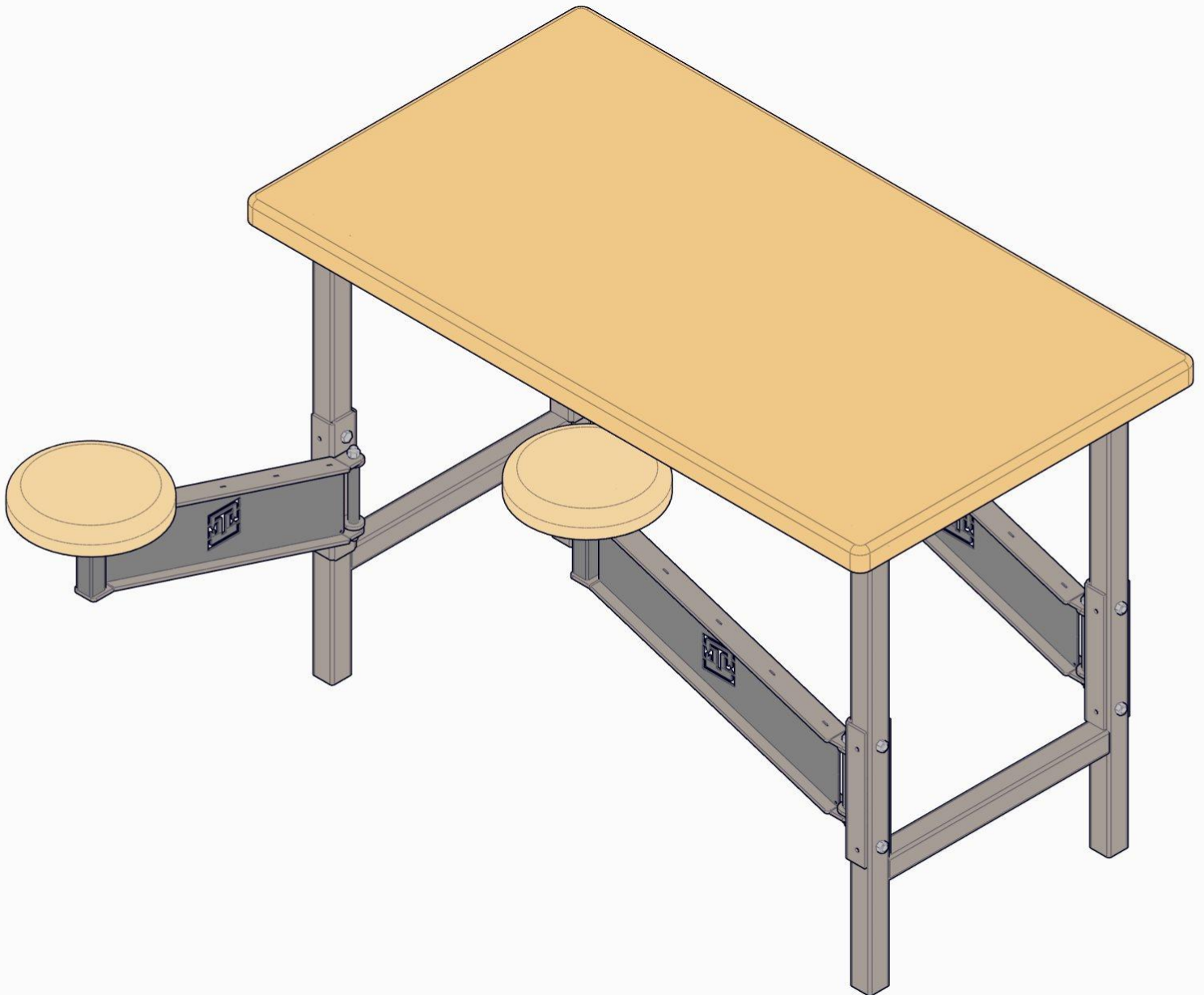


# SWIVEL TABLE

(SWIV-000-000)



# Contents

WARNING..... 3

BILL OF MATERIALS..... 4

GLOSSARY..... 5

AWS SYMBOLS..... 6

ASSEMBLY INSTRUCTIONS..... 7

PART DRAWINGS ..... 29

# 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 29 for detailed drawings of each part.

ITEM	PART NUMBER	DESCRIPTION	REV	MATERIAL	QTY.
1	1000-000-011	Steel Hex Head Bolt - 3/8"-16 x 3" - Partially Threaded	A-1	Steel	8
2	1000-002-000	Phillips Pan Head Screws - #8-32 x 7/16"	A-1	Steel	16
3	1001-000-001	Steel Hex Nut - 3/8"-16	A-1	Steel	8
4	1001-000-002	Steel Hex Nut - 1/2"-13	A-1	Steel	8
5	1001-001-000	Low-Strength Steel Hex Nut - #8-32	A-1	Steel	16
6	1040-000-000	Weld mount - T Handle - Retractable Spring Plunger - 1" dia body x 0.25" dia nose	A-1	Steel	4
7	1045-000-000	Lazy Susan - 4" Square holes - 300 lbs capacity	A-1	Steel	4
8	98750A477	Steel Threaded Rod - 1/2-13 - 8in long	A-1	Steel	4
9	SWIV-051-000	Swivel Table Frame Bottom Reacher	A-1	SQ_A500_2X2_0.109T	2
10	SWIV-052-000	Swivel Table Frame Top Reacher	A-1	SQ_A500_2X2_0.109T	2
11	SWIV-053-000	Swivel Table Frame Inner Stretcher	A-1	SQ_A500_2X2_0.109T	1
12	SWIV-054-000	Swivel Table Frame Outer Stretcher	A-1	SQ_A500_2X2_0.109T	2
13	SWIV-055-000	Swivel Table Frame Leg - Left	A-1	SQ_A500_2X2_0.109T	2
14	SWIV-055-001	Swivel Table Frame Leg - Right	A-1	SQ_A500_2X2_0.109T	2
15	SWIV-056-000	SWIVEL SEAT MIDDLE PLATE	A-1	SM_A36_0.1345T	4
16	SWIV-057-000	TOP PLATE	A-1	SM_A36_0.25T	4
17	SWIV-057-001	BOTTOM PLATE	A-1	SM_A36_0.25T	4
18	SWIV-058-000	TABLE CHAIR BRACKET	A-1	SM_A36_0.25T	4
19	SWIV-059-000	SWIVEL HINGE BRACKET	A-1	SM_A36_0.25T	8
20	SWIV-060-000	Pivot Tube	A-1	CR_A500_0.75x0.62	4
21	SWIV-061-000	Seat Telescopic Tube	A-1	SQ_A500_1.5X1.5_0.105T	4
22	SWIV-062-000	INNER SEAT CHANNEL	A-1	SM_A36_0.1345T	4
23	SWIV-063-000	SEAT PLATE	A-1	SM_A36_0.1345T	4
24	SWIV-900-000	Wooden Seat	A-1	Wood_2T	4
25	SWIV-901-000	Pine Wood Top	A-1	Wood_2T	1

\*\* 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


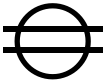


SQ = Square tube profile  
RT = Rectangle tube profile  
CR = Circle tube profile  
AG = Angle tube profile  
SM = Sheet Metal

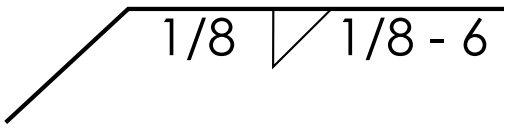
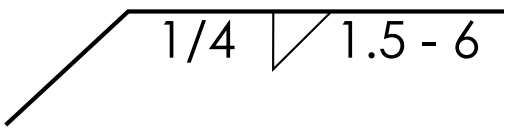
### Material Thickness

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

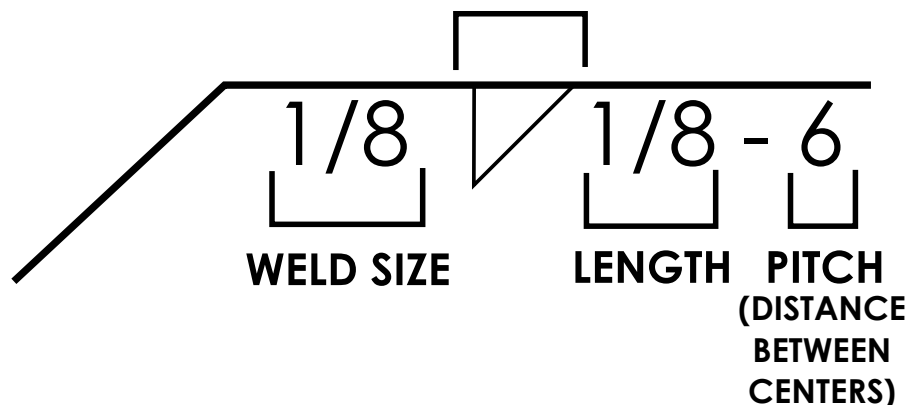
# AWS SYMBOLS

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

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

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

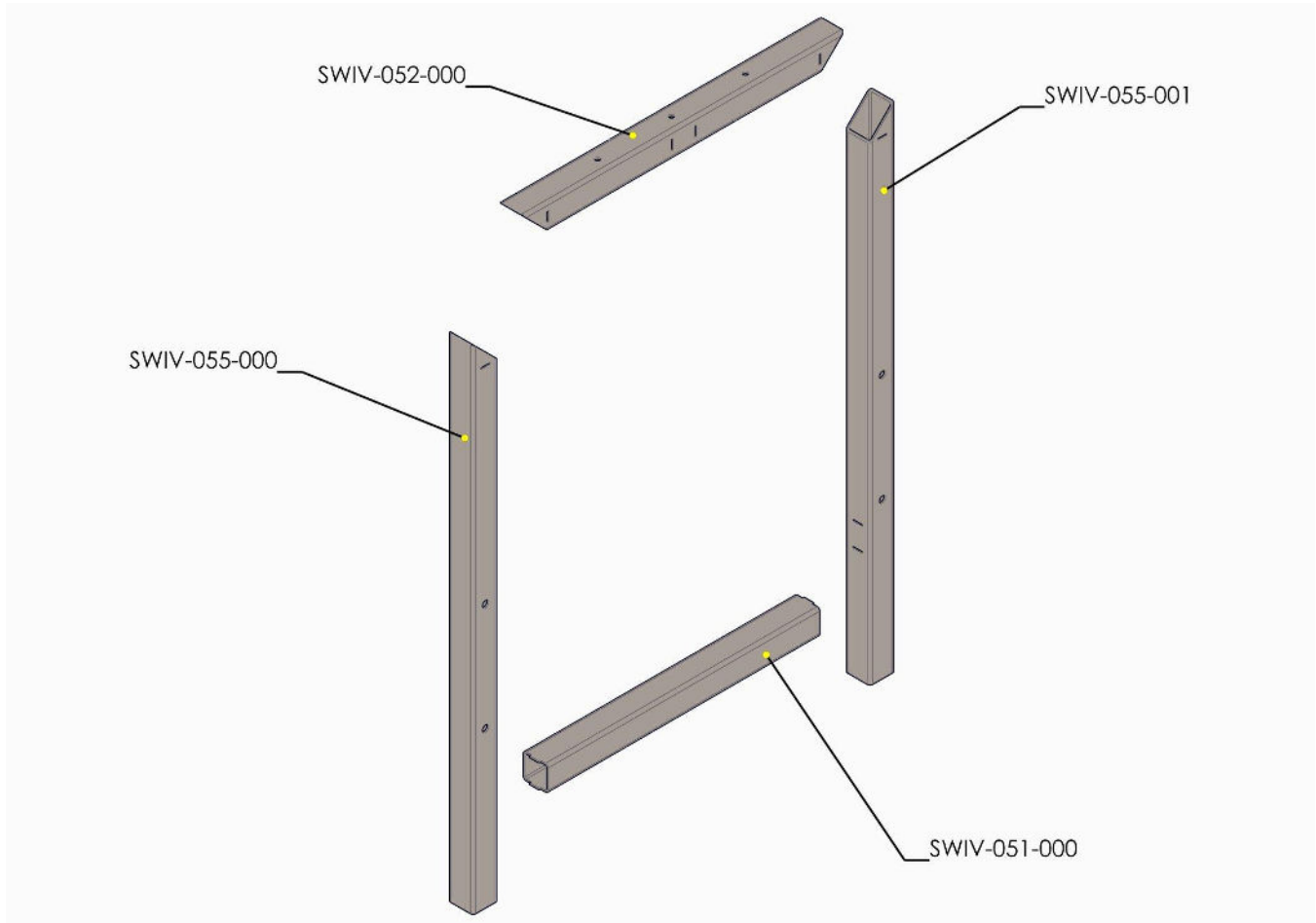
## WELD SYMBOL



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).

