



Wallace Fixed Height Gantry Cranes

15 Ton Crane Assembly Instructions

For any additional information, Please call 800-553-5438.

CAUTIONS

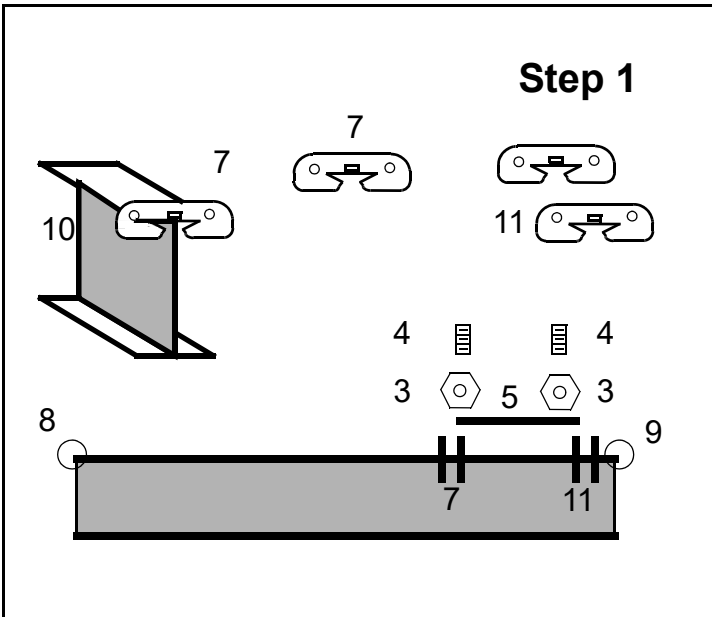
1. Read and understand instructions before using this gantry.
2. Inspect gantry thoroughly before using (see Form 379) for damaged or missing parts.
3. Do not lift more than rated capacity.
4. Center hoist over the load.
5. Do not allow load to swing or to roll against any supporting members.
6. When moving gantry under load, push on the gantry, not the load. Be certain that rolling surface is hard, level, clean and smooth.
7. Do not move gantry over 50 feet per minute (1/2 mph).
8. Not to be used for lifting or supporting humans.

Before You Begin

- Select a clear area to assemble the Crane. The work envelope should extend five feet beyond twice the leg length (when flat) and the length of the I-beam
- This clear area should be serviced by two overhead hoists or alternate as shown in Form 379. The cranes will raise the I-beam and leg assemblies when required.
- Select tools for fastening the nuts and bolts. You will also need: C-clamps to hold the trolley in place while the crane is assembled.
- Place parts on a flat surface, preferably on cardboard, to keep small parts clean and organized.

Before Placing the Gantry Under Load

- A. Make certain all hardware is securely attached and all locking pins are in place.
- B. Give the enclosed "Operating and Safety Instructions" to the person(s) with responsibility for the safe use of the Gantry.



Step 1. Attaching the I-Beam Fittings to the I-Beam

- A. For assembly, select a lifting device (for example, an overhead crane, boom crane) able to lift the entire weight of the gantry crane model being assembled.
 - B. Place **I-beam** (Item 10) upright on suitable supports so stenciling is right side up.
 - C. Slide the **brace leg brackets** (Item 7), then the **main leg brackets** (Item 11), on the I-beam (Item 10). Be sure all brackets are aligned as shown on the Parts Location diagram.
 - D. Attach the **spacer bar** (Item 5) to the **main leg bracket** (Item 11) and **brace leg bracket** (Item 7) as shown using the **set screws** (Item 4) and **nuts** (Item 3).
- NOTE:** Do not tighten set screws (Item 4) until after installing the main legs and brace legs as in Step 3.
- E. Position bracket assemblies on **I-Beam** (Item 8) for desired span.
 - F. Insert **key ring** (Item 9) without caution tag in holes at both ends of **I-Beam** (Item 10).

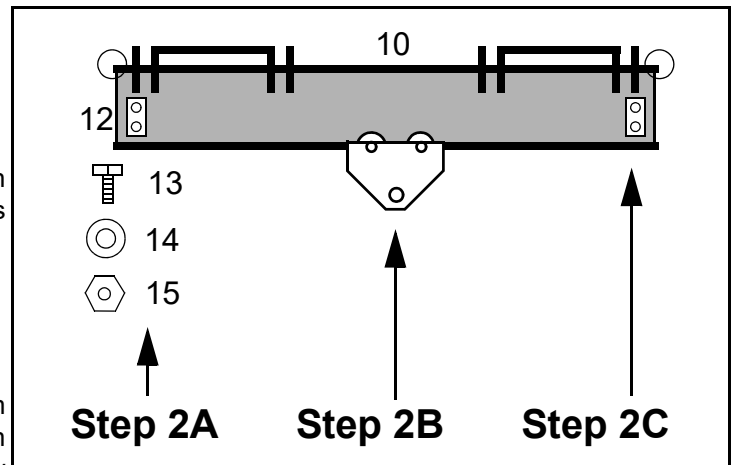
Step 2. Attaching the Trolley Stops and Trolley

- A. Install two **trolley stop angles** (12) at one end of **I-Beam** using **bolts** (13) **lock washers** (14) and **hex nuts** (15).
- B. Install trolley on end of **I-beam** (Item 10) without the **trolley stops** (Item 12).

