



# 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

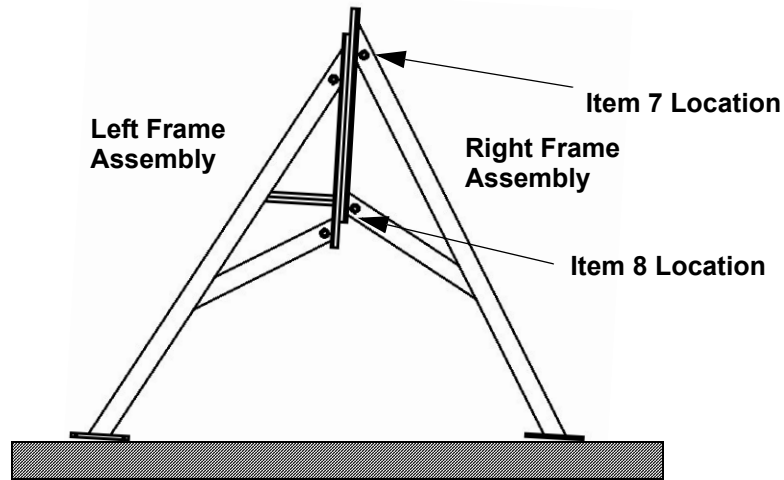
Item	Description
1	Post
2	Frame Assembly -- Left
3	Frame Assembly -- Right
4	Pin -- Height Adjustment
5	Spring -- Height Adjustment
6	Spring -- Pin
7	Upper Bolt Plate
8	Lower Bolt Plate
9	Stabilizer Plate
10	Cap Screw -- Caster
11	Lock Washer (Internal Tooth) Caster
12	Hex Nut -- Caster
13	Caster
14	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

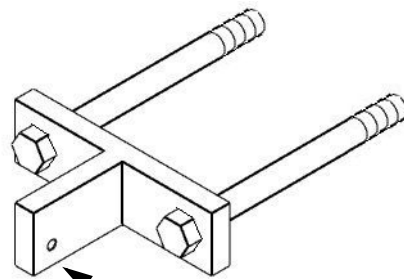
- Unpack the boxed frames and hardware.
- Stand both frames together as indicated in the sketch below:



#### Step 2. Place Bolts in Plates

- Place 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:**

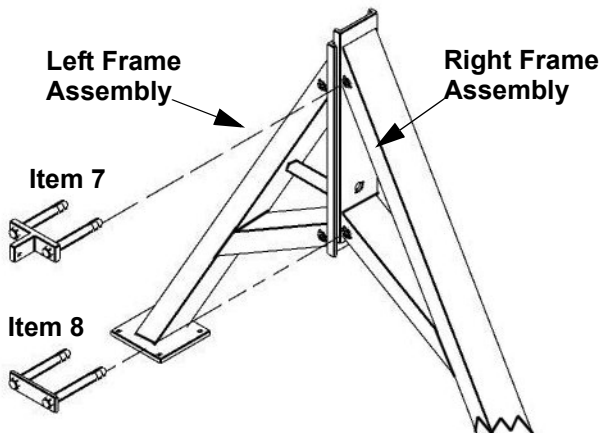


Note Hole Orientation



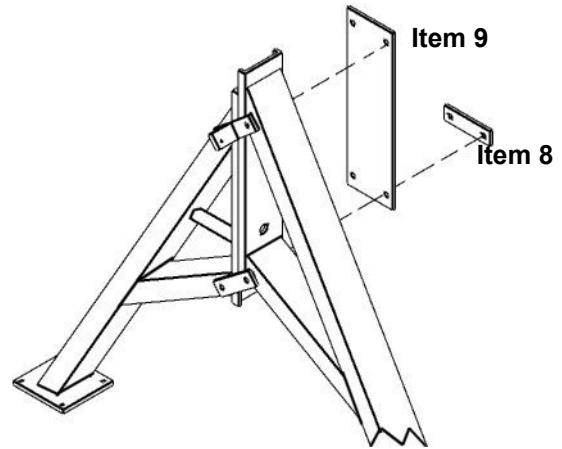
### Step 3. Bolts and Plate into Frame

- 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**





# Wallace Thrifty Adjustable Gantry Cranes

## Assembly Instructions

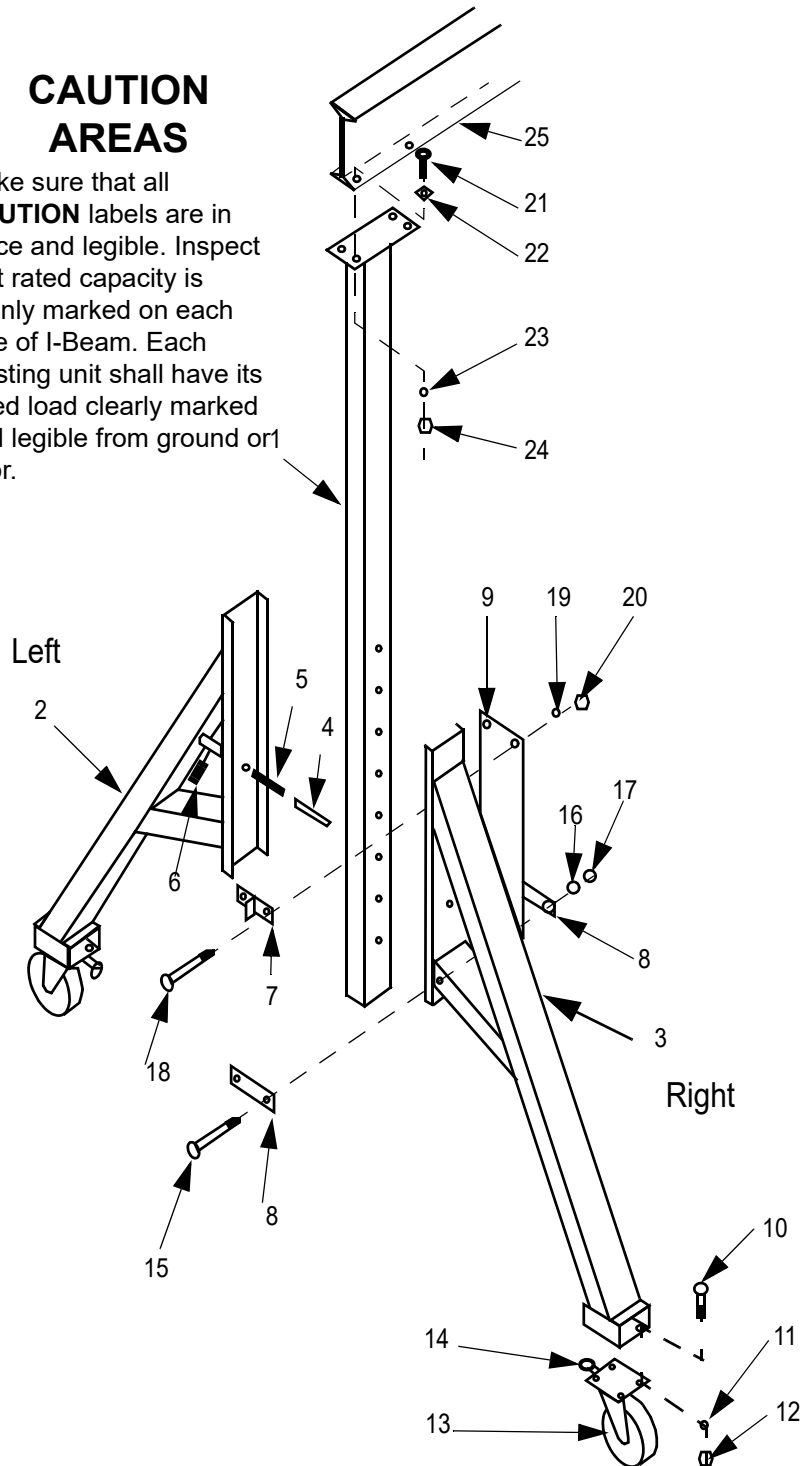
Read, Understand, and Comply with all instructions supplied with this crane. Also, pay attention to the equipment used with this crane such as hoists, trolleys, power drives (if applicable), etc. Read, Understand, and Comply with the requirements of OSHA (Occupational Safety, and Health Administration)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

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11	Lock Washer (Internal Tooth) Caster
12	Hex Nut -- Caster
13	Caster
14	Caster Swivel Lock -- (attached)
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

### CAUTION AREAS

Make sure that all **CAUTION** labels are in place and legible. Inspect that rated capacity is plainly marked on each side of I-Beam. Each hoisting unit shall have its rated load clearly marked and legible from ground or floor.



### Before you Begin

- Clear an open area at least as large as 2 X the leg length and wider than the beam.
- Get a crane or lifting device capable of lifting the entire weight of the completed crane.
- Assemble a work crew of no less than three. One will operate the lifting crane and the others perform the assembly. You may need more to lift the higher capacity legs.

See Safe Use Instruction Form 1004

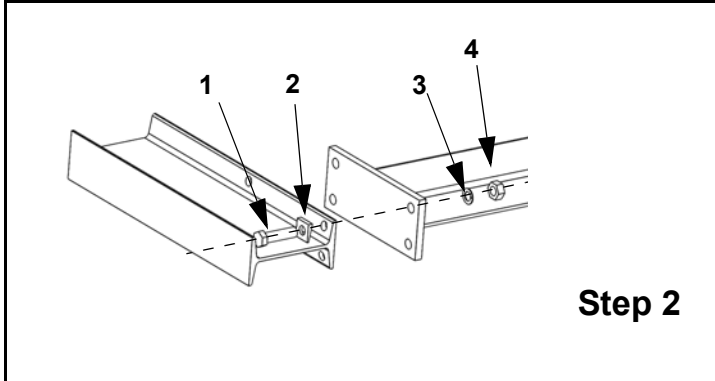


# Assembly Instructions

For assembly, select an area with a safe lifting means. For easiest and safest assembly, use an area with two overhead hoists (for example an overhead crane) to raise the I beam when required.

