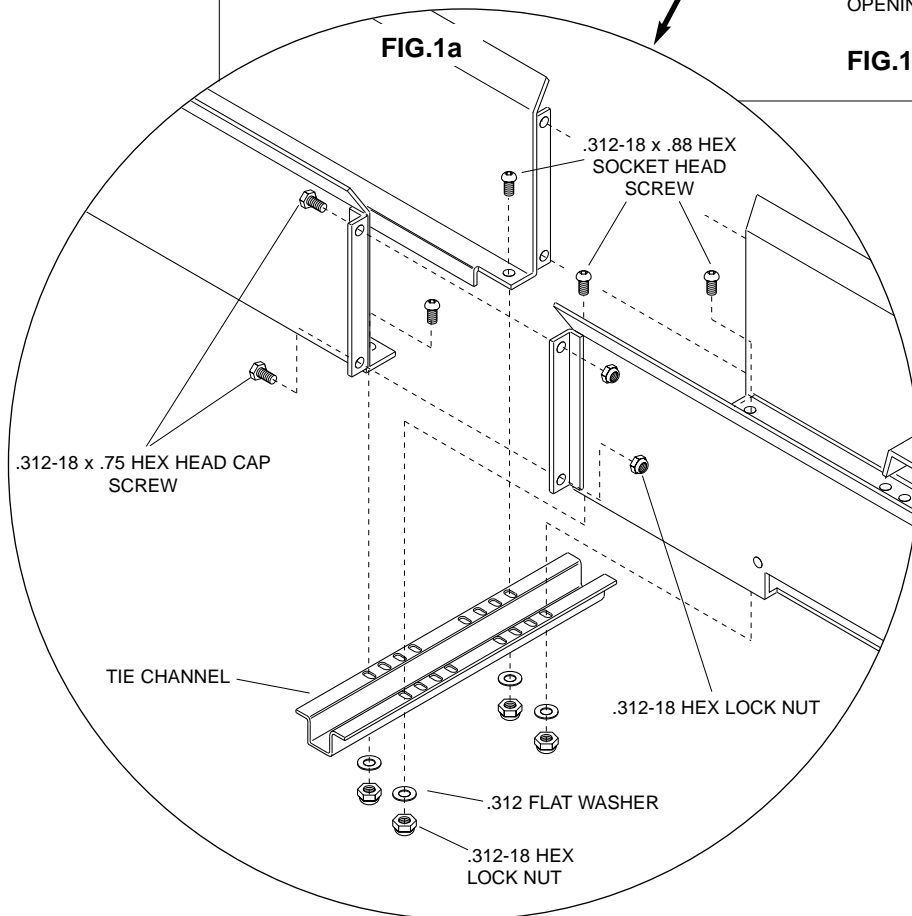
