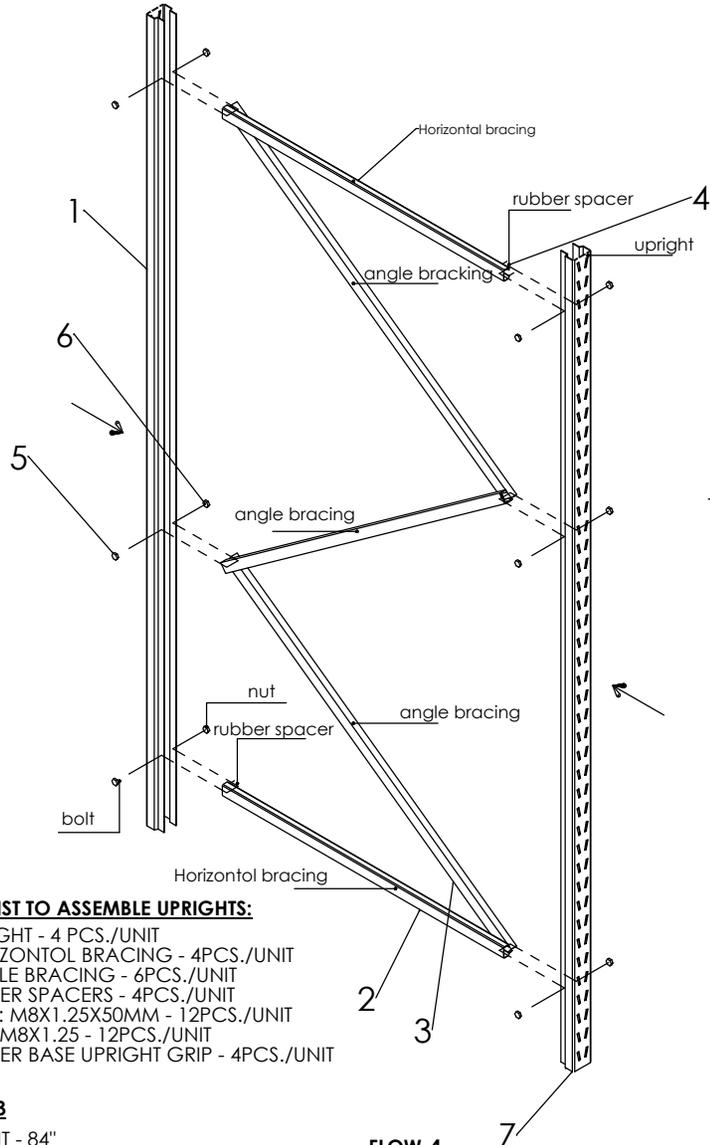


### STEP 1:

- 1 - LAYDOWN 2 UPRIGHTS ON THE FLOOR, WITH OPEN SIDES FACING EACH OTHER.
- 2 - WHEN ASSEMBLING BOTTOM & TOP HORIZONTAL BRACING, USE THE RUBBER SPACER
- 3 - CONNECT ONE END OF THE HORIZONTAL BRACING WITH 1ST UPRIGHT AND CONNECT THE OTHER END OF HORIZONTAL BRACING AND ANGLE BRACING WITH THE 2ND UPRIGHT
- 4 - USE RUBBER BASE UPRIGHT GRIP ON BOTTOM OF THE UPRIGHTS.

