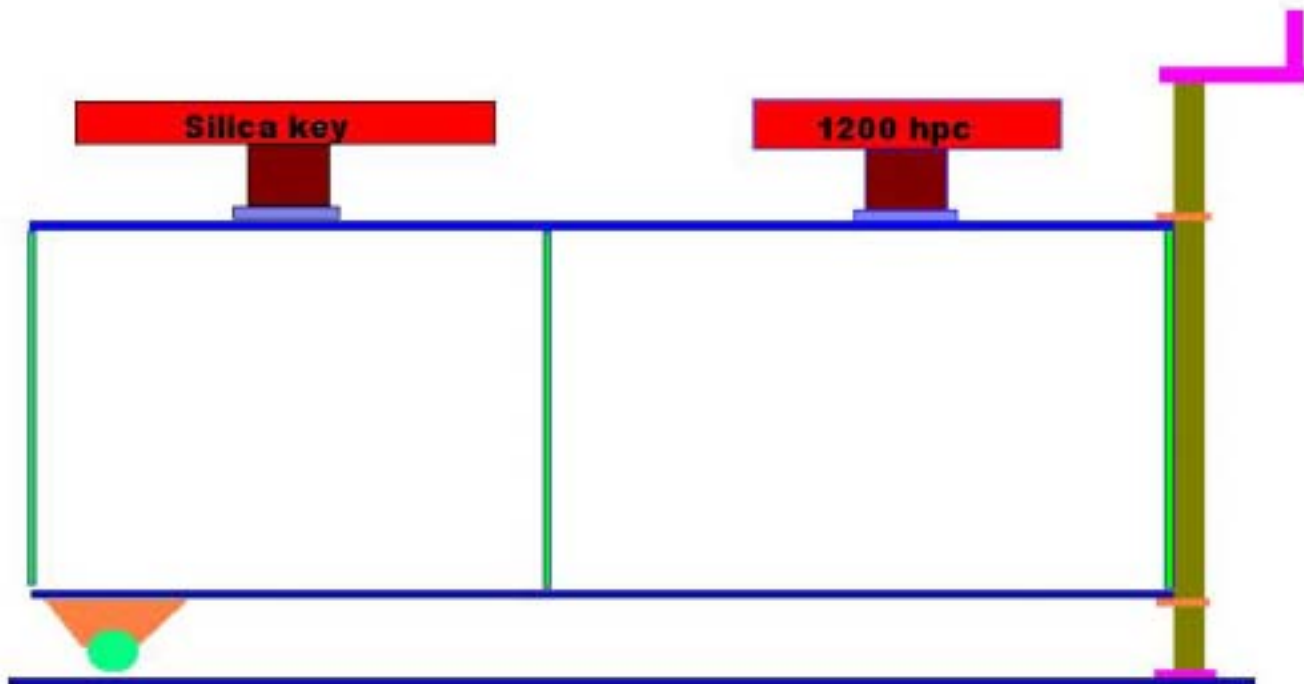


Swing-out Van Key Bench

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In this article we will describe how we made a swing-out bench with key machine mounts and key storage cabinets on a Ford Van F350 (one ton). To start with Bernard Dobesh had an idea that he brought to me to see if I could make it happen (he had been wanting to do this for several years) and after about 6 months of planning and discussing (and cussing) ☺ we drew up a rough plan of attack, the following is a rough drawing of the bench and parts list (this was changed as we progressed with the building)



Parts List & options:

- 2 key machine mounts – 1 each Silica / 1200 HPC
- Flat Steel (3 pc) $\frac{1}{4}$ x 48 x 48 (1)
 $\frac{1}{4}$ x 45 x 18 (2)
- Angle Iron (8 Pc) $\frac{1}{8}$ x $\frac{1}{2}$ x 15
- Angle Iron (4 pc) $\frac{1}{8}$ x $\frac{1}{2}$ x 15 (optional)
- Bearings 2 pc 4 bolt style
- Flanges 2 pipe Flanges 2"
- 2 pipe Flanges 1 $\frac{1}{4}$ "
- Pipe Nipples 2 pipe nipples 3"

Wheels (options 3 wheel low profile, 1 wheel 3" swivel, HD 2 $\frac{1}{2}$ swivel) load bearing about 450 lbs counting cabinets, key machines, steel, and keys

- Solid Shaft 1 $\frac{1}{4}$ " steel pivot
- Flat Iron to make top mount



48 x 48 sheet of 3/16 steel this is for the floorboard to allow the rollers to move over the corrugated flooring of the Van



After cutting the sheet with a cutting torch (plasma cutter would have been GREAT but I don't have one. 😊)



Floor area of the van the steel is to occupy we laid a piece of cardboard down as a pattern to make it as close a fit as we could (note neither of us claim to be metal workers -aka- Welders or Torch men)



Bernard laying out some of the parts



The top and bottom of the cabinet rack (the C clamps are holding the angle iron stop for the cabinets -so they don't slide out of the front)



Roller brackets square steel tubes (hard to cut with a hacksaw – we borrowed a chop saw and it didn't like the steel either). That saved a LOT of time the chop saw was at a different location and we had to run back and forth but it saved our arms like you wouldn't believe a torch was an option but I can't cut square very well.



Bottom side up for welding on the roller brackets (note one is a lot shorter and only has 1 wheel – due to fender-well) also the notch is for the shaft (measure 2 or 3 times before you cut makes less patching 😊)



Pivot Shaft 1.25" solid steel shaft with Heavy Duty bearings should last a lifetime note the steel floor



Bolting down the flooring



Modification #1 we added a Bulk key storage rack between the rollers for handy access to 4 boxes of key blanks
Added materials 10' of 1/8 x 3/4 x 3/4 angle iron and 24" of 1/8 x 1 1/2 x 2 angle iron



Attaching the upright angle iron for the top



Top welded on also added the machine mounts for the key machines



Dry fitting the key Cabinets



On its top for primer (Krylon white primer runs all over the place)



Shaft welded to the cart (learned a lot on fabricating this one it is hard to get it square and level if the area you are working on is not square or level {3 tries to get it right} and I got fair at patching holes note notches are for the door frame).



Bernard Checking out my handiwork.



Bernard checking out the height of the key machines



Key Machines mounted HPC 1200 on left, Silica Duplicator on right.



In the swung out position.



Key storage cabinets installed (they were a tight fit) until the lock-overs are installed he is using bungee cords to keep the drawers in place. Latch bracket not shown (let you figure that one out yourself).



A Happy Camper! Special Thanks to Bernard Dobesh for the use of his shop & Van to play with and to Chuck Smallcomb for his help and assistance with welding. ☺☺Make Money☺☺Be Happy☺☺