## Step 1. Installing the Trolley (Sold Separately)

- Raise the I-Beam, using a safe lifting means, so stencilling is right-side up.
- Install Trolley from either end of the beam on the lower flange of the beam
- Lock Trolley in center of beam using C-Clamps on the bottom flange of the beam.

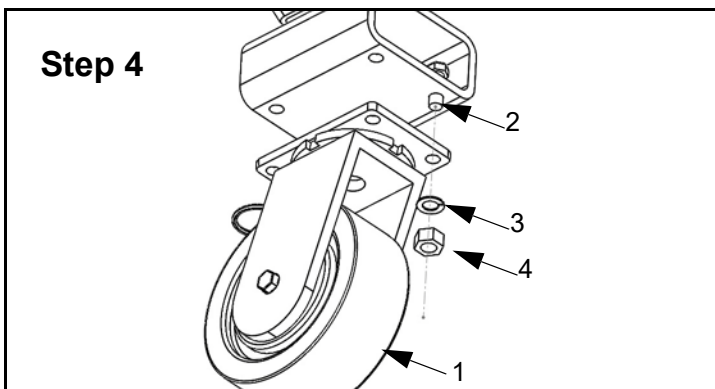
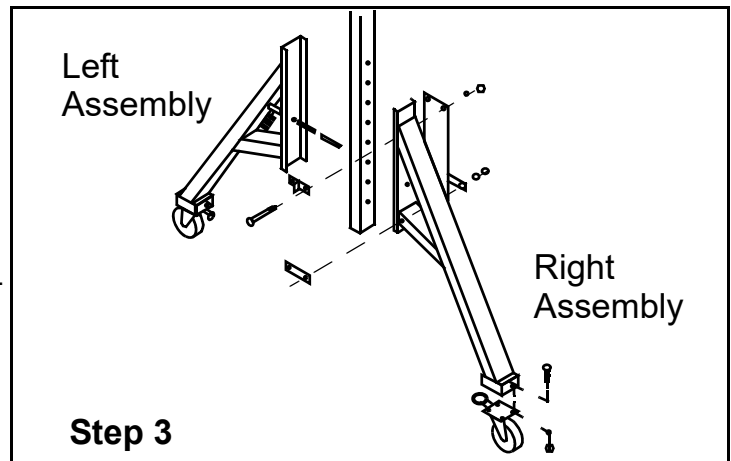


## Step 2. Attaching the Post to the I-Beam

- Place I-Beam web side down on minimum height supports approximately 4" - 24" above floor (i.e. wood planks) that provide enough clearance under beam for Trolley and lifting means being used.
- Align adapter plates of the posts with the applicable location of the I-Beam for attachment. (**NOTE:** Raise and support (such as wood planks) both ends of posts, as necessary). **NOTE:** If unit is equipped with Adjust-A-Span kit, disregard 2C through 2D and refer to Adjust-A-Span kit instructions.
- Insert cap screws (1) with bevel washers (2) through flange of I-Beam and adapter plates of the posts.
- Insert lock washers (3) and hex nuts (4) on cap screws (1) and tighten cap screws and hex nuts.

## Step 3. Attaching the Frames to the Posts

- Remove the cap screws, lock washers, hex nuts, upper bolt plate, lower bolt plates and stabilizer plate that hold the left hand frame and right hand frame together.
- Raise the I-Beam with posts attached, using a safe lifting means.
- Place left hand frame to post and align 3/4" diameter pin with hole in post. (**NOTE:** Raise or lower beam to adjust height of post as necessary) and insert pin through post.
- Place right hand frame to post, align the 3/4" diameter pin with hole in frame. Use a large C- clamp to hold both frames while attaching bolt to plates, stabilizer plate and hardware previously removed.
- Tighten all hardware and remove C-clamp.



## Step 4. Attaching the Casters To the Frame Assemblies

- Raise the I-Beam, so that the frames are sufficiently above the floor for installation of the casters.
- Attach casters with swivel locks (1) to the frame as shown, using cap screw (2), lock washer (3) and hex nut (4) provided.
- Lower gantry so that casters are on floor and remove lifting means. (**NOTE:** For track-mounted gantries - if frames/casters do not properly align with track, slightly loosen bolts that attach posts to frames and re-tighten).

Step 5. Remove C-Clamps on Bottom Flange of Beam (to release Trolley)

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