## GRAVITY FLOW RACK



### PARTS LIST TO ASSEMBLE UPRIGHTS:

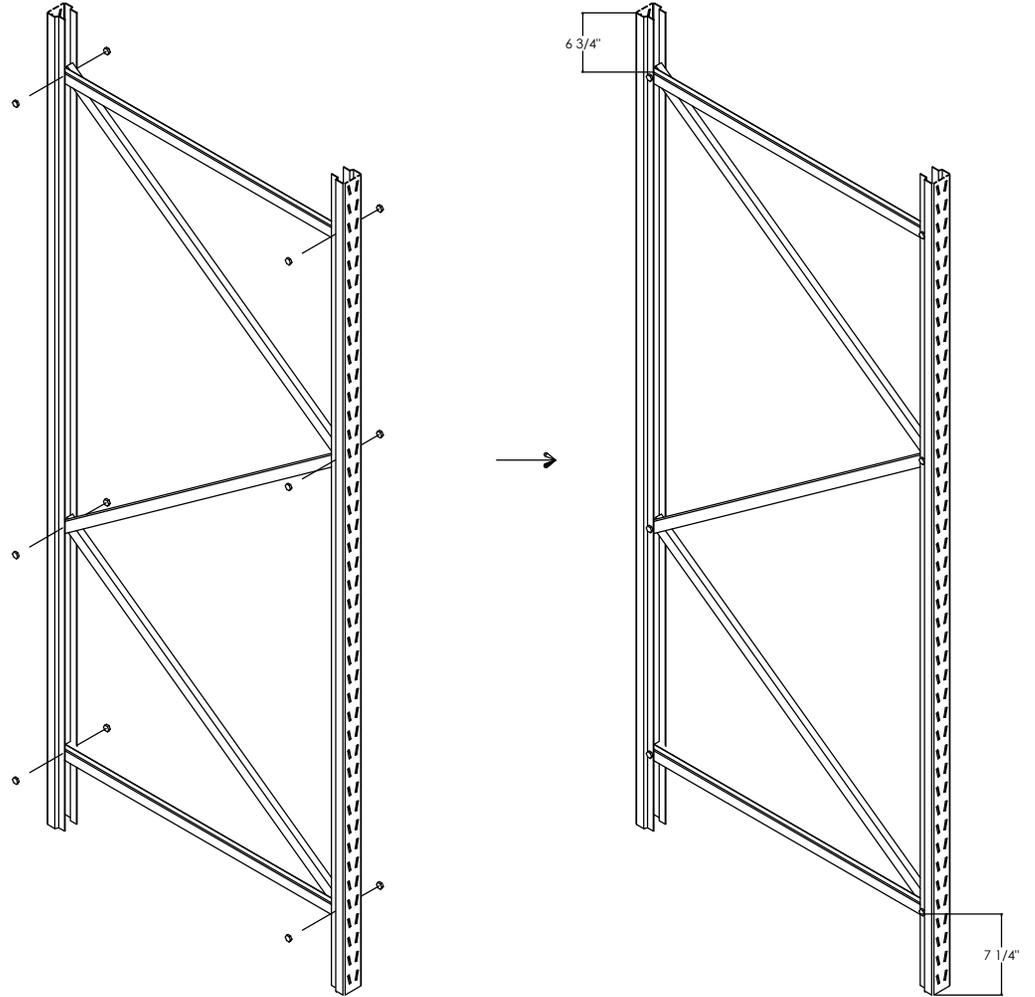
- 1 - UPRIGHT - 4 PCS./UNIT
- 2 - HORIZONTAL BRACING - 4PCS./UNIT
- 3 - ANGLE BRACING - 6PCS./UNIT
- 4 - RUBBER SPACERS - 4PCS./UNIT
- 5 - BOLT: M8X1.25X50MM - 12PCS./UNIT
- 6 - NUT: M8X1.25 - 12PCS./UNIT
- 7 - RUBBER BASE UPRIGHT GRIP - 4PCS./UNIT

### FLOW-3

- UPRIGHT - 84"
- HORIZONTAL BRACE OVERALL LENGTH - 34"
- ANGLE BRACE OVERALL LENGTH - 41.60"
- DIVIDER OVERALL LENGTH - 37"
- ROLLER OVERALL LENGTH - 37"

