INSTALLATION GUIDE



MODULAR 3000 SERIES

WINE CAPTAIN® MODELS

BEVERAGE CENTERS

GLASS DOOR REFRIGERATORS

REFRIGERATORS



U-3018WCOL-00







O-301011 COL-00	
U-3018WCOL-01	
U-3018WCS-00	
U-3018WCS-01	
U-3018WCS-13	
U-3018WCS-15	
U-3024WCOL-00	
U-3024WCOL-01	
U-3024WCS-00	
U-3024WCS-01	
U-3036WCWCOL-00	
U-3036WCWCS-00	
U-3036WCWCS-13	

U-3024BEVOL-00	
U-3024BEVOL-01	
U-3024BEVS-00	
U-3024BEVS-01	
U-3036BVWCOL-00	
U-3036BVWCS-00	
U-3036BVWCS-13	

U-3018RGLOL-00
U-3018RGLOL-01
U-3018RGLS-00
U-3018RGLS-01
U-3018RGLS-13
U-3018RGLS-15
U-3024RGLOL-00
U-3024RGLOL-01
U-3024RGLS-00
U-3024RGLS-01
U-3036RRGLOL-00
U-3036RRGLS-00
U-3036RRGLS-13

U-3018RFOL-00
U-3018RFS-01
U-3018RFS-01
U-3024RFOL-00
U-3024RFOL-01
U-3024RFS-00
U-3024RFS-01
U-3036RROL-00
U-3036RRS-00

THE MODULAR 3000 SERIES ARE INTENDED FOR BUILT-IN INSTALLATIONS ONLY

Table of Contents

I - Safety Precautions	
Safety Alert Definitions	1
General Precautions	1
2 - Inspect & Plan	
Product Registration	2
Product Description	2
Exterior Cleaning	2
3 - Prepare Site	
Electrical Specifications	3
Cut-Out Dimensions	
3018 Series	3
3024 Series	3
3036 Series	3
4 - Product Dimensions	
3018, 3024 & 3036 Series	4
5 - Door Swing Dimensions	
Other Site Requirements	
Side-By-Side Installation	
Power Supply	
Environmental Requirements	5
6 - 3000 Series Doors	
Door Alignment and Adjustment	6
7 - 3000 Series Overlays	
Overlay / Frame Overlay Panel	
Panel Preparation	
Panel Installation	
Overlay Grille	9
8 - 3000 Series Anti-Tip Bracket	
Anti-Tip Brackets InstallationI	I
9 - Level & Install	
Leveling Information	
Installation	
Relocating the Shelves	
Installation Troubleshooting I	3

General Information

NOTICE

- PLEASE READ all instructions before installing, operating, or servicing the appliance.
- Proper installation procedures must be followed when completing an installation or relocation of a unit. An INSTALLATION GUIDE for the unit, providing complete installation information, is available from U-Line Corporation direct. Consult the installation guide before any installation begins. U-Line contact information appears on the rear cover of this guide.
- This unit requires connection to a dedicated 15 Amp grounded (three-prong), polarized receptacle, installed by a qualified electrician, compliant with applicable electrical codes.

Safety Alert Definitions

Throughout this guide are safety items labeled with a Danger, Warning or Caution based on the risk type:

▲ DANGER

Danger means that failure to follow this safety statement will result in severe personal injury or death.

▲ WARNING

Warning means that failure to follow this safety statement could result in serious personal injury or death.

▲ CAUTION

Caution means that failure to follow this safety statement may result in minor or moderate personal injury, property or equipment damage.

General Precautions

Use this appliance for its intended purpose only and follow these general precautions with those listed throughout this guide:

▲ DANGER

RISK OF CHILD ENTRAPMENT. Before you throw away your old refrigerator or freezer, take off the doors and leave shelves in place so children may not easily climb inside.

MARNING

SHOCK HAZARD - Electrical Grounding Required.

- Never attempt to repair or perform maintenance on the unit until the electricity has been disconnected.
- Never remove the round grounding prong from the plug and never use a two-prong grounding adapter.
- Altering, cutting of power cord, removal of power cord, removal of power plug, or direct wiring can cause serious injury, fire and or loss of property and or life, and will void the warranty.
- Never use an extension cord to connect power to the unit.
- · Always keep your working area dry.

