



Installation Instructions for TS Type 4 Joining Kit

Part Numbers:

8106.204/504

8108.204/504

8186.204/504

8188.204/504



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Part Numbers: 8106.204/504, 8108.204/504, 8186.204/504 and 8188.204/504

Joining Kit includes:

- 1 box TS8800.430 Angular Baying Brackets
- 2 boxes TS8800.500 Quick-fit Baying Clamps
- 1 box TS8800.400 Baying Clamps
- 1 box TS8800.410 Baying Clamps
- 1 Sealing Sidewall
- 7 red sealing plugs for frame (1 extra)

Tools Required:

- Hammer
- Flat-blade screwdriver
- 3/8" Socket wrench
- Cordless screw gun (recommended)
- T25 Torx driver or bit
- T30 Torx driver or bit
- 7 mm socket or 7 mm wrench
- 13 mm socket or 13 mm wrench



Photo 1

1. Unpack enclosures.
2. **Important: Enclosures must be joined together on a flat and level surface. Do not try to join the enclosures together while they are on a pallet.**
3. Remove one sidewall from each enclosure being joined. Remove the sidewall on the side of the enclosure that will be joined together. (See Figure 1, Page 8)
4. On one of the enclosures that will be joined, remove the sidewall hanger brackets located near the top of the enclosure. (See Figure 1, Page 8, Diagram C)
5. For the same enclosure, remove the rearwall. For easier access to the interior of both enclosures during installation, remove both rearwalls. (See Figure 2, Page 9)
Note: The remaining sidewall hardware still installed in one of the remaining enclosures will be used to install the sealing sidewall in step 10.
6. For the same enclosure, remove the door. The door can be removed by using a flat-head screwdriver to disengage the hinge pins holding the door to the hinge. Simply insert the flat of the screwdriver into the groove at the end of the hinge pins. Push the pin up or down until the pin disengages. (See Figure 3, Page 10)
7. For the same enclosure, remove the sidewall fastening brackets on the side of the enclosure that is being joined. (See Figure 1, Page 8 and Photo 1)
8. Install the red sealing plugs into the holes on the frame formally used to attach the sidewall fastening brackets. There are 6 holes that need to be plugged. (See Photo 2)
 - 8.1. Insert a plug into each hole ensuring that the plugs are straight. (See Photo 3)
 - 8.2. Using a small hammer (or similar tool), lightly tap plugs into the holes until the flange of the plug seats flush with the frame. (See Photo 4)
9. Remove the mounting panels from each enclosure that will be joined. This will make it easier to join the enclosures together. It is not necessary to remove the mounting brackets for the mounting panel. (See Figure 4, Page 11)
 - 9.1. Note: The upper mounting brackets for the mounting panel cannot be located in the first square hole counting from the corner of the frame. The first square hole will be used to install an M8 threaded block that will be used to attach angle brackets. (See Photo 5)



Photo 2



Photo 3



Photo 4



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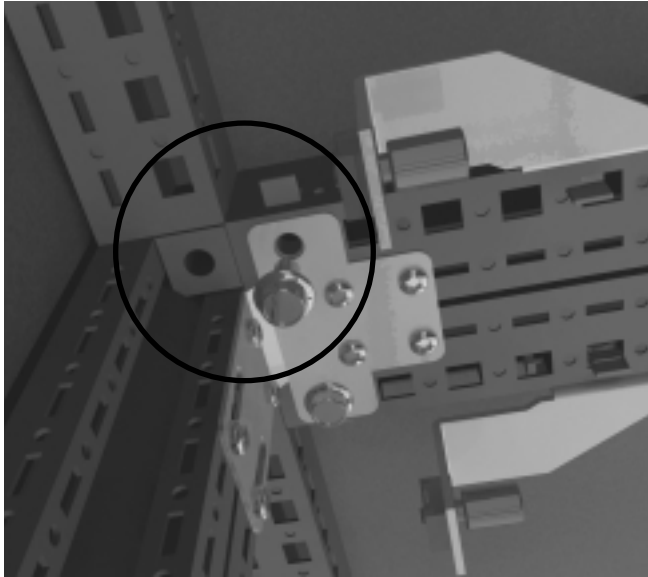


Photo 5

10. Using a T25 Torx bit, remove the shipping depth bars from the side of the enclosures that are being joined together. These will be reinstalled later.
11. Install the Sealing Sidewall on the enclosure with the sidewall hanging brackets still attached. Position the sidewall over the hangers, center Sealing Sidewall along the depth and then allow the Sealing Sidewall to hang vertically. (See Photo 6)



Photo 6

12. Ensure that the centerline of the gasket on the inside of the Sealing Sidewall is aligned with the centerline of the frame profile.
13. Securely fasten the Sealing Sidewall to the enclosure using the sidewall screws removed in Step 3. Once again, ensure that the centerline of the gasket on the inside of the Sealing Sidewall is aligned with the centerline of the frame profile.
14. Position the enclosures next to each other and line up the frame member with the Sealing Sidewall. (See Figure 5, Page 12 and Photo 7)
 - 14.1. Push the enclosures together as much as possible to compress the gasket. (See Photo 8)
 - 14.2. The inside surface of the frame members should be approximately parallel to each other.



