

Foundry Bench
FB Series 48" & 60"

Assembly Instructions

REV 03062024



How can we improve our assembly instructions?
Your comments and suggestions are important to us.
Please e-mail us at: support@versaproducts.com



**MADE IN
AMERICA**

Parts

Bamboo Surfaces



Top Surface (1 pc)



Bottom Surface (1 pc)

Metal Panels



Back Panel (1 pc)



Front Panel (1 pc)

Steel Support



Foot (2 pc)



Leg Upright (2 pc)

Electronics



Actuator (2 pc)



Power Cord (1 pc)



Control Switch (1 pc)



Control Box (1 pc)



Extension Cord (1 pc)



Cross Support (1 pc)



Moving Beam (2 pc)

Hardware



Caster (**4 pc**)
2 Brake, 2 No Brake



20mm Furniture Bolt (**16 pc**)



50mm Furniture Bolt (**4 pc**)



8A x 5/8"
Wood Screw (**5 pc**)



3/8-16 Washer (**12 pc**)



12mm Washer (**2 pc**)



Clevis Pin (**2 pc**)



Cotter Pin (**2 pc**)



3/8-16 Hex Nut (**6 pc**)



1/4-20 x 1/2"
Truss Head Screw (**12 pc**)



3/8-16 x 2 1/2" Hex Bolt (**6 pc**)



8-32 x 3/4 Flat
Head Screw (**4 pc**)

Additional Tools Required



4mm Allen Wrench



13/16" Wrench
(Qty 2)



Phillips Head Screwdriver

Assembly

Step 1

Leg Uprights

Attach the Leg Upright to the Foot using (3) 3/8-16 x 2 1/2 Hex Bolts, (3) 3/8-16 Washers and (3) 3/8-16 Hex Nuts as shown. Repeat for other side.

Please note: Insert the bottom Hex Bolt first and secure it with the nut. Then, move your way up and tighten all bolts at the end.

x6



3/8-16 x 2 1/2
Hex Bolt

x6

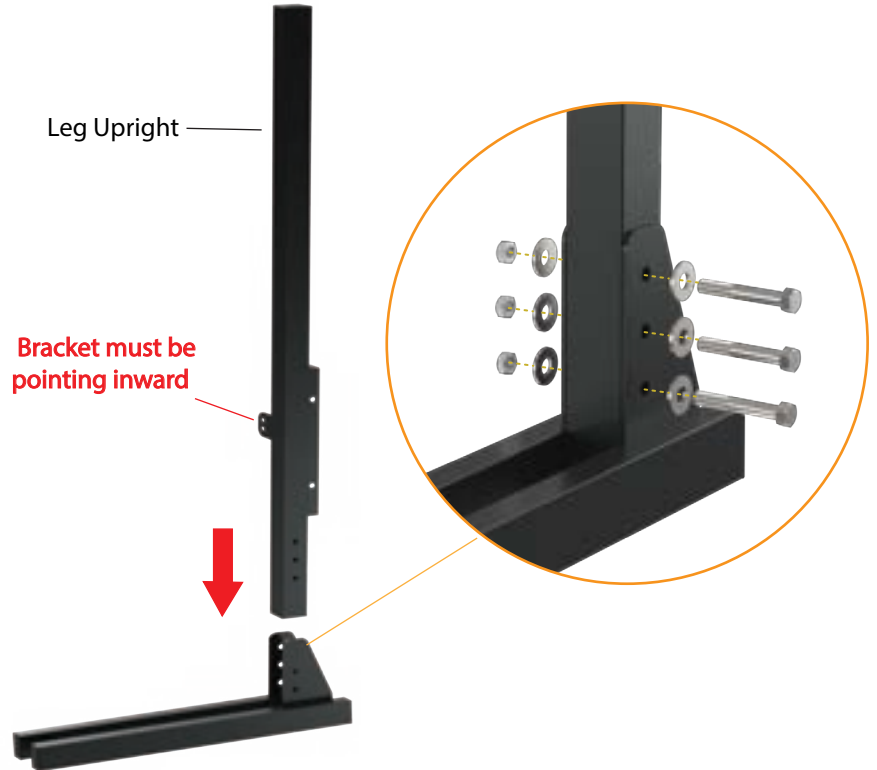


3/8-16 Hex
Nut

x12



3/8-16 Washer



Step 2

Back Panel

Please note: We highly recommend that you place a cardboard or soft material beneath the parts in this step to avoid damage from scraping.

Place both Leg Uprights on the ground as shown. Then, attach the Back Panel to the uprights using (4) 20mm Furniture Bolts. Repeat for other side.

