



Wallace Fixed Height Gantry Cranes

15 Ton Crane Assembly Instructions

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

CAUTIONS

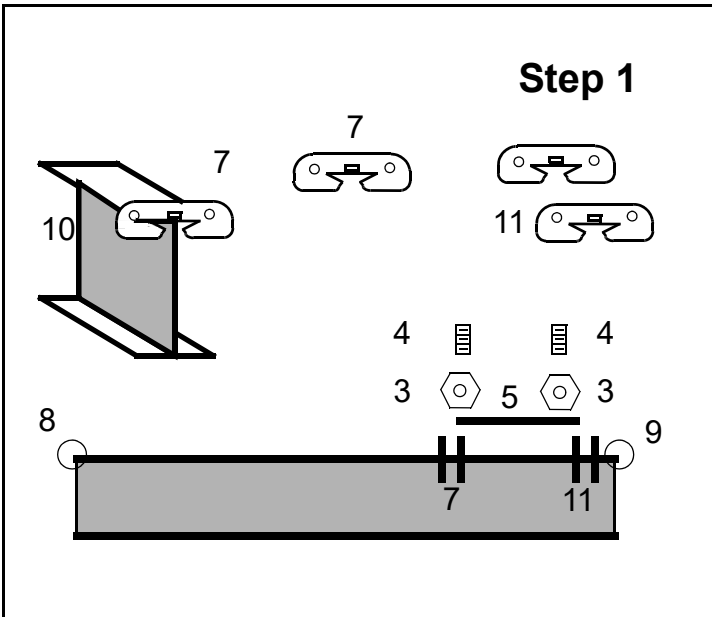
1. Read and understand instructions before using this gantry.
2. Inspect gantry thoroughly before using (see Form 379) for damaged or missing parts.
3. Do not lift more than rated capacity.
4. Center hoist over the load.
5. Do not allow load to swing or to roll against any supporting members.
6. When 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).

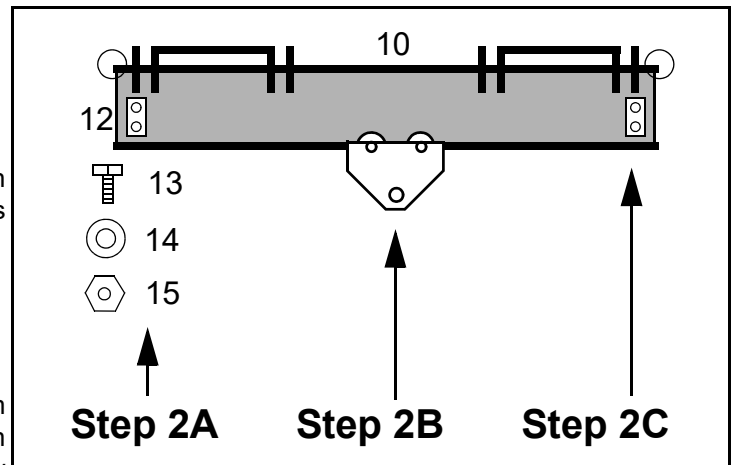
Step 2. Attaching the Trolley Stops and Trolley

- 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.



