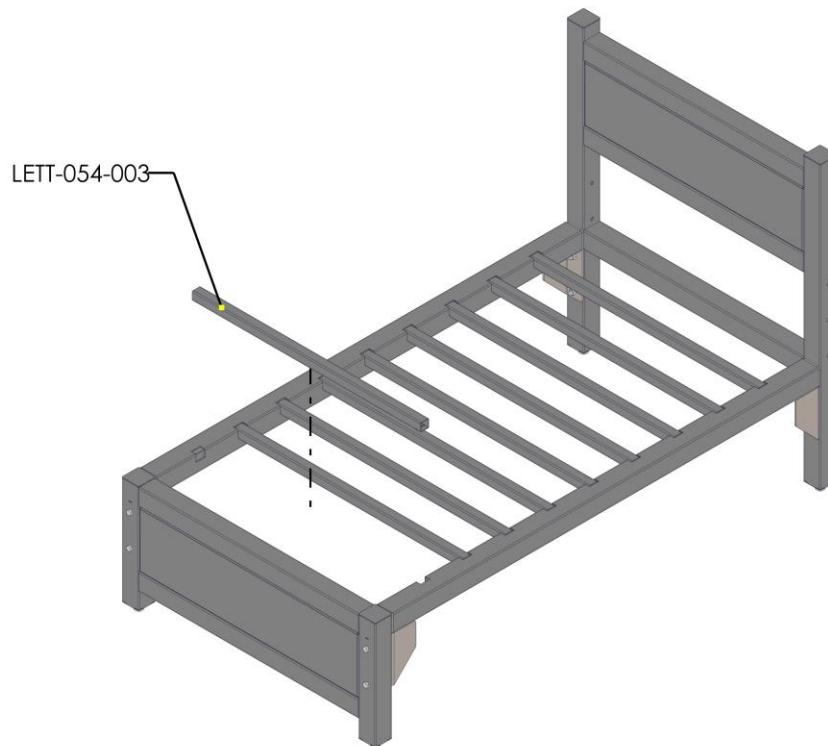
NOTES:

25



NOTES:

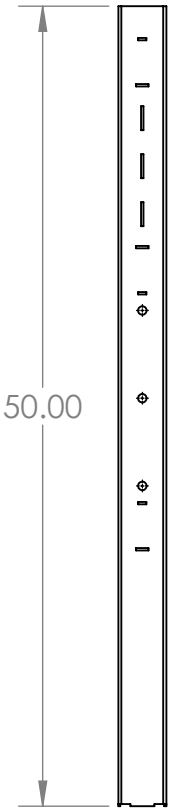
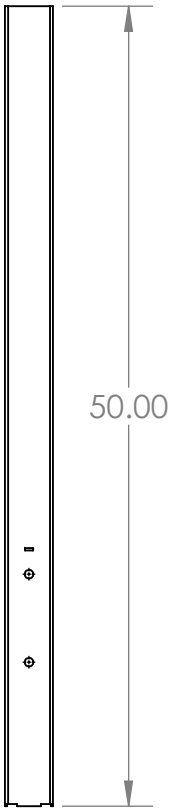
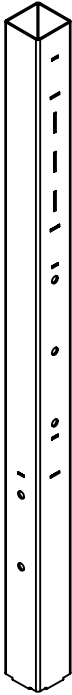
26



NOTES:

PART DRAWINGS

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

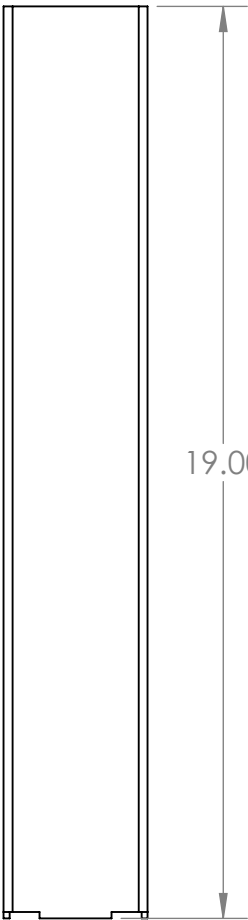
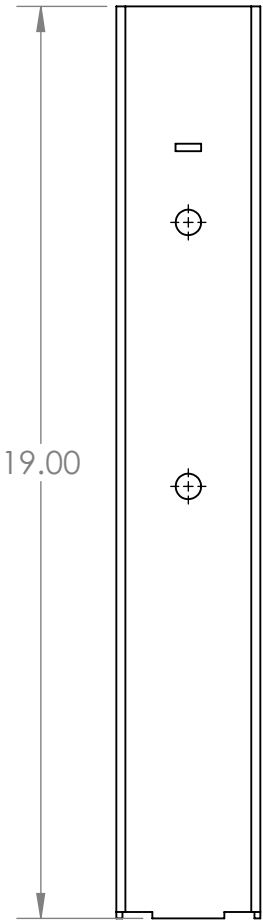
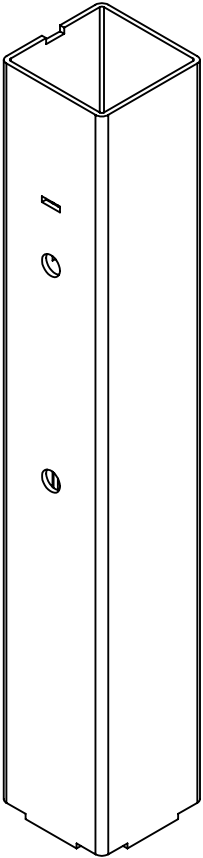
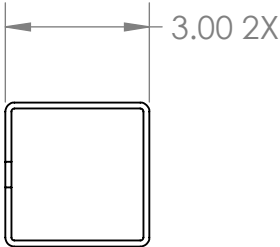


101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|-------------------------------------|---------------------------------------|
| PART # LETT-050-000 | MATERIAL SQ_A500_3x3_0.125T |
| | DESCRIPTION : Headboard Leg |
| DRAWN BY: MMoreno 01/12/24 | |
| SHEET 1 OF 1 | |

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

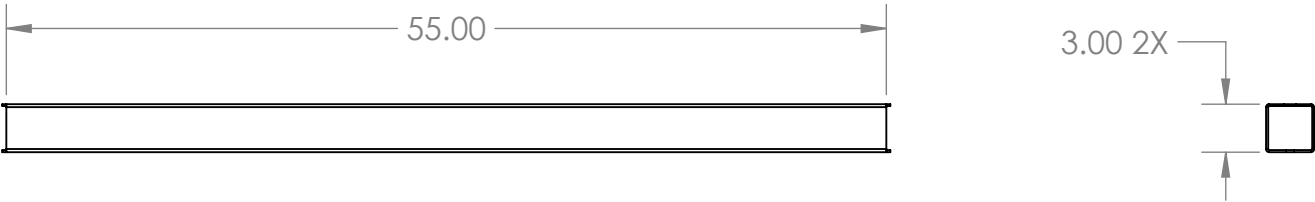
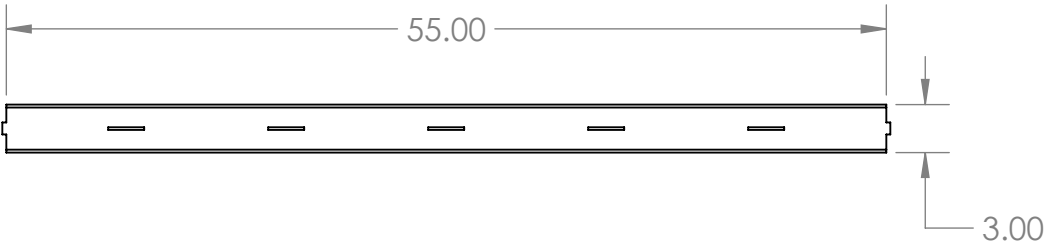
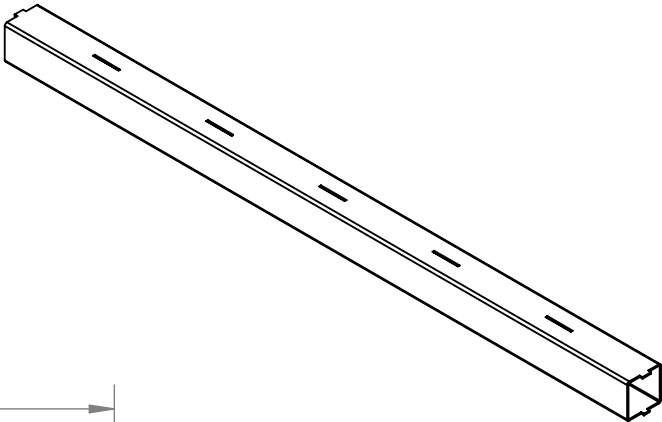