x8



20mm Furniture Bolt



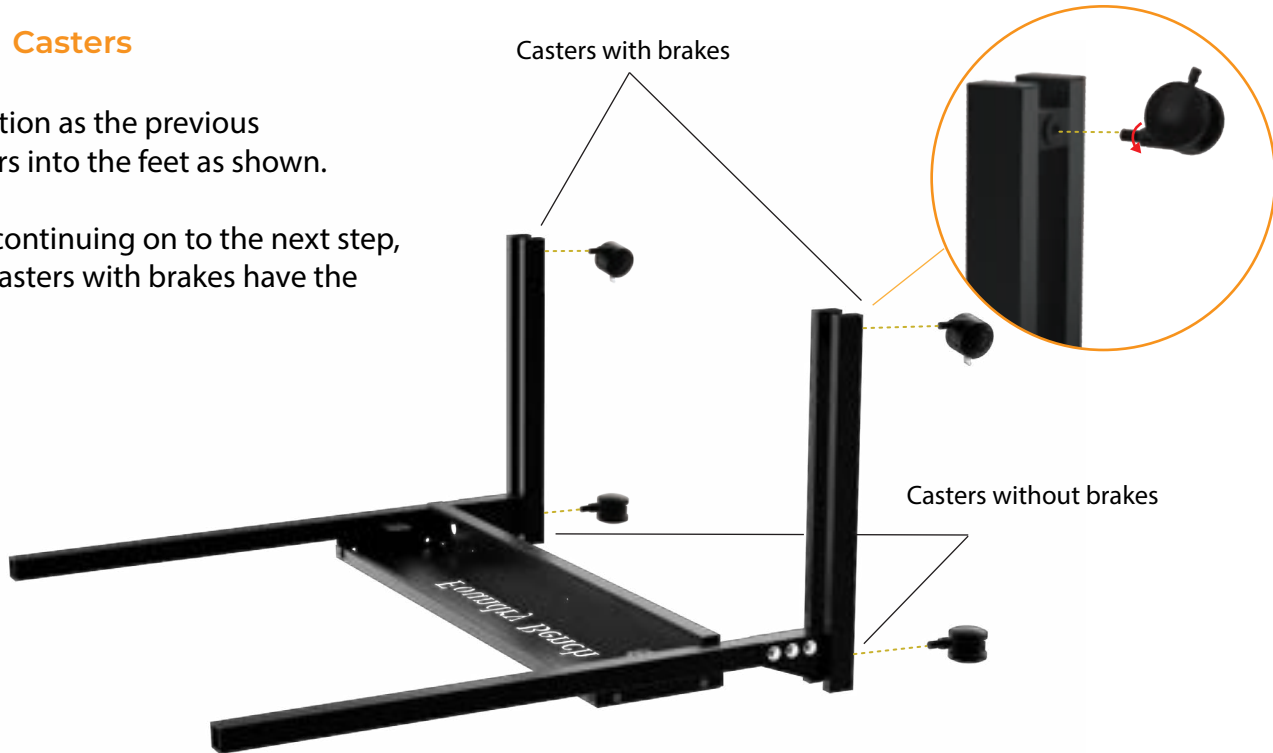
Assembly

Step 3

Casters

Using the same position as the previous step, insert (4) Casters into the feet as shown.

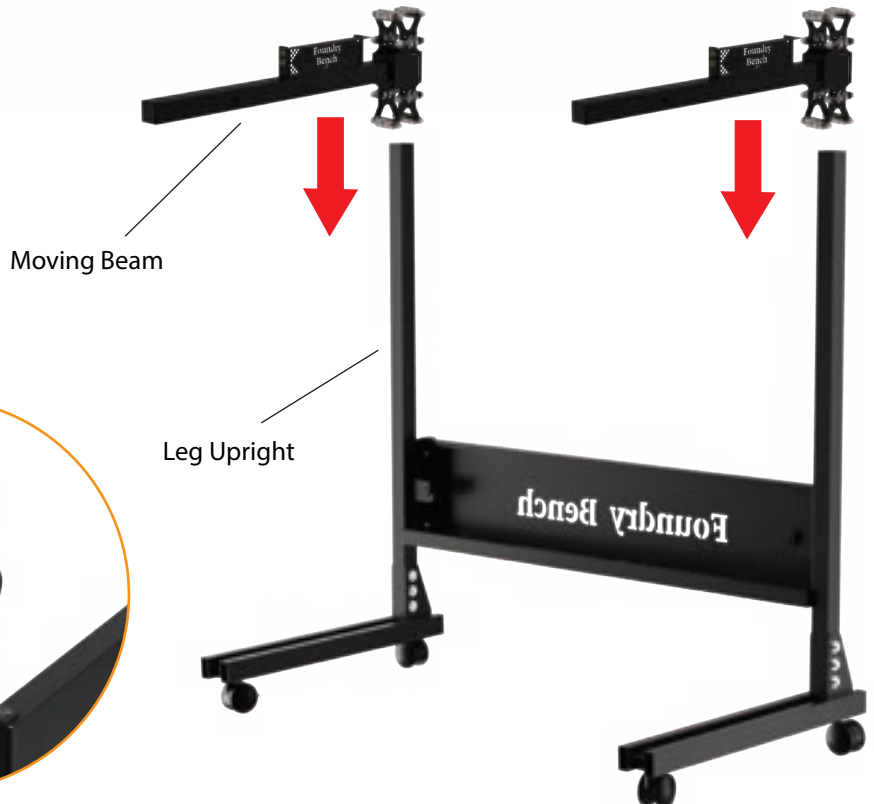
Please note: Before continuing on to the next step, make sure the two casters with brakes have the brake ON.



Step 4

Moving Beams

Carefully turn the frame of the bench over. Then, slide (2) Moving Beams down the leg uprights until the beams touch the Back Panel as shown.



Assembly

Step 5

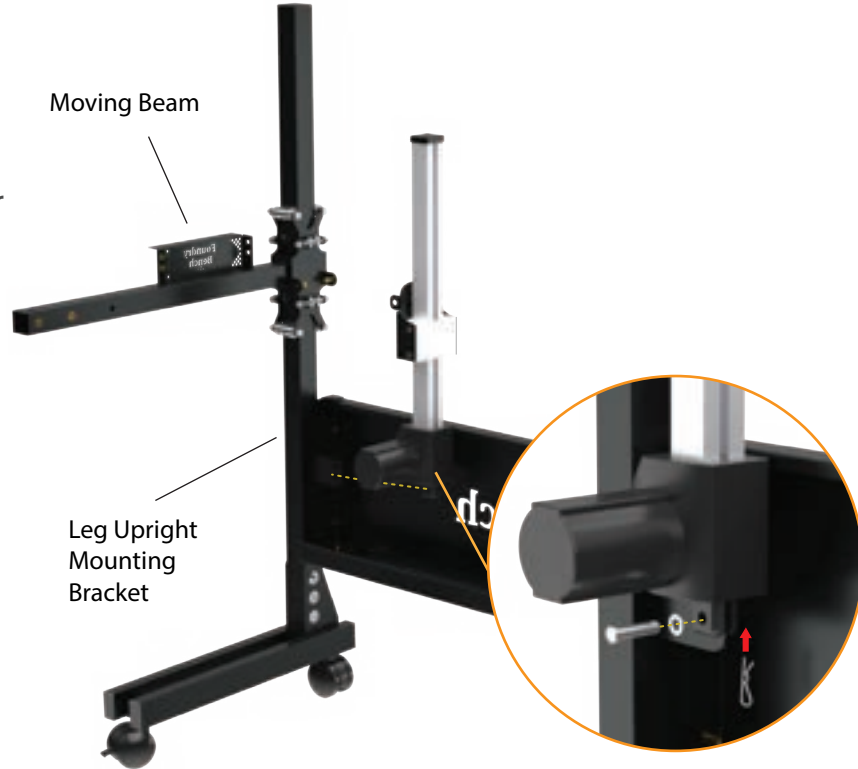
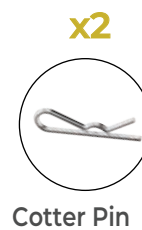
Actuators

Secure the bottom of the Actuator to the Leg Upright as shown.

First, align the Actuator to the Leg Upright and put (1) Clevis Pin through the holes.

Then, put (1) Cotter Pin through the hole of the Clevis Pin.

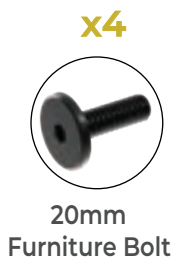
Repeat these 2 steps for the other side.