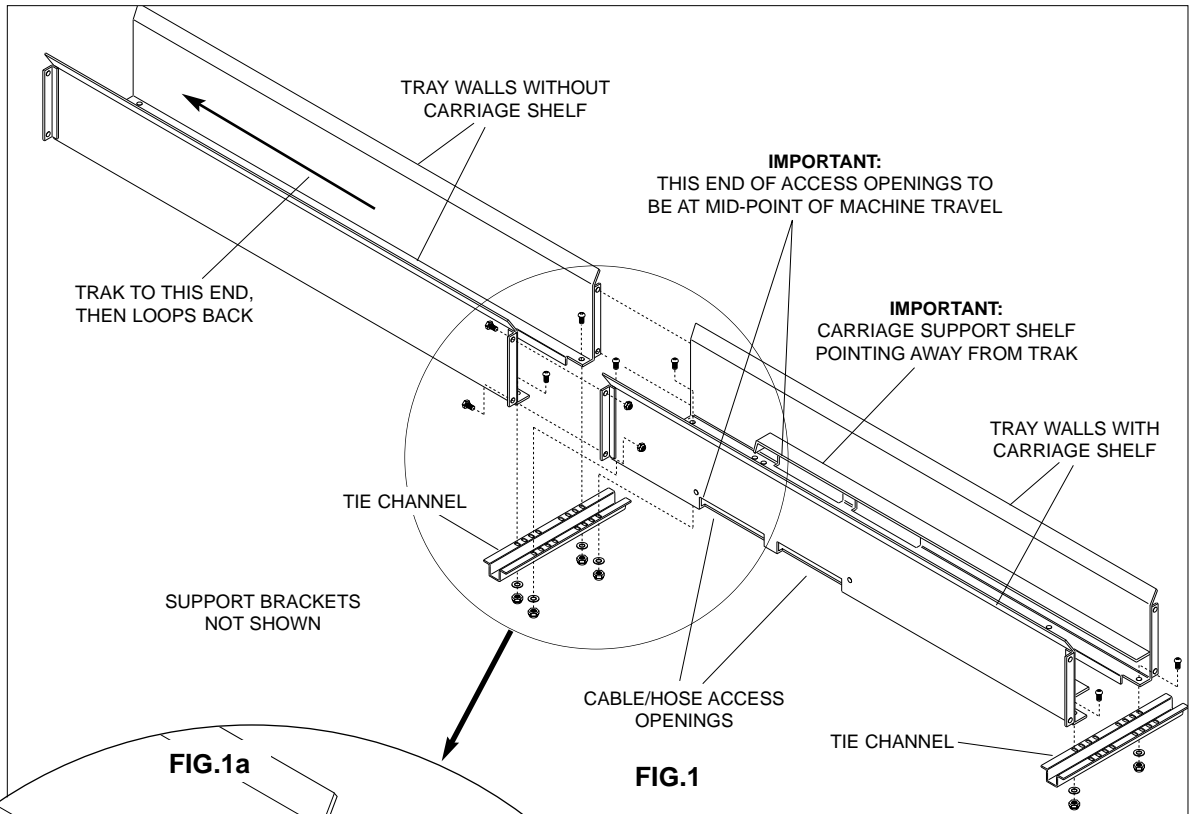