Photo 7

Photo 8

15. Caution: Do not stand inside either of the enclosures during this assembly process. Standing inside the enclosures will not allow the enclosures to pull together evenly.
16. Due to installation methods, tool control, positioning of frames, and slight variations in gasket thickness/width, a minimal amount of gasket tear along the interior joint of the enclosures can be expected and will not affect the seal.
17. **Installation of the TS8800.500 Quick-fit Baying Clamps.** The TS8800.500 is comprised of a wedge-shaped bracket and four self-tapping T25 Torx screws. Six brackets will be installed on the front and six brackets on the rear vertical surfaces of the enclosures being joined together. The clear plastic plugs can be discarded. (See Figure 6, Page 12)
 - 17.1. Note: For enclosure heights less than 2000 mm, the number of brackets that can be installed on the vertical sections of the frame will be less. To ensure proper installation and spacing, always start at the top of the enclosure.



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- 17.2. Begin at the front of the enclosures where the two frames are going to be joined together.
- 17.3. From the top inside corner of the frame (left or right side), count down 10 round holes (distance between each round hole is 25 mm) on the vertical surface of the frame directly next to the gasket. This is the mounting hole of the first bracket.
- 17.4. Insert a screw into the angled slot of the bracket.
- 17.5. Install the screw/bracket into the mounting hole. Tighten the screw down only halfway. Make sure the bracket is free to move.
- 17.6. Rotate the bracket until the other angled slot is aligned with the other mounting hole (10 holes from the corner).
- 17.7. Insert a screw into the angled slot of the bracket.
- 17.8. Install a screw into the mounting hole. Tighten the screw down only halfway. Make sure the bracket is free to move.
- 17.9. At this point, the bracket should be at an angle to the vertical frame. (See Photo 9)

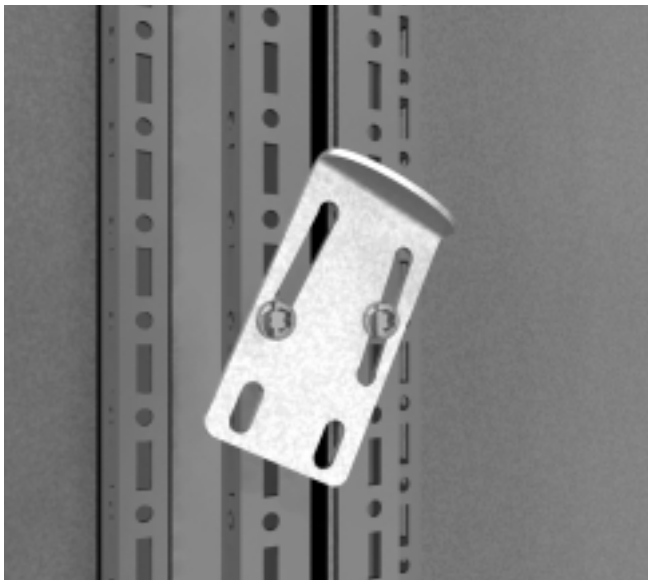


Photo 9

- 17.10. Move to the rear of the enclosures.
- 17.11. Repeat steps 17.3 through 17.9 for each corner, top and bottom.
- 17.12. With a hammer, tap the top of the bracket until the bracket aligns vertically with the frame. Do this for both brackets. (See Photo 10 and 11)