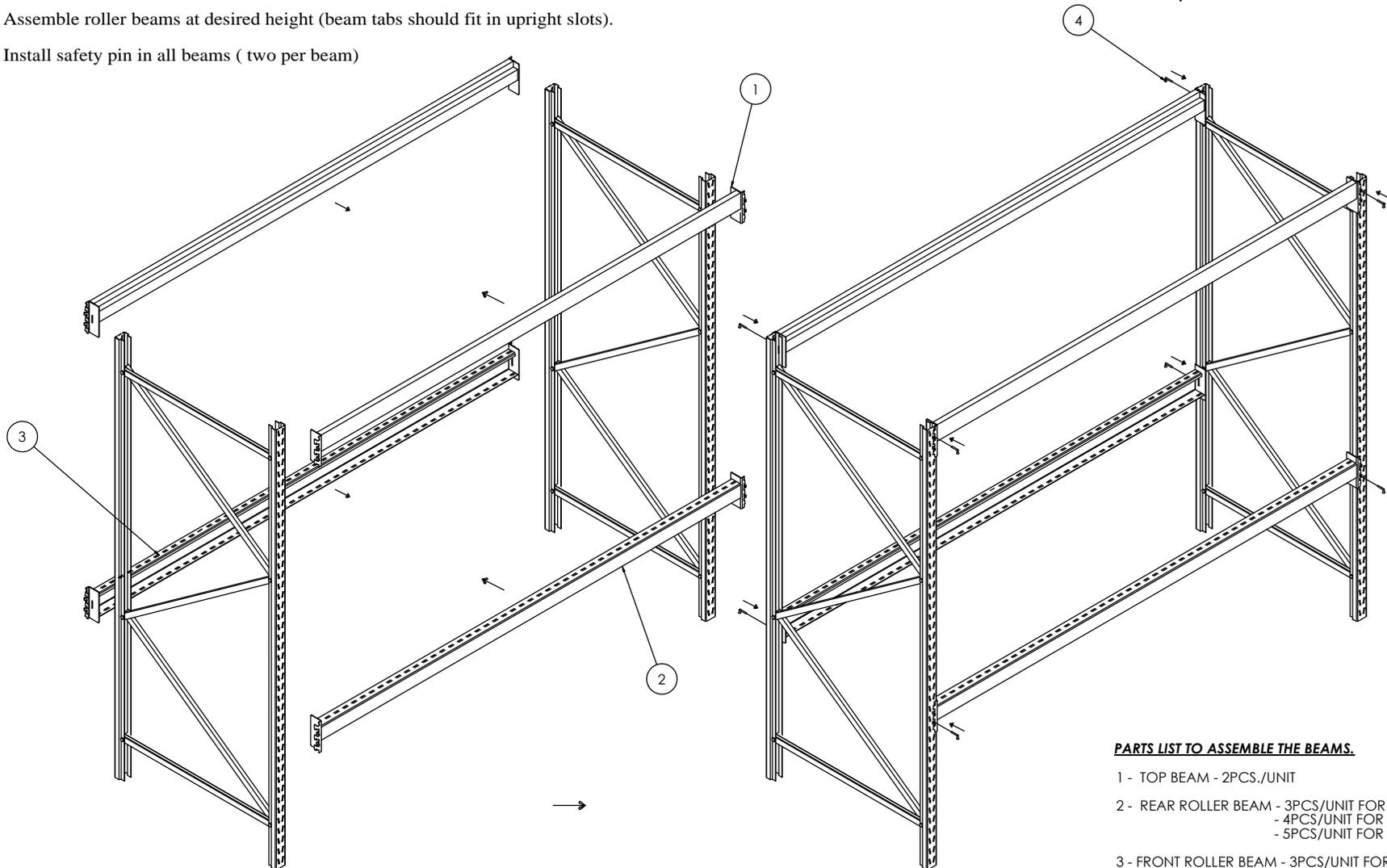
### FLOW-4

- UPRIGHT HEIGHT - 84"
- HORIZONTAL BRACE OVERALL LENGTH - 46"
- ANGLE OVERALL LENGTH - 52"
- DIVIDER OVERALL LENGTH - 49"
- ROLLER OVERALL LENGTH - 49"



## STEP 2:

- 1 - Assemble 2 top beams (beam tabs should fit in upright slots).
- 2 - Assemble roller beams at desired height (beam tabs should fit in upright slots).
- 3 - Install safety pin in all beams ( two per beam)



### PARTS LIST TO ASSEMBLE THE BEAMS.

- 1 - TOP BEAM - 2PCS./UNIT
- 2 - REAR ROLLER BEAM - 3PCS/UNIT FOR FLOW-3  
- 4PCS/UNIT FOR FLOW-4  
- 5PCS/UNIT FOR FLOW-5
- 3 - FRONT ROLLER BEAM - 3PCS/UNIT FOR FLOW-3  
- 4PCS/UNIT FOR FLOW-4  
- 5PCS/UNIT FOR FLOW-5
- 4 - SAFETY PIN - 2PCS/BEAM  
16 PCS. FOR FLOW-3  
20 PCS. FOR FLOW-4  
24 PCS. FOR FLOW-5

## STEP 3:

- 1 - Assemble 8 rollers per shelf.
- 2 - Assemble 4 dividers per shelf.