Step 6

Actuators

Align the Actuator with both the Moving Beam and Leg Upright as shown. Use (2) 20mm Furniture Bolts to attach the Actuator to the Moving Beam. **Repeat for other side.**



Assembly

Step 7

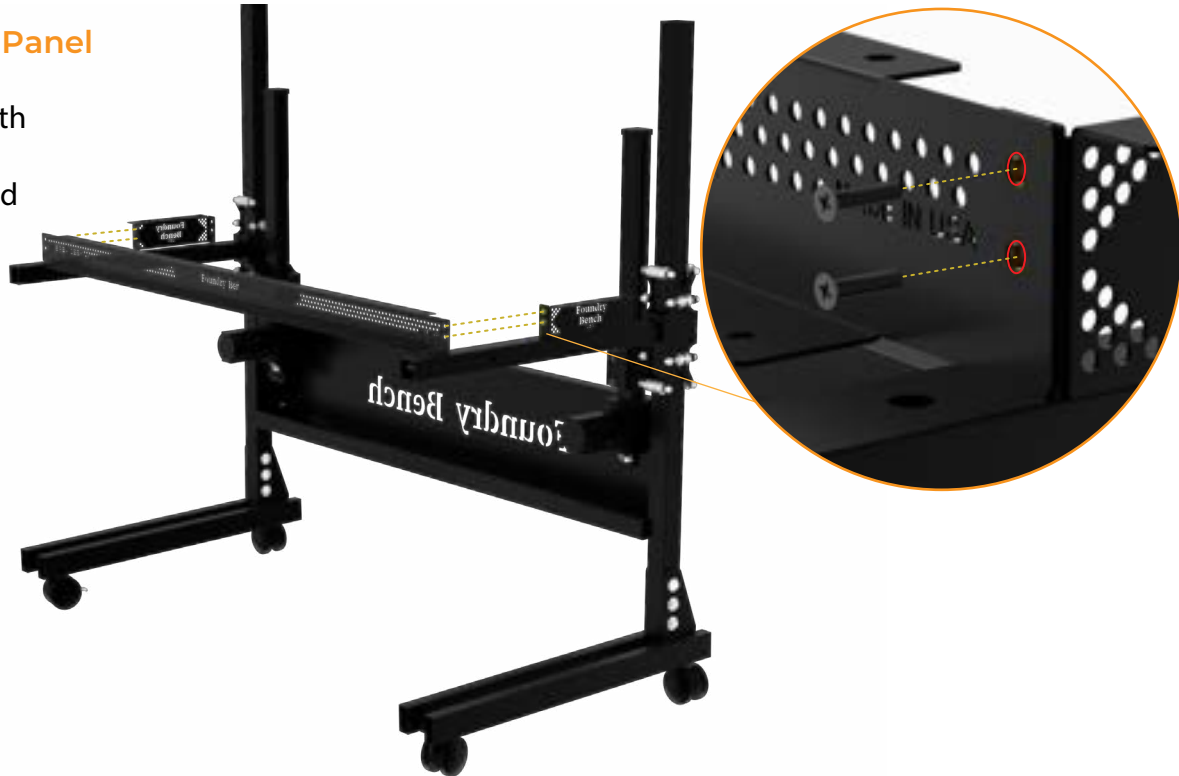
Front Panel

Attach the Front Panel to both of the supporting brackets using (4) 8-32 x 3/4" Flat Head Screws (2 screws per side).

x4



8-32 x 3/4
Flat Head Screw



Step 8

Top Surface

Place the Top Surface on top of the supporting brackets and the Front Panel.

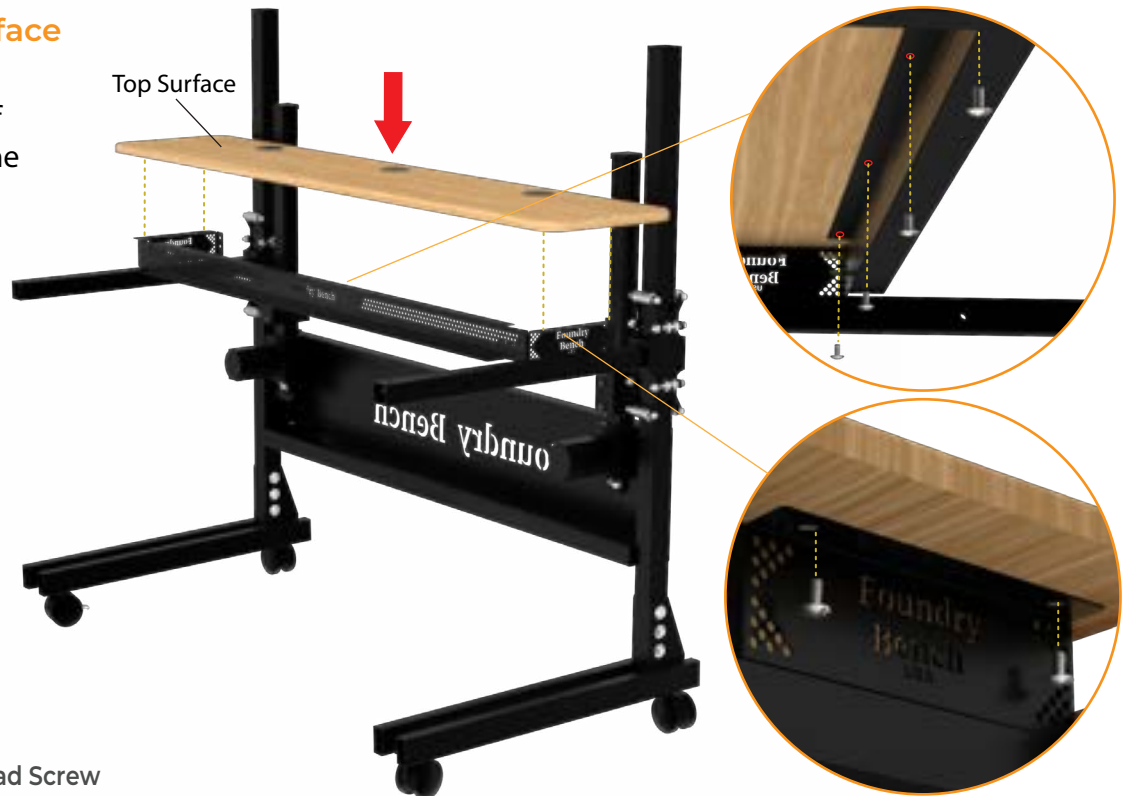
To attach the Top Surface to the supporting brackets, use (4) 1/4-20 x 1/2 Truss Head Screws (2 per side).

