

ASSEMBLY INSTRUCTIONS

X-SIEGE PACKAGES



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Expansion for 14', 24' and longer X-SIEGE systems:

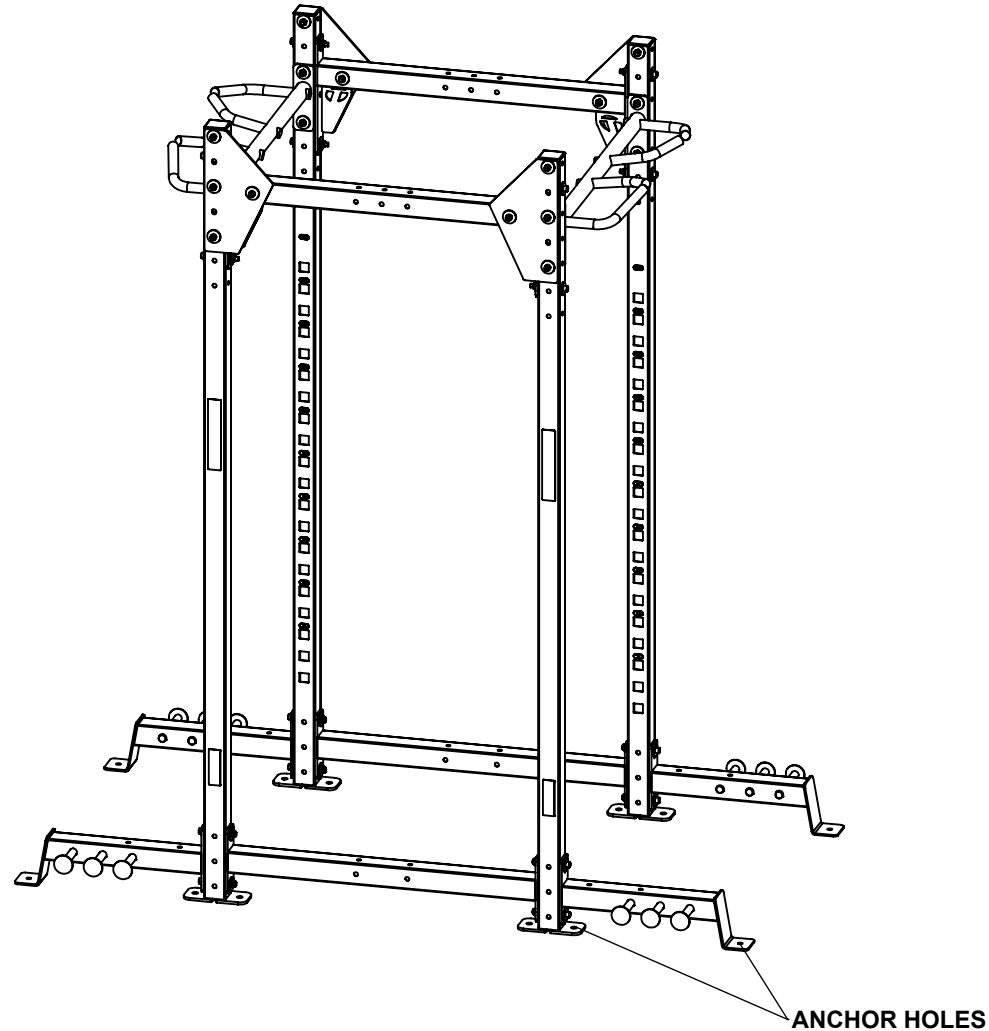
- **XSS-4-24-X1: PAGE 52**
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NOTES:

Standard packages include 9' Uprights. These instructions detail assembly of standard 9' packages and optional 8' packages.

8' Upright option is not compatible with XSSC-4-4-X1, XSSC-4-24-X1 or any SIEGE system that includes the XCCS Cable Component Station.

ANCHOR STEP (OPTIONAL)



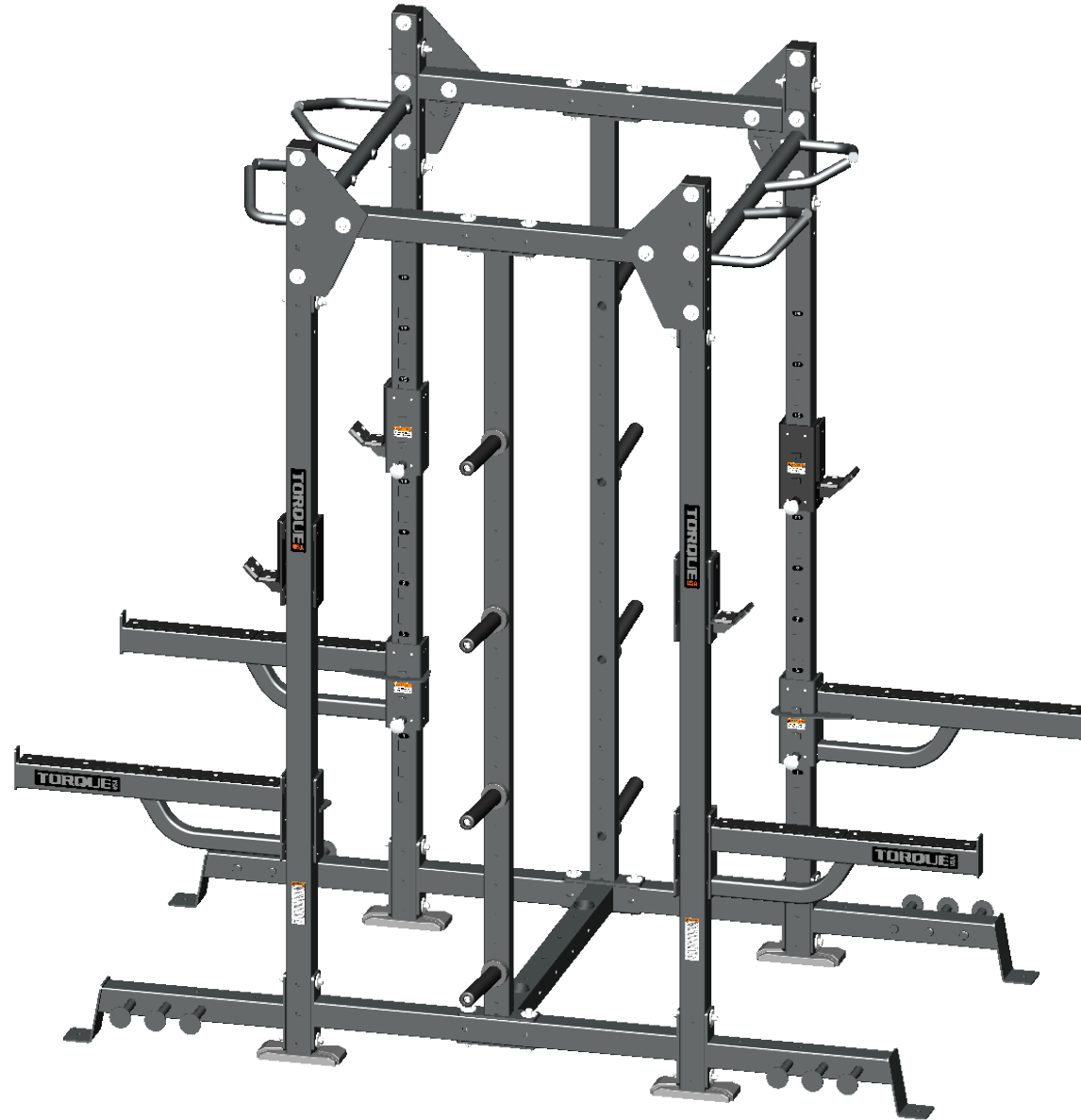
WARNING!

IF THE X-SIEGE SYSTEM IS TO BE USED FOR BODY WEIGHT STRAP TRAINING, (ALSO REFERRED TO AS SUSPENSION TRAINING OR TRX TRAINING) THE SYSTEM MUST BE PROPERLY SECURED TO THE FLOOR TO STABILIZE AND ELIMINATE ROCKING OR TIPPING.

For floor anchoring instructions, please visit our web site at:
www.torquefitness.com/assembly-manuals/X-SERIES
ANCHORING INSTRUCTIONS/X-SERIES FLOOR ANCHORING INSTRUCTIONS

ASSEMBLY INSTRUCTIONS

4 X 4 STORAGE RACK

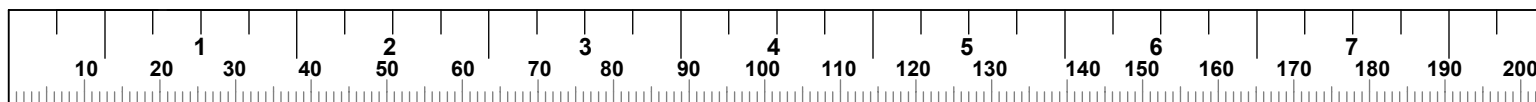


TORQUE USA

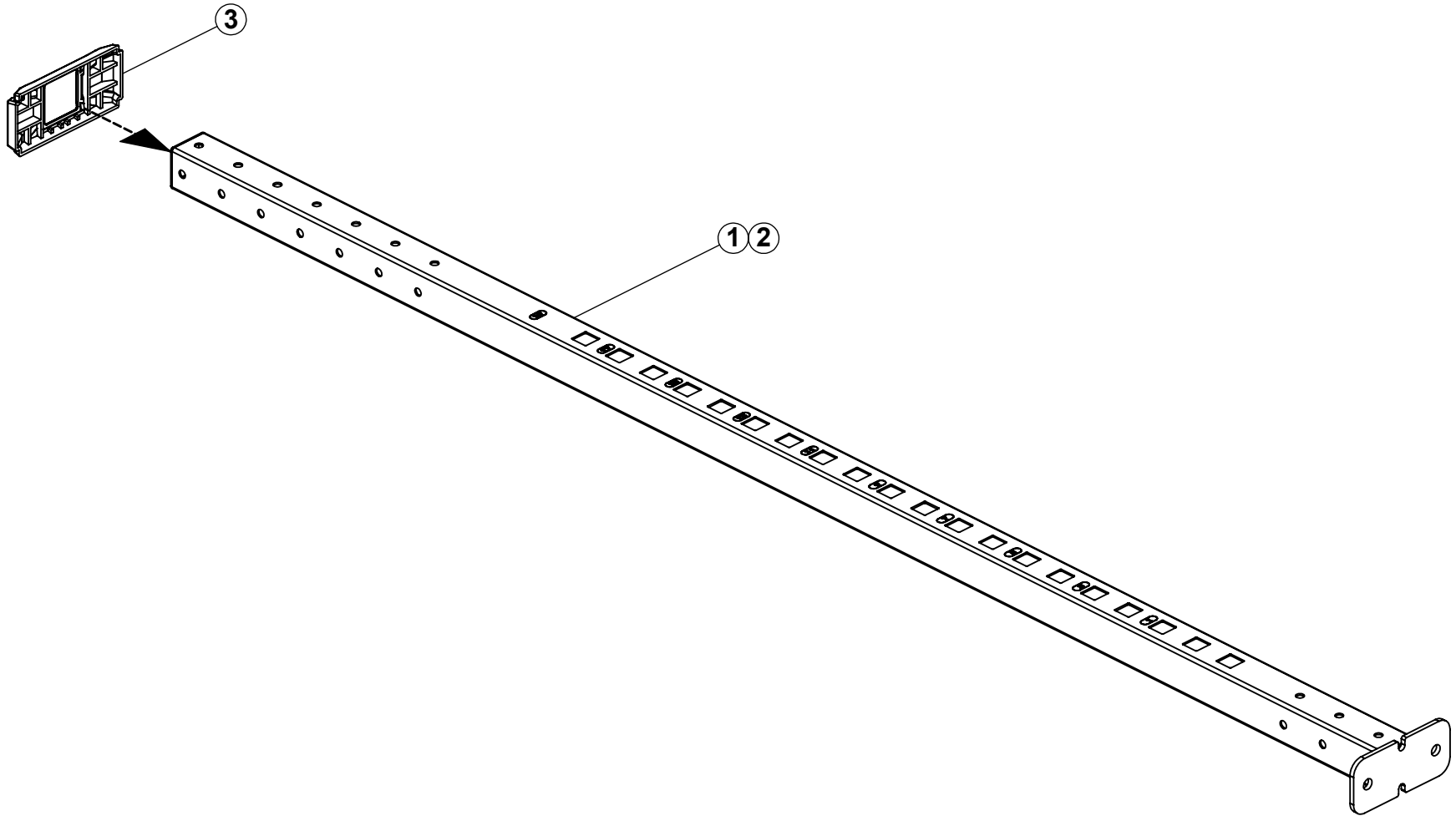
ITEM	PART NUMBER	DESCRIPTION	QTY
1	55077PA	PTD ASSY, 9' UPRIGHT	4
2	55899PA	PTD ASSY, 8' UPRIGHT	4
3	5479401	BOOT, X-RACK	4
4	5474901	WLDMT, 4' RECTANGLE CROSS	2
5	5589701	WLDMT, 4' LOWER RECTANGLE CROSS	2
6	5582701	WLDMT, LBPA RIGHT	2
7	5582201	WLDMT, LBPA LEFT	2
8	55891PA	PTD ASSY, 9' UPRIGHT VERTICAL WEIGHT STORAGE	2
9	55901PA	PTD ASSY, 8' UPRIGHT VERTICAL WEIGHT STORAGE	2
10	2007801	WASHER, 1/2 X 1-3/4 X 4.5†	80
11	2005817	BOLT, 1/2-13 X 4-1/2" (114mm) SOCKET HEAD	32
12	2001401	NUT, 1/2-13 LK ST ZN	40
13	5565901	PLATE, UPRIGHT GUSSET	4
14	5481301	WLDMT, 4' MULTI-GRIP CROSS	2
15	2005816	BOLT, 1/2-13 X 4-1/4" (108mm) SOCKET HEAD	8
16	5589401	WLDMT, 4' LOWER CROSS CONNECTOR	1
17	54737PA	PTD ASSY, LEFT BAR SUPPORT	2
18	54742PA	PTD ASSY, RIGHT BAR SUPPORT	2
19	54745PA	PTD ASSY, LEFT BAR CATCH	2
20	54748PA	PTD ASSY, RIGHT BAR CATCH	2

*Used with 8' option only.

*Used with 8' option only.

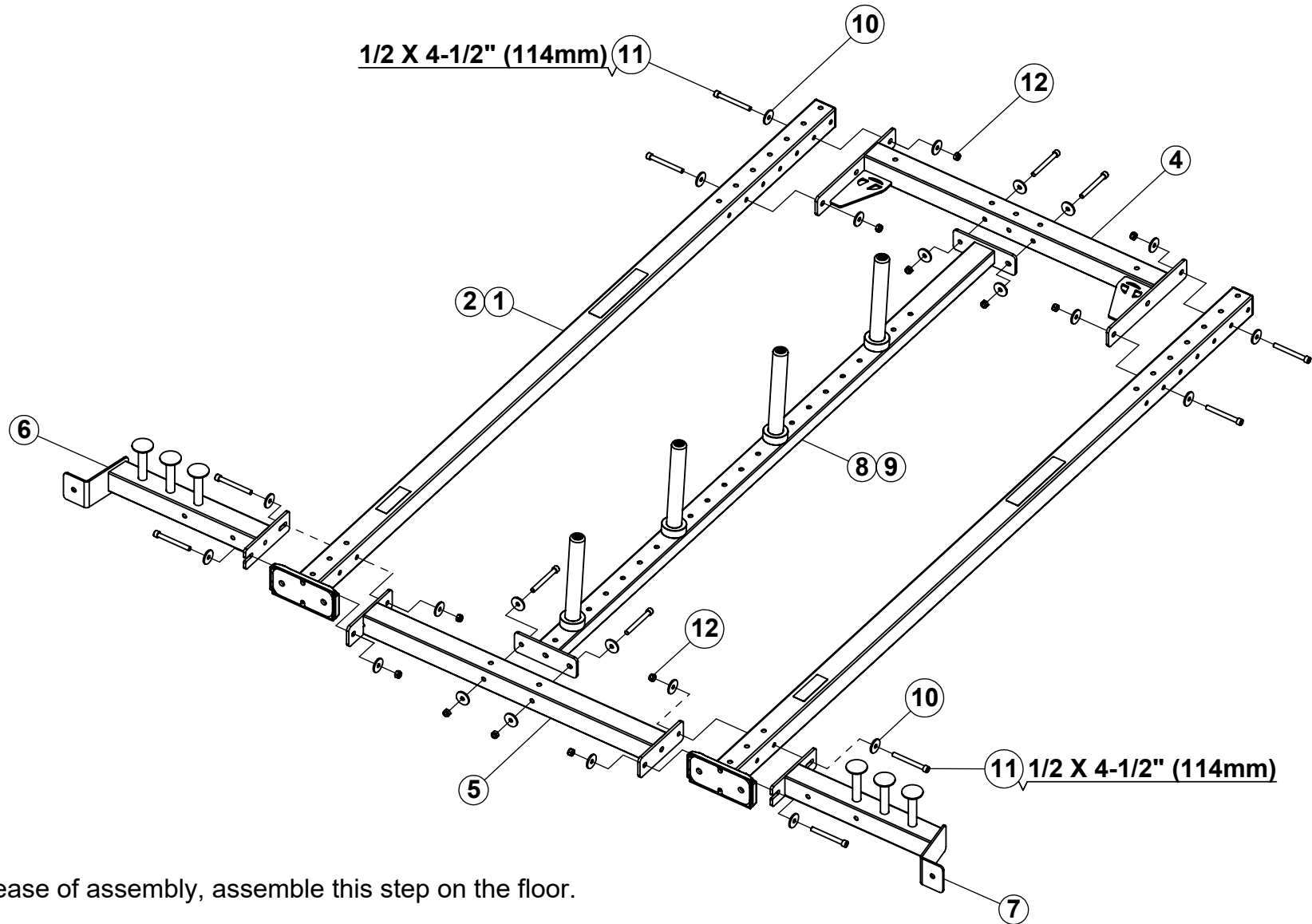


STEP 1



NOTE: Repeat this step for all four uprights.

STEP 2

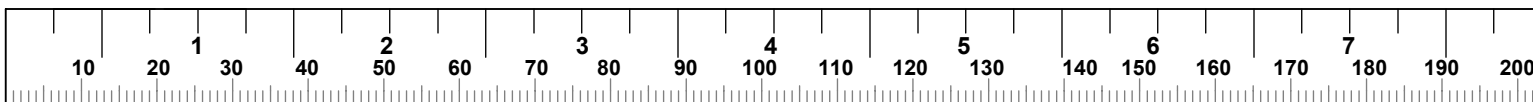


NOTE: For ease of assembly, assemble this step on the floor.

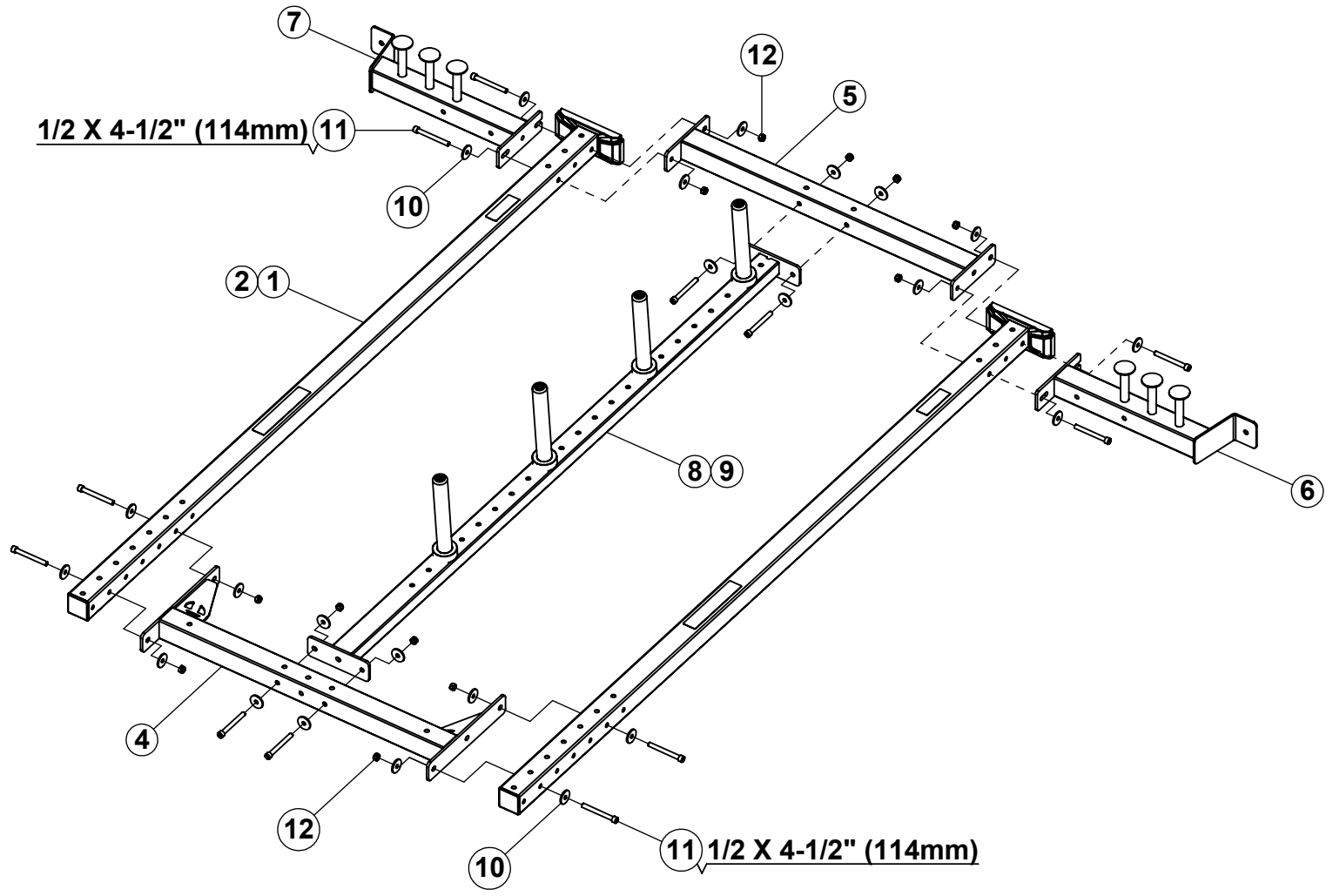
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (12) 1/2 X 4-1/2" BOLTS
- (24) 1/2" FENDER WASHERS
- (12) 1/2" LOCK NUTS



STEP 3

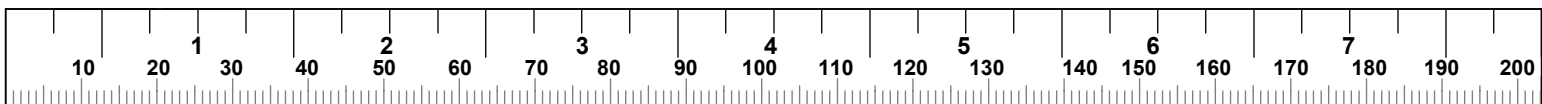


NOTE: For ease of assembly, assemble this step on the floor.

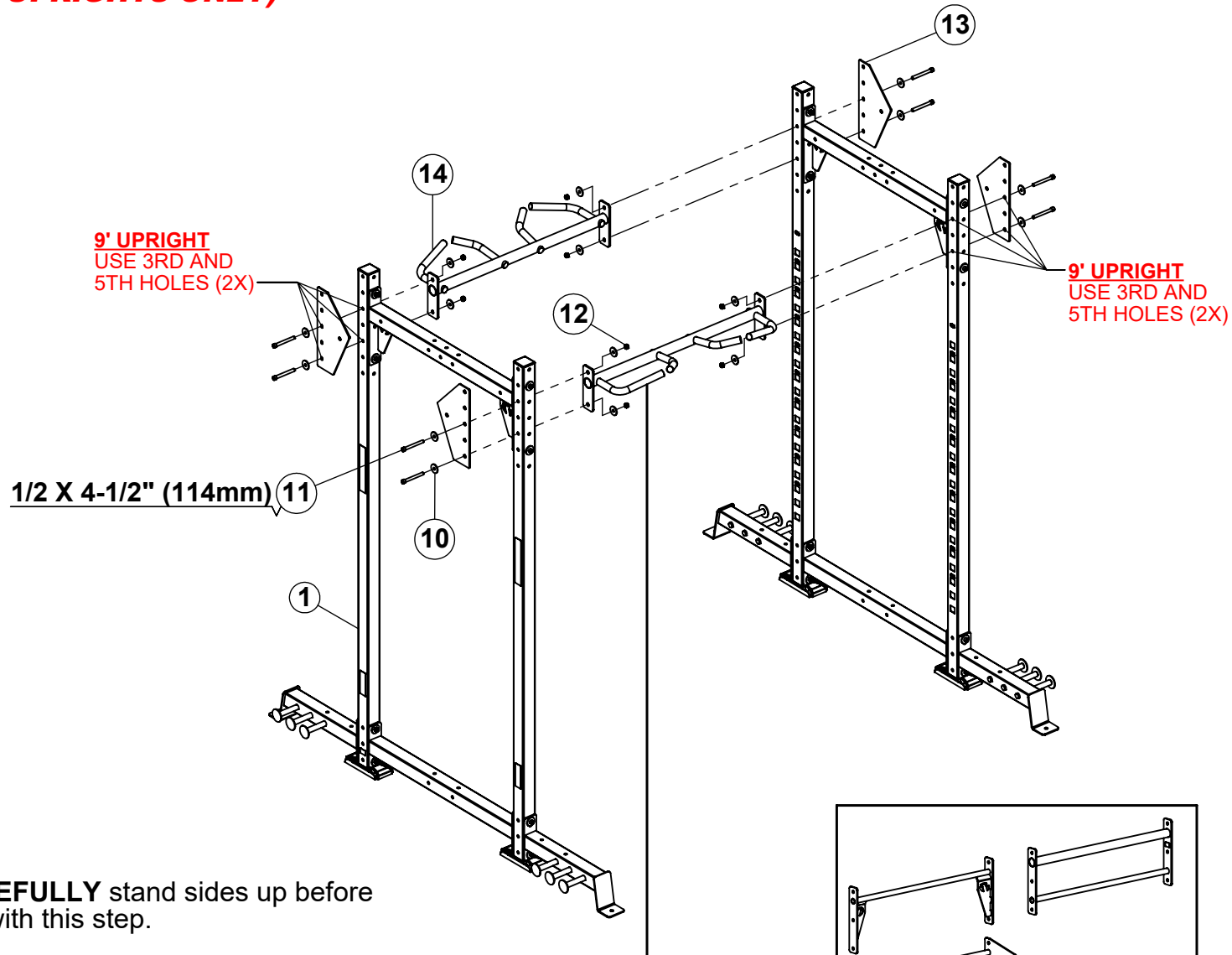
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (12) 1/2 X 4-1/2" BOLTS
- (24) 1/2" FENDER WASHERS
- (12) 1/2" LOCK NUTS



STEP 4 (9' UPRIGHTS ONLY)



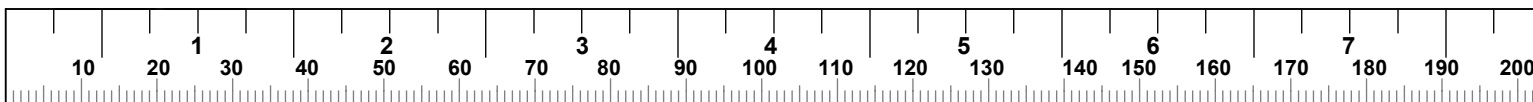
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