### PARTS LIST TO ASSEMBLE ROLLERS & DIVIDERS

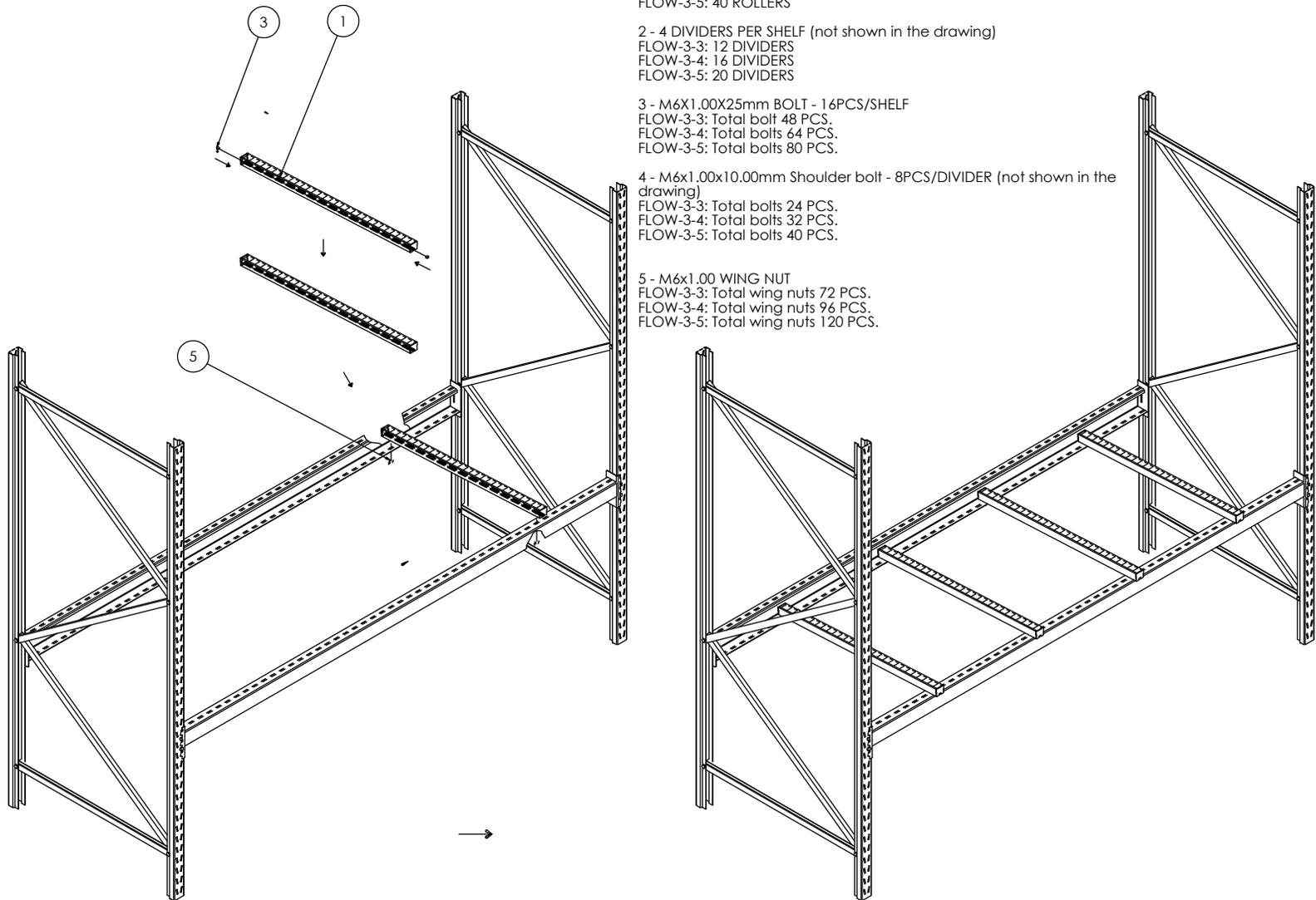
1 - 8 ROLLERS PER SHELF  
FLOW-3-3: 24 ROLLERS  
FLOW-3-4: 32 ROLLERS  
FLOW-3-5: 40 ROLLERS

2 - 4 DIVIDERS PER SHELF (not shown in the drawing)  
FLOW-3-3: 12 DIVIDERS  
FLOW-3-4: 16 DIVIDERS  
FLOW-3-5: 20 DIVIDERS

3 - M6X1.00X25mm BOLT - 16PCS/SHELF  
FLOW-3-3: Total bolt 48 PCS.  
FLOW-3-4: Total bolts 64 PCS.  
FLOW-3-5: Total bolts 80 PCS.

