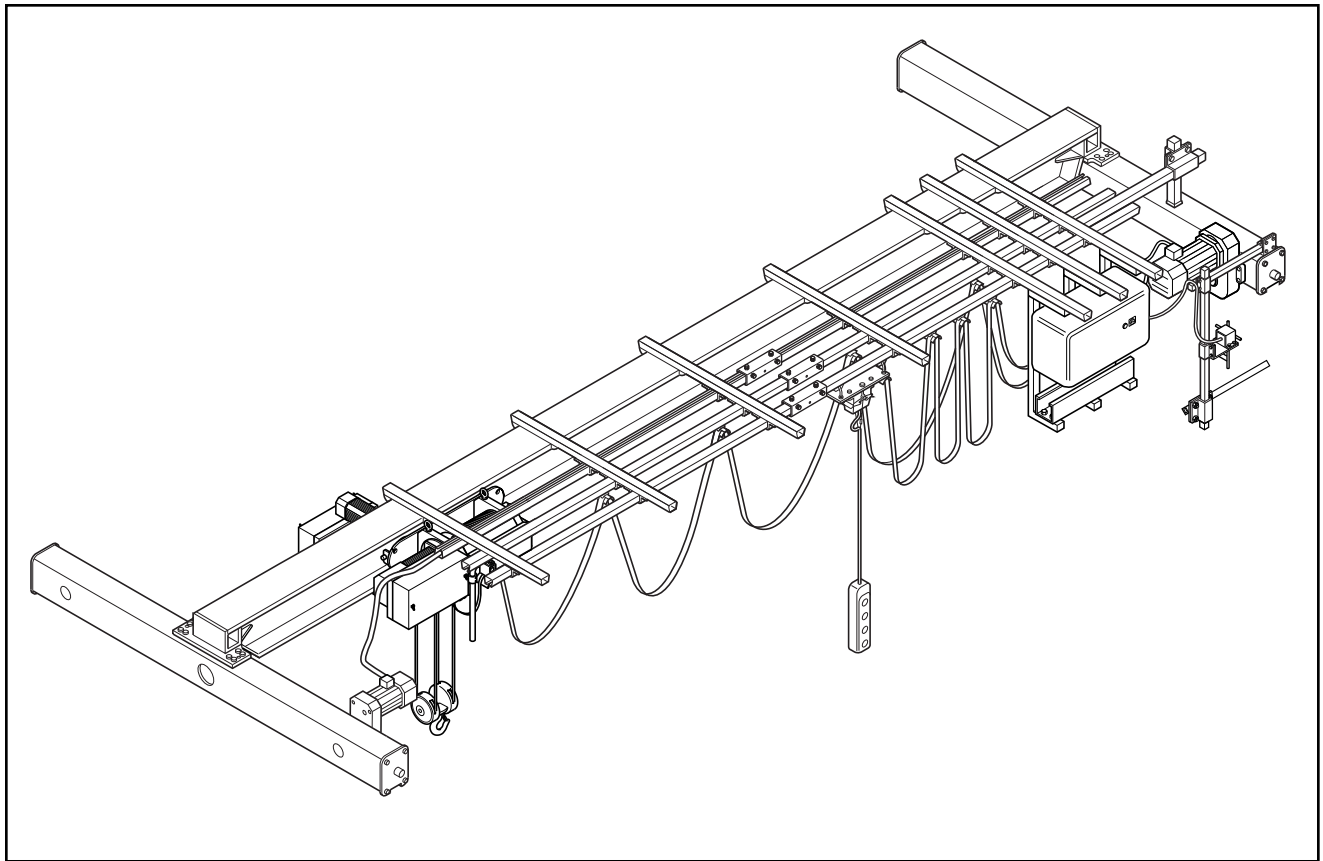


# QC 2000 MODULAR CRANE

## ASSEMBLING INSTRUCTIONS



**SINGLE GIRDER**



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## IMPORTANT ASSEMBLY INSTRUCTIONS

1. Ensure you have all correct assembly instructions before starting assembly.
2. Ensure you have the correct component package for your span and capacity.
3. Ensure the crane layout is the correct one for the application.
4. Use the correct size main girder.
5. Do not exceed maximum crane spans or capacities for any girder connection type.
6. Ensure you check alignment of drilling jigs before using.
7. Do not substitute metric girder connection hole sizes with English sizes.
8. Do not substitute any girder connection bolts or roll pin sizes with English sizes.
9. Use roll pins with all girder connections.
10. Tighten girder connection bolts to correct torque.
11. Plastic hammer may only be used to install traveling components.
12. Use bridge travel limit switch whenever possible.
13. Adjust hoist trolley and crane end stops correctly.
14. Perform a test run for assembled crane before shipping to job site.
15. Adjust crane collector pole at job site and cut excess tubing.
16. Run crane the length of the runway and adjust end stops.



BEFORE STARTING ASSEMBLY, MAKE SURE THAT YOU HAVE ALL CORRECT ASSEMBLY INSTRUCTIONS AND THE COMPLETE MODULAR CRANE COMPONENT PACKAGE. DO NOT MIX OR REPLACE COMPONENTS FROM ONE SET TO ANOTHER BEFORE CONFIRMING THAT THEY ARE INTERCHANGEABLE. MAKE SURE YOU ARE ALWAYS USING CORRECT COMPONENTS.

## CRANE LAYOUT

There are two possibilities for crane layout depending on the location of the crane power supply in the building and the required push button side of the crane. All assembly instructions in this guide are shown in the crane layout drawing. If the other crane layout is desired, assemble bridge accessories in a mirror image. To maintain correct crane movement directions, bridge drive motor plugs (X-15, X-16) should be simply switched with each other at the bridge panel. Before starting crane assembly, make sure that the crane layout is the correct one for the application.

- Assemble the main girder and main girder/end truck connection per instructions in this guide.
- Install the hoist per instructions in the "Hoist Owners Manual".
- Assemble crane festoon system per instructions in this guide.

## CRANE TEST RUN

All modular crane components and cable connections are already factory tested before shipping, but to complete the quality cycle of R&M Materials Handling, a test run **must be done** before shipping the crane to the job site.

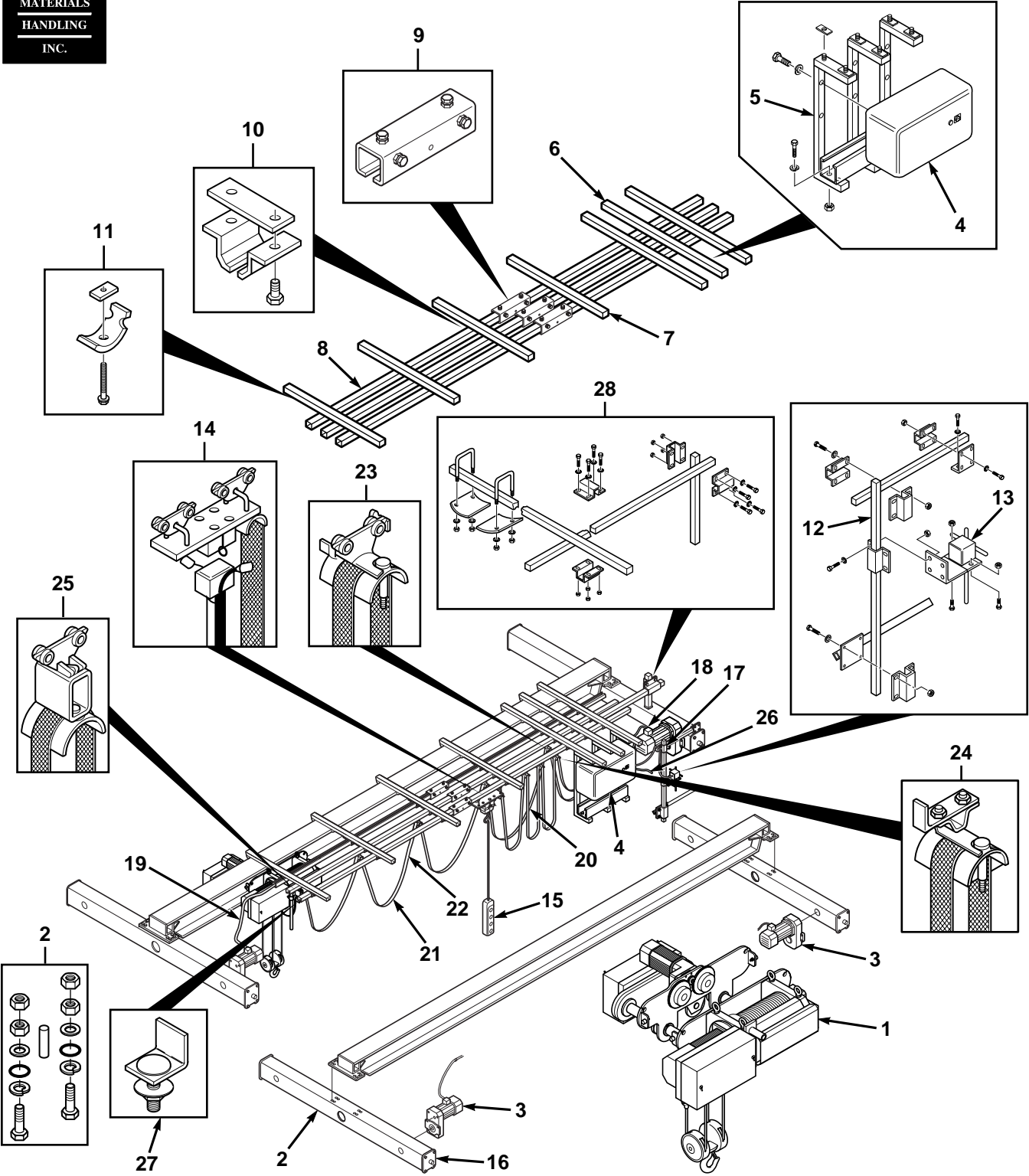
1. Turn off the main power disconnect switch from bridge panel.
2. Connect **correct** power to crane main power supply cable.
3. Turn on the power.
4. Turn on the main power connect switch from bridge panel. Wait a few seconds.
5. Press the green button from the push button to turn on the main line contactor.
6. The green button needs to be pressed every time after cutting off power or shutting down crane by e-stop.
7. Press slowly the hoist lowering button for a very short time, watching the rope underneath the drum.
8. If rope tends to tighten, turn off the power and main power disconnect switch and change phasing of the crane main power supply by switching any two of the of the three wires.
9. Turn on the power and main power disconnect switch again. Remember to press the green button.
10. Press lowering button again and make sure that rope is loosening from drum.
11. **NOTE:** When hook is on the ground and wire rope is loose, be very careful when raising or lowering hook, as it may result in a rope jam around the drum. Always follow the rope underneath the hoist.
12. Raise the hook carefully off the ground and check operation of hoist upper limit switch.
13. Now, perform all other hoisting and trolley directions, both fast and slow speed, and make sure they are working correctly.
14. Check the bridge drives and make sure that the wheels are turning opposite direction. Check fast and slow speed. (Fast speed does not work if bridge limit switch is not in center position.)
15. Check the operation of the bridge travel limit switch by turning the actuating arm of the switch while pressing bridge drive to fast speed.
16. The speed of both drives should be switched from fast speed to slow speed, for two speed, off for single speed, and to decel with inverter, when limit switch arm is turned to either direction from center position.
17. Listen to the sound of hoist and drive motors and ensure that motor brake is opening properly when motor is running.
18. Check that the emergency stop button of push button station is working. Remember to press the green button again to run the crane.
19. If horn is supplied with your crane, press the green button to sound the horn.