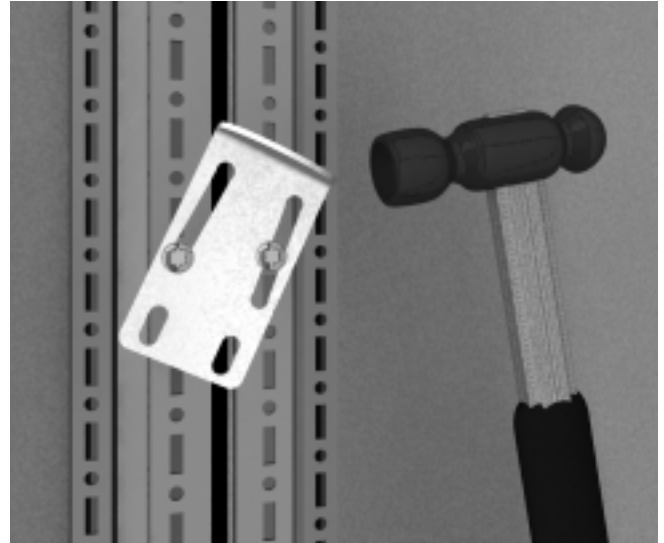


Photo 10

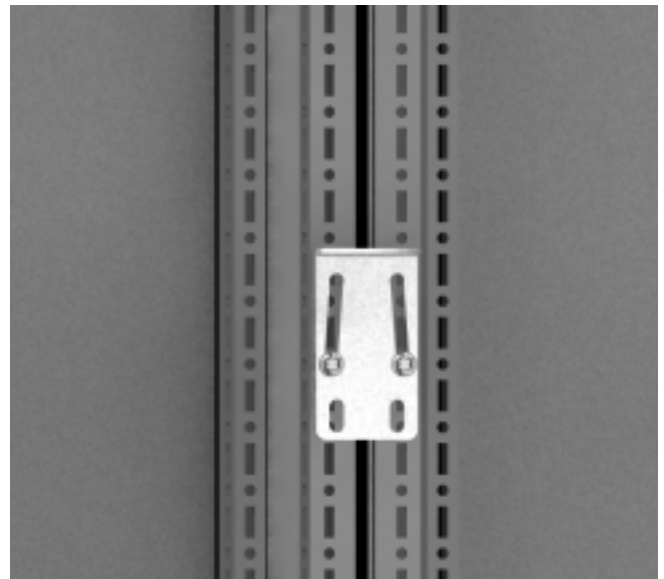


Photo 11

- 17.13. With both brackets in a vertical position, start at the front bracket and tap the top/middle of the bracket with a hammer. Tap the bracket down until the screws are within 1/4" of the end of the slot. This action will start pulling the enclosures together. Do not fully engage the bracket at this time. (See Photo 12 and 13)



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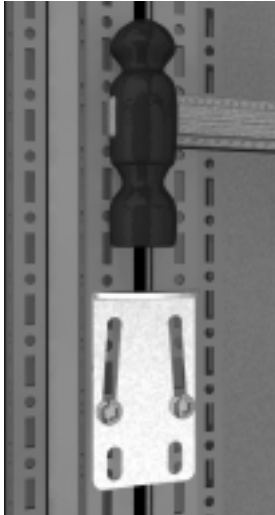


Photo 12



Photo 13

- 17.14. Repeat for the bracket at the rear.
 - 17.15. To install the remaining brackets, count down 10 round holes to locate the next mounting hole. When the mounting hole is determined, follow steps 17.4 through 17.14.
 - 17.16. Repeat 17.15 until all 12 brackets (six front and six rear) are installed.
 - 17.17. Finalize installation by fully engaging all of the brackets. Once again, with a hammer, tap the brackets down until the screw bottoms against the end of the slot.
 - 17.18. Securely tighten down (5Nm/3.69 ft-lbf) all screws located in the slots.
 - 17.19. Install a screw in each of the two remaining oblong holes on the bracket. Securely tighten down (5Nm/3.69 ft-lbf). Repeat for all remaining brackets.
- 18. Installation of the TS8800.410 Baying Clamps.**
- The TS8800.410 is comprised of a C-shaped clamp and a 7 mm hex head setscrew. Four clamps will be installed to facilitate the installation of the TS8800.430 Angular Baying Brackets. The clear plastic plugs can be discarded. (See Figure 7, Page 12)
- 18.1. The clamp straddles the frames of the enclosures being joined. One side of the clamp has two round protrusions that fit into the round holes of the frame on the inner face of the frame. The other side of the clamp has a setscrew that is designed to engage the round hole on the inner surface of the frame to pull the frames together.

- 18.2. From the inside corner of the frame (left or right side), count down four round holes on the vertical surface of the frame. Align the top of the clamp with this hole and engage the round protrusions on the clamp with the holes on the inner surface of the frame.
- 18.3. To position the clamp, rotate the clamp (left or right) over the vertical frame surfaces of the joining frames. (See Photo 14 and 15)

