



# Wallace Hippolift Fixed Height Gantry Cranes

## Assembly Instructions

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

### CAUTIONS

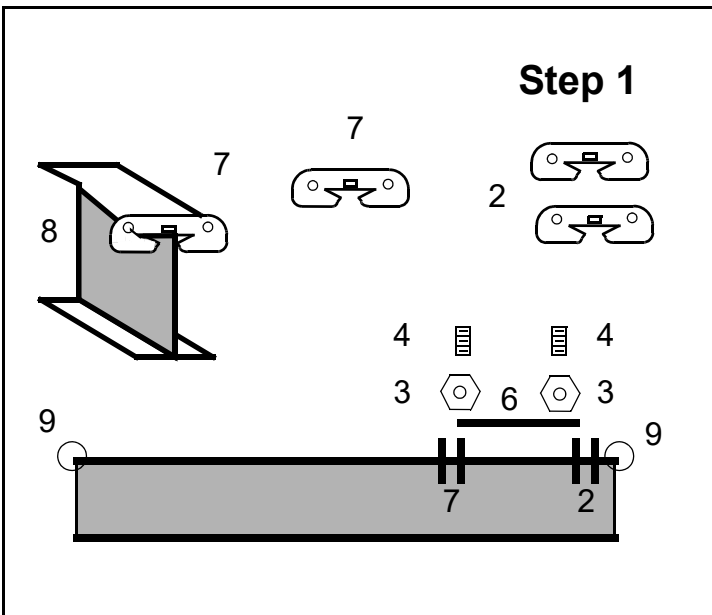
1. Read and understand instructions before using this gantry.
2. Inspect gantry thoroughly before using (see Form 379) for damaged or missing parts.
3. Do not lift more than rated capacity.
4. Center hoist over the load.
5. Do not allow load to swing or to roll against any supporting members.
6. When 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 8) upright on suitable supports so stenciling is right side up.
- C. Slide the **brace leg brackets** (Item 7), then the **main leg brackets** (Item 2), on the I-beam (Item 8). Be sure all brackets are aligned as shown on the Parts Location diagram.
- D. Attach the **spacer bar** (Item 6) to the **main leg bracket** (Item 2) 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 8).



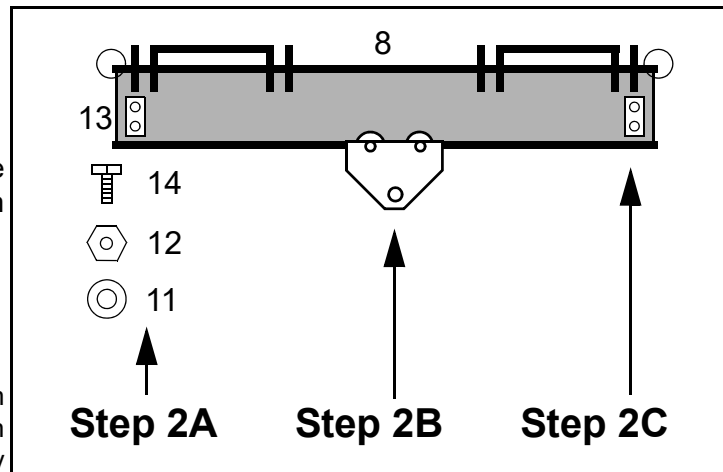
## Step 2. Attaching the Trolley Stops and Trolley

- Install two **trolley stop angles** (13) at one end of **I-Beam** using **bolts** (14) **lock washers** (11) and **hex nuts** (12).
- Install trolley on end of **I-beam** (Item 8) without the **trolley stops** (Item 13).

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

- Install two **trolley stop angles** (Item 13) at the other end of the beam using the **bolts** (Item 14), **washers** (Item 11) and **nuts** (Item 12). For both trolley stops, tighten each nut and bolt to 200 ft./lb. of torque.