Crane traveling motions are set for operator standing on the push button side of the bridge, watching the load (up, down, left, right, forward, backward). If crane traveling motions from push button are not as desired, do not start to change hard wiring from hoist or bridge panels before checking the following possibilities.

1. Change main power phasing if all crane motions are opposite.
2. Change bridge travel motions by switching X-15 and X-16 plugs at bridge panel.
3. Check that bridge limit switch is connected and in "center" position if fast speed of drives is not working.
4. If crane does not start to operate, check that main line disconnect switch is "on" at bridge panel and that you have pressed the green button to turn main line contactor "on".

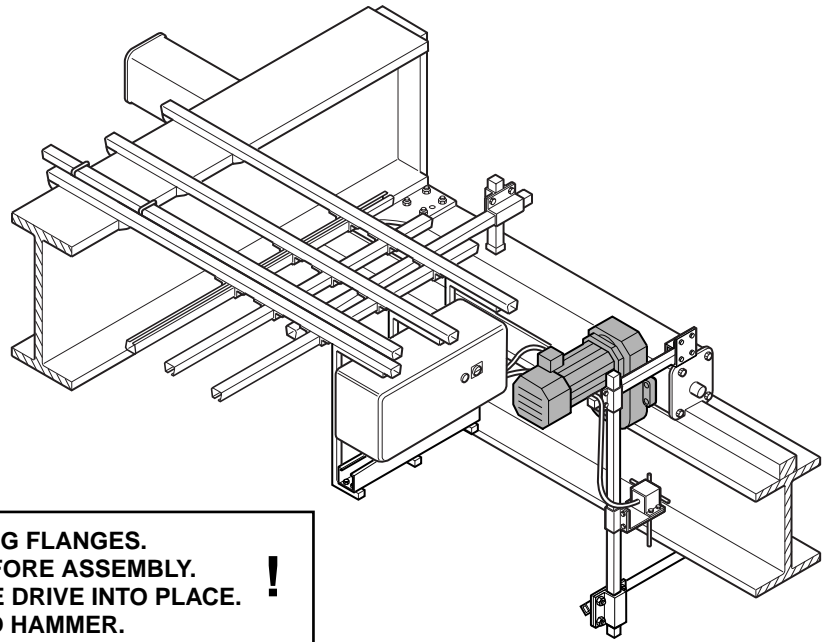


**SINGLE GIRDER TOP RUNNING CRANE**



- |                              |                                |                                       |
|------------------------------|--------------------------------|---------------------------------------|
| 1. Hoist                     | 11. Beam clip                  | 20. Cable for pendant trolley         |
| 2. End carriage & fasteners  | 12. Crane power towing arm     | 21. Cable for hoist power             |
| 3. Traveling machinery       | 13. Bridge travel limit switch | 22. Cable for hoist control           |
| 4. Bridge panel              | 14. Pendant trolley            | 23. Cable trolley                     |
| 5. Bridge panel support      | 15. Push button station        | 24. End clamp                         |
| 6. Bridge panel support rail | 16. End truck bumper           | 25. Towing trolley                    |
| 7. Profile support rail      | 17. Cable for limit switch     | 26. Cable for crane main power supply |
| 8. C-track                   | 18. Cable for drive motor 1    | 27. End stop for pendant trolley      |
| 9. Joint clamp               | 19. Cable for drive motor 2    | 28. Bridge panel support              |

**QC2000 BULLETIN SGT-1**



- ! • CLEAN THE SPLINE AND MOUNTING FLANGES. GREASE THE SPLINE LIGHTLY BEFORE ASSEMBLY. !
- ! • USE A PLASTIC HAMMER TO MOVE DRIVE INTO PLACE. DO NOT USE ANY METAL OR LEAD HAMMER. !

**TM4 BRIDGE DRIVE**

**Parts Listing**

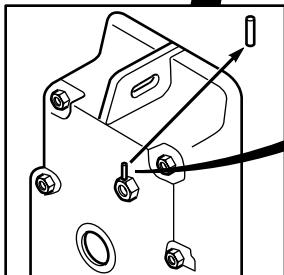
1. Gear reducer	5. Nut
2. Motor	6. Spacer
3. End truck	7. Washer
4. Torque arm	8. Bolt

**DS3 BRIDGE DRIVE**

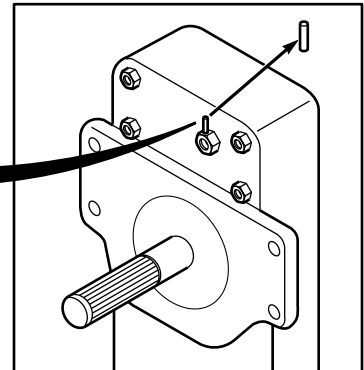
**Parts Listing**

1. Gear reducer	3. End truck	5. Washer
2. Motor	4. Bolt	

- ! • TIGHTENING TORQUE 30 FT-LBS. !



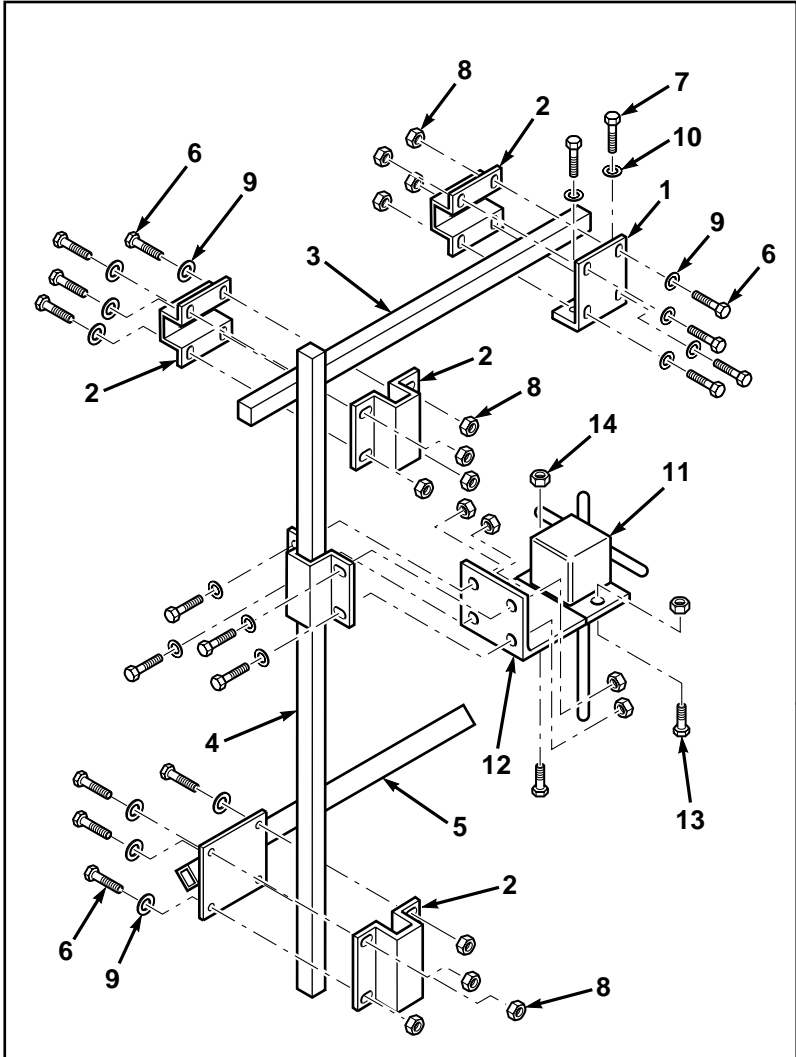
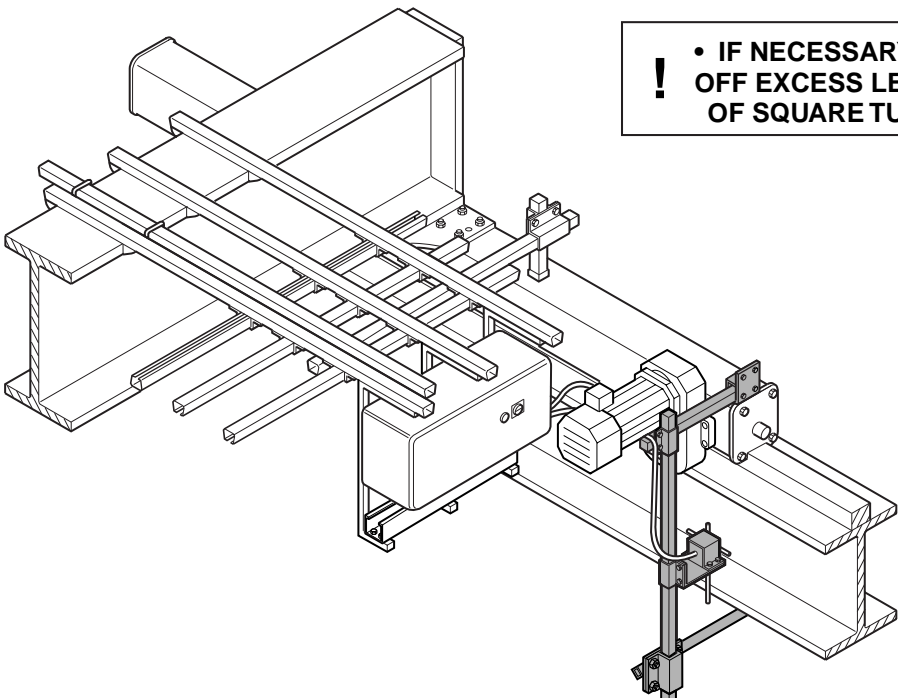
- ! • REMOVE THE PROTECTION PIN FROM BREATHER PLUG. !