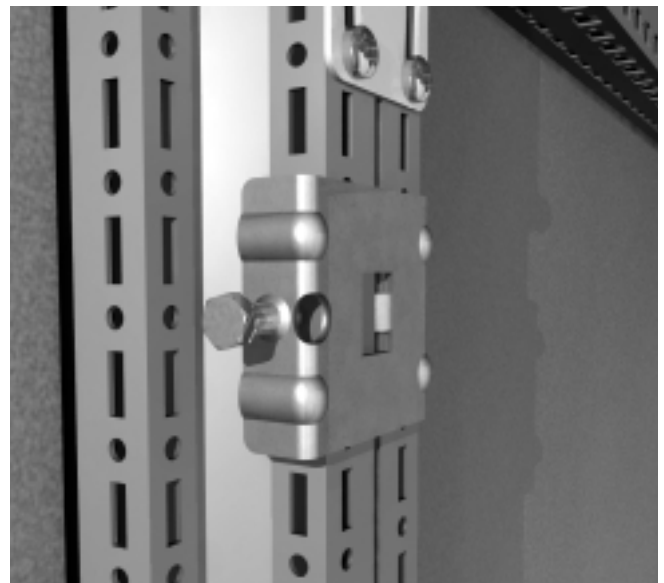


Photo 14

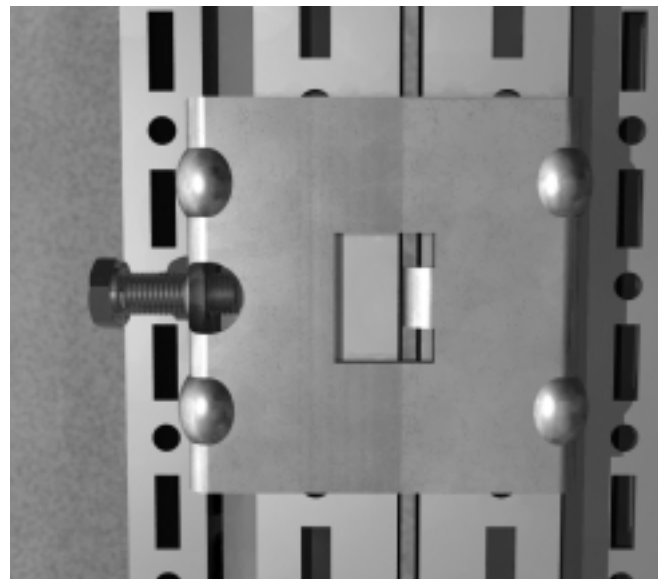


Photo 15



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- 18.4. Slowly tighten the setscrew using a 10 mm hex head driver or wrench. Ensure that the setscrew is engaging the round hole on the frame; if not, move the clamp until the setscrew is aligned with the round hole.
 - 18.5. Once the setscrew is engaged, start tightening the setscrew until the gap between the enclosures is reduced to ~ 1/8".
 - 18.6. Repeat 18.2 through 18.5 for the three remaining clamps.
19. **Installation of the TS8800.430 Angular Baying Brackets.** The TS8800.430 is comprised of a angle bracket, six self-tapping T25 Torx screws, two M8 x 16 mm hex head bolts, and two M8 threaded blocks. Four brackets will be installed, one on each inside corner of the enclosures being joined together. The clear plastic plugs can be discarded. (See Figure 8, Page 12)
- 19.1. From the inside corner of the frame (left or right side), count (up or down) three round holes on the vertical surface of the frame directly next to the gasket. This is the mounting hole of the angle bracket.
 - 19.2. Insert a screw into the angled slot of the angle bracket.
 - 19.3. Install the screw/bracket into the mounting hole. Tighten the screw down only halfway. Make sure the bracket is free to move.
 - 19.4. Move the angle bracket until the other angled slot is aligned with the other mounting hole (third from corner). If the hole does not line-up, pull the frames together further by tightening the setscrew on the TS8800.410 clamps. (See Photo 16)



Photo 16

- 19.5. Insert a screw into the mounting hole through the angled slot of the bracket. Tighten the screw down only halfway. Make sure the bracket is free to move.
 - 19.6. Do not install the remaining hardware.
 - 19.7. Repeat 19.1 through 19.5 for the three remaining angle brackets, one in each corner.
20. **Installation of TS8800.400 Baying Clamps.** The TS8800.400 is comprised of a solid metal clamp, a M8 hex head bolt, and an M8 washer. Four clamps will be installed: two on the top horizontal frame surfaces; and two on the bottom horizontal frame surfaces. (See Figure 9, Page 12)
- 20.1. Starting at the top or bottom frames count in seven square holes along the horizontal from the corner of the frames. This is the mounting hole for the clamp. If there is other hardware occupying this hole move forward or back to the next available hole.
 - 20.2. Place the hooked end of the clamp into the square with the clamp pointing towards the adjoining enclosure. (See Photo 17)



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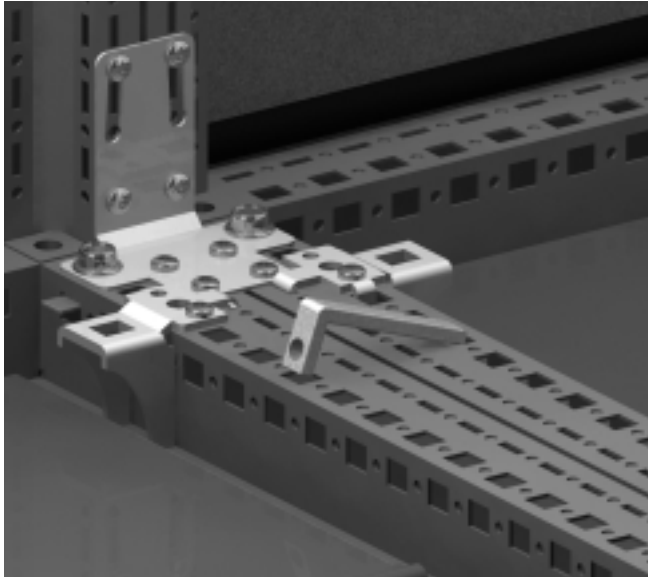


Photo 17

- 20.3. Rotate the clamp towards the adjoining enclosure frame and insert the end of the clamp into the square hole of the adjoining frame. If there is some resistance, use a hammer to tap the clamp into place. Ensure that the tapped hole in the clamp is aligned and accessible through the square hole on the inner surface of the frame.
- 20.4. Insert the M8 bolt and washer into the square hole in the frame to engage threads. (See Photo 18)

