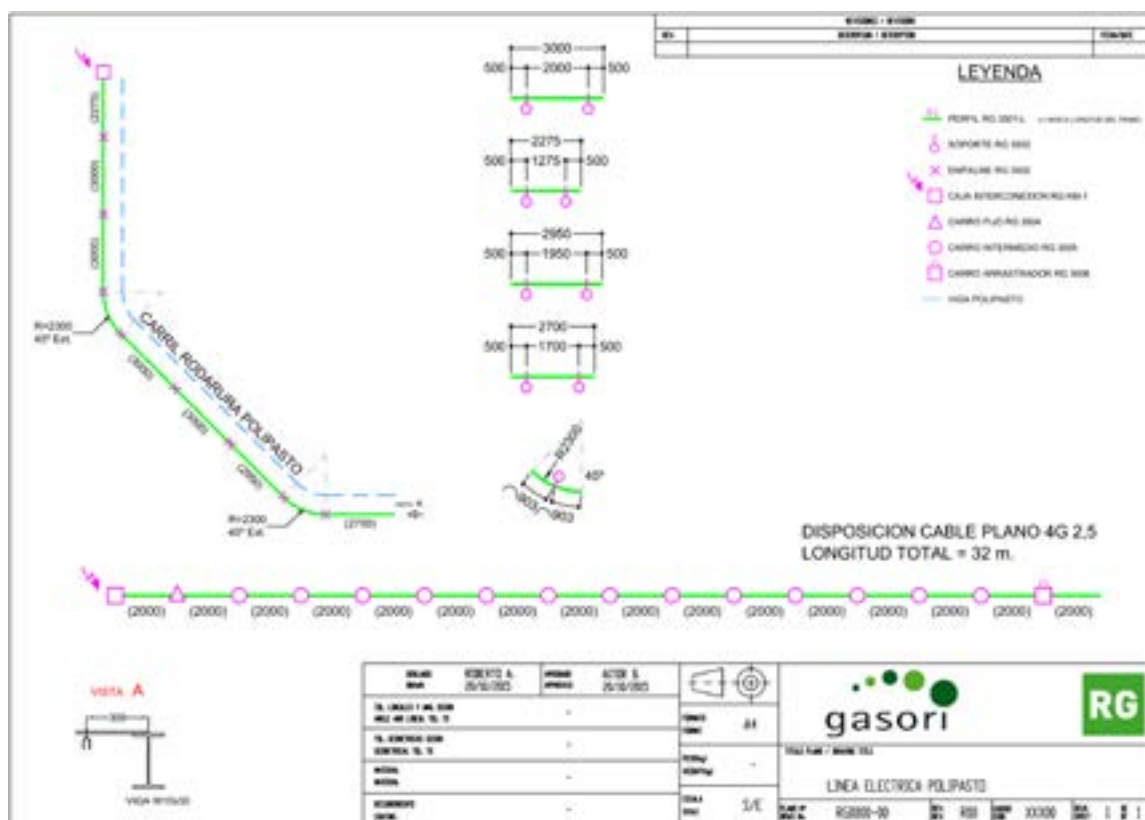


ASSEMBLY INSTRUCTIONS FOR CABLE SUPPORTING TROLLEYS Running on standardized profiles (IPN, IPE, IPS...)

1) PRELIMINARIES

This system is supplied with a drawing of the installation previously agreed and established, that indicates the distance for installing the supports, as well as the layout of the joints that are numbered on the running track profile, so it can be assembled like a kit.



2) INSTALLATION OF THE FIXED PARTS OF THE INSTALLATION (PROFILES RG3501, JOINTS RG3502 AND SUPPORTS RG3503)



The installation of our universal supports is absolutely necessary to guarantee the correct operation and alignment of the system. We will install them at the distances indicated on the drawing supplied with the installation. Both the supports and the joints are installed on the profile.



Firstly, we present the supports RG3503, fixing them to the universal supports by means of the M10 bolts, without definite tightening.



Then we will join the consecutive profiles using joint RG3502.



We will fully unite both profiles,



and finally tighten the two M& bolts to fix the joint. Repeat this operation until finishing the line.



The next step is to align the line at its operational height, which we do by adjusting the M10 bolts of the supports. After levelling the entire system, we then definitely tighten all the bolts of the mentioned supports.

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

In these installations, the minimum distance between trolleys is defined by the smallest radius of the curves forming the line. This distance can be seen on the supplied drawing.



We have laid the length of the cable(s) on the floor, and marked the distance we have defined between the cable supports, and we install the cable(s) on the saddle of the end clamp RG3504, fixing both elements by tightening the M6 bolts of the end clamp saddle.



Now we repeat this operation with the cable trolleys RG3505.



Finally, with the towing trolley RG3506.

We would like to highlight that this complete unit can be sent directly from GASORI, saving an important amount of time.



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.



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 RG3507, by means of tightening the M6 bolts to avoid accidental exits of the trolleys.



Finally, we will install the towing arm RG3514 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.