To attach the Top Surface to the Front Panel, use another (4) 1/4-20 x 1/2 Truss Head Screws.

x8



1/4-20 X 1/2 Truss Head Screw



Assembly

Step 9

Cross Support

Attach the Cross Support to the Moving Beams using (4) 20mm Furniture Bolts (2 bolts per side).



x4

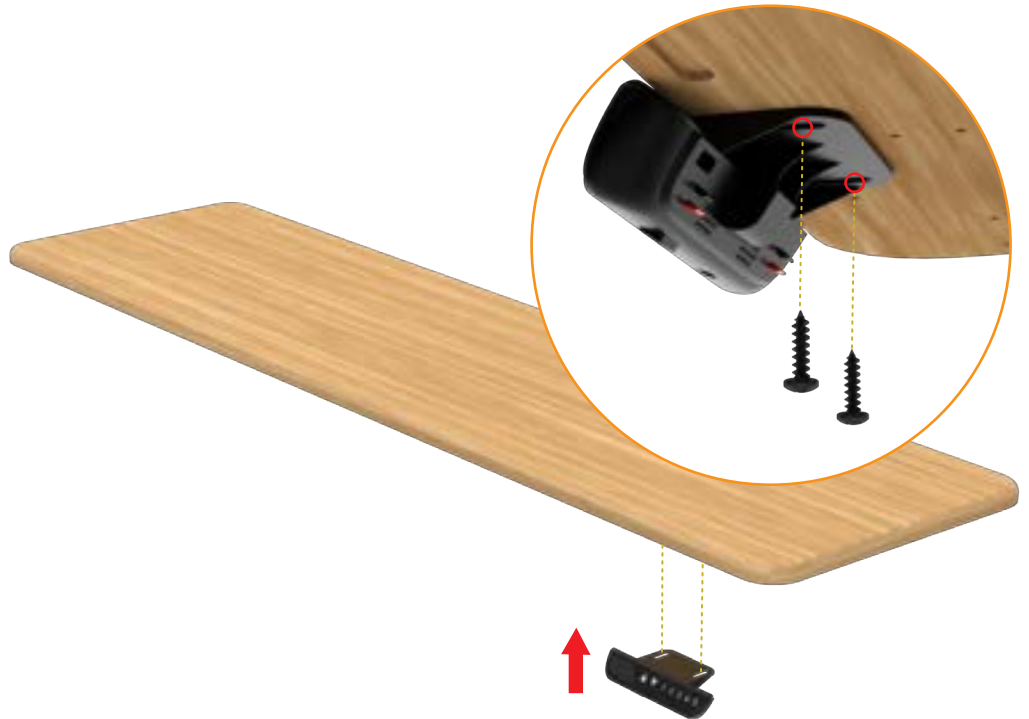


20mm
Furniture Bolt

Step 10

USB Switch

Attach the Switch Bracket to the Bottom Surface using (2) 8A x 5/8" Wood Screws as shown.



x1



Switch Bracket
with USB Switch

x2



8A x 5/8
Wood Screw

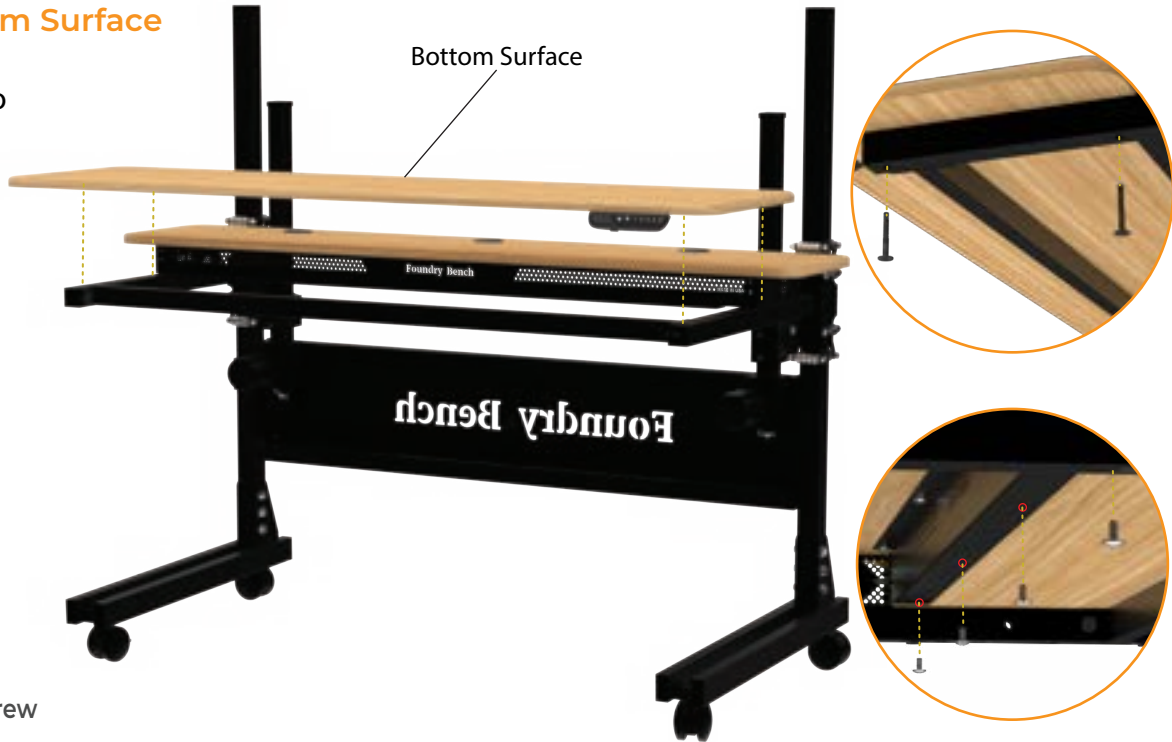
Assembly

Step 11

Bottom Surface

Attach the Bottom Surface to the Moving Beams using (4) 50mm Furniture Bolts as shown.