GUIDE TRAY & 215G CARRIAGE

for single direction PowerTrak
INSTALLATION INSTRUCTIONS



GUIDE TRAY ASSEMBLY



NOTE:

Customer must provide support at every tray joint beneath tie channels (60.00"[1524mm] spacing).

It is recommended that guide tray be assembled on support brackets. Lifting assembled tray could damage tray.

STEP 1: Refer to GENERAL ARRANGEMENT DRAWING.

Determine direction trak will travel. NOTE: Your installation may be opposite that shown. Position two tray walls **without shelves** near travel midpoint toward trak end of tray. Position tray walls **with access openings** and carriage support shelves to opposite side of midpoint, shelves pointing away from trak end. (See Fig. 1.)

STEP 2: Consult General Arrangement Drawing for proper inside tray width. Attach tray walls to tie channels using .312-18 x .88 lg. hex socket head screws, flat washers and lock nuts. Fasten tray sides together using .312-18 x .75 lg. hex head cap screws and lock nuts. (See Figs. 1 & 1a.) At this time, assemble only above two sections (four walls, three tie channels). **DO NOT** fully tighten screws .

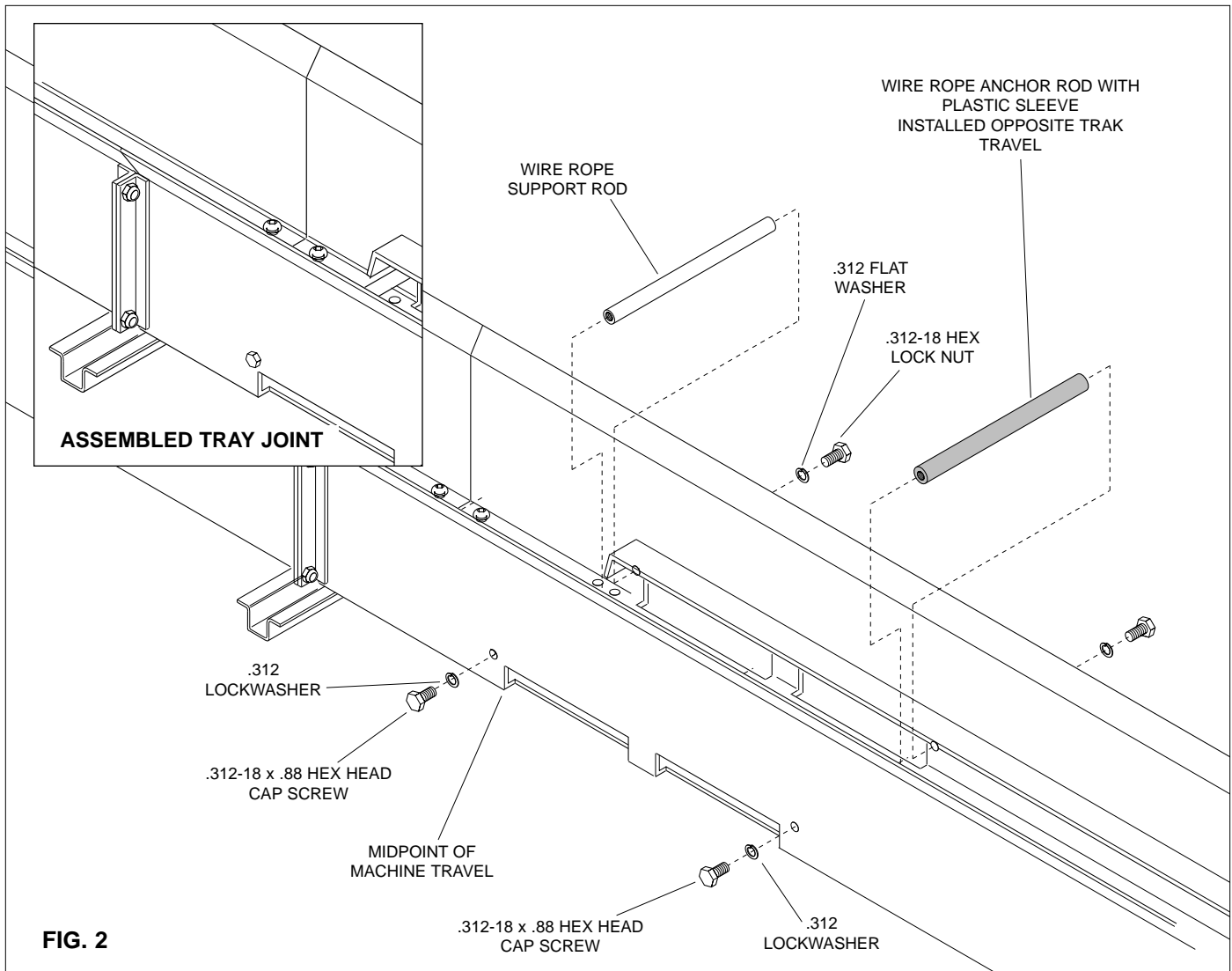


FIG. 2

STEP 3: Install wire rope support rod at end of access openings nearest trak. Install wire rope anchor rod (with plastic sleeve) at end of cable/hose access openings farthest from trak. Be sure there is a **lock-washer** on the .312-18 x .88 cap screws that screw into the rods. (See Fig 2). **DO NOT** fully tighten screws until tray is assembled and aligned.

STEP 4: Attach additional tray walls **without shelves** to trak end of assembled tray sections and tray walls **with shelves** to opposite end. (See Fig. 3). Typically, the quantity of tray sections extending from the joint nearest the travel midpoint is equal in both directions. Short tray sections, if any, go at extreme ends. Consult the General Arrangement Drawing for correct overall length. **DO NOT** fully tighten screws at this time.