CAUTION: Make sure trolley is adjusted for I-beam size with the manufacturer's recommendation on washer counts for each side.

- C. Install two **trolley stop angles** (Item 12) at the other end of the beam using the **bolts** (Item 13), **washers** (Item 14) and **nuts** (Item 15). For both trolley stops, tighten each nut and bolt to 200 ft./lb. of torque.

CAUTION: Secure trolley in the center of the I-Beam (Item 10), with suitable means, such as heavy clamps, when raising or lowering the assembly. Failure to do so may result in injury or death.



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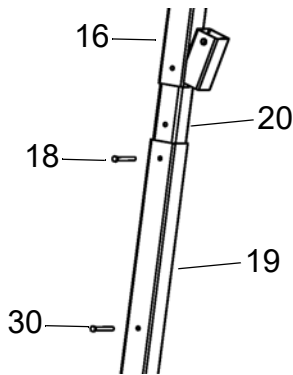
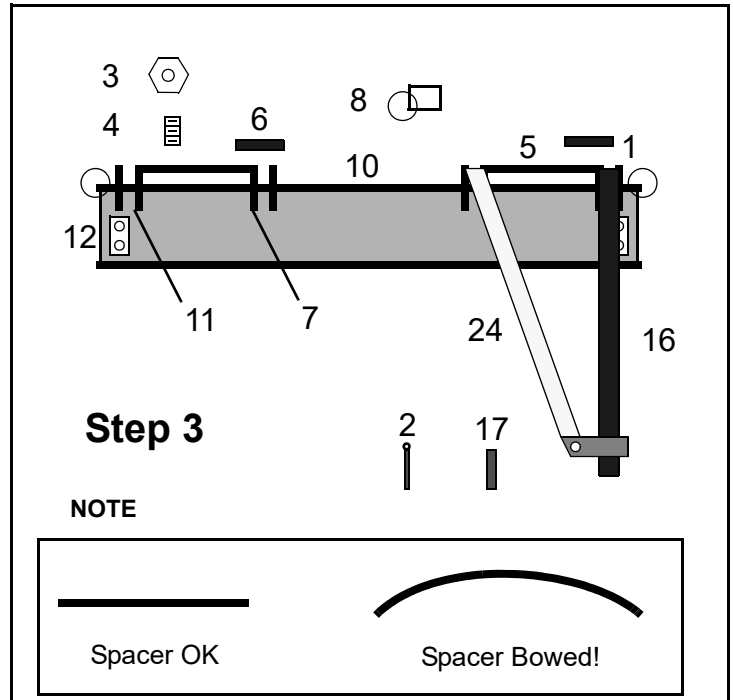
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For any additional information, Please call 1-800-553-5458.

Step 3. Attaching Main Legs and Brace Legs to I-beam

- Place upper end of **main leg** (Item 16) between **main leg brackets** (Item 11) as shown and install pin (Item 1) and key ring (Item 8) with **caution tag** to secure main leg. The **main leg** (Item 16) must be placed so that brace leg support (as indicated on the Parts Location diagram) is facing towards the brace leg brackets (Item 7).
- Place **brace leg** (Item 24) in the brace leg support on the main leg (Item 16) and fasten in place with the **pin** (Item 17) and **Cotter Pin** (Item 2) as shown. Brace leg must be oriented so that the hole in the upper end is parallel with I-beam (Item 10).
- The brace leg can now be installed between the **brace leg brackets** (Item 7). Install using the **pin** (Item 6) and **key ring** (Item 8) with caution tag.
- Tighten all set screws (Item 4) to securely lock brackets in place on the I-beam (Item 10).

NOTE: Be sure the Spacer is NOT bowed.