**CRANE POWER TOWING ARM ASSEMBLY**

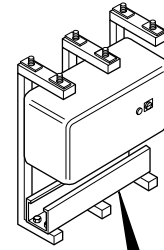
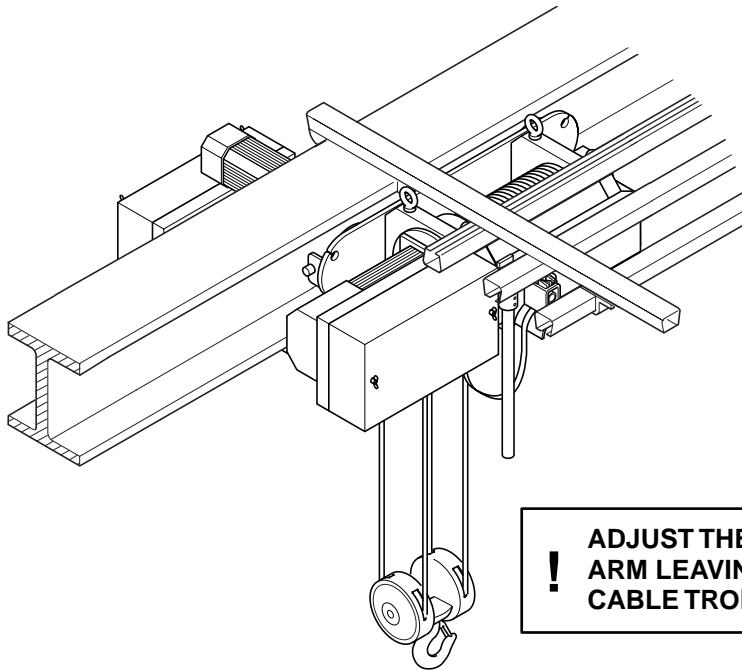
**! IF NECESSARY, CUT OFF EXCESS LENGTH OF SQUARE TUBES. !**



**NOTE:  
ARRANGEMENT MAY VARY  
WITH INSTALLATION.**

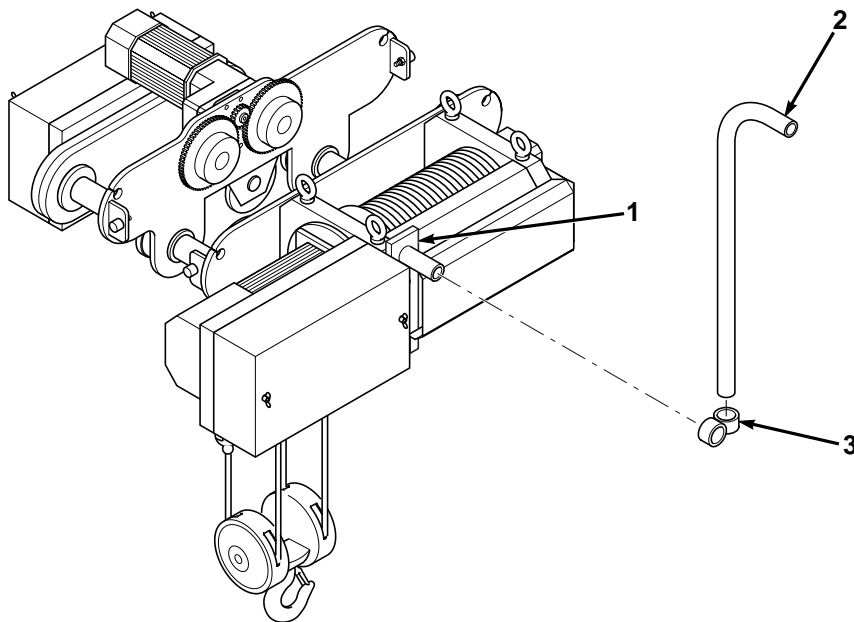
**Parts Listing**

- |               |                  |
|---------------|------------------|
| 1. Plate      | 8. Nut           |
| 2. Clamp      | 9. Washer        |
| 3. Tube       | 10. Washer       |
| 4. Tube       | 11. Limit switch |
| 5. Towing arm | 12. Plate        |
| 6. Bolt       | 13. Bolt         |
| 7. Bolt       | 14. Nut          |



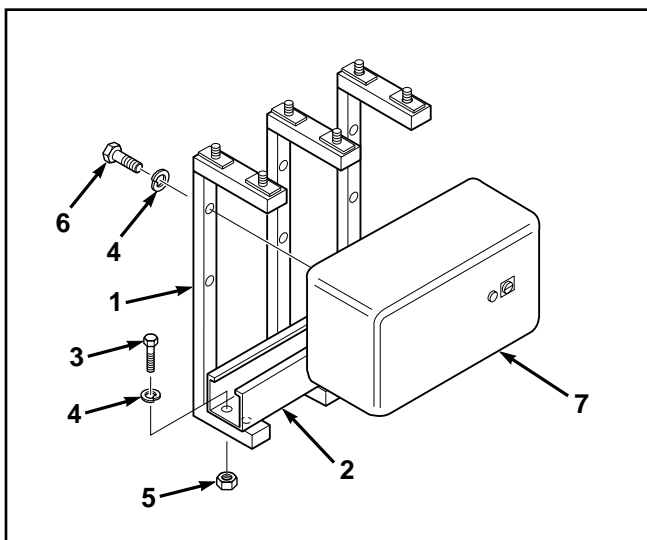
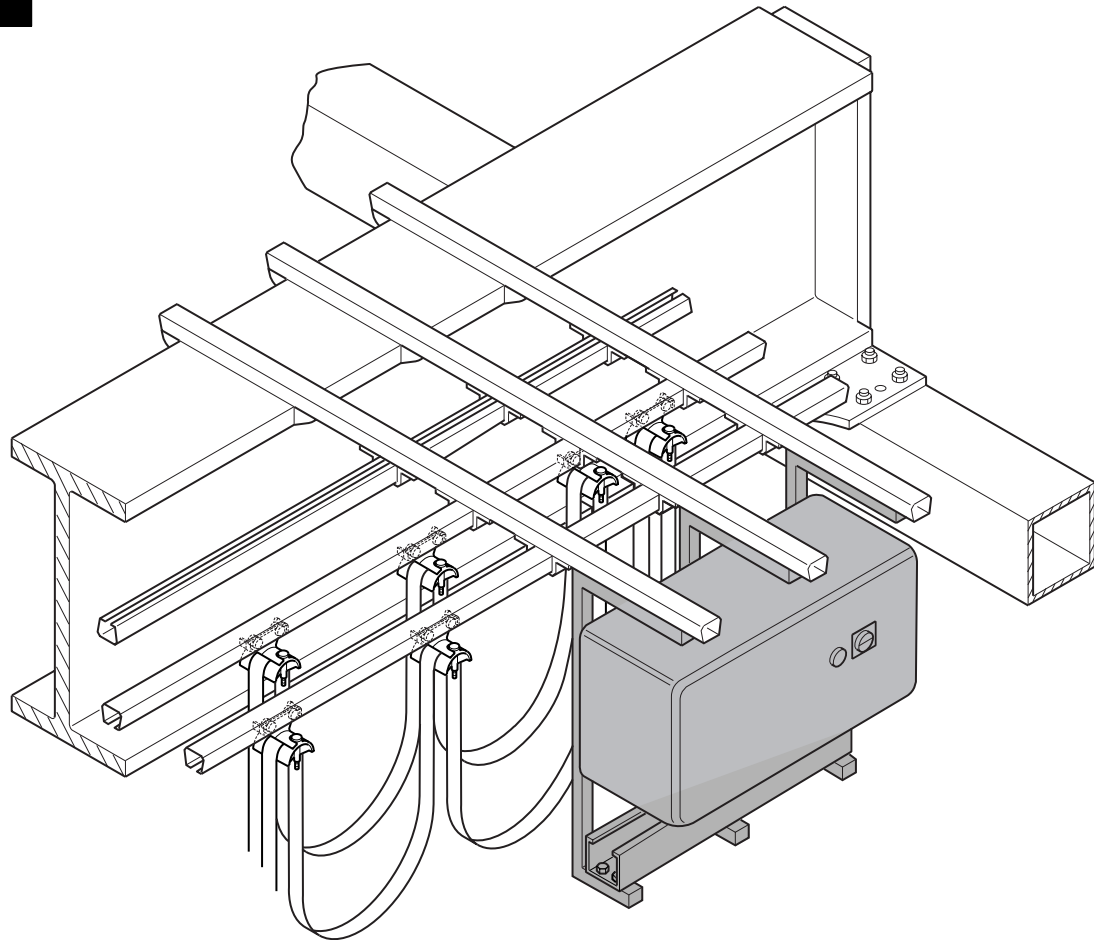
**! • BRIDGE PANEL THIS END. !**

**! ADJUST THE HOIST POWER TOWING ARM LEAVING ENOUGH ROOM FOR CABLE TROLLEYS TO COLLECT. !**



**Parts Listing**

- 1. Plate
- 2. Towing arm
- 3. Joint



**!**

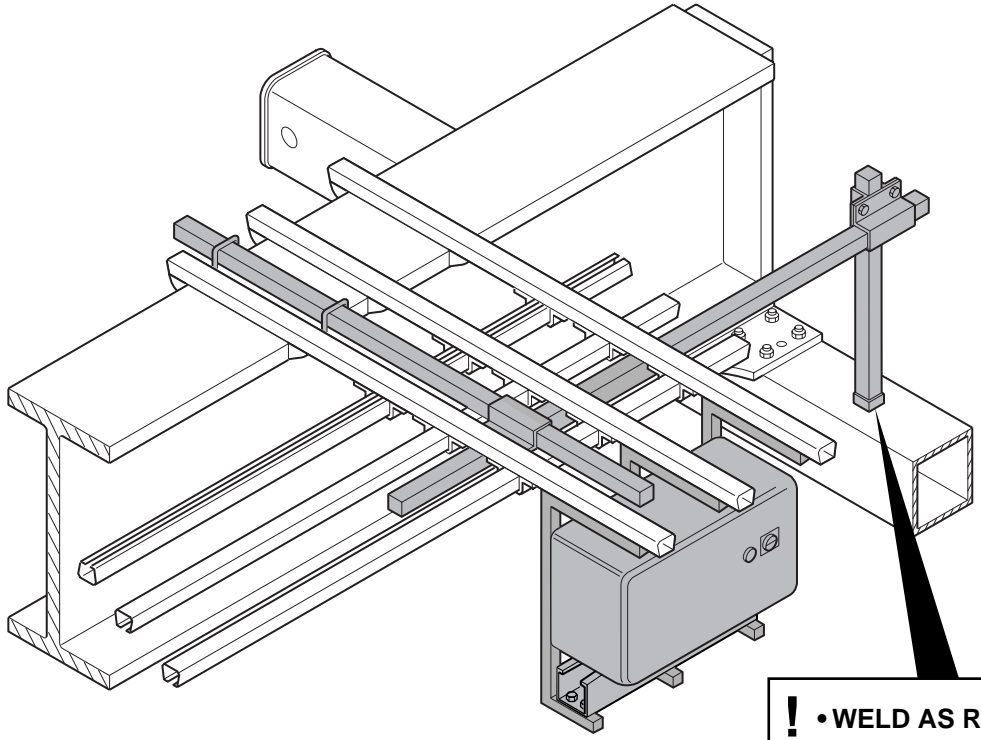
- ASSEMBLE THE FRAME TO BRIDGE PANEL FIRST.
- SLIDE ASSEMBLY INTO SUPPORTING C-RAIL.

