

For Expanded PVC used Weldon 2007 adhesive with standard applicator or syringe.

Work in well ventilated area and applying all safety protocols

[https://www.tapplastics.com/product/repair\\_products/plastic\\_adhesives/weld\\_on\\_2007/133](https://www.tapplastics.com/product/repair_products/plastic_adhesives/weld_on_2007/133)

## SCIGRIP Weld-On 2007 for PVC



[https://www.tapplastics.com/product/repair\\_products/plastic\\_adhesives/hypo\\_type\\_solvent\\_cement\\_applicator/409](https://www.tapplastics.com/product/repair_products/plastic_adhesives/hypo_type_solvent_cement_applicator/409)

## Hypo-Type Solvent Cement Applicators



Small BD-25/2  
Hypo Applicator

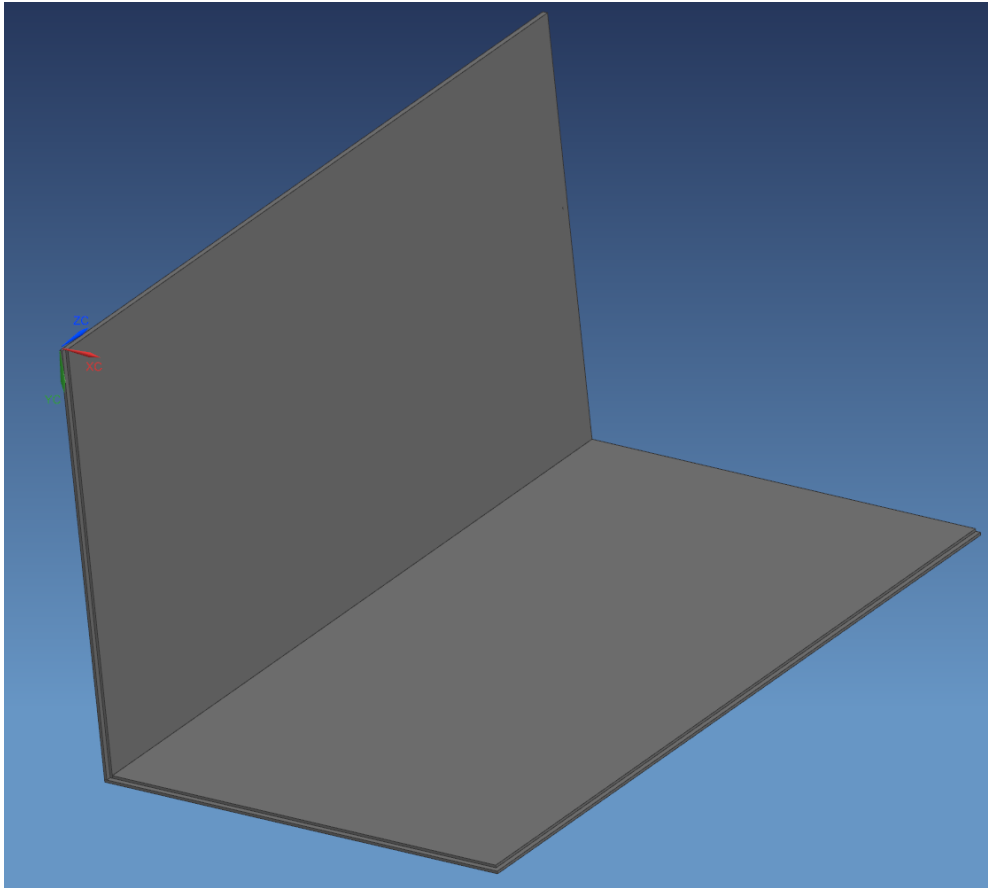


Large BD-49/2  
Hypo Applicator

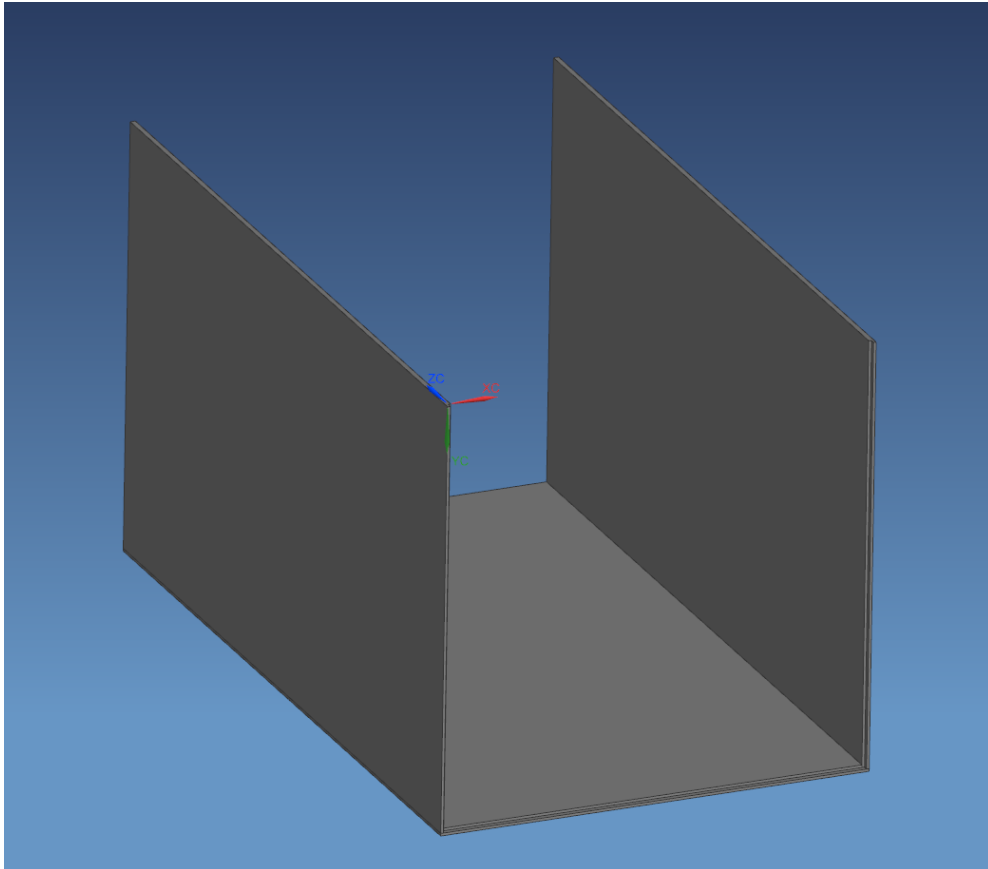


16 Gauge Hypo  
Applicator

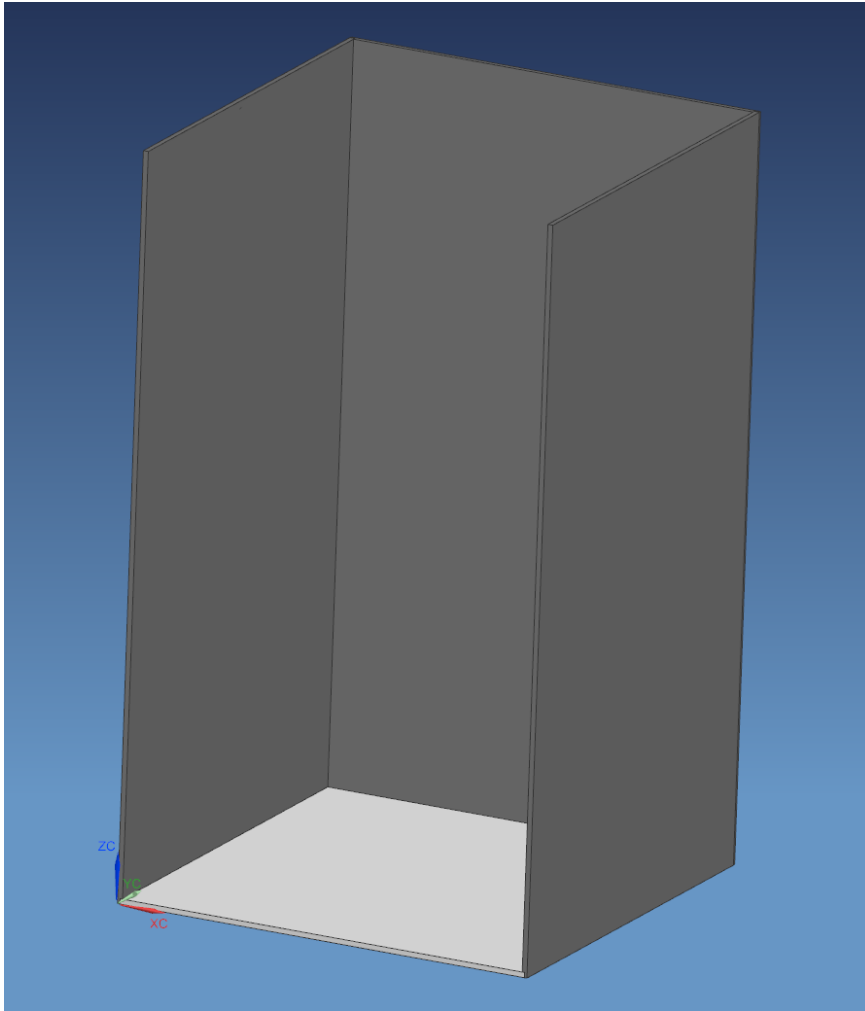
1. Glue together back and one side wall, make sure bottom step is match



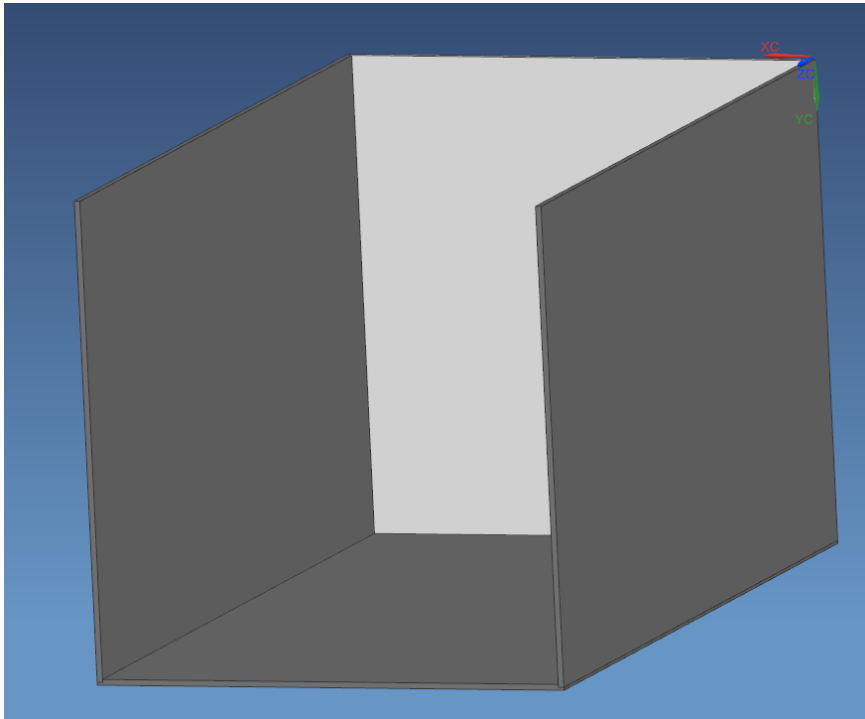
2. Once walls are dry glue second Side wall (add support to first wall, a simple box should do)