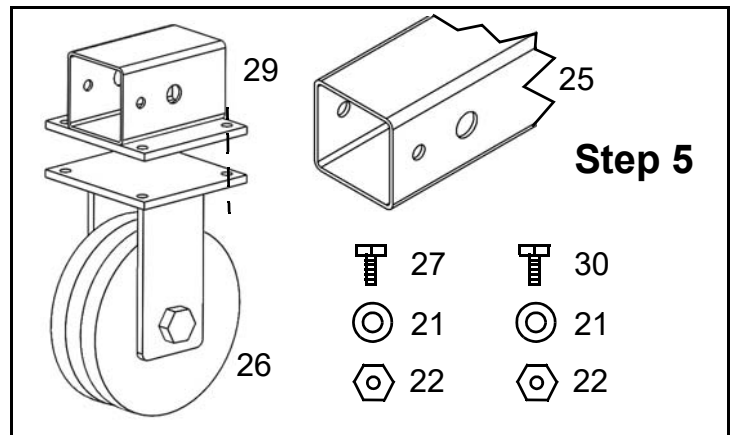
Step 4

Step 4. Attach Inner Support Tube

- Insert Splice Tubes (Item 20) into Upper Main leg (Item 16) and install retaining bolts (Item 18 and Item 30), nuts (22) and washers (21). Tighten nuts and bolts to 57 ft/lb. of torque.
- Attach Lower Leg (Item 19) over Splice Tube and install remaining bolts as in A above. Tighten nuts and bolts to 57 ft/lb. of torque.

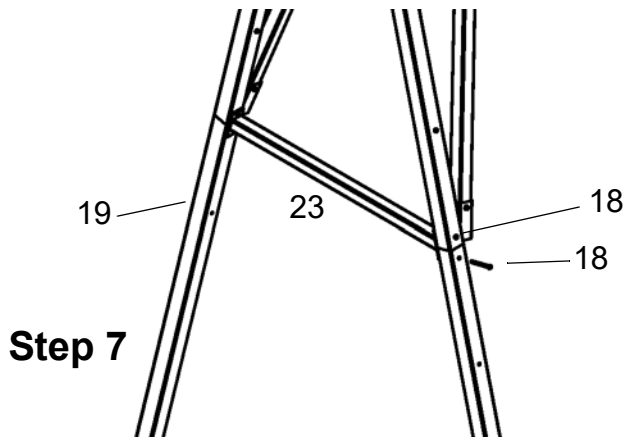
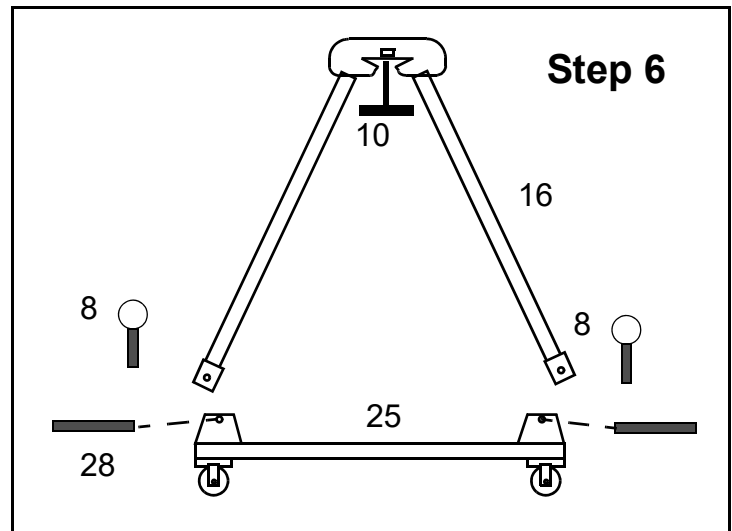
Step 5. Caster Frame Assembly

- Assemble **casters** (Item 26) to **caster plate** (Item 29) with **bolts** (Item 27), **lock washers** (Item 21) and nuts (Item 22). Tighten nuts and bolts to 57 ft/lb. of torque.
- Connect assemblies (Left) to **caster frame** (Item 25) using **bolt** (Item 30), **lock washer** (Item 21) and **nuts** (Item 22). Tighten nuts and bolts to 57 ft/lb. of torque.



Step 6. Assembly of Main Legs to Caster Frame

- A. Raise the **I-beam** (Item 8) with an approved lifting device until the distance between the bottom of the **main legs** (Item 16) is approximately the same as the length of the **caster frame tube** (Item 25).
- B. Attach **main legs** (Item 16) to **caster frame tube** (Item 25) using **pin** (Item 28). Secure pins with **key ring** (Item 8) with caution tag.
- C. Recheck to make certain all locking devices (nuts, cotter pins, locking rings, etc.) are in place and secured.
- D. Lower the Gantry to the floor



Step 7. Cross Brace Assembly

- A. Cross brace (Item 23) (Not applicable to models beginning 15T15, the shorter models) is placed between the main legs as shown left, using bolts (Item 18), and nuts and washers (Items 21 and 22).

NOTE: Bolts (Item 18) were installed in Steps 4-A and 4-B. These must be temporarily removed in order to install the cross brace. The splice tubes will hold the crane together during this operation.

Read Form 379F and Form 504 prior to use.