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



www.wallacecranes.com
800-553-5438

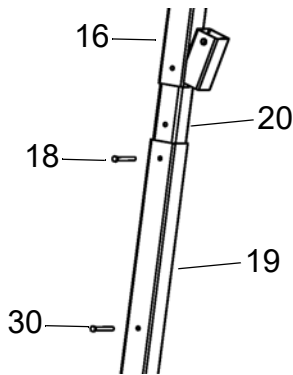
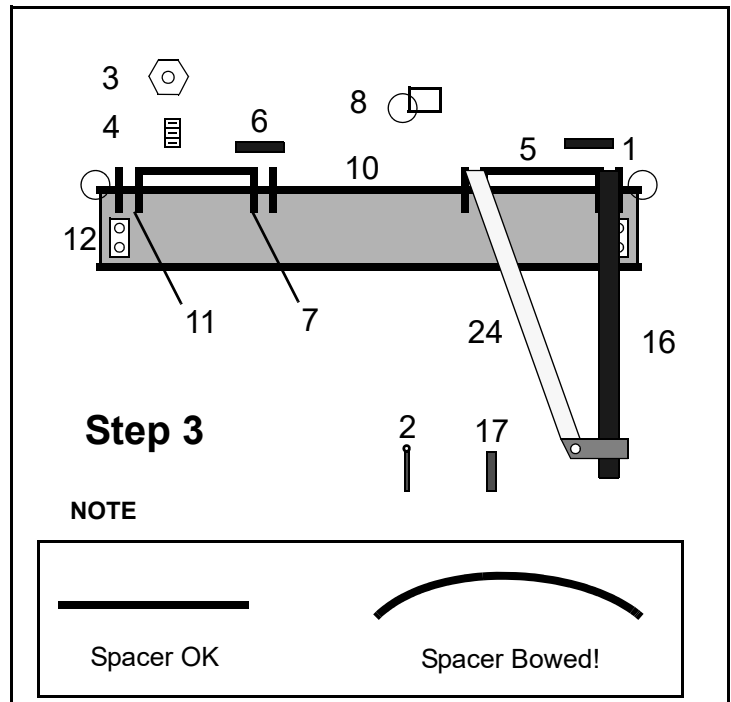
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For any additional information, Please call 1-800-553-5458.

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.



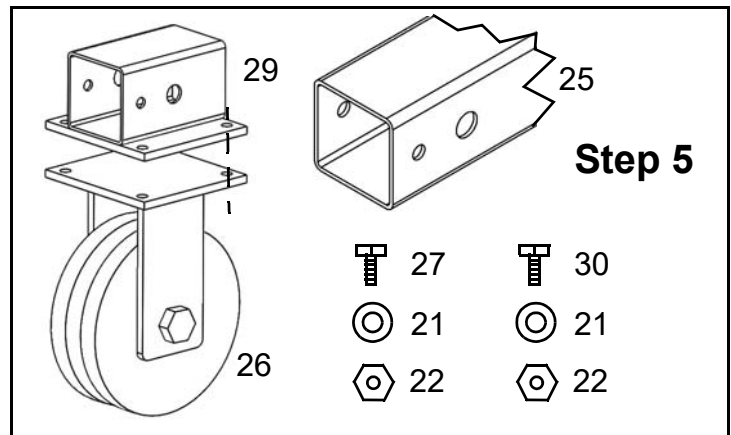
Step 4

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.

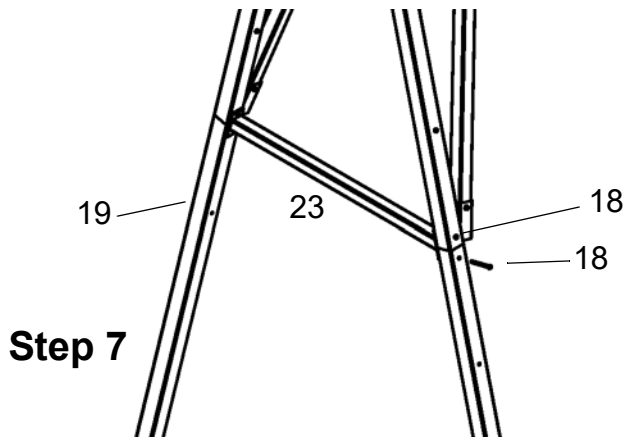
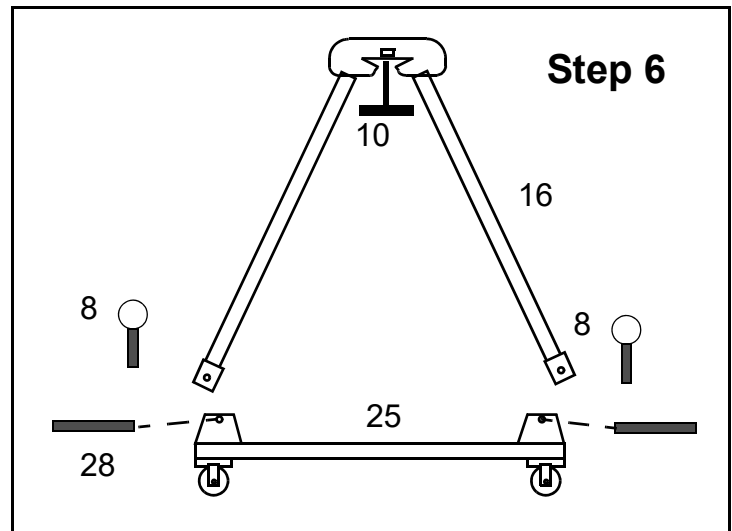
Step 5. Caster Frame Assembly

