HAMMOND MANUFACTURING®

BUL10020
REV. J
EFFECTIVE: JUL. 24, 2026

HAMMOND MANUFACTURING COMPANY LIMITED
394 EDINBURGH RD. N, GUELPH, ON, CAN. NIH 1E5
TEL: (519) 822-2960 OR (905) 456-3770, FAX: (519) 822-0715
475 CAYUGA RD, CHEEKTOWAGA, NY, USA 14225
TEL: (716) 630-7030, FAX: (716) 630-7042

Visit us @ our website: www.hammondmfg.com

FINISH:

HAMMOND painted enclosures are finished with recoatable powder paint. Stainless steel and aluminum enclosures are also available.

SUB PANELS:

Panels are normally fitted to the mounting studs at the factory. If panels are ordered seperately, switched from another enclosure, or rotated, the mounting studs may not line up properly. Simply bend the misaligned stud using a short length of pipe or place the panel on the studs that do line up and pry the other studs into position with a large screwdriver.

HINGES:

PIANO HINGES: Removal of piano hinges may be accomplished by
1) Use a centre punch and hammer to start the removal process.
2) Use a hammer and pin with a smaller diameter than that of the hinge to continue driving the hinge pin out.

SLIP HINGES: Many freestanding enclosures feature heavy duty slip hinges which allow for convenient door removal when desired. These hinges provide excellent strength to support items mounted onto doors. (door for 72" high enclosure tested successfully at 575 lbs. loading)



DOOR ADJUSTMENTS:

TWO DOOR ENCLOSURES: The overlapping doors are fitted at the factory to match evenly at the top and bottom. If the enclosure is mounted on an uneven surface, the door may not close evenly and will require shims to be placed between the enclosure and the mounting surface.

FLOOR MOUNTED ENCLOSURES: Shims under the right front corner will raise the right door. Shims under the left front corner will raise the left door.

WALL MOUNTED ENCLOSURES: Shims behind the bottom right mounting foot will raise the right door. Shims under the bottom left foot will raise the left door. External mounting hardware required to maintain Type 4, 4X, 12, 12K and 13.

SINGLE DOOR WALL MOUNT ENCLOSURES: If the surface on which the enclosure is mounted is not flat, or if heavy equipment is mounted on the door, the door may not close properly. If the top of the door strikes the flange around the body opening, metal shims placed between the mounting surface and the bottom of the mounting foot
(on the hinge side) will raise the door. Tighten all mounting bolts.

COVER SCREW TORQUE RATINGS:

Screw Cover Series (10-32 screws) = 10 in-lbs / 1.13 Nm
Clamp Cover Series (1/4-20 and 1/4-28 screws) = 30 in-lbs / 3.39 Nm

For details of Hammond Manufacturing warranty, visit www.hammfg.com/warranty
-Hammond standard warranty supersedes any alternative request or demand unless specifically approved in writing by Hammond.

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INSTRUCTIONS FOR REPAINTING HAMMOND POWDER COATED PRODUCTS

- All Hammond standard powder coated products can be repainted.
- Check with your paint manufacturer to insure that the paint you are applying is compatible with the paint on the Hammond product. (Hammond uses Polyester and Hybrid powder coatings on standard catalogue products)
- Always test the repainting process in an inconspicuous area prior to use.

This painting instruction applies to ANSI 61 (Gray) and RAL7035 (Light Gray).
All other Hammond powder paints can be repainted by following step 5.

1) IMPORTANT - This step is mandatory and must be done carefully.
   Wipe down the entire area to be repainted with laquer thinner or acetone. Use a clean cloth and change cloth frequently.
2) Apply finish coats as per your paint manufacturers instructions.
3) Allow paint to cure properly for best adhesion and hardness. Consult your paint manufacturer for proper cure time and temperature.
4) The above procedure promotes good inter-coat adhesion. To enhance this process sanding with a 220 grit sandpaper is recommended. Remove all sanding dust using clean rags and a tack cloth.
5) All Hammond standard powders can be repainted after a light sanding with 220 grit sandpaper and cleaning.

Hammond Touch-Up (Spray Cans)

Part Number	Color Match
1413LRS	Gray (ANSI 61)
1413WH9003	White (RAL9003)
1413CGRALS	Beige (RAL7032)
1413BKS	Black
1413LGS	Light Gray

Recommended Torque Rating (in-lbs) for Welded Studs					
10-32 / M5 or Smaller		1/4-20 / M6 or Smaller		3/8-16 / M10 or Smaller	
(in-lbs)	(Nm)	(in-lbs)	(Nm)	(in-lbs)	(Nm)
10	1.13	20	2.26	40	4.52

RECOMMENDED CLEANING INSTRUCTIONS FOR STAINLESS STEEL PRODUCTS

Simple stainless steel stains can be cleaned using a soft cloth, mild soap, and warm water. For more stubborn stains including fingerprints and grease, a commercial grade stainless steel polish is recommended. (Note: Avoid use of chlorine based cleaners)