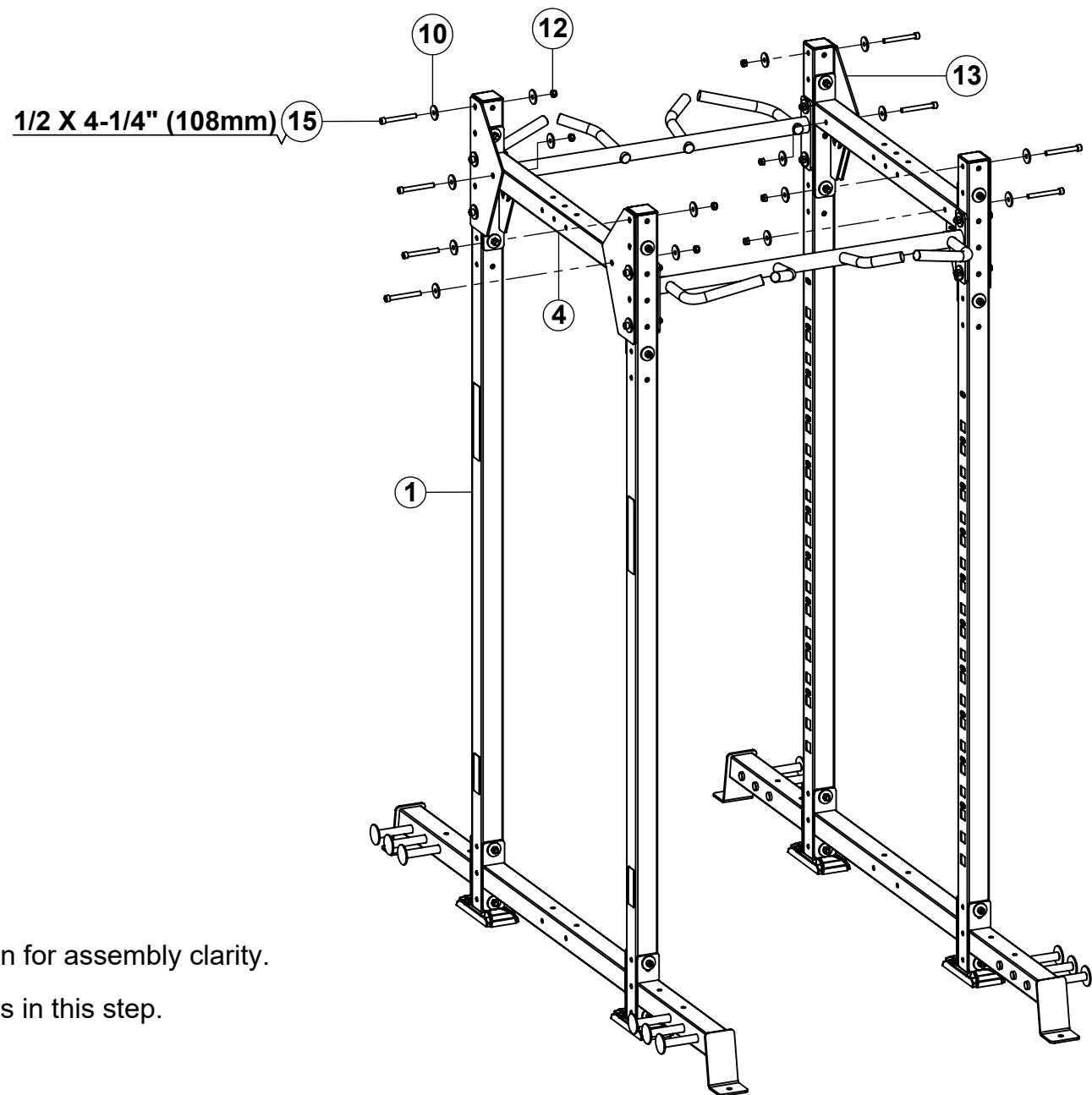
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/2" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 5 (9' UPRIGHTS ONLY)

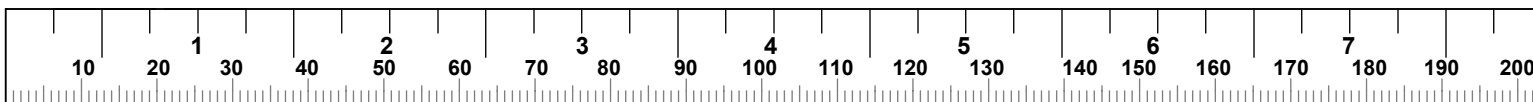


NOTE: Some items have been hidden for assembly clarity.

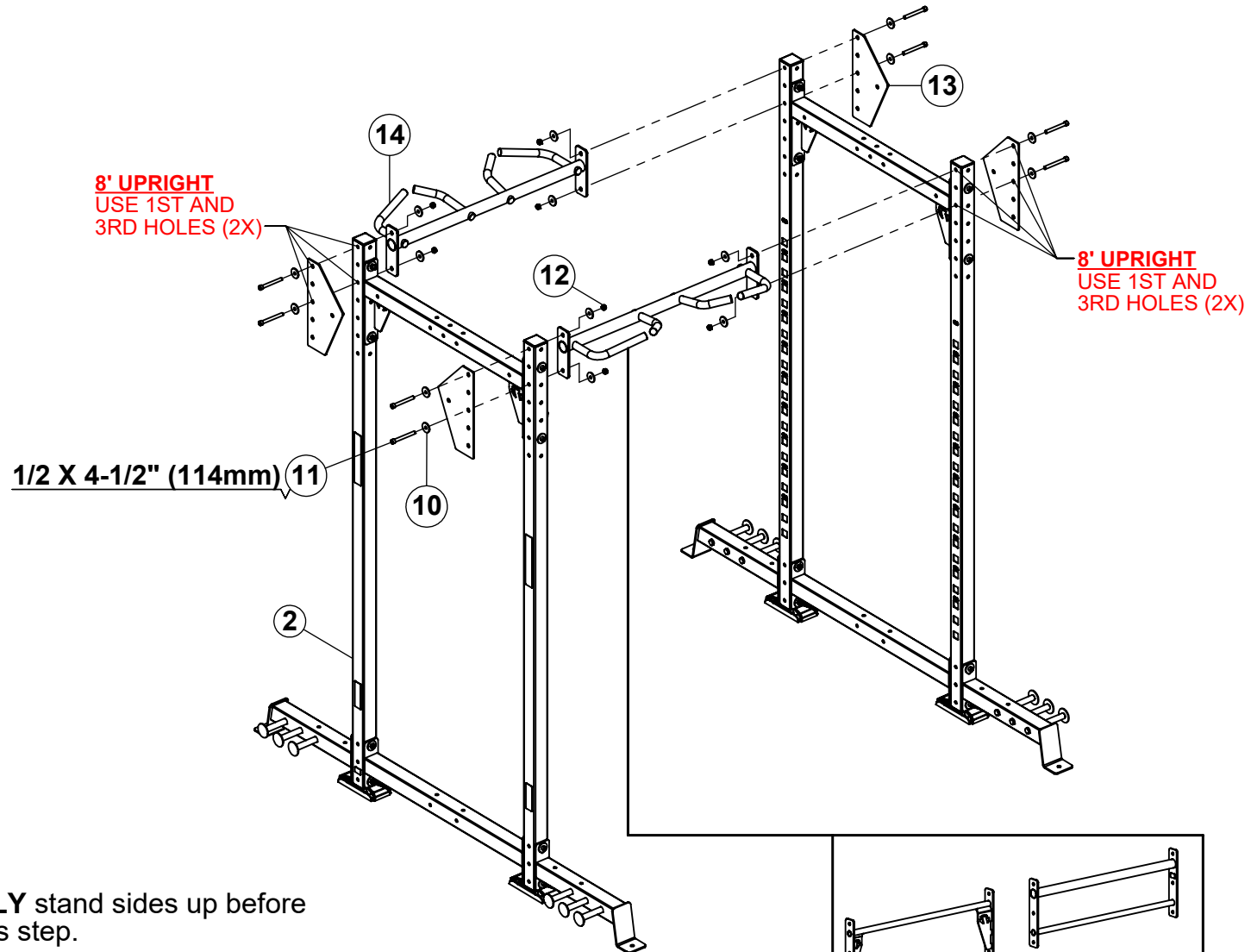
LOOSELY assemble bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 6 (8' UPRIGHTS ONLY)



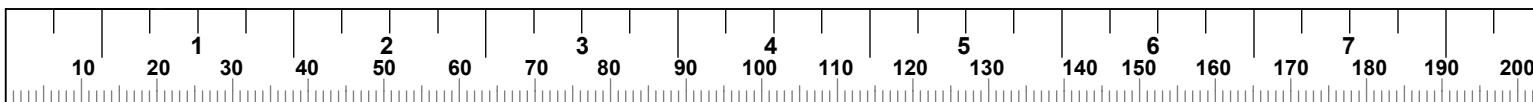
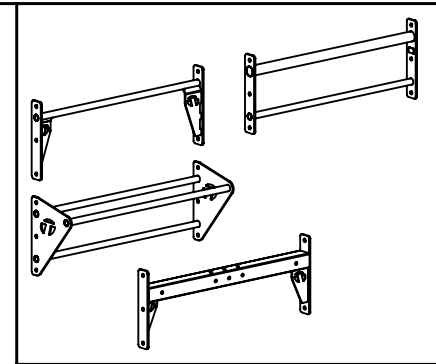
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

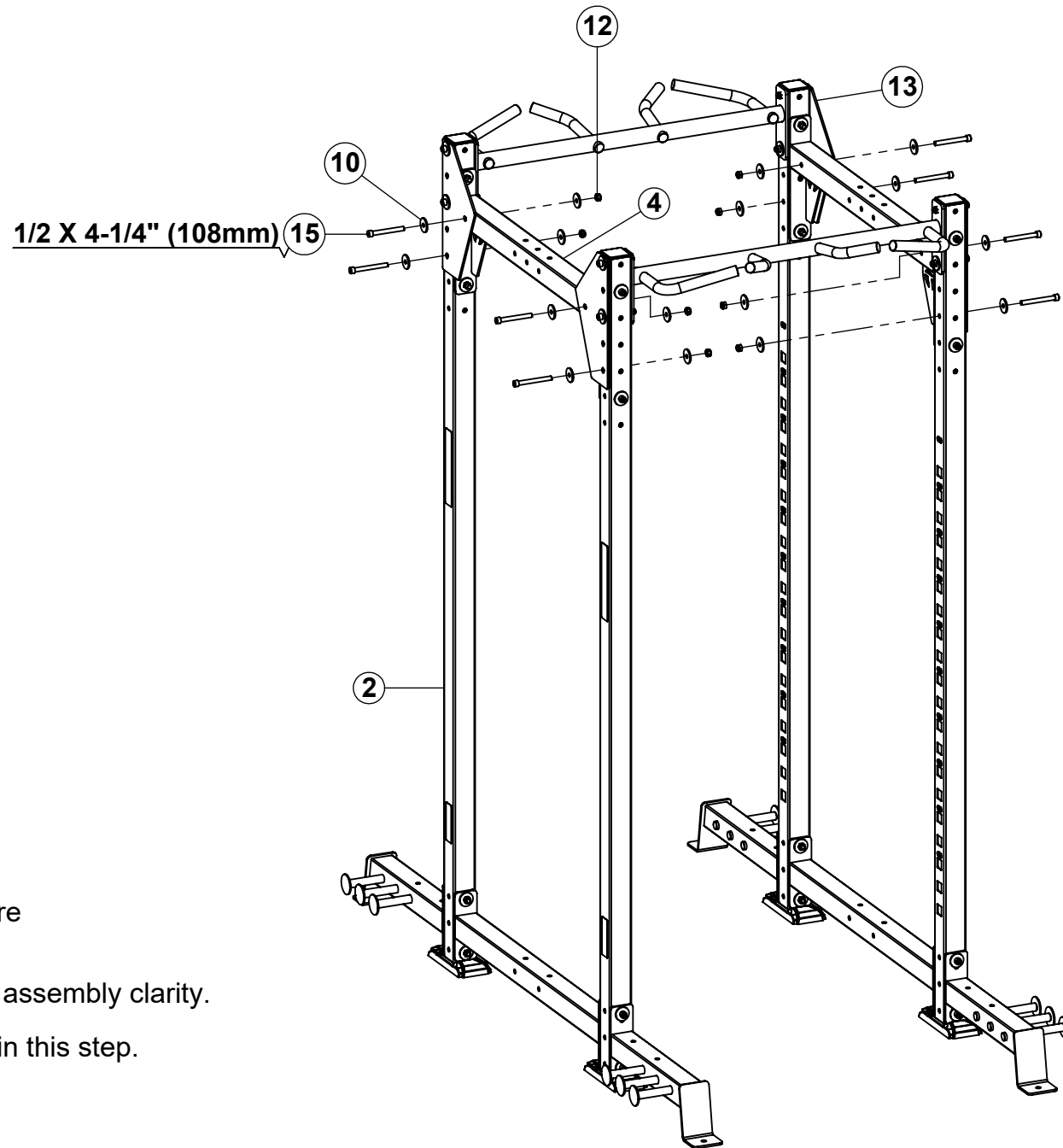
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/2" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 7 (8' UPRIGHTS ONLY)



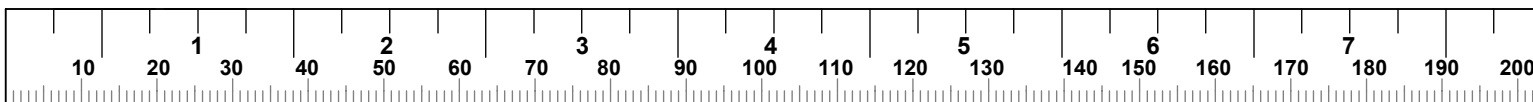
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

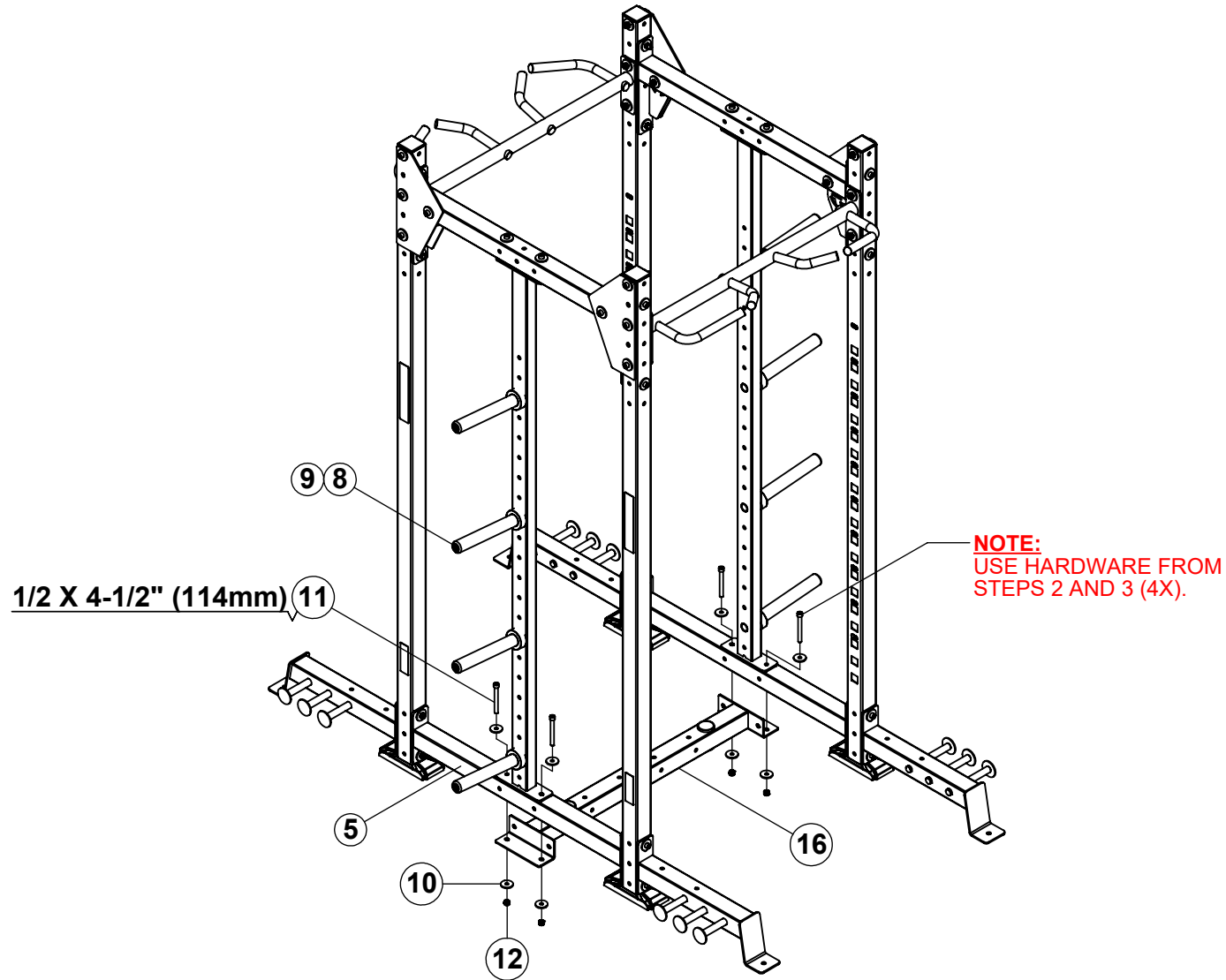
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 8

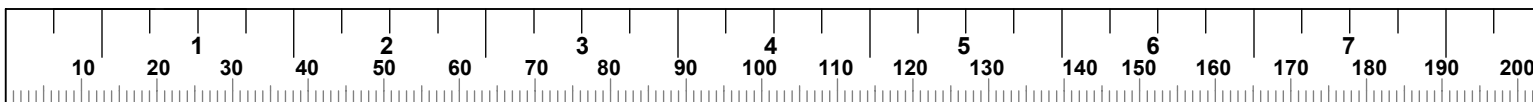


NOTE:

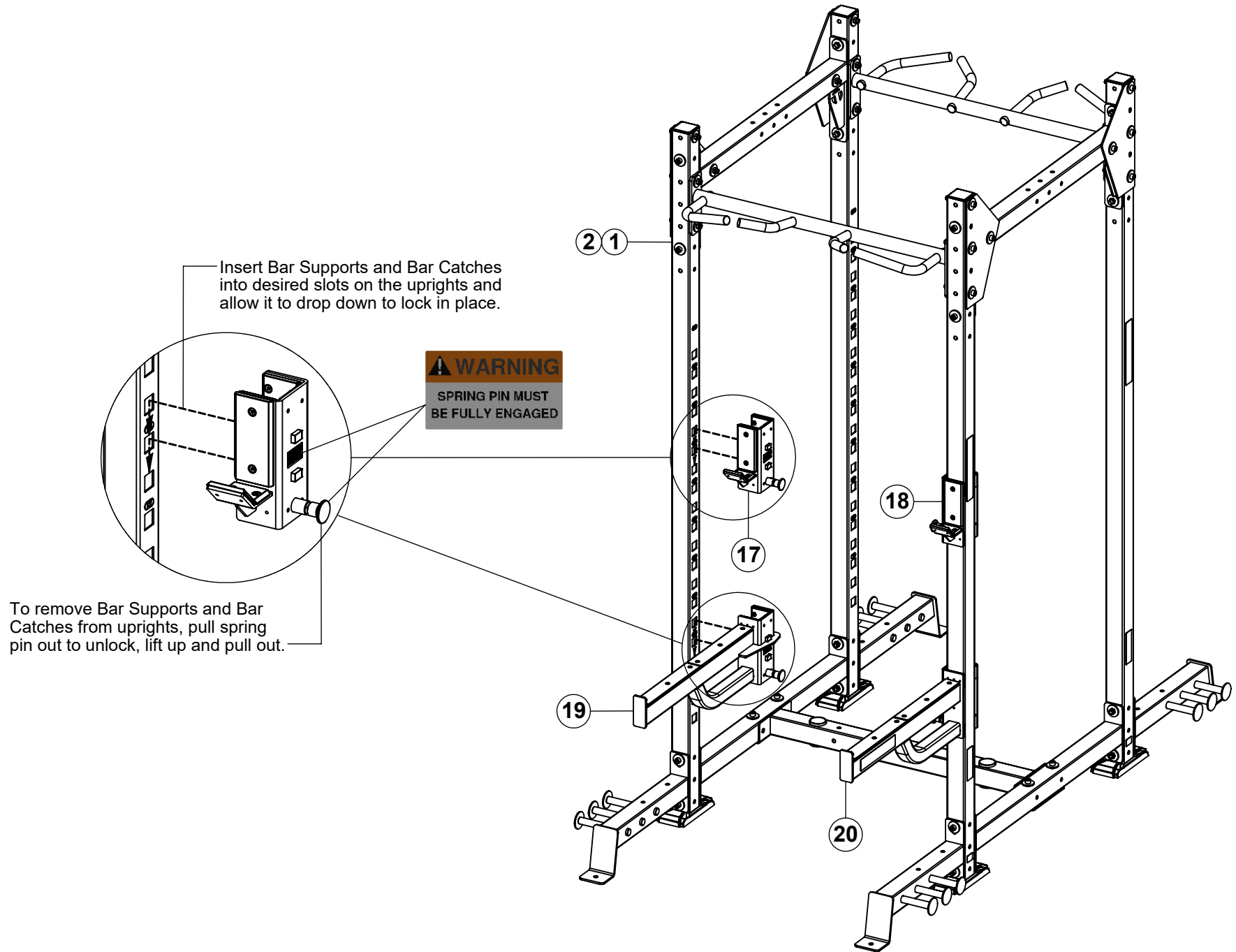
After this step has been completed, **SECURELY** tighten all bolt connections from previous steps.

Hardware from previous step:

- (4) 1/2 X 4-1/2" BOLTS
- (8) 1/2" FENDER WASHERS
- (4) 1/2" LOCK NUTS



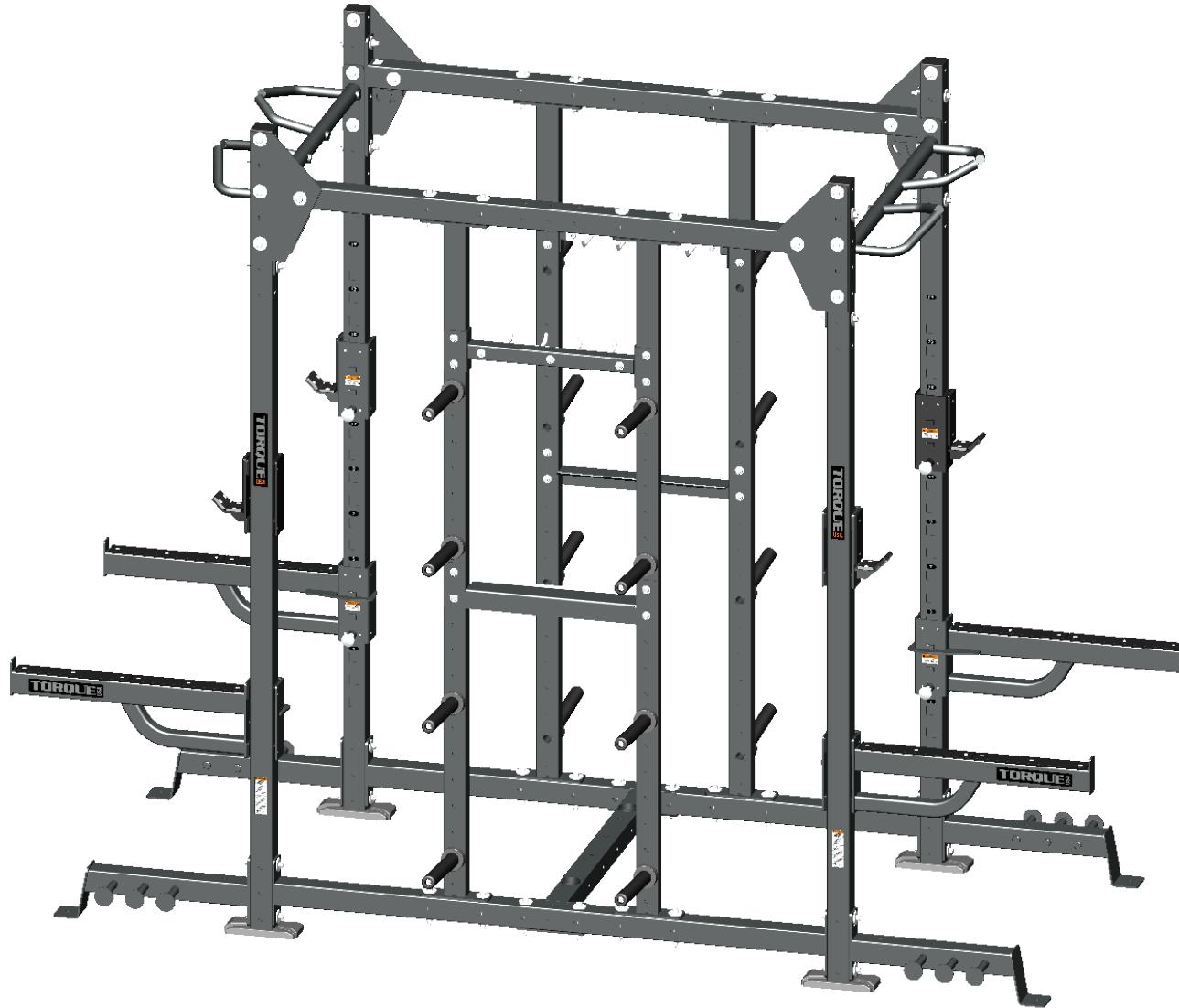
STEP 9



NOTE:
Some parts have been hidden for assembly clarity.

