

ASSEMBLY INSTRUCTIONS

Supply 'n Return™ GRAVITY FEED CART

DESCRIPTION

The *Supply 'n Return Gravity Feed Cart* provides a mobile parts bin supply system with two levels of gravity feed conveyors sloping toward the workplace and one bin return conveyor sloping toward the aisle. Slope of all levels of conveyors can be adjusted for optimum performance with various sizes and weights of bins. Bin boxes are not included. Optional side guides can be added to stabilize bins on conveyors. **Maximum rated capacity is 300 lbs.**

NOTE:

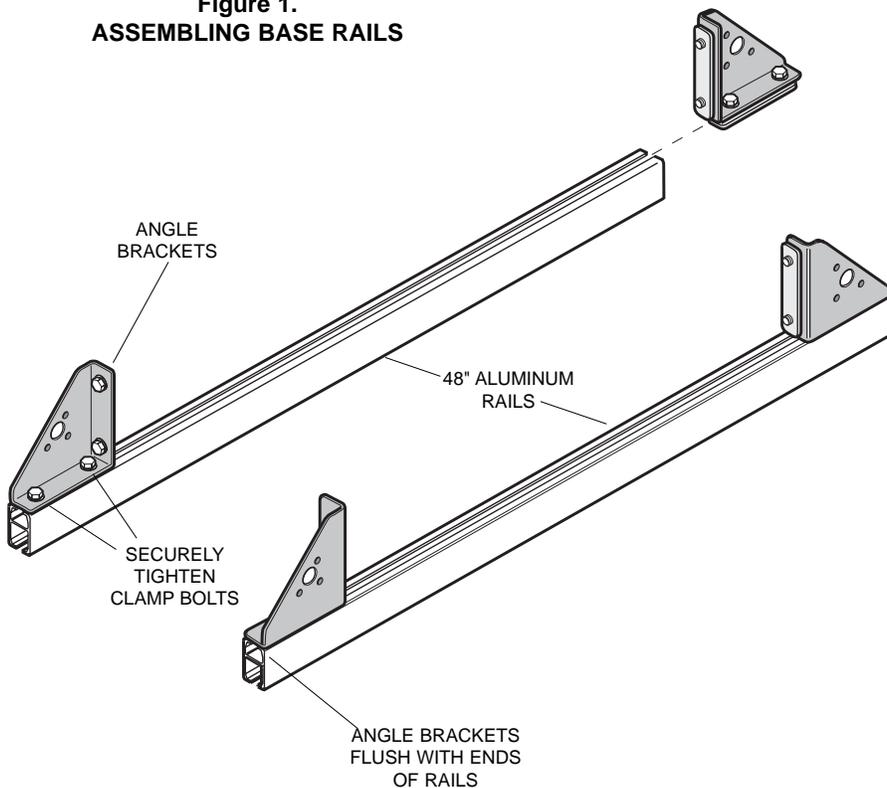
Prior to assembly, become familiar with the following instructions and names of components.

ASSEMBLY

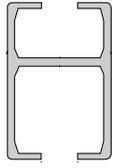
1. Locate four angle brackets and two 48" aluminum frame members. Place two 48" aluminum frame members on floor with large slot down. Affix angle brackets to frame members by sliding clamp plates into aluminum rails. Position as shown in Figure 1, and tighten track nuts to secure.



Figure 1.
ASSEMBLING BASE RAILS



IMPORTANT ASSEMBLY NOTES

1. Components are assembled using the Hubbell Workplace Solutions "ALIGN – SET – TIGHTEN" system. Brackets are clamped to aluminum extrusions with track nuts (single bolt) or clamp bars (two bolts) inside one of the two cavities. **Always install single bolt track nuts with widest dimension perpendicular to aluminum rail.**
2. All main frame members are extruded aluminum rail. Install with large cavity down. 
3. Shelf, coil holders, bin bar and all brackets are steel and shipped with assembly hardware (usually track nuts) installed. Some track nuts may have to be reversed (bolt head on opposite side of plate) for proper assembly.

- Assemble four 42.38" long uprights to angle brackets on base rails as shown in Fig. 3. Wrench tighten to secure.