Completed Crane

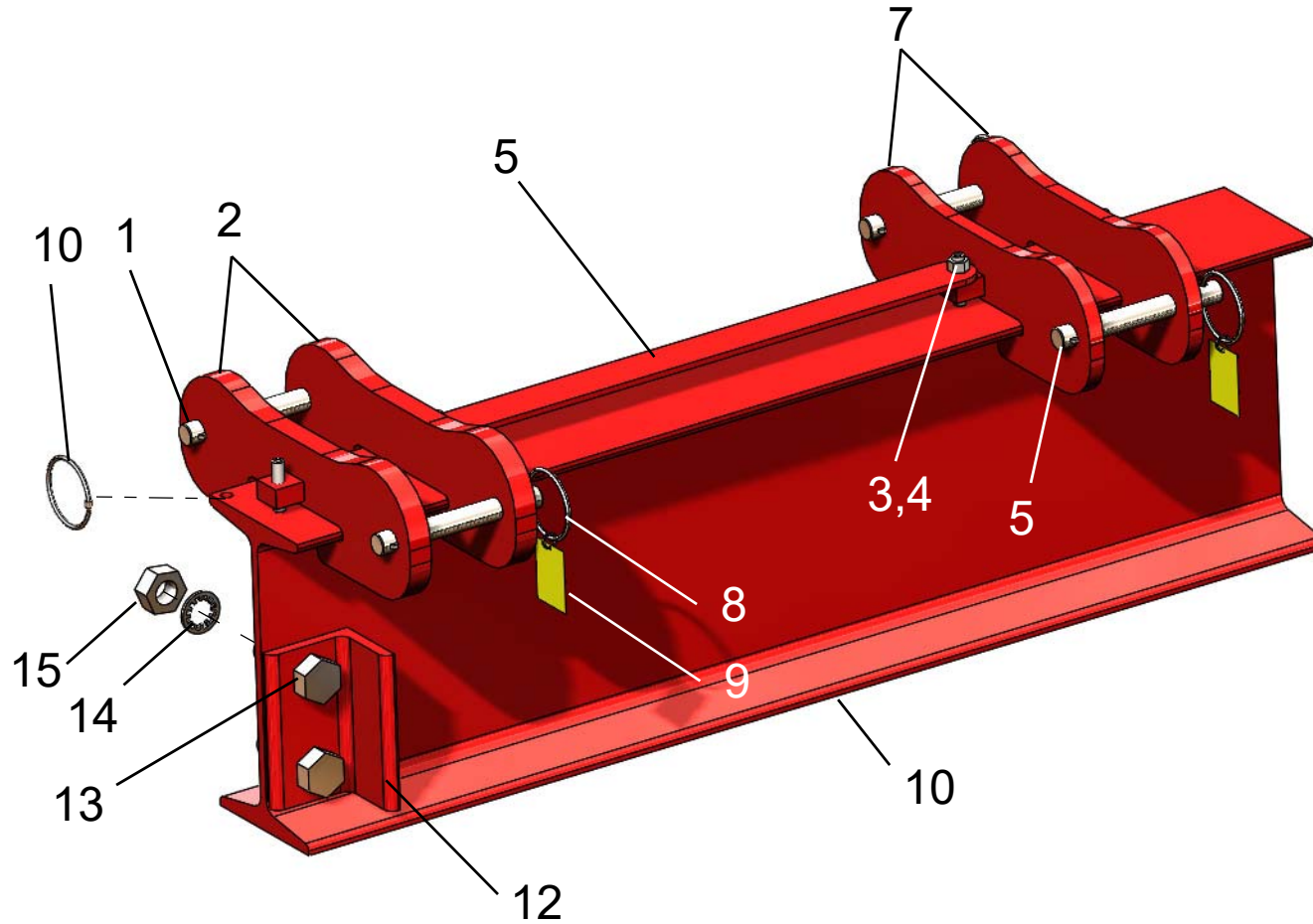


NOTE: Crane shown without track. This crane **must** be used with Wallace 15 Ton Track.