4 - M6x1.00x10.00mm Shoulder bolt - 8PCS/DIVIDER (not shown in the drawing)  
FLOW-3-3: Total bolts 24 PCS.  
FLOW-3-4: Total bolts 32 PCS.  
FLOW-3-5: Total bolts 40 PCS.

5 - M6x1.00 WING NUT  
FLOW-3-3: Total wing nuts 72 PCS.  
FLOW-3-4: Total wing nuts 96 PCS.  
FLOW-3-5: Total wing nuts 120 PCS.



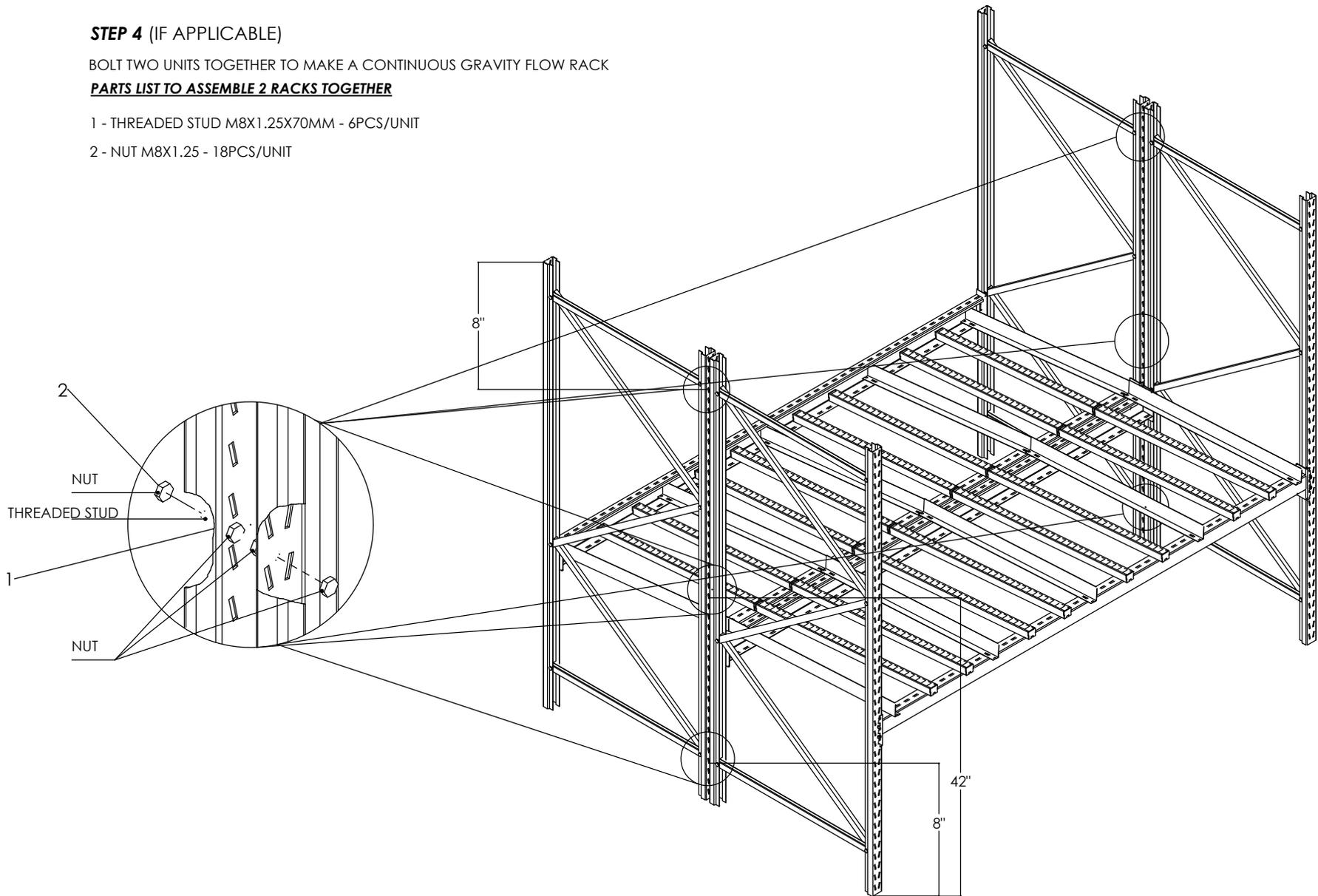
**STEP 4 (IF APPLICABLE)**

BOLT TWO UNITS TOGETHER TO MAKE A CONTINUOUS GRAVITY FLOW RACK

**PARTS LIST TO ASSEMBLE 2 RACKS TOGETHER**

1 - THREADED STUD M8X1.25X70MM - 6PCS/UNIT

2 - NUT M8X1.25 - 18PCS/UNIT



**GRAVITY FLOW RACK ASSEMBLY INSTRUCTIONS**

9/24/2007



Fig.1

M8-1.25x50mm long Bolt (12 pcs/unit)  
to secure horizontal & angle bracing to  
to uprights

Position of bottom horizontal brace (Fig.2)



Fig.2

7 1/4"

Position of top horizontal brace (Fig.3)