101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|-------------------------------------|---------------------------------------|
| PART # LETT-051-000 | MATERIAL SQ_A500_3x3_0.125T |
| | DESCRIPTION : Footboard Leg |
| DRAWN BY: MMoreno 01/12/24 | |
| SHEET 1 OF 1 | |

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE



101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

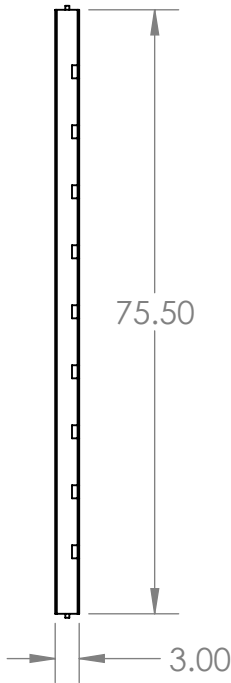
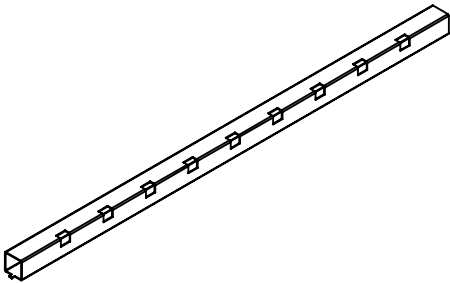
PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|-------------------------------|---------------------------------------|
| PART # LETT-052-002 | MATERIAL SQ_A500_3x3_0.125T |
|-------------------------------|---------------------------------------|

DESCRIPTION :
Horizontal Rail Full Size

DRAWN BY: MMoreno | 01/12/24 **SHEET 1 OF 1**

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE



101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

PART #

LETT-053-001

MATERIAL

SQ_A500_3x3_0.125T

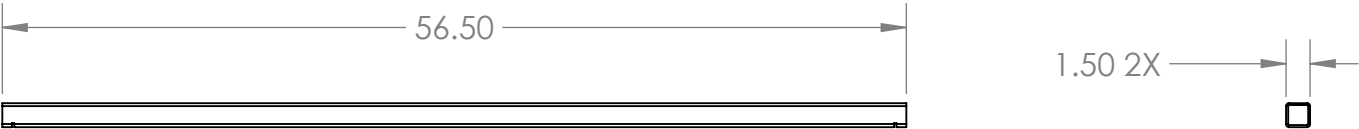
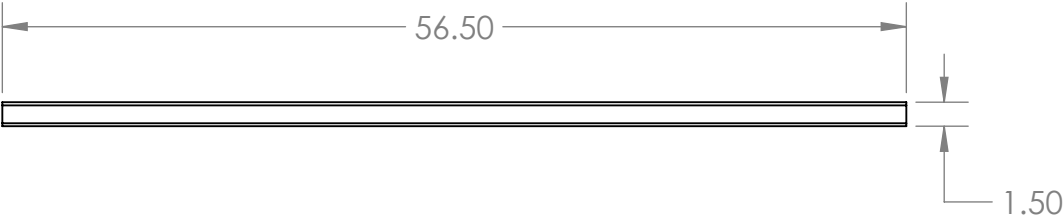
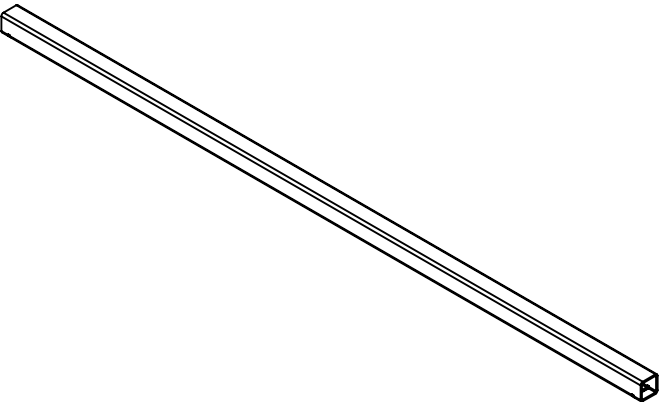
DESCRIPTION :