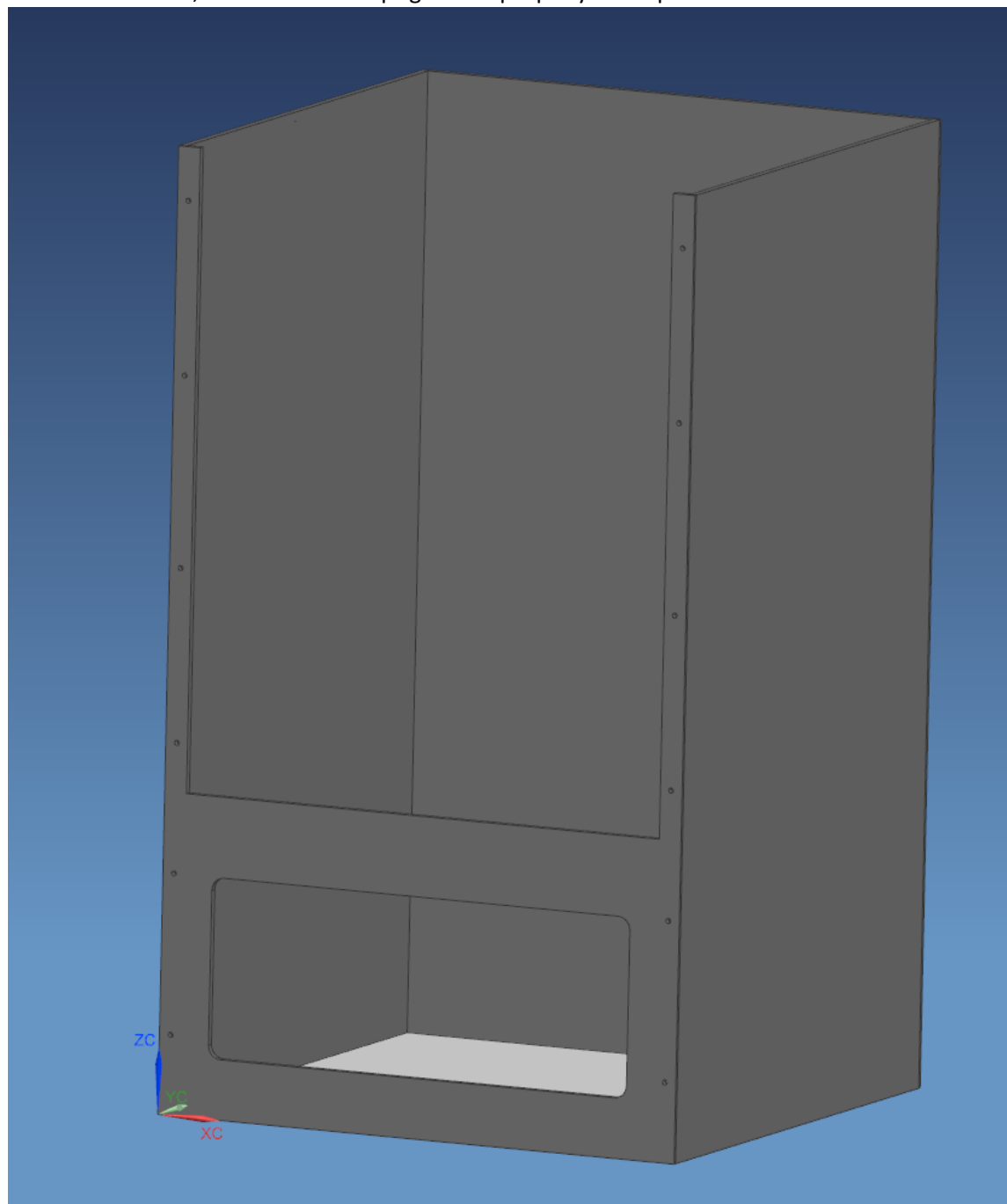
3. Glue in White EXP PVC Floor



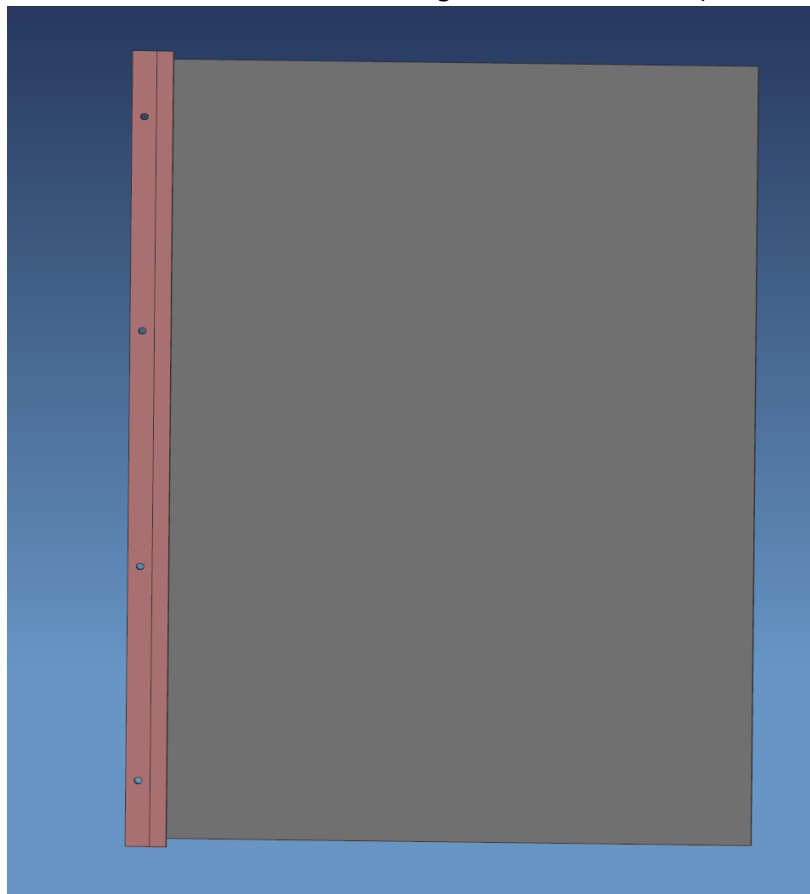
4. At this stage once all is dry its good idea to run Additional Glue along all inner seams to ensure proper