**!**

**Parts Listing**

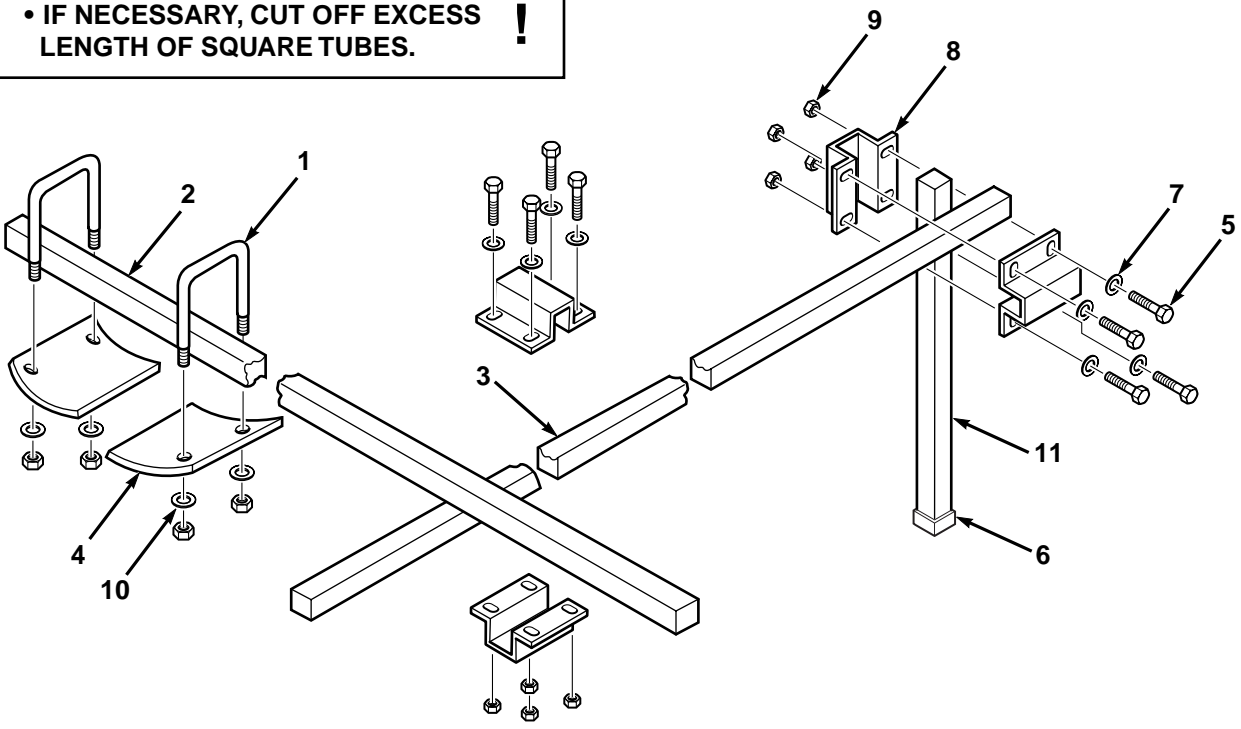
- |               |                 |
|---------------|-----------------|
| 1. Frame      | 5. Nut          |
| 2. Cable tray | 6. Bolt         |
| 3. Bolt       | 7. Bridge panel |
| 4. Washer     |                 |





**! • WELD AS REQUIRED. !**

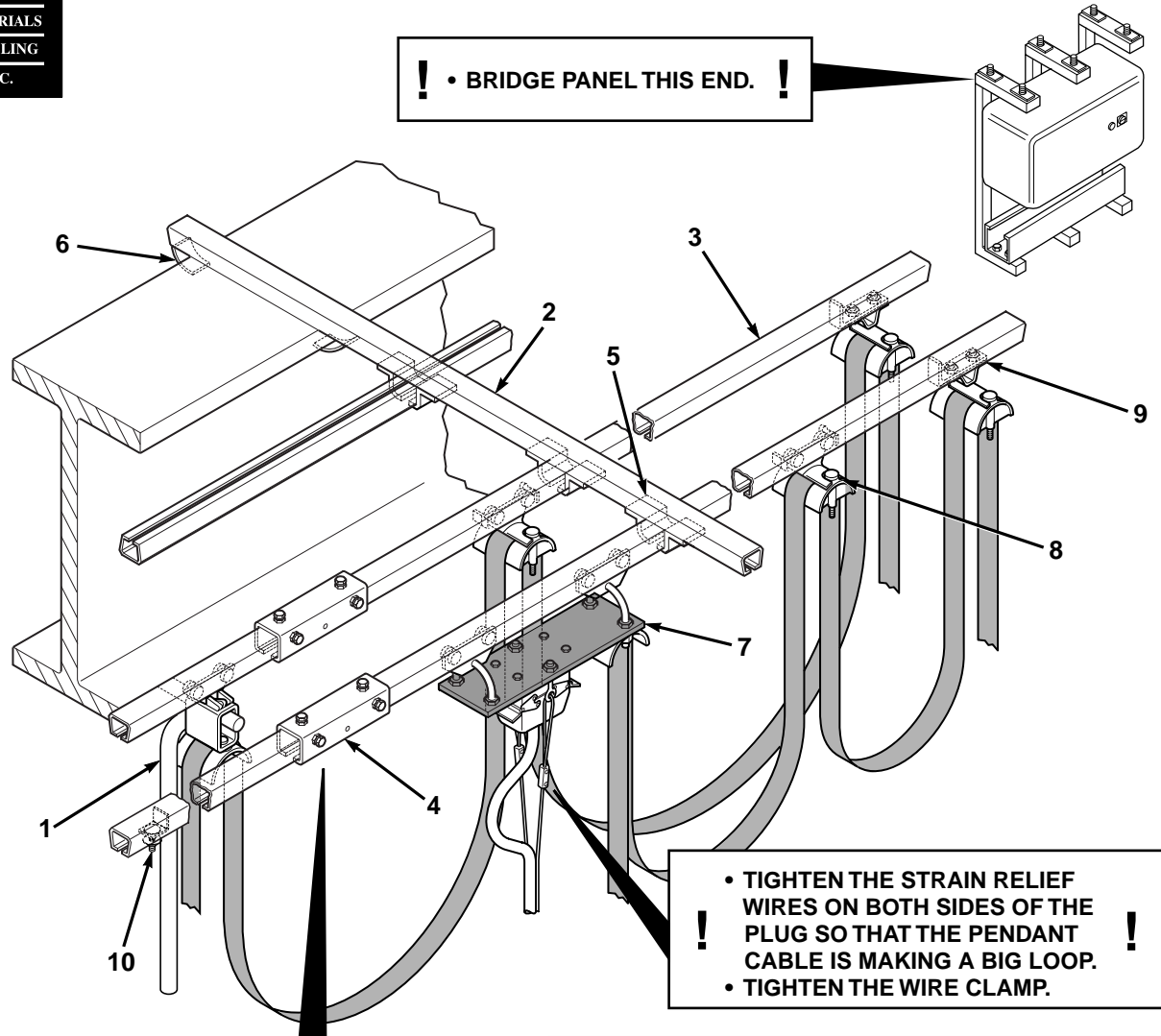
**! • IF NECESSARY, CUT OFF EXCESS LENGTH OF SQUARE TUBES. !**



**Parts Listing**

- |                |             |                 |
|----------------|-------------|-----------------|
| 1. Loop        | 5. Bolt     | 9. Nut          |
| 2. Square tube | 6. Tube end | 10. Washer      |
| 3. Square tube | 7. Washer   | 11. Square tube |
| 4. Clamp       | 8. Bracket  |                 |

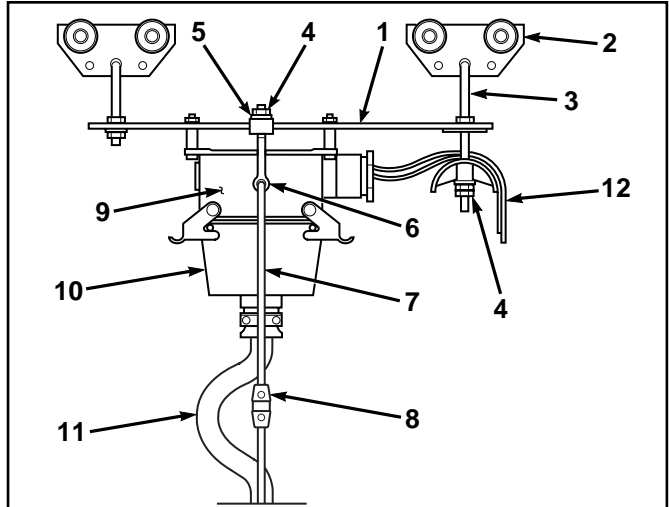
**! • BRIDGE PANEL THIS END. !**



**! • TIGHTEN THE STRAIN RELIEF WIRES ON BOTH SIDES OF THE PLUG SO THAT THE PENDANT CABLE IS MAKING A BIG LOOP. !**  
**• TIGHTEN THE WIRE CLAMP.**

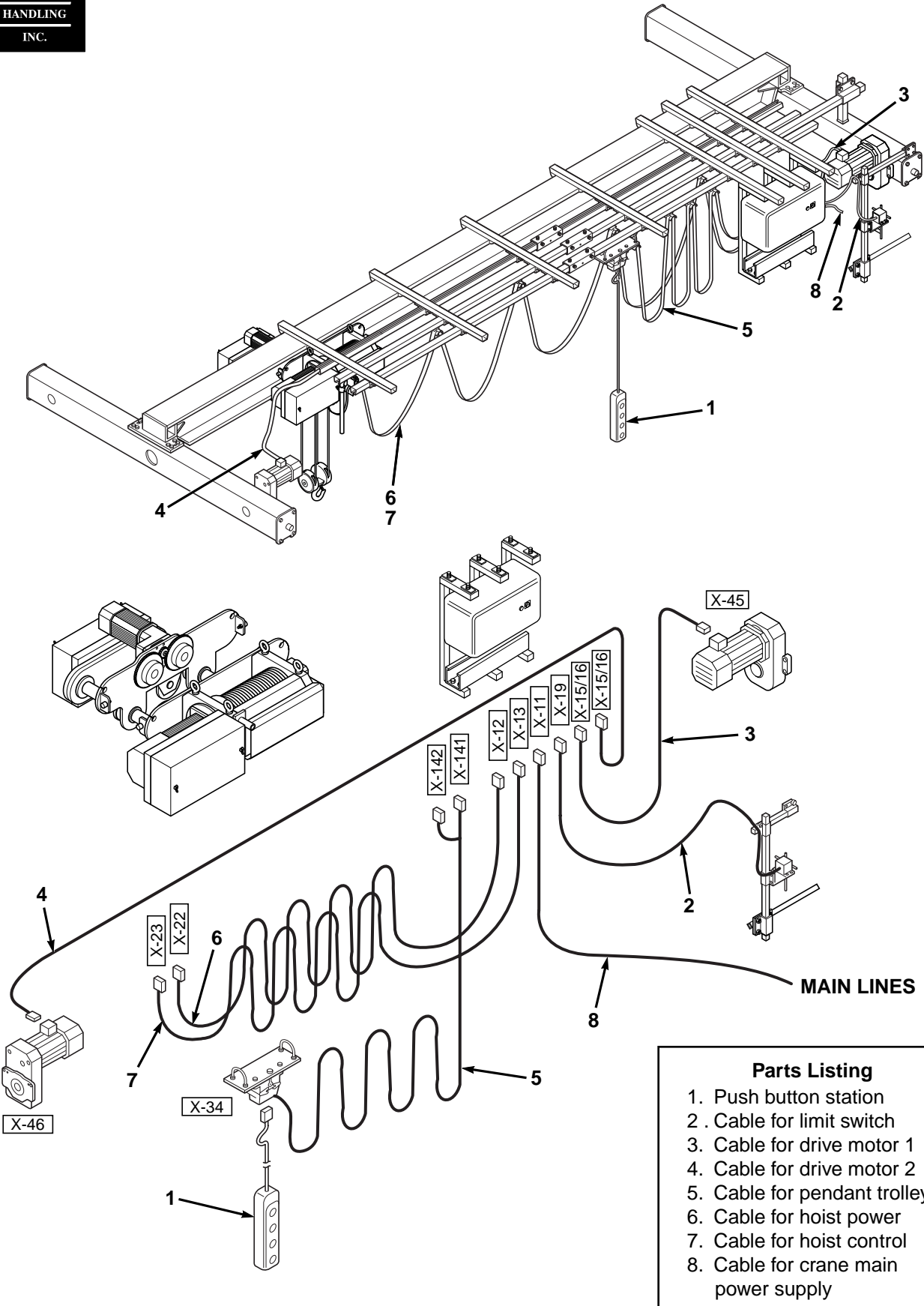
**! • MAKE SURE THE JOINT IS SMOOTH FOR TROLLEY TRAVEL. !**

