



Empire Series: Modifications



Like all Allied Moulded enclosures, Empire Series enclosures can be specially modified to meet your requirements. In addition to our typical modifications such as holes, cutouts, molded-in color matches and EMI/RFI shielding, the Empire Series offers a number of other options.

Mounting Strut

- Fiberglass mounting strut bonded to enclosure interior
- Allows for installation of depth-adjustable mounting panels
- Facilitates addition of side mounted panels

Rear Access Doors

- Allows both front and rear access to enclosure
- Enables use of, and access to, both sides of mounting panel
- Increases usable door and mounting panel space

Custom Sizes

- Hand lay-up manufacturing process allows for easy fabrication of larger custom sizes
- Unique capability to fabricate enclosure size exactly to space constraints

*We are pleased to quote your custom size requirements.
For a modification request form, see pages 78.*

A brief overview of our hand lay-up process follows.

Empire Series Hand Lay-Up Process



1. Fiberglass material is cut to size.



2. The outer surface of the enclosure is sprayed into the enclosure mold using a marine grade gelcoat.



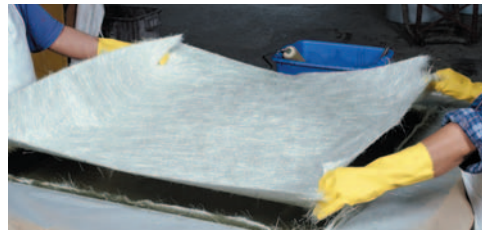
3. Enclosures are molded in industrial gray inside and out, but are also available in other color options.



4. Individual layers of fiberglass are laid up and then wetted out with a fire retardant polyester resin.



5. A roller is used to push out entrapped air and compress the laminate before the next layer is added.



6. Each layer of fiberglass overlaps the corners to form a consistent thickness of three sixteenth of an inch.



7. Once the resin cures and hardens, the parts are removed from the mold.



8. The door is installed to the enclosure base using a heavy duty, continuous stainless steel hinge.



9. A highly flexible gasket is attached to the flange, creating a tight seal when compressed.



10. An opening is cut into a door for an optional gasketed window. Holes and cutouts can be provided to customer specifications.