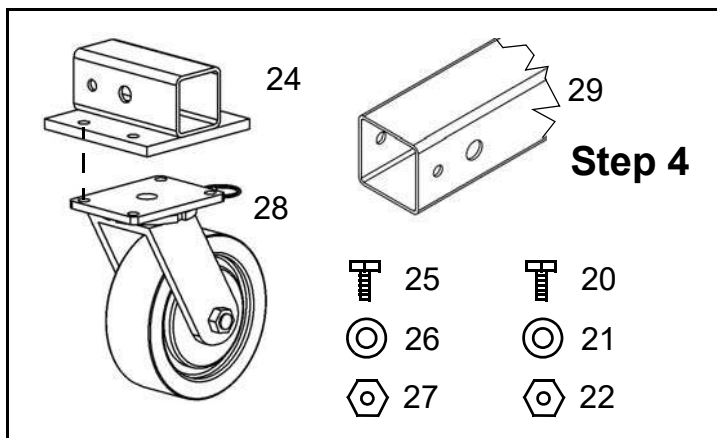
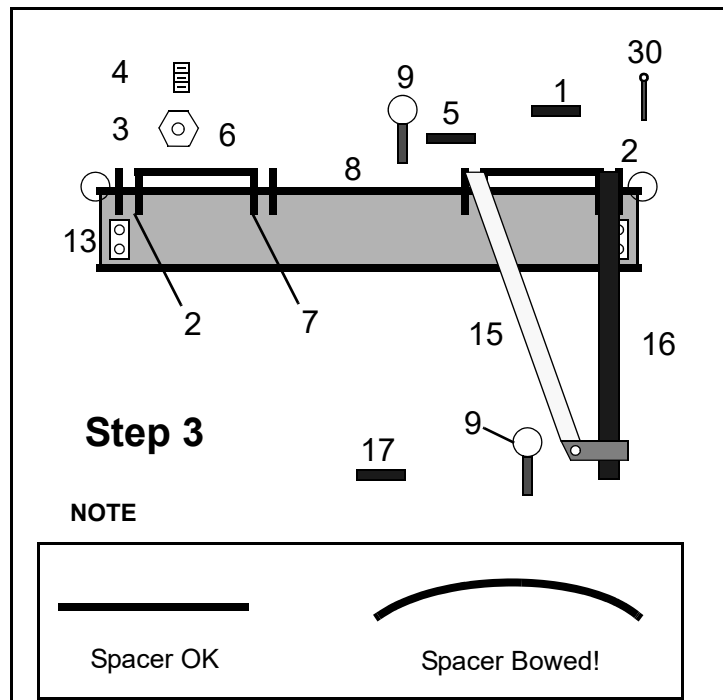
**CAUTION:** Secure trolley in the center of the I-Beam (Item 8), with suitable means, such as heavy clamps, when raising or lowering the assembly. Failure to do so may result in injury or death.



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

- Place upper end of **main leg** (Item 16) between **main leg brackets** (Item 2) as shown and install pin (Item 1), key ring (Item 9) with **caution tag** and cotter pin (Item 30) 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 15) in the brace leg support on the main leg (Item 16) and fasten in place with the **pin** (Item 17) and **key ring** (Item 9) with **caution tag** as shown. Brace leg must be oriented so that the hole in the upper end is parallel with **I-beam** (Item 8).
- The brace leg can now be installed between the **brace leg brackets** (Item 7). Install using the **pin** (Item 5) and **key ring** (Item 9) with caution tag.
- Tighten all set screws (Item 4) to securely lock brackets in place on the I-beam (Item 8).

**NOTE:** Be sure the Spacer is NOT bowed.

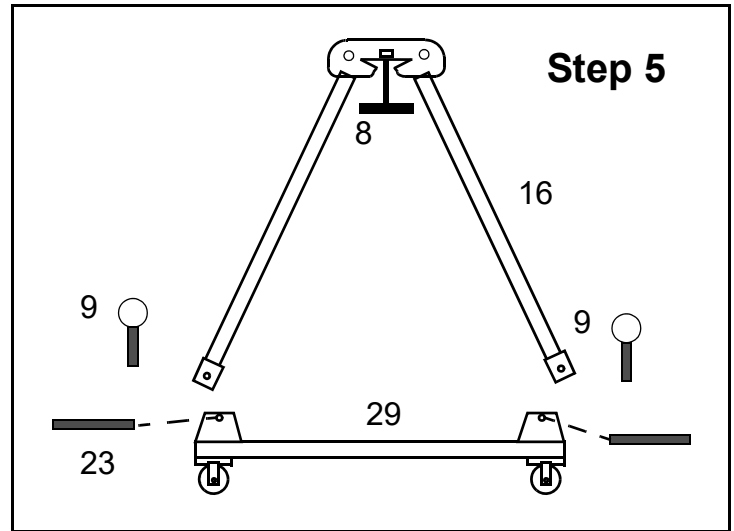


## Step 3. Caster Frame Assembly

- Assemble **casters** (Item 28) to **caster plate** (Item 24) with **bolts** (Item 25), **lock washers** (Item 26) and nuts (Item 27). Tighten nuts and bolts to 57 ft./lb. of torque.
- Connect assemblies (Left) to **caster frame** (Item 29) using **bolt** (Item 20), **lock washer** (Item 21) and **nuts** (Item 22). Tighten nuts and bolts to 57 ft./lb. of torque.

### Step 5. 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 29).
- B. Attach **main legs** (Item 16) to **caster frame tubes** (Item 29) using **pin** (Item 23). Secure pins with **key ring** (Item 9) 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



**Read Form 379F and Form 504 prior to use.**