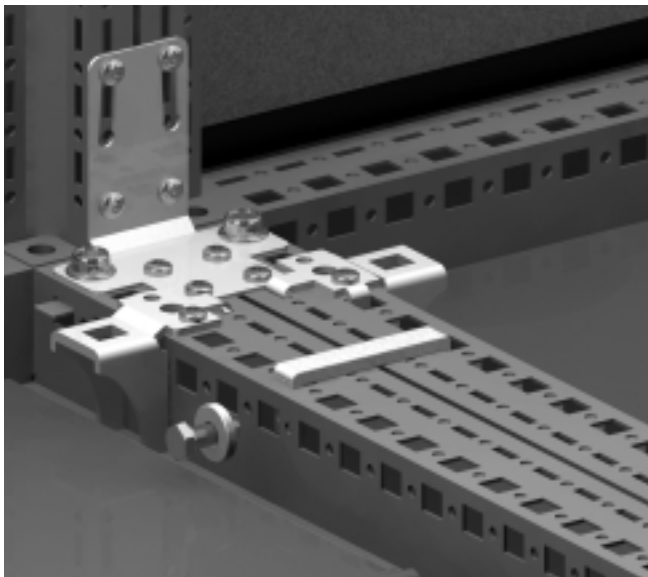


Photo 18

- 20.5. Slowly tighten the M8 bolt to pull the frames together until the gap between the enclosures is reduced to $\sim 1/8"$. (See Photo 19)

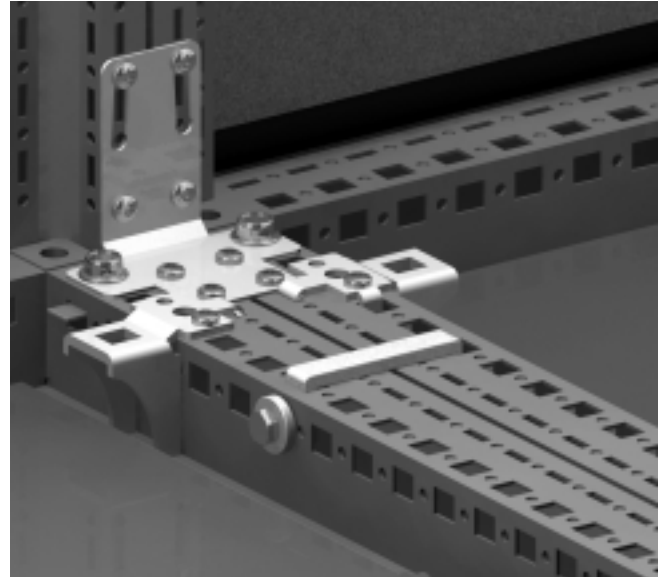


Photo 19

- 20.6. Repeat 20.1 through 20.5 for the three remaining clamps on the horizontal frame members, top and bottom.

21. Finalize installation of TS8800.430 Angular Baying Brackets. (See Figure 8, Page 12)

- 21.1. Note: The upper mounting brackets for the mounting panel cannot be located in the first square hole counting from the corner of the frame. The first square hole will be used to install an M8 threaded block that will be used to attach angle brackets.
- 21.2. Starting in any of the four corners, with a hammer, tap the angle brackets towards the corner of the frames until the bottom of the bracket is flush against the top or bottom horizontal frame surfaces.
- 21.3. Insert an M8 threaded block into the first square hole (left or right) from the corner on the inner surface of the frame.
- 21.4. Holding the threaded block with your finger, insert an M8 bolt through the large round hole in the angle bracket directly above the threaded block.
- 21.5. Securely tighten the bolt (9Nm/6.64 ft-lbf).
- 21.6. Repeat 21.3 through 21.5 for the other side of the angle bracket.

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- 21.7. Repeat 21.2 through 21.6 for the remaining three corners.
- 21.8. Install a self-tapping T25 Torx screw in each of the remaining holes on the angle bracket. Securely tighten down (5Nm/3.69 ft-lbf). Repeat for all remaining brackets.
- 21.9. Securely tighten down (5Nm/3.69 ft-lbf) all screws located in the slots of the angle brackets. (See Photo 20)
22. Reinstall the shipping depth bars. If there is hardware interference, move the depth bars up or down until they can be installed. However, the depth bars must be located as close to the vertical center of the enclosures as possible.
23. The doors, rear walls, and mounting panels can be re-installed at this time.