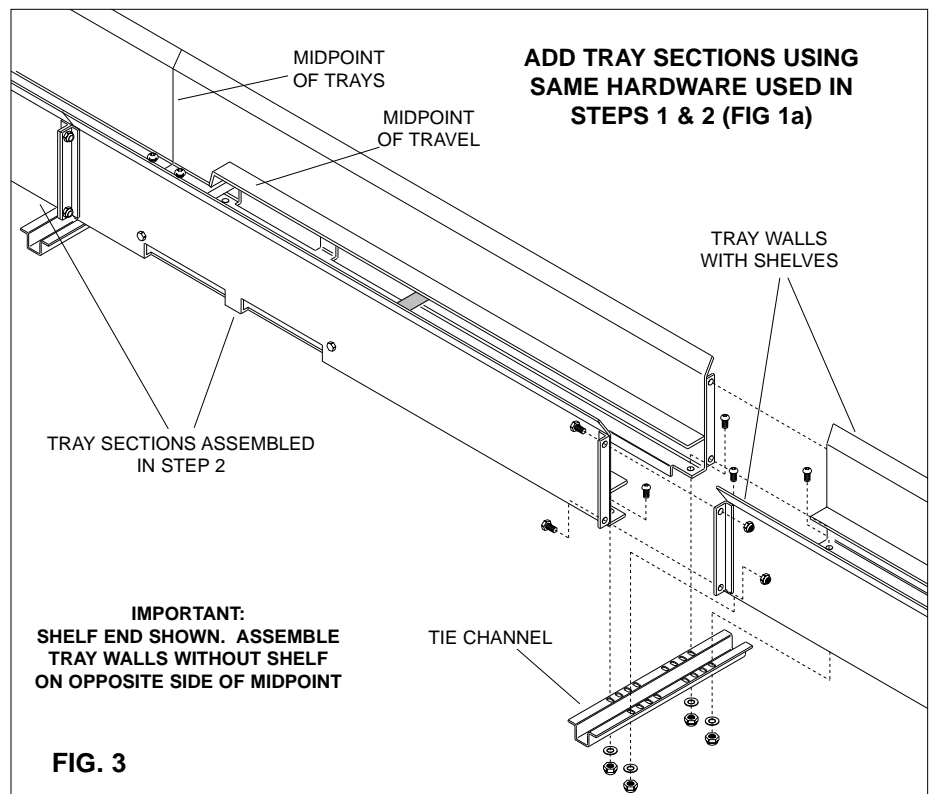


FIG. 3

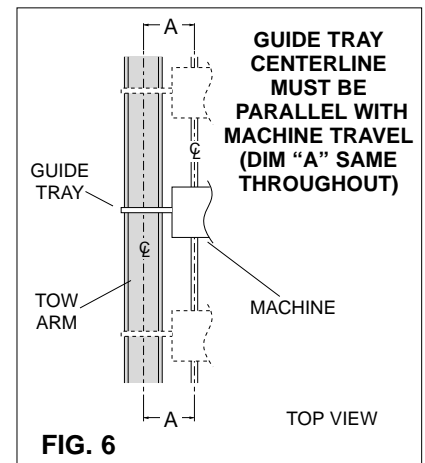
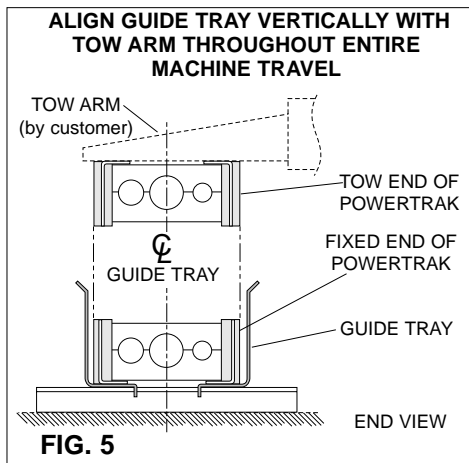
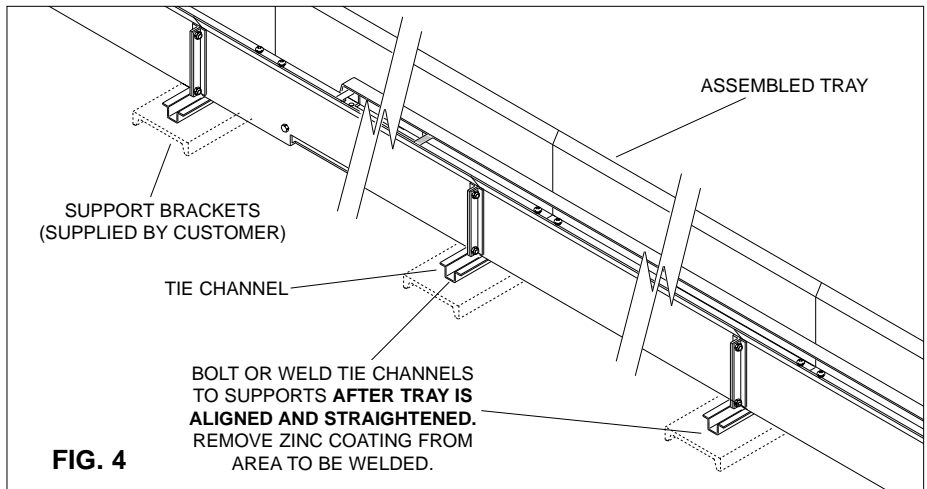
STEP 5: Align tray sections so that tray assembly is straight, all walls are parallel and all joints are flush (no bumps).
Securely tighten all bolts used in assembly.

