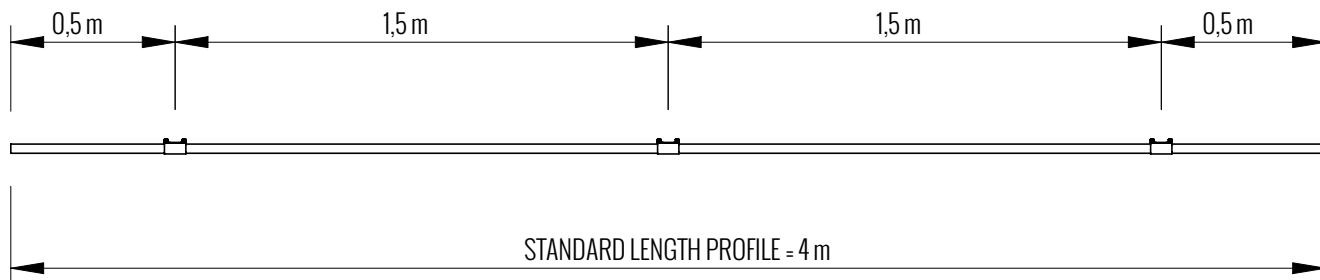


ASSEMBLY INSTRUCTIONS FOR CABLE SUPPORTING TROLLEYS

Running on standardized profiles (IPN, IPE, IPS...)

1) INSTALLATION OF THE FIXED PART OF THE SYSTEM (PROFILES, JOINTS and SUPPORTS)

Firstly, we install our universal supports (avoiding welding, and allowing better alignment), or any type of arm to be welded by the onsite installer, respecting the installation distances as indicated on this drawing.



If you have the universal supports, these will be fixed to the upper flange of the beam by means of tightening the M8 bolts of the tabs. Next, we install the line supports.



In series 28 and 40 systems, these are introduced from one end of the profiles, because they are manufactured as a single piece. In the case of Series 80, the supports are manufactured in two halves, so the profiles are housed in the support by press upwards, and then fixing both with M6 bolts.



After fixing the profiles to the supports, and fixing these to the structure, we then slide the line joints into the profiles from one end of the same.



To join two consecutive profiles we will position the joint at the link between two profiles so we can see the mentioned joint through the window.



Finally, first tighten the two upper M6 bolts, and then the two side ones, checking that the joint on the running side is uniform. Repeat this operation until completing the entire length of the line.

2) INSTALLATION OF THE MOBILE PART OF THE SYSTEM (TROLLEYS AND CABLES)

We have laid the length of the cable on the floor, and marked on these cables the distance we have defined between the cable supports, as well as their excess at both ends of the line (from the end clamp to the electricity panel, and from the towing trolley to the cabinet of the unit to be supplied).



Next, we will install the cable on the saddle of the end clamp, fixing both elements by means of tightening the M6 bolts of the clamp saddle



We repeat this operation with the cable trolleys.



Finally, we will do the same with the towing trolley.



After having finished the carousel of trolleys and cables, we will take it from the end where we have established the power supply, and introduce the towing trolley into the profile.



Next, we will introduce the cable trolleys,



until reaching the end clamp,



which will fix to the profile by means of the M8 bolts on its lower part.



We will manually slide the trolleys along the line checking the correct alignment of the same, as well as the smooth operation of the trolleys in its entire length.



When we reach the other end, we will install the end stop, to avoid accidental exits of the trolleys.



Finally, we will install the towing arm by introducing it into the tube of the towing trolley, linking it to the machine to be supplied from the other end. Make the corresponding electrical connections, and check the operation of the entire system.