ASSEMBLY INSTRUCTIONS

6 X 4 STORAGE RACK

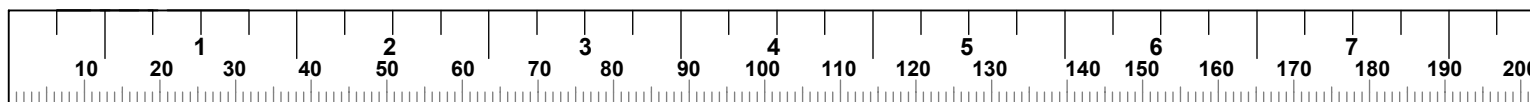


TORQUE USA

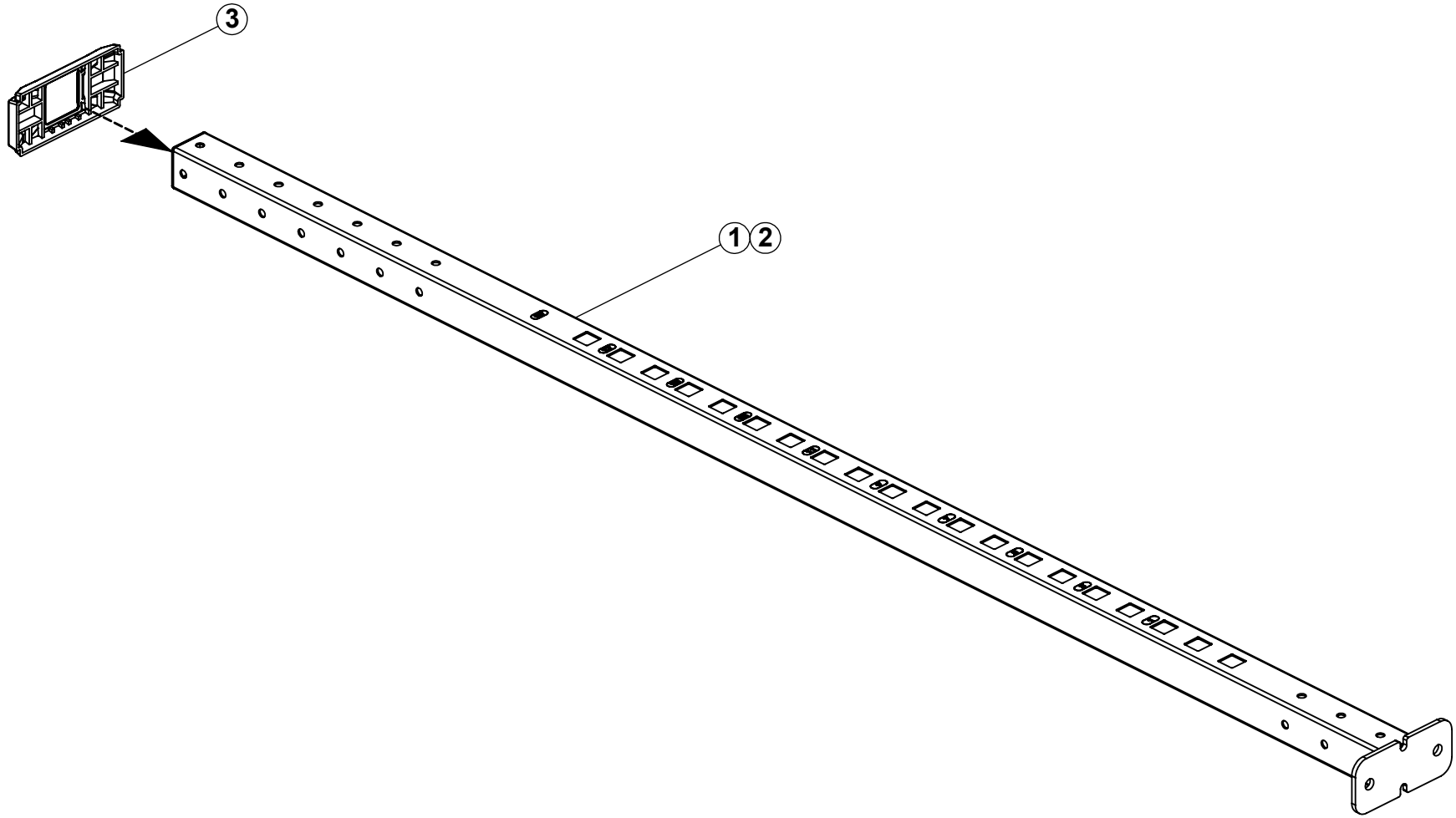
ITEM	PART NUMBER	DESCRIPTION	QTY
1	55077PA	PTD ASSY, 9' UPRIGHT	4
2	55899PA	PTD ASSY, 8' UPRIGHT	4
3	5479401	BOOT, X-RACK	4
4	5475201	WLDMT, 6' RECTANGULAR CROSS	2
5	5588801	WLDMT, 6' LOWER RECTANGLE CROSS	2
6	5582701	WLDMT, LBPA RIGHT	2
7	5582201	WLDMT, LBPA LEFT	2
8	55891PA	PTD ASSY, 9' UPRIGHT VERTICAL WEIGHT STORAGE	4
9	55901PA	PTD ASSY, 8' UPRIGHT VERTICAL WEIGHT STORAGE	4
10	2007801	WASHER, 1/2 X 1-3/4 X 4.5†	104
11	2005817	BOLT, 1/2-13 X 4-1/2" (114mm) SOCKET HEAD	44
12	2001401	NUT, 1/2-13 LK ST ZN	68
13	5565901	PLATE, UPRIGHT GUSSET	4
14	5481301	WLDMT, 4' MULTI-GRIP CROSS	2
15	2005816	BOLT, 1/2-13 X 4-1/4" (108mm) SOCKET HEAD	8
16	5589401	WLDMT, 4' LOWER CROSS CONNECTOR	1
17	5573201	BRKT, BAR CATCH STORAGE	2
18	2001301	WASHER, FLAT 1/2 SAE ST ZN	32
19	2005811	BOLT, 1/2-13 X 3" (76mm) SOCKET HEAD	16
20	55654PA	PTD ASSY, ACCESSORY HOLDER	2
21	54737PA	PTD ASSY, LEFT BAR SUPPORT	2
22	54742PA	PTD ASSY, RIGHT BAR SUPPORT	2
23	54745PA	PTD ASSY, LEFT BAR CATCH	2
24	54748PA	PTD ASSY, RIGHT BAR CATCH	2

*Used with 8' option only.

*Used with 8' option only.

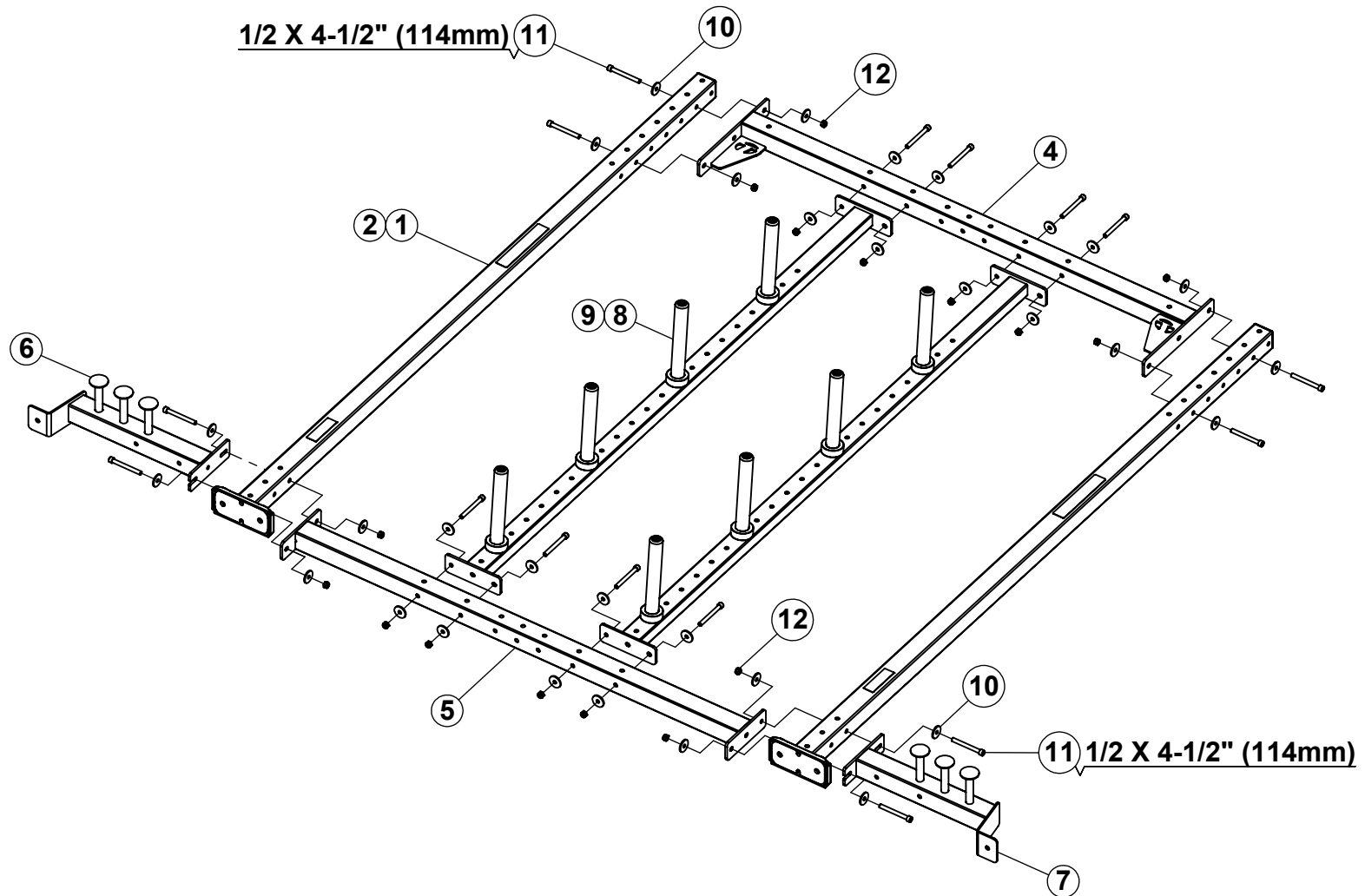


STEP 1



NOTE: Repeat this step for all four uprights.

STEP 2

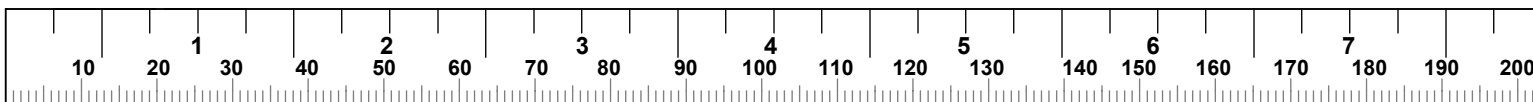


NOTE: For ease of assembly, assemble this step on the floor.

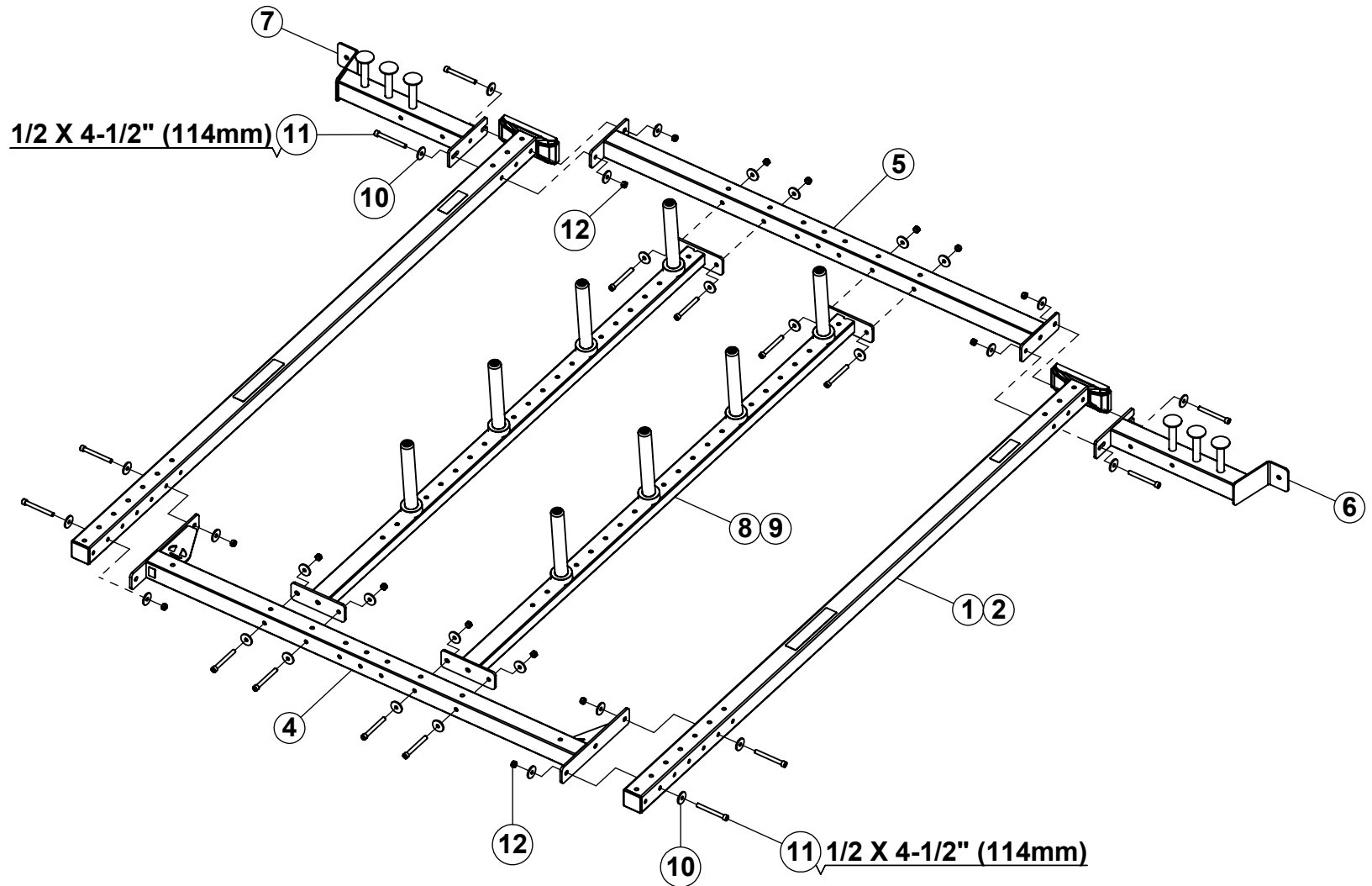
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (16) 1/2 X 4-1/2" BOLTS
- (32) 1/2" FENDER WASHERS
- (16) 1/2" LOCK NUTS



STEP 3

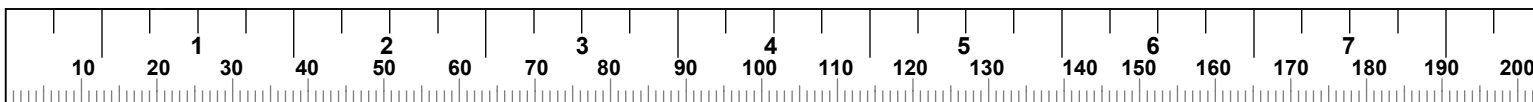


NOTE: For ease of assembly, assemble this step on the floor.

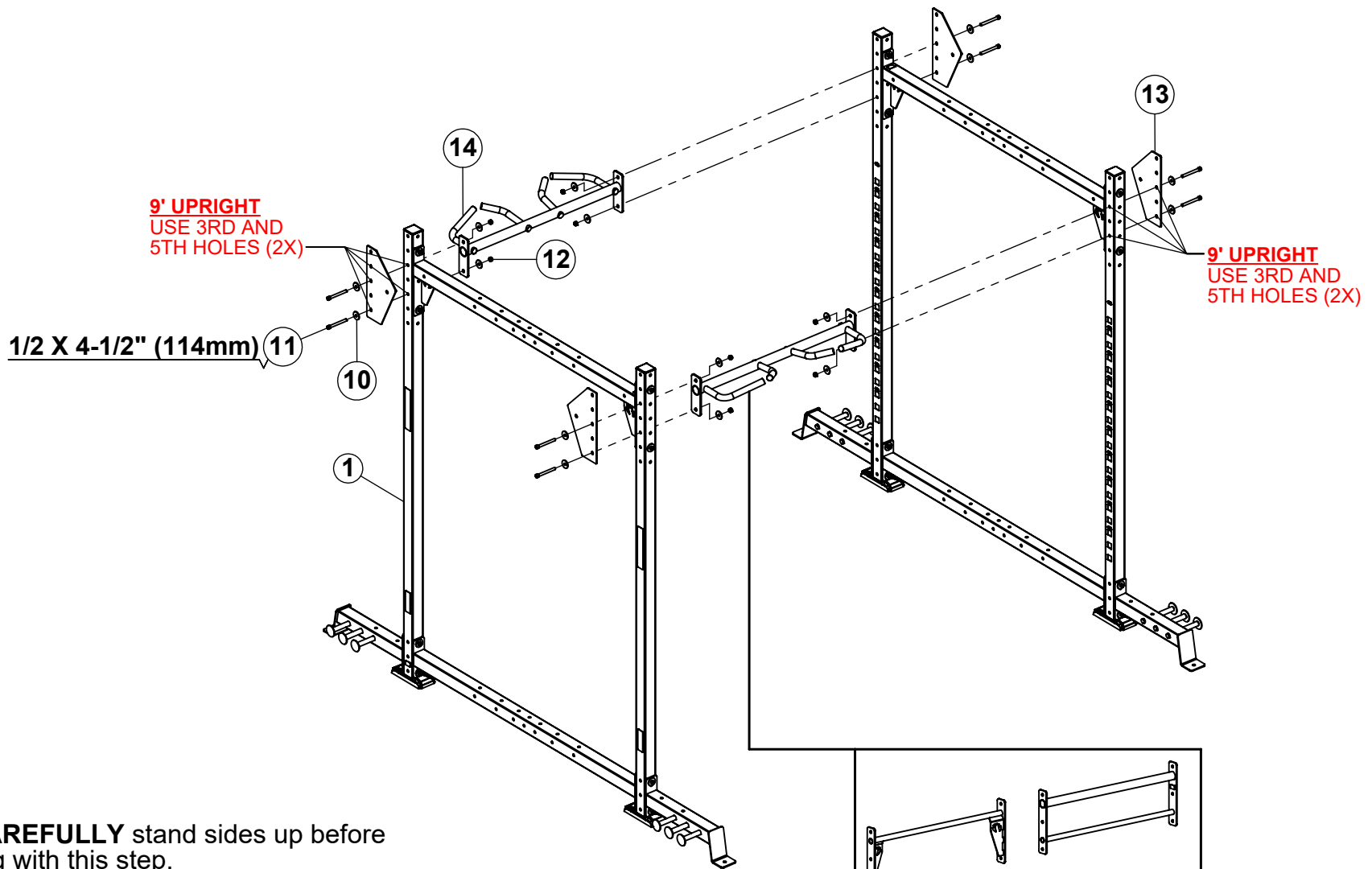
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (16) 1/2 X 4-1/2" BOLTS
- (32) 1/2" FENDER WASHERS
- (16) 1/2" LOCK NUTS



STEP 4 (9' UPRIGHTS ONLY)



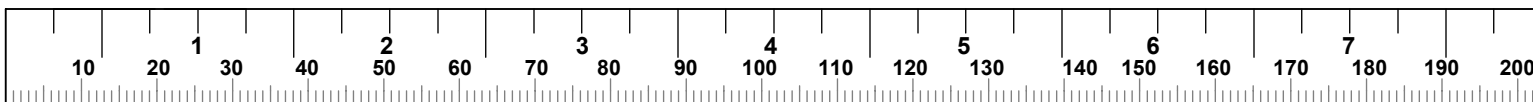
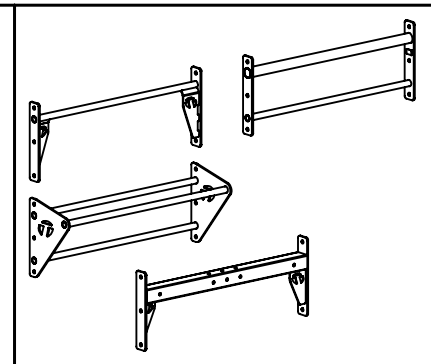
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

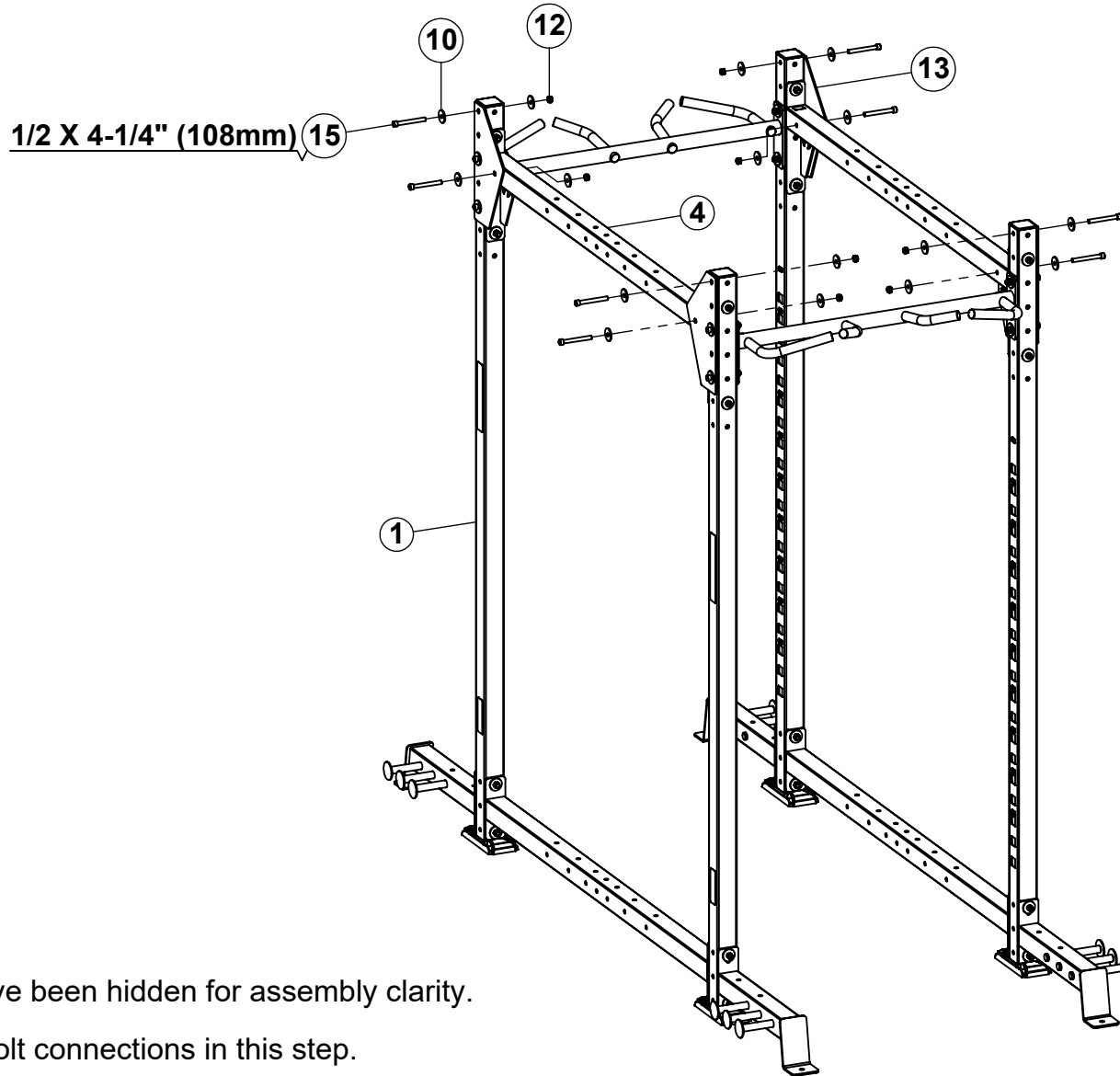
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/2" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 5 (9' UPRIGHTS ONLY)

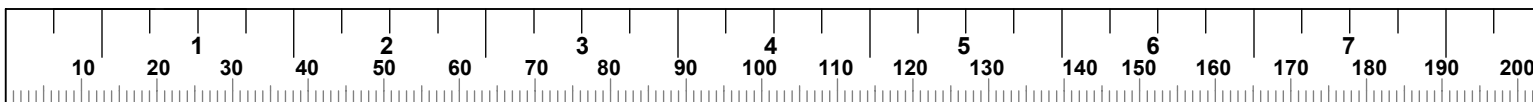


NOTE: Some items have been hidden for assembly clarity.