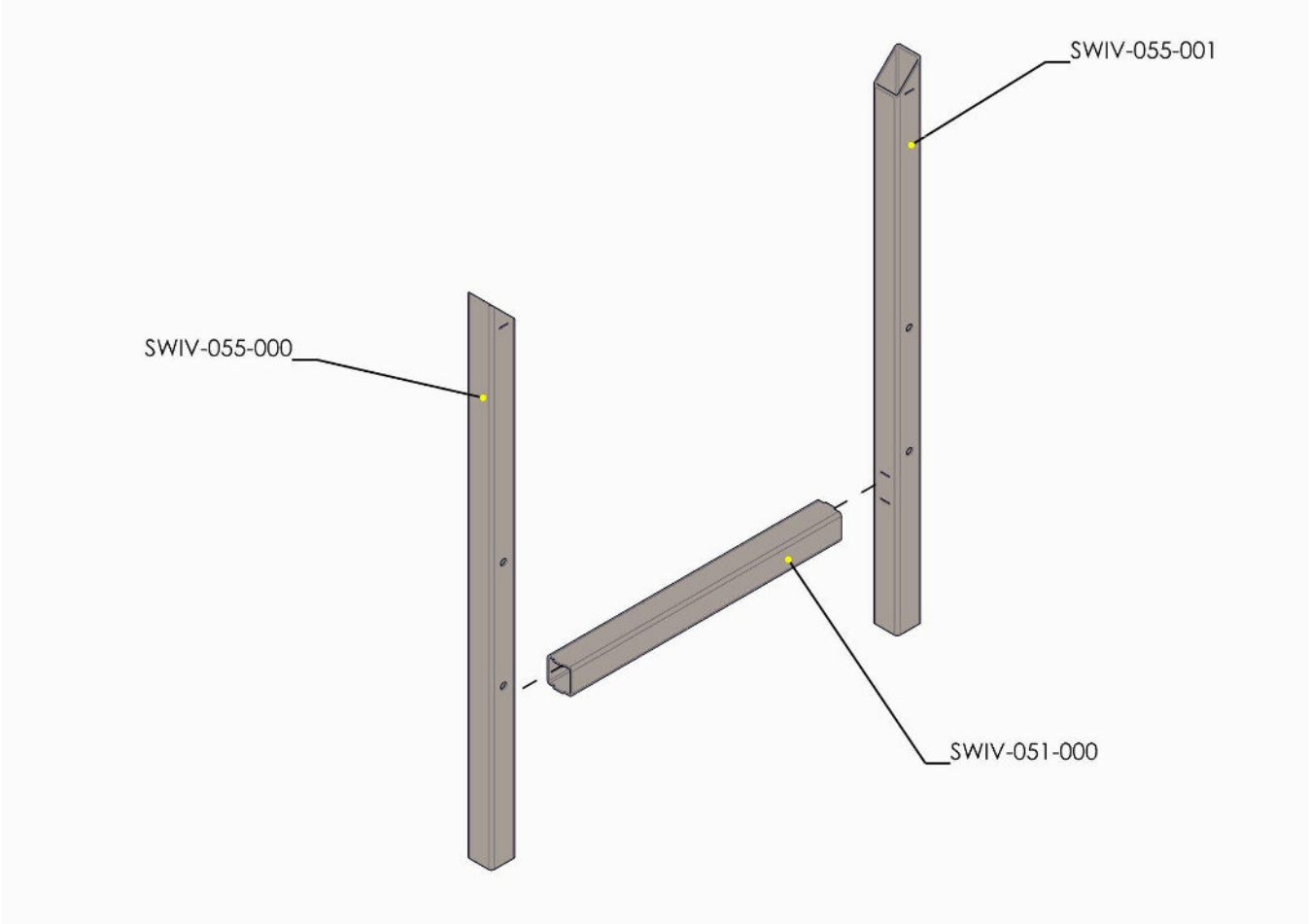
# ASSEMBLY INSTRUCTIONS

## 1



### NOTES:

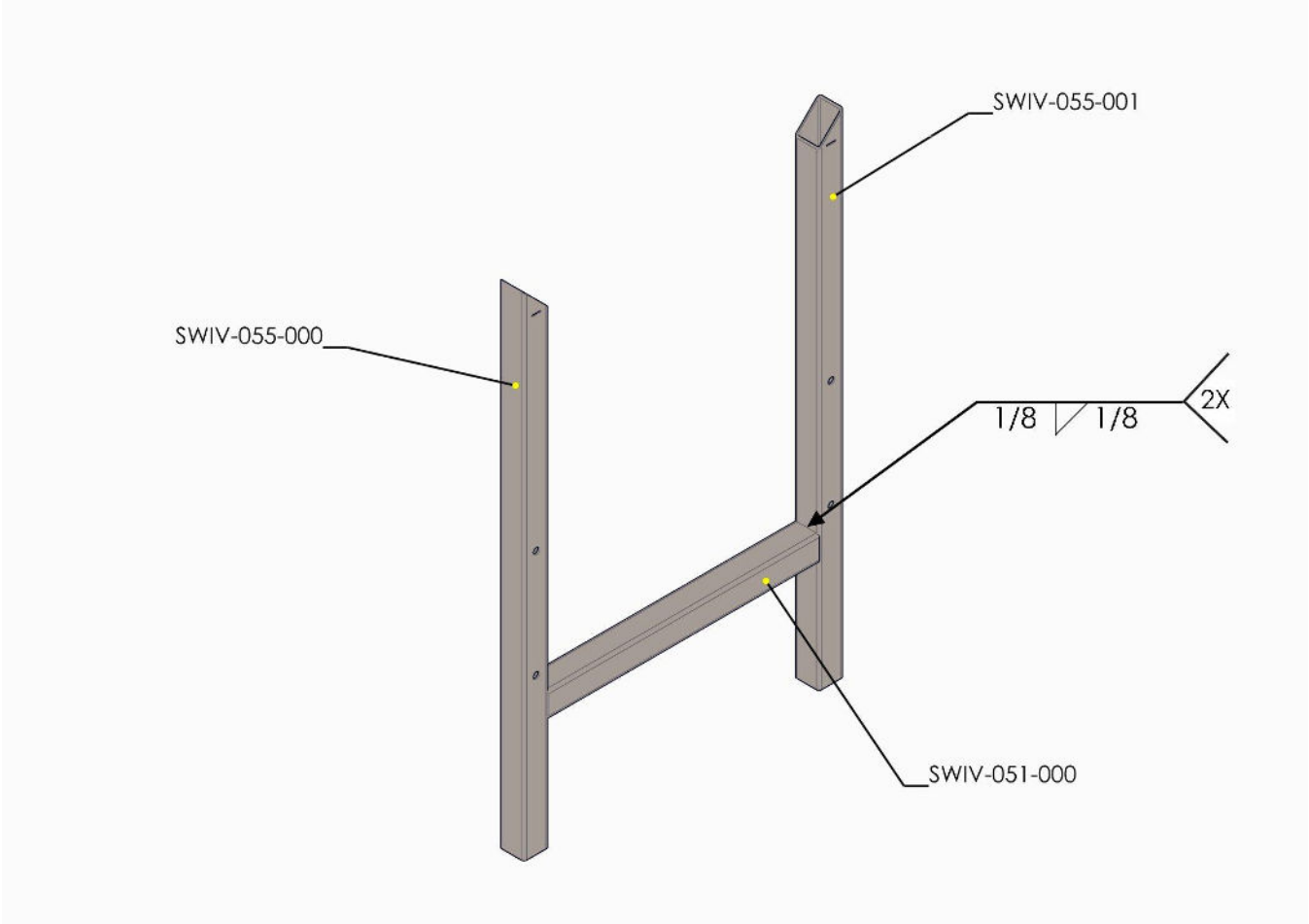
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NOTES:

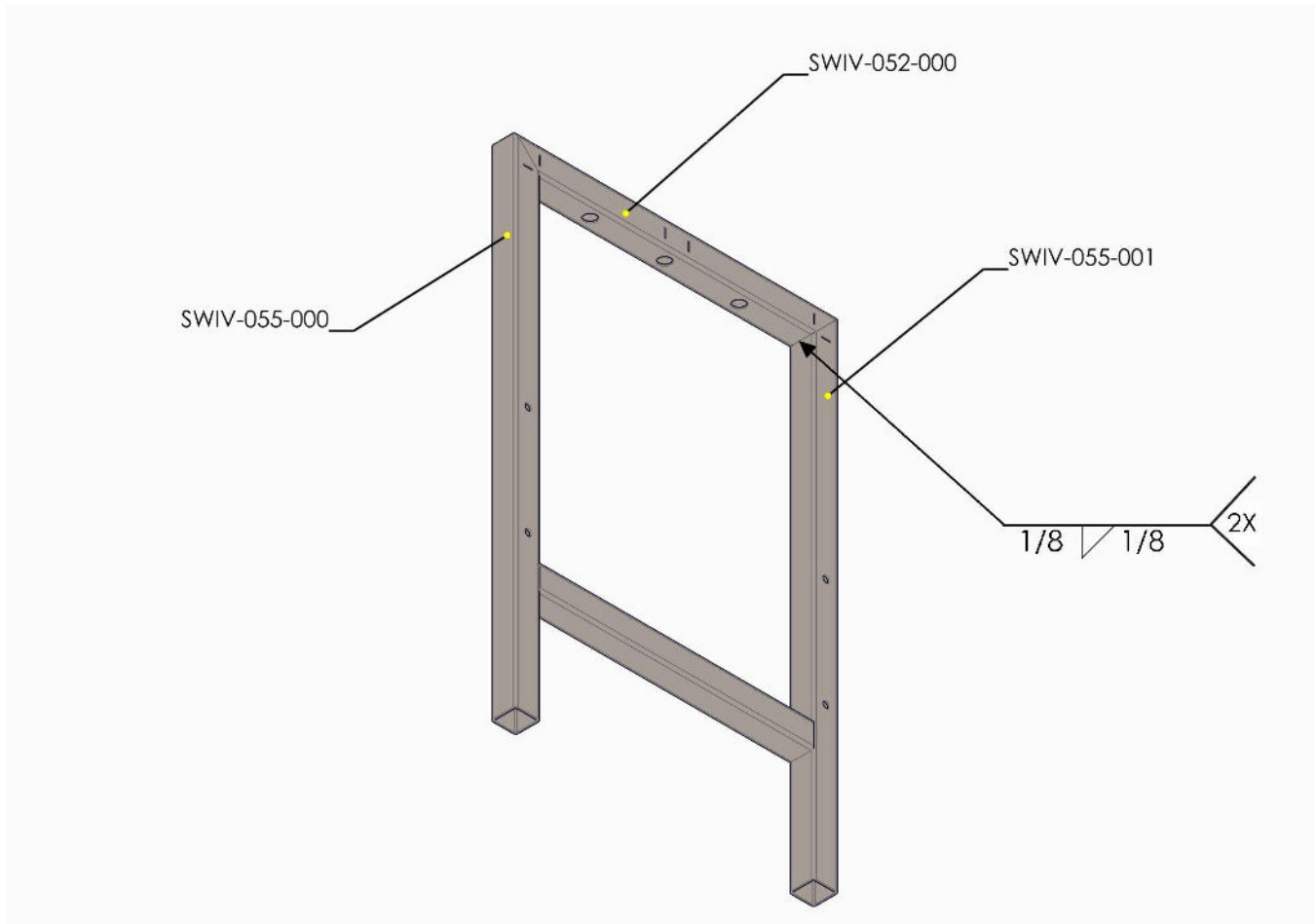


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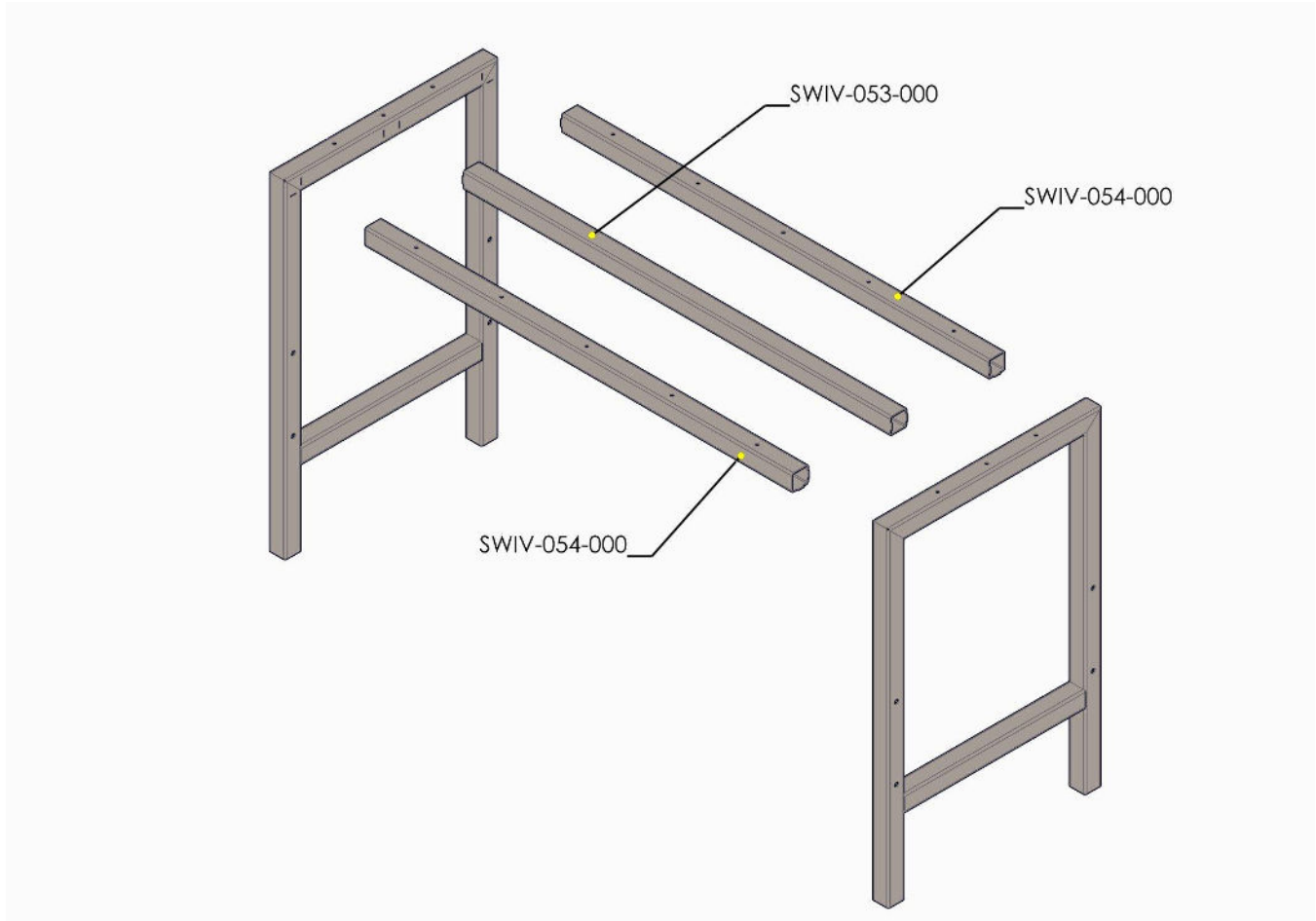


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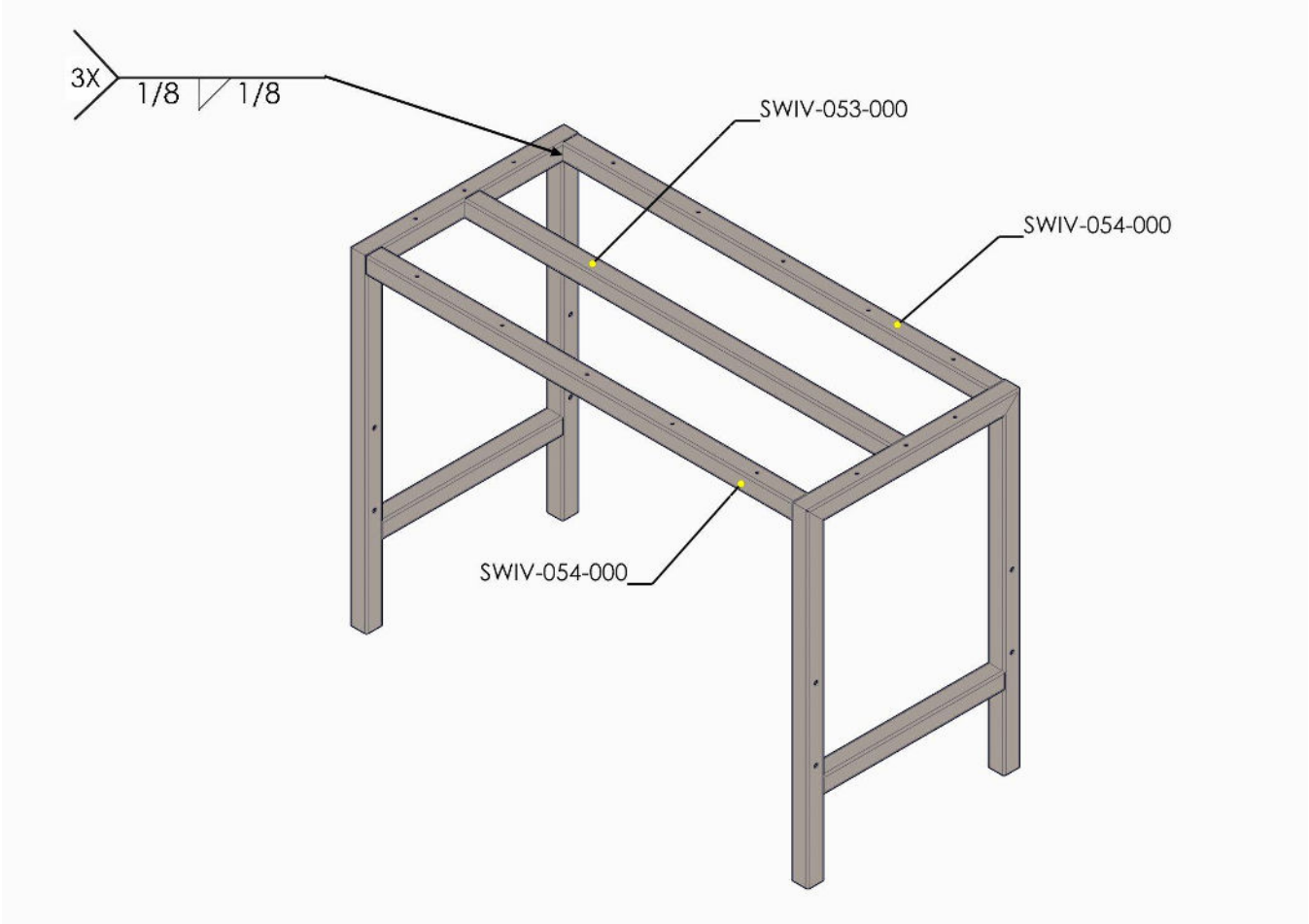
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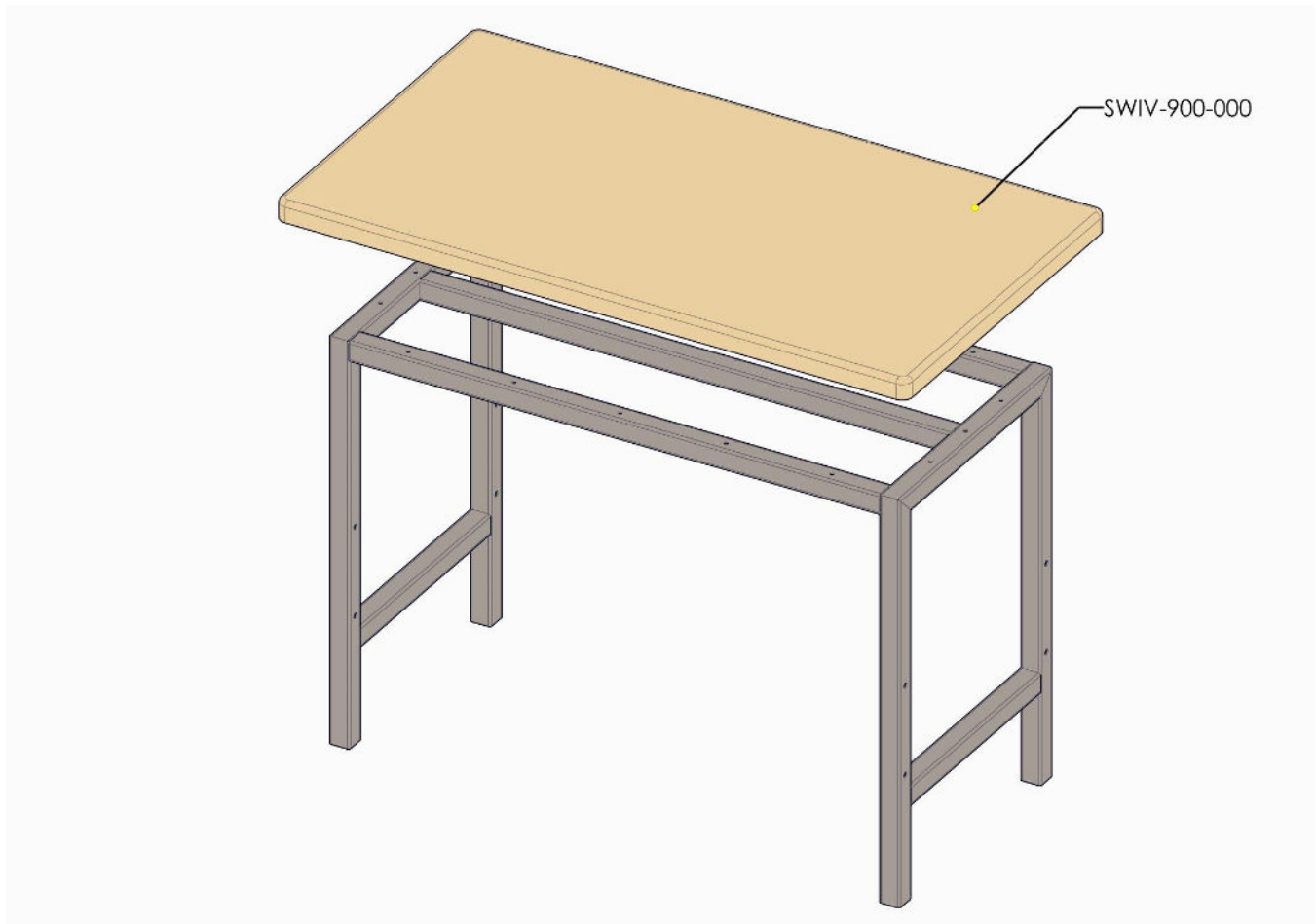