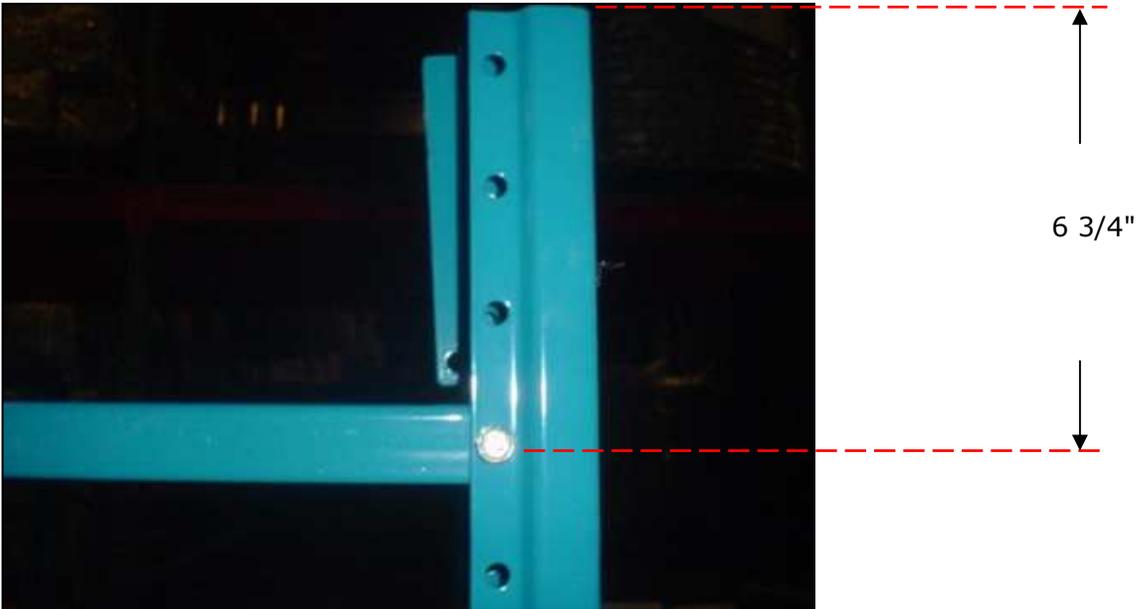


Fig.3

Spacer 4 pcs/unit



Fig.4

Roller bar

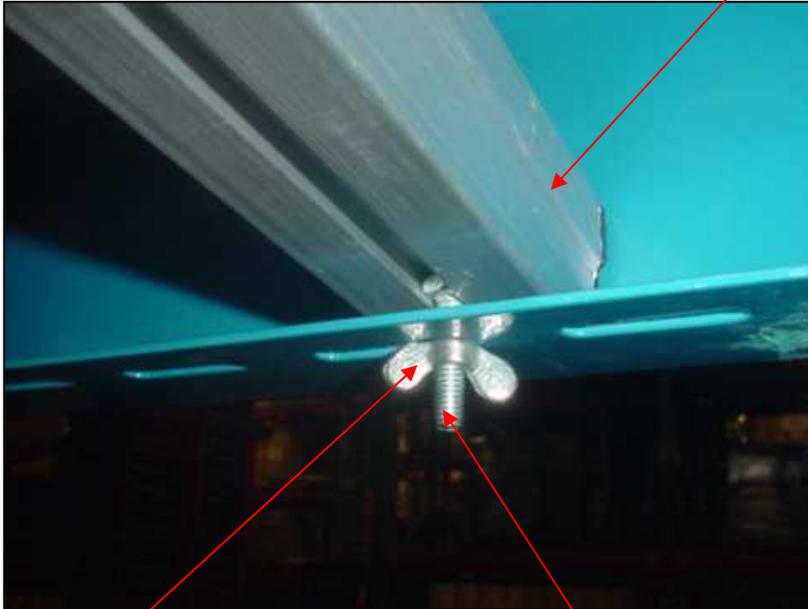


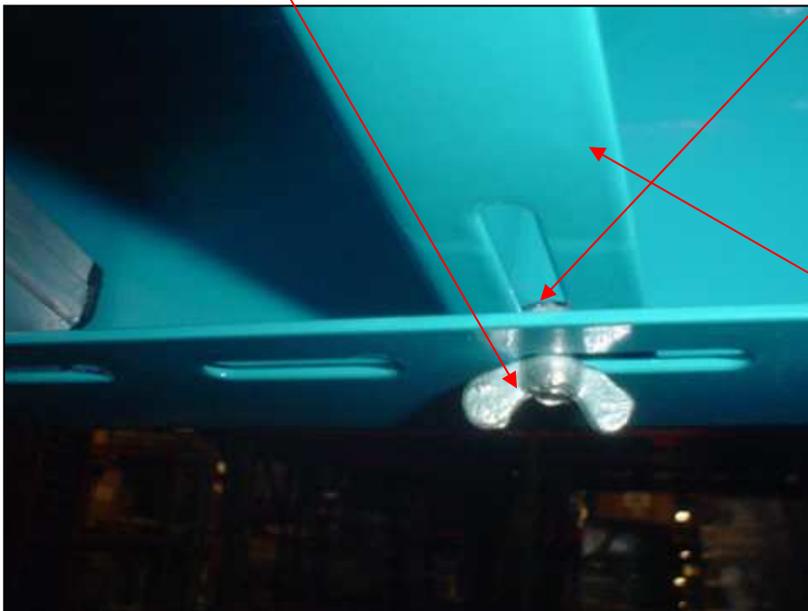
Fig.5

M6-1.25x25mm long Bolt 16 pcs/shelf to secure 8 roller bars.