Side Rail Bracket Full and Twin

DRAWN BY: MMoreno | 01/12/24

SHEET 1 OF 1

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE



101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

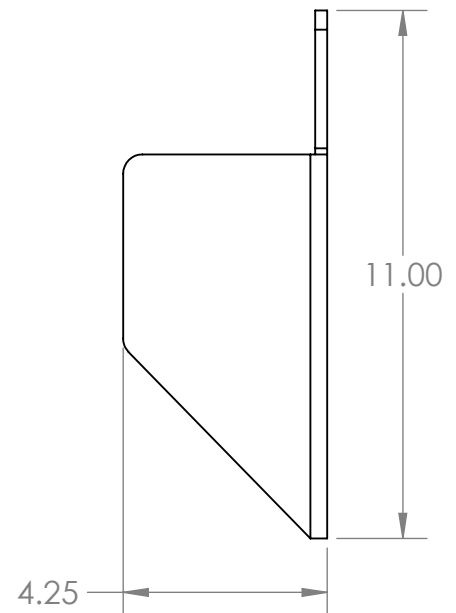
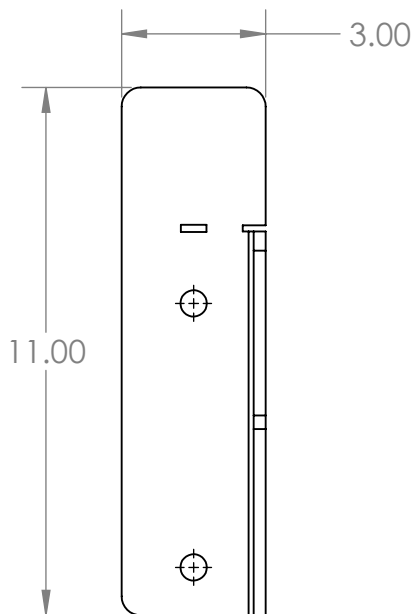
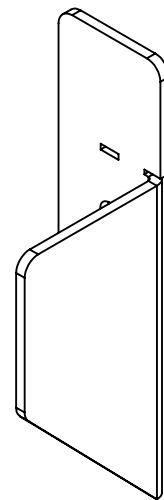
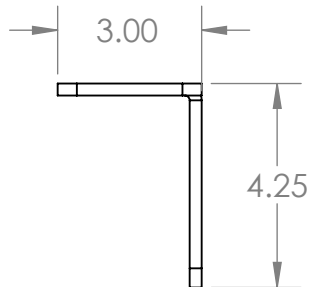
PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|---------------|------------------------|
| PART # | MATERIAL |
| LETT-054-002 | SQ_A500_1.5x1.5_0.125T |