- 1. Hoist power towing arm
- 2. Profile support rail
- 3. C-track
- 4. Joint clamp
- 5. Track support clamp
- 6. Beam clip
- 7. Pendant trolley
- 8. Cable trolley
- 9. End clamp
- 10. End stop for pendant trolley



**Parts Listing**

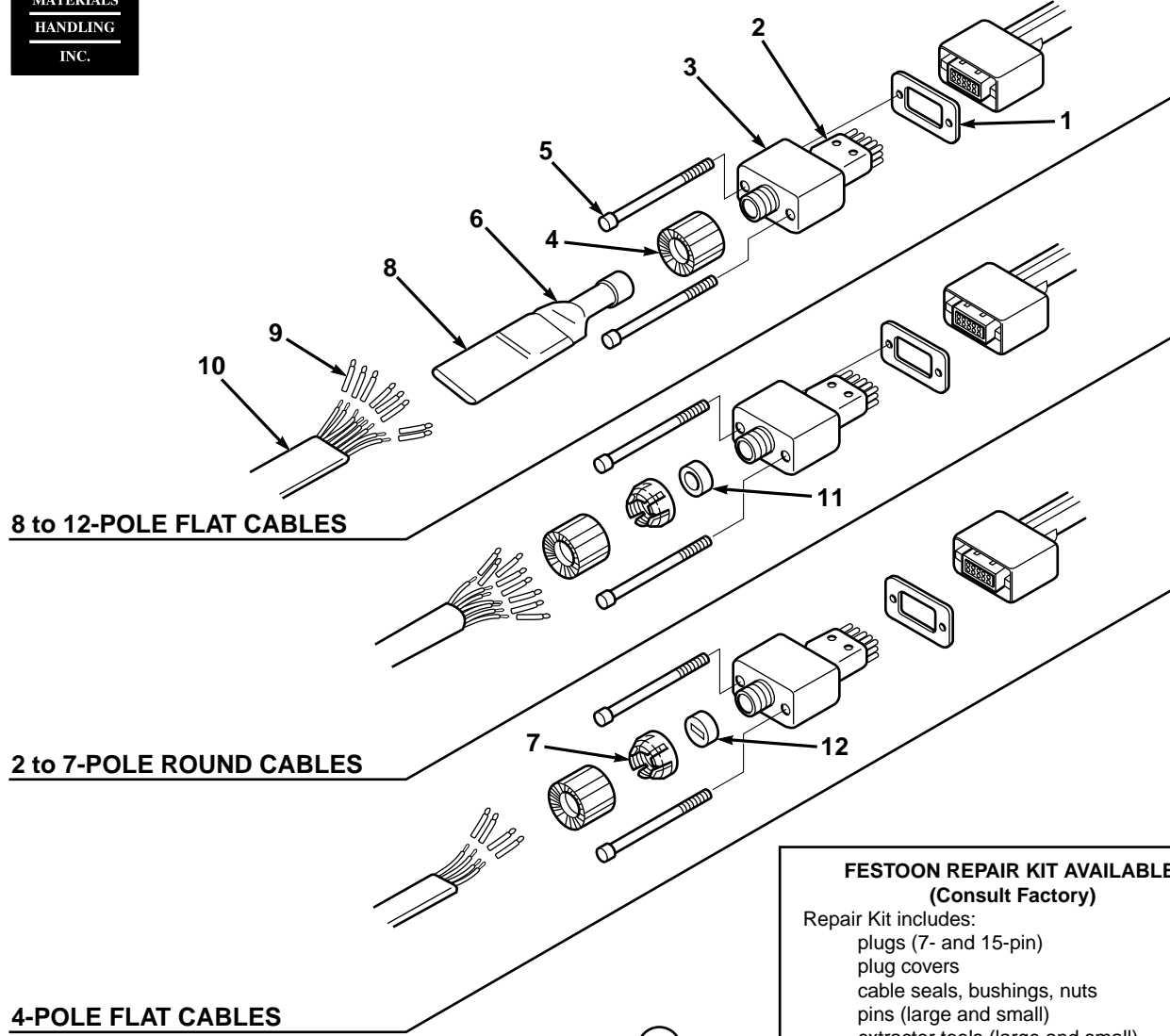
- |                  |                           |
|------------------|---------------------------|
| 1. Plate         | 7. Strain relief wire     |
| 2. Trolley       | 8. Wire clamp             |
| 3. U-bolt        | 9. Plug female            |
| 4. Nut           | 10. Plug male             |
| 5. Rubber washer | 11. Pendant cable         |
| 6. Eye bolt      | 12. Cable to bridge panel |



- Parts Listing**
1. Push button station
  2. Cable for limit switch
  3. Cable for drive motor 1
  4. Cable for drive motor 2
  5. Cable for pendant trolley
  6. Cable for hoist power
  7. Cable for hoist control
  8. Cable for crane main power supply

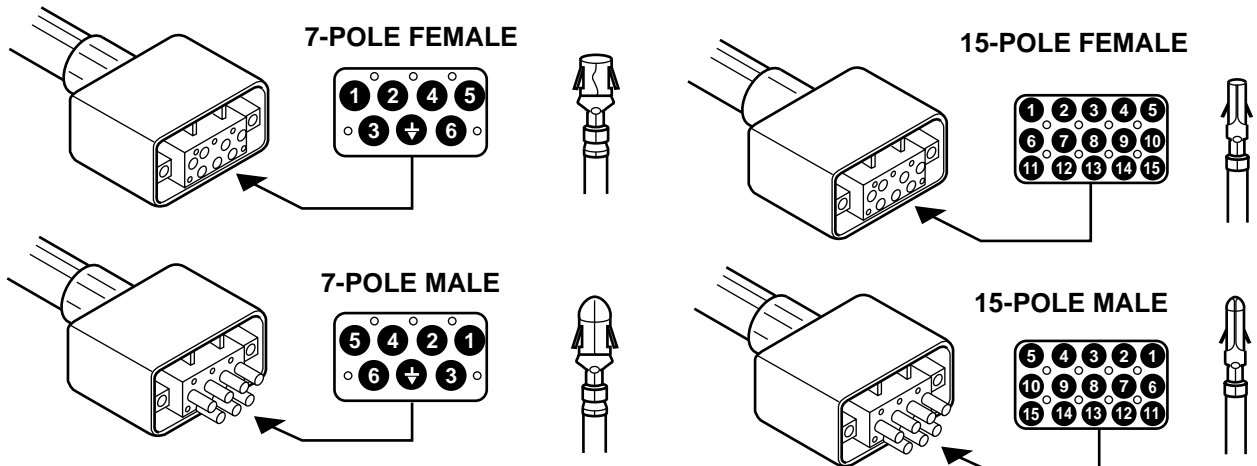


**PLUG CONNECTION ASSEMBLY  
Kit, Cranes, Plastic Plug**



**PLUG TYPES ②**

**FESTOON REPAIR KIT AVAILABLE  
(Consult Factory)**  
Repair Kit includes:  
plugs (7- and 15-pin)  
plug covers  
cable seals, bushings, nuts  
pins (large and small)  
extractor tools (large and small)  
cable end with shrink tube

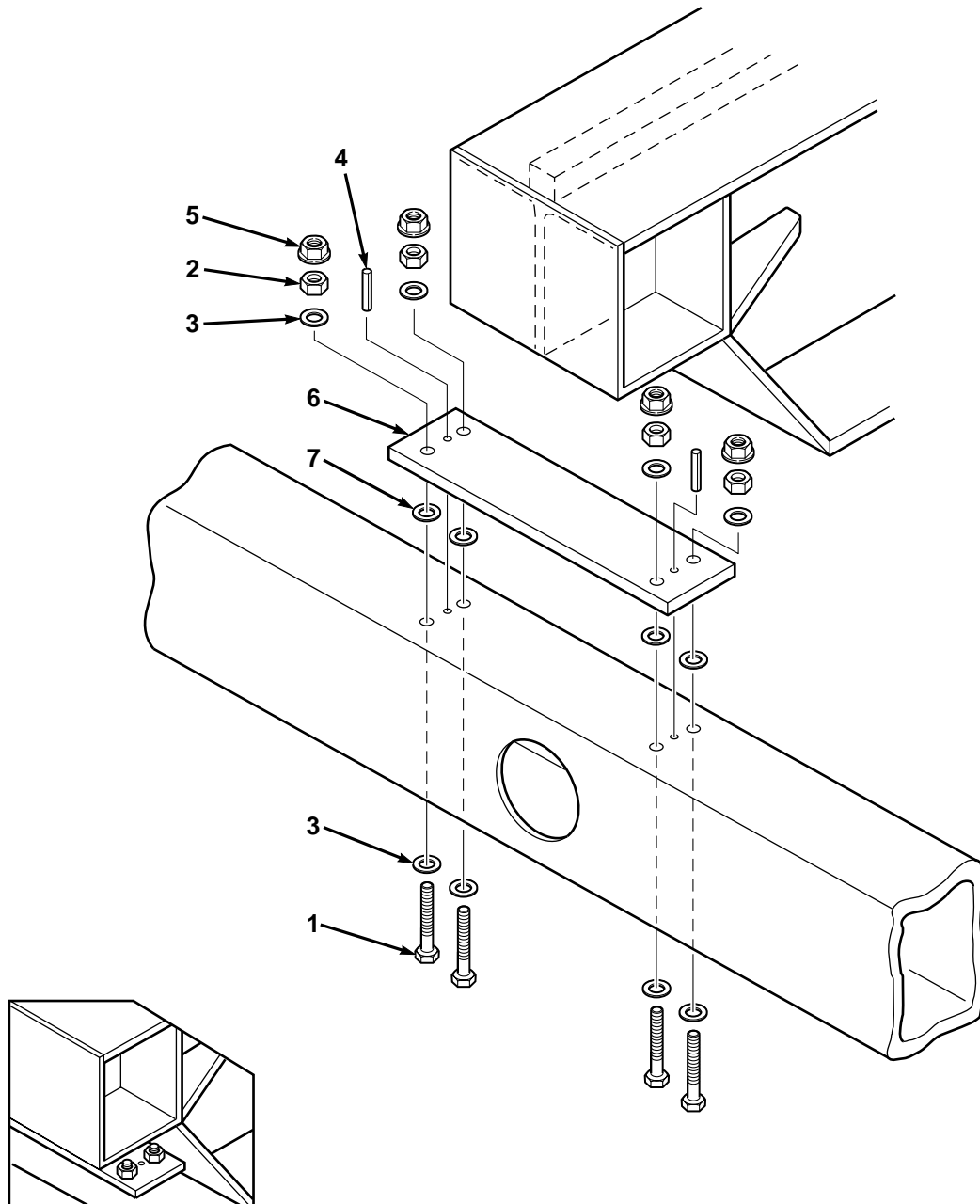


**Parts Listing**

- |               |                |                      |
|---------------|----------------|----------------------|
| 1. Seal       | 5. Bolt        | 9. Molex connector   |
| 2. Plug       | 6. Cable end   | 10. Cable            |
| 3. Plug cover | 7. Bushing     | 11. Round cable seal |
| 4. Nut        | 8. Shrink tube | 12. Flat cable seal  |