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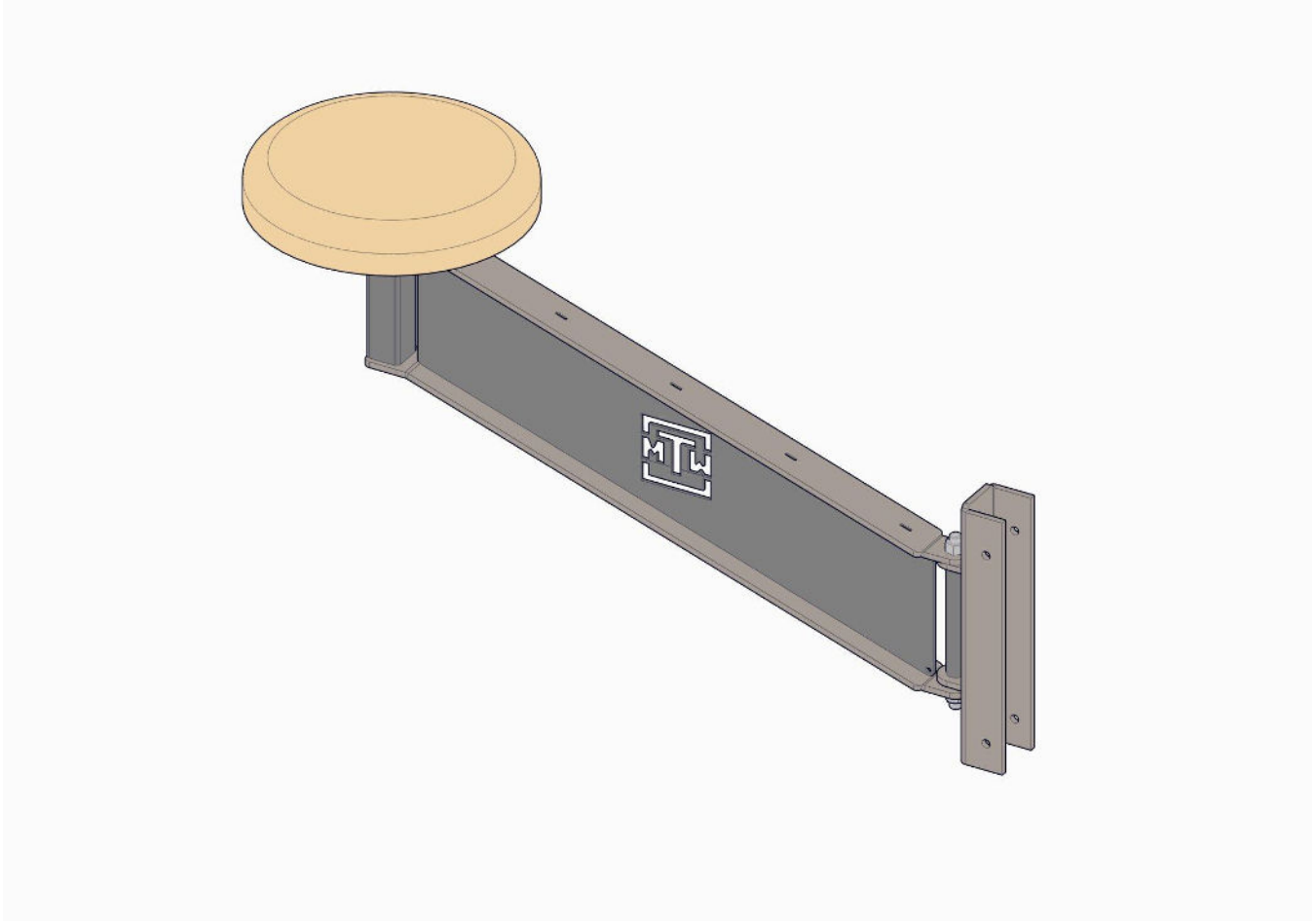
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**NOTES:**

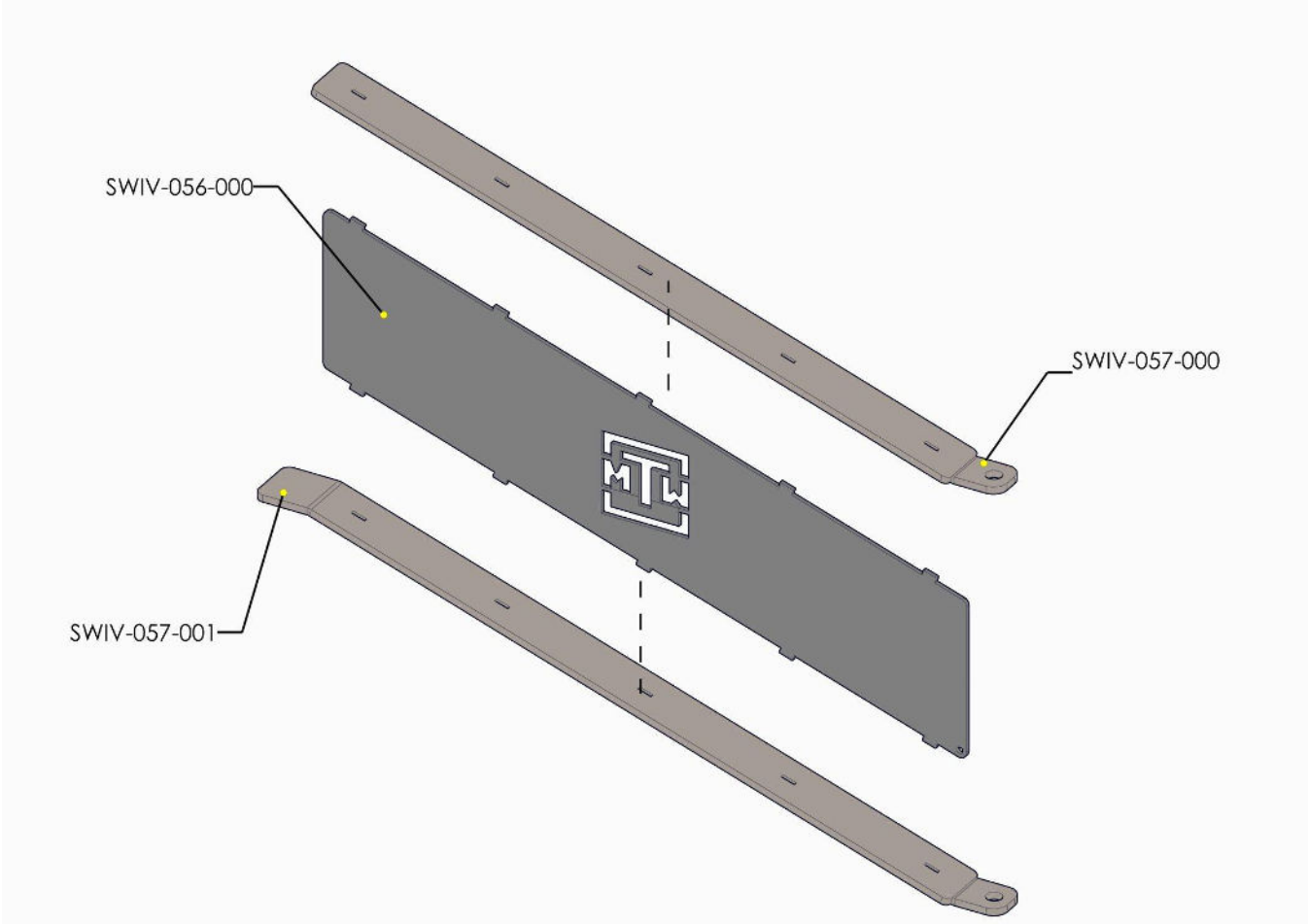
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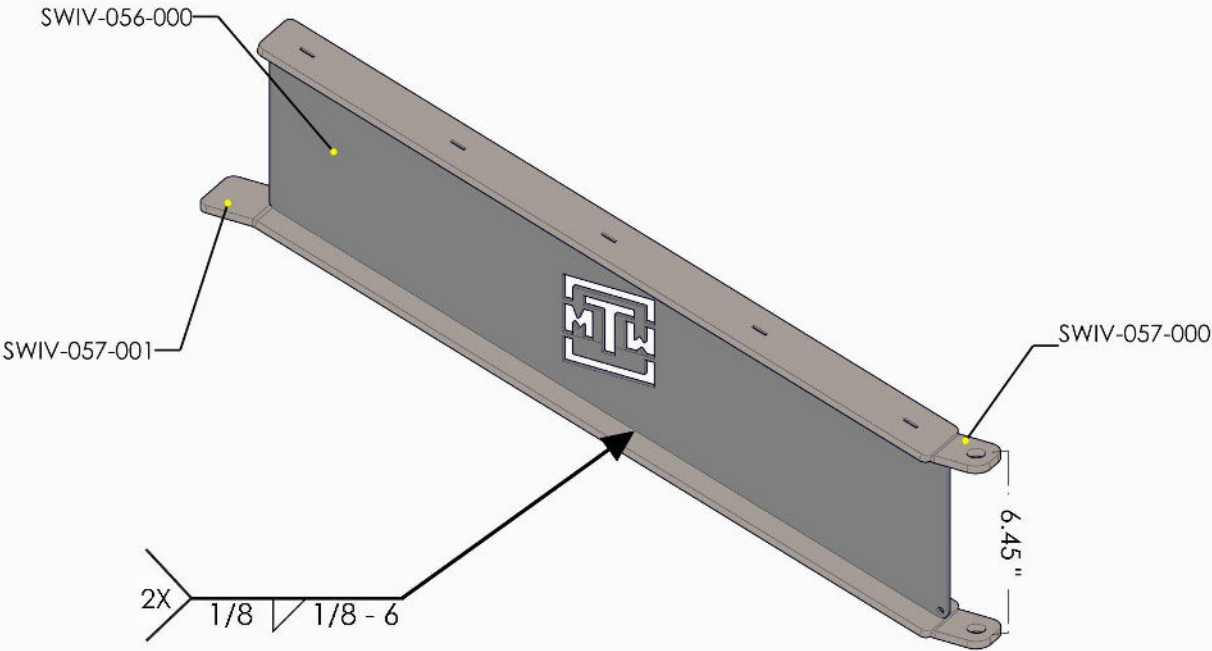
**NOTES:**

9



**NOTES:**

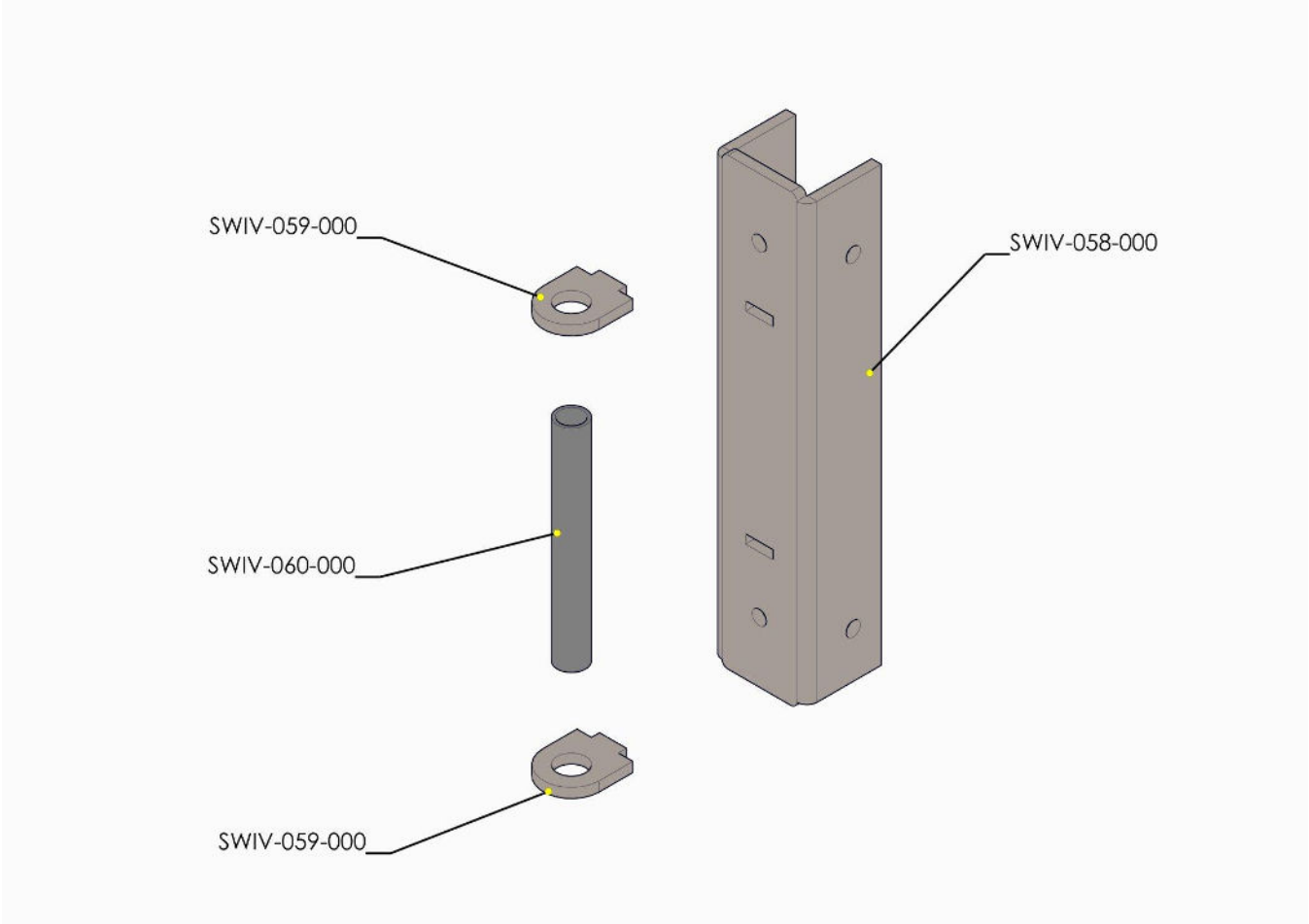
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**NOTES:**