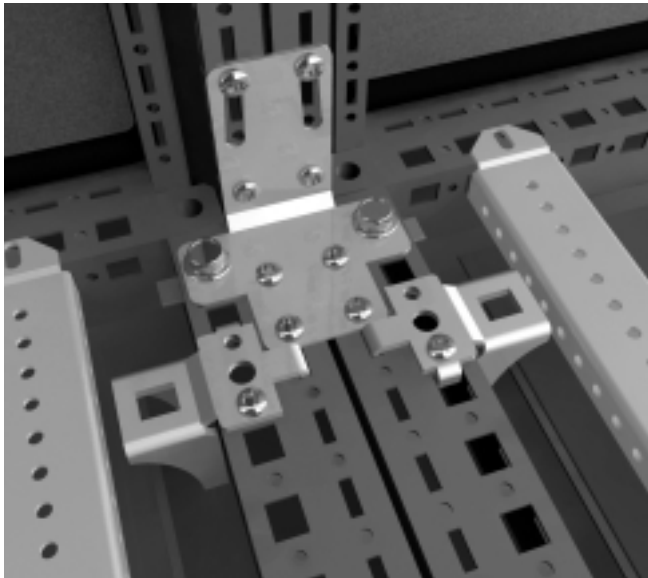
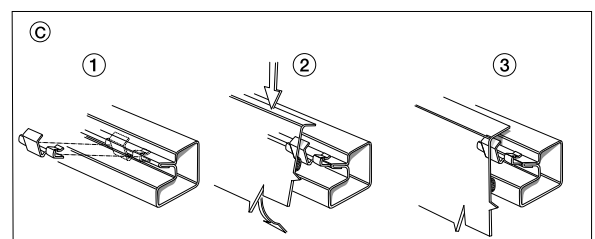
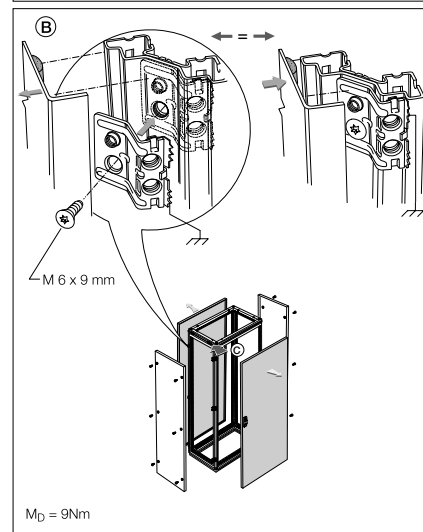
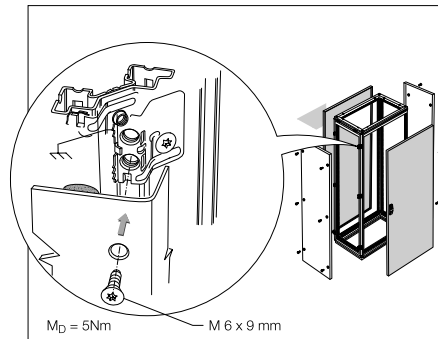
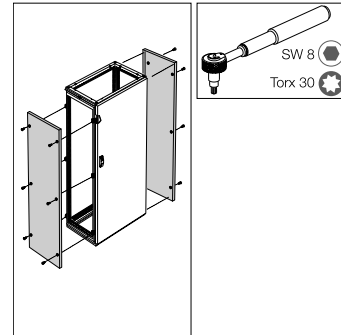