**QC2000 BULLETIN SGT-1**

**P-MED-B6**



**Parts Listing**

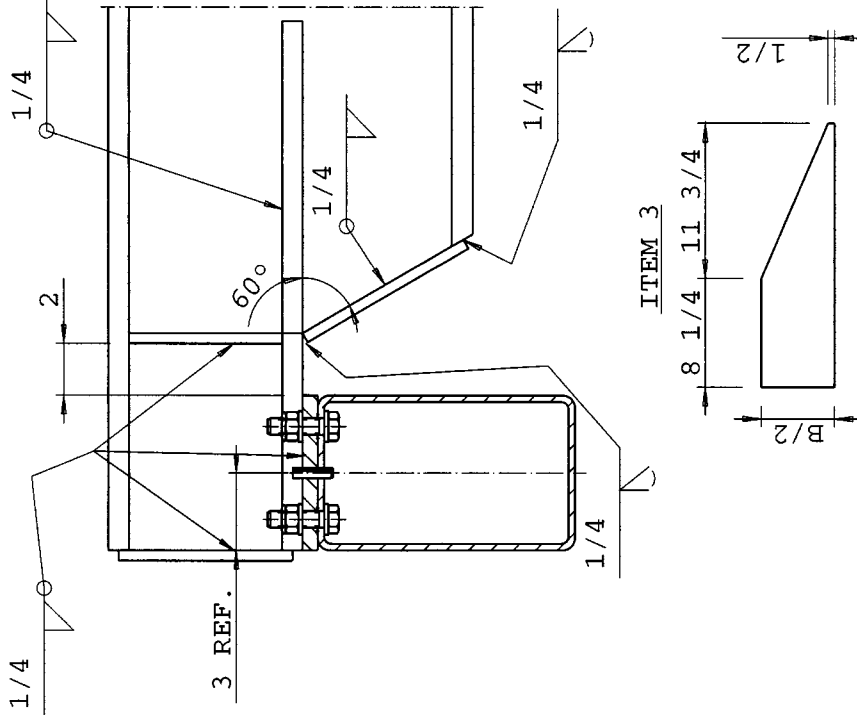
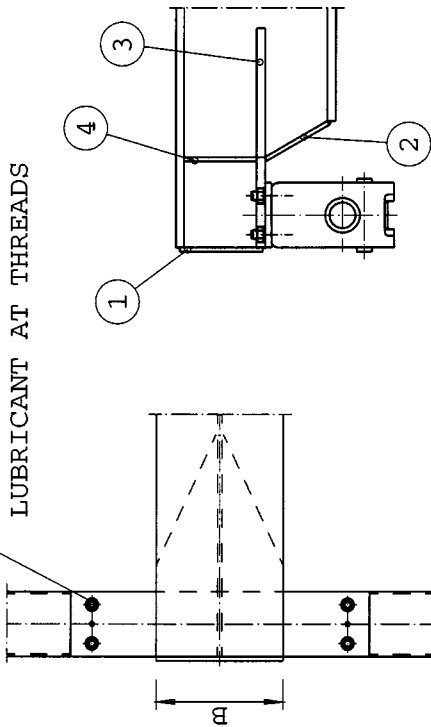
- |         |               |                |                  |
|---------|---------------|----------------|------------------|
| 1. Bolt | 3. Washer     | 5. Pal-nut     | 7. Friction ring |
| 2. Nut  | 4. Spring pin | 6. Joint plate |                  |

Included in	Revision explanation	Date	Drn	N-file
Issue		1998-06-29		

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**B = FLANGE WIDTH**  
**H = GIRDER HEIGHT**

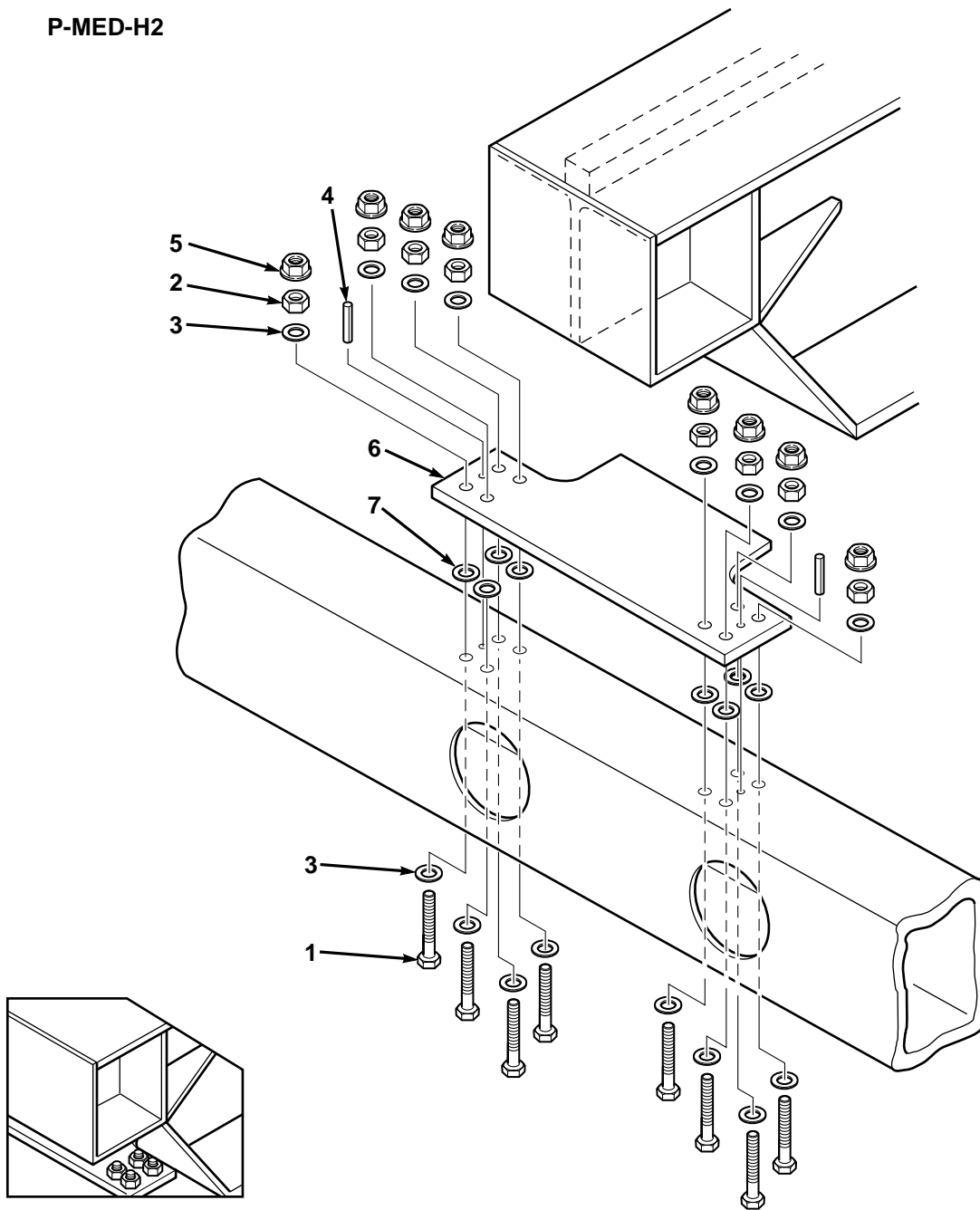
**TIGHTENING TORQUE 220 LB-FT**  
**USE APPROPRIATE LUBRICANT AT THREADS**



Item	Qty	Description	Specification	Quality	Weight
04	2	PLATE, 3/8" THK		A36	
03	2	PLATE, 3/4" THK		A36	
02	1	PLATE, 3/8" THK		A36	
01	1	PLATE, 3/8" THK		A36	

L	DATE	ECN	DESCRIPTION
Cochran, Mike	1998-06-29	1 : 12	P-PMEDB6
Design	Appd	Scale	File
			P-MED-B6 GIRDER CONNECTION
Drn	1998-06-29		R&M Materials Handling Inc.
Mis / Rev	Date		4501 Gateway Blvd, Springfield
R&M			PMEDB6
Issue			

**P-MED-H2**



**Parts Listing**

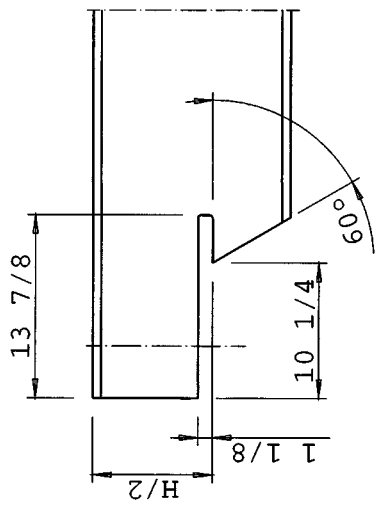
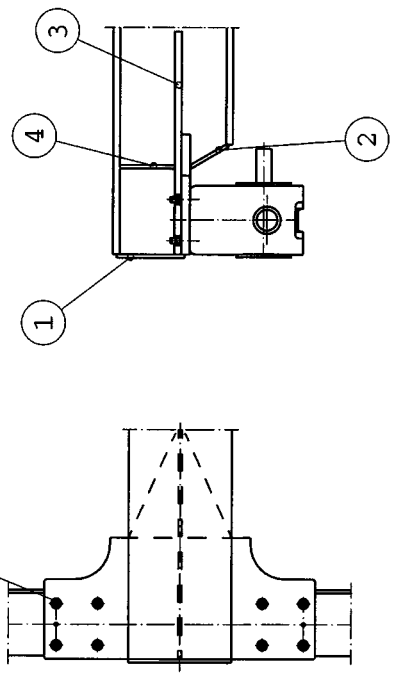
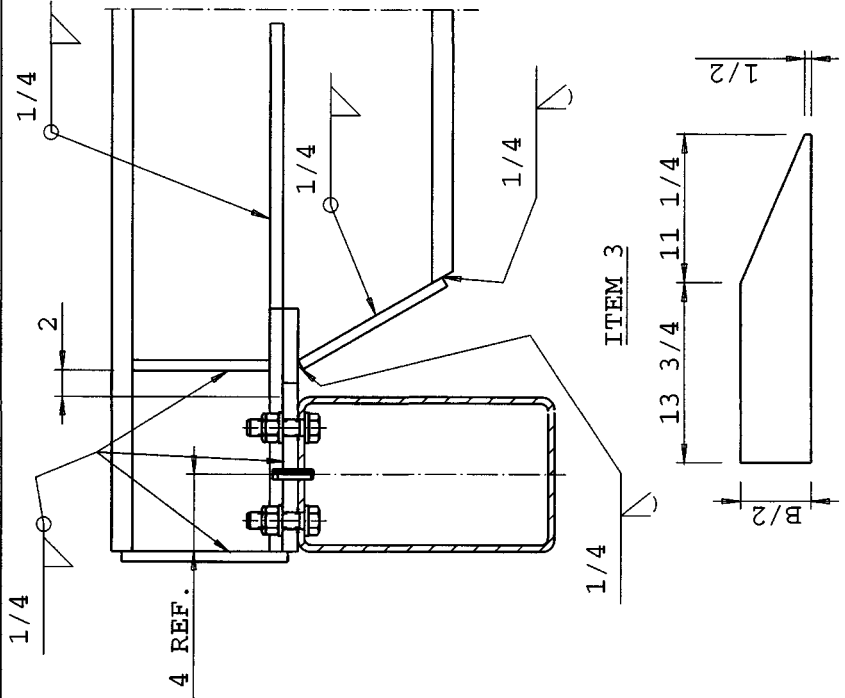
- |         |               |                |                  |
|---------|---------------|----------------|------------------|
| 1. Bolt | 3. Washer     | 5. Pal-nut     | 7. Friction ring |
| 2. Nut  | 4. Spring pin | 6. Joint plate |                  |