▲ WARNING

Install provided Anti-Tip kit on all 3000 series units. Serious personal injury could occur.

▲ CAUTION

- Use care when moving and handling the unit. Use gloves to prevent personal injury from sharp edges.
- If your model requires defrosting, DO NOT use an ice pick or other sharp instrument to help speed up defrosting. These instruments can puncture the inner lining or damage the cooling unit. DO NOT use any type of heater to defrost. Using a heater to speed up defrosting can cause personal injury and damage to the inner lining.

NOTICE

- · Do not lift unit by door handle.
- Never install or operate the unit behind closed doors.
 Be sure front grille is free of obstruction. Obstructing free airflow can cause the unit to malfunction and will void the warranty.
- Failure to clean the condenser every six months can cause the unit to malfunction. This could void the warranty.
- Do not Block any internal Fans.

Use only genuine U-Line replacement parts. Imitation parts can damage the unit, affect its operation or performance and may void the warranty.



Product Registration

You have received a carton containing your 3000 series unit with a package inside containing a Quick Start Guide and a Registration Card. Please complete and mail the Product Registration Card. You may also register the unit online at u-line.com. Go to the Customer Service tab and click on Product Registration. Once your unit is installed, keep the Quick Start Guide in a safe place for future reference.

Product Description

This installation guide covers the following models.

0	0
U-3018RGLOL-00	U-3024RGLS-00
U-3018RGLOL-01	U-3024RGLS-01
U-3018RGLS-00	U-3024RFOL-00
U-3018RGLS-01	U-3024RFOL-01
U-3018RGLS-13	U-3024RFS-00
U-3018RGLS-15	U-3024RFS-01
U-3018RFOL-00	U-3024WCOL-00
U-3018RFOL-01	U-3024WCOL-01
U-3018RFS-00	U-3024WCS-00
U-3018RFS-01	U-3024WCS-01
U-3018WCOL-00	U-3036RRGLOL-00
U-3018WCOL-01	U-3036RRGLS-00
U-3018WCS-00	U-3036RRGLS-13
U-3018WCS-01	U-3036BVWCOL-00
U-3018WCS-13	U-3036BVWCS-00
U-3018WCS-15	U-3036BVWCS-13
U-3024BEVOL-00	U-3036WCWCOL-00
U-3024BEVOL-01	U-3036WCWCS-00
U-3024BEVS-00	U-3036WCWCS-13
U-3024BEVS-01	U-3036RRS-00
U-3024RGLOL-00	U-3036RROL-00
U-3024RGLOL-01	

Inspection

Unwrap and inspect the unit on a flat, level surface capable of supporting its entire weight. If necessary, remove protective film from Stainless Steel models.

Exterior Cleaning

NOTICE

Stainless door panels, handles and frames can discolor when exposed to chlorine gas, pool chemicals, salt water or cleaners with bleach.

- Keep your Stainless unit looking new by cleaning with a good quality all-in-one stainless steel cleaner/polish on a monthly basis. For best results use Claire Stainless Steel Polish and Cleaner, which can be purchased from U-Line Corporation (Part numbers 173348). Frequent cleaning will remove surface contamination that could lead to rust. Some installations may require cleaning on a weekly basis.
- · Do not clean with steel wool or abrasive pads.
- Do not use cleaners that are not specifically intended for stainless steel on stainless surfaces (this includes glass, tile and counter cleaners).
- If any surface discolors or rust appears, clean it quickly with Bon-Ami or Barkeepers Friend Cleanser and a non-abrasive cloth. Always clean in the direction of the grain. Always finish this process with Claire Stainless Steel Polish and Cleaner or comparable product to prevent further problems.
- Glass surfaces may be cleaned with standard household window cleaners.



Rust that is allowed to linger can penetrate into the surface of the stainless steel and complete removal of the rust may not be possible.

Prepare Site

Your U-Line product has been designed exclusively for a built-in installation. When built-in, your unit does not require additional air space for top, sides, or rear. However, the front grille must NOT be obstructed.