seal (Best practice is to Orient seam to vertical position and run glue that way, pay attention to puddles)



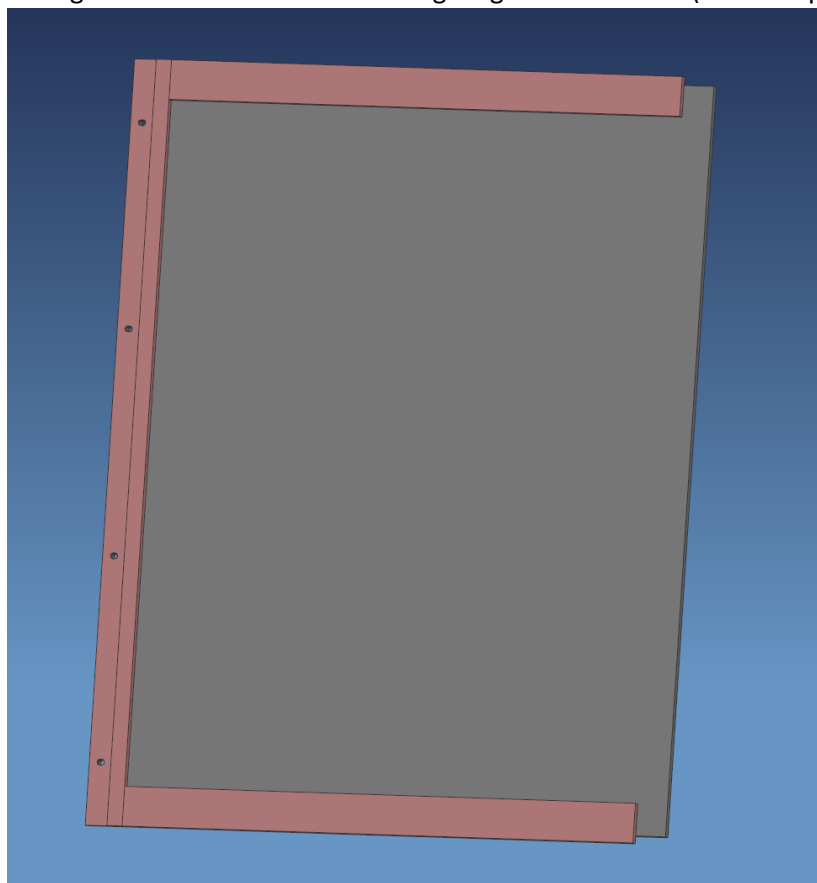
5. Glue in Front wall, make sure thin uprights are properly set in place