Included in		Revision explanation		Date	Drn	M-film
Issue				1998-06-29		

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**B = FLANGE WIDTH**  
**H = GIRDER HEIGHT**

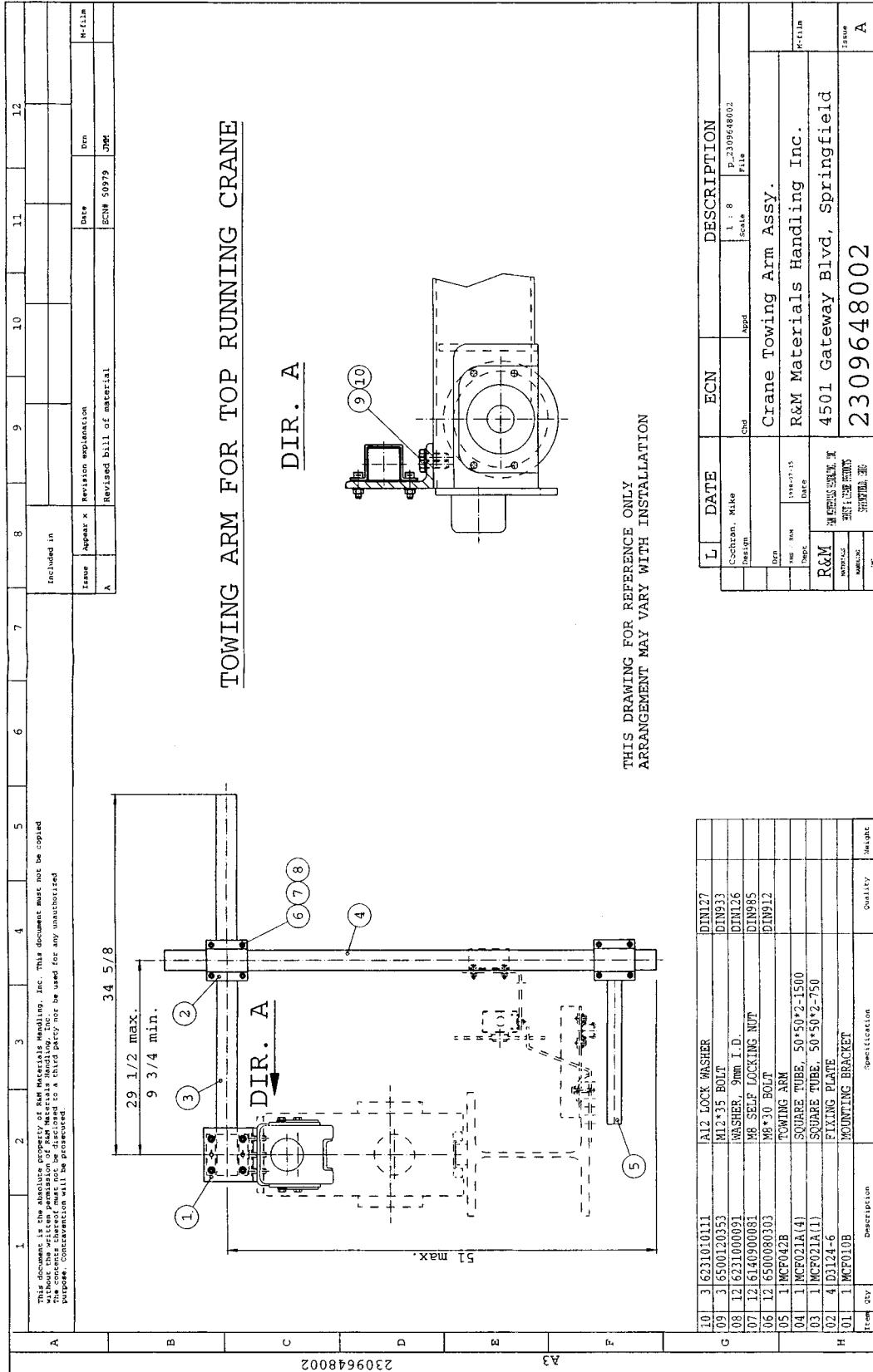
**TIGHTENING TORQUE 220 LB-FT**  
**USE APPROPRIATE LUBRICANT AT THREADS**



L	DATE	ECN	DESCRIPTION
Cochran, Mike		Chd	1 : 12 P_MEDH2
Design		Appd	File
Drn			
RHS / R&M	1998-06-29		
Dept	Date		
R&M			
R&M MATERIALS HANDLING, INC.			
4501 Gateway Blvd, Springfield			
SALES / CRM DEPT			
SKETCHED, JED			

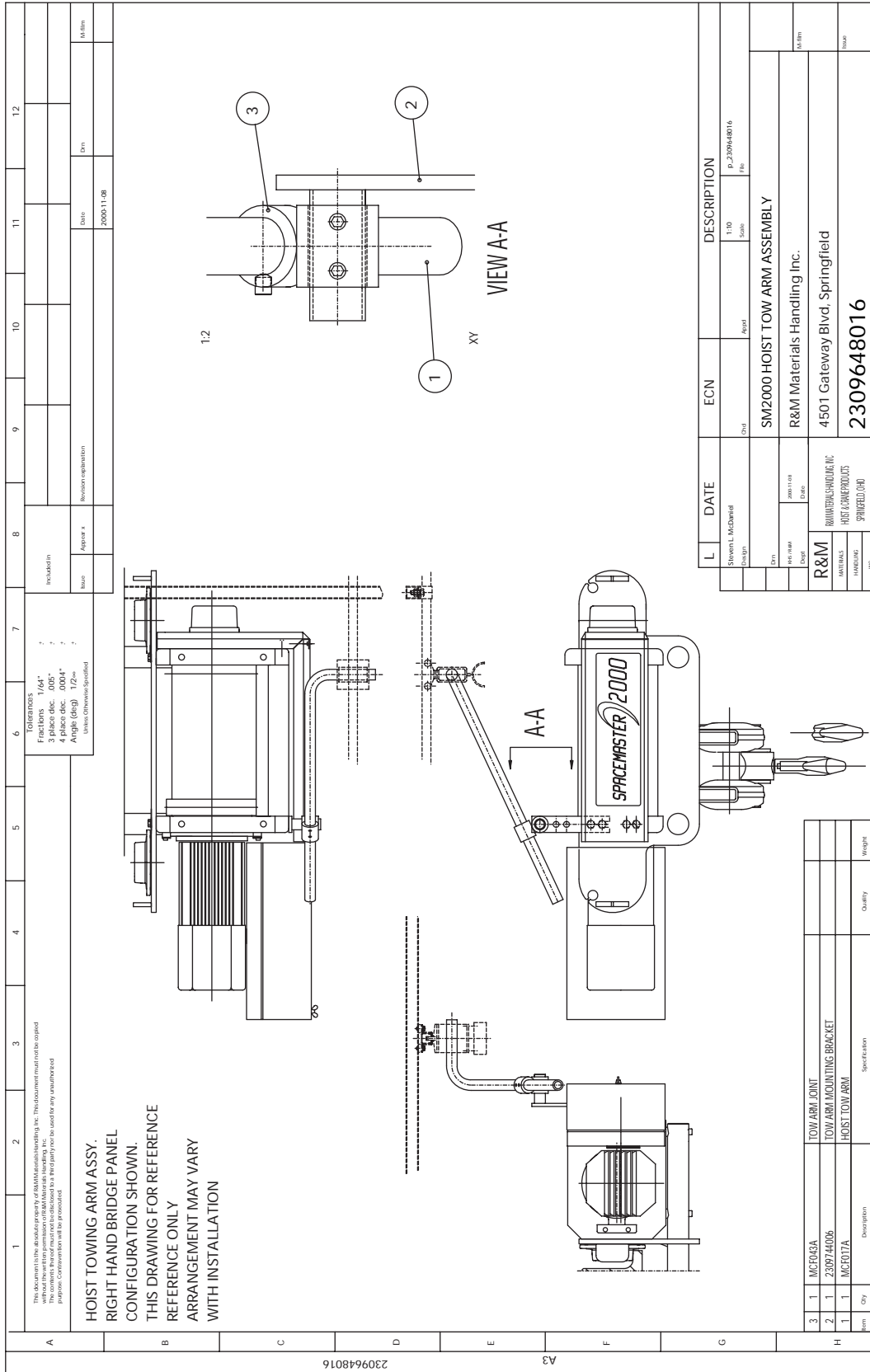
Item	Qty	Description	Specification	Quality	Weight
04	2	PLATE, 3/8"THK		A36	
03	2	PLATE, 3/4"THK		A36	
02	1	PLATE, 3/8"THK		A36	
01	1	PLATE, 3/8"THK		A36	





1	2	3	4	5	6	7	8	9	10	11	12	
Included in												
Issue	Appear x	Revision explanation						Date	Drn	R-File		
A		Revised bill of material						ECN# 50979	JMP			

L	DATE	ECN	DESCRIPTION
Cochran, Mike	1 : 8		
Design	Scale	File	
Drn	Ver	Appd	
Ver	Rev	Date	
Dept			
R&M	Crane Towing Arm Assy.		
4501 Gateway Blvd, Springfield	R&M Materials Handling Inc.		
2309648002	4501 Gateway Blvd, Springfield		
	A		