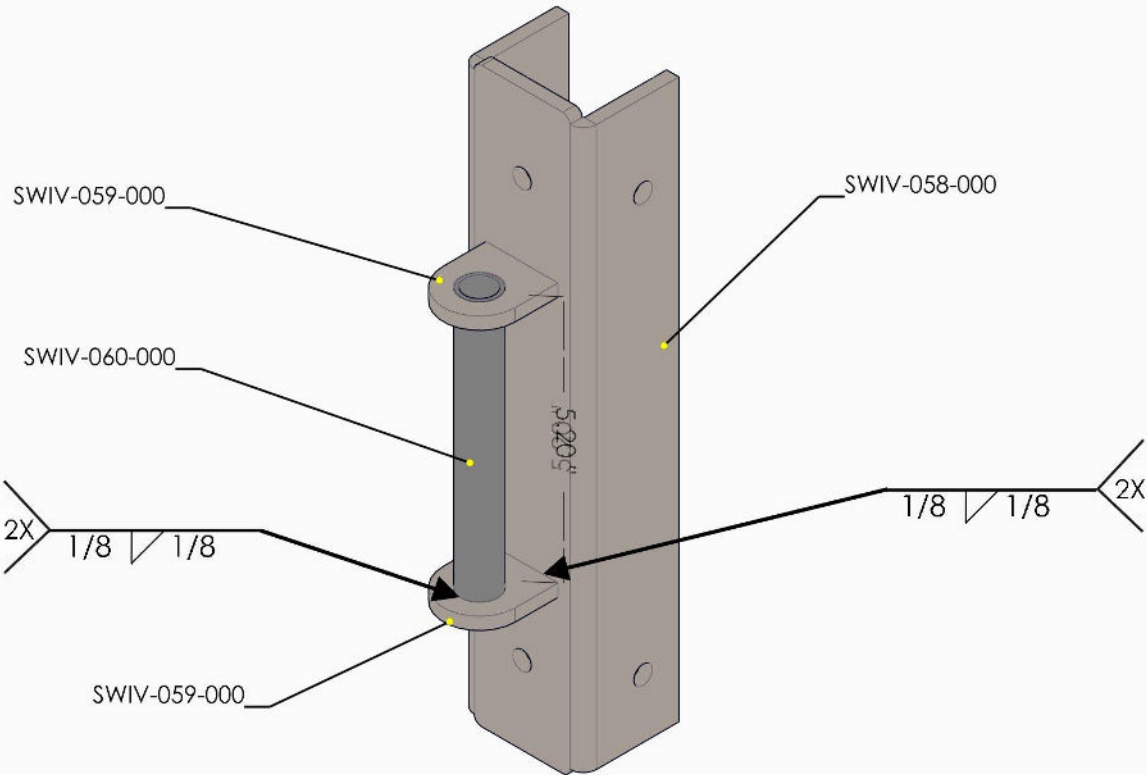


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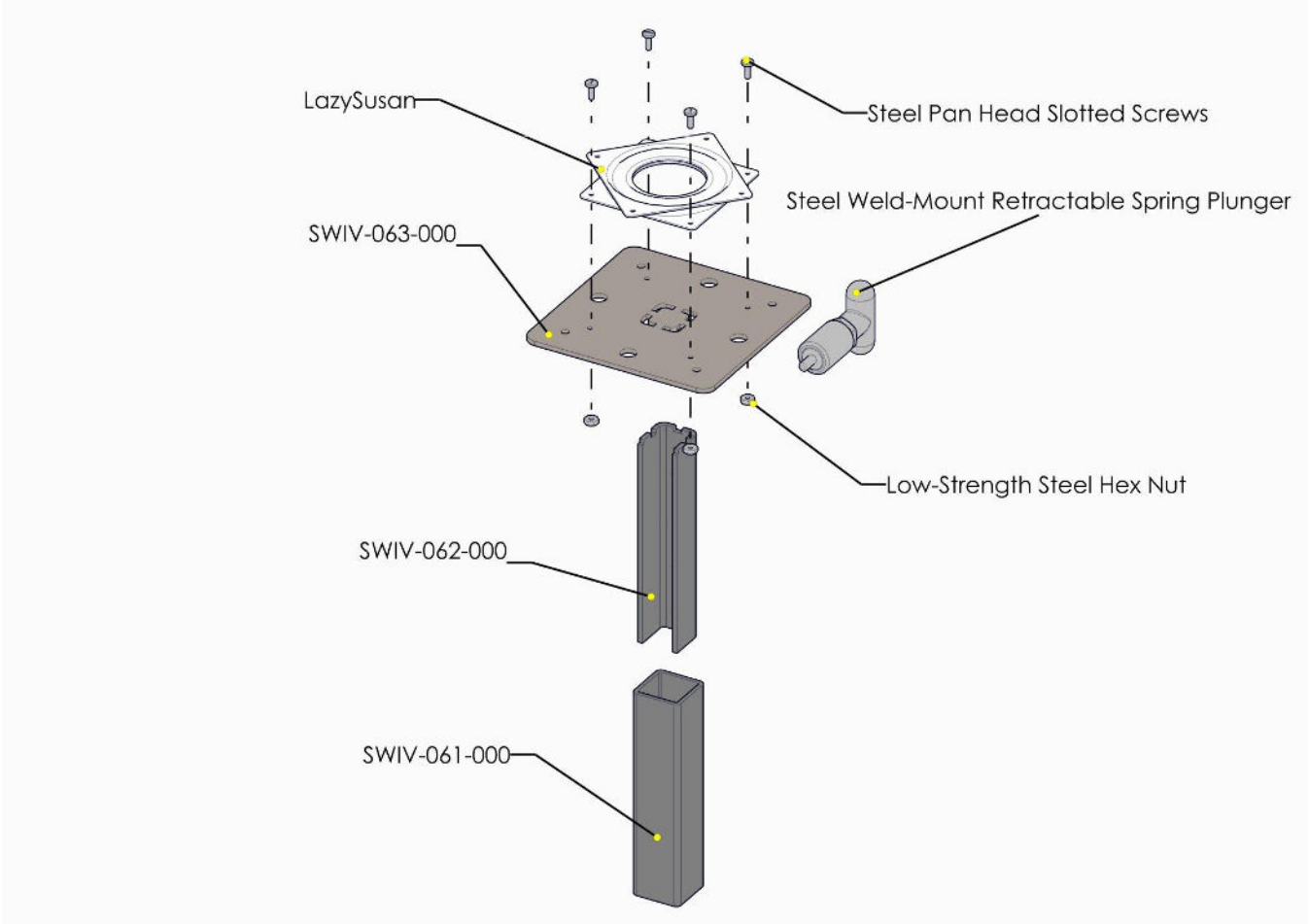
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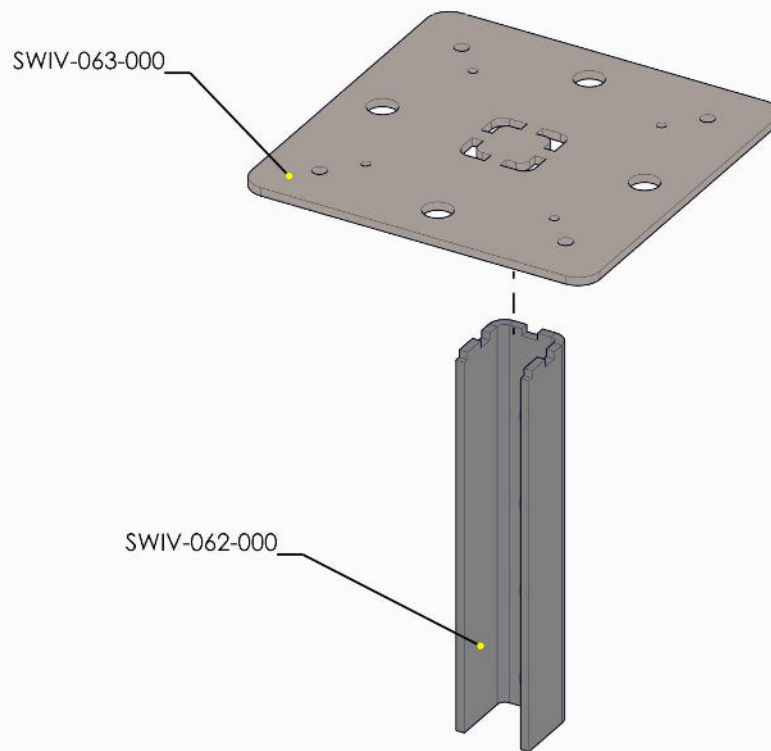
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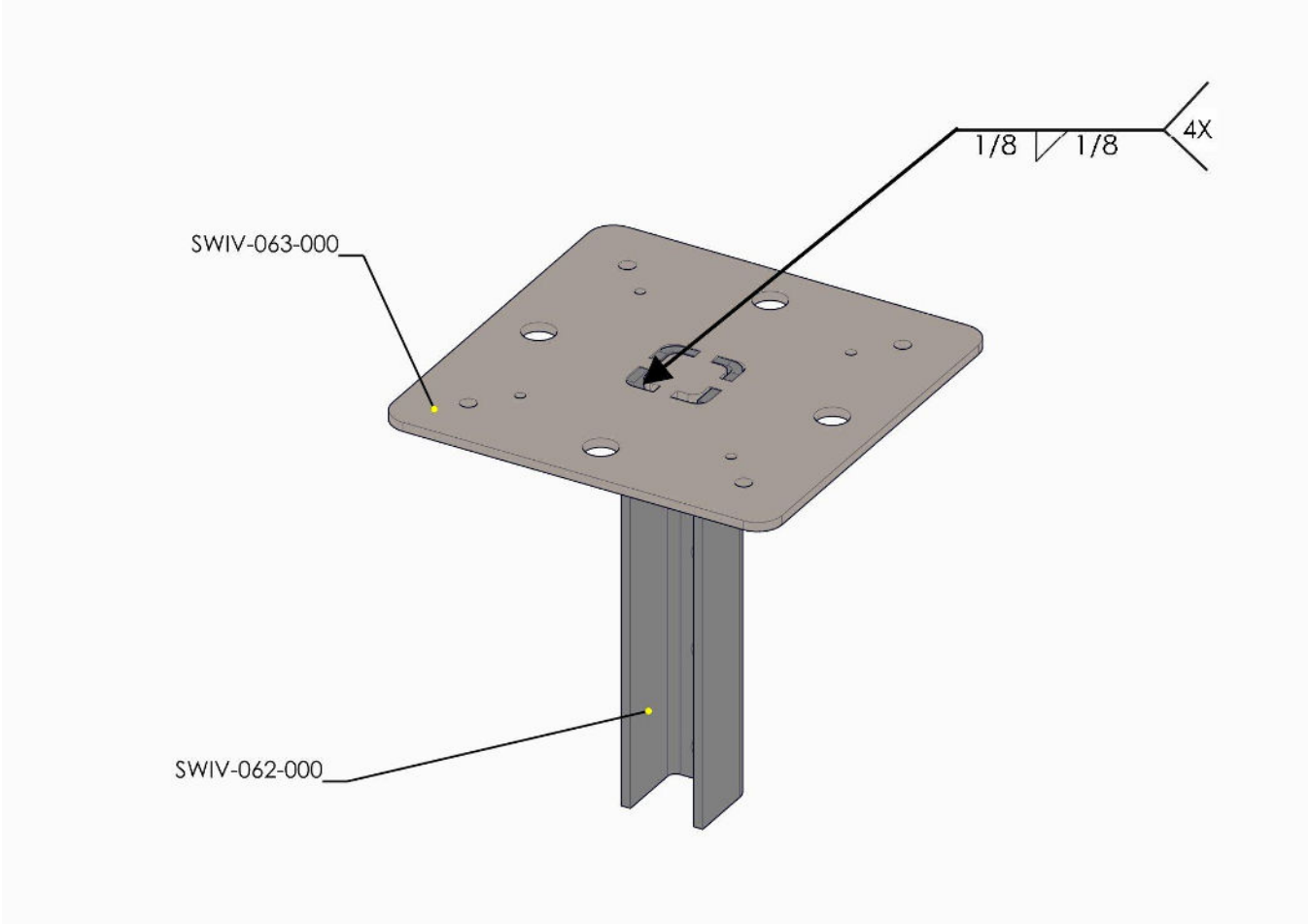
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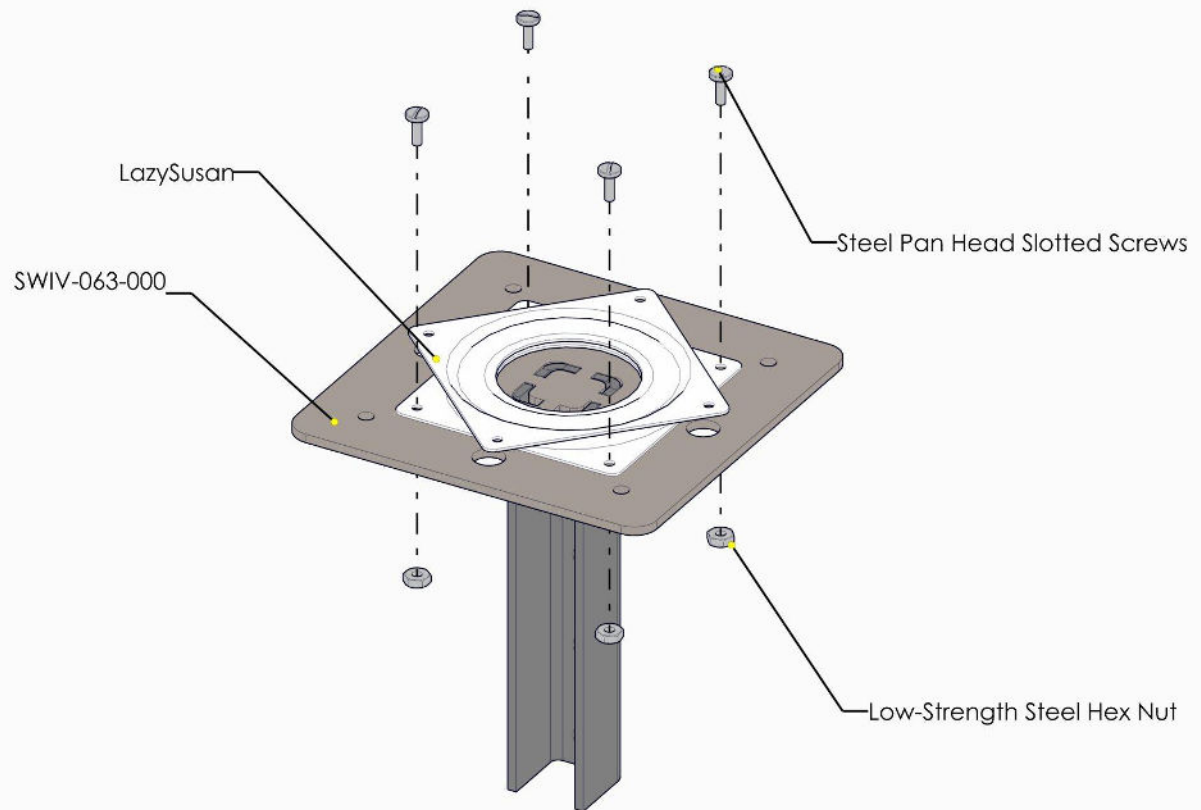
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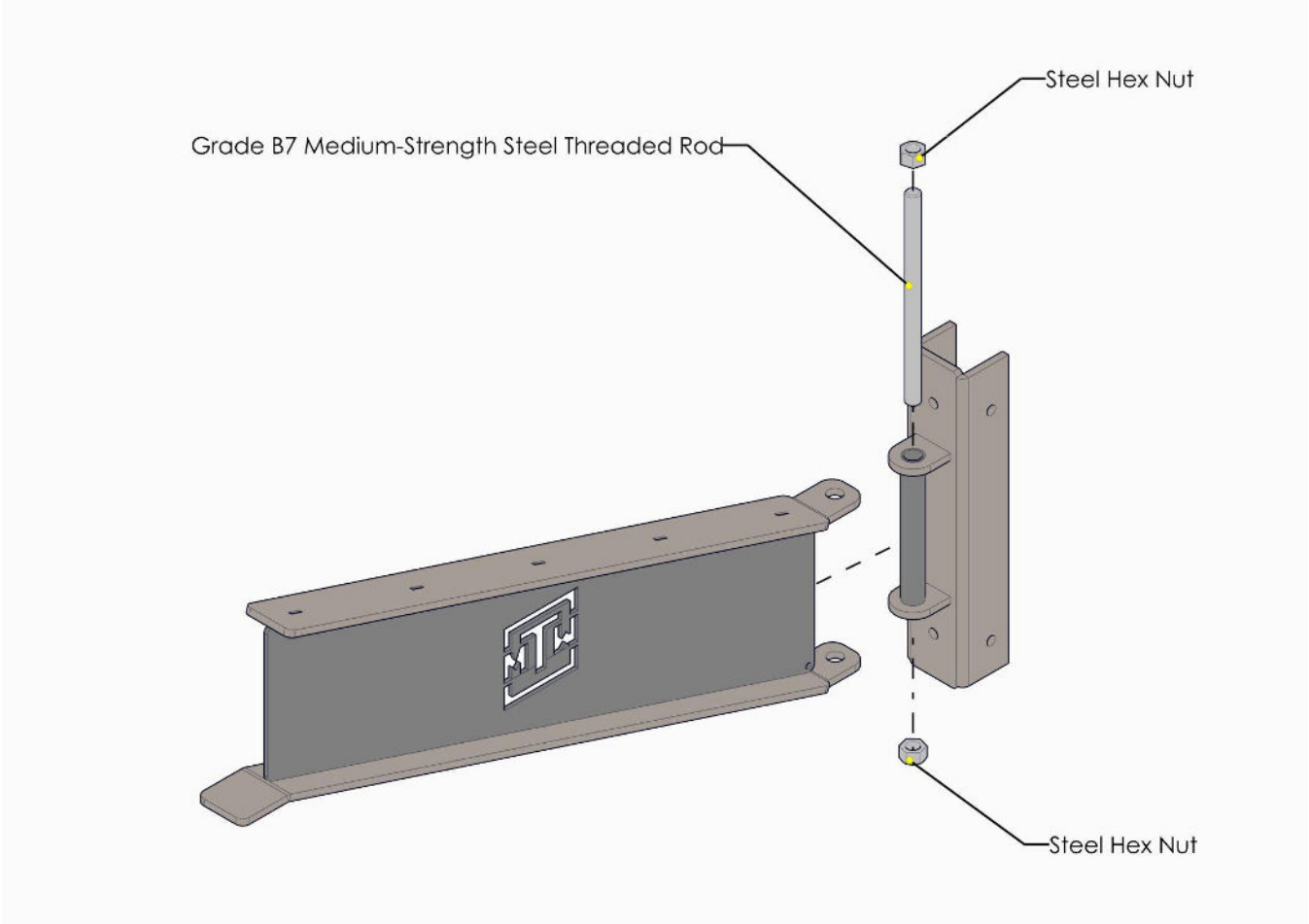
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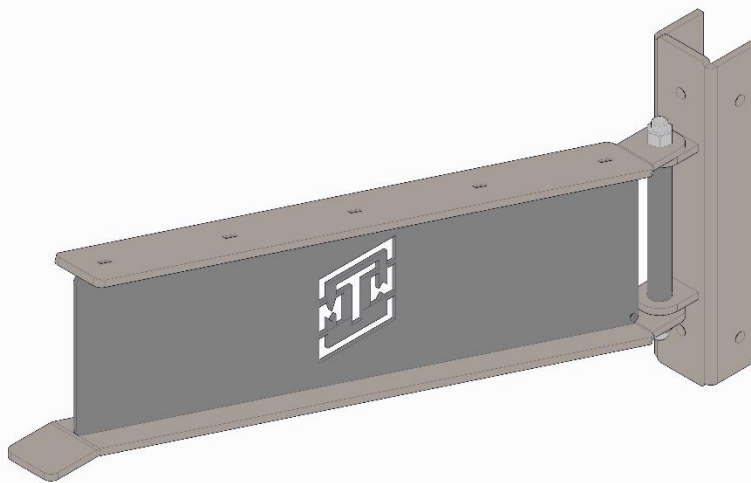
## NOTES:

17



**NOTES:**

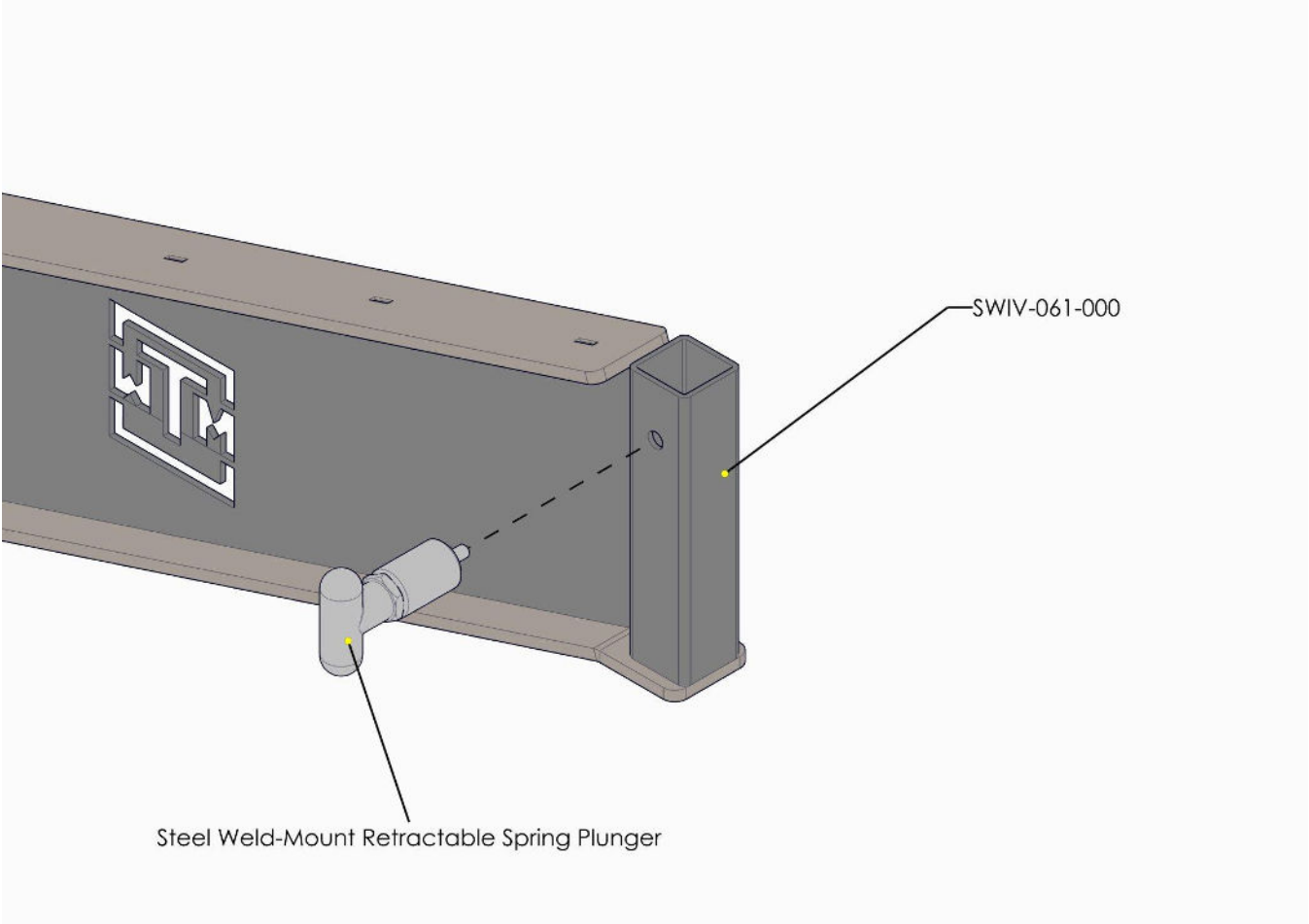
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## NOTES:

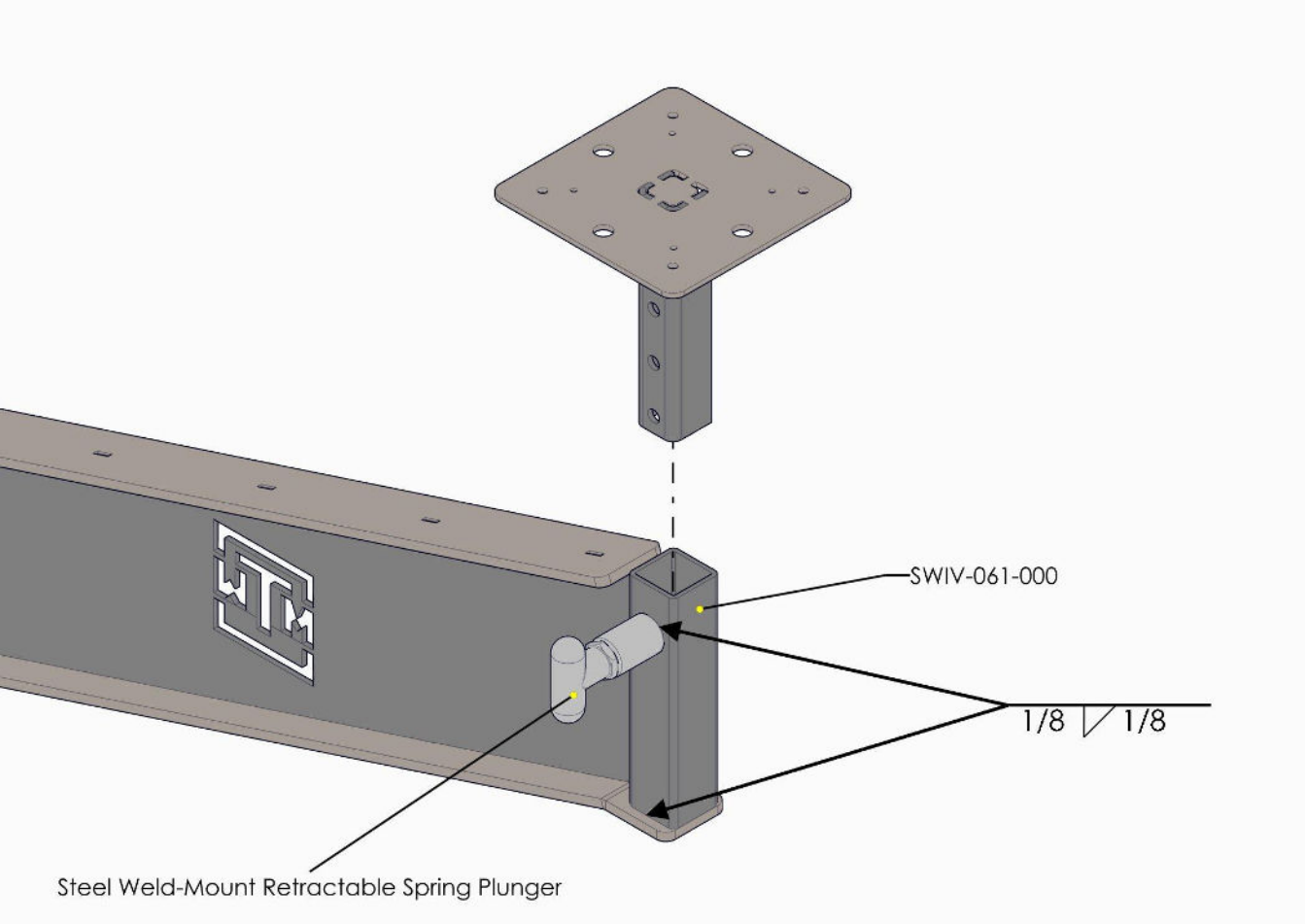


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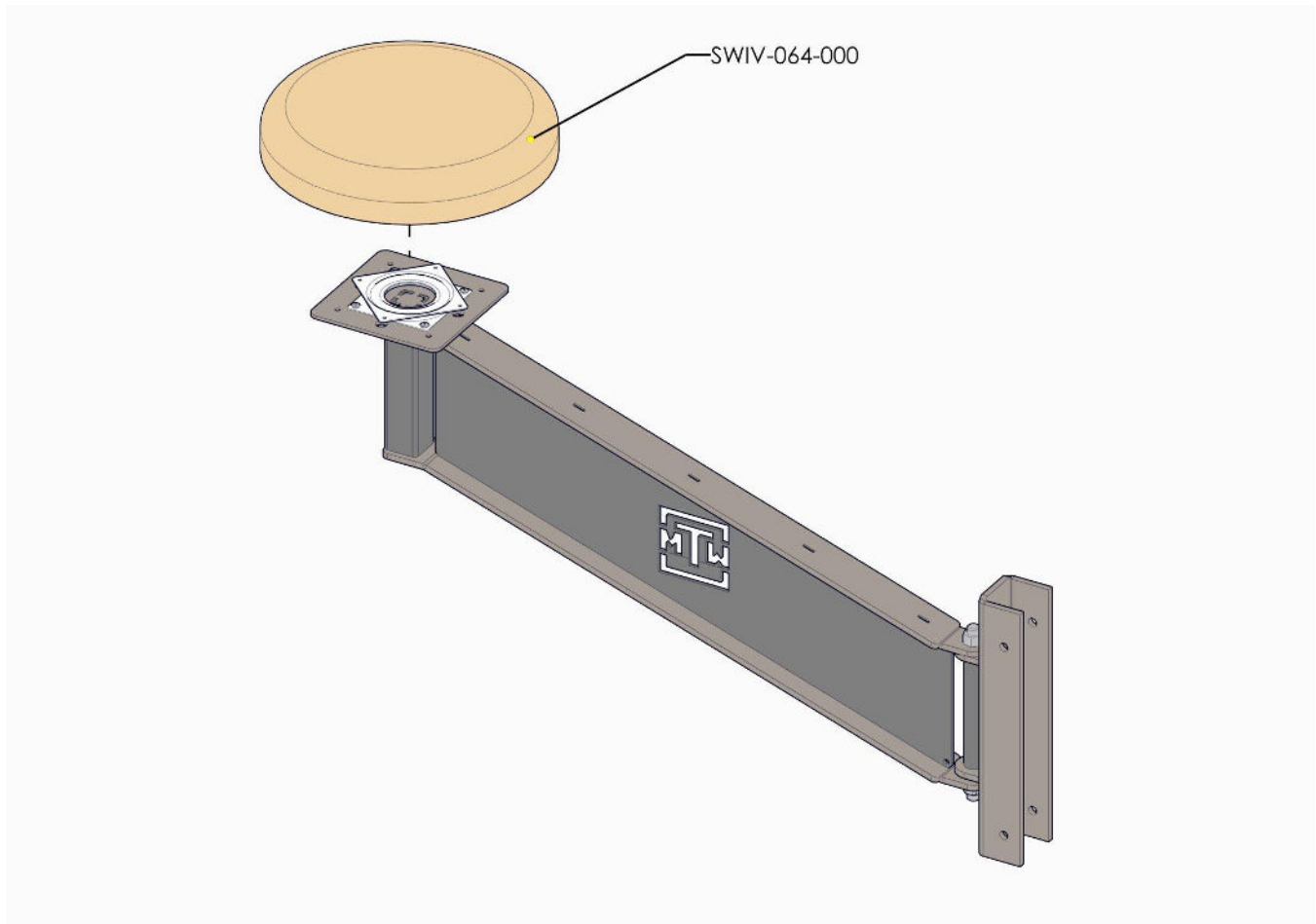
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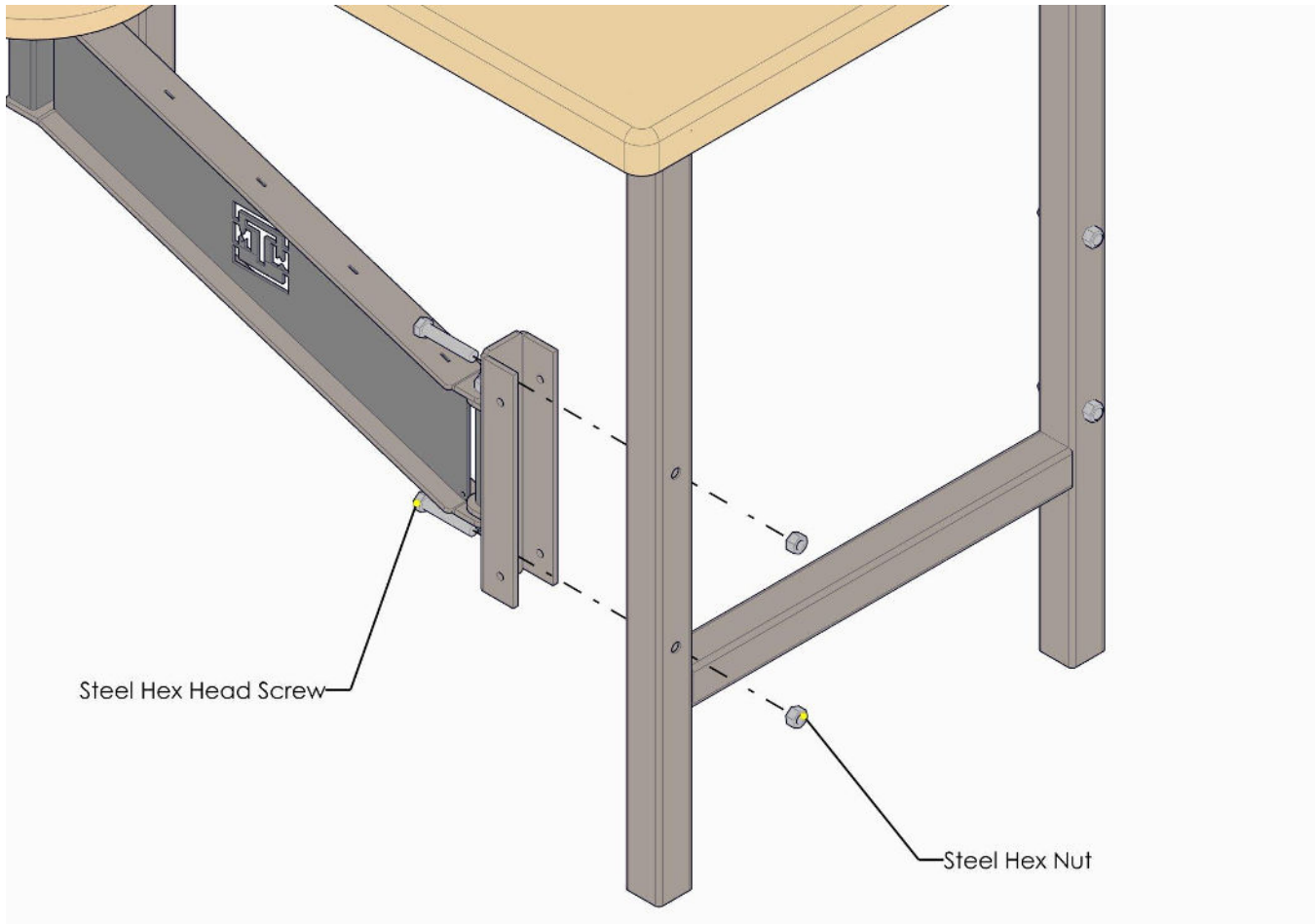
**NOTES:**

