Chop Source Rotisserie Stand Assembly Instructions

The following instructions explain the process to assemble the Chop Source Rotisserie Stand.

If you have any questions regarding any part of the assembly process after reading these instructions, please email sales@chopsource.com or call/text (651) 300-9575.

See page 5 for the lengths of structural tubing required for the jig.

Chop Source Rotisserie Stand Shown with Feet (not included in rotisserie stand bundle). When adding a rotisserie stand to your jig, the feet are removed from the jig and installed onto the stand.

Chop Source Motorcycle Frame Jig with Rotisserie Stand (and frame installed)

Chop Source Bicycle Frame Jig with Rotisserie Stand

General Guidelines

Hand-tighten all fasteners during assembly (until the lock washers just start to compress) and torque fasteners when instructed.

Stamped washers typically have a sharp edge on one side and a smooth rounded edge on the other side. The sharp edge can scratch the powder coating on the plates. Install all washers with the smoother side touching the powder coating. The washer won't look as good, but scratched powder coating looks worse.

Step 1: Assemble Fixtures

Assemble each fixture as shown in the following photos to make sure you have received everything. If anything is missing, email sales@chopsource.com or call/text (651) 300-9575 and the missing parts will be sent to you right away. Please wait until all fixtures are assembled before contacting us, especially with international orders shipped in multiple boxes.

Base Clamps

Each base clamp uses two square plates and four 7/16″ x 7-1/2″ bolts (each with two washers, a lock washer, and a nut). For 2″x3″ tubing, use the outer most holes. The rotisserie stand comes with three base clamps.

Rotisserie Brackets:

Insert four 7/16″ x 1″ bolts with a washer (**no lock washer)** through the 7/16″ holes in one round rotisserie plate. Use a couple of drops of medium strength thread locking fluid (blue) on each bolt. Thread a 7/16″ coupling nut onto each bolt and **torque bolts to 20ft-lbs** while holding the coupling nut with a wrench. Attach two square plates to the round rotisserie plate using four 7/16″ x 4-1/2″ bolts (each with a lock washer and washer). These bolts will thread into the coupling nuts. If you are using 2″x2″ uprights, use the 3-1/2″ bolts provided instead (not shown in the image below). Keep these bolts loose for now. Repeat for the second rotisserie bracket.

Step 2: Cut Structural Tubing to Length

Several lengths of 2″x3″ and 2″x2″ tubing (1/8″ or 11ga wall) are required to complete the jig. This should be available locally at a metal supply store or welding/fabrication shop. Many times, the store/shop will cut them to size for a small fee per cut. The lengths provided below are a guideline that should work for many different styles of frames and can be adjusted to suit your needs.

Tubing Required for Part:	Size (all 1/8″ or 11ga wall)	Qty.	Length
Rotisserie Stand			
Main rails for stand*	2″x3″	2	84″
Uprights for stand	2″x3″	2	40″
Upright for rear rotisserie bracket (attaches to jig)	2″x3″	1	18″

*If you extend the main rails for the jig, you'll need to extend the rails for the stand by an equal amount. The main rails for the stand should be 12″ longer than the main rails of the jig.

Using 2"x2" tubing: *The rotisserie stand can be built with 2"x2" tubing. However, if you're using 2"x2" tubing for the main rails of the stand, the 4" spacers for the legs should be made from 1"x2" tubing (to allow room for the nut welded to the spacer; see photos in step 6).*

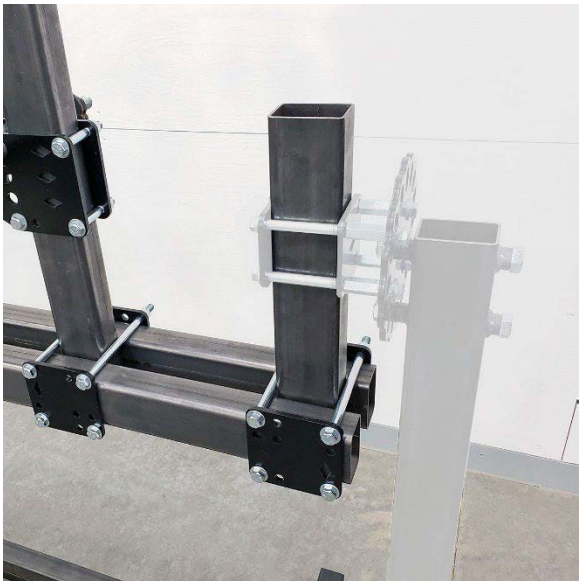
Metric Tubing: *The rotisserie stand can be built with 50x50mm tubing. However, if you're using 50x50mm tubing for the main rails of the stand, the 4" spacers the legs should be made from 25x50mm (or 20x50mm) tubing (to allow room for the nut welded to the spacer; see photos in step 6).*

Step 3: Weld Spacers into Stand Uprights

On both uprights for the stand (40″), drill a 7/8″ hole one inch from one end, and drill another 7/8″ hole four inches from the same end (a step drill bit or a good hole saw works well for the 7/8″ holes). The holes should be 3″ apart and centered width wise on the tube. Flip each tube over and repeat for the other side (not the opposite end). You are creating two 7/8″ through holes in each upright. Deburr the holes with a file or small grinding tool so the 4″ x 7/8″ O.D. spacers will fit through the holes. Weld the spacers into the uprights with 1/2″ of the spacer protruding from the inside of the upright. Two sets of 1/4″ plates stacked work well for this (second image). If you are using 2″x2″ uprights for the stand, leave 1″ of each spacer protruding from the inside of the upright.