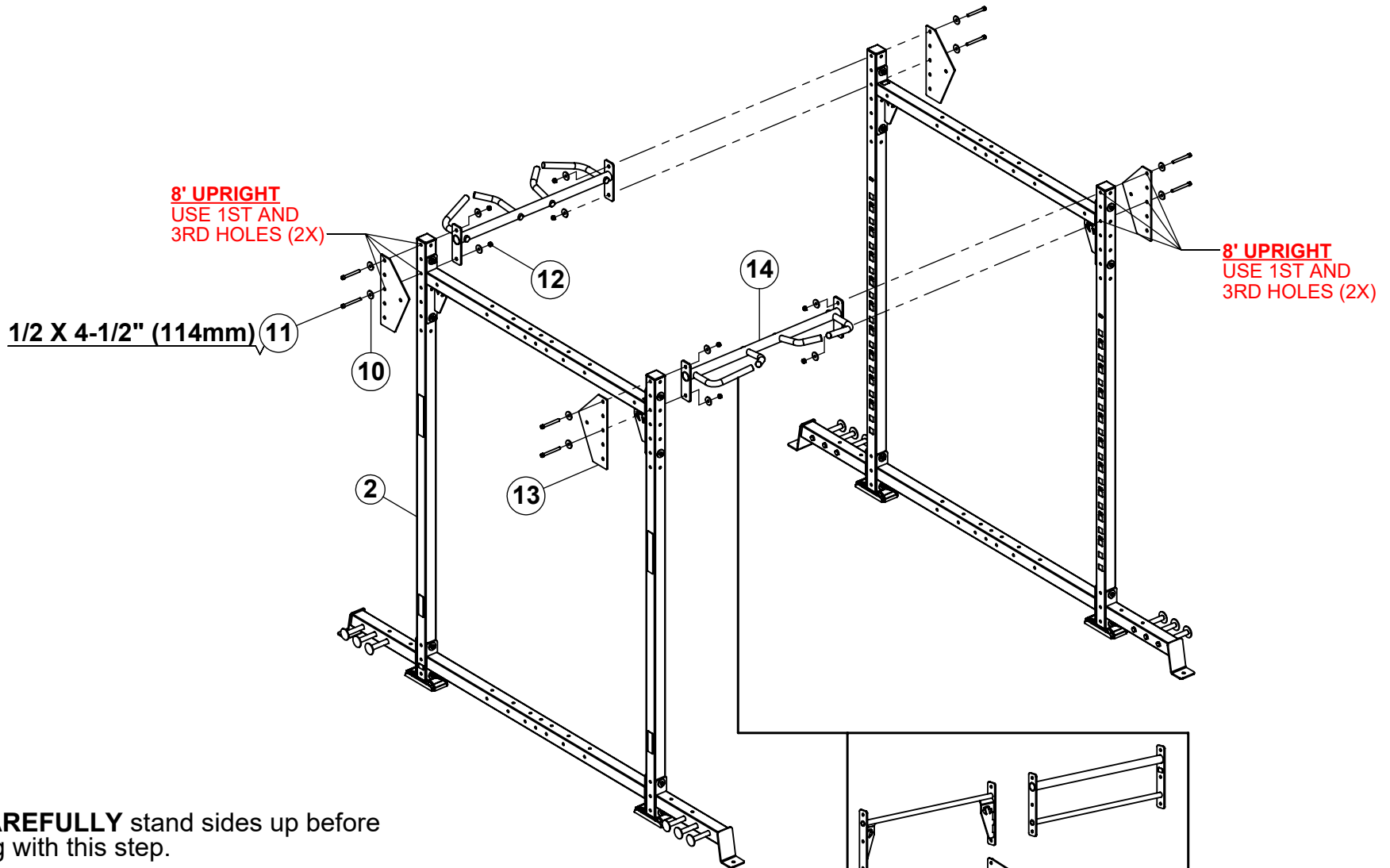
LOOSELY assemble bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 6 (8' UPRIGHTS ONLY)



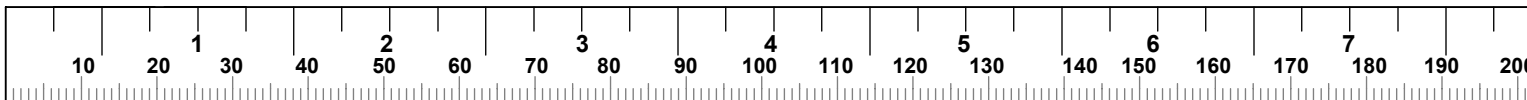
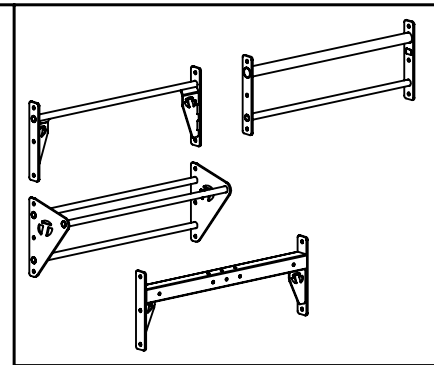
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

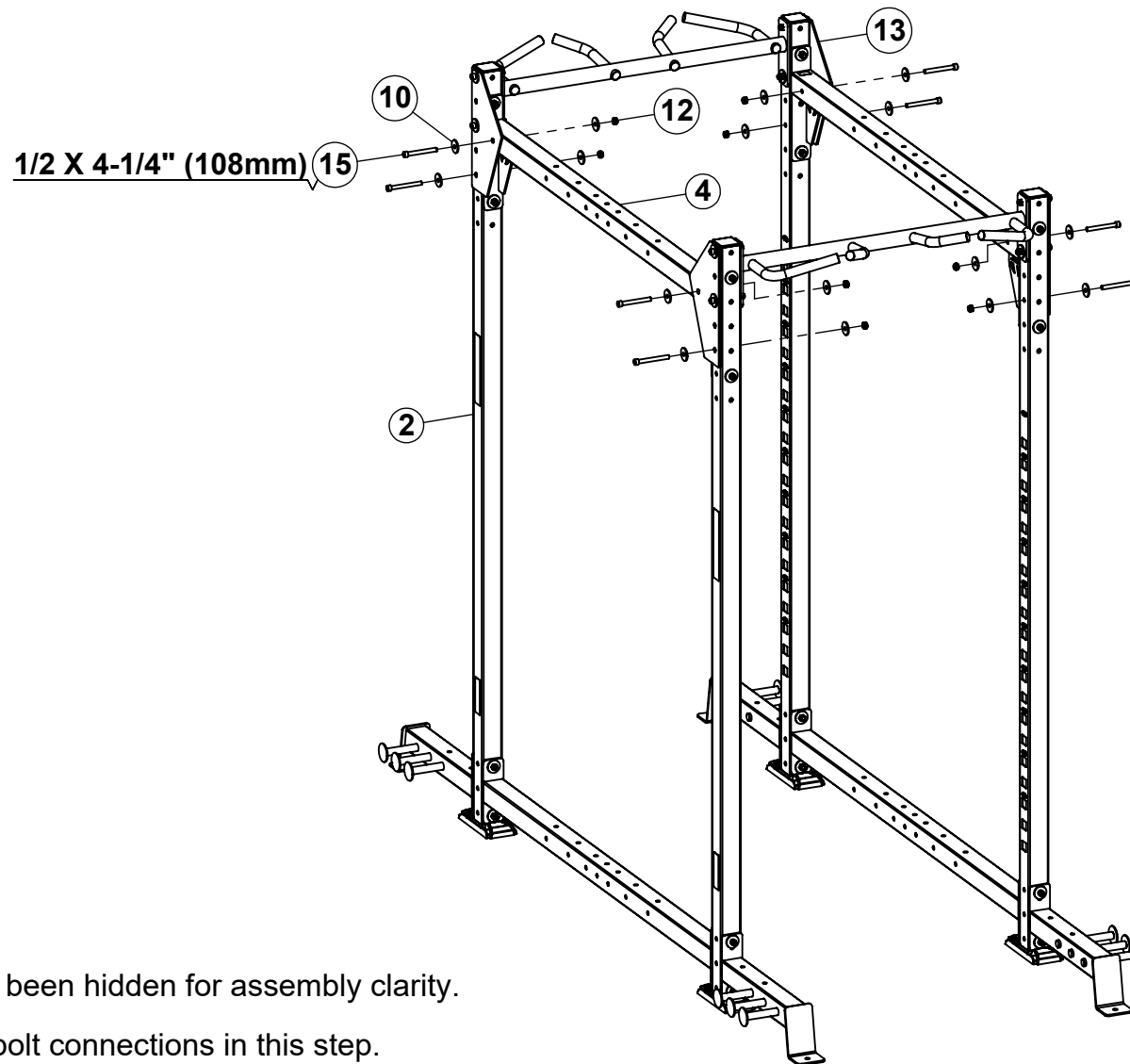
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/2" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 7 (8' UPRIGHTS ONLY)

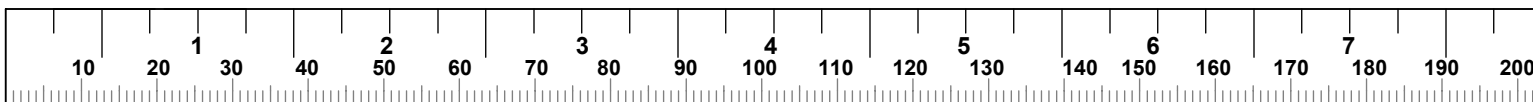


NOTE: Some items have been hidden for assembly clarity.

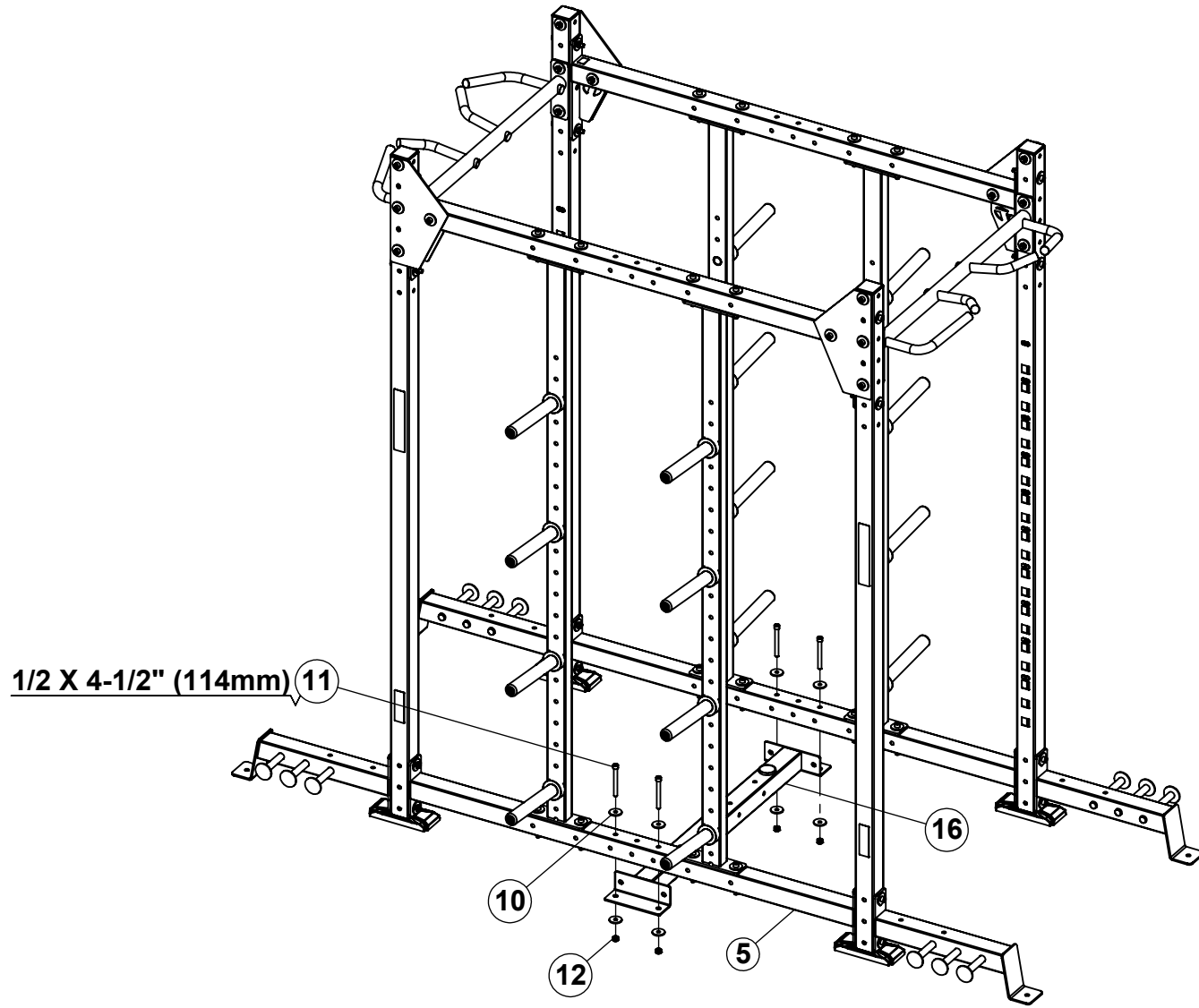
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



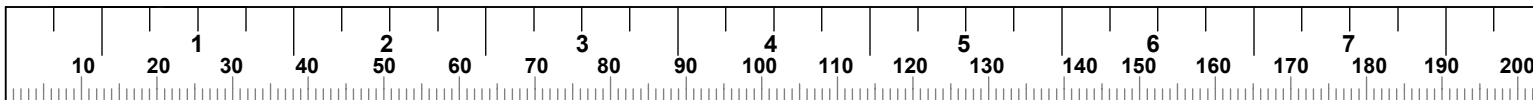
STEP 8



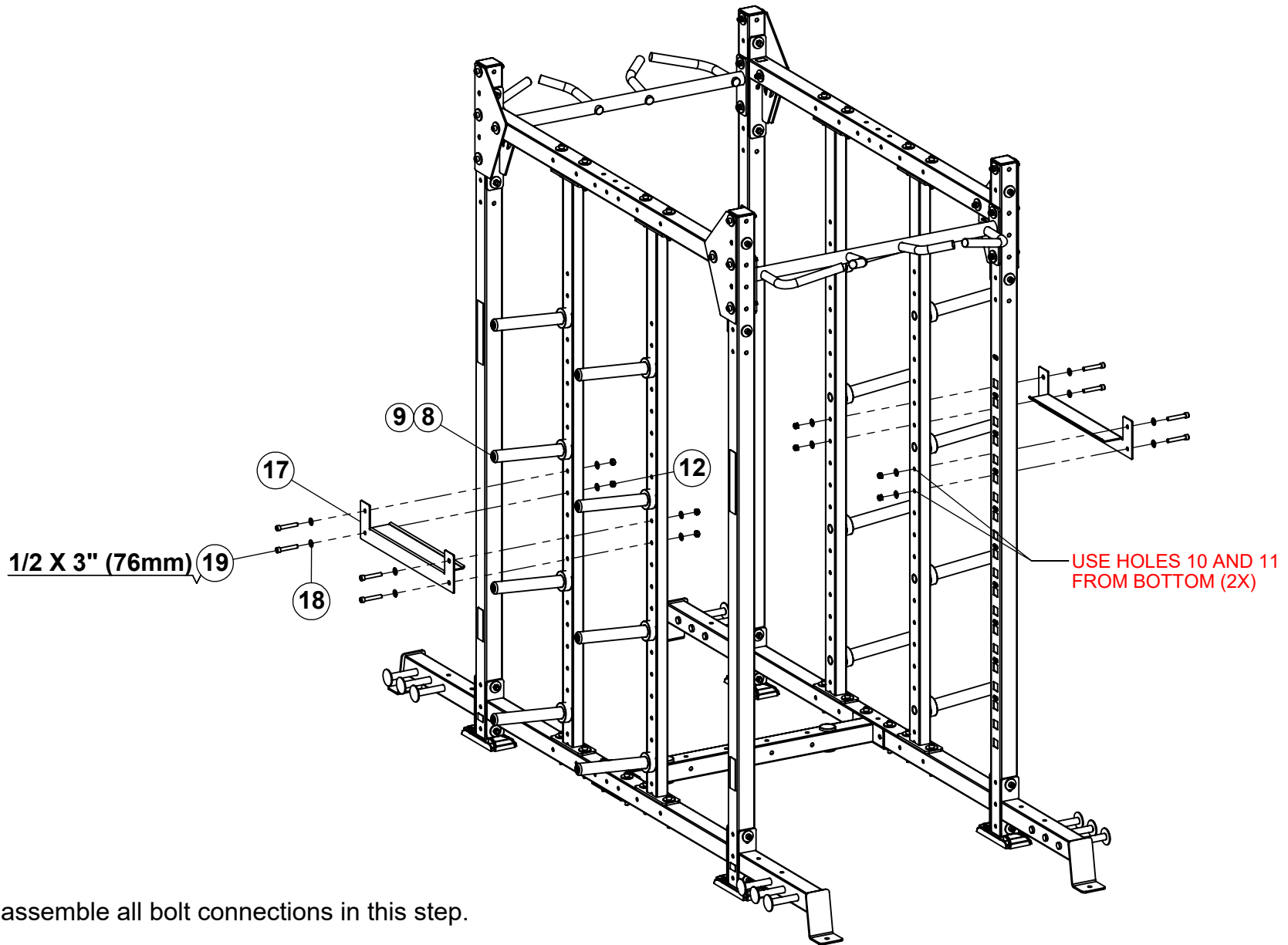
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (4) 1/2 X 4-1/2" BOLTS
- (8) 1/2" FENDER WASHERS
- (4) 1/2" LOCK NUTS



STEP 9

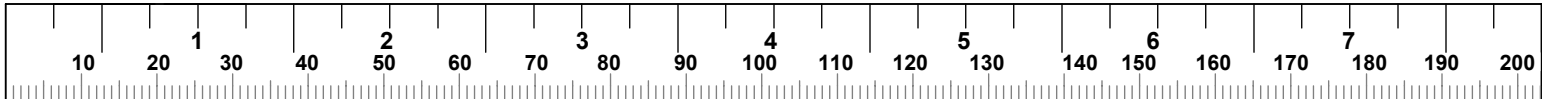


1/2 X 3" (76mm) 19

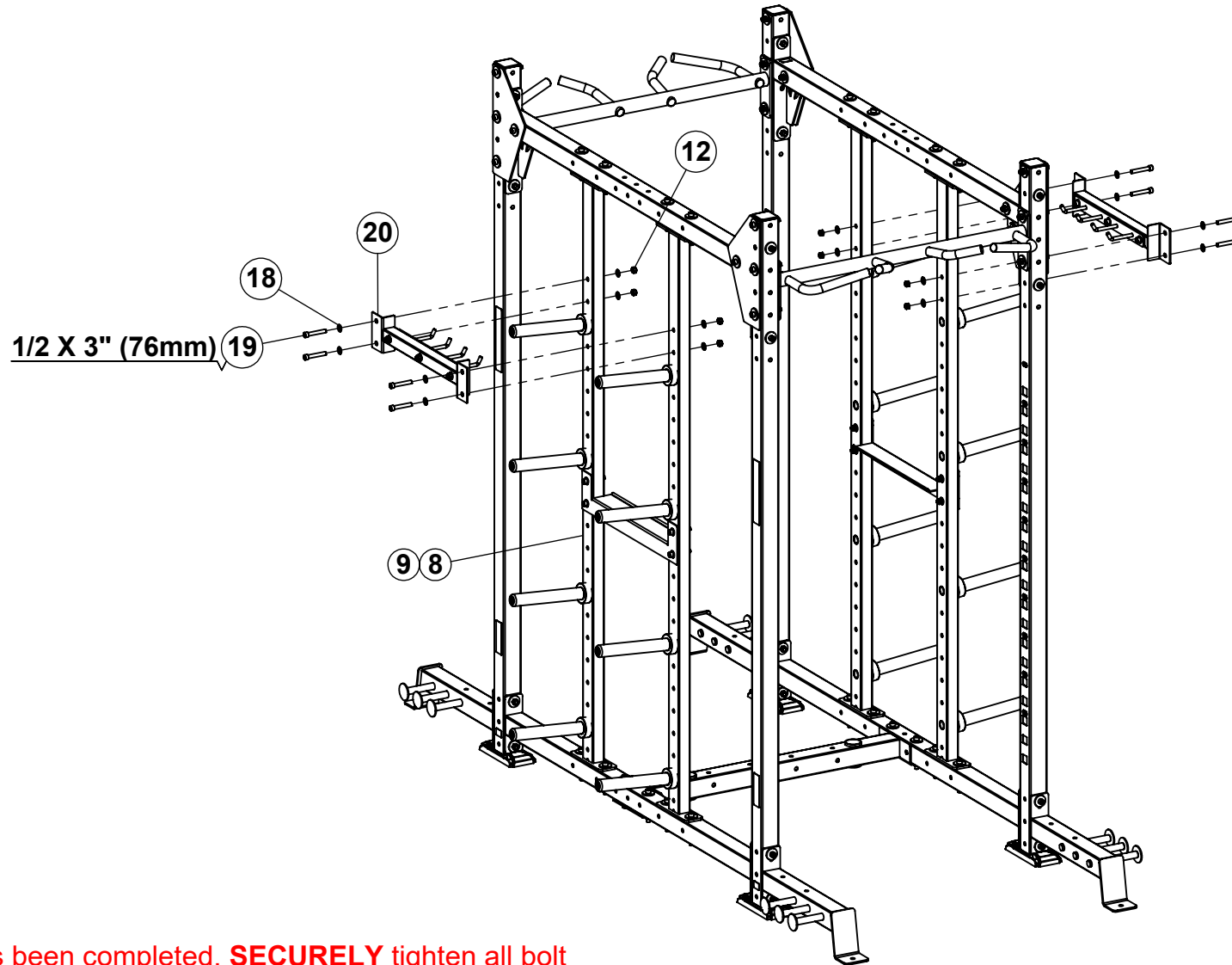
USE HOLES 10 AND 11 FROM BOTTOM (2X)

LOOSELY assemble all bolt connections in this step.

- Hardware for this step:**
(8) 1/2 X 3" BOLTS
(16) 1/2" FLAT WASHERS
(8) 1/2" LOCK NUTS

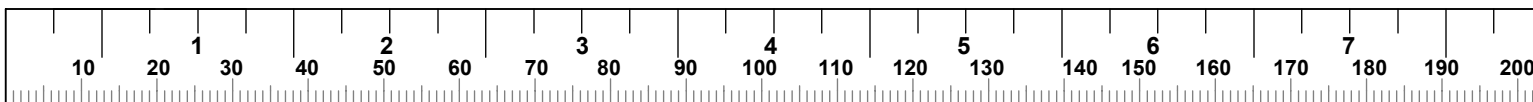


STEP 10

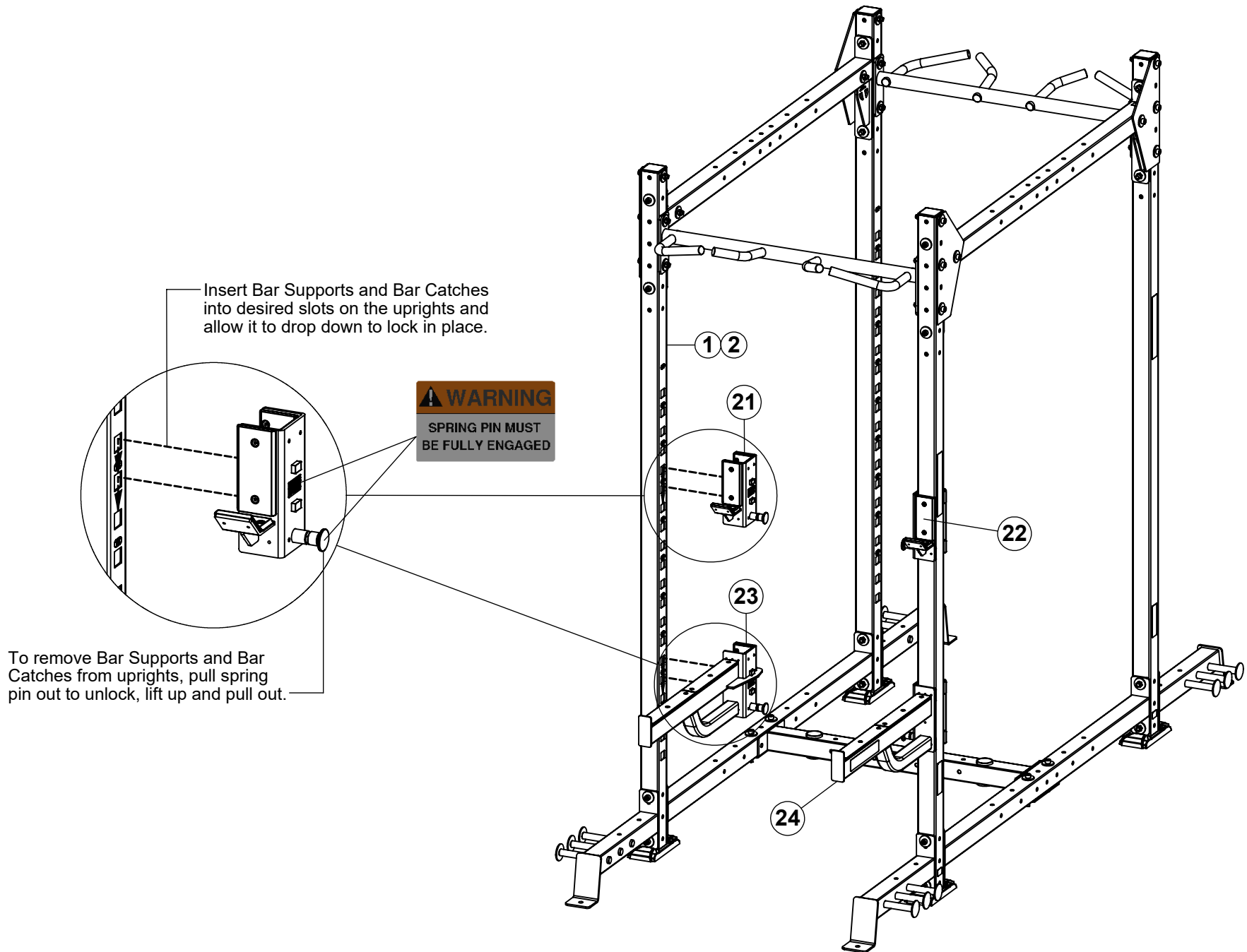


NOTE:
After this step has been completed, **SECURELY** tighten all bolt connections from previous steps.

- Hardware for this step:**
- (8) 1/2 X 3" BOLTS
 - (16) 1/2" FLAT WASHERS
 - (8) 1/2" LOCK NUTS



STEP 11



NOTE:
Some parts have been hidden for assembly clarity.

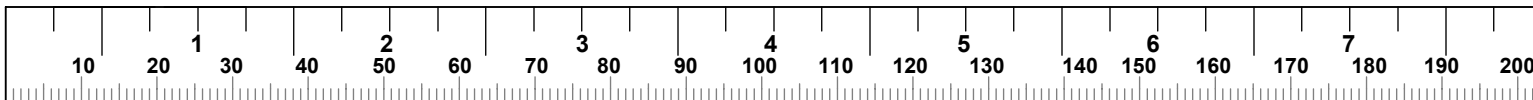
ASSEMBLY INSTRUCTIONS

4 X 4 STORAGE CABLE RACK

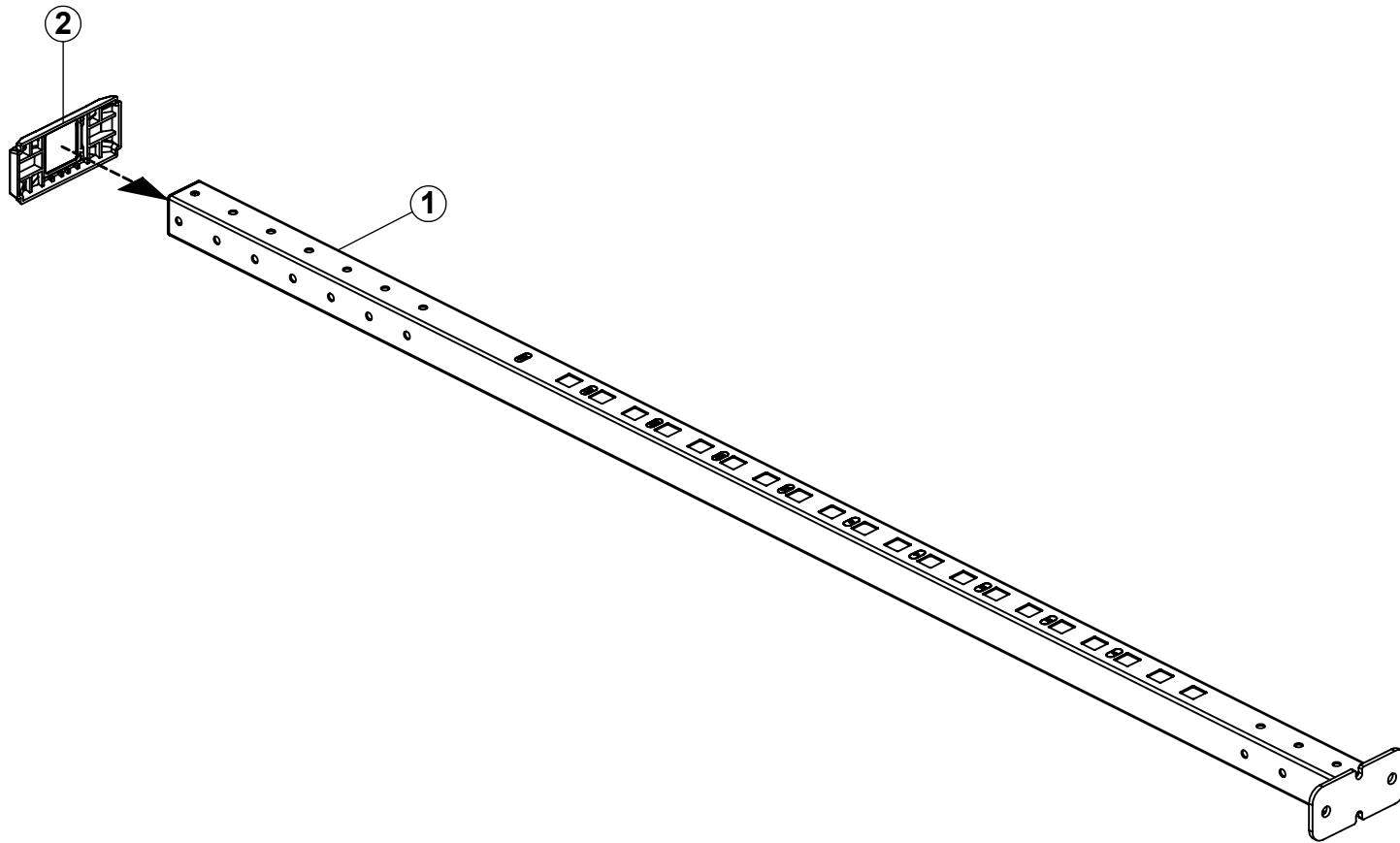


TORQUE USA

ITEM	PART NUMBER	DESCRIPTION	QTY
1	55077PA	PTD ASSY, 9' UPRIGHT	4
2	5479401	BOOT, X-RACK	4
3	5474901	WLDMT, 4' RECTANGLE CROSS	2
4	5589701	WLDMT, 4' LOWER RECTANGLE CROSS	2
5	5582201	WLDMT, LBPA LEFT	1
6	55891PA	PTD ASSY, 9' UPRIGHT VERTICAL WEIGHT STORAGE	2
7	2007801	WASHER, 1/2 X 1-3/4 X 4.5†	80
8	2005817	BOLT, 1/2-13 X 4-1/2" (114mm) SOCKET HEAD	32
9	2001401	NUT, 1/2-13 LK ST ZN	40
10	5582701	WLDMT, LBPA RIGHT	1
11	5565901	PLATE, UPRIGHT GUSSET	4
12	5481301	WLDMT, 4' MULTI-GRIP CROSS	1
13	5442801	WLDMT, 4' SINGLE CROSS	1
14	2005816	BOLT, 1/2-13 X 4-1/4" (108mm) SOCKET HEAD	8
15	5589401	WLDMT, 4' LOWER CROSS CONNECTOR	1
16	54737PA	PTD ASSY, LEFT BAR SUPPORT	1
17	54742PA	PTD ASSY, RIGHT BAR SUPPORT	1
18	54745PA	PTD ASSY, LEFT BAR CATCH	1
19	54748PA	PTD ASSY, RIGHT BAR CATCH	1