DESCRIPTION :
Full Size Support Slat

DRAWN BY: MMoreno | 01/12/24 **SHEET 1 OF 1**

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

WELD PROJECTS COM

101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

PART #

LETT-055-001

MATERIAL

SM_A36_0.075T

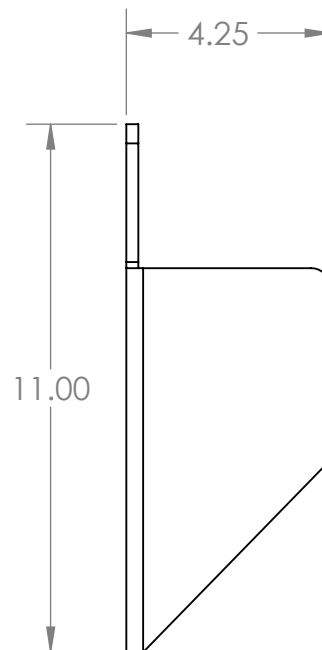
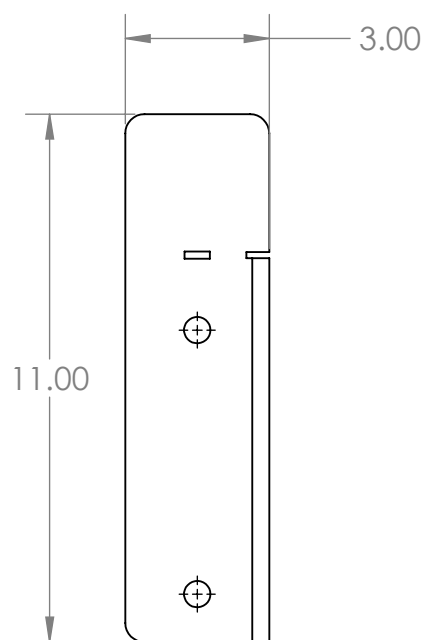
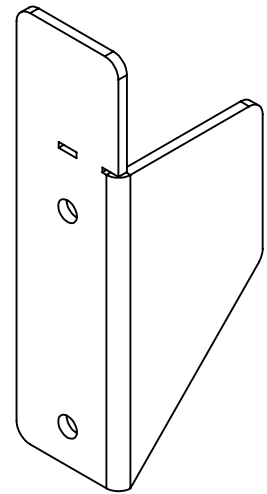
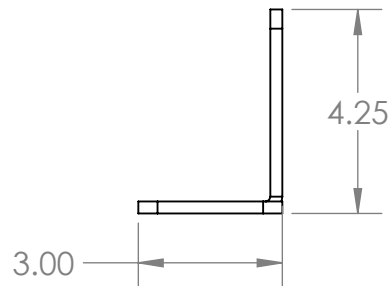
DESCRIPTION :

Side Rail Bracket Right

DRAWN BY: MMoreno | 01/12/24

SHEET 1 OF 1

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

WELD PROJECTS COM

101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

PART #

LETT-055-000

MATERIAL

SM_A36_0.075T

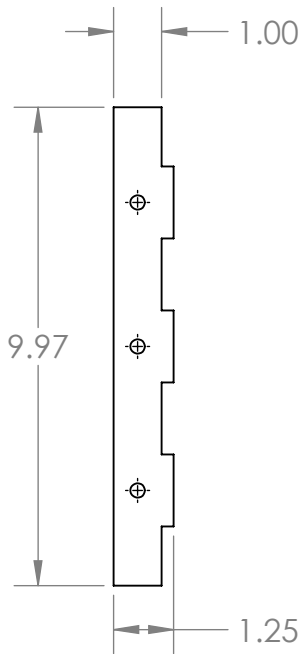
DESCRIPTION :

Side Rail Bracket Left

DRAWN BY: MMoreno | 01/12/24

SHEET 1 OF 1

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE



101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

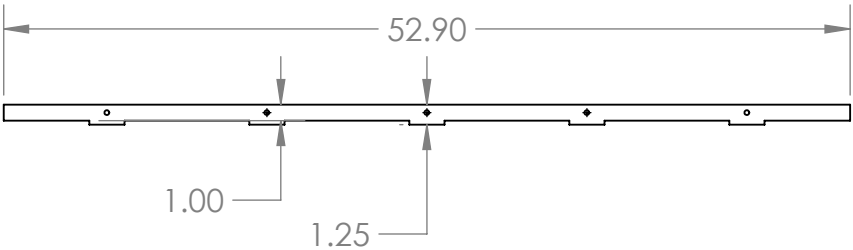
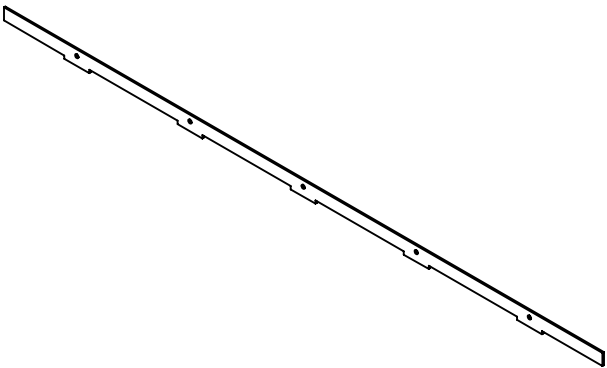
PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|-------------------------------|----------------------------------|
| PART # LETT-056-000 | MATERIAL SM_A36_0.075T |
|-------------------------------|----------------------------------|