Photo 20

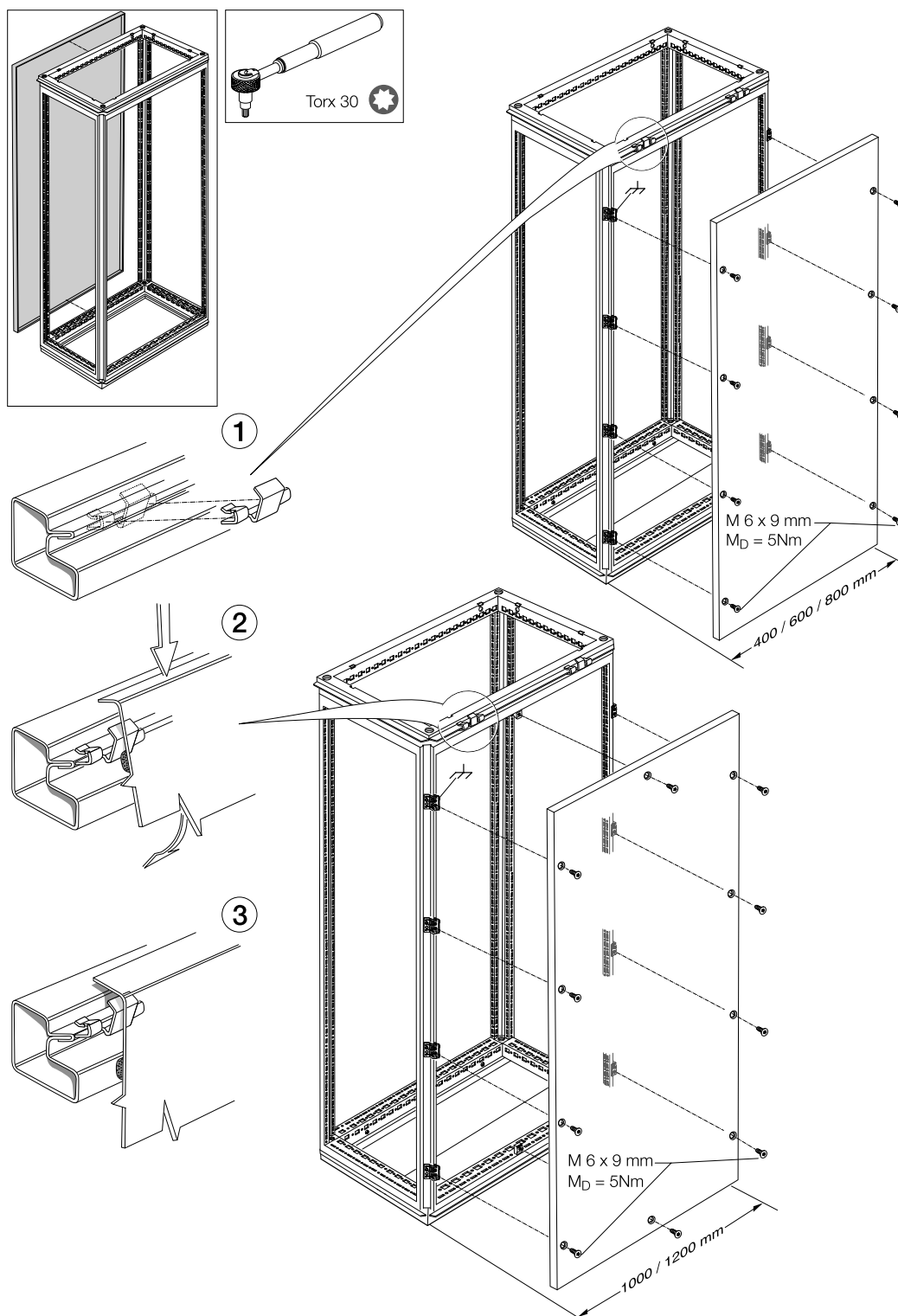
Figure 1



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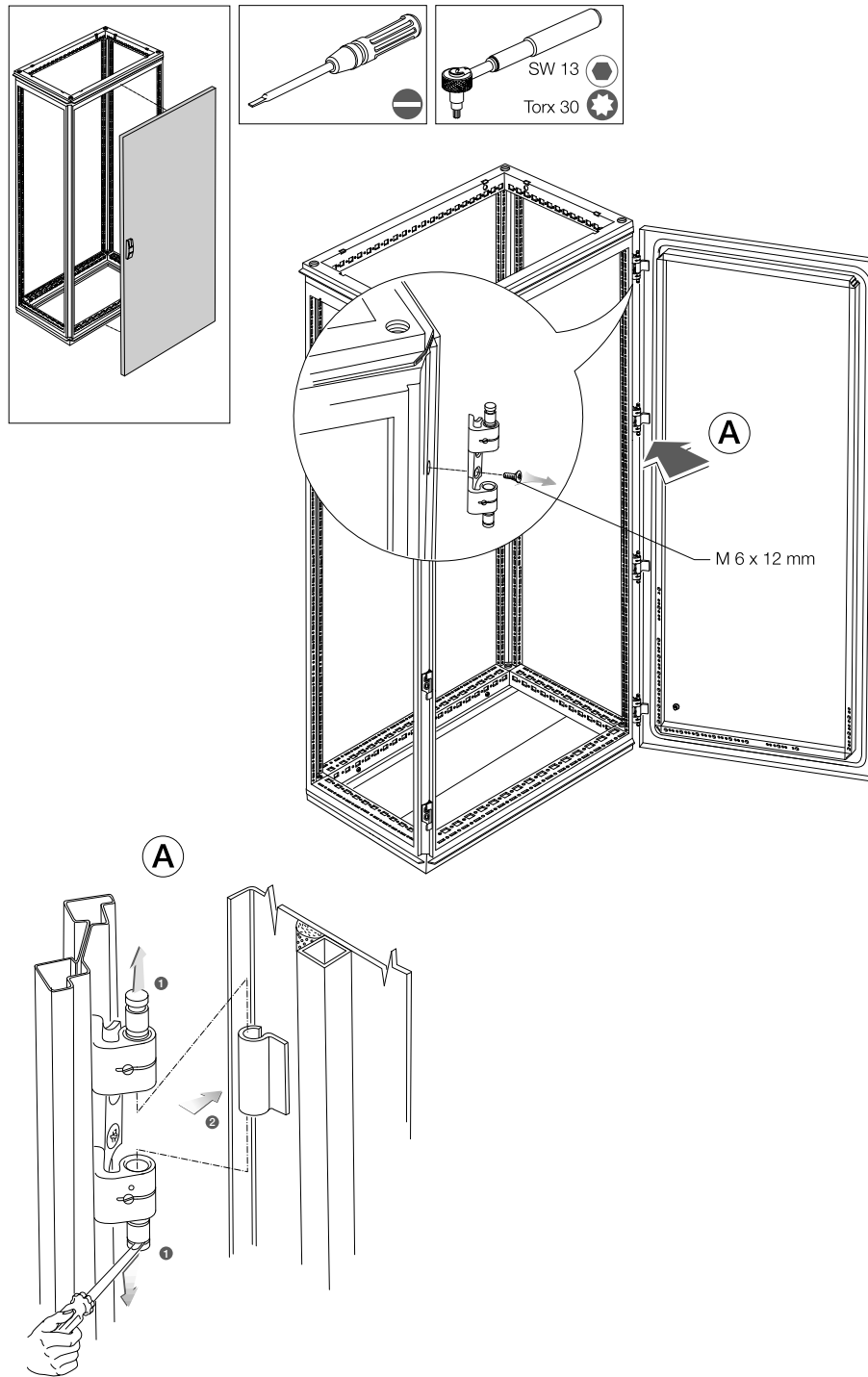
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Figure 2



