



Wallace Adjustable Gantry Cranes

Aluminum/Steel Thrifty Frame Assembly Instructions

Read, Understand, and Comply with all instructions supplied with this crane. Also, pay attention to the equipment used with this crane such as hoists, trolleys, power drives (if applicable), etc. Read, Understand, and Comply with the requirements of OSHA (Occupational Safety, and Health Administration) 1910.179

Parts List

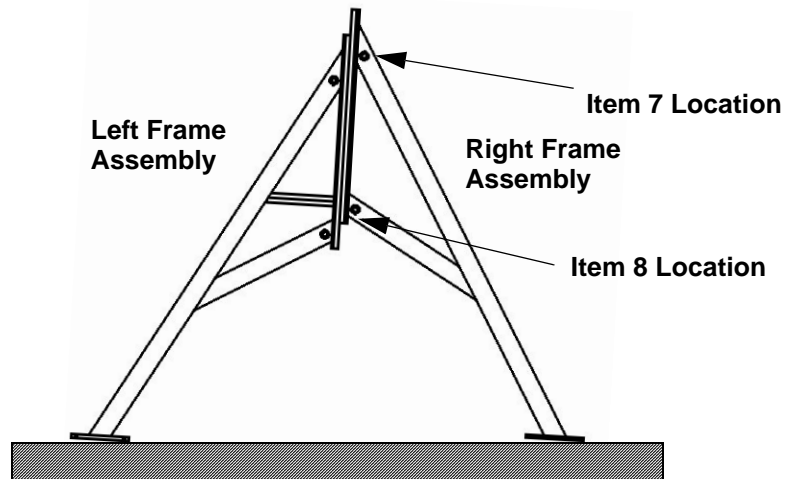
Item	Description
1	Post
2	Frame Assembly -- Left
3	Frame Assembly -- Right
4	Pin -- Height Adjustment
5	Spring -- Height Adjustment
6	Spring -- Pin
7	Upper Bolt Plate
8	Lower Bolt Plate
9	Stabilizer Plate
10	Cap Screw -- Caster
11	Lock Washer (Internal Tooth) Caster
12	Hex Nut -- Caster
13	Caster
14	Swivel Lock -- Caster
15	Cap Screw -- Lower Bolt Plate
16	Lock Washer -- Split
17	Hex Nut -- Lower Bolt Plate
18	Cap Screw -- Upper Bolt Plate
19	Lock Washer -- Split
20	Hex Nut -- Upper Bolt Plate
21	Cap Screw
22	Bevel Washer
23	Lock Washer
24	Hex Nut
25	I- Beam

Before you Begin

- Clear an open area at least as large as 2 times the leg length and wider than the beam.
- Get a crane or lifting device capable of lifting the entire weight of the completed crane. The lifting device must have sufficient height that the posts can be raised clear of the frames.

Step 1. Stand Frames Up for Pre-Assembly

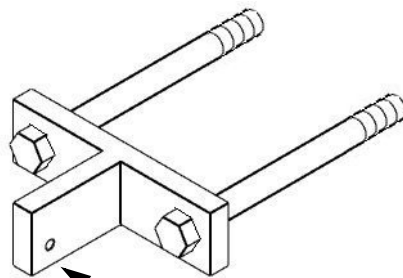
- Unpack the boxed frames and hardware. (NOTE: Only aluminum frames are boxed).
- Stand both frames together as indicated in the sketch below:



Step 2. Place Bolts in Plates

- Place 6" cap screws (Items 15 and 18) in the lower (Item 8) and upper bolt plate (Item 7).

NOTE: Make sure the hole in the Upper Bolt Plate is down, as shown below:

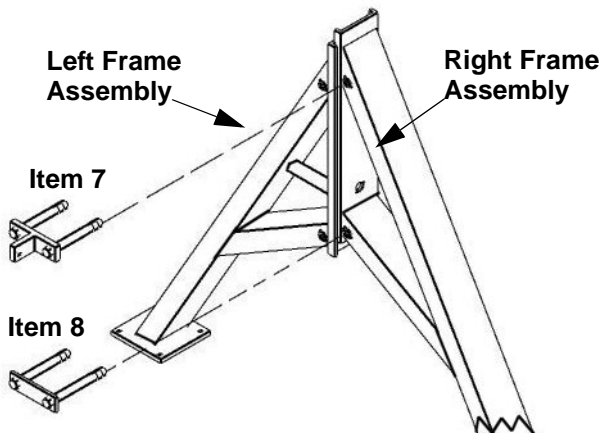


Note Hole Orientation



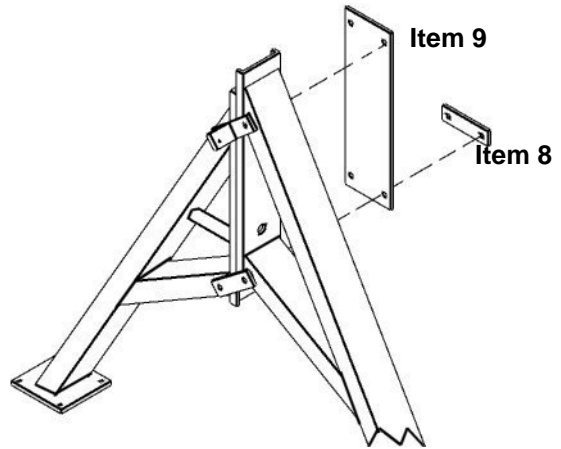
Step 3. Bolts and Plate into Frame

- A. With the Height Adjustment Pin on the Left Frame, insert the bolt plate/cap screw assemblies into the frame.



Step 4. Add Stabilizer Plate

- A. Place the Stabilizer Plate (Item 9) on the cap screws from the last step.



NOTE: Slide the plate onto a cap screw in a top hole and then rotate the plate until the other top hole engages.

- B. Make sure all four holes are on the cap screws.
C. Place the other Lower Bolt Plate (Item 8) at the base of the Stabilizer Plate.
D. Place internal tooth lockwashers on all cap screws.
E. Loosely place nuts on the cap screws.

Step 5. Orient the Frame

- A. Rotate the two frames so that the base plates are both flat on the floor.

NOTE: Try to assemble the frames on a level floor. Do not use a hammer. A small amount of hand pressure should be sufficient.

- B. The frame should not rock.
C. Tighten, but not fully, the nuts (Item 24)

Step 6. Check Post Fit

- A. With the Adjusting Pin locked out, insert a post (Item 1) into the assembled frame.
B. There should be approximately 1/16" (0.0625 inch) clearance around the post.
C. Adjust the frame as necessary to ensure the clearance of the post.
D. Tighten the bolts to the tension specified below.
E. Before you remove the post be sure the load pin can clear all holes in the post.
F. Continue to follow the instructions as detailed in Form 386.

NOTE: These instruction replace Step 3 on Form 386.

**ALL BOLTS SHOULD BE TIGHTENED TO 25 FOOT POUNDS
25 FOOT POUNDS = 300 INCH POUNDS**