The Modular 3000 Series units are engineered with a variety of adjustment features to help ensure a seamless installation. adjustable doors, leveling legs and grille will assist in fine tuning the installation.

All 3000 Series models fully integrate into overlay/face frame, inset or European/frameless cabinet styles and install seamlessly into standard 24" depth cabinet base.

NOTICE

- Unit can NOT be installed behind a closed cabinet door.
- U-Line products are designed and manufactured to be seamlessly installed in the specified cut-out openings shown, and variance to the floors or cabinetry must be accounted for in your installation.

Electrical Specifications



SHOCK HAZARD — Electrical Grounding Required.

- Never remove the round grounding prong from the plug and never use a two-prong grounding adapter.
- Never use an extension cord to connect power to the unit.

NOTICE

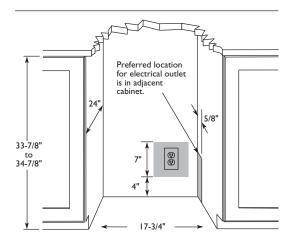
Electrical installation must observe all state and local codes. This unit requires connection to a grounded (three-prong), polarized receptacle that has been placed by a qualified electrician.

The unit requires a grounded and polarized 115 VAC, 60 Hz, 15A power supply (normal household current). An individual, properly grounded branch circuit or circuit breaker is recommended. GFCI (ground fault circuit interrupter) is usually not required for fixed location appliances and is not recommended for your unit because a GFCI could be prone to nuisance tripping. However, be sure to consult your local codes.

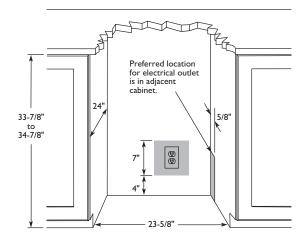
See Cut-Out Dimensions for recommended receptacle location.

Cut-Out Dimensions

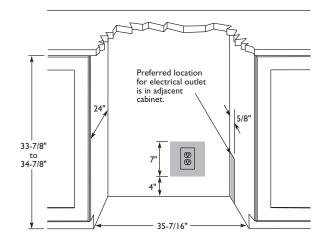
3018 Series



3024 Series



3036 Series

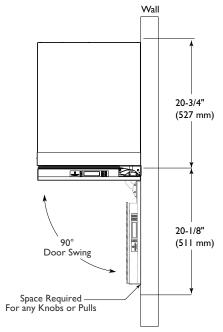


4 Product Dimensions

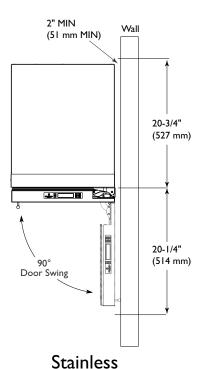
3018 **S**eries 3024 Series 3036 Series 22-11/16" 22-11/16" 22-11/16" 33-11/16" To 34-11/16" To 34-11/16" 3-5/8" To 4-5/8" 3-5/8" To 4-5/8" Glass & Solid Overlay Glass & Solid Overlay Glass & Solid Overlay 23-7/16" 23-7/16" 33-11/16" 33-11/16" To 34-11/16" To 34-11/16" 33-11/16" To 34-11/16" 3-5/8" To 4-5/8" Stainless Steel Glass Door Stainless Steel Glass Door Stainless Steel Overlay Door 33-11/16" To 34-11/16" 33-11/16" To 34-11/16" 33-11/16" To 34-11/16" 3-5/8" To 4-5/8" Stainless Steel Overlay Door Stainless Steel Overlay Door Stainless Steel Solid Door

Door Swing Dimensions

Units have a zero clearance when the door to open 90°. Overlay models will need additional space for any knobs or pulls installed on the overlay panel / frame. Stainless Steel models require 2" door clearance to accommodate the handle if installed next to a wall.



Overlay



Other Site Requirements

Side-By-Side Installation

Cut-out width for a side-by-side installation is the total of the widths listed under Cut-Out Dimensions in each unit's Installation Guide.

No trim kit is required. However, a 1/4-inch (6.4 mm) of space needs to be maintained between the units to ensure unobstructed door swing.