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Figure 3



11



Installation Instructions for TS Type 4 Joining Kit Part Numbers: 8106.204/504, 8108.204/504, 8186.204/504 and 8188.204/504

Figure 5

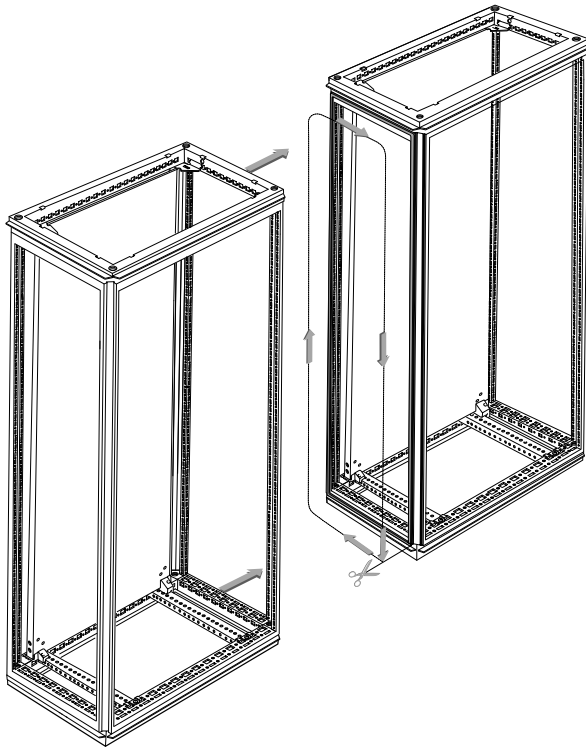


Figure 8

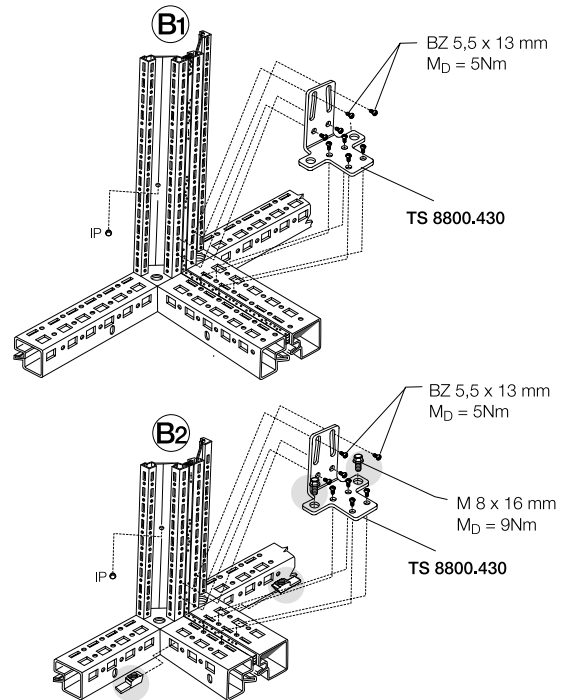


Figure 6

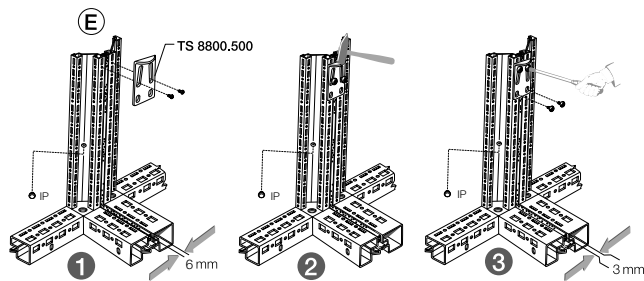


Figure 9

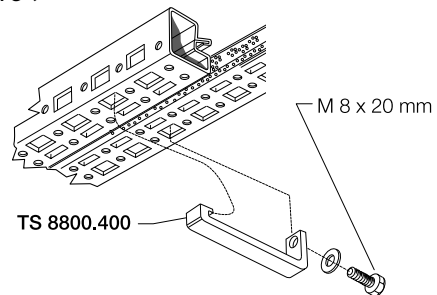
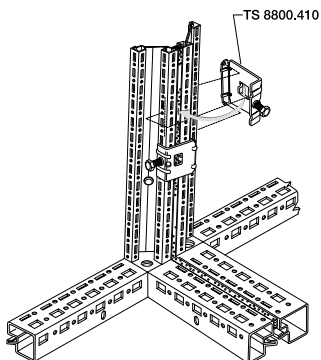


Figure 7



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