The entire guide tray installation must be provided with support brackets (by customer) at every joint (Fig. 4).

NOTE:
Guide tray must be supported level and parallel to machine travel.

STEP 6: Adjust guide tray so it is parallel to machine travel and so tow arm (tow end mounting point of PowerTrak) is plumb with tray centerline throughout entire machine travel. (See Figs 5 & 6). Check positioning as shown on General Arrangement Drawing and reposition tray as needed.

STEP 7: Shim between support brackets and tie channels, if necessary, and securely bolt or weld tie channels to support brackets.



WARNING

This movable carriage may present a drop hazard when operated in elevated locations. It is recommended that a metal stop be installed at each end of the support tray or rails to prevent the carriage from rolling beyond the ends of the support should a wire rope or chain fail.

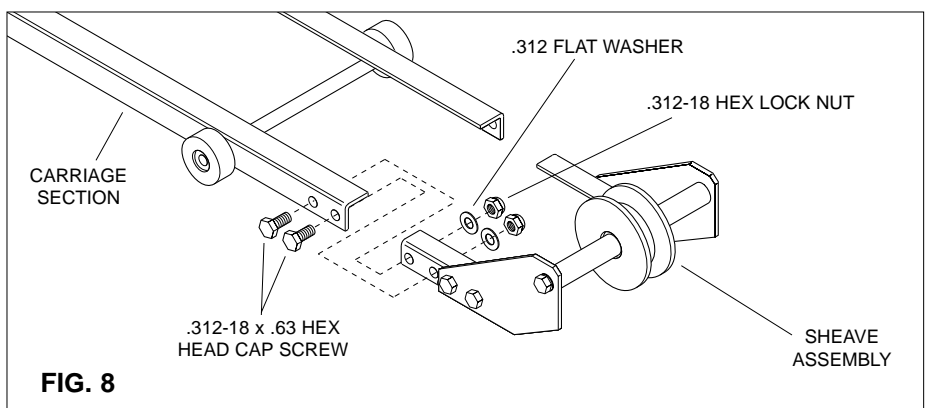
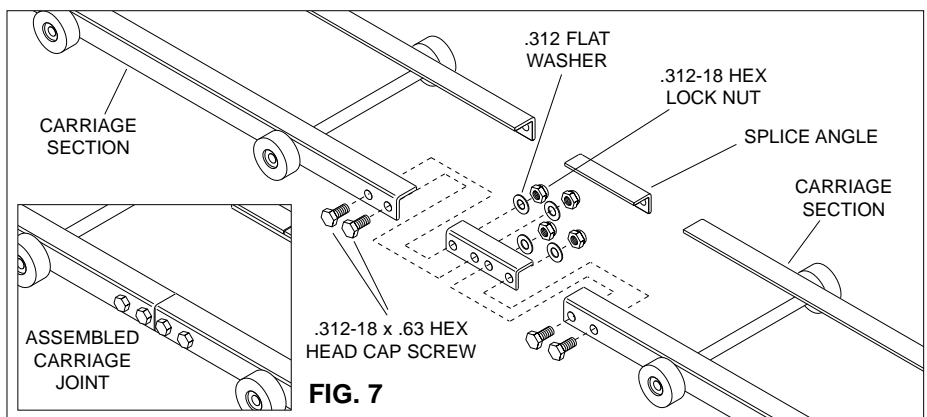
CARRIAGE ASSEMBLY

