The C-24U Server Rack comes with five packing boxes for assembly. There are two boxes for the frame, two boxes for the side panels and doors, and one box for the top and bottom plates.
Step 1: Put one side frame onto the bottom plate and screw the side frame into the bottom plate with the Allen wrench. Do the same with the other side frame. (Total: 8 screws and nuts, 1 bottom plate, 2 side frame)

Step 2: Put the top plate onto the side frames and screw the top plate onto the side frame with the Allen wrench. (Total: 8 screws and nuts, 1 top plate)
The two cable slots on both the top plate and bottom plate can be covered if not in use with small screws and a screwdriver. (Total: 8 self tapping small screws, 4 cable slot covers)

Step 3: Install the casters onto the bottom plate with a screwdriver. Screw in the levelers onto the bottom plate. (Total: 16 self tapping screws, 4 casters, 4 levelers)
Step 4: Insert two cage nuts about one foot from the top of the rack and two cage nuts about one foot from the bottom of the rack into the square holes on each frame pole. Make sure the cage nuts are at the same position for each frame pole. (Total: 16 cage nuts)

Step 5: Insert two cage nuts into each horizontal rail two holes from the end of each side. Line up the horizontal rail with the cage nuts on the side frames, place it in the mounting slots, and screw the horizontal rail onto the side frame with the Allen wrench. Do the same with each horizontal rail. (Total: 16 cage nuts, 16 screws, 4 horizontal rails)
Step 6: Line up the mounting rack with the cage screws on the horizontal rail. Screw in the mounting rack and horizontal rail with the Allen wrench. Do the same with each mounting rack. The position of the mounting rail is adjustable. (Total: 16 screws, 4 mounting racks)

Step 7: Install the side panel stoppers on each frame pole with small screws and a screwdriver. (8 self tapping small screws, 4 side panel stoppers)
Step 8: Place the side panel onto the frame. (Total: 2 side panels)

Step 9: Insert door pins into the front and rear of the bottom plate. Place the front and rear doors onto the rack. (Total: 2 door pins, 1 front door, 1 rear door)