- 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

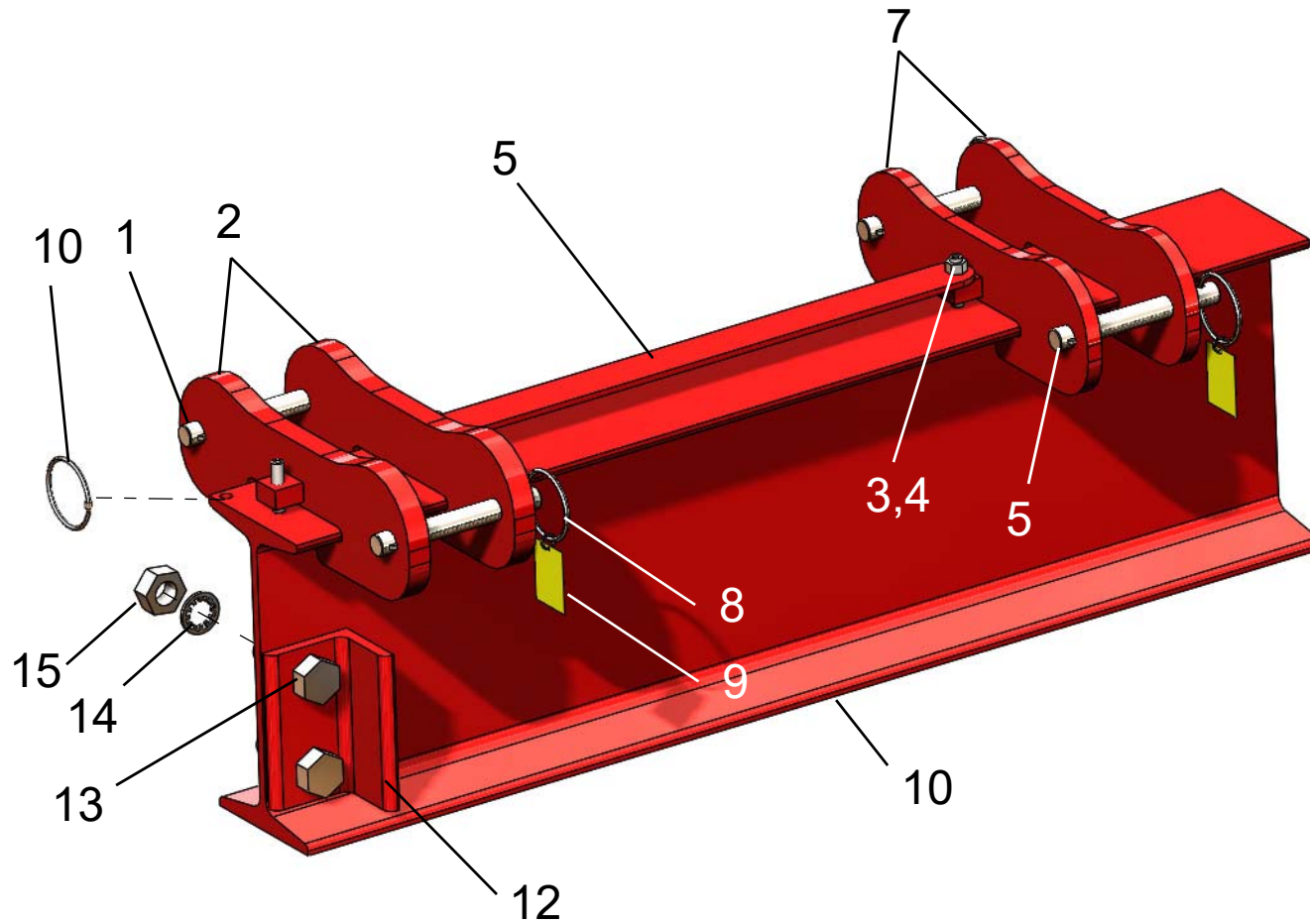


NOTE: Crane shown without track. This crane **must** be used with Wallace 15 Ton Track.