The carriage lies on the bottom portion of the PowerTrak and on the shelves. It supports the top portion of the PowerTrak during part of the machine travel. Assemble carriage within the guide tray **following trak assembly but with tow end detached and trak laid flat.** See POWERTRAK ASSEMBLY INSTRUCTIONS.

Carriage sections are typically provided preassembled in 60" (1524mm) lengths. Other lengths, if any, go on ends.

STEP 1: Assemble carriage sections using splice angles, .312-18 x .63 long hex head cap screws, flat washers, and .312 locknuts as shown in Fig. 7. Securely tighten all nuts. Be sure finished length of carriage is same as shown on General Arrangement Drawing.

STEP 2: Attach sheave assembly to each end of assembled carriage as shown in Fig. 8 using same size bolts, washers, and locknuts used in STEP 1.



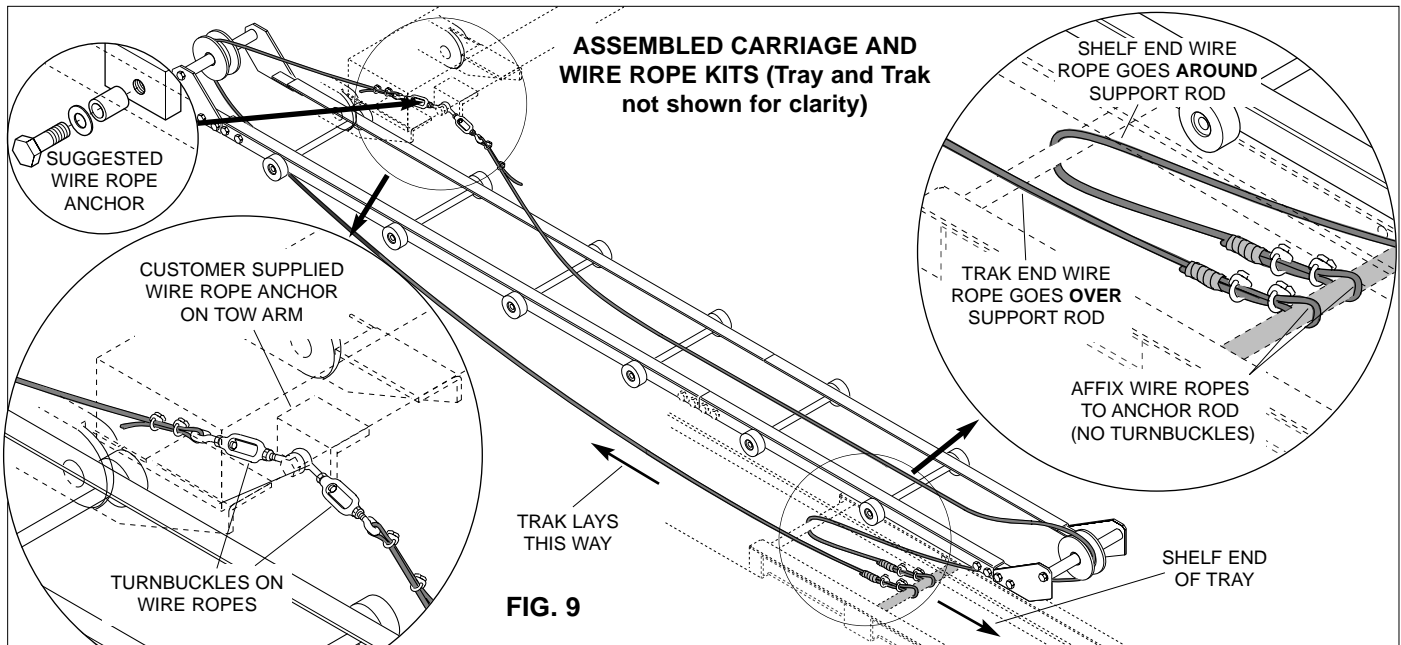


FIG. 9

STEP 3: Attach wire ropes to anchor rod (with plastic sleeve) in guide tray (See Fig 9). Run one wire rope **over** support rod, toward trak, around sheave at trak end of carriage assembly and up to anchor on tow arm. Run other wire rope under support rod then back over rods, toward shelf end, around sheave, and over carriage to anchor on tow arm. Attach turnbuckles to tow arm as shown. Adjust length of turnbuckles to 12" (305mm) overall. **DO NOT PULL WIRE ROPES TIGHT AT THIS TIME.**

STEP 4: Anchor tow end of PowerTrak to tow arm. Refer to PowerTrak INSTALLATION AND MAINTENANCE INSTRUCTIONS.