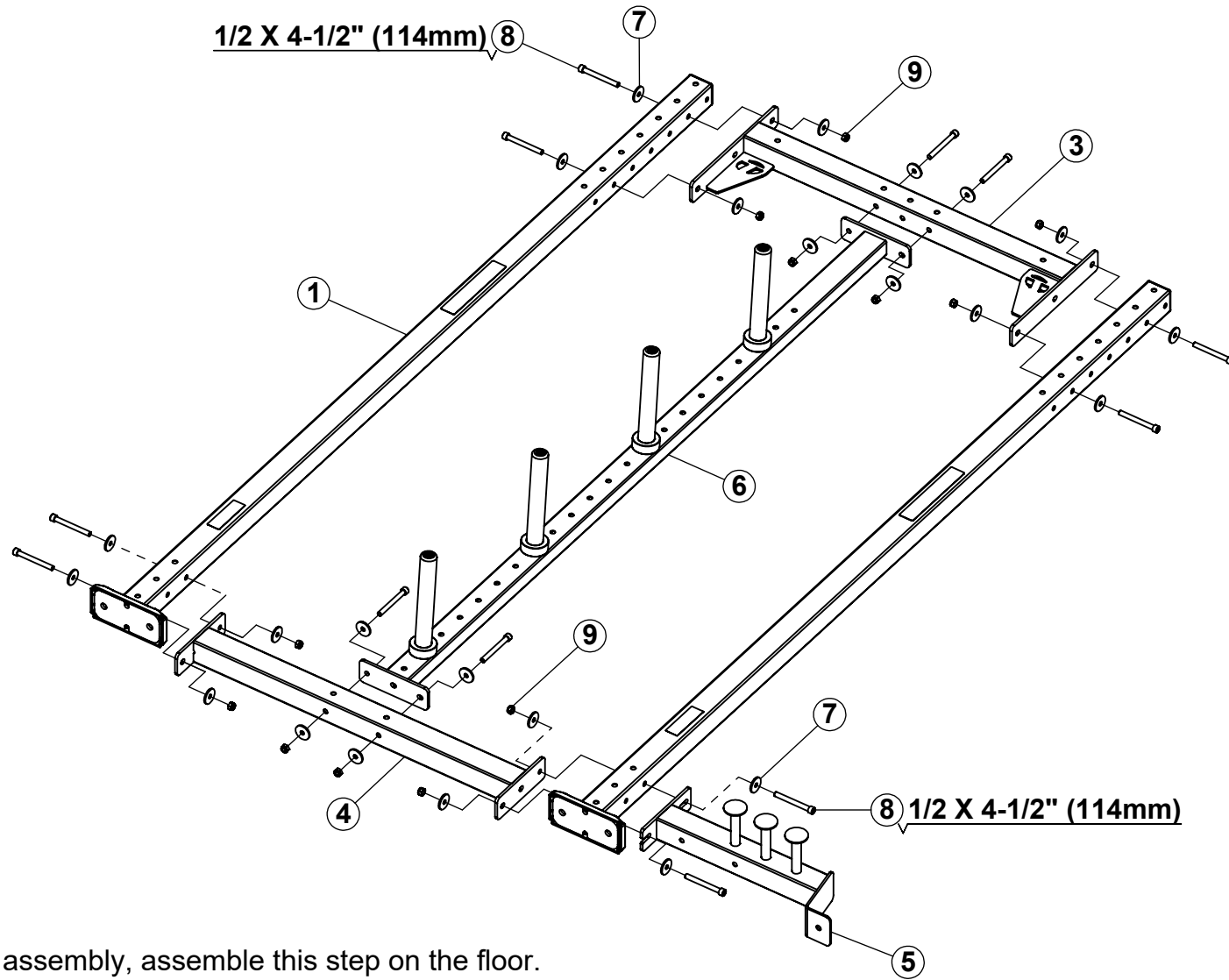


STEP 1



NOTE: Repeat this step for all four uprights.

STEP 2

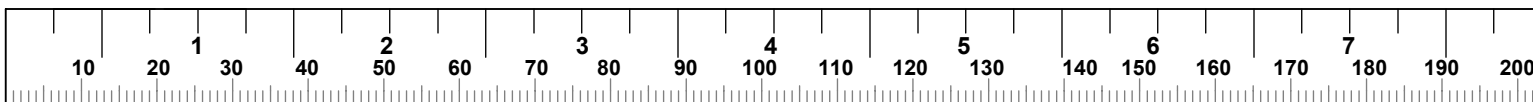


NOTE: For ease of assembly, assemble this step on the floor.

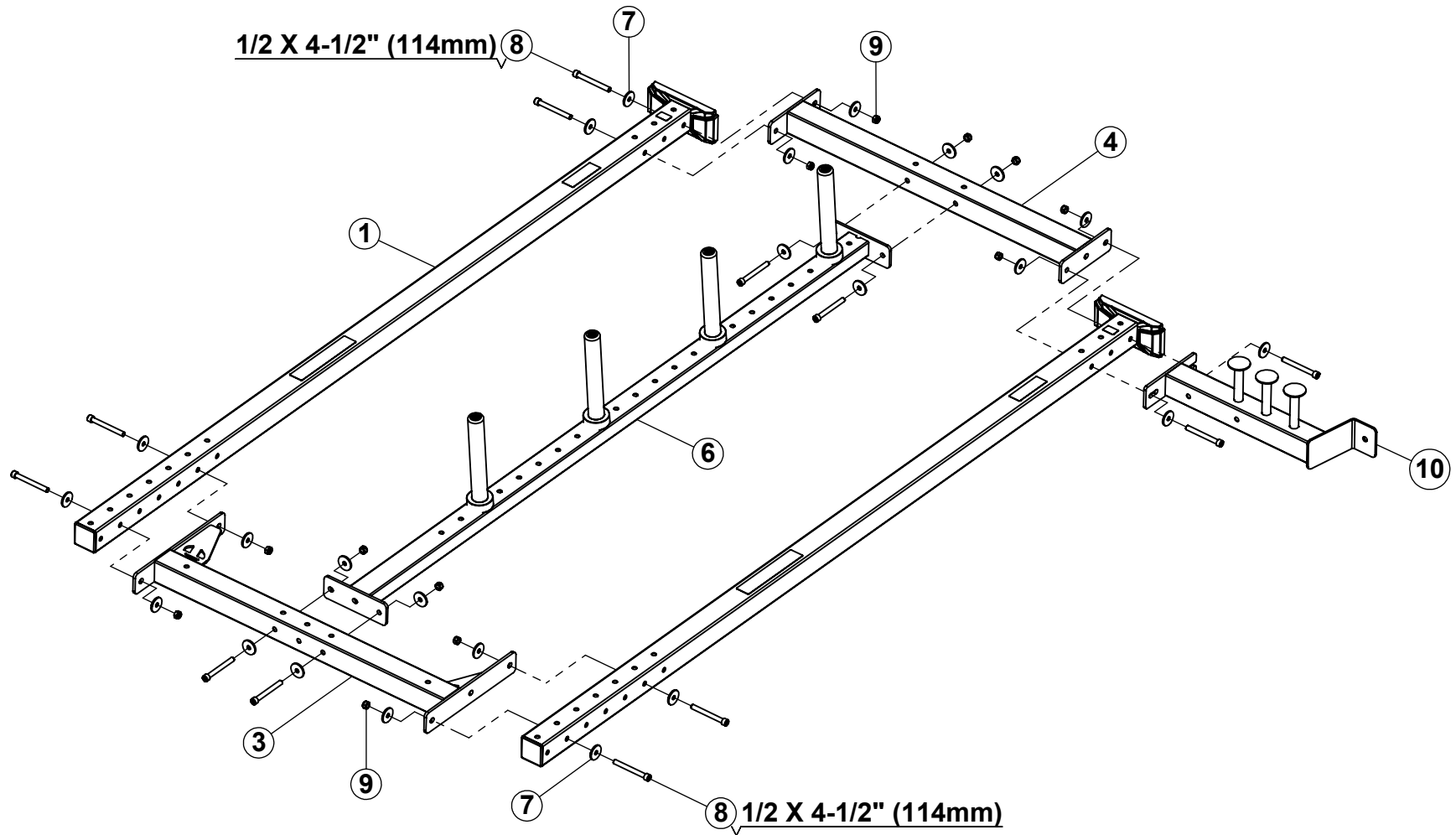
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (12) 1/2 X 4-1/2" BOLTS
- (24) 1/2" FENDER WASHERS
- (12) 1/2" LOCK NUTS



STEP 3

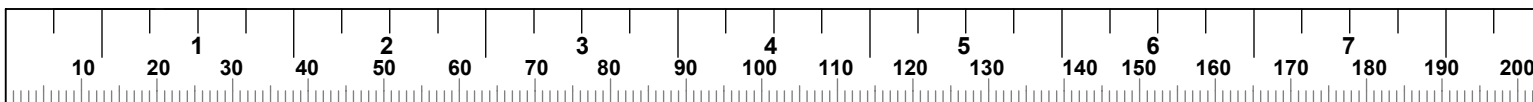


NOTE: For ease of assembly, assemble this step on the floor.

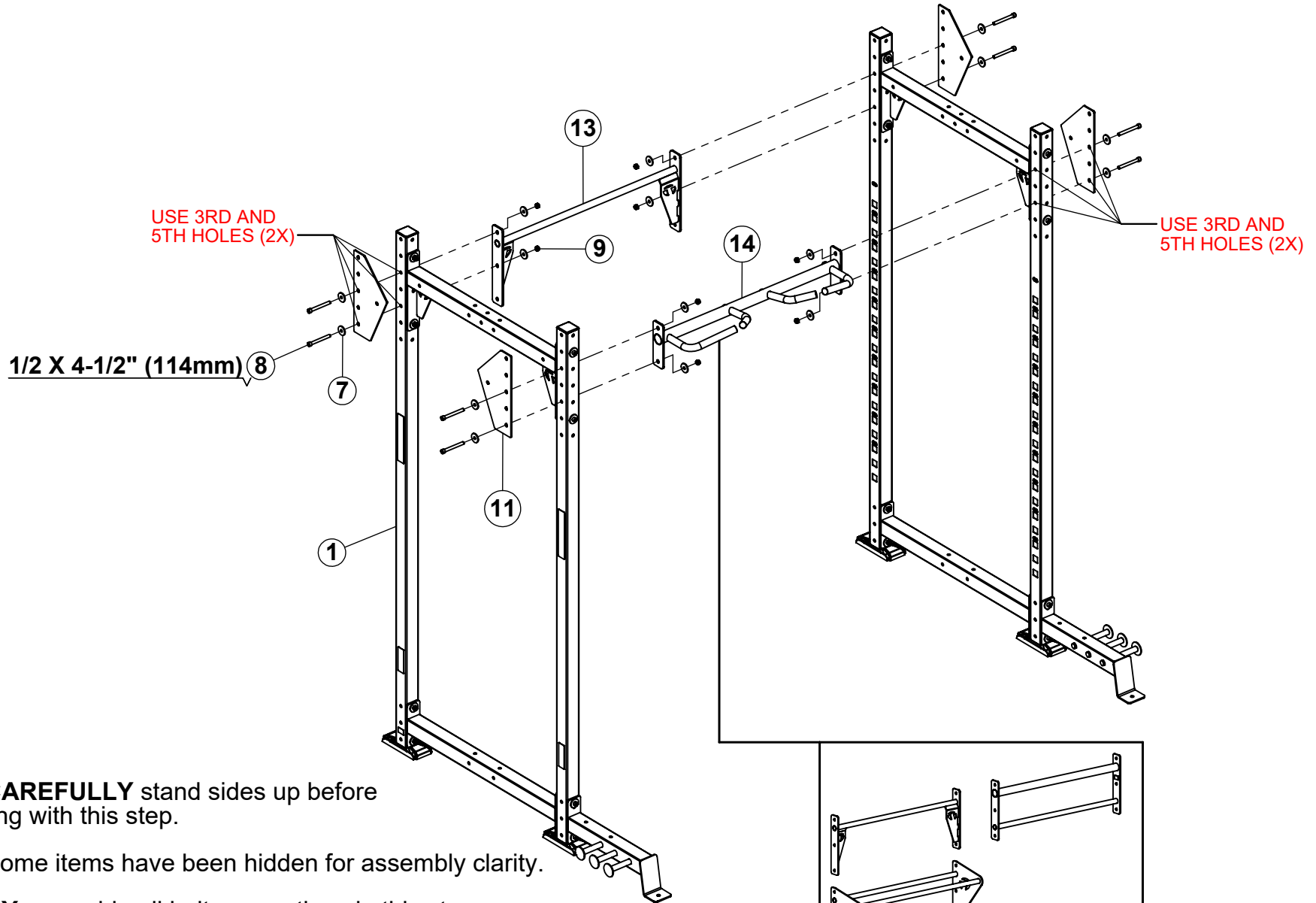
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (12) 1/2 X 4-1/2" BOLTS
- (24) 1/2" FENDER WASHERS
- (12) 1/2" LOCK NUTS



STEP 4



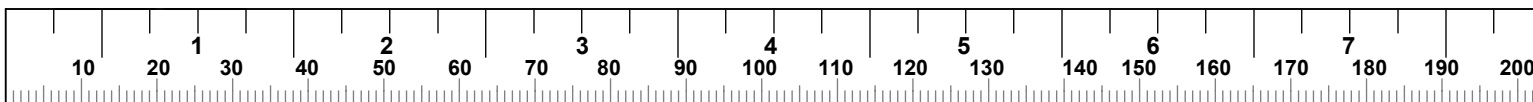
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

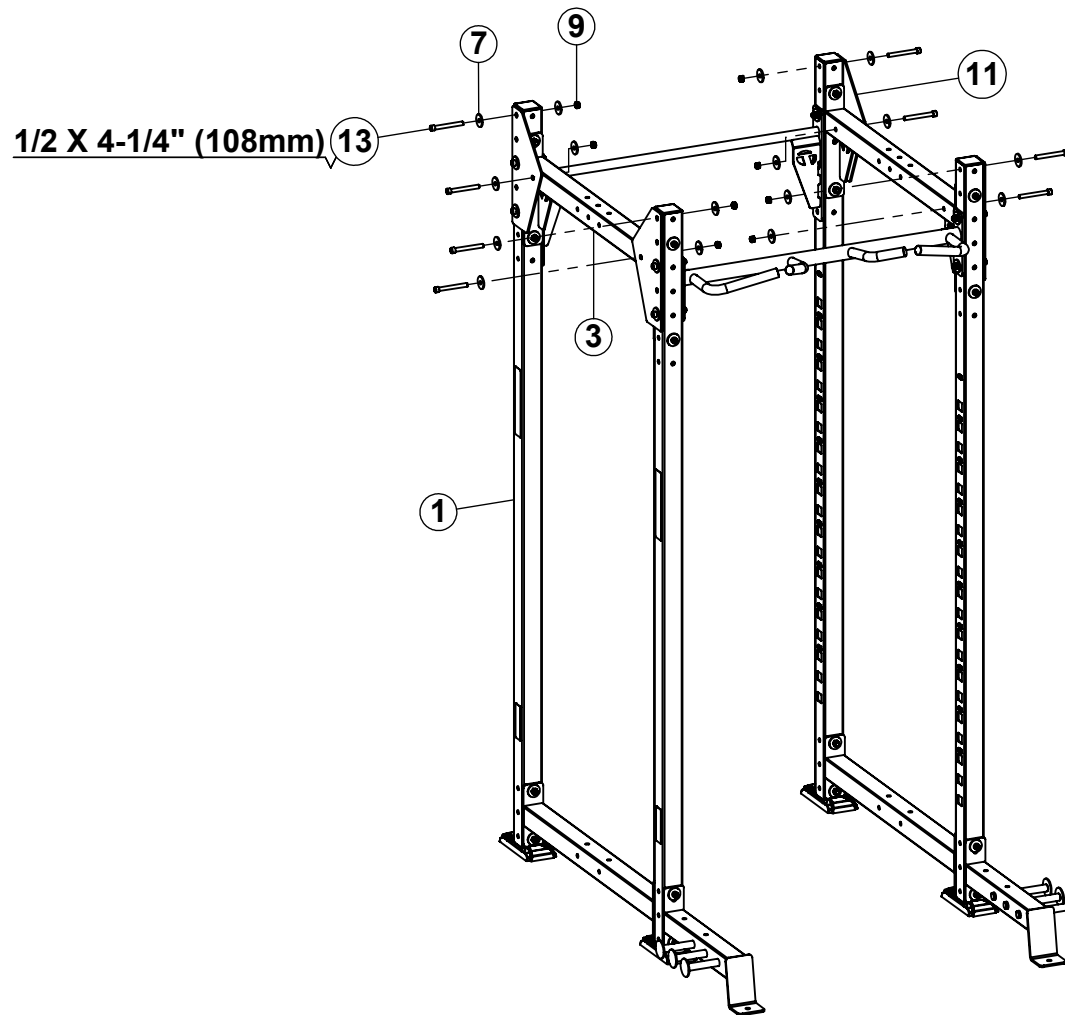
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/2" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 5

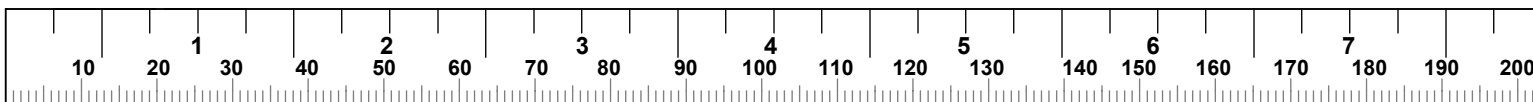


NOTE: Some items have been hidden for assembly clarity.

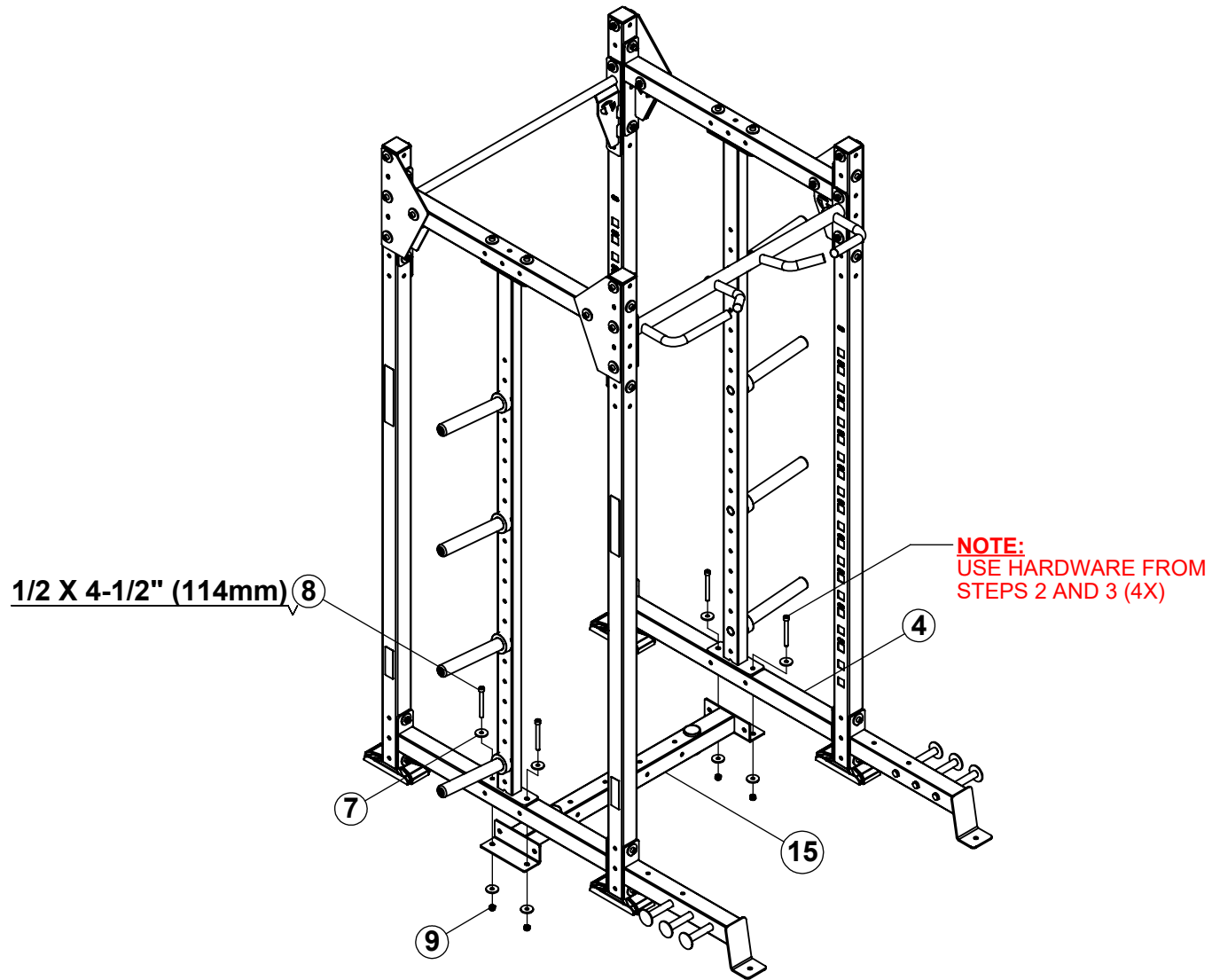
LOOSELY assemble bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 6

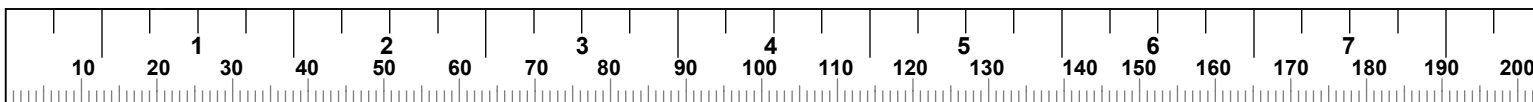


NOTE:

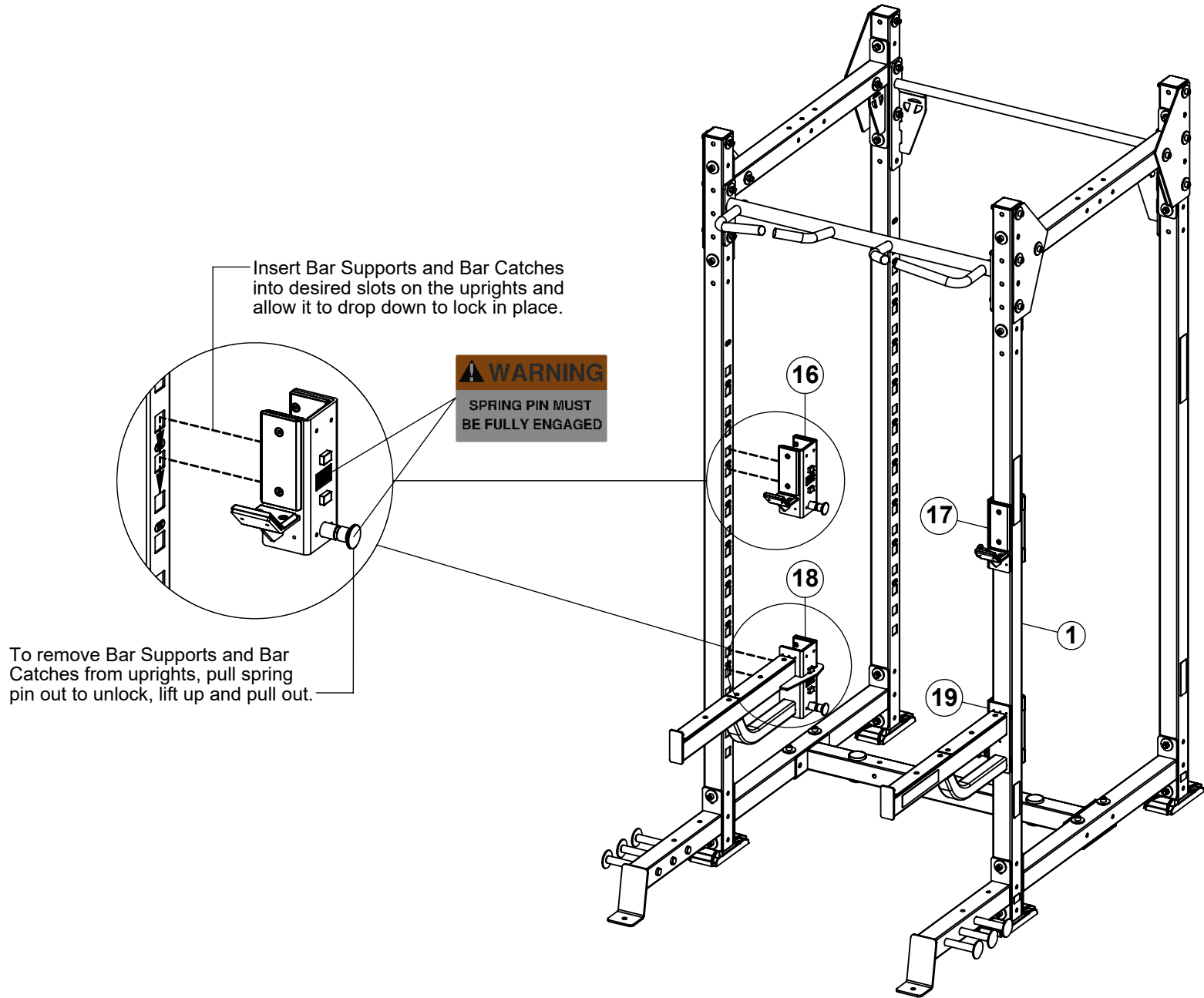
After this step has been completed, **SECURELY** tighten all bolt connections from previous steps.