Wallace Cranes Parts Location

15 Ton Fixed Height

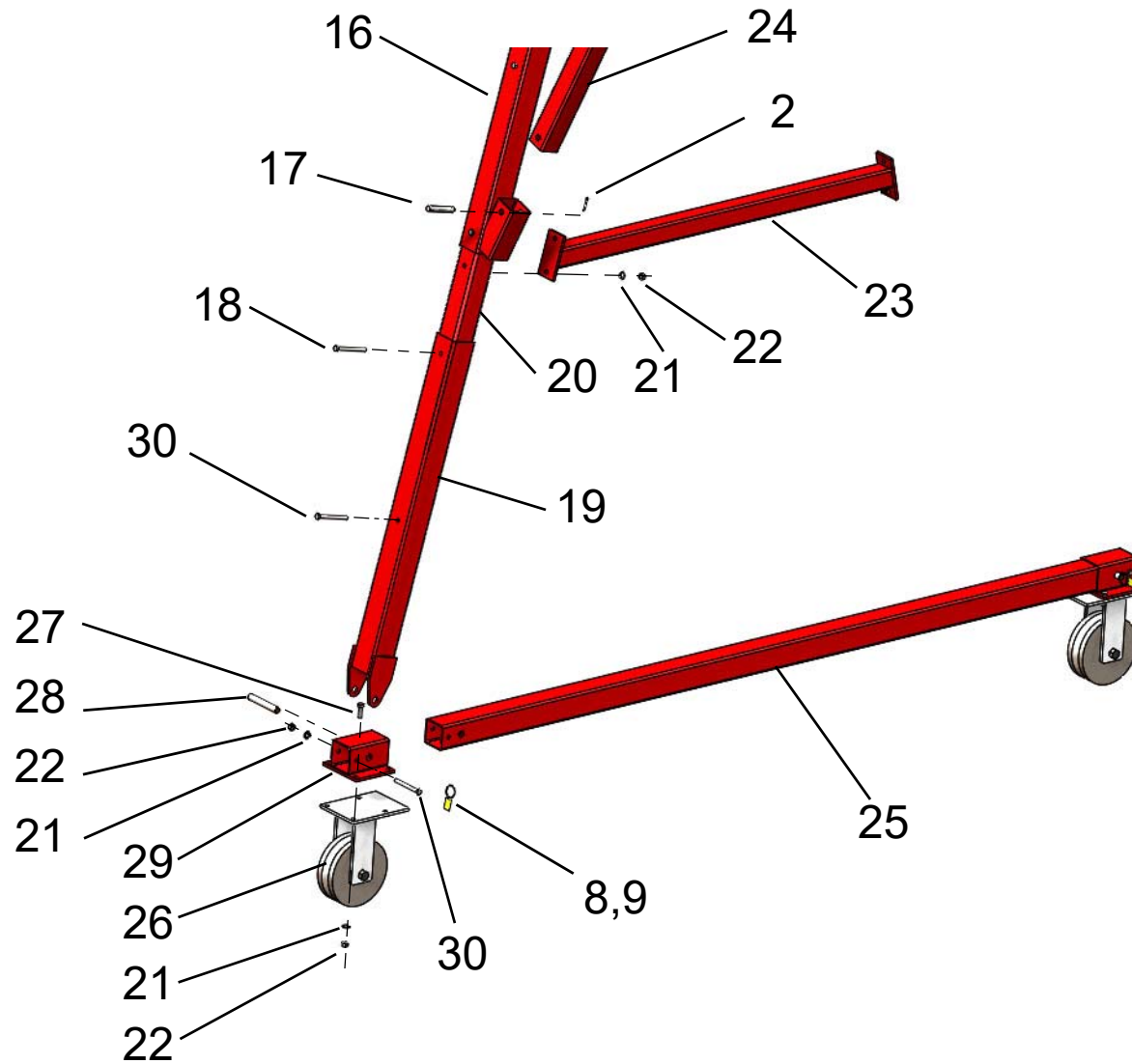


I-Beam
Assembly
Parts Location

Wallace Cranes
71 N Bacton Hill Rd.
Malvern, PA 19355



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Caster Frame
Assembly
Parts Location

NOTE:
The Brace (Part 23)
is not used on all
models of this crane.

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Wallace Crane Safety

Safe Use and Operation Instructions & Inspection Checklist

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

To ensure the safe operation of your Gantry, frequently inspect it for BENT, BROKEN, CORRODED, CRACKED, DAMAGED, or MISSING parts. DO NOT USE GANTRY if it does not meet inspection requirements. Please contact Wallace for replacements for any non-functional components.

DO NOT:

- Overload Gantry
- Lift loads greater than the rated capacity.
- Make any adjustments when the Gantry is under load. If necessary to adjust the Gantry, first lower and disconnect the load.
- Lift or support humans.
- Allow the load to swing or roll against any supporting members.
- Tow or Pull Gantry.

DO:

- Make certain the load is not attached to the floor.
- Remove any obstacles that may impede lifting.
- Make adjustments and/or repairs in an area where these operations will have the least impact on the normal operating environment.
- Secure the trolley and hoist to prevent movement during adjustment of the Gantry.
- Position the load at the center of the I-Beam when moving the Gantry under load.
- Use the Gantry at the lowest height possible.

Disclaimer

Please note these instructions were derived from company proprietary materials and (3) source documents including **ANSI B30.17**, **CMAA Specification #74, Revised 1987**, and **OSHA 1910.179**. As excerpts, the short form Wallace documents are intended to serve as general guidelines and are not to be considered the sole source when performing routine maintenance and inspection tasks.

Inspection Checklist on Other Side



Inspection Checklists

Excerpted from ANSI B30.17 –1980

Chapter 17-2 Inspection, Testing, and Maintenance.

Frequent Inspection

- a. Normal service, monthly.
- b. Heavy service, weekly to monthly.
- c. Severe service, daily to weekly.