DESCRIPTION :
Panel Vertical Bracket

DRAWN BY: MMoreno | 01/12/24 **SHEET 1 OF 1**

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

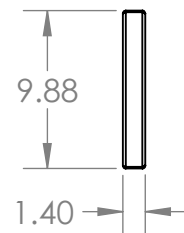
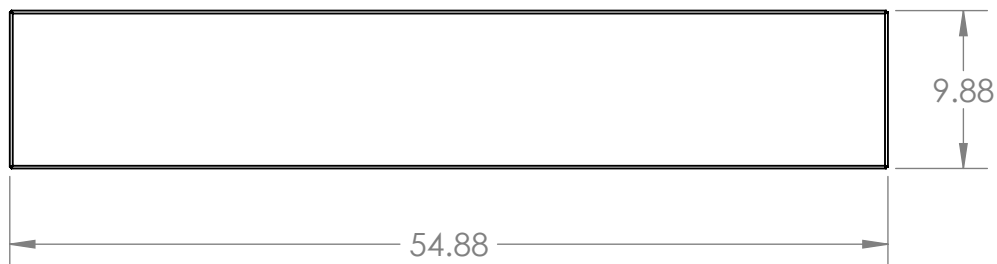
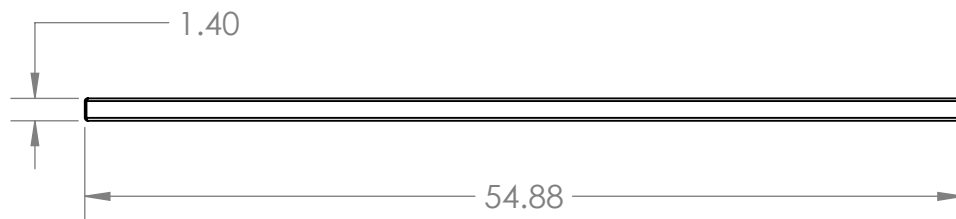
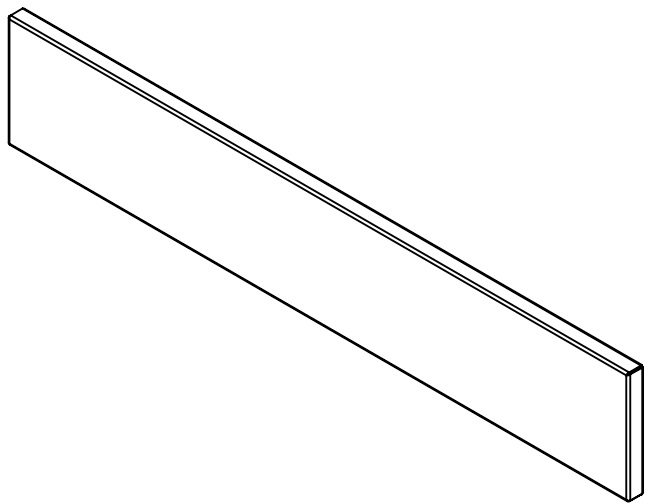


101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

| | |
|--|-----------------------------------|
| PART # LETT-057-002 | MATERIAL SM_A36_0.1345T |
| DESCRIPTION : Full Size Panel Horizontal Bracket | |
| DRAWN BY: MMoreno 01/12/24 SHEET 1 OF 1 | |

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

WELD PROJECTS COM

101 INDUSTRIAL CT, CONROE, TX 77301 | PH: 281-238-9652

PROPRIETARY AND CONFIDENTIAL : THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF WELD PROJECTS. ANY REPRODUCTION, IN PART OR AS A WHOLE, WITHOUT WRITTEN PERMISSION OF WELD PROJECTS IS PROHIBITED.

PART #

LETT-058-002

MATERIAL

SM_A36_0.075T

DESCRIPTION :

Full Size - Solid Beauty Panels

DRAWN BY: MMoreno | 01/12/24

SHEET 1 OF 1