Then, use (4) 1/4-20 x 1/2" Truss Head Screws to fasten the Bottom Surface onto the Front Panel as shown.



x4



50mm
Furniture Bolt

x4



1/4-20 x 1/2
Truss Head Screw

Step 12

Complete

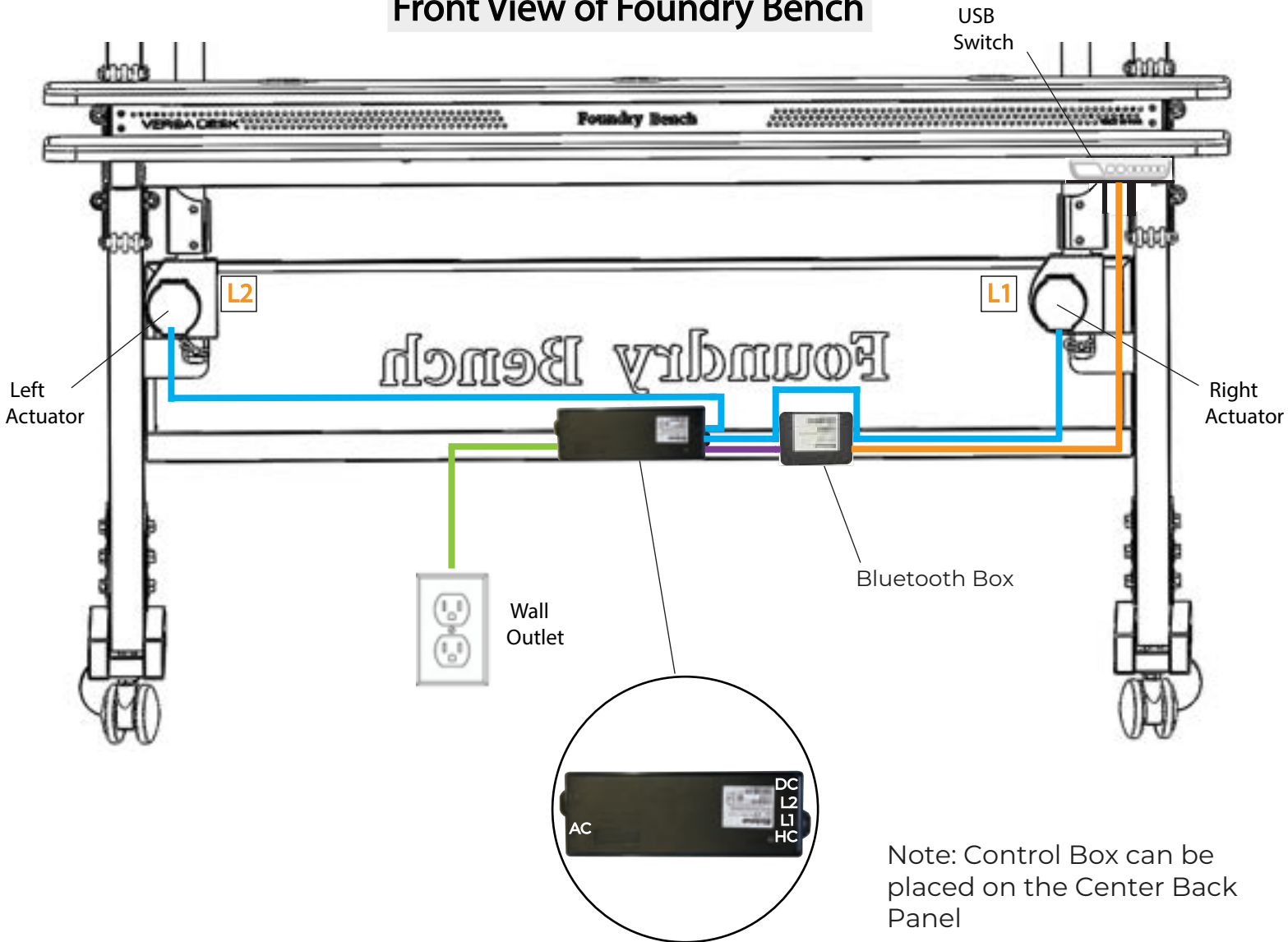
Assembly is now complete. Please refer to the next page to complete the wiring of the electronics.



Assembly

Wiring

Front View of Foundry Bench



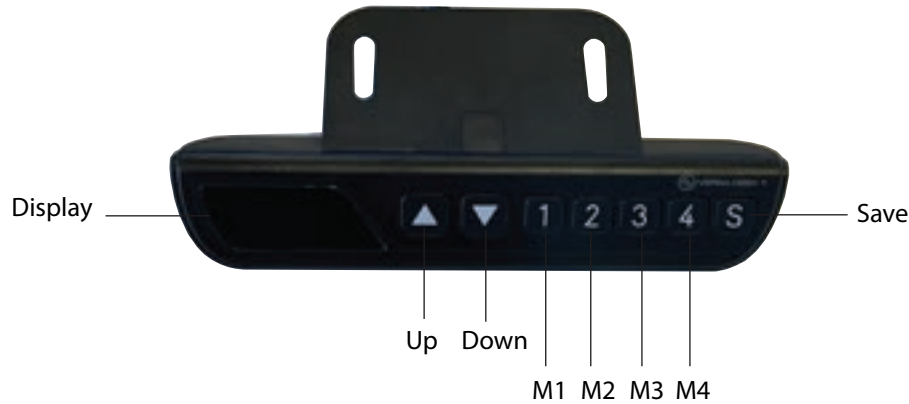
Note: Control Box can be placed on the Center Back Panel

Connect the **Control Switch** to **Bluetooth Box** (if purchased) to **HC** on Control Box (**Orange** - C66 Converter (**Purple**) - HC). If **Bluetooth Box** not purchased, connect **Control Switch** to **HC** on Control Box (**Orange** - HC).

Connect the **Power Cord** to **AC** on Control Box (**AC** - **Green**)

Connect the **Actuators** to their respective location on the control box. (**L2** - **Left Actuator** and **L1** - **Right Actuator**).

Control Switch Operation Instructions



1. INITIALIZATION / RESET

Press and hold **▲** and **▼** for 3 seconds, the desk moves down while the control reads **SET** or Error Code; keep pressing the buttons until the desk reaches the lowest height then bounces back about 5mm, the control box beeps and the height figure is shown on the control. The initialization / reset is complete.

2. Memory Position

2.1 Set memory position 1:

Adjust the desk to the desired height, then press **1** and **S** hold and for 3 seconds, the height figure flashes for 3 second. Memory Position 1 is set.

2.2 Recall memory position 1:

Change Memory Position Recall Mode: Press and hold **▲** and **2** for 3 seconds, the control shows **R 1 1** (Constant Touch)/ **R 1 2** (One Touch).

(1) " **R 1 1** / Constant Touch": Press and hold on **1**, the desk moves to the preset Memory Position 1.

(2) " **R 1 2** / One Touch": Click **1**, the desk moves to the preset Memory Position 1.