Periodic Inspection

- a. Normal service, yearly – done in place.
- b. Heavy service, yearly – done in place unless disassembly is indicated (*if you completely disassemble, you must retest*) emphasis WCC.
- c. Severe Service, quarterly – done in place.
- d. Recommended interval as suggested by manufacturer.

Frequent Inspection Checklist

Any deficiencies as listed below shall be examined to determine if they constitute a hazard.

- All functional operating mechanisms for mis-adjustment interfering with proper operations.
- All limit switches should be checked without a load on the hook.
- Lines, tanks, valves, pumps and other parts of the pneumatic system for leakage.
- Hoists as specified in ANSI B30.16-1973

Periodic Inspection Checklist

The crane should be examined to determine if any of the following defects exists. DO NOT USE if any damage is found.

- Deformed, cracked, or corroded structural members
- Loose bolts or rivets.
- Cracked or worn sheaves and drums.
- Worn, cracked or distorted parts, such as pins, bearings, wheels, shafts, gears, rollers, locking and clamping devices, bumpers, switch baffles, interlock bolts, and trolley stops.
- Excessive wear on brake system parts.
- Excessive wear of chain drive sprockets and excessive chain stretch.





Wallace Fixed Height Gantry Cranes

Operating, Adjustment, and Inspection 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

Assembly and Safety Instructions

Inspect Crane Before Moving and/Or Each Day's Use

- Center Load under I-Beam before lifting
- When moving crane under load, position load at center of the I-Beam.
- DO NOT Lift or support humans.
- DO NOT allow load to swing or roll against any supporting members.
- DO NOT TOW or Pull Crane.
- DO NOT OVERLOAD CRANE.
 - Do not lift loads that are heavier than the rated capacity of the crane.
 - Make certain the load is free to be lifted.

Positioning of Crane to Handle Loads

DO

- Keep Load Hook of Hoist in the Shaded Safe Zone.

Allowable

The hinged suspension of the I-Beam allows 7.5° movement to either side to allow for slight off-center loading.

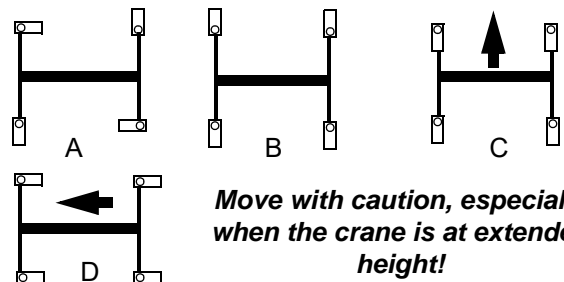
Under normal conditions (for example, the casters positioned at right angles to the I-Beam and the crane is free to roll), the crane will move to self-align over the load.

DO NOT!

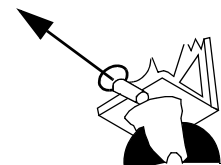
- The crane may "topple" if the hook is not kept in the shaded safe load zone and the crane is not free to align over the load.
- Lifting off centerline at one end of the crane is dangerous! Up to 90% of the load can be carried by ONE leg. Even though rated capacity is not exceeded, the result can be a 90% overload and the trolley is improperly loaded

Positioning of Casters

- To secure crane position while lifting load, lock diagonally opposite casters as shown.
- To utilize maximum crane strength, lock casters as shown.
- To move crane and/or load perpendicular to I-beam, lock casters as shown or allow casters to pivot freely.
- To move crane and/or load parallel to I-beam, lock casters as shown or allow casters to pivot freely.



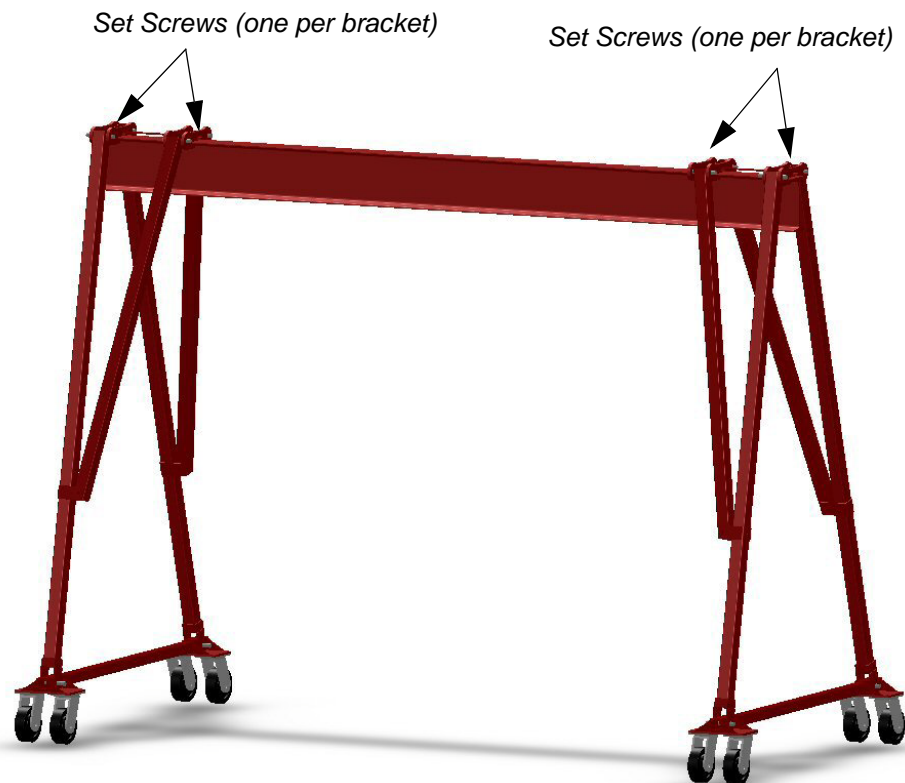
Pull out and turn pin as necessary to provide a locked or unlocked caster position, then release pin.