# 21

**NOTES:**

**FOR REMAINING SEATS, REPEAT STEPS 9 TRHU 21**

# 23



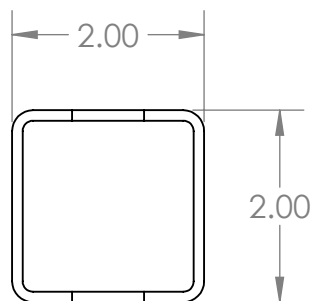
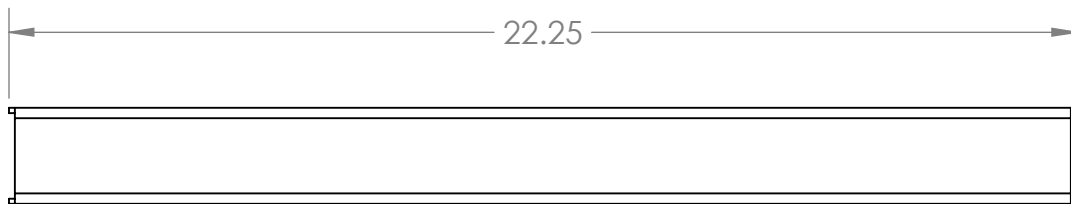
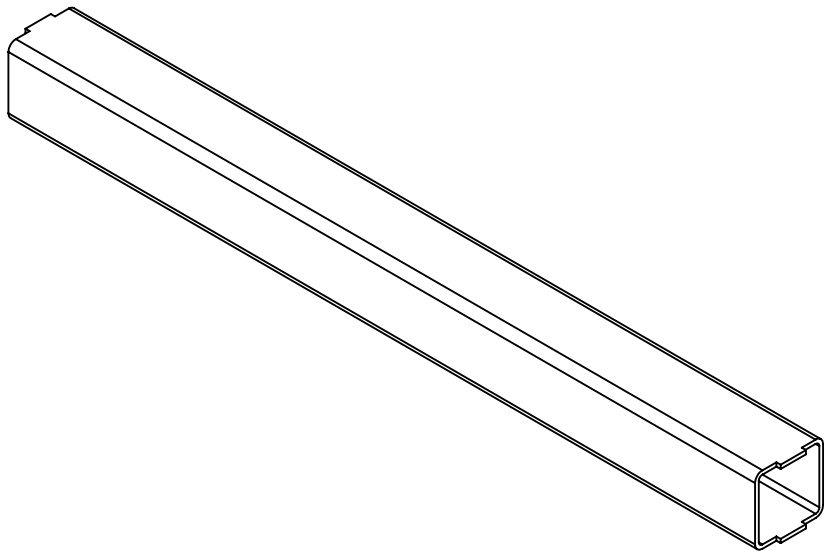
## NOTES:

**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**

# PART DRAWINGS

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

**WELD PROJECTS** COM

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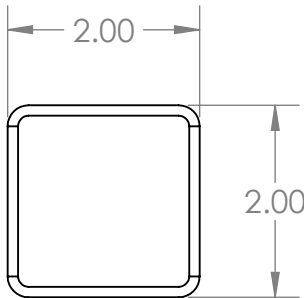
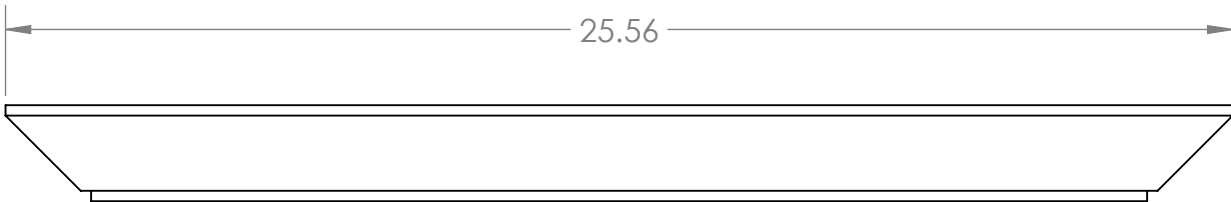
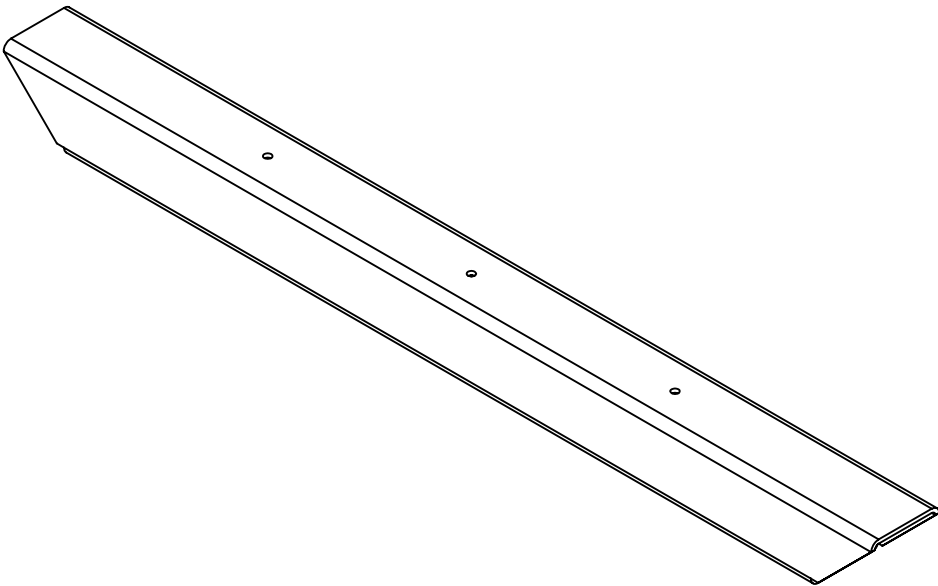
**PART #**  
SWIV-051-000

**MATERIAL**  
SQ\_A500\_2X2\_0.109T

**DESCRIPTION :**  
Swivel Table Frame Bottom Reacher

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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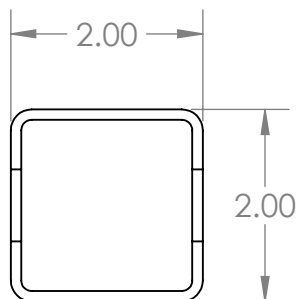
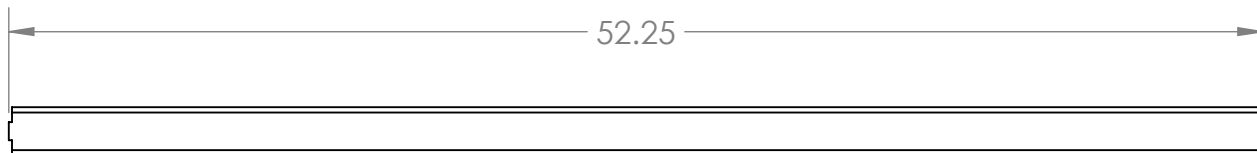
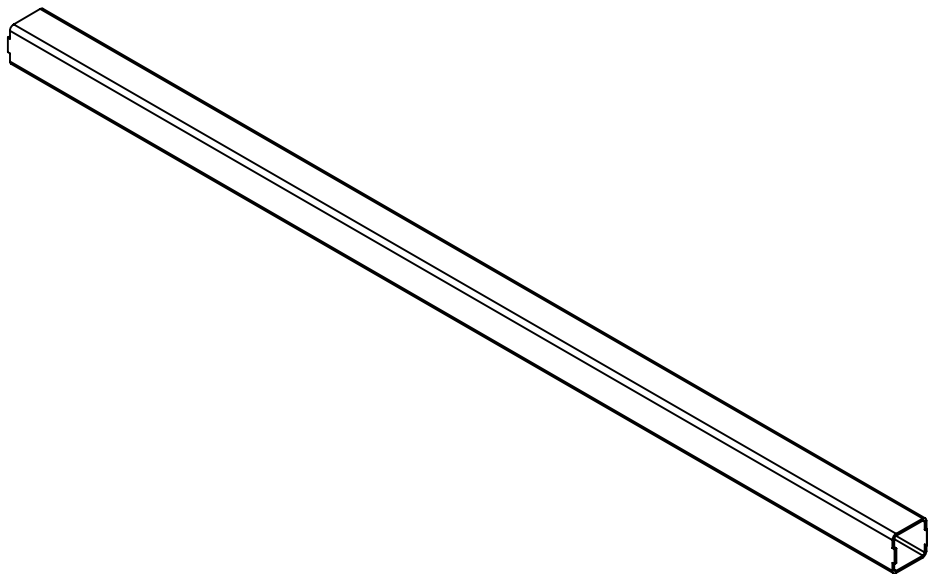
PART #  
SWIV-052-000

MATERIAL  
SQ\_A500\_2X2\_0.109T

DESCRIPTION :  
Swivel Table Frame Top Reacher

DRAWN BY: MMoreno | 01/15/24      SHEET 1 OF 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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**PART #**  
SWIV-053-000

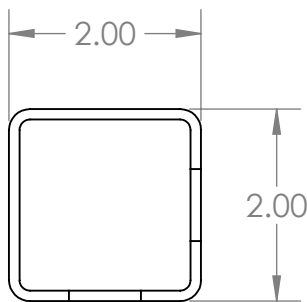
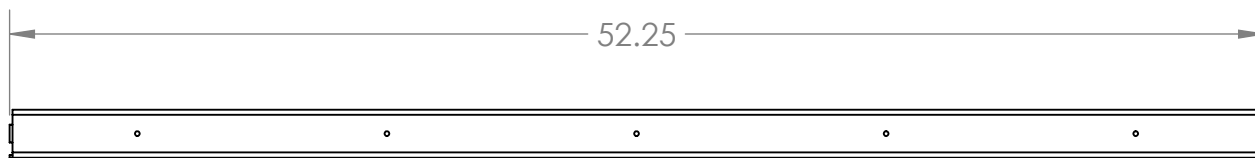
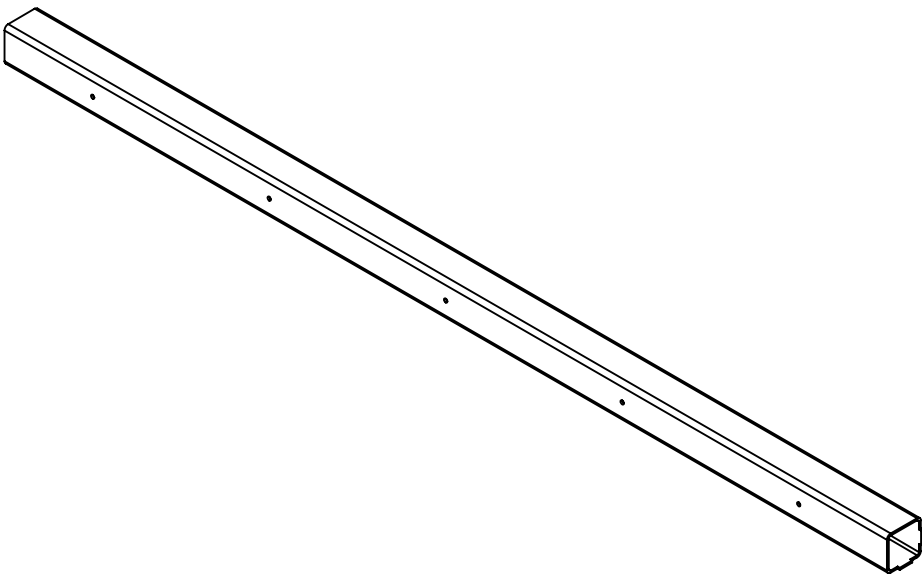
**MATERIAL**  
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**DESCRIPTION :**  
Swivel Table Frame Inner Stretcher

**DRAWN BY:** MMoreno | 01/15/24      **SHEET 1 OF 1**



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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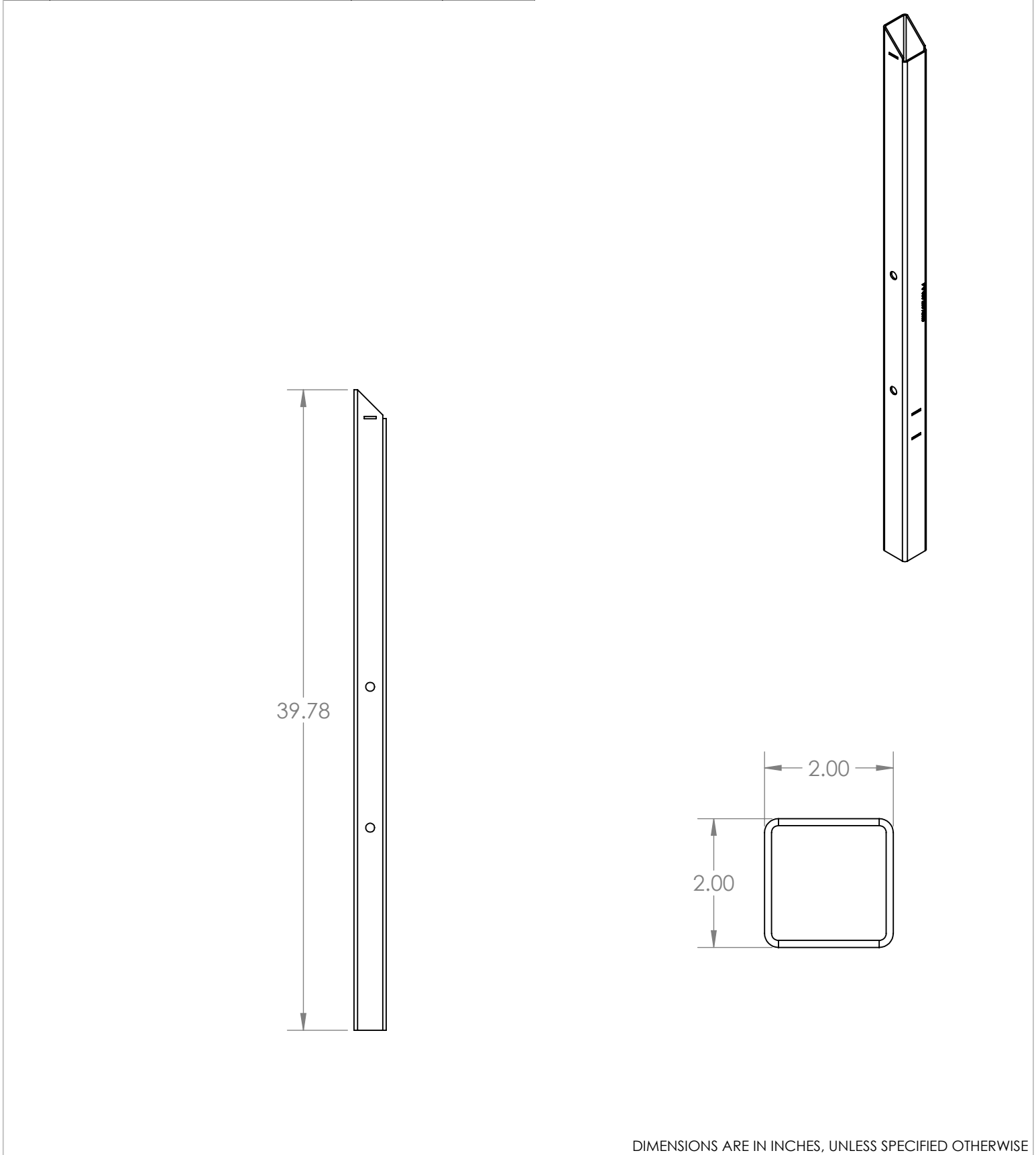
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SWIV-054-000