- Set memory position 2: Refer to 2.1 (Buttons: **2 S**)
- Recall memory position 2: Refer to 2.2 (Buttons: **2**)

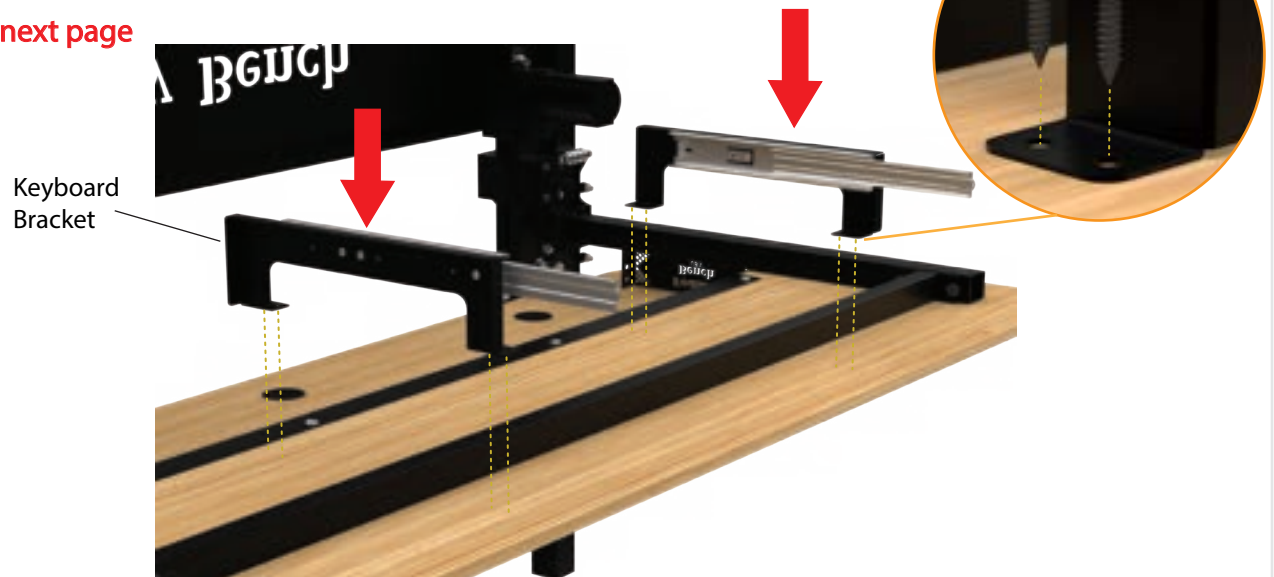
- Set memory position 3: Refer to 2.1 (Buttons: **3 S**)
- Recall memory position 3: Refer to 2.2 (Buttons: **3**)

- Set memory position 4: Refer to 2.1 (Buttons: **4 S**)
- Recall memory position 4: Refer to 2.2 (Buttons: **4**)

Add-on: Sit to Stand Keyboard Arm and Tray**Tools****Parts****Assembly****Step 1**

Attach both keyboard brackets to the Bottom Surface using (8) 8A x 5/8" Wood Screws as shown.

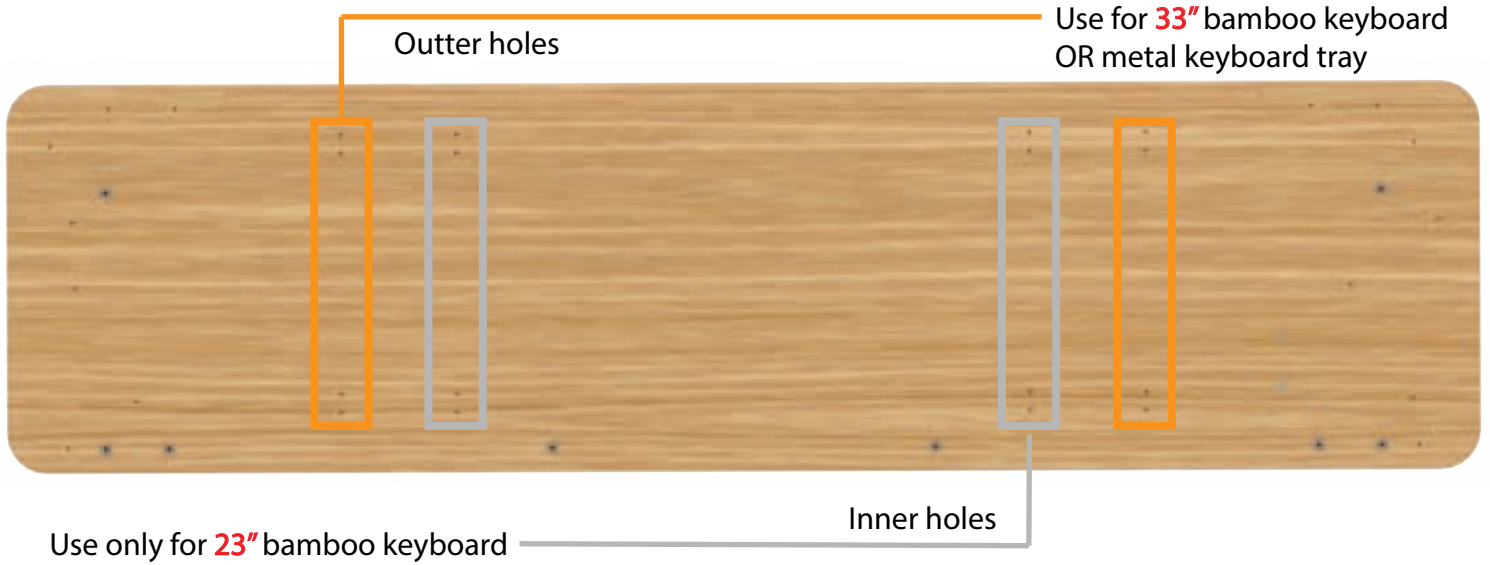
Please look at the next page before attaching.



