

# Technical Specifications

## Develop® E Base Tables



### Develop® E Base Table

This system employs 14-gauge, 1-3/4" O.D. tubular 1010 steel components in fixed, folding or flip-top models. Develop's E Base offering includes T, TT, X, LX and cantilevered 'T' leg combinations. LX series is furnished with 3" O.D. seamless tubular steel column. All ends capped with finished steel plugs brazed in place, ground and polished smooth. End cap joints and leg to stringer joints will be silver brazed with 505 alloy (50% silver and 50% other, including 2% nickel added for a strong joint). Adjustable glides are secured to the legs via steel inserts in foot tube (riv-nuts) which provide a 5/16" threaded hole for the glide.

### Fixed Base

Fixed table column welded to an 8" x 8" square, 12-gauge sheet steel plate with formed ribs for added strength and 4 mounting screws (5/16" hole for a #14 screw). LX legs will be welded to an 8" x 8", 1/4" sheet steel plate.

### Folding Base

Develop E Base table's folding mechanism is built of 11-gauge (.120" thick) hot rolled, black zinc plated steel. The folding mechanism easily releases and folds leg tightly to table bottom and securely locks with two injection molded polypropylene clips. When opened, legs engage into place for a tight, rigid fit between leg and mechanism. Locks are built of 10-gauge (.135" thick) black zinc plated hot rolled steel and rotate into place with .075" diameter wire torsion springs. Mechanism utilizes 1/4" diameter black zinc plated solid rivets in all pivoting joints. Leg pivots about a 5/8" diameter solid steel support rod. Built-in nylon bumpers keep tables separated to prevent marring when tables are stacked on edge.

### Flip-Top Base

The mechanism will be made of formed steel plates hinged at one end with a steel hinge pin. The lower plate will be welded to the base. The upper plates will be attached to the table top with six wood screws. As the table top is rotated from its storage position to its use position, a lock rod fixed to the upper plate will deflect the lock bar until it snaps into engagement. Cam surfaces on both ends of the lock bar will engage ends of the lock rod to prevent looseness in the mechanism. To store the table the release handle on the lock bar is pushed and the table is rotated to its storage position. The lock is designed to lock firmly and to be dependable, with only one moving part in the lock mechanism.

### Folding Modesty Panels

Modesty panels are 6-1/4" high by length of table. Mounting brackets are black and packed with base. Lower edge of panel extends 8-1/4" from underside of table.

### Leg Wireways

Leg wireways will be scuff resistant, high impact, rigid PVC plastic with two separate wire channels per leg. Leg wireways will be fastened to the legs using a full length adhesive bond. Wireways will be available in black only. They will be shipped assembled. There will be one wireway per leg.

### **Under-Table Wire Harness**

Constructed of high quality black Velcro. Harness is fastened to table bottom with screws. Shipped assembled. Wire management options (HO, HW and WO) are only available on rectangle tables 96" and smaller (not available on any cantilever, flip-top or folding tables).

### **Table Truck**

Product minimums for the truck will be 48" round or square and 18" x 48" rectangular. Maximum table sizes are 48" x 96" rectangular or 60" round or square. Maximum number of Develop E Base folding tables will be 6, short fold will be 4. Overall dimension of the truck will be 30" wide, 60" long and 54" high. Overall weight will be 90 lbs. The truck platform will be constructed of 2" x 2" angle iron and the two side rails of 1" diameter x 14-gauge tubing. Two swivel and two rigid 5" diameter casters with heavy-duty roller bearings will permit easy and safe movement on any hard floor surface. Shipment will be in two packages: one with the truck platform and one with the two side rails. Assembly with four thumbscrews will be required.

### **Chroming**

Steel surfaces will be duplex nickel-chrome plated in a twenty-two step process. This process is the same as is used in the automotive industry for exterior finishes.

### **Brazing**

Brazing will entail the joining of two metal parts by melting an alloy into the joint between the two parts. By heating the joint and melting the alloy through contact with the joint, the alloy will be pulled into the joint through a phenomenon called capillary action. This will create a strong bond between the two parts. The joint is actually stronger than the parent material. Plus, joint appearance will be clean and smooth.