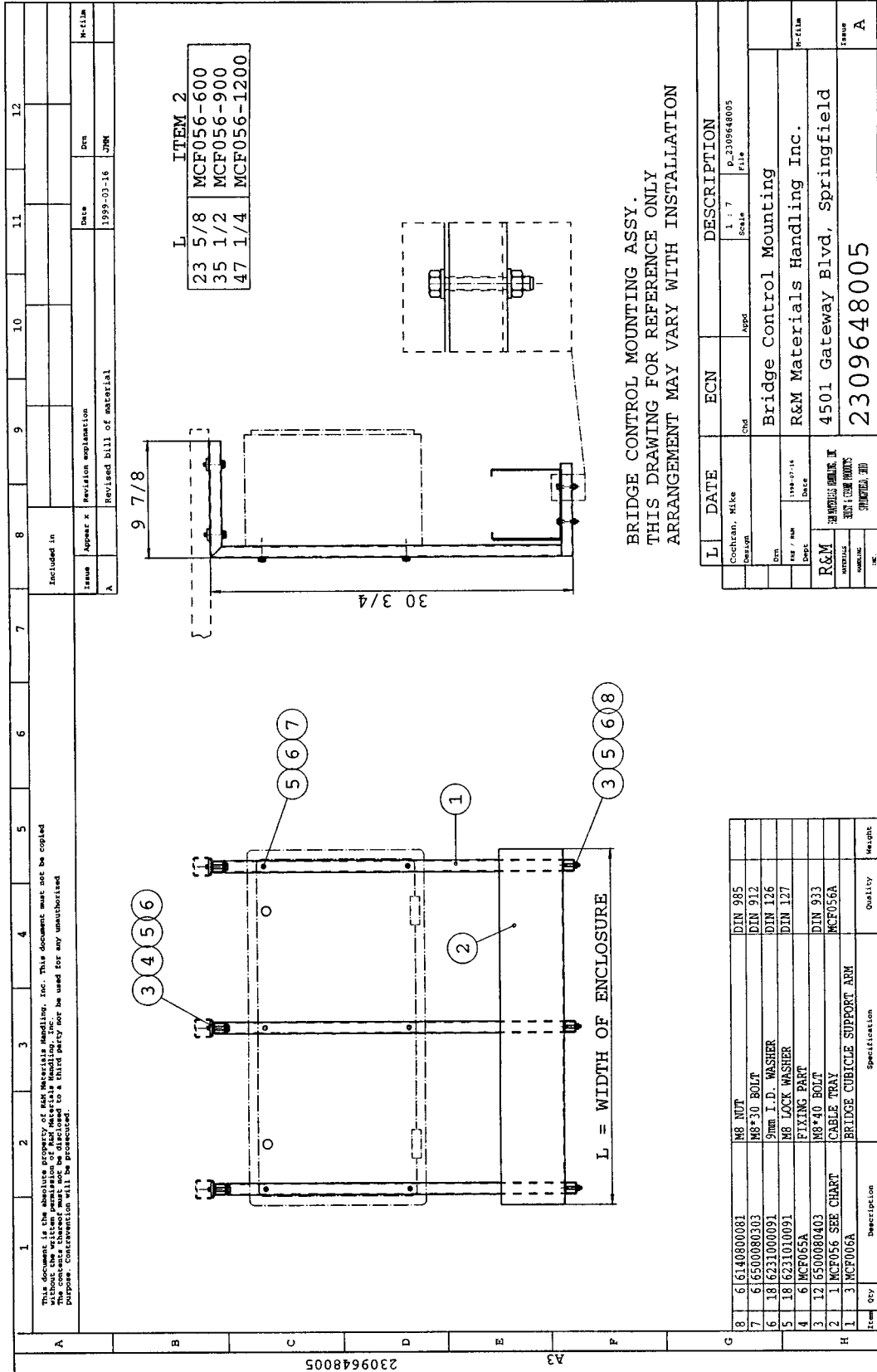


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**HOIST TOWING ARM ASSY.  
RIGHT HAND BRIDGE PANEL  
CONFIGURATION SHOWN.  
THIS DRAWING FOR REFERENCE  
REFERENCE ONLY  
ARRANGEMENT MAY VARY  
WITH INSTALLATION**

Item	Qty	Description	Specification	Quality	Weight
3	1	MCFR43A	TOW ARM JOINT		
2	1	239744006	TOW ARM MOUNTING BRACKET		
1	1	MCF017A	HOIST TOW ARM		

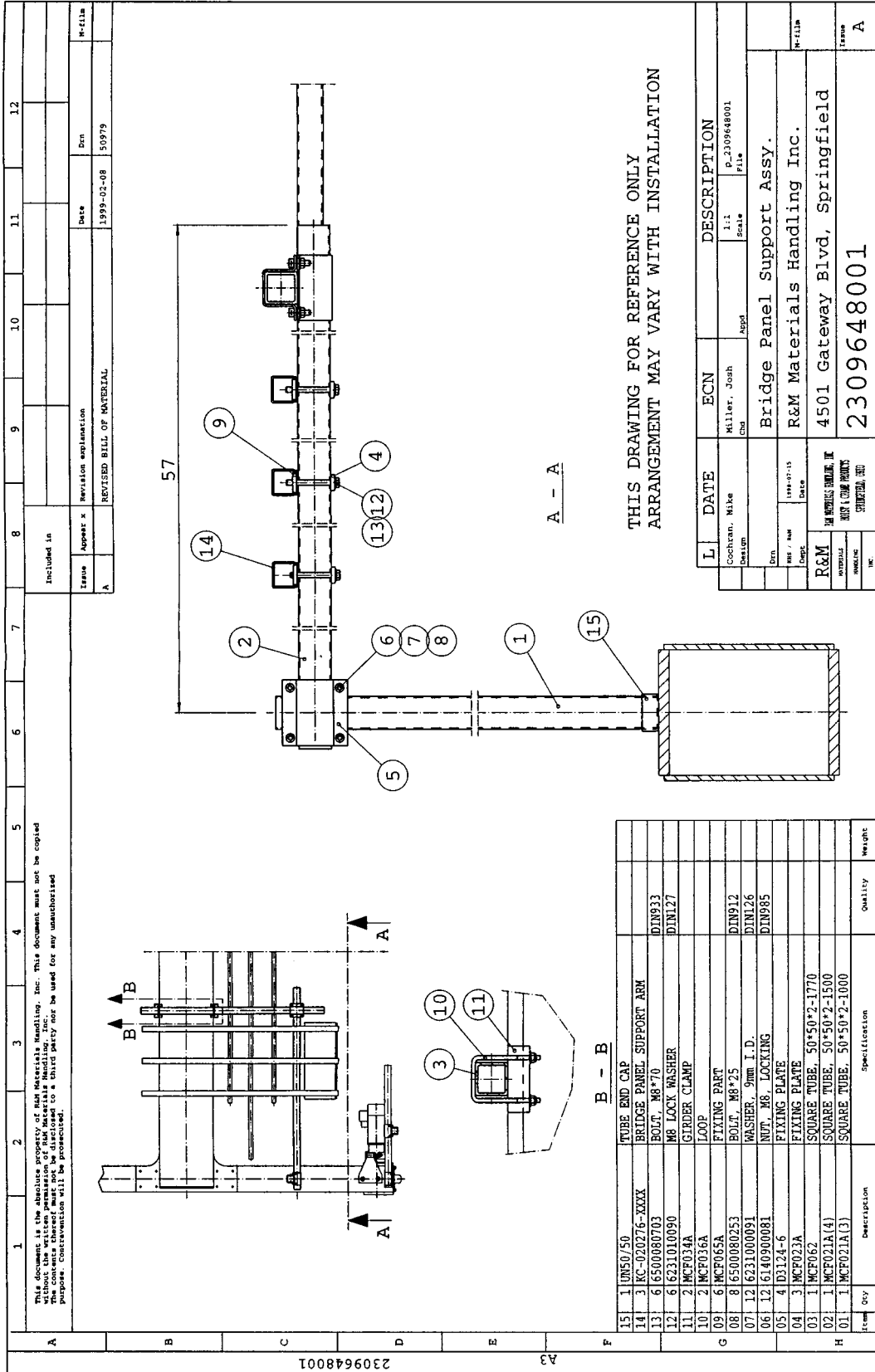
L	DATE	ECN	DESCRIPTION
Sheet 1 of 2	11/10/08		SM2000 HOIST TOW ARM ASSEMBLY
Design			R&M Materials Handling Inc.
Drawn			4501 Gateway Blvd. Springfield
Dept			2309648016
2008.11.08			
0.000			
R&M			
MATERIALS			
HANDLING			
INC.			



BRIDGE CONTROL MOUNTING ASSY.  
THIS DRAWING FOR REFERENCE ONLY  
ARRANGEMENT MAY VARY WITH INSTALLATION

Item	Qty	Description	Specification	Quality	Weight
8	6	M8 NUT	DIN 935		
7	6	M8*30 BOLT	DIN 912		
6	18	9mm I.D. WASHER	DIN 126		
5	18	M8 LOCK WASHER	DIN 127		
4	6	MCF056	FIXING PART		
3	12	M8*40 BOLT	DIN 933		
2	1	MCF056 SEE CHART	CABLE TRAY		
1	3	MCF056	BRIDGE CUBICLE SUPPORT ARM		

L	DATE	ECN	DESCRIPTION
Cochran, Mike	11-7	P.2309648005	
Design	Scale	File	
			Bridge Control Mounting
Drawn			R&M Materials Handling Inc.
Part / Rev	1999-03-16		
Dept.	Date		
R&M			4501 Gateway Blvd, Springfield
Material			
Part No.			2309648005
Rev.			
			A



THIS DRAWING FOR REFERENCE ONLY  
ARRANGEMENT MAY VARY WITH INSTALLATION

L	DATE	ECN	DESCRIPTION
Cochran, Mike	Miller, Josh	1:1	P. 2309648001
Design	Chk	Scale	File
Design	Appd		
Bridge Panel Support Assy.			
R&M	R&M		
4501 Gateway Blvd, Springfield			
2309648001			

Item	Qty	Description	Specification	Quality	Weight
13	1	UN50/50	TUBE END CAP		
14	3	KC-020276-XXXX	BRIDGE PANEL SUPPORT ARM	DIN933	
13	6	6500080703	BOLT, M8*70	DIN127	
12	6	6231010090	M8 LOCK WASHER		
11	2	MCF034A	GRIPPER CLAMP		
10	2	MCF036A	LOOP		
09	6	MCF065A	FIXING PART	DIN912	
08	8	6500080253	BOLT, M8*25	DIN126	
07	12	6231000091	WASHER, 9mm I.D.	DIN985	
06	12	6140000081	NET, M8 LOCKING		
05	4	D3124-6	FIXING PLATE		
04	3	MCF023A	FIXING PLATE		
03	1	MCF062	SQUARE TUBE, 50*50*2-1770		
02	1	MCF021A(4)	SQUARE TUBE, 50*50*2-1500		
01	1	MCF021A(2)	SQUARE TUBE, 50*50*2-1000		

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Issue	Appear x	Revision explanation	Date	Drn	M-File
A		REVISED BILL OF MATERIAL	1999-02-08	50979	

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