Add-on: Sit to Stand Keyboard Arm and Tray

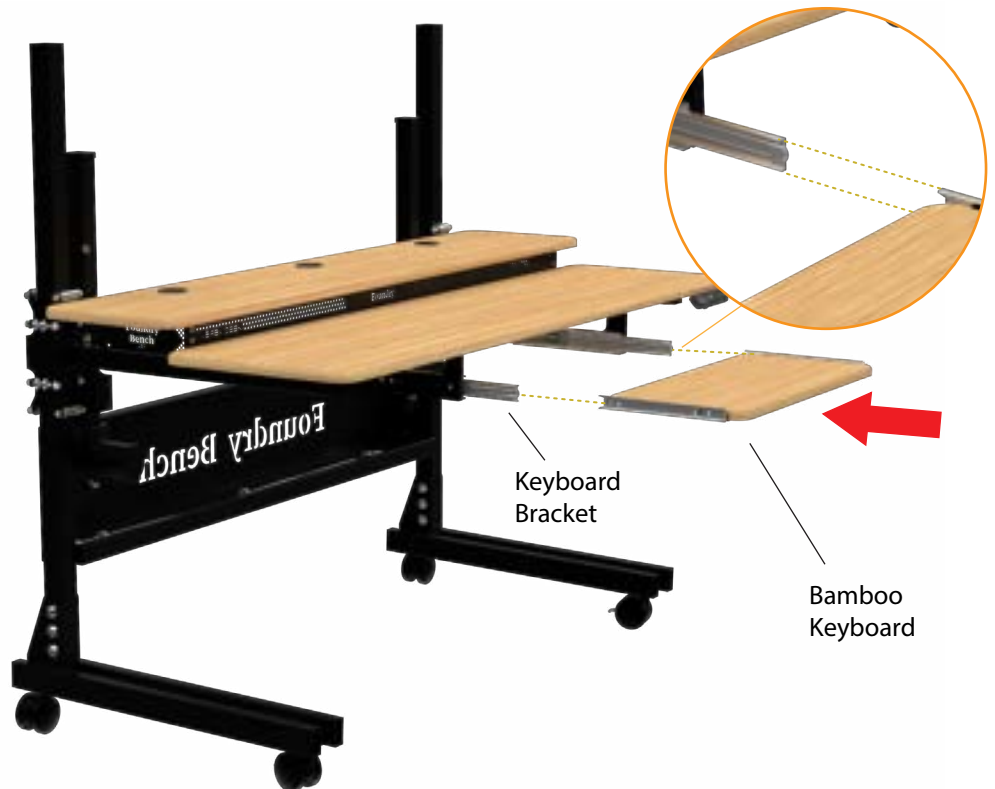
Assembly

Bamboo Keyboard Surfaces



Step 2

Slide the Keyboard Tray or Bamboo Keyboard into the Keyboard Brackets as shown.

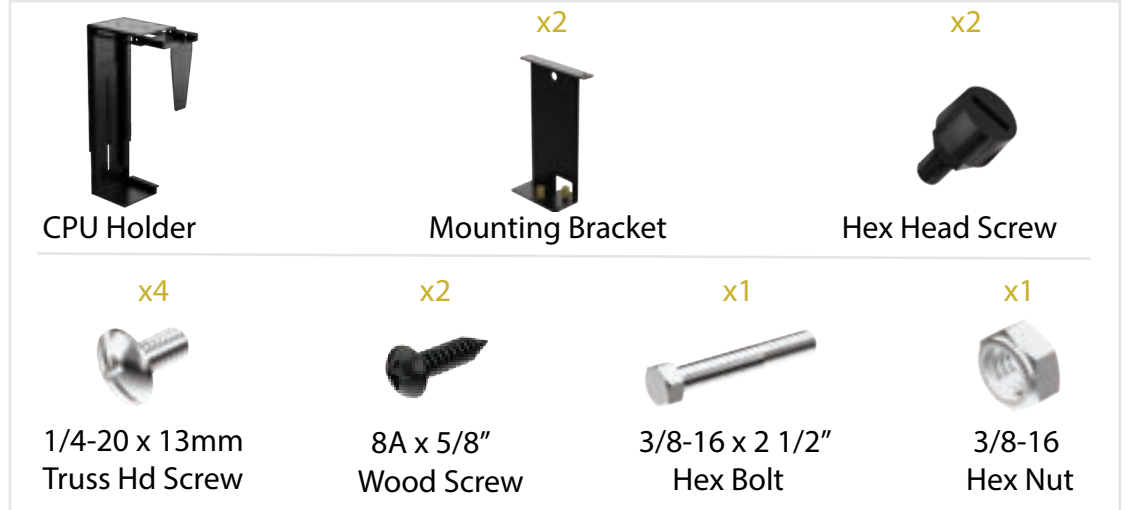


Add-on: CPU Holder

Tools



Parts



Assembly

Step 1

Align the top frame of the CPU Holder with the 4 holes on the mounting brackets.

Then, use **(4) 1/4-20 x 13mm Truss Head Screws** to attach the top frame of the CPU Holder to the mounting brackets as shown.

The screws should go into the inserts of the mounting brackets.



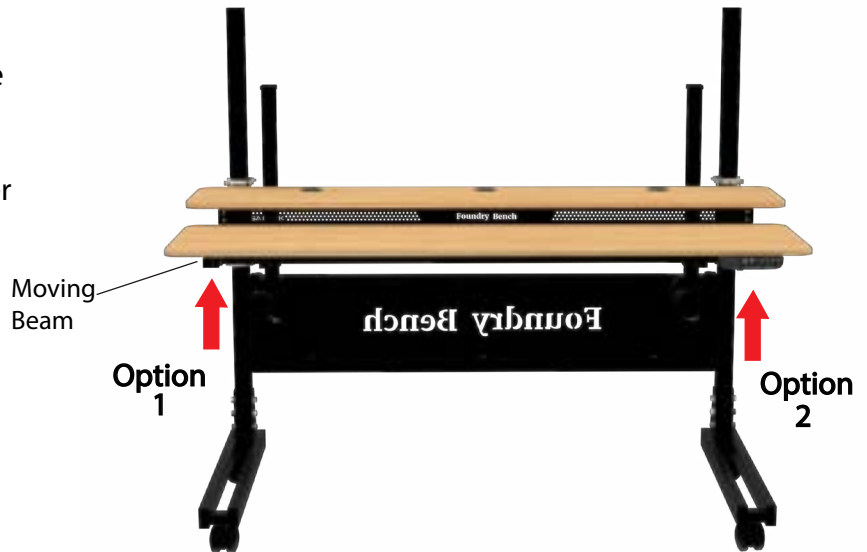
Truss Head Screw



Add-on: CPU Holder**Assembly****Step 2**

Decide which side you would like to place the CPU Holder on.

The CPU Holder can be mounted on either one of the moving beams.

**Step 3**

Align the holes of the mounting brackets with the holes on the moving beam as shown in the upper right corner.

Then, use **(2) 8A x 5/8" Wood Screws** to attach the mounting brackets to the bottom surface as shown.

The image on the bottom right shows a successful completion of this step.



Add-on: CPU Holder**Assembly****Step 4**

Fasten the CPU Holder brackets to the moving beam using **(1) 3/8-16 x 2 1/2" Hex Bolt** and **(1) 3/8-16 Hex Nut** as shown.

