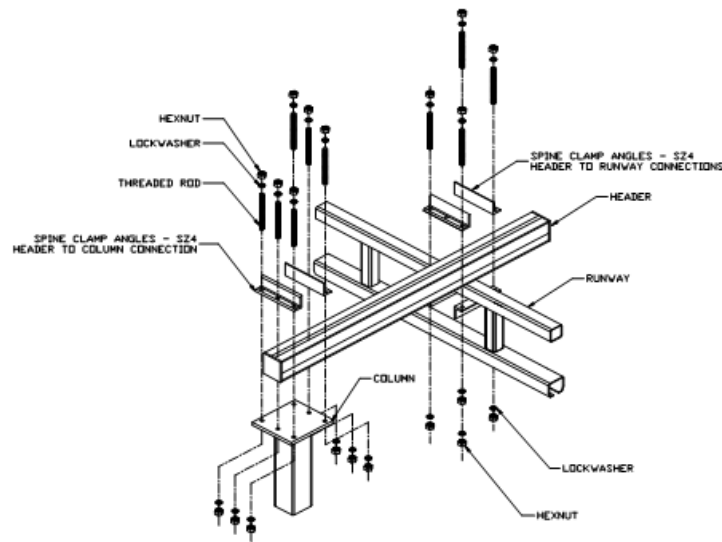


## Column to Header Weldment Connections

**Note:** The support structure for Gorbels® Free Standing Cranes are all bolted connections for seismic zone 4 conditions.

1. Lift and position header weldment onto two column weldments which have been secured to proper foundation requirements. Refer to General Arrangement Drawing for dimensions and header placement location.
2. Using clamp angles and hardware provided, attach header weldment to column weldment. Torque hardware as follows: 1/2" = 50 ft-lbs., 5/8" = 95 ft-lbs., 3/4" = 175 ft-lbs. There must be a minimum of two threads exposed at each end of threaded rod.



## Runway to Header Weldment Connection

1. Suspend runway section under installed support structure. Refer to General Arrangement for dimensions and runway locations.
2. Using clamp angles and hardware provided, attach runway section to header weldment as shown.
3. Check to make sure runway is level (within +/- 1/8") and parallel to opposite runway (within +/- 1/4") over a 20'-0" distance.
4. Tighten 5/8" hanger hardware to 95 ft-lbs. of torque per nut. There must be a minimum of two threads showing at both ends of the threaded rod.

**WARNING: Do not deviate from the bridge "span" dimension shown on the General Arrangement Drawing.**