M6-1.25 Wing Nut 16 pcs/shelf to secure 8 Roller bars

M6-1.25 Wing Nut 8pcs/shelf to secure 4 dividers

M6-1.25x10mm long Shoulder Bolt 8 pcs/shelf to secure 4 dividers



Divider

Fig.6

Bolt two units together to make a continuous Gravity Flow Rack

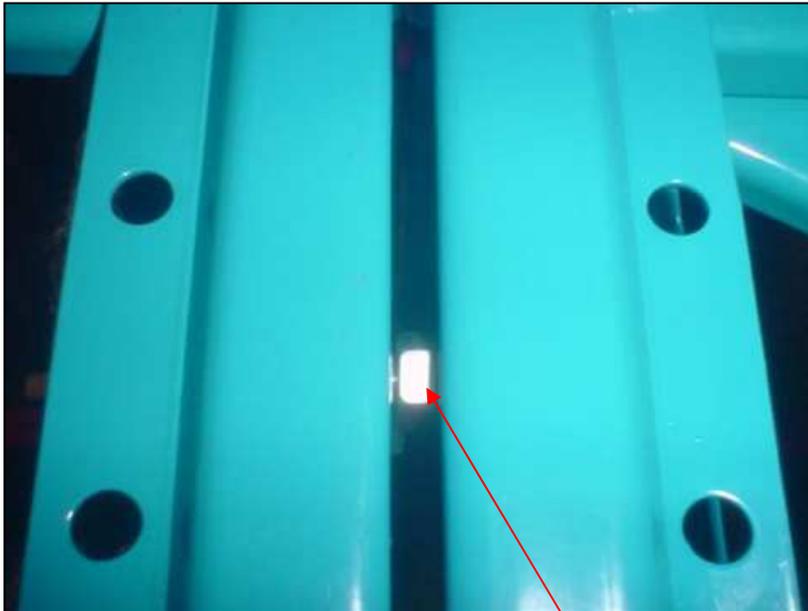


Fig.9

M8-1.25 nut as a spacer between 2 racks, 18pcs./unit

M8-1.25x70mm long stud, 6 pcs./unit

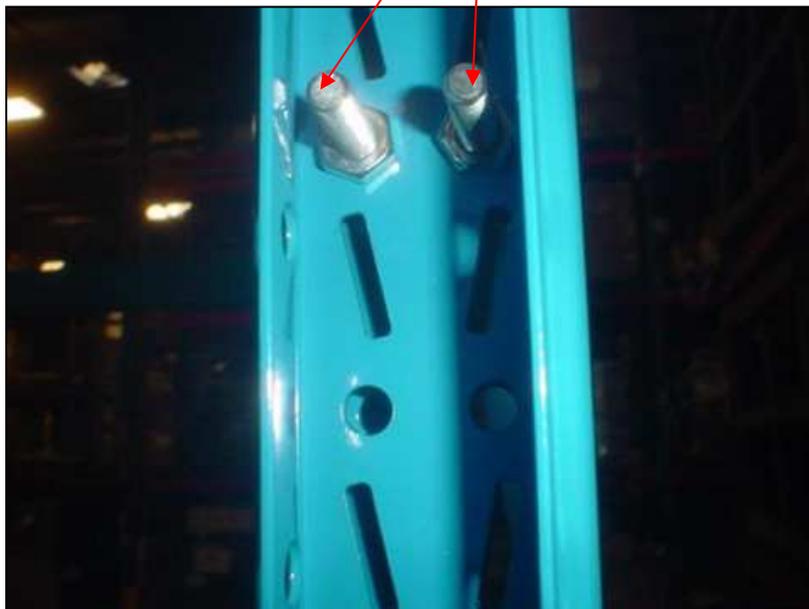


Fig.10

## LIMITED WARRANTY

Vestil Manufacturing Corporation (“Vestil”) warrants this product to be free of defects in material and workmanship during the warranty period. *Our warranty obligation is to provide a replacement for a defective original part if the part is covered by the warranty, after we receive a proper request from the warrantee (you) for warranty service.*

### Who may request service?

Only a warrantee may request service. *You are a warrantee if you purchased the product from Vestil or from an authorized distributor AND Vestil has been fully paid.*

### What is an “original part”?

An original part is a part used to make the product as shipped to the warrantee.

### What is a “proper request”?

A request for warranty service is proper if Vestil receives: 1) a photocopy of the Customer Invoice that displays the shipping date; AND 2) a written request for warranty service including your name and phone number. Send requests by any of the following methods:

Mail  
Vestil Manufacturing Corporation  
2999 North Wayne Street, PO Box 507  
Angola, IN 46703

Fax  
(260) 665-1339  
Phone  
(260) 665-7586

Email  
sales@vestil.com

In the written request, list the parts believed to be defective and include the address where replacements should be delivered.