Wallace Cranes Parts Location

15 Ton Fixed Height

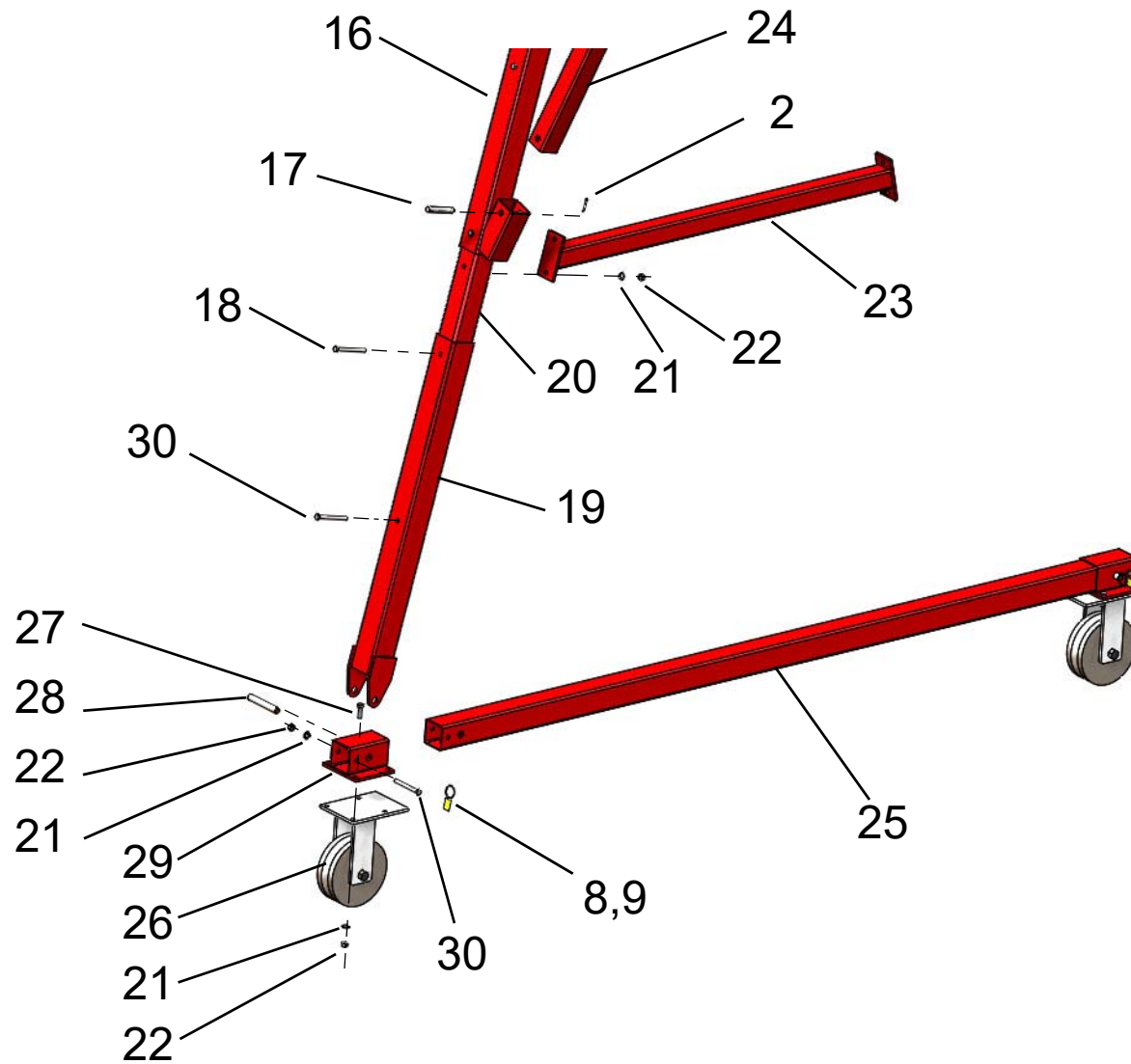


I-Beam
Assembly
Parts Location

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



www.wallacecranes.com
800-553-5438
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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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