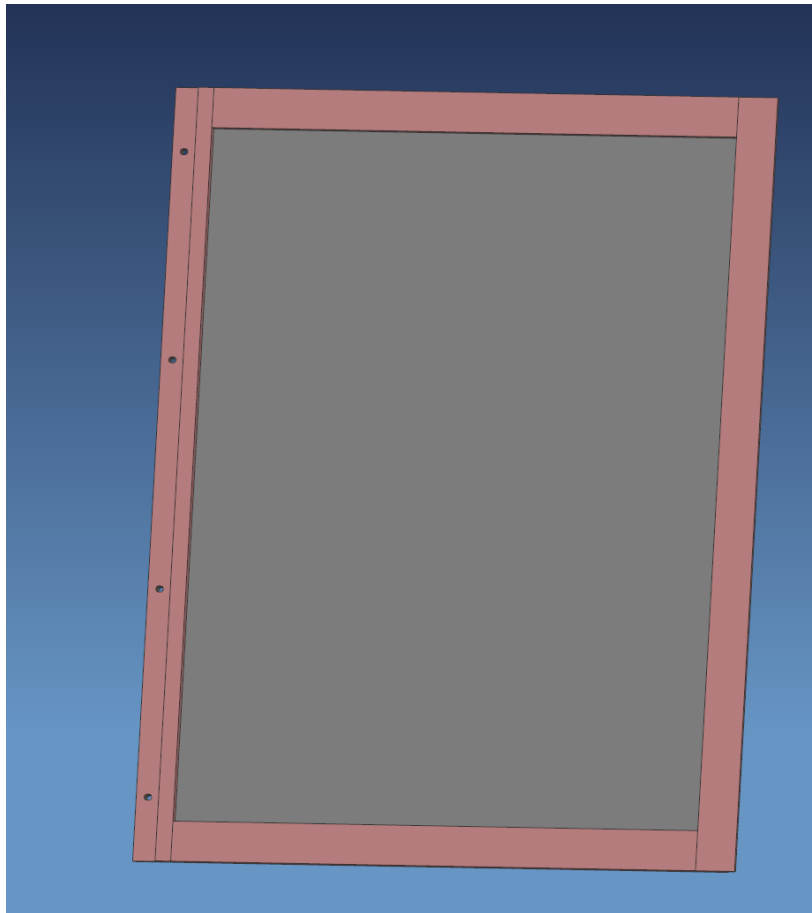
6. Glue in Door and left frame matching all 4 count out slots (Use clamps for drying time)



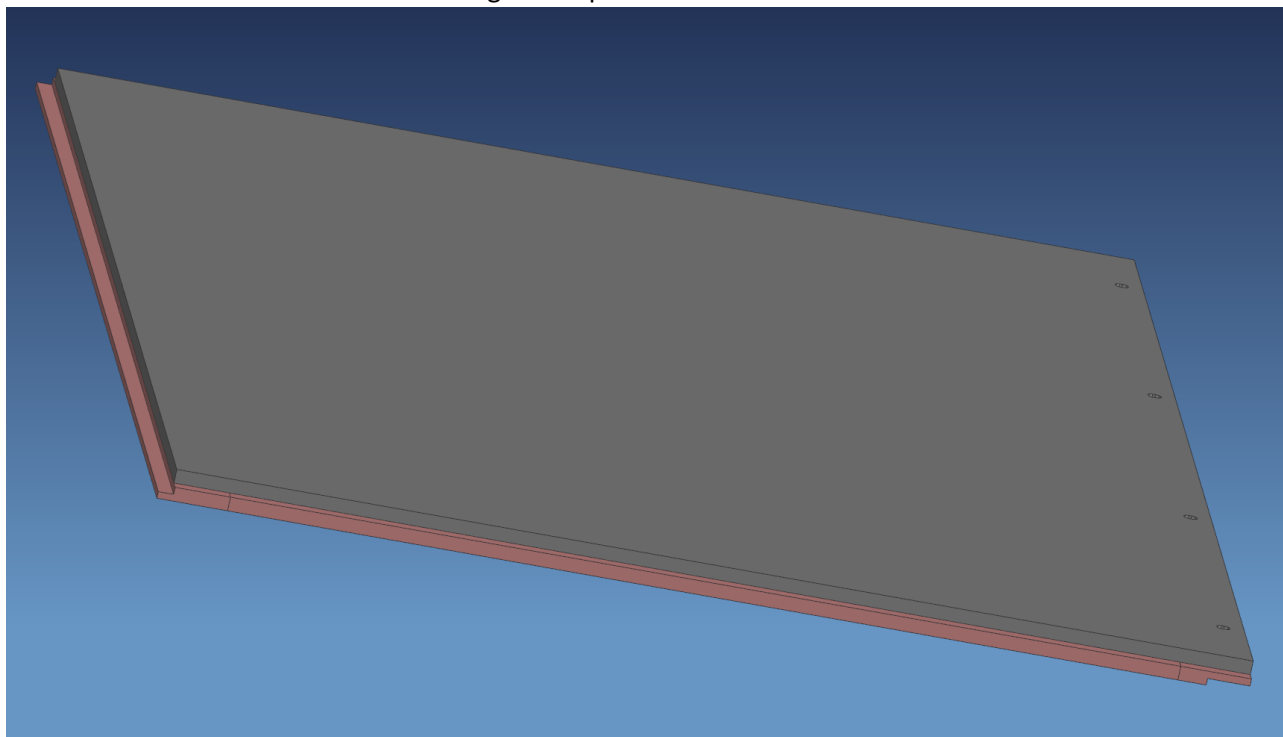
7. Next glue in 2 short frames matching height of left frame (Use clamps for drying time)