The image on the bottom right corner shows a successful completion of this step.

x6

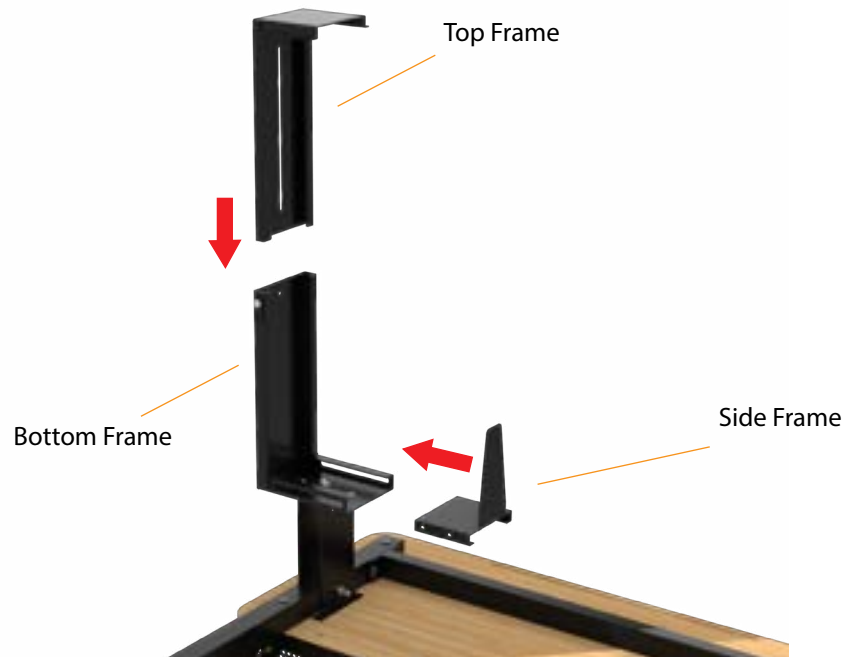
3/8-16 x 2 1/2
Hex Bolt

x6

3/8-16 Hex
Nut

**Step 5**

Attach the bottom frame and the side frame of the CPU Holder to the top frame of the CPU Holder as shown. The frames are designed to simply slide into one another.



Add-on: CPU Holder**Assembly****Step 6**

Secure the side frame to the top frame using **(2) Head Hex Screws** as shown.

**Step 7**

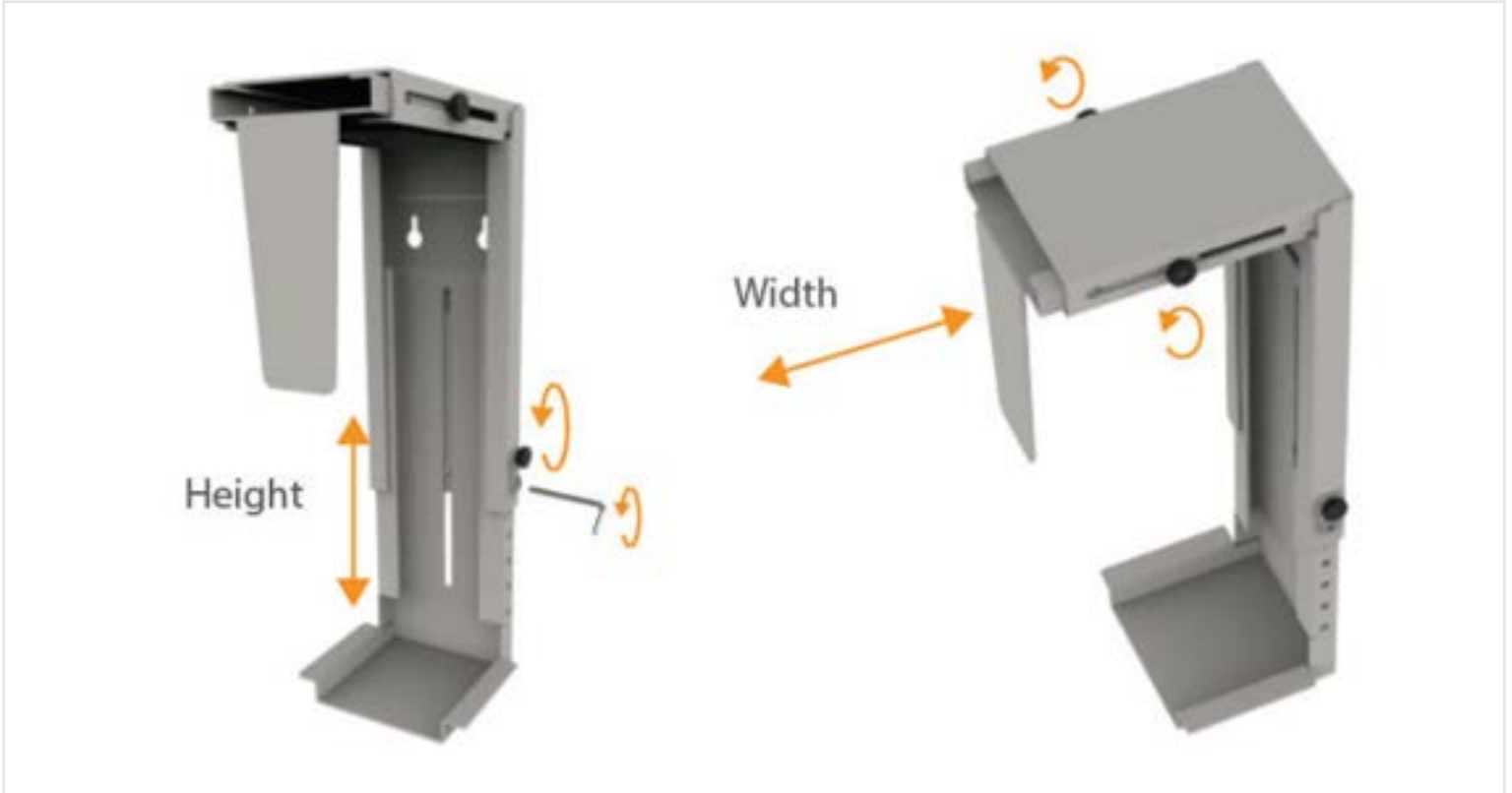
Place your CPU into the CPU Holder.

Adjust the CPU Holder to ensure that your CPU is secured properly. Look at the next page for more details on adjustability.



Add-on: CPU Holder

Adjustability



Add-on: LED Strips

Assembly

x1

 LED Strip 1
(Long)

x1

 LED Strip 2
(Short)

x1


Splitter Cable

x1


LED Switch

x1


AC Adapter

x3


Wood Screw

x2


Large P Clip

x1


Small P Clip