Hardware from previous step:

- (4) 1/2 X 4-1/2" BOLTS
- (8) 1/2" FENDER WASHERS
- (4) 1/2" LOCK NUTS



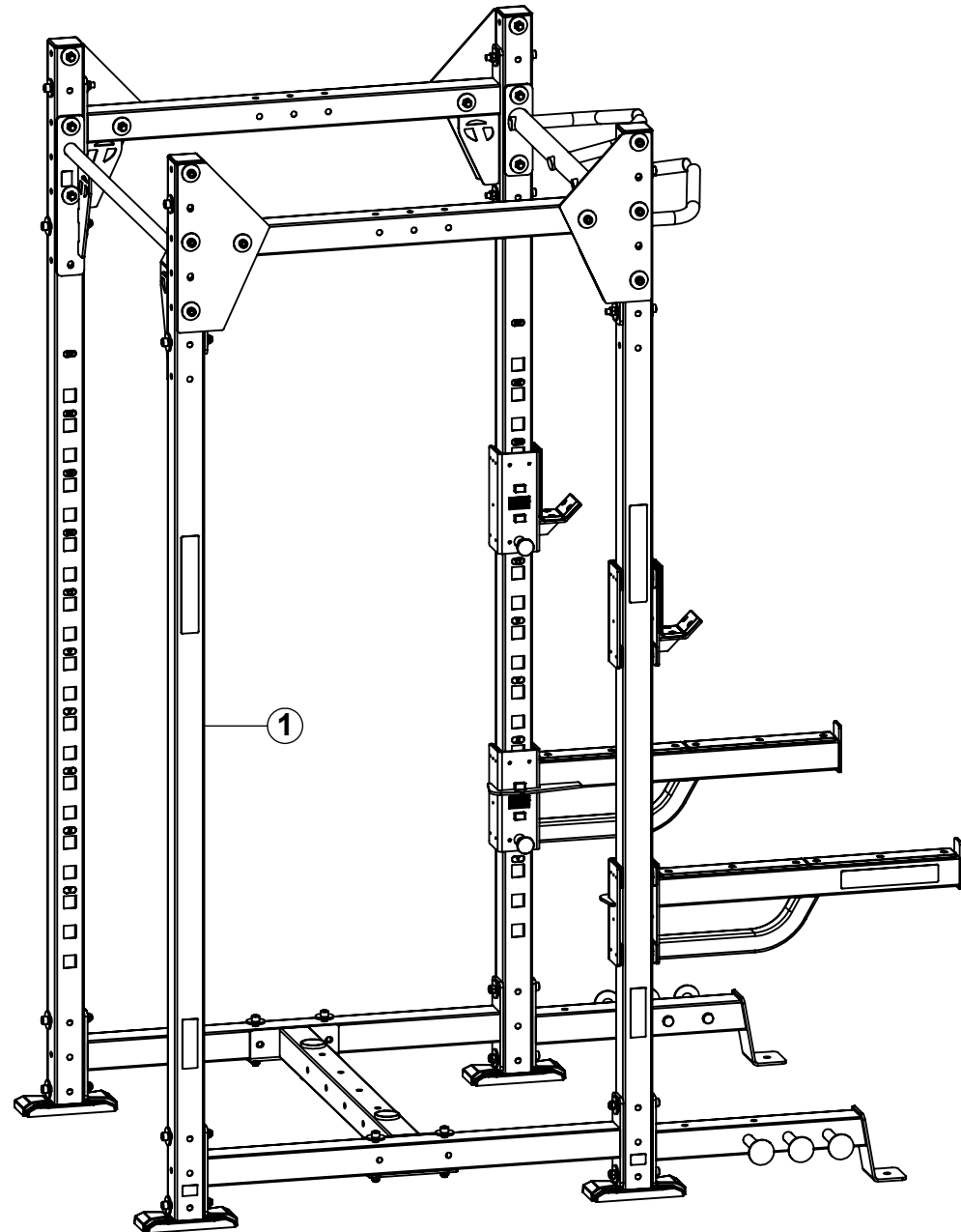
STEP 7



NOTE:
Some parts have been hidden for assembly clarity.

STEP 10 (9' UPRIGHTS ONLY)

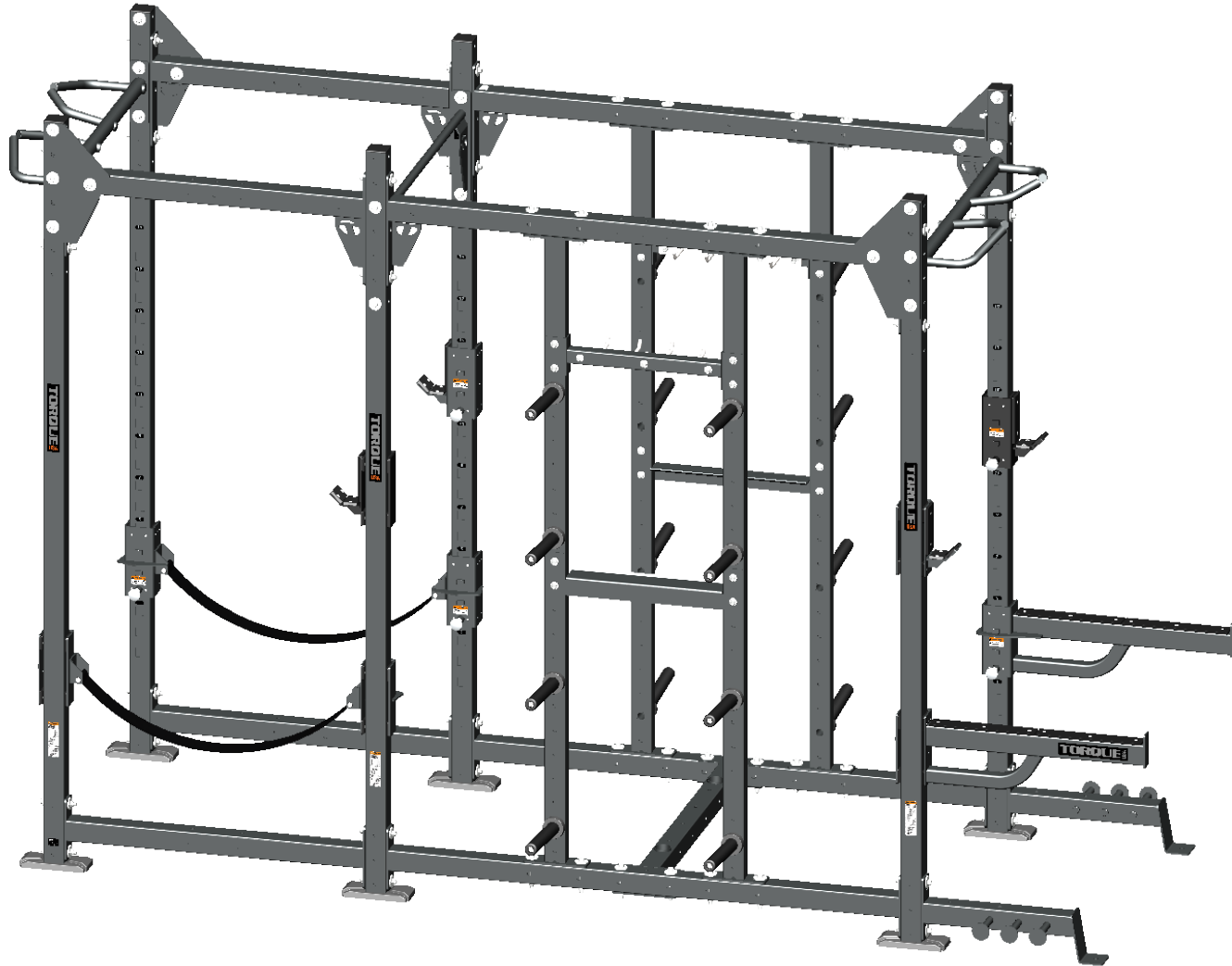
XCCS
CABLE COMPONENT
STATION (SEE NOTE) —————



NOTE:
ASSEMBLE THE XCCS TO THE X-SIEGE USING THE
INSTRUCTIONS INCLUDED WITH THAT PRODUCT.

ASSEMBLY INSTRUCTIONS

4 X 10 STORAGE COMBO RACK



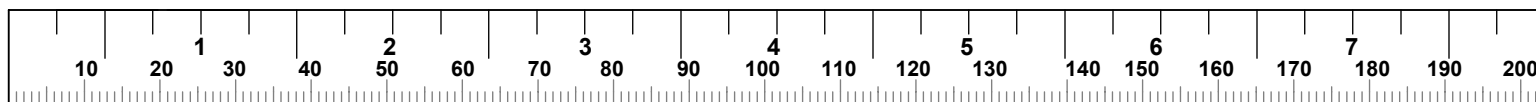
TORQUE USA

ITEM	PART NUMBER	DESCRIPTION	QTY
1	55077PA	PTD ASSY, 9' UPRIGHT	6
2	55899PA	PTD ASSY, 8' UPRIGHT	6
3	5479401	BOOT, X-RACK	6
4	5475201	WLDMT, 6' RECTANGULAR CROSS	2
5	5588801	WLDMT, 6' LOWER RECTANGLE CROSS	2
6	5582201	WLDMT, LBPA LEFT	1
7	5589701	WLDMT, 4' LOWER RECTANGLE CROSS	2
8	5474901	WLDMT, 4' RECTANGLE CROSS	2
9	55891PA	PTD ASSY, 9' UPRIGHT VERTICAL WEIGHT STORAGE	4
10	55901PA	PTD ASSY, 8' UPRIGHT VERTICAL WEIGHT STORAGE	4
11	2007801	WASHER, 1/2 X 1-3/4 X 4.5†	128
12	2005817	BOLT, 1/2-13 X 4-1/2" (114mm) SOCKET HEAD	56
13	2001401	NUT, 1/2-13 LK ST ZN	80
14	5582701	WLDMT, LBPA RIGHT	1
15	5565901	PLATE, UPRIGHT GUSSET	4
16	5481301	WLDMT, 4' MULTI-GRIP CROSS	2
17	5442801	WLDMT, 4' SINGLE CROSS	1
18	2005816	BOLT, 1/2-13 X 4-1/4" (108mm) SOCKET HEAD	8
19	5589401	WLDMT, 4' LOWER CROSS CONNECTOR	1
20	5573201	BRKT, BAR CATCH STORAGE	2
21	2001301	WASHER, FLAT 1/2 SAE ST ZN	32
22	2005811	BOLT, 1/2-13 X 3" (76mm) SOCKET HEAD	16
23	55654PA	PTD ASSY, ACCESSORY HOLDER	2
24	54737PA	PTD ASSY, LEFT BAR SUPPORT	2
25	54742PA	PTD ASSY, RIGHT BAR SUPPORT	2
26	54745PA	PTD ASSY, LEFT BAR CATCH	1
27	54748PA	PTD ASSY, RIGHT BAR CATCH	1
28	5566501	ASSY, 4' BAR CATCH STRAP	2

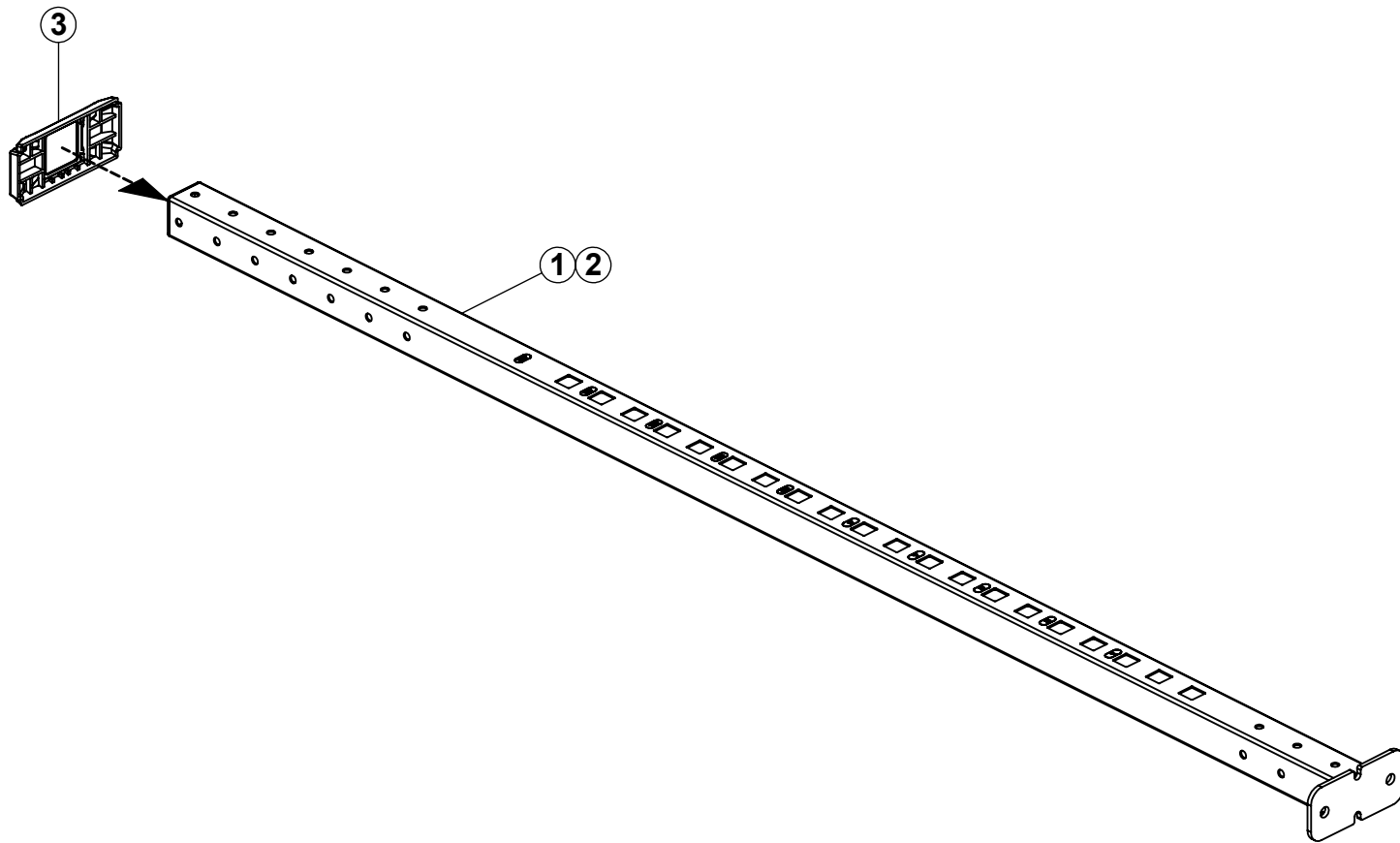
*Used with 8' option only.

*Used with 8' option only.

**The extra part (item 19) will not be used in this package.

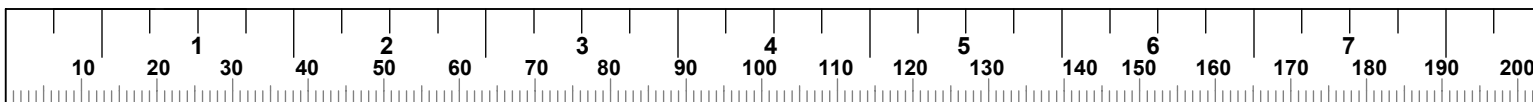
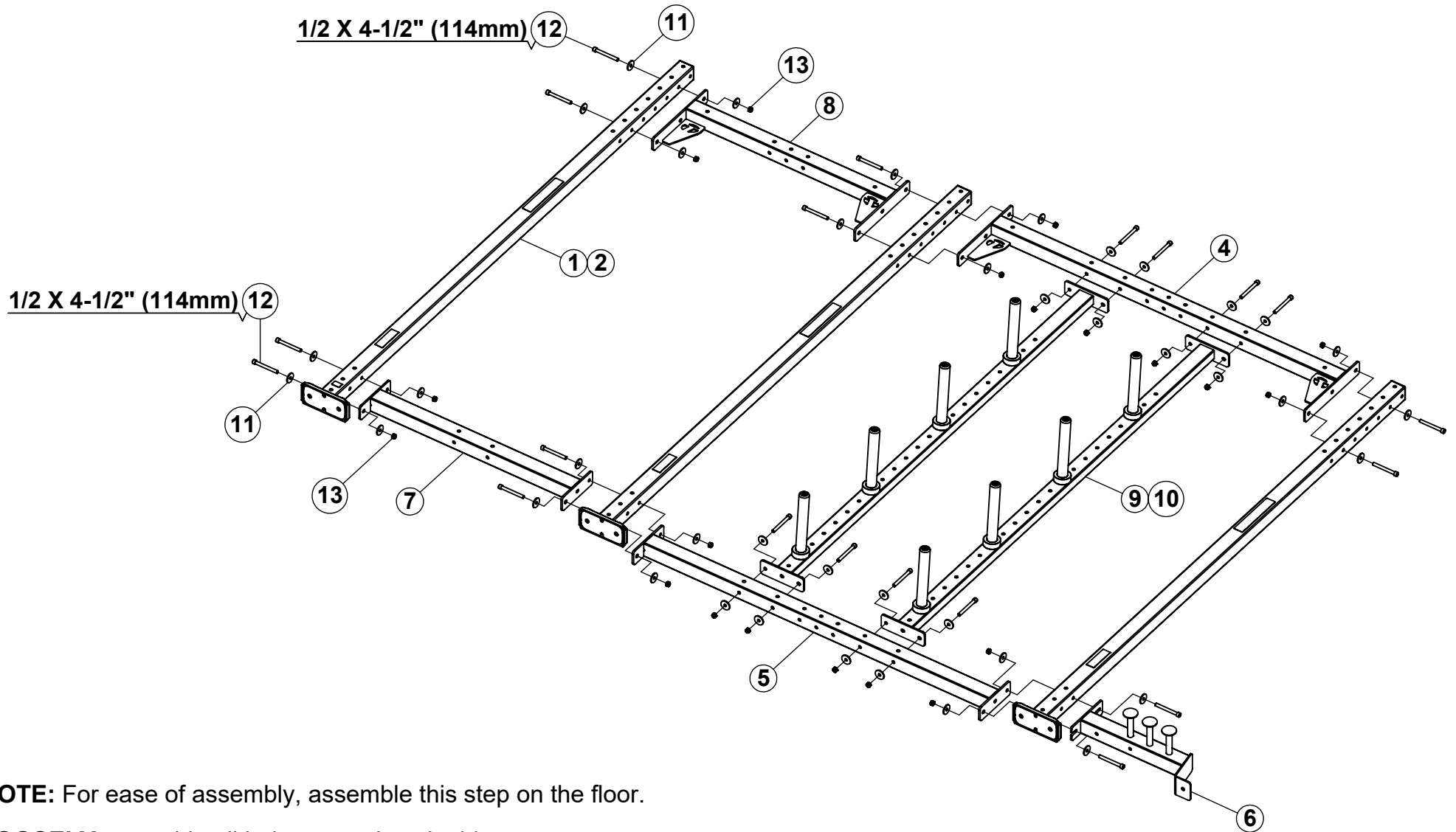


STEP 1

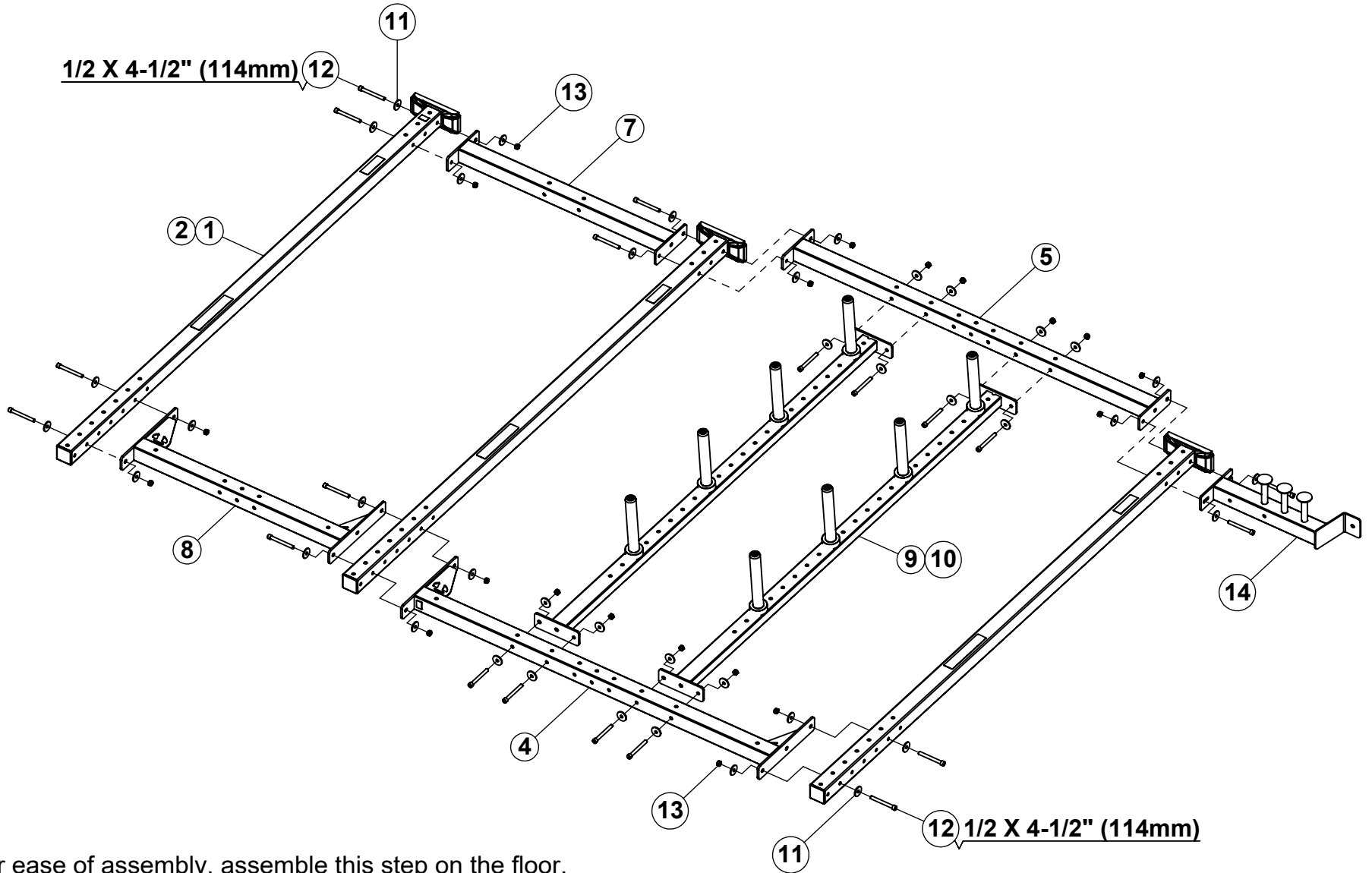


NOTE: Repeat this step for all six uprights.

STEP 2



STEP 3

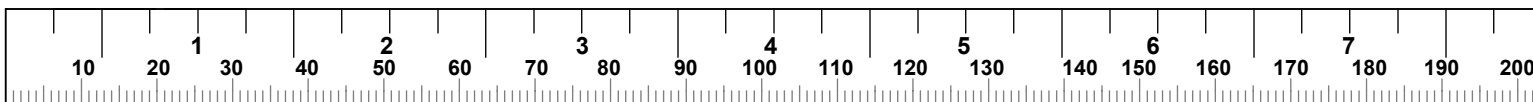


NOTE: For ease of assembly, assemble this step on the floor.

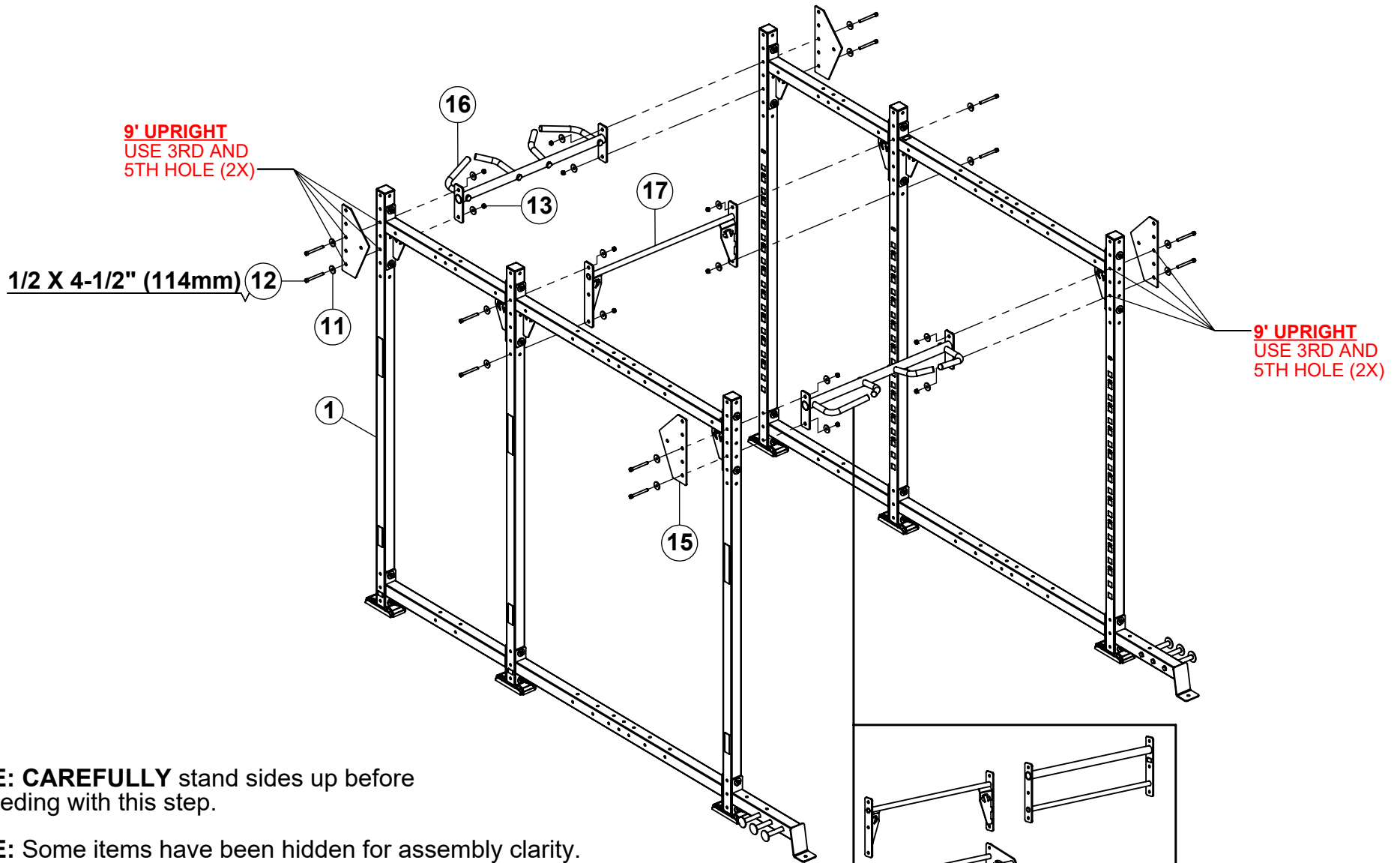
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (20) 1/2 X 4-1/2" BOLTS
- (40) 1/2" FENDER WASHERS
- (20) 1/2" LOCK NUTS



STEP 4 (9' UPRIGHTS ONLY)



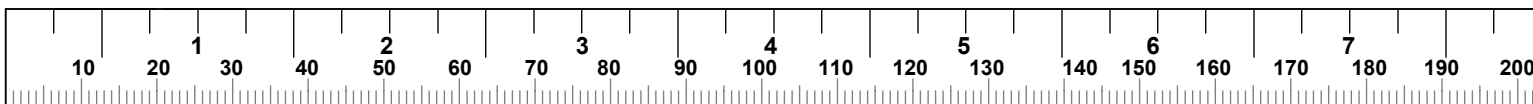
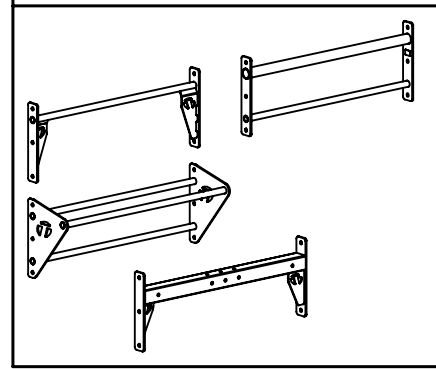
NOTE: CAREFULLY stand sides up before proceeding with this step.