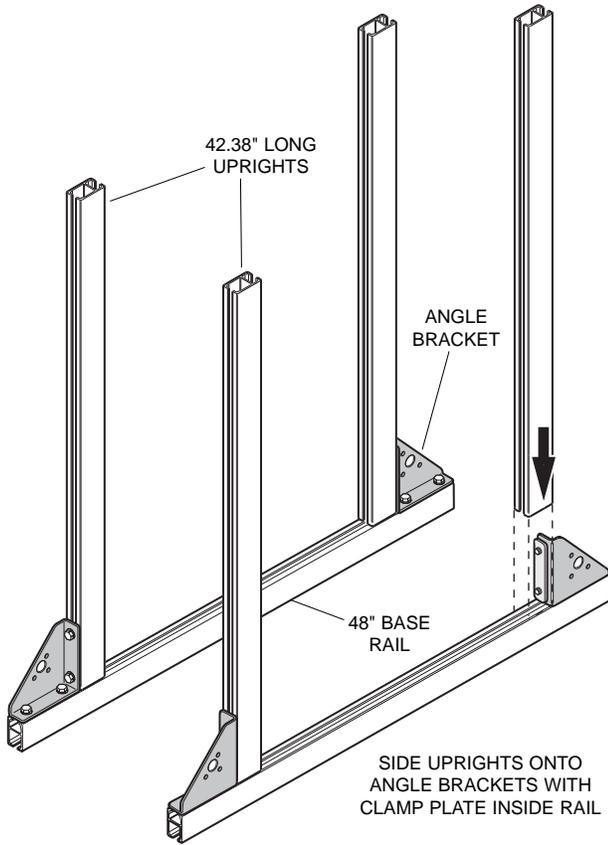


Figure 2.
ASSEMBLING SIDE FRAMES

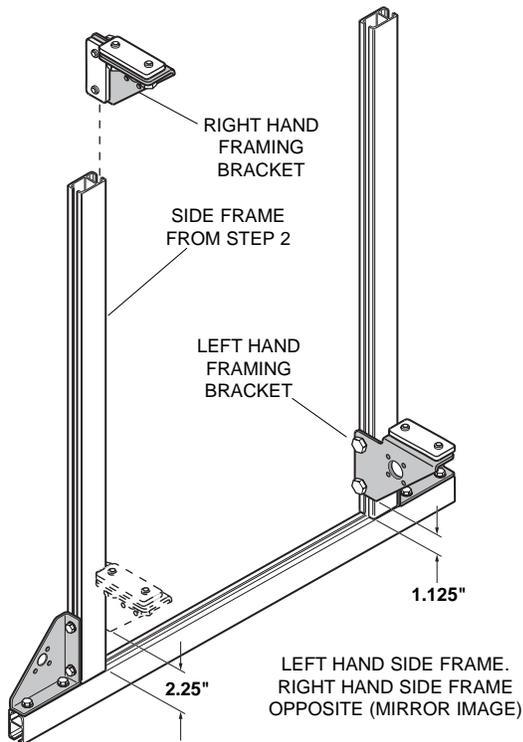


Figure 3.
ASSEMBLING SIDE FRAMES

- Locate one right-hand and one left-hand framing bracket. Slide framing brackets onto side frame uprights on one side frame assembly as shown in Figure 3. Position as shown and tighten. Repeat for other side frame assembly.

NOTE:

"Right hand" and "Left hand" sub-assemblies are required. Make side frames "mirror images".

- Join left and right side frames by standing assemblies upright with two 42.38" rails. Slide rails onto framing brackets with rails ends tight against side frame uprights. Tighten securely. (Fig. 4).