Wallace Fixed Height Gantry Cranes

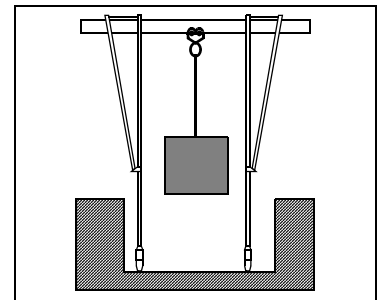
Cantilever Procedure

NOTE:
This feature not
available for 15 Ton
Cranes

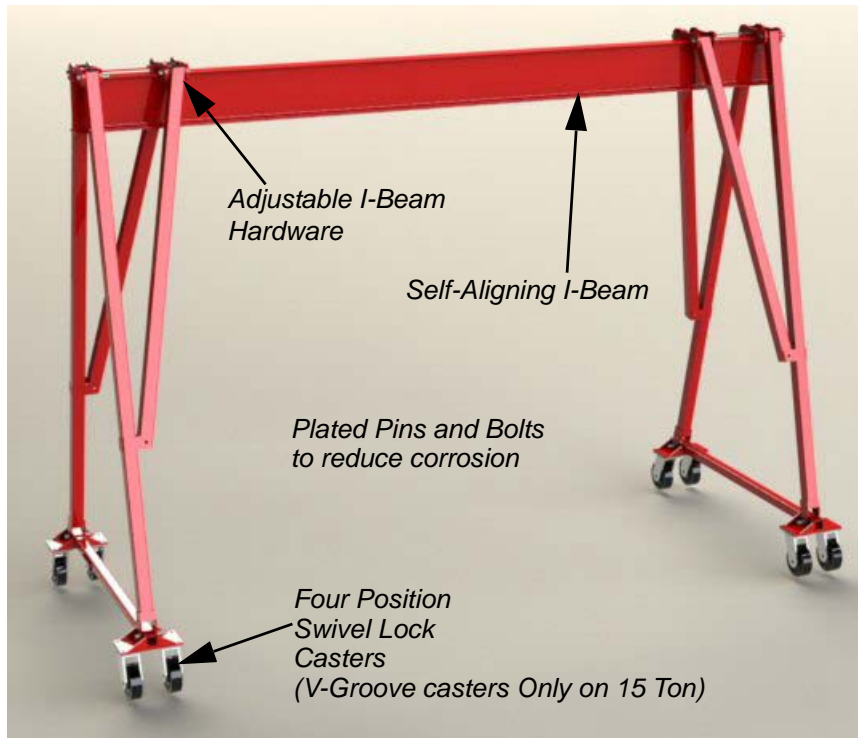


Cantilever Configuration/Adjustment of Distance Between Legs Along Length of I-Beam Procedure

1. Raise one end of I-beam until casters are off the floor.
2. Loosen set screws on top of I-beam hardware. (See above).
3. Slide I-beam hardware, with legs attached, on I-beam until the desired amount of cantilever or leg adjustment is achieved.
4. When adjusting for cantilever, **DO NOT OVER-ADJUST**. Adhere to distances specified in Form 123 (Cantilever Chart provided with the crane) for the amount of cantilever, load and counterweight required.
5. When desired amount of cantilever or leg adjustment is achieved, securely tighten set screws to prevent movement.
6. Repeat above if leg adjustment on opposite end is required.



Wallace Cranes, Built-in Safety

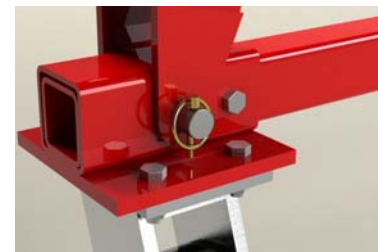


Wallace Fixed Height Visual Check Points

To ensure the safe operation of your crane, inspect it for bent, broken, worn, corroded, cracked, or missing parts. A series of vital checkpoints are described and shown below. Check these areas closely to ensure that all pins and fastening hardware are in place and securely attached. Caution Tags are attached to the Locking Rings and Locking Pins in these critical areas to aid in your inspection. **DO NOT USE** the crane if it does not meet these and the relevant ANSI B30.17 inspection requirements.