**MATERIAL**  
SQ\_A500\_2X2\_0.109T

**DESCRIPTION :**  
Swivel Table Frame Outer Stretcher

**DRAWN BY:** MMoreno | 01/15/24      **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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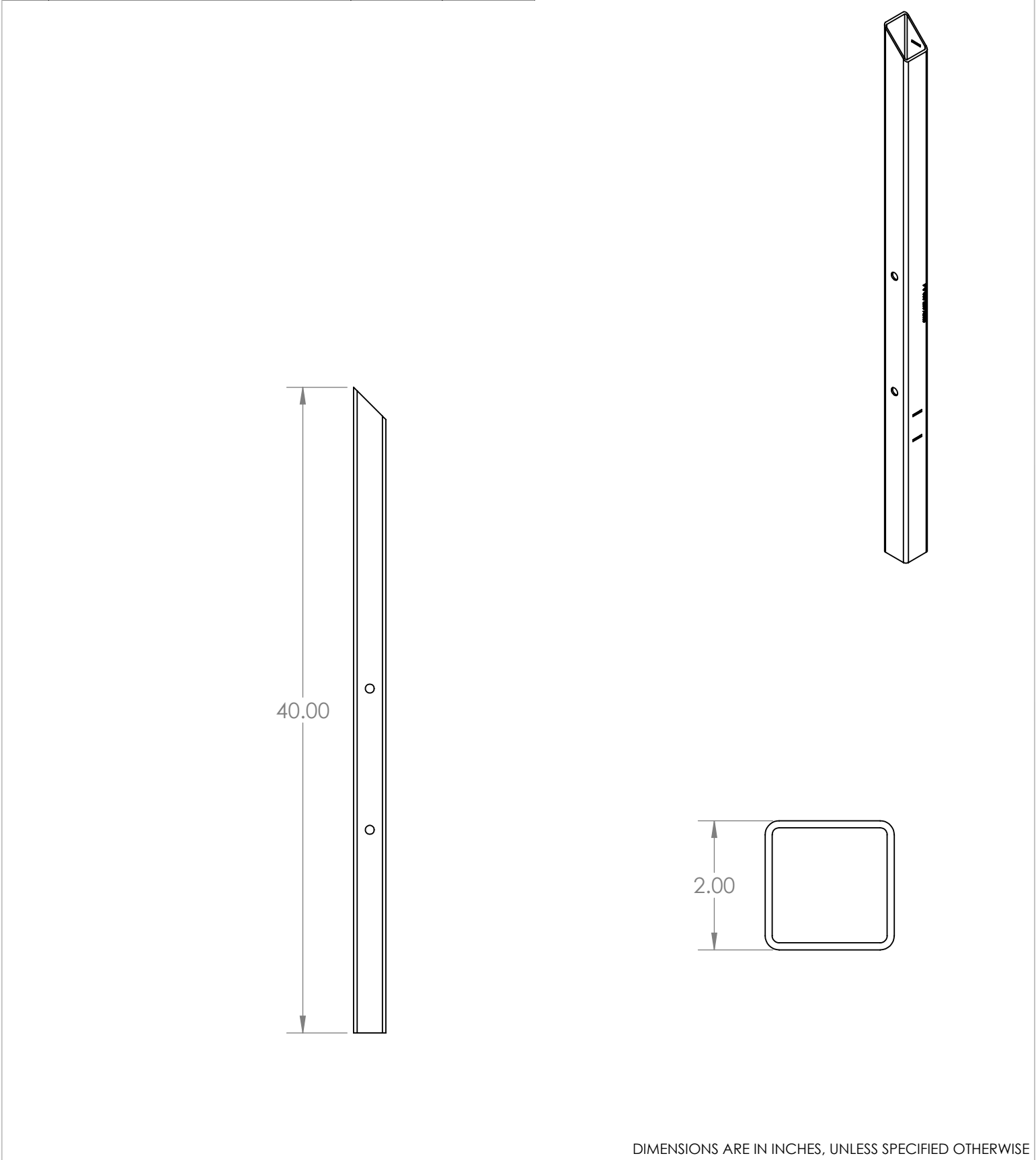
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<b>PART #</b>	<b>MATERIAL</b>
SWIV-055-000	SQ_A500_2X2_0.109T

**DESCRIPTION :**  
Swivel Table Frame Leg - Left

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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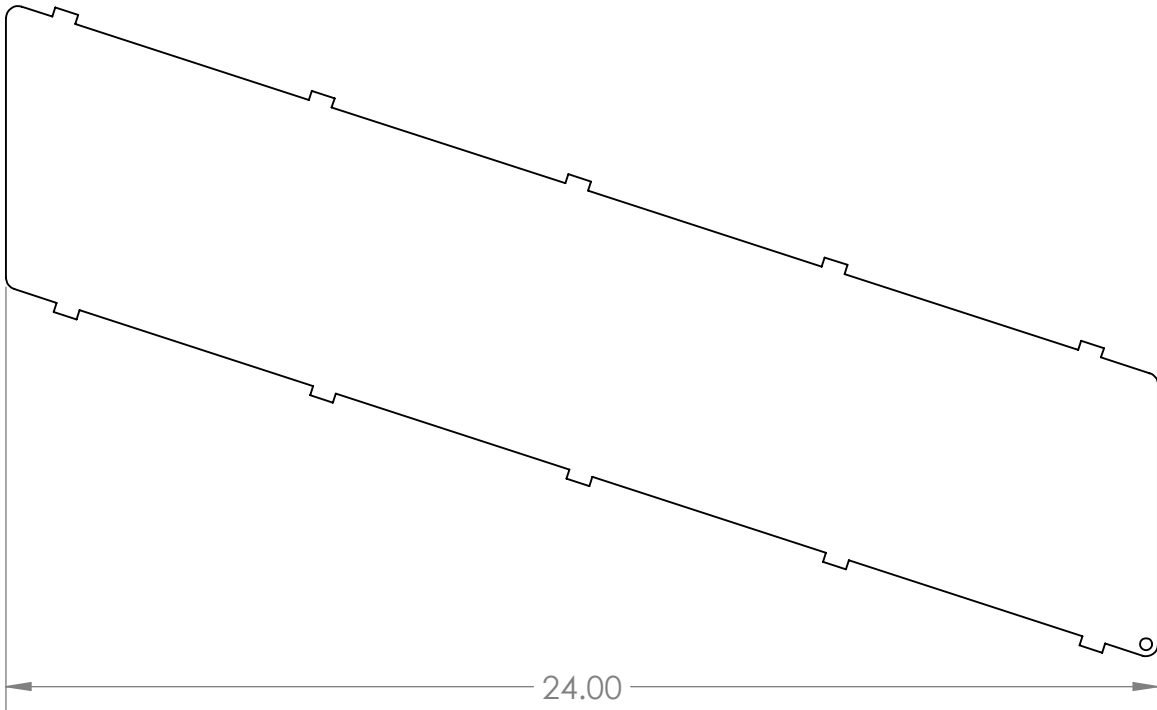
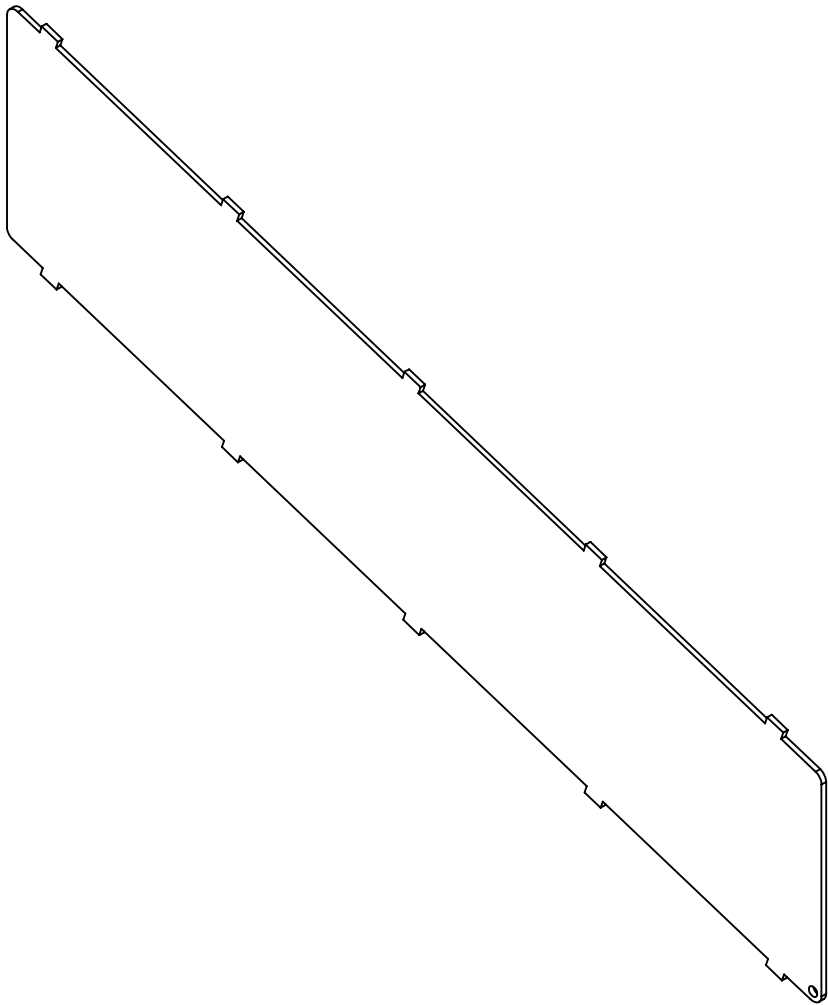
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<b>PART #</b>	<b>MATERIAL</b>
SWIV-055-001	SQ_A500_2X2_0.109T

**DESCRIPTION :**  
Swivel Table Frame Leg - Right

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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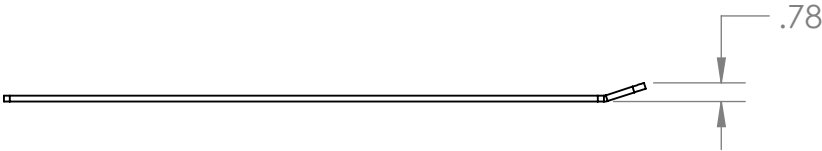
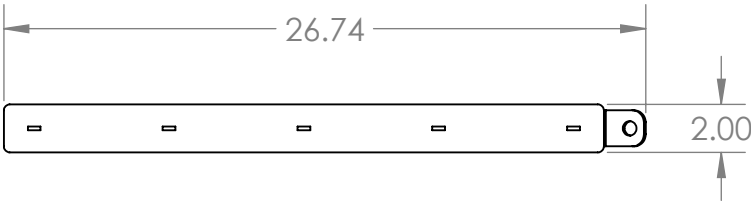
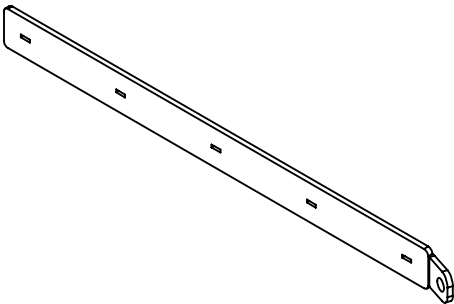
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<b>PART #</b> SWIV-056-000	<b>MATERIAL</b> SM_A36_0.1345T
-------------------------------	-----------------------------------

**DESCRIPTION :**  
SWIVEL SEAT MIDDLE PLATE

**DRAWN BY:** MMoreno | 01/15/24      **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE

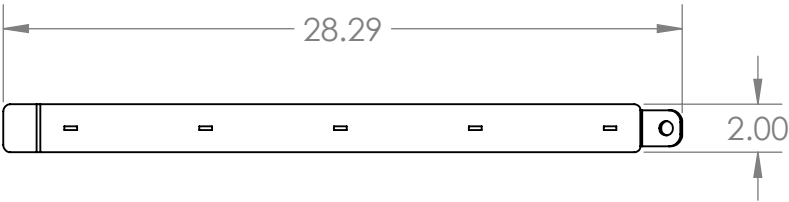
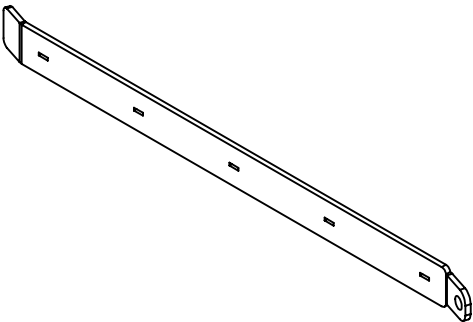


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<b>PART #</b> SWIV-057-000	<b>MATERIAL</b> SM_A36_0.25T
	<b>DESCRIPTION :</b> TOP PLATE
<b>DRAWN BY:</b> MMoreno   01/15/24	
<b>SHEET 1 OF 1</b>	

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



DIMENSIONS ARE IN INCHES, UNLESS SPECIFIED OTHERWISE



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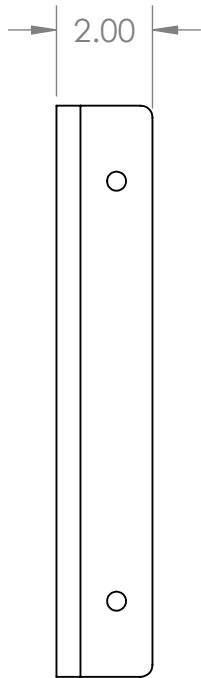
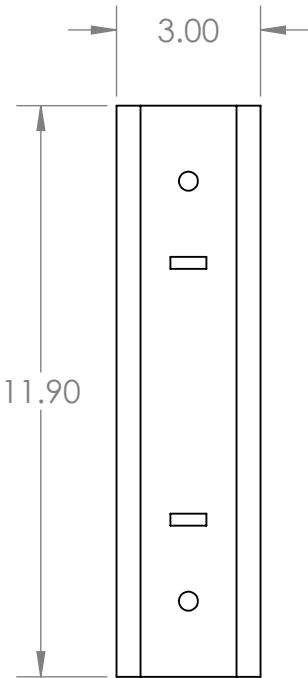
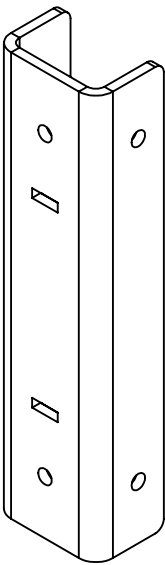
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<b>PART #</b> SWIV-057-001	<b>MATERIAL</b> SM_A36_0.25T
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**DESCRIPTION :**  
BOTTOM PLATE

**DRAWN BY:** MMoreno | 01/15/24      **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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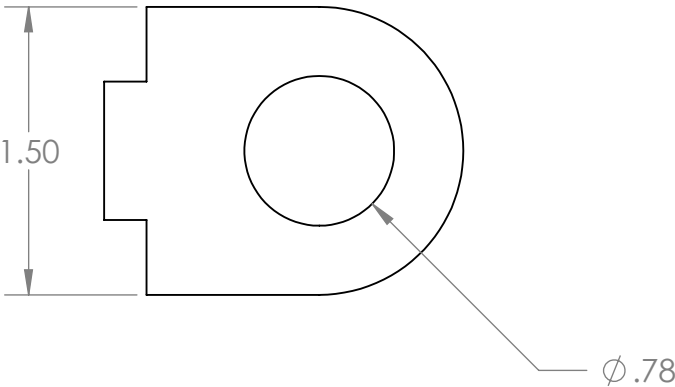
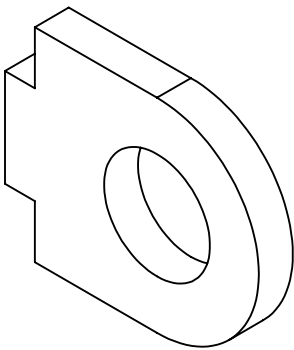
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<b>PART #</b> SWIV-058-000	<b>MATERIAL</b> SM_A36_0.25T
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<b>DESCRIPTION :</b> TABLE CHAIR BRACKET
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<b>DRAWN BY:</b> MMoreno   01/15/24	<b>SHEET 1 OF 1</b>
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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PART #  
SWIV-059-000

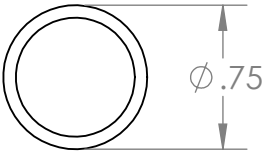
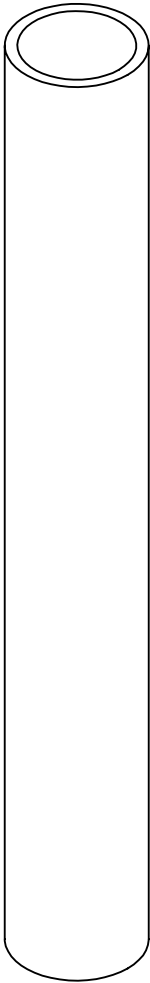
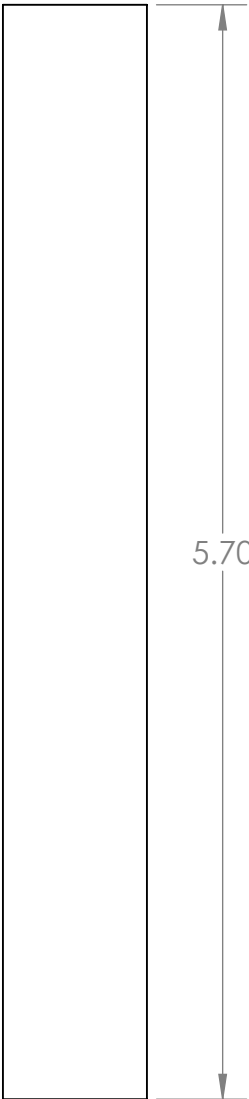
MATERIAL  
SM\_A36\_0.25T

