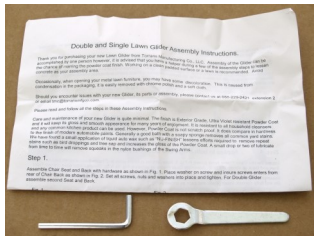


# Heavy Duty Retro Metal Chair Assembly Instructions



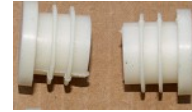
1 set of instructions



Chair Back



2 chair legs  
1 rear crossmember



2 end caps



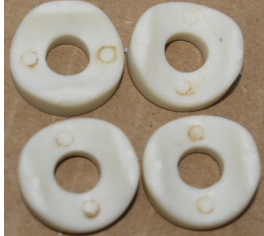
Chair Seat



12 lock nuts



1 Cross Member/brace



4 plastic spacers



24 washers



4 short bolts



4 medium bolts



4 long bolts

Your chair seat and back may not resemble these pictures. Instructions are for all styles of metal chairs equipped with our exclusive Heavy Duty Frames. These heavier made and reinforced chairs have a weight rating of 325 lbs. static load.

Working on a clean, padded surface or a lawn is recommended. **Avoid concrete as your assembly area.**

**DO NOT OVER TIGHTEN ! THIS WILL RESULT IN BREAKING THE POWDERCOAT AND WILL VOID YOUR WARRANTY!**

***Occasionally, when opening your metal lawn furniture, you may encounter some slight discoloration. This and many other scuff marks can be easily removed with Automotive Chrome Polish or any common Metal Polish and buffed with a soft cloth. An initial light coat of liquid automotive wax such a "NU-FINISH" with a follow-up application about every 6 months is recommended.***

Care and maintenance of your new chair is quite minimal. The finish is Exterior Grade, Ultra Violet resistant Powder Coat and it will keep its gloss and smooth appearance for many years of enjoyment. It is resistant to most household cleansers and many common kitchen product can be used. However, Powder Coat is **NOT** scratch proof. It does compare in hardness to the finish of modern automotive paints. Generally a good bath with a soapy sponge removes all common yard stains. We have found a small application of liquid auto wax such as "NU-FINISH" lessens efforts required to remove repeat stains such as bird droppings and tree sap and increases the gloss of the Powder Coat.

**Note:** Certain Steps may be more easily accomplished with temporary assistance from a helper to hold or steady parts during assembly.

Locking Nuts contain a captured nylon ring and function to prevent loosening during use. This nylon ring must face away from the head of the screw when treading on Locking Nut. Resistance will be felt when this nylon ring engages screw threads. This resistance is normal and usually will be greater than simple finger pressure can overcome. Finger tight means to turn the Locking Nut onto the screw until this resistance is felt.

## Heavy Duty Chair Assembly Instructions-Pg 2

### Step 1.

Assemble Chair Seat and Back using **4 short screws, 8 washers and 4 locking nuts (NOTE: Thunderbird Chairs use 3 short screws, 6 washers and 3 locking nuts)** Place 1 washer on each short screw. Align the 4 (3 for Thunderbird) mounting holes of Seat with Chair Back and insert 1 screw with washer through a mounting hole. *Ensure screw enters Chair Back from rear of Chair Back.* Place another washer on short screw with locking nut and hand tightened only. Repeat for remaining mounting holes. After all short screws, washers and locking nuts are installed, fully tighten. Set assembly safely aside.

### Step 2.

Locate Left and Right **Chair Frame/Legs, Rear crossmember** and **Front crossmember brace**. Fully insert a plastic **end cap** into straight portion of both Chair Legs. Place **Rear crossmember** into bent ends of each Chair Leg. Loosely align semi completed Chair Frame into general shape of completed Chair. A helper may be needed for this and Step 3.

### Step 3.

Locate **4 long screws, 8 washers, 4 plastic spacers and 4 locking nuts**. Place 1 washer onto each long screw. Working from rear of Chair Frame, set the previously assembled Seat with Chair Back loosely into the semi completed Frame. Align mounting holes located on both sides of Chair Back with Chair Frame mounting holes located at rear of Chair Frame. Fully insert a long screw with washer into rear mounting hole entering from outside of Chair Frame. Place Plastic Spacer over screw with curved area facing Chair Frame. Align Chair Back mounting hole and place over long screw. Place 1 washer and 1 locking nut onto long screw and hand tighten only. Repeat operation of opposite side. Tighten long screws and locking nuts until firm only.

Working from front of semi completed Chair, insert from outside of Chair Frame 1 long screw with washer into front mounting hole. Place 1 Plastic Spacer over screw with curved portion of Plastic Spacer facing Chair Frame. Align Seat mounting hole over long screw and loosely secure with 1 washer and 1 locking nut. Hand tighten only. Repeat on opposite side.

**Note:** During assembly process, Rear Cross Member may become loose or partially disengaged from either one or both Chair Frame/Leg halves. Ensure Rear Cross Member remains firmly and completely seated into Frame halves until Chair is fully assembled. Once Chair is fully assembled, Rear Cross Member becomes locked into place and will not loosen during normal use. Also, when assembling the Chair frame to front of Seat, there will be a pronounced gap between the Chair frame and the Seat. This is normal and not a defect. The frame is specifically designed to be assembled under the pressure required for Chair frame to become tight against the Seat.

### Step 4.



Locate **Front Brace, 4 medium screws, 8 washers and 4 locking nuts**. Place 1 washer onto each medium screw. Fully insert medium screw with washer from outside of Frame into Brace mounting hole of Chair Frame. Align Brace over screw and with corresponding mounting hole then loosely secure with 1 washer and 1 locking nut. Hand tighten only. Repeat for remaining 3 medium screws and mounting holes. After all 4 medium screws, washers and locking nuts are installed, fully tighten.

### Step 5.

Return to 2 long screws mounting Seat to Frame assembly previously left "hand tight only". Fully tighten. Return to rear of Chair and fully tighten 2 long screws securing Chair Back to Frame. This concludes the assembly.