



Assembly Instructions 222R or 224R PowerTrak Carriage Systems (Opposed Chains)



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.

Follow all dimensions on 224R or 222R PowerTrak assembly print carefully.

Numbers in parentheses () correspond with chart shown on 224R or 222R PowerTrak print.

1. Bolt or weld rail channels to the floor or support. Maintain the distance between rails as shown on the print. If rails are elevated, provide a trough which is flush with the bottom of the rails. This trough would be required for the entire rail length.
2. Place the two PowerTraks (1) on the floor or trough between the rails.
3. Bolt down two stationary mounting brackets.
4. String cables or hoses through carriers (4) and (5).
5. Place support roller (7) on rails and roll along the rails. Repeat this operation until all support rollers (7) are on the rails.
6. Place guide roller (6) on rails one unit at each end and assemble its angle iron to the adjacent support roller assembly (7).
7. Assemble angle connectors (9) between each set of support roller assemblies (7).
8. Assemble intermediate roller (8) assemblies to angle connectors.
9. Roll completed assembly along rails to make sure of satisfactory operation.
10. Return carriage assembly over chain "A" of PowerTrak (1).
11. Loop end of chain "A" Powertrak (1) 180° and bring up over the guide roller (6).
12. Attach moving bracket to the movable carrying arm furnished by customer.
13. Move machine to extreme opposite travel position.

14. Repeat operations 11 and 12 for chain "B" of PowerTrak (1).
15. Loosen nuts on tension adjusting rods and drum shaft on the guide roller assembly (6).
16. Adjust tension on the PowerTraks (1) with the adjusting rod nuts at each end of the assembly (6). There should be 1/4" to 1/2" of clearance between the guide roller drum and the inside of the chain. Do not over tension chain as this will cause excessive wear on the guide rollers.
- 16a. PowerTrak should run centered between roller flanges. If PowerTrak runs to one side, tighten the adjusting rod on that side until PowerTrak centers on rollers. Failure to adjust properly will cause premature Powertrak and roller wear.
17. After carriage assembly is properly adjusted, tighten the shaft and adjusting rod nuts.
18. Attach cables or hoses to terminals or connectors.
19. PowerTrak & carriage are ready for operation.
20. Check carriage adjustment periodically.



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