Step 4: Attach Third Upright to Main Part of Frame Jig

Attach the upright for the rear rotisserie bracket (18″) to the main rails of the jig using one base clamp. Slide the base clamp over the end of the lower rails and insert the 18″ upright for the rear rotisserie bracket. The upright should extend below the main rails by 1-1/2″ and be spaced inward **1-1/4″** from the end of the main rails. Square the upright to the main rails. **Torque the nuts for the base clamp to 15 ft-lbs.**



Step 5: Attach Rotisserie Brackets

Attach the rotisserie bracket to the front upright on the jig using four 4-1/2″ bolts. If you have 2″x2″ uprights, use the 3-1/2″ bolts provided instead. Attach the bracket to the upright so the round plate is facing out. The center of the diamond on the square plate should be about 8″ from the top of the main rails. Repeat for the rear upright. **Torque the bolts to 15 ft-lbs.**

Step 6: Assemble Stand and Attach Feet

Assemble the stand in a similar fashion to assembling the main jig using two base clamps. The uprights should extend below the main rails by 1-1/2″ and be spaced inward about 1″ from the end of the main rails. An easy way to assemble these parts is to set the lower rails on two short scrap pieces of 2x4 lumber. Place the 2x4s about four feet apart and set the main rails on the 2x4s with about a 2″ gap between them. Slide a base clamp over each end of the main rails and insert the 40″ uprights. Tighten the nuts until the lock washers just start to compress. These uprights will be repositioned during Step 7.

Install the feet on the rails of the stand. Secure using two 1-1/2″x5″ rectangle plates (clamp bars) on top of the rails with 1/2″ x 1-3/4″ bolts (each with a lock washer and washer), and **torque the two bolts to 15 ft-lbs. Do not over-tighten or you will bend the clamp bars.**

Level the stand by adjusting the feet.

Step 7: Final Adjustment of Stand Uprights

The uprights should be spaced far enough apart so that the outside of the rotisserie brackets will just fit between the spacers welded into the uprights. Leave an extra 1/16″ for clearance. Measure the distance between the outside of the round rotisserie plates and adjust the uprights accordingly while also ensuring the uprights are square to the main rails of the stand. **Torque the base clamp nuts to 15 ft-lbs.**

Step 8: Lift Jig into Stand

Double check to ensure that all nuts on the base clamps (all five), and all bolts on the rotisserie brackets and feet are tight.

Insert two 5/8″ x 5″ bolts halfway into the upper spacers in each of the stand uprights. With the help of a friend or two, lift the main part of the jig into the stand and slide the bolts through the spacers and into the round rotisserie plate. The top bolt on each upright will go through the middle hole of the round rotisserie plate. Use two 5/8″ SAE washers and a 5/8″ nut to secure each 5/8″ bolt.

Some people have had success laying the jig on its side and attaching the stand. You will still want a friend to help lift it upright as the assembled jig weighs well over 200lbs.

Frequently Asked Questions:

Question: Do you have a list of the tubing required to complete the Rotisserie Stand?

Answer: See page 5 for the cut list.

Question: Where do I buy the 2″x3″ and 2x2″ tubing?

Answer: Structural tubing should be available locally at a metal supply store or welding/fabrication shop. Many times, the store/shop will cut them to length for a small fee. Google 'metal supply near me' or 'steel supply near me'.

Question: Can I use Metric tubing?

Answer: Yes, see page 10 for more details.

Question: How long should I make the main rails for the stand?

Answer: 12″ longer than the main rails of the frame jig.

Tips:

When drilling holes, use a center punch so your bit doesn't wander, then drill a small pilot hole. For thin metal, a step bit works well to enlarge the hole to the required size. Use cutting oil to keep the drill bit cool. A drill press makes the job easier.

Level the stand and jig before starting your project. Ensure all uprights are at 90 degrees to the main rails. Digital angle finders (available on our site) work well for this.

Keep fixtures somewhat loose when putting a frame into the jig. Before loosening the base clamp for the axle plate upright, put a C clamp or welding clamp on the upright directly above the base clamp plates to prevent the upright from dropping down.

If you need to raise or lower the rotisserie brackets on the uprights to balance the jig, rotate the jig in the stand 90 degrees first. The uprights holding the rotisserie bracket should now be horizontal and when you loosen the rotisserie brackets the jig won’t fall to the floor.