NOTE: Some items have been hidden for assembly clarity.

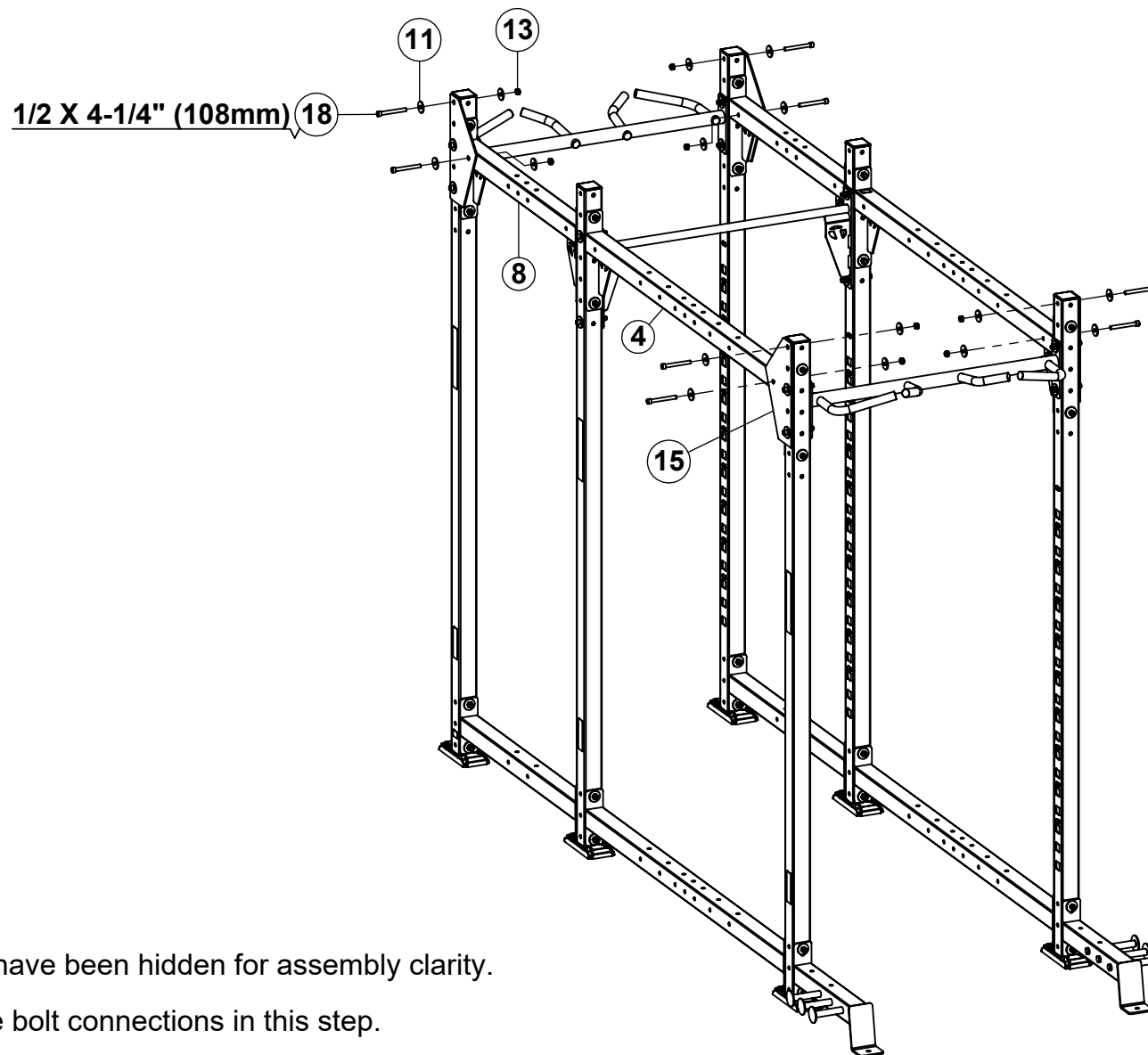
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (12) 1/2 X 4-1/2" BOLTS
- (24) 1/2" FENDER WASHERS
- (12) 1/2" LOCK NUTS



STEP 5 (9' UPRIGHTS ONLY)

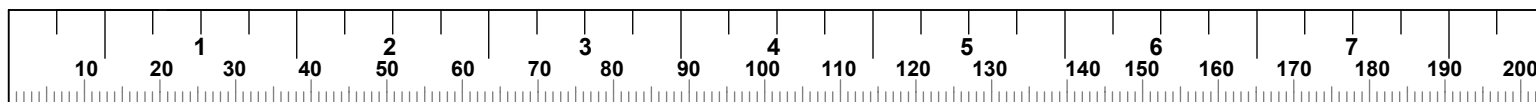


NOTE: Some items have been hidden for assembly clarity.

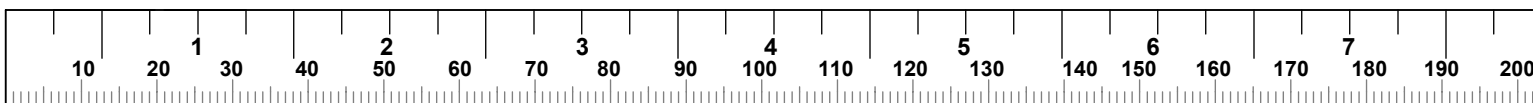
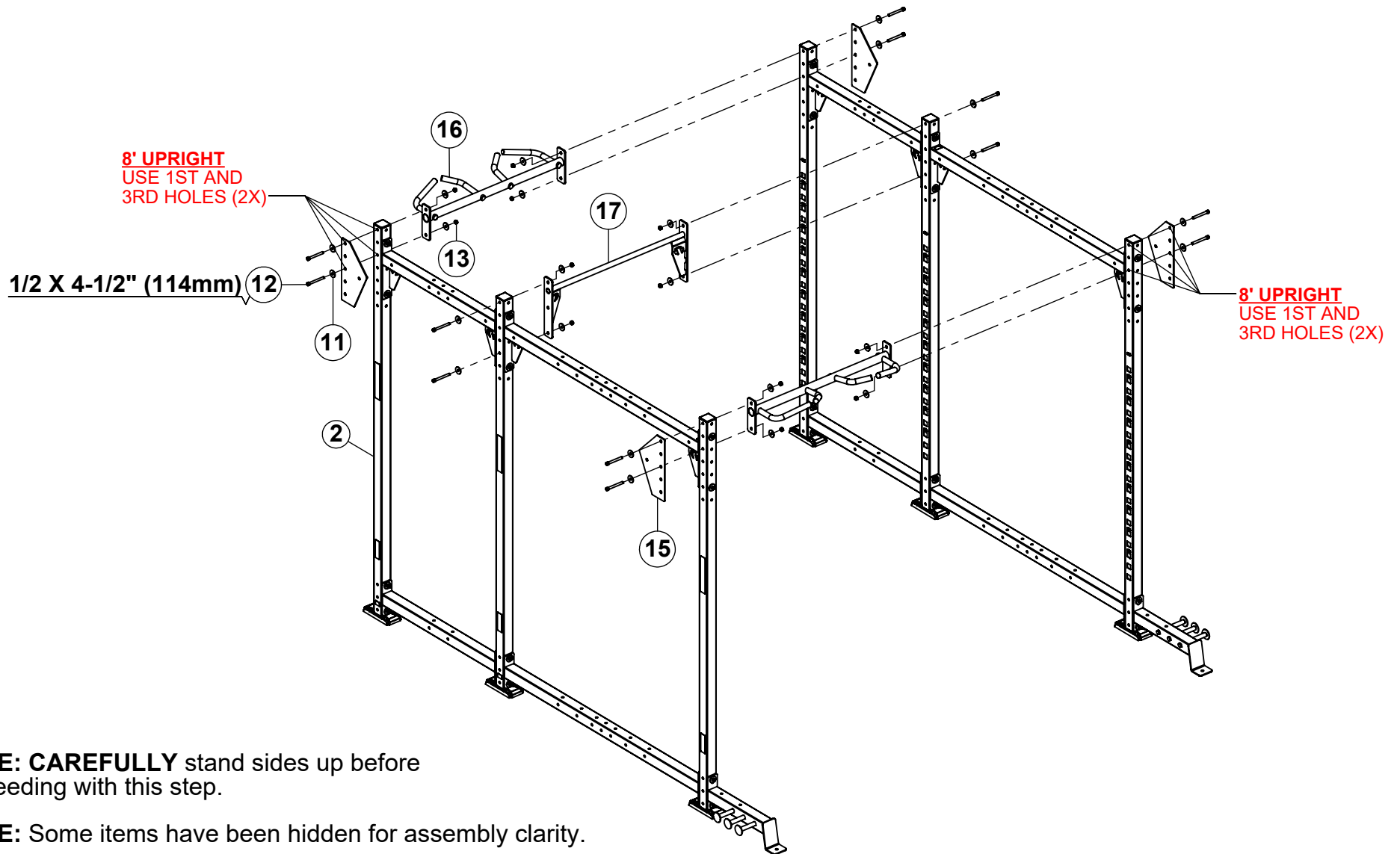
LOOSELY assemble bolt connections in this step.

Hardware for this step:

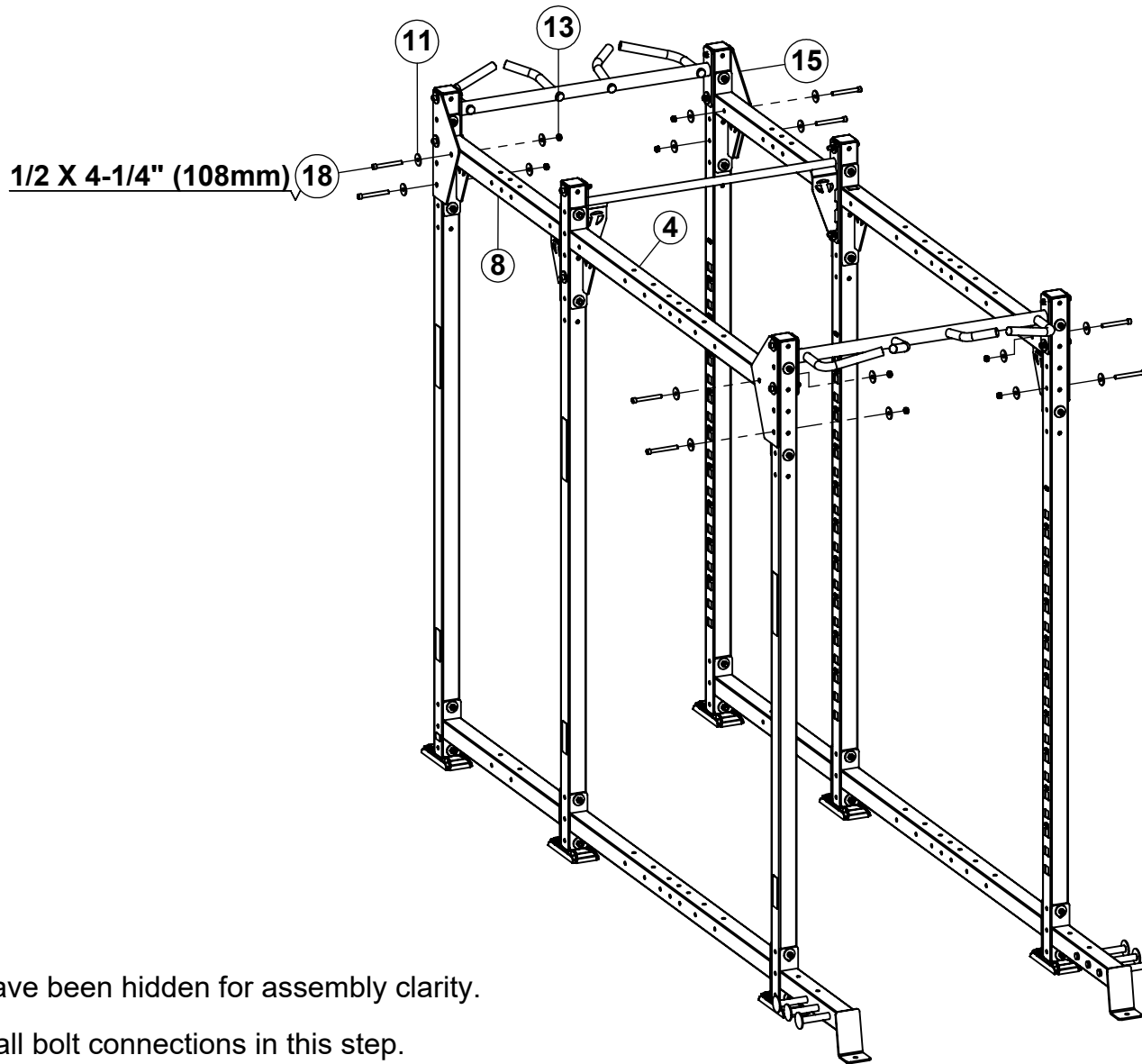
- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



STEP 6 (8' UPRIGHTS ONLY)



STEP 7 (8' UPRIGHTS ONLY)

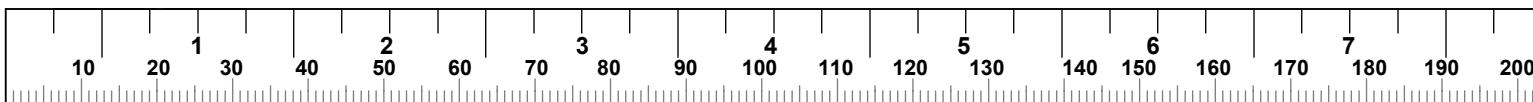


NOTE: Some items have been hidden for assembly clarity.

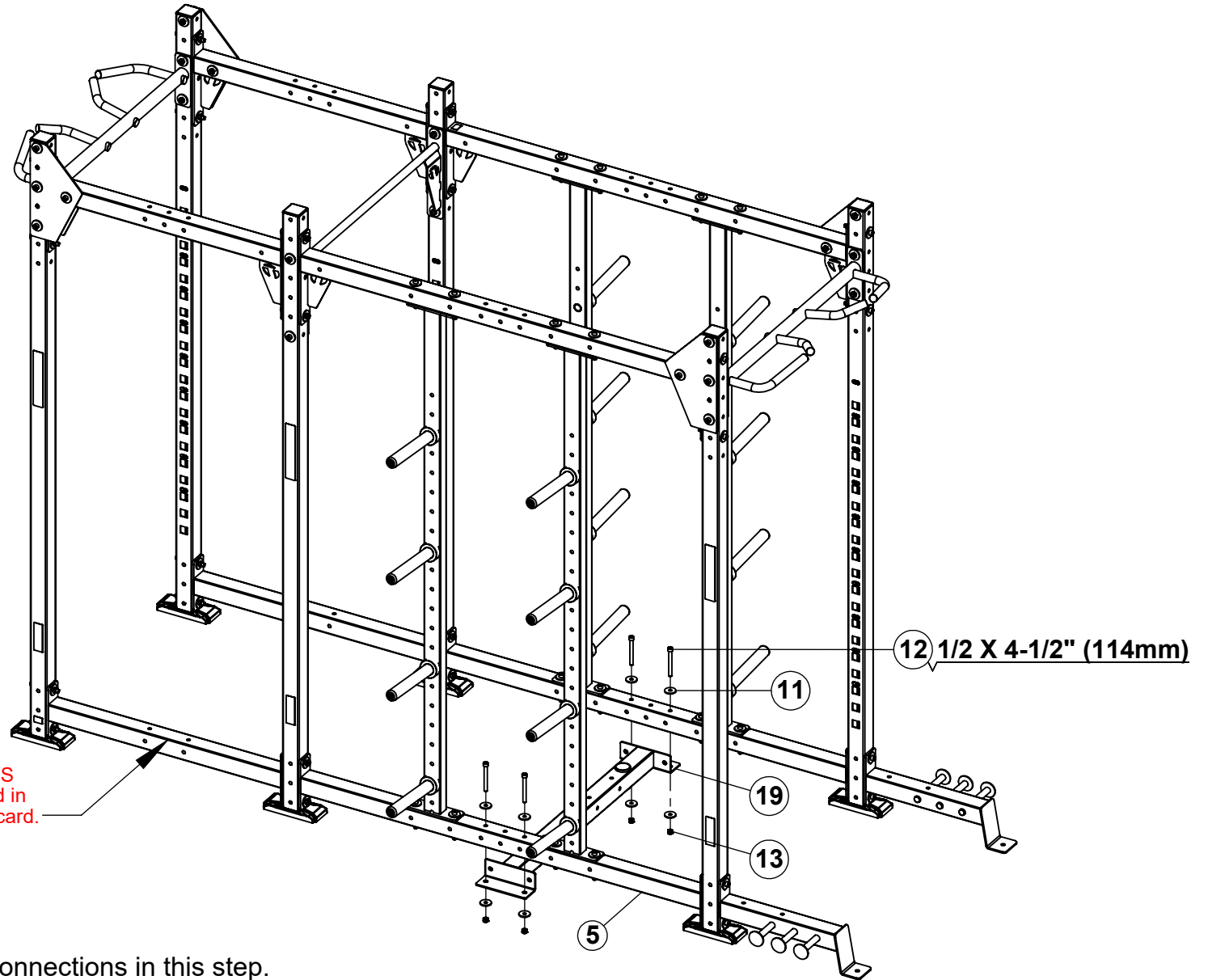
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 4-1/4" BOLTS
- (16) 1/2" FENDER WASHERS
- (8) 1/2" LOCK NUTS



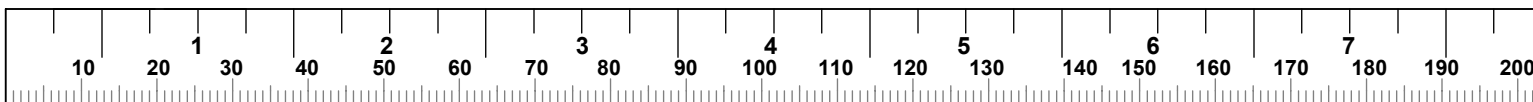
STEP 8



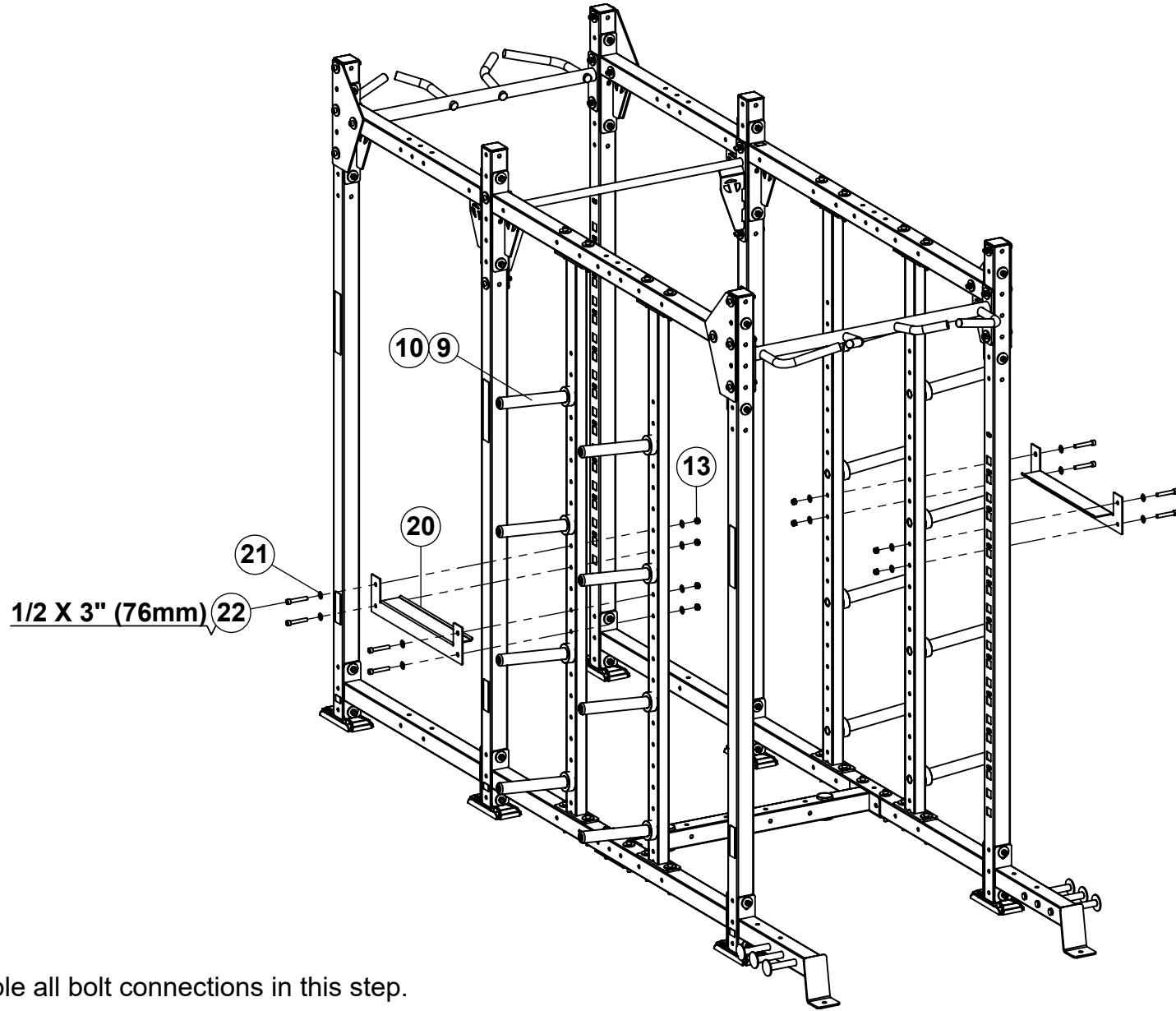
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (4) 1/2 X 4-1/2" BOLTS
- (8) 1/2" FENDER WASHERS
- (4) 1/2" LOCK NUTS



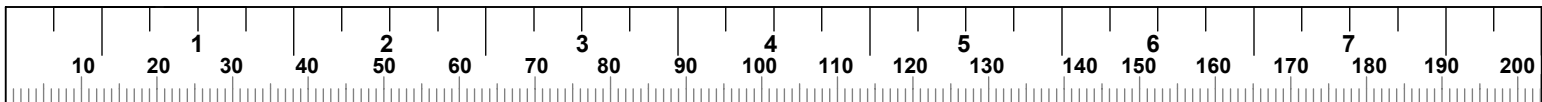
STEP 9



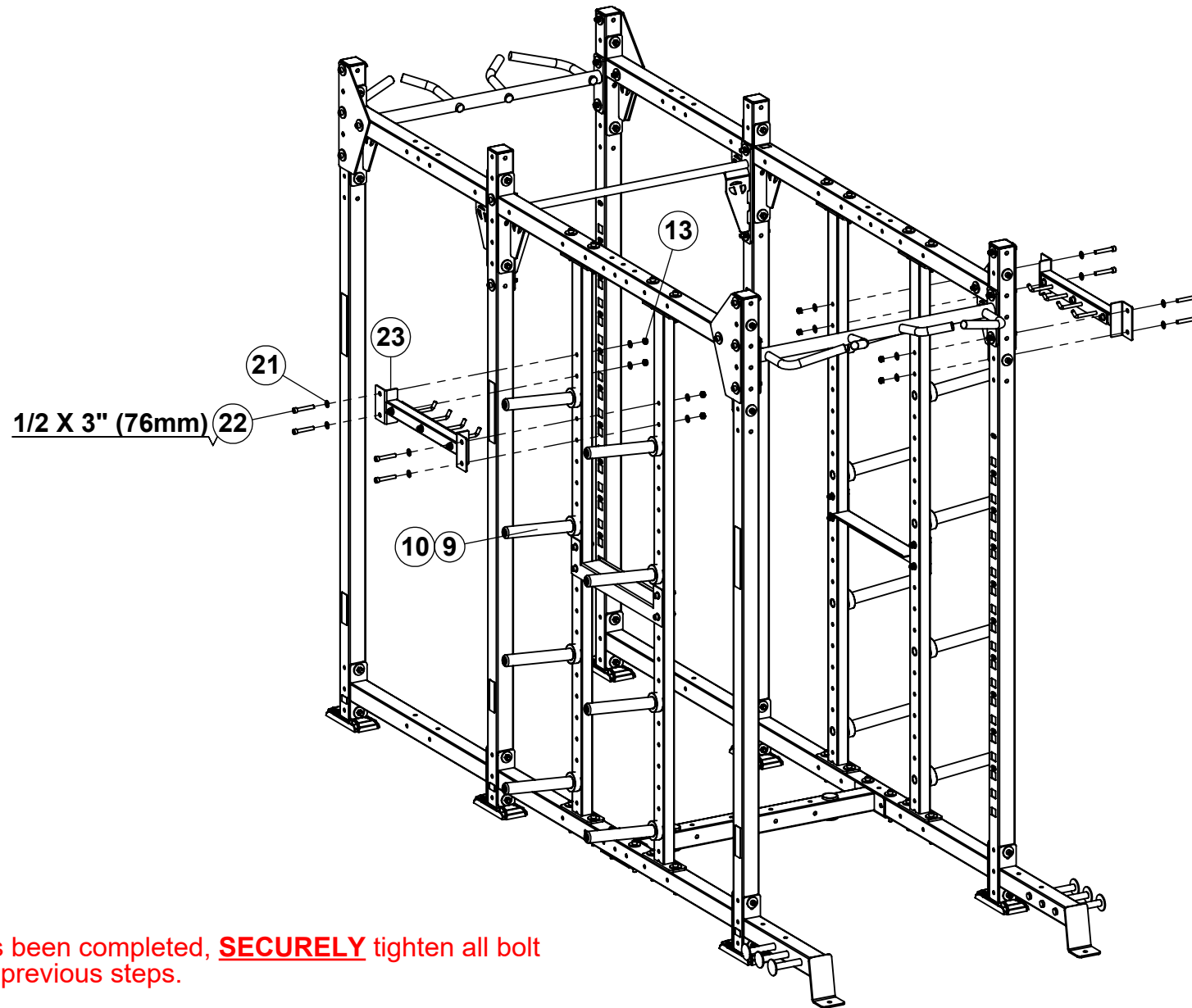
LOOSELY assemble all bolt connections in this step.