STEP 5: Move machine (tow arm) to extreme end of travel. (See Fig 10).

STEP 6: Position carriage so that edge of sheave lies at approximate center of loop formed by trak (Fig 10). **NOTE: The wire ropes must lay in a straight path above and below the carriage.**

STEP 7: Loosen wire rope clamps at turnbuckles and adjust until carriage maintains position in Step 6. Do not use turnbuckles to adjust wire rope at this time. Tighten clamps.

STEP 8: Slowly run tow arm to extreme opposite end of travel. Check location of carriage and use turnbuckles to adjust wire ropes as needed. At no time during machine travel should sheave contact

trak loop. **DO NOT OVER TENSION WIRE ROPES.** Wire rope should have enough slack to lay under portion of trak that lies on carriage. Over tensioning will cause ends of carriage to raise at extreme end of machine travel, placing undue strain on carriage and wire ropes and causing possible damage to unit.

STEP 9: Once the wire rope lengths have been verified by operating the system one complete cycle, cut off excess wire rope 3.0" (76mm) beyond the clips and tape end onto itself.

STEP 10: Verify travel capacity and operation of Trak and carriage. Consult Gleason Reel Corporation or your Gleason Representative if you have questions or problems.

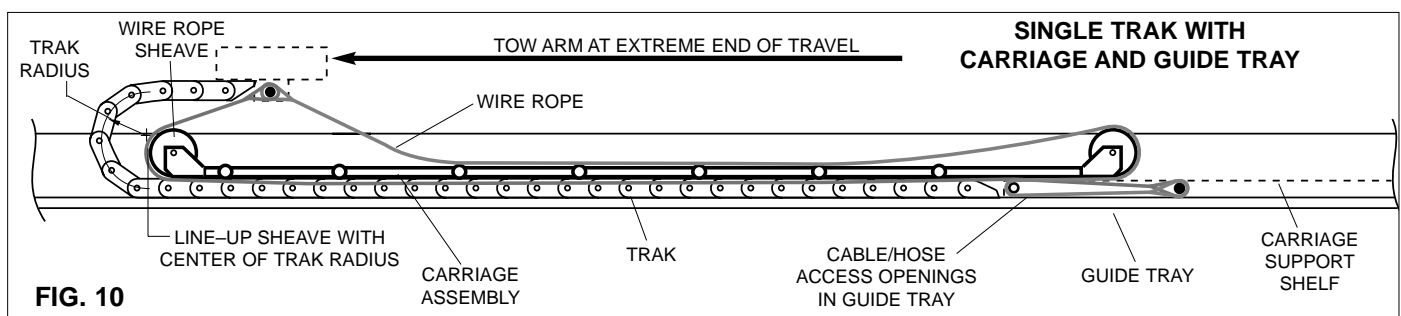


FIG. 10



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