Units must operate from separate, properly grounded electrical receptacles placed according to each unit's electrical specifications requirements.

Power Supply

The unit requires a grounded and polarized 115 VAC, 60 Hz, 15A circuit (normal household current). See Electrical Specifications.

Environmental Requirements

The units are designed to operate between $50^{\circ}F$ ($10^{\circ}C$) and $100^{\circ}F$ ($37^{\circ}C$). High ambient temperatures ($100^{\circ}F$ [$37^{\circ}C$] or higher) may reduce the unit's ability to reach low temperatures and/or may also reduce the ice production rate for those models with icemakers.

For best performance, keep the unit out of direct sunlight and away from heat generating equipment.

In climates where high humidity and dew points are present, condensation may appear on outside surfaces. This is considered normal. The condensation will evaporate when the humidity drops.

3000 Series Doors

Door Alignment and Adjustment

Align and adjust the door if it is not level, or is not sealing properly. If the door is not sealed the unit may not cool properly, or excessive frost or condensation may form in the interior.

NOTICE

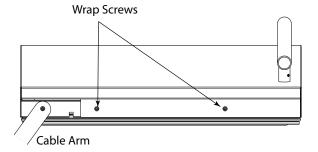
Properly aligned, the door's gasket should be firmly in contact with the cabinet all the way around the door (no gaps). Carefully examine the door's gasket to assure that it is firmly in contact with the cabinet. Also make sure the door gasket is not pinched on the hinge side of the door.

A CAUTION

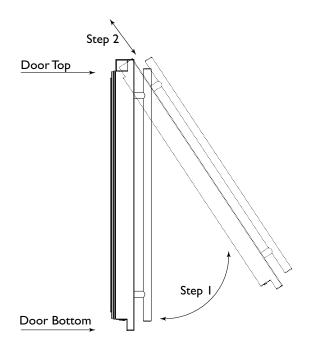
- Do not attempt to use the door to raise or pivot your unit. This would put excessive stress on the hinge system.
- Pay special attention to the Cable Arm. Make sure not to over extend or damage it during door alignment.

Stainless Models (Removing Wrap)

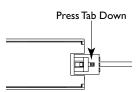
- 1. Open door completely.
- Remove the two wrap screws from the bottom of the stainless steel door wrap.



- 3. Gently pull bottom of wrap away from door.
- The Wrap hinges on top of the door. Carefully pull wrap away and then up. See below.



 If door being adjusted houses the display unit, remove cable from display by pressing in the release tab on the cable connector.



Alignment and Adjustment

- Using a T-25 Torx Bit, loosen each pair of Torx head screws on both the upper and lower hinge plate.
- 2. Square and align door as necessary.
- 3. Tighten Torx head screws on hinge.
- 4. If necessary re-connect display and re-install stainless steel wrap.



Overlay / Frame Overlay Panel

NOTICE

Due to differences in surrounding cabinetry the panel may not perfectly align with door. The procedure below is designed to provide a finished overlay panel that seamlessly integrates with surrounding cabinetry.

Panel Preparation

A full overlay door panel completely covers the door frame and provides a built-in appearance.

NOTICE

- The door panel must not weigh more than 20 lbs (9.1 kg).
- It is important to ensure that all drilled holes are drilled to the correct depth in order to avoid splits in the wood when hardware is installed.
- Appliance will need up to 34-1/2" (876 mm) to the under side of the counter to leave room for leveling adjustments.
- Cut the panels to the dimensions listed in the appropriate diagram below.
- 2. Optional: Stain or Finish panel to desired stain or color. Be sure to closely follow the instructions provided by the manufacturer.