Hardware for this step:

- (8) 1/2 X 3" BOLTS
- (16) 1/2" FLAT WASHERS
- (8) 1/2" LOCK NUTS

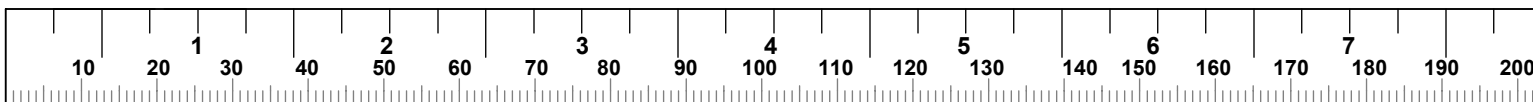


STEP 10

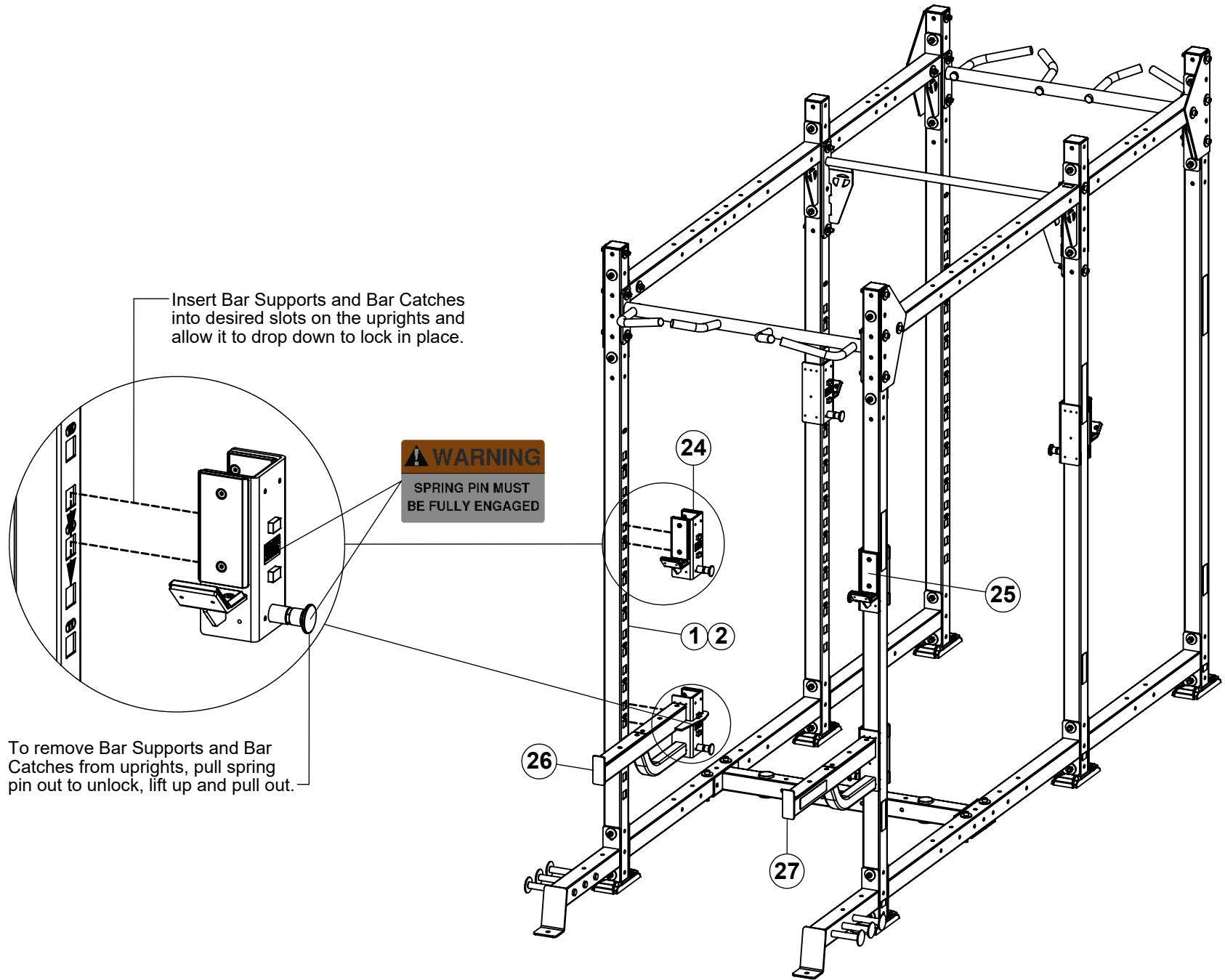


NOTE:
After this step has been completed, **SECURELY** tighten all bolt connections from previous steps.

- Hardware for this step:**
- (8) 1/2 X 3" BOLTS
 - (16) 1/2" FLAT WASHERS
 - (8) 1/2" LOCK NUTS



STEP 11



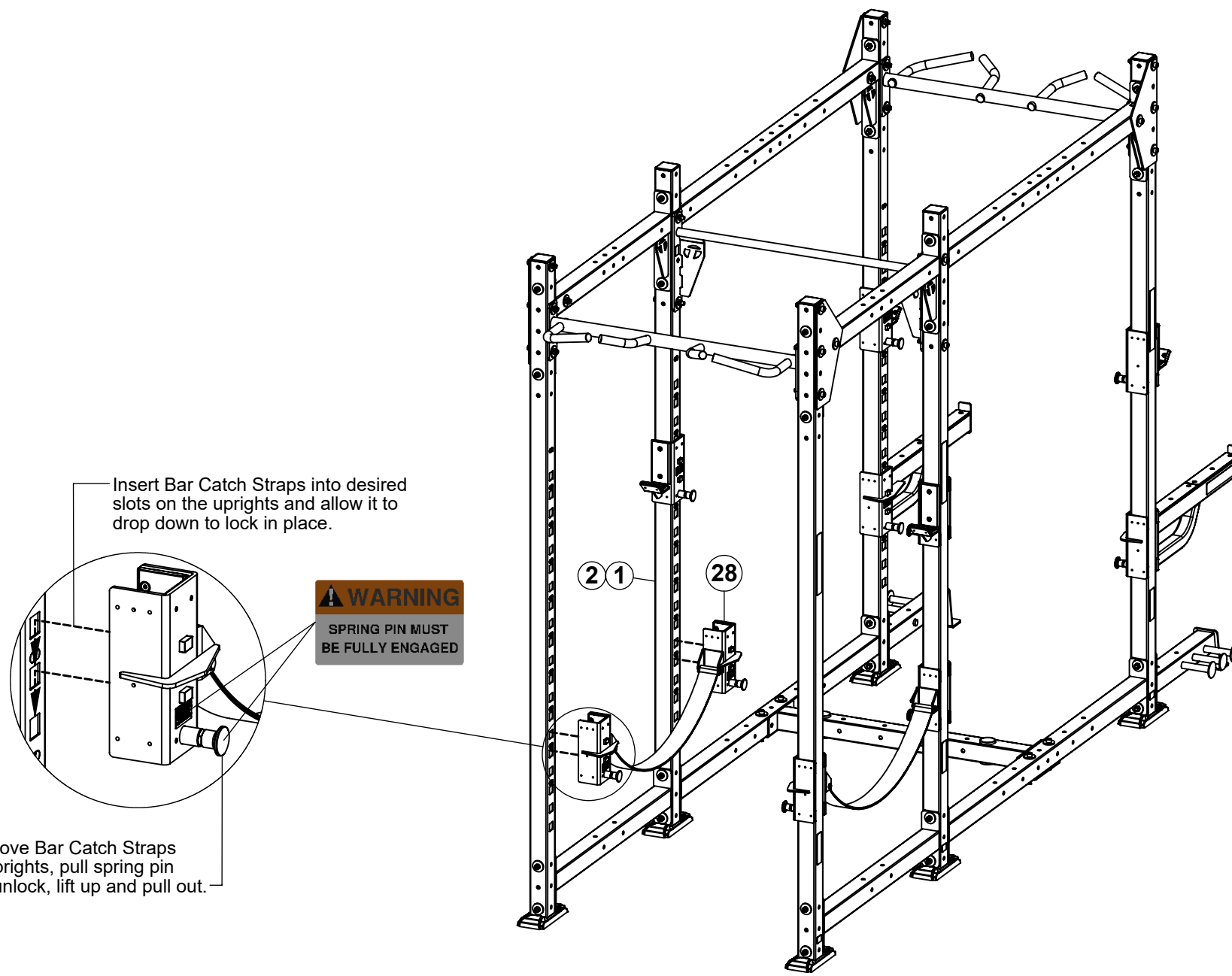
Insert Bar Supports and Bar Catches into desired slots on the uprights and allow it to drop down to lock in place.

WARNING
SPRING PIN MUST BE FULLY ENGAGED

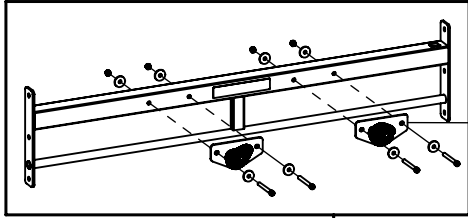
To remove Bar Supports and Bar Catches from uprights, pull spring pin out to unlock, lift up and pull out.

NOTE:
Some parts have been hidden for assembly clarity.

STEP 12



NOTE:
Some parts have been hidden for assembly clarity.

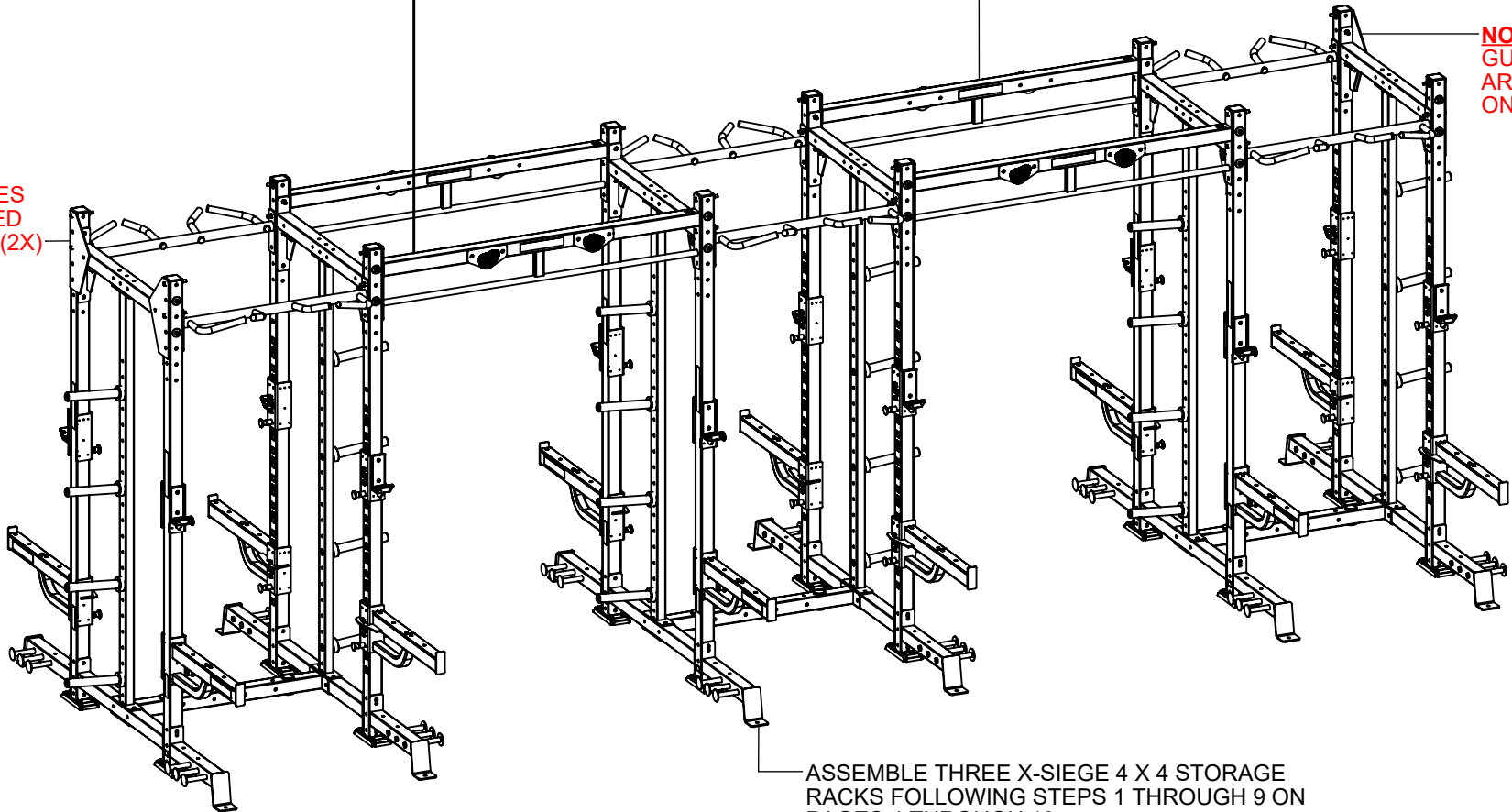


ASSEMBLE LEFT AND RIGHT ROCK GRIPS TO THE 6' MONKEY BAR CROSS AS SHOWN (4X).

SECURELY ASSEMBLE 6' MONKEY BAR CROSSES BETWEEN RACKS USING EXISTING HARDWARE (4X)

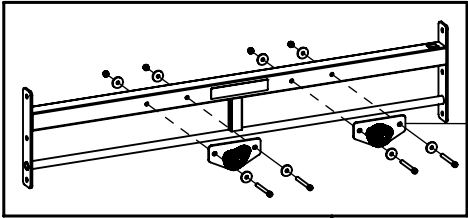
NOTE:
GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)

NOTE:
GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)



ASSEMBLE THREE X-SIEGE 4 X 4 STORAGE RACKS FOLLOWING STEPS 1 THROUGH 9 ON PAGES 4 THROUGH 13

XSS-6-24-X1

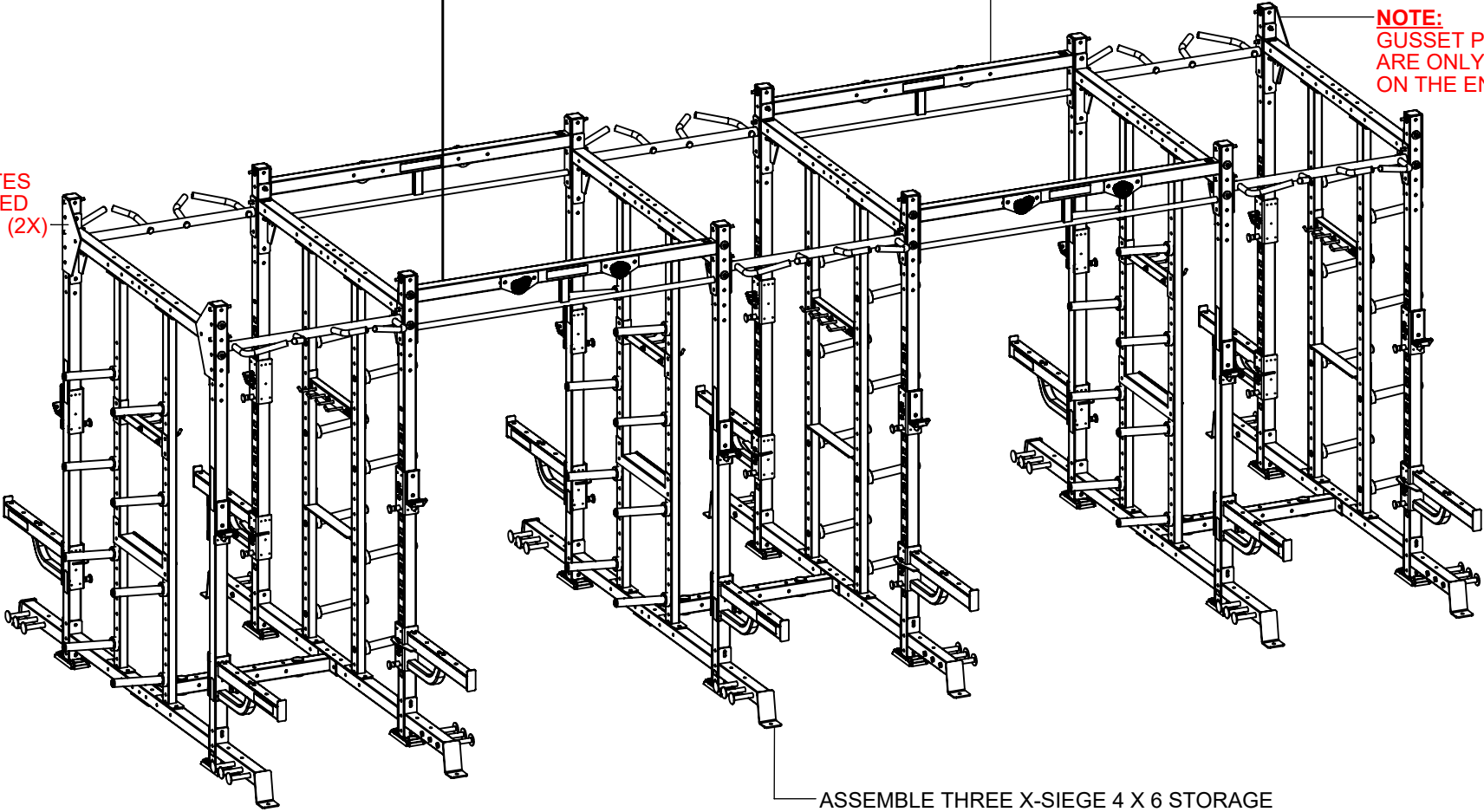


ASSEMBLE LEFT AND RIGHT ROCK GRIPS TO THE 6' MONKEY BAR CROSS AS SHOWN (4X).

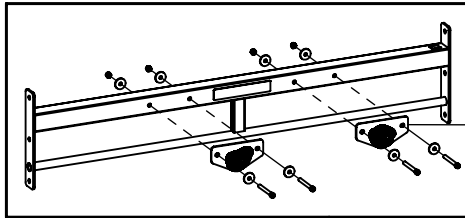
SECURELY ASSEMBLE 6' MONKEY BAR CROSSES BETWEEN RACKS USING EXISTING HARDWARE (4X)

NOTE: GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)

NOTE: GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)



ASSEMBLE THREE X-SIEGE 4 X 6 STORAGE RACKS FOLLOWING STEPS 1 THROUGH 11 ON PAGES 16 THROUGH 26

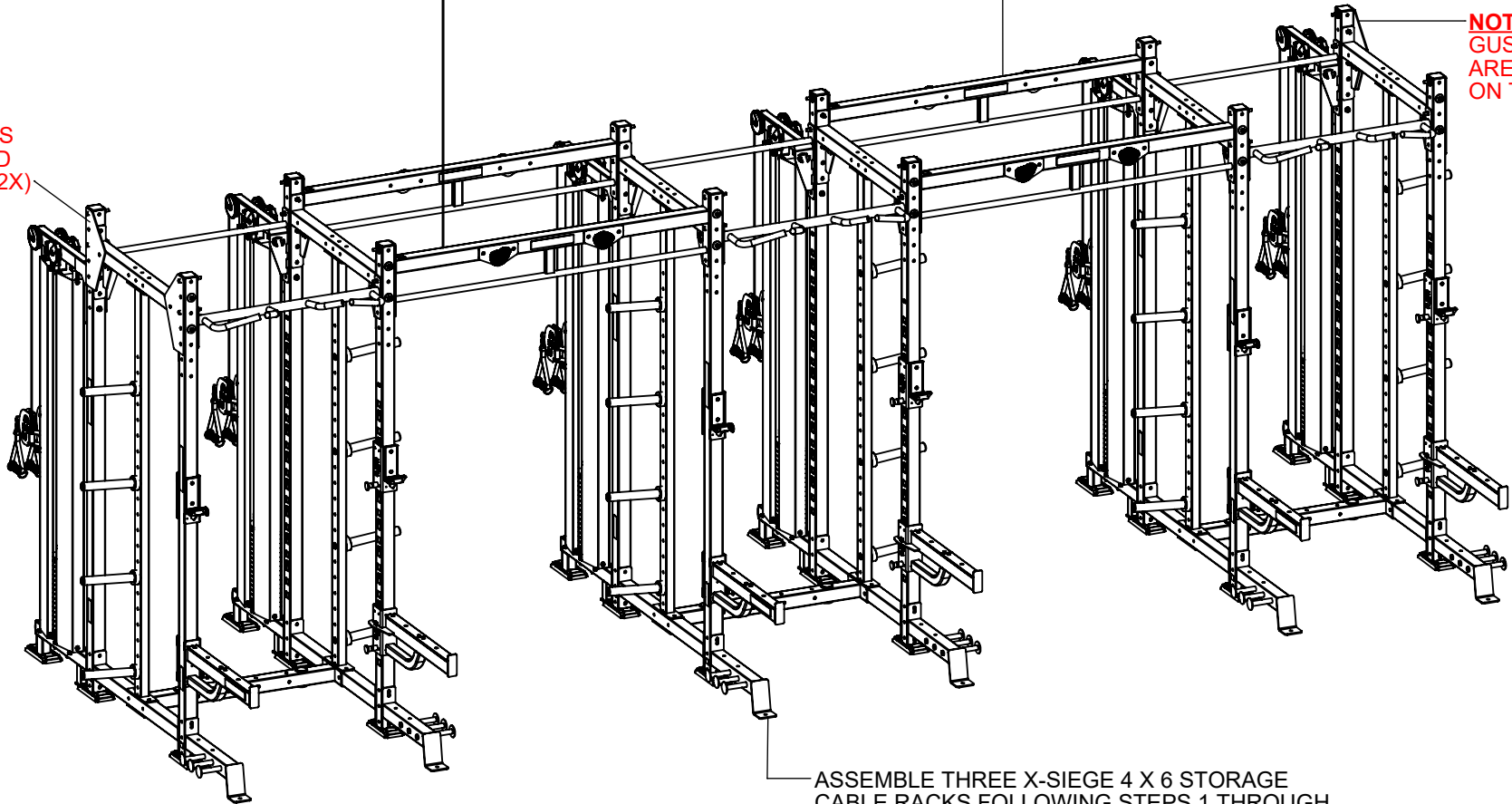


ASSEMBLE LEFT AND RIGHT ROCK GRIPS TO THE 6' MONKEY BAR CROSS AS SHOWN (4X).

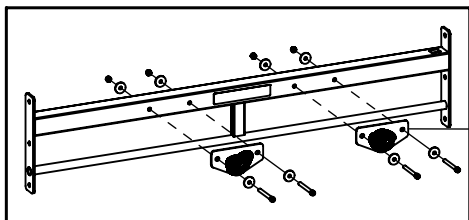
SECURELY ASSEMBLE 6' MONKEY BAR CROSSES BETWEEN RACKS USING EXISTING HARDWARE (4X)

NOTE:
GUSSET PLATES
ARE ONLY USED
ON THE ENDS (2X)

NOTE:
GUSSET PLATES
ARE ONLY USED
ON THE ENDS (2X)



ASSEMBLE THREE X-SIEGE 4 X 6 STORAGE CABLE RACKS FOLLOWING STEPS 1 THROUGH 10 ON PAGES 29 THROUGH 36

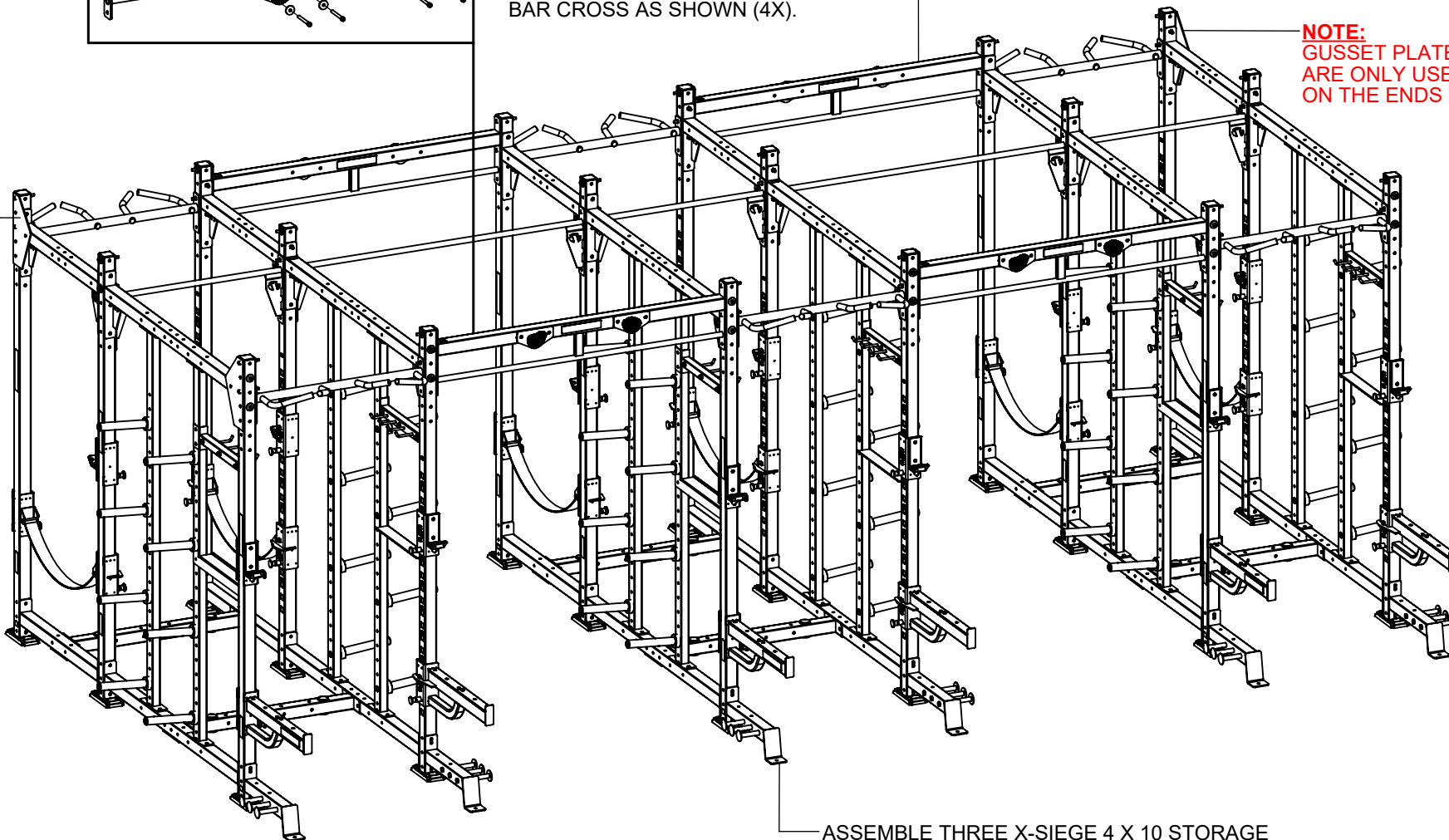


ASSEMBLE LEFT AND RIGHT ROCK GRIPS TO THE 6' MONKEY BAR CROSS AS SHOWN (4X).

SECURELY ASSEMBLE 6' MONKEY BAR CROSSES BETWEEN RACKS USING EXISTING HARDWARE (4X)

NOTE:
GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)

NOTE:
GUSSET PLATES ARE ONLY USED ON THE ENDS (2X)



ASSEMBLE THREE X-SIEGE 4 X 10 STORAGE COMBO RACKS FOLLOWING STEPS 1 THROUGH 12 ON PAGES 39 THROUGH 50