### What is covered under the warranty?

After Vestil receives your request for warranty service, an authorized representative will contact you to determine whether your claim is covered by the warranty. Before providing warranty service, Vestil may require you to send the entire product, or just the defective part or parts, to its facility in Angola, IN. The warranty covers defects in the following *original* dynamic components: motors, hydraulic pumps, electronic controllers, switches and cylinders. It also covers defects in *original* parts that wear under normal usage conditions (“wearing parts”): bearings, hoses, wheels, seals, brushes, batteries, and the battery charger.

### How long is the warranty period?

The warranty period for original components is 30 days. The warranty period begins on the date when Vestil ships the product to the warrantee. If the product was purchased from an authorized distributor, the period begins when the distributor ships the product. Vestil may extend the warranty period for products shipped from authorized distributors by *up to 30 days* to account for shipping time.

### If a defective part is covered by the warranty, what will Vestil do to correct the problem?

Vestil will provide an appropriate replacement for any *covered* part. An authorized representative of Vestil will contact you to discuss your claim.

### What is not covered by the warranty?

1. Labor;
2. Freight;
3. Occurrence of any of the following, which automatically voids the warranty:
  - Product misuse;
  - Negligent operation or repair;
  - Corrosion or use in corrosive environments;
  - Inadequate or improper maintenance;
  - Damage sustained during shipping;
  - Collisions or other incidental contacts causing damage to the product;
  - Unauthorized modifications: DO NOT modify the product IN ANY WAY without first receiving written authorization from Vestil. Modification(s) might make the product unsafe to use or might cause excessive and/or abnormal wear.

### Do any other warranties apply to the product?

Vestil Manufacturing Corp. makes no other express warranties. All implied warranties are disclaimed to the extent allowed by law. Any implied warranty not disclaimed is limited in scope to the terms of this Limited Warranty.