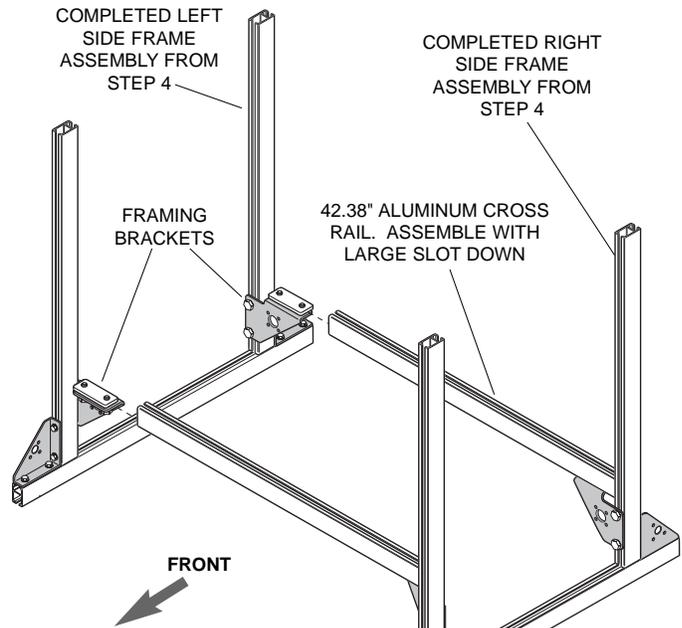


Figure 4.
JOINING SIDE FRAMES

- Locate remaining four 42.38" long cross rails, four left hand framing brackets and four right hand framing brackets. Assemble framing brackets to cross members. Finger tighten (Fig. 5).

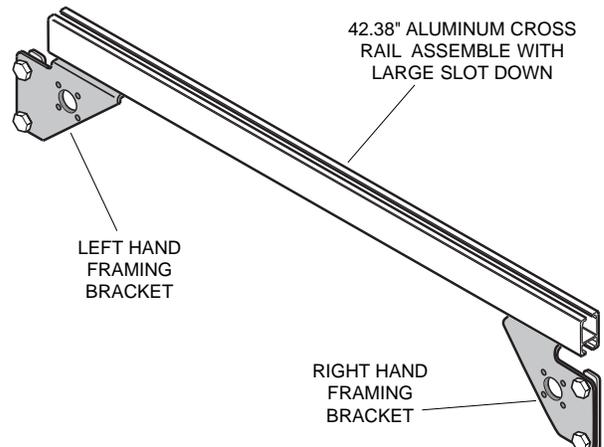


Figure 5.
ASSEMBLING CROSS MEMBERS

6. Mark heights for other four cross rails on uprights both side frames with (Fig 6). Note that top two cross rails on front uprights are installed lower than corresponding cross rails on back uprights so that bins will roll to front on roller conveyors. Bottom cross rails (already installed) are higher at front to facilitate bin return (Fig. 6a).

NOTE: Slope and spacing of roller conveyors may be adjusted for optimal performance following assembly.

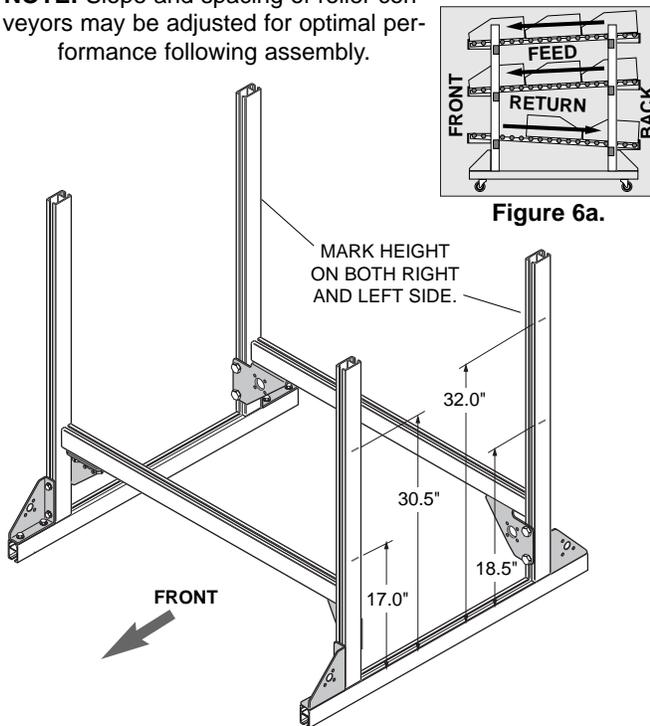


Figure 6a.

Figure 6.
MARKING CROSS RAIL LOCATIONS