DESCRIPTION :  
SWIVEL HINGE BRACKET

DRAWN BY: MMoreno | 01/15/24      SHEET 1 OF 1



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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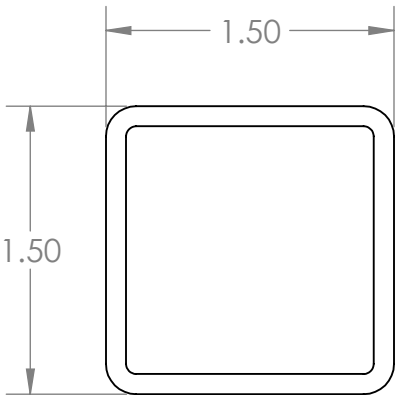
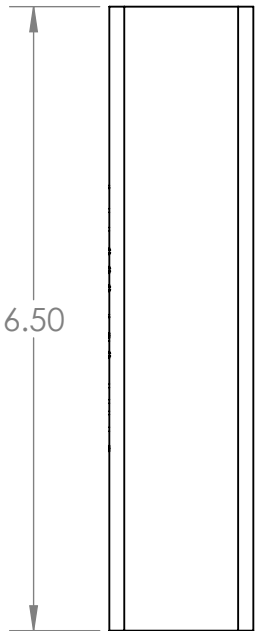
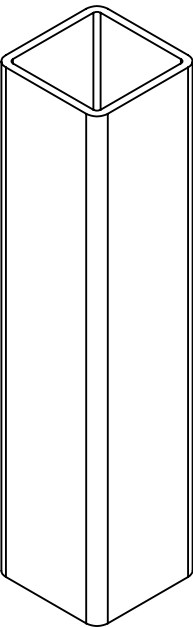
PART #  
SWIV-060-000

MATERIAL  
CR\_A500\_0.75x0.62

DESCRIPTION :  
Pivot Tube

DRAWN BY: MMoreno | 01/15/24      SHEET 1 OF 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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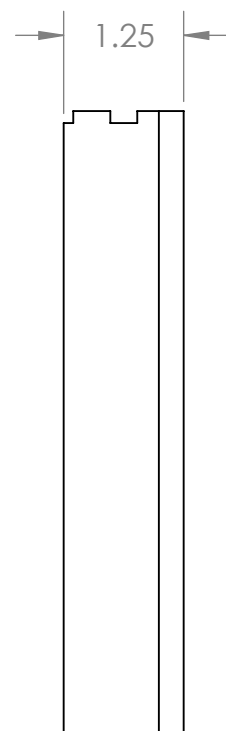
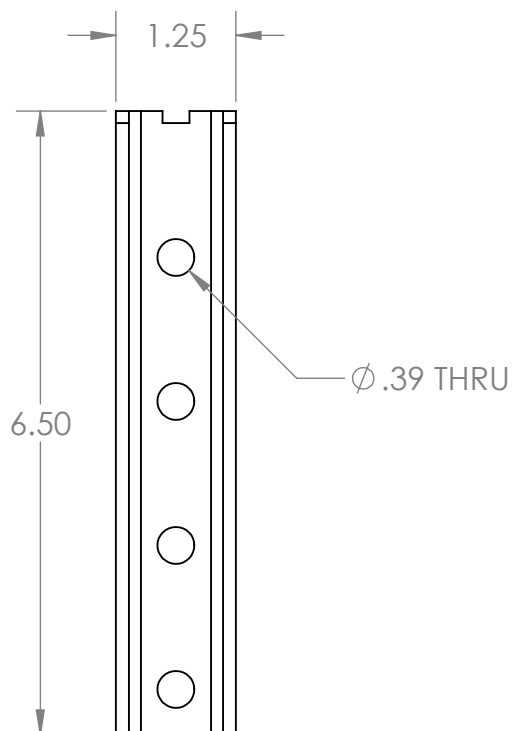
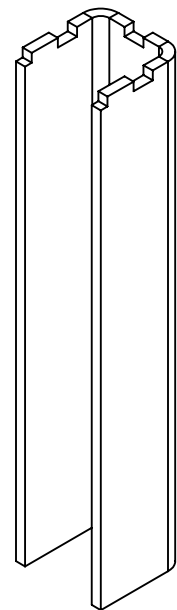


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<b>PART #</b> SWIV-061-000	<b>MATERIAL</b> SQ_A500_1.5X1.5_0.10 5T
	<b>DESCRIPTION :</b> Seat Telescopic Tube
<b>DRAWN BY:</b> MMoreno   01/15/24 <b>SHEET 1 OF 1</b>	

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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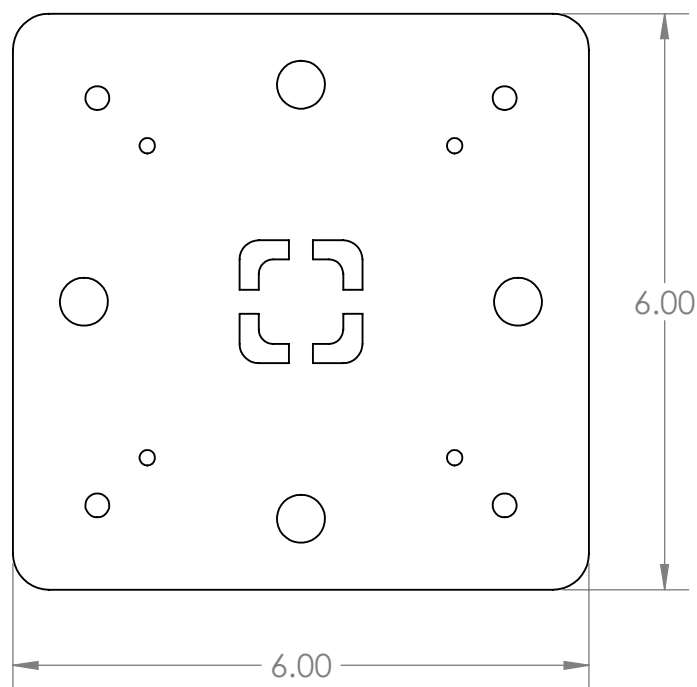
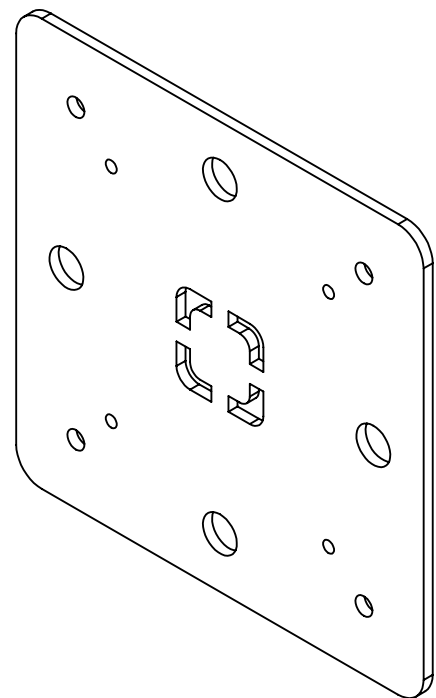
**PART #**  
SWIV-062-000

**MATERIAL**  
SM\_A36\_0.1345T

**DESCRIPTION :**  
INNER SEAT CHANNEL

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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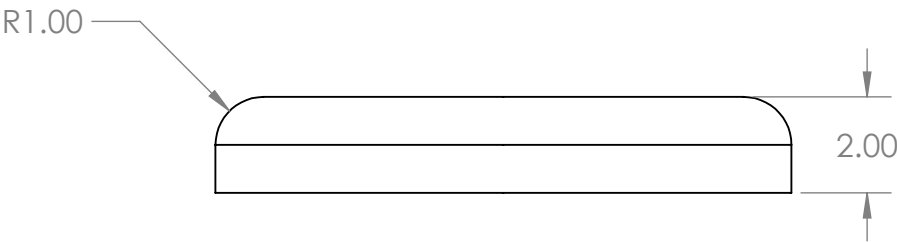
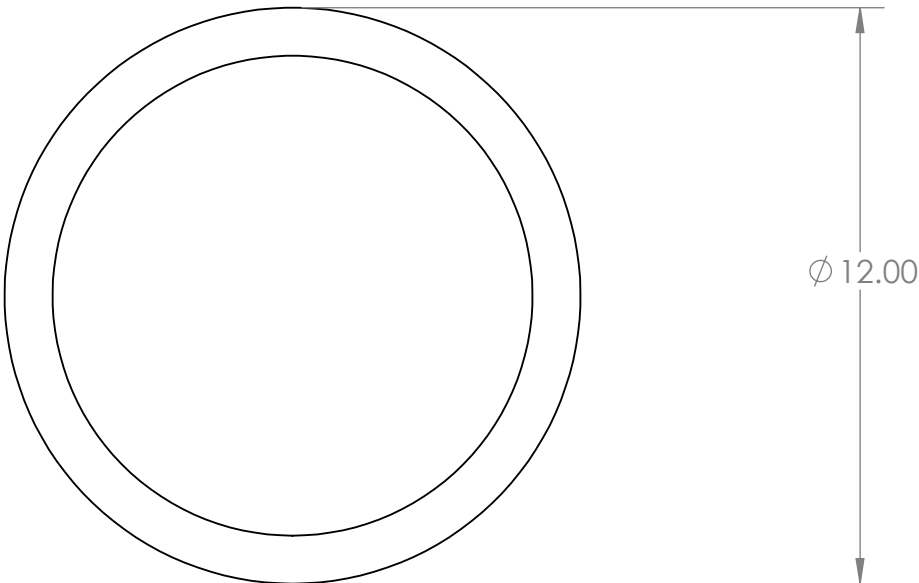
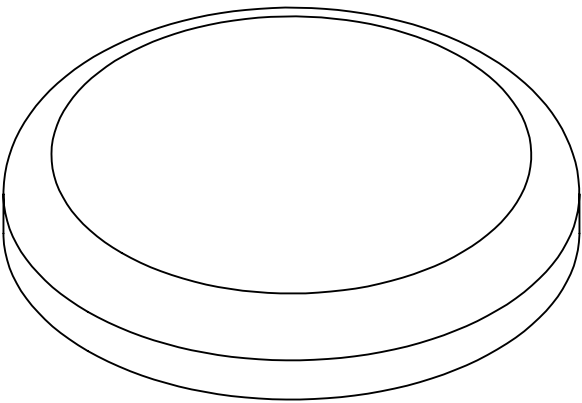
**PART #**  
SWIV-063-000

**MATERIAL**  
SM\_A36\_0.1345T

**DESCRIPTION :**  
SEAT PLATE

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



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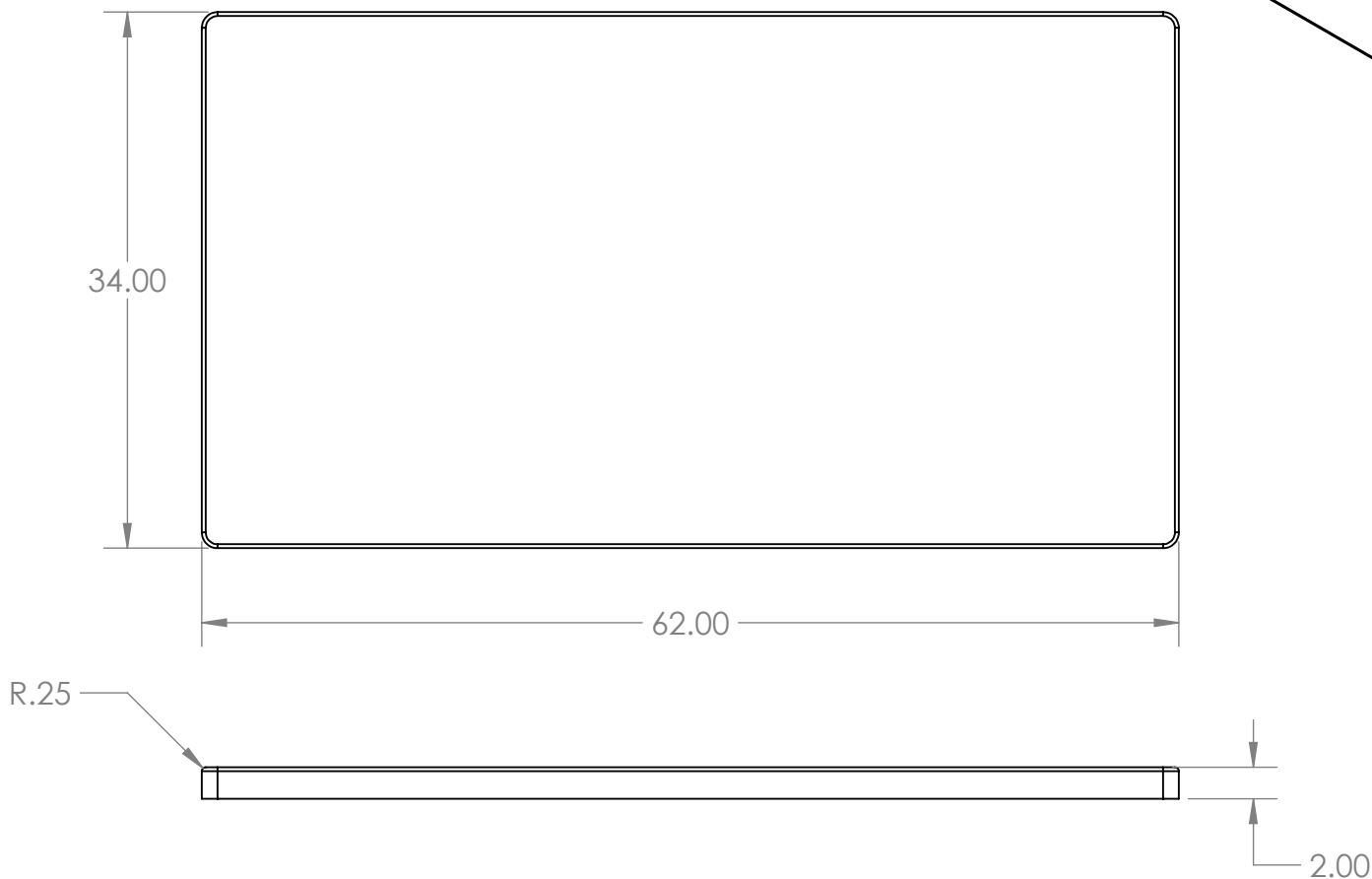
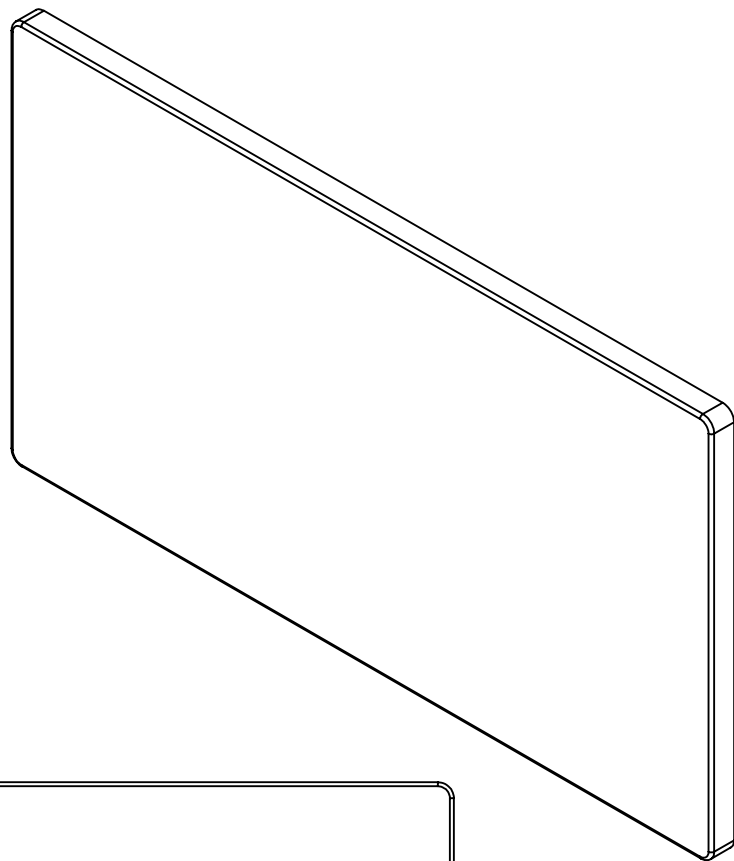
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<b>PART #</b>	<b>MATERIAL</b>
SWIV-900-000	Wood_2T

**DESCRIPTION :**  
Wooden Seat

**DRAWN BY:** MMoreno | 01/15/24      **SHEET 1 OF 1**

REVISIONS			
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**PART #**  
SWIV-901-000

**MATERIAL**  
Wood\_2T

**DESCRIPTION :**  
Pine Wood Top

**DRAWN BY:** MMoreno | 01/15/24 **SHEET 1 OF 1**