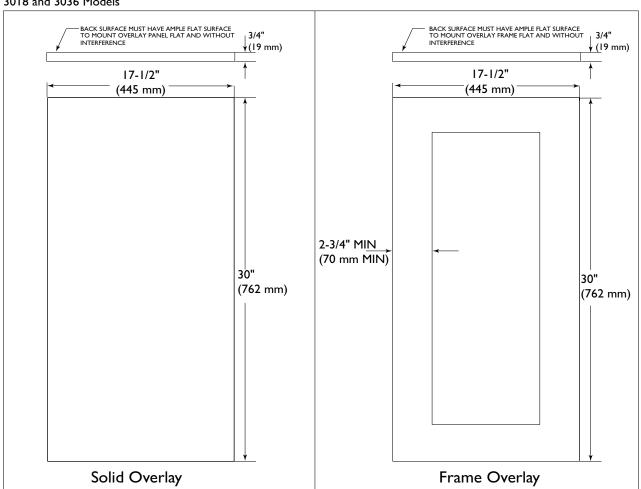
NOTICE

If finishing frame overlay, both sides of overlay must be finished in order to prevent warping.

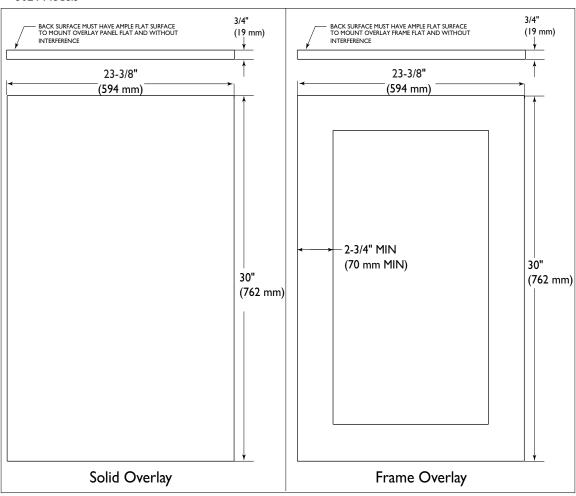
3. Optional: Install handles and hardware.

Overlay & Frame Overlay Panel Dimensions

3018 and 3036 Models

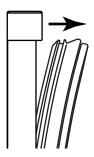


3024 Models



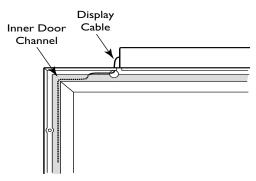
Panel Installation

- I. Fully open door.
- 2. Starting at corner, pull gasket away from door.
- 3. Continue to pull gasket free from gasket channel.
- 4. Upon removal, lay gasket down on a flat surface.

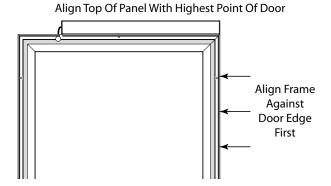


NOTICE

If working with the door that houses the display, make certain the display cable remains securely seated in the inner door channel, see below.

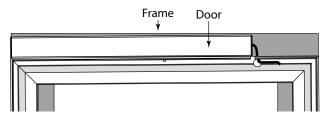


The frame should be aligned with the outside edge (opposite the hinge) and high enough to align with the highest point in the door.

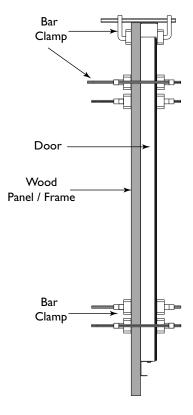


NOTICE

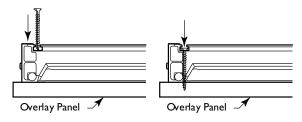
Due to differences in floor construction or surrounding cabinetry, the frame may not sit flush with the top of the door.



- Secure overlay to door using clamps. A robust tape may also be used. U-Line recommends the use of bar clamps to securely clamp the overlay to the door. If using tape, be certain the tape will not damage overlay finish upon removal.
- Using a 7/64" drill bit, drill 6 pilot holes into the wood panel 1/2" deep using the holes in the door frame as a guide.
- 8. Locate 6 of the #6x I-1/2" screws provided with your unit.
- Using a Phillips screwdriver, place one screw into each of the 6 pilot holes and screw down. Do not overtighten screws.



10. Be sure the screws force their way past the opening on the gasket channel and sit flush against the bottom of the channel.



11. Remove clamps from door.

NOTICE

If frame requires additional adjustment after removing clamps, slightly loosen each screw and adjust frame as necessary. Tighten screws upon completion.

- 12. Starting at the corners, re-install the gasket into the gasket channel in the frame. Make sure the gasket is fully seated. This may take some force.
- 13. If installing an additional overlay on a 36" unit, repeat steps I through 12 on the opposite door.

Overlay Grille

The 3000 series grille is fully adjustable and can be set to match your surrounding cabinetry dimensions. In addition to its adjustability, an overlay may also be installed to truly provide a seamless appearance.

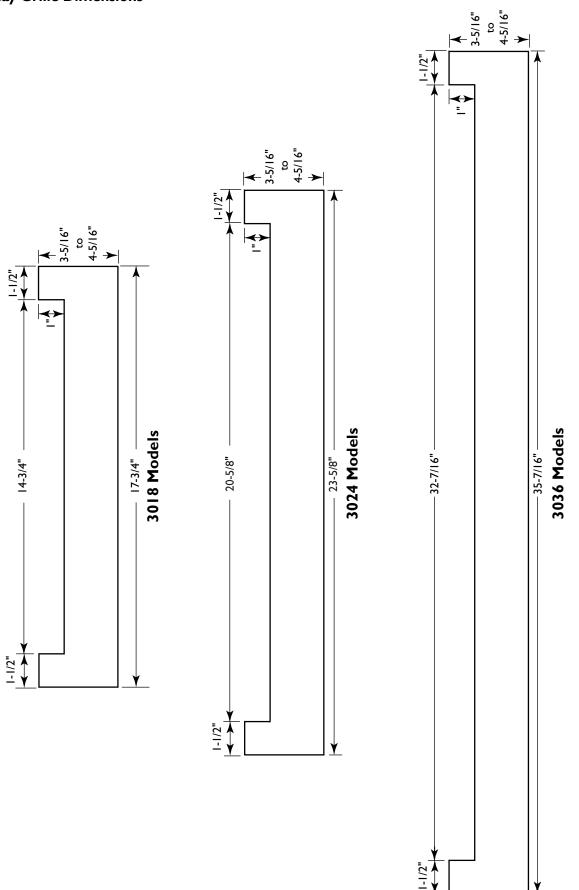
Preparing the Overlay

- Use the dimensions provided in the diagram on page 10 to cut and shape your grille overlay. Recommended overlay thickness is between 1/4" and 3/8". Dimension A will vary based on your toe kick height.
- Finish or stain your grille overlay to match your surrounding cabinetry. Both sides require finishing to prevent warping. Be certain to carefully follow the finish manufacturer's recommendations for application and cure times.
- Apply double sided tape to the backside of the overlay grill. Use the diagram below for reference. U-Line recommends 3MTM VHBTM tape, a high strength bonding tape.

Apply Tape To Shaded Area



- 4. Remove backing paper from double sided tape.
- 5. Carefully align grille over overlay and press into position.



Recommended Overlay Grille Thickness is 1/4" and May Not Exceed 3/8"

3000 Series Anti-Tip Bracket

Anti-Tip Brackets Installation

▲ CAUTION

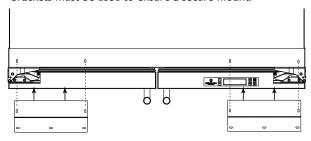
The anti-tip bracket must be installed to prevent the unit from tipping when doors are fully opened, or excess weight is placed on the front of the unit.

The anti-tip brackets have multiple mounting options. Mounting will depend on your particular cabinet configuration. Follow the instructions below to secure the anti-tip plate(s) to the unit. Locate your two anti-tip brackets and 10 $\#8 \times 5/8$ " screws included with your unit.

3036 Top Mount

Top mount configurations work well with fully secured wood or laminate countertops.

 Align the brackets on top of your unit as shown below. Both brackets must be used to ensure a secure mount.



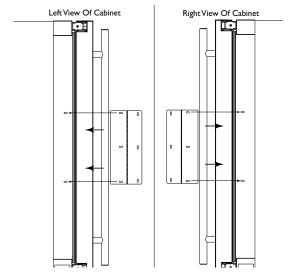
- 2. Using 4 of the supplied 10 #8 5/8" screws, install 2 screws into each plate using a #2 Phillips head screwdriver.
- Completely slide the unit into its position in the opening. Be certain unit height is properly adjusted. (See Leveling Information on page 13)
- 4. Open both doors completely. Make certain doors clear surrounding cabinetry.
- Using a 3/32" drill bit, drill 6 pilot holes, 3 for each bracket, 5/8" deep into bottom of counter top. Use the anti-tip brackets as a template.

The 6 remaining cabinet side mounting screws will be installed later in this guide.

3036 Side Mount

Side mount configurations work well if you have a granite countertop or do not wish to mount the brackets to the underside of your countertop.

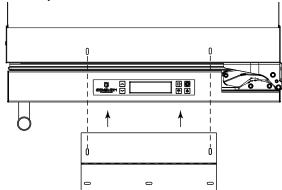
 Align each bracket to the side mounting holes on the hinge side of your model as shown below.



- 2. Using 4 of the supplied 10 #8 5/8" screws, install 2 screws into each anti-tip bracket, mounting the bracket to your unit.
- Completely slide the unit into its position in the opening. Be certain unit height is properly adjusted. (See Leveling Information on page 13)
- 4. Open both doors completely to gain access to the anti-tip brackets. Make certain doors clear surrounding cabinetry.
- Using a 3/32" drill bit, drill 6 pilot holes, 3 for each bracket, 5/8" deep into cabinetry frame using the anti-tip brackets as a template.

The 6 remaining cabinet side mounting screws will be installed later in this guide.

3018/3024 Top Mount

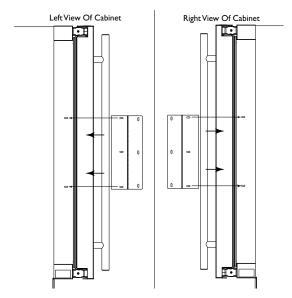


Top mount configurations work well with fully secured wood or laminate countertops.

- Align the bracket on top of your unit as shown above. The bracket must be used to ensure a secure mount.
- 2. Using 2 of the supplied 10 #8 5/8" screws, install screws into the plate using a #2 Phillips head screwdriver.
- Completely slide the unit into its position in the cabinet. Be certain unit height is properly adjusted. (See Leveling Information on page 13)
- Open door completely. Make certain door clears surrounding cabinetry.
- 5. Using a 3/32" drill bit, drill 3 pilot holes, 5/8" deep into bottom of counter top. Use the anti-tip bracket as a template.

The 3 remaining cabinet side mounting screws will be installed later in this guide.

3018/3024 Side Mount



Side mount configurations work well if you have a granite countertop or do not wish to mount the bracket to the underside of your countertop.

- 1. Align the bracket to the hinge side of the unit as shown above.
- 2. Using 2 of the supplied 10 #8 5/8" screws, install screws into the anti-tip bracket, mounting the bracket to your unit.
- Completely slide the unit into its position in the opening. Be certain unit height is properly adjusted. (See Leveling Information on page 13)
- Open door completely to gain access to the anti-tip bracket.
 Make certain door clears surrounding cabinetry.
- 5. Using a 3/32" drill bit, drill 3 pilot holes, 5/8" deep into cabinetry frame using the anti-tip bracket as a template.

The 3 remaining cabinet side mounting screws will be installed later in this guide.

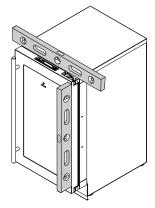
9 Level & Install

Leveling Information

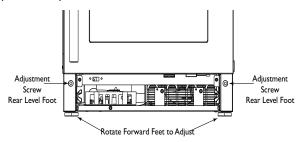
It is recommended that the unit is level once installed.

I. Use a level to check the levelness of the unit from front to back and from side to

side. Level should be placed along top edge and side edge as shown.



- 2. If the unit is not level, remove grille and adjust feet as necessary. Use included tool to adjust the height of the rear leveler feet. Turn screw clockwise to raise the rear foot, counter-clockwise to lower.
- Check the levelness after each adjustment and repeat the previous steps until the unit is level.



INSTALLATION TIP

If the room floor is higher than the floor in the cut-out opening, adjust the rear feet to achieve a total unit rear height of 1/8" less than the opening's rear height. Shorten the unit height in the front by adjusting the front feet. This allows the unit to be gently tipped into the opening. Readjust the front feet to level the unit after it is correctly positioned in the opening.

Installation

- I. Plug in the powercord.
- Gently push the unit into position. Be careful to not entangle the electrical cord.
- Re-check the leveling, from front to back and side to side. Make any necessary adjustments. The unit's top surface should be approximately 1/8" below the countertop.
- 4. Install the 6 cabinet mounting screws for the anti-tip bracket.
- Remove the tape from the glass shelves and wipe out the inside of the unit with a clean, water-dampened cloth.

Relocating the Shelves

The glass shelves can be moved to accommodate your bottles, cans and containers.

Glass Shelves

- Open door fully, grasp shelf firmly, lift front edge slightly, and pull straight out.
- · Remove shelf tabs and reposition as necessary.
- · Reinsert shelf into cabinet and set down onto shelf tabs.
- All four shelf tabs must be set to the same height to properly support the weight of the shelf.

Installation Troubleshooting



The door remains open unless it is pushed closed.

Solution

The hinges should be self-closing when the door is open approximately 8". If this is not the case, make sure nothing is caught in the hinge closing mechanism. Also, re-check leveling from front to back of the unit and readjust if necessary. Make sure that pivot plate is installed correctly.

Problem

The custom overlay door was designed to align with the rest of the cabinet doors, but the unit has crept forward.



Make sure that the electrical cord is not obstructing the installation.

INSTALLATION GUIDE



PRODUCT INFORMATION

Complete Installation Guides, Use and Care Guides, Specifications & Features and Benefits, CAD Drawings, Overlay Panel/Frame and Toe-Kick Specifications and Instructions, Compliance Documentation and Applicable Energy Guides are available for reference and download at u-line.com.

SERVICE INFORMATION

Please consult your Use and Care Guide for troubleshooting information. Answers to Customer Frequently Asked Questions are available at u-line.com under Customer Service. You may contact U-Line directly:

GENERAL INQUIRIES:

U-Line Corporation
P.O. Box 245040

Milwaukee, Wisconsin 53224-9540 U.S.A.
Phone I-414-354-0300
FAX I-414-354-7905
Email: sales@u-line.com
u-line.com

SERVICE ASSISTANCE:

Phone I-800-779-2547 FAX I-414-354-5696 Email: onlineservice@u-line.com u-lineservice.com

PARTS ASSISTANCE:

E-mail: onlineparts@u-line.com

BUILDING ON THREE GENERATIONS OF INNOVATION

For over five decades and through three generations, U-Line continues to be the leader in innovation, quality and performance in the premium built-in undercounter ice making, refrigeration and wine preservation market. U-Line has captivated those with an appreciation for the finer things with exceptional functionality, style, inspired innovation and attention to even the smallest details. We are known and respected for our unwavering dedication to product design, quality and selection.

In 1962, Henry Uihlein founded U-Line Corporation as an outgrowth of Ben-Hur Freezer Company and was the first to develop and patent an automatic stand-alone undercounter residential ice maker. His foresight and determination to develop new ideas and to succeed when there were no clear guidelines or solutions are evident today. The newest Uihlein generation continues to build upon the family's innovative legacy at the Milwaukee, Wisconsin based business by providing continuity and vision from which new designs and technology continue to be born.

Today the complete U-Line product collection includes Ice Makers, Ice Machines, Wine Captain[®] Models, Combo[®] Models, Refrigerator / Freezers, Refrigerators, Drawer Models and Beverage Centers. The U-Line brand offers products in the 1000 Series, 2000 Series and the Modular 3000 Series. The 1000 Series offers a more targeted priced product with appropriate features, while the 2000 Series offers upscale features, advanced technology and specialized product families. Our Modular 3000 Series provides sleek design and versatile temperature settings with our U-Select[®] control. U-Line's approach to its breadth of products, multiple price points and features allows a choice and product that will fit any lifestyle.

DESIGNED, ENGINEERED AND ASSEMBLED IN WISCONSIN, USA