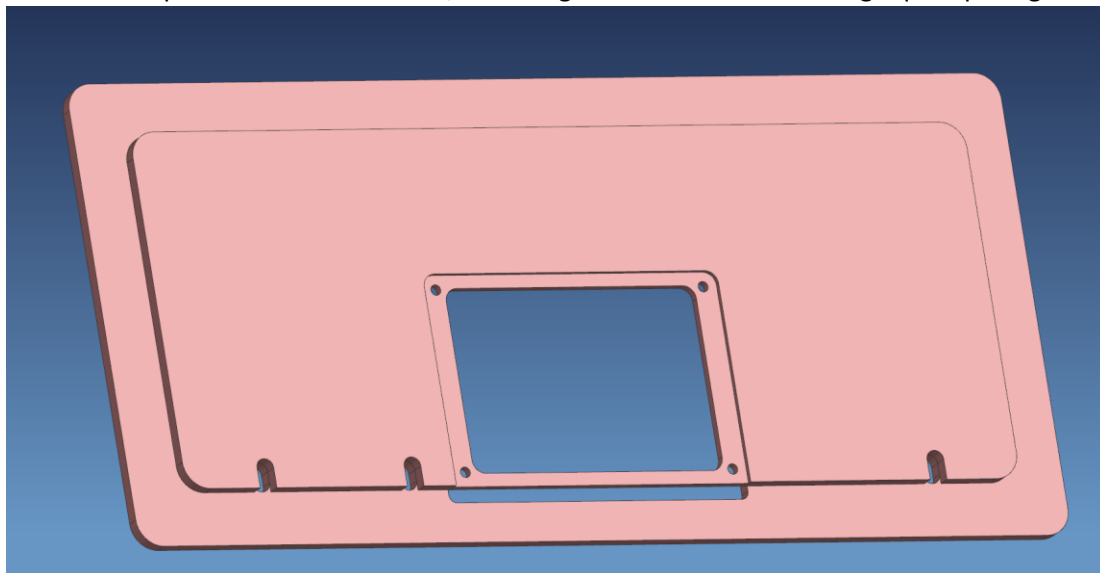
8. Glue in right frame making sure all heights match (Use clamps for drying time)



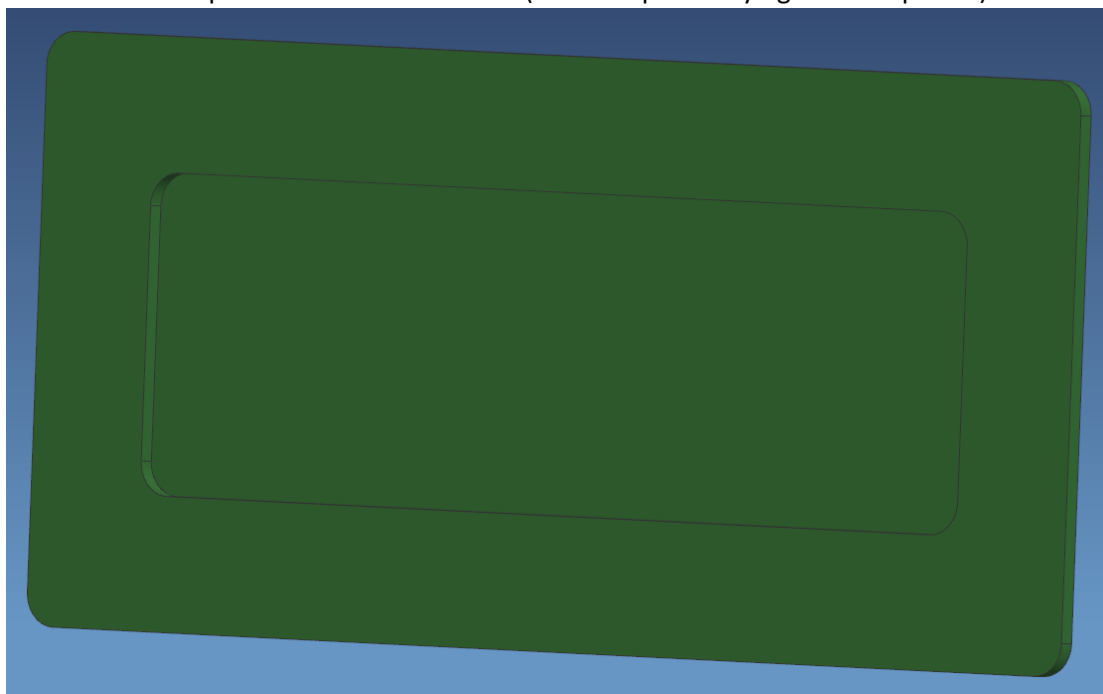
Portion of frame should stick out creating over lap

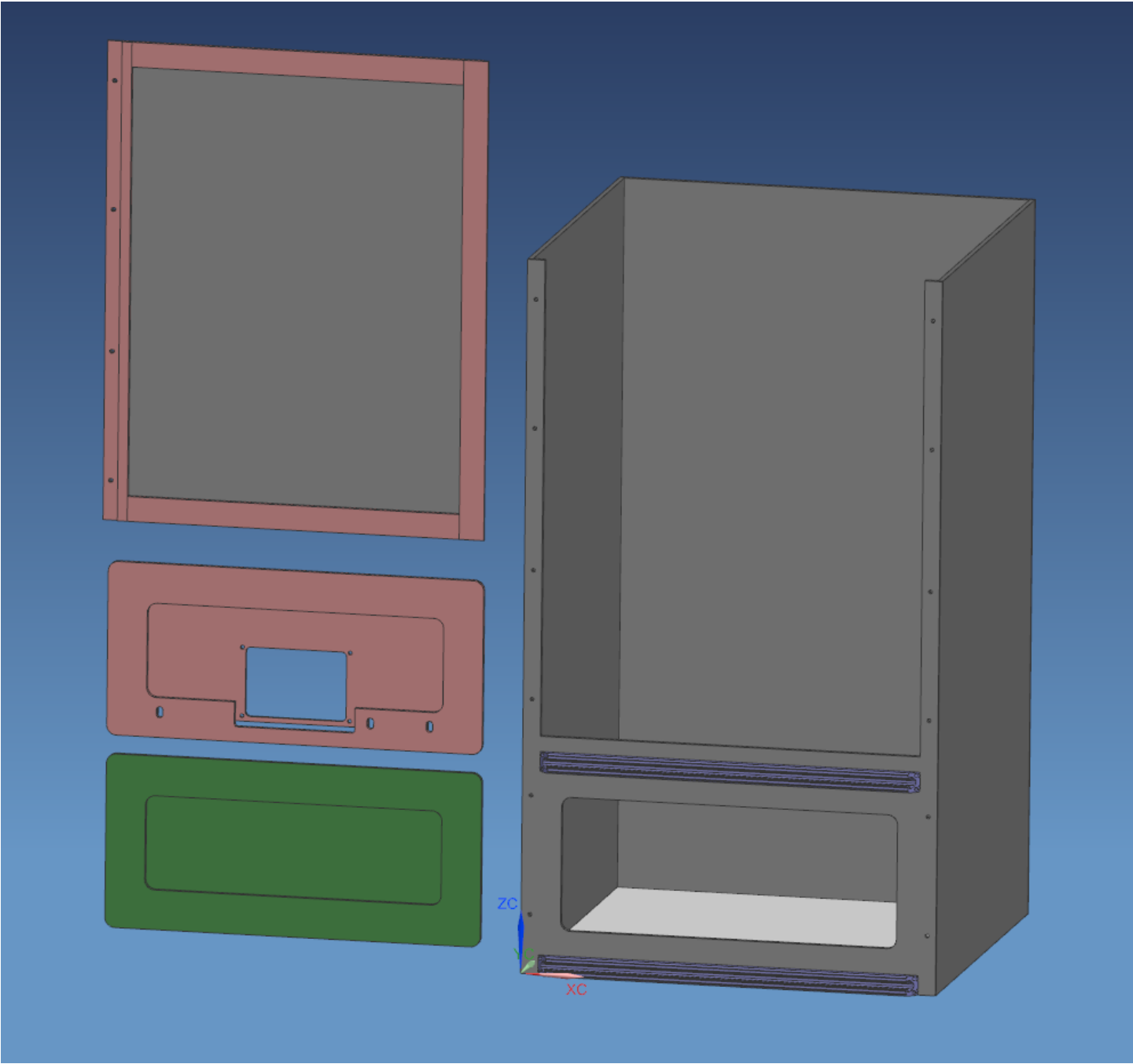


9. Glue in front panel with food cutouts, matching all features and ensuring equal spacing



10. Follow the same procedure for Blank Panel (Use clamps for drying for both panels)





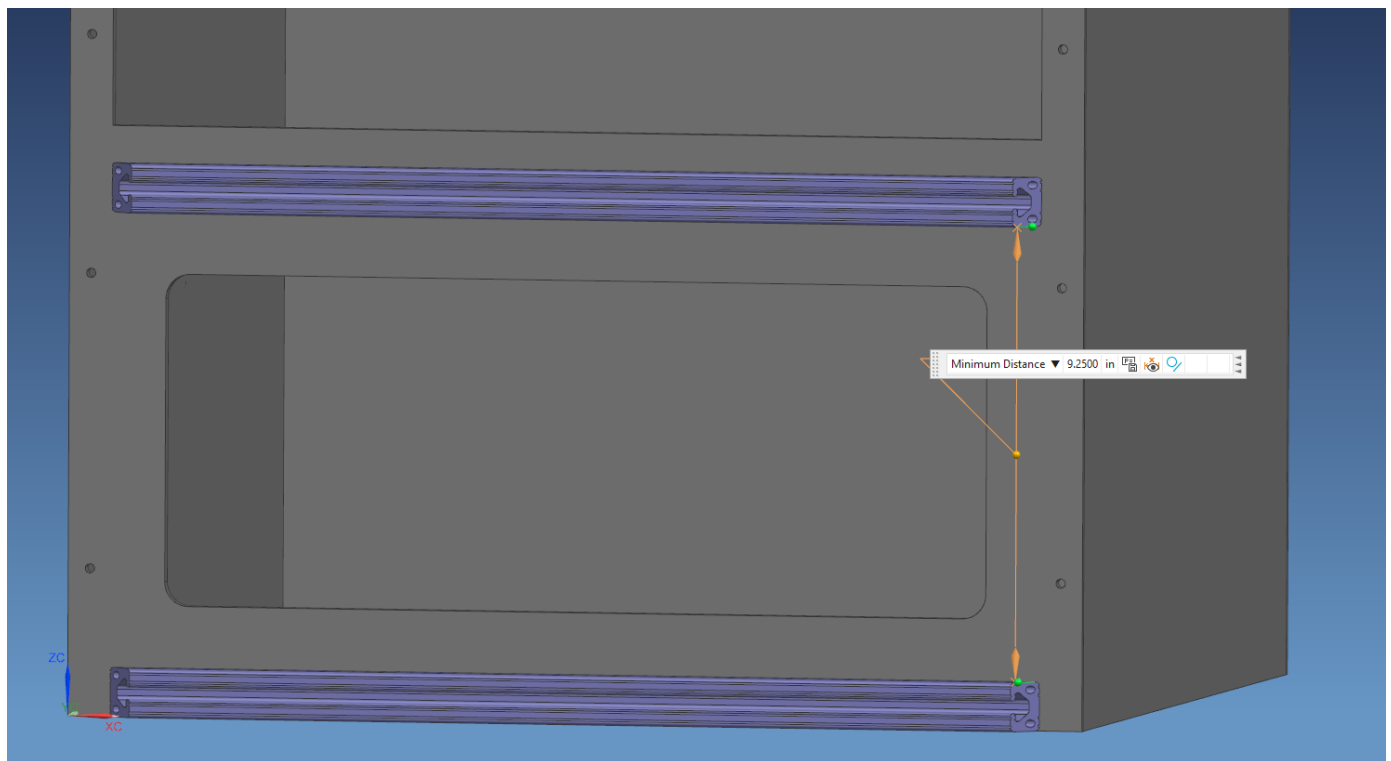


11. Gluing aluminum rails, for this step use super glue or cement glues. We used Loctite 495 that worked very well.

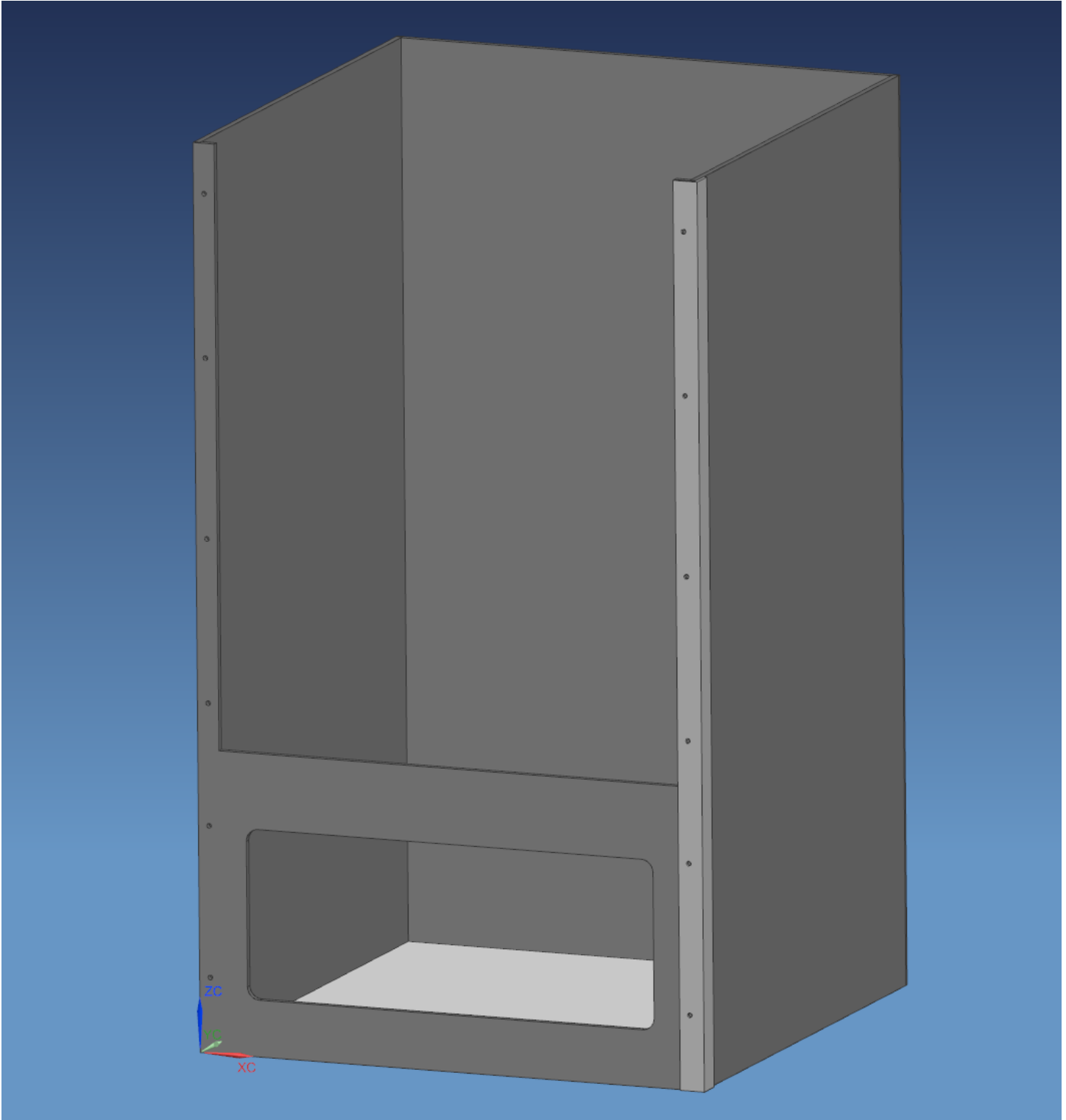


[Link to Glue information](#)

Glue lower rail even with bottom of the unit and top rail 9.25" from top of lower rail to bottom of upper, make sure both are centered on front wall (Use clamps to hold in place for drying)



12. Aluminum Corners – purpose of this part is to strengthen open frame doorway.  
Make sure to purchase aluminum corners with straight inside corner.  
Cut those to match unit's height and mark all hole's locations using machined front as template,  
Drill all holes and fasten corners to the units 2 lower holes (Near opening) using #10-32 or #10-24 nylon screws  
and nuts, trim those flush when done.



13. Hinge: purchase stainless steel piano hinge from part list, it does not need to be with holes as only two will match per side. Cut Hinge to 24 1/8" (61.25 mm) and mark holes location from one of the uprights. Notice on door there 4 small slots so mark center of those for hinge drilling (this is for fine tuning door)
14. when ready attach hinge to either upright using same screws as for aluminum corners (this design allows left of right opening) and attach door the hinge, trim screws length even with nuts.