1. Brace and main legs are attached to the pin assemblies and secured with locking rings. Locking rings at each end of the I-Beam should be in place and secured to ensure the I-Beam Hardware never slides beyond end of I-Beam.



2. Lower main legs are attached to the caster frame casting with pins, secured with a Klik pin. Inspect casters and wheels for damage, such as cracks, bent king pins, and freedom of movement. Replace any damaged casters immediately.

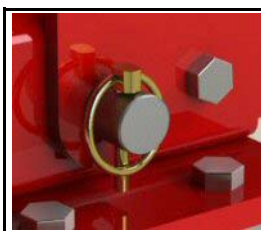
Read, Understand, and Comply with the instructions on the Crane and:

- A. Rated load clearly stenciled on opposite sides of I-beam.
- B. Rated load clearly stenciled on Hoist and Trolley.
- C. Form 379F (This Form) attached in convenient location by user.
- D. Caution tag attached to locking pins.

CAUTION AREAS

Make certain that all **CAUTION** labels are in place and legible. Replacements for damaged or missing labels upon request.

Inspect that rated capacity is plainly marked on each side of I-beam. Each hoisting unit shall have its rated load clearly marked and shall be legible from ground or floor.



Klik pins must be closed.

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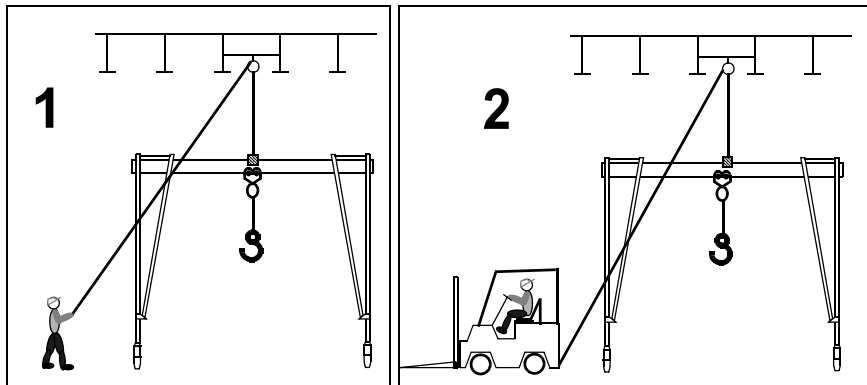
Wallace Cranes, Built-in Safety

General Safety Instructions for Crane Adjustments

- **ADJUSTMENTS** and/or repairs should be made in an area where they will have the least interference with ongoing operations.
- **DO NOT** make adjustments when the crane is under load. If crane is in operation, lower and disconnect the load before making any adjustments.
- **SECURE TROLLEY AND HOIST** to prevent movement during adjustment of crane.

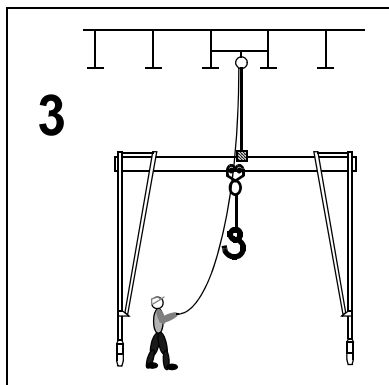
Methods of Supporting Crane for Assembly

DO NOT ASSEMBLE OR DISASSEMBLE OR MAKE ANY ADJUSTMENTS TO CRANE
UNTIL the unit is supported by one of the five methods illustrated below.

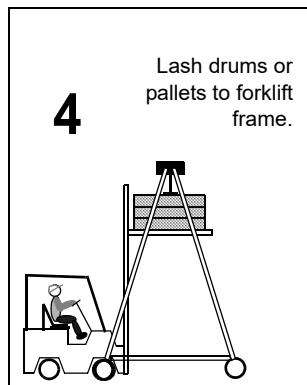


1 Use a Block and Tackle with cable winch with lifting bracket or beam clamp

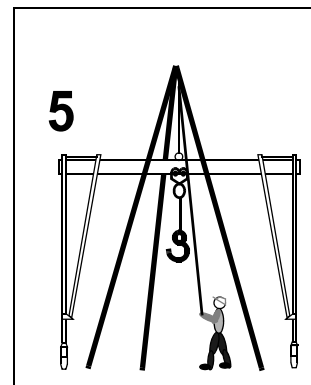
2 Use a block and tackle with lifting bracket or beam clamp with a suitable truck.



3 Use a hand or electric hoist with a lifting bracket or beam clamp.



4 Use a forklift truck.



5 Use a tripod and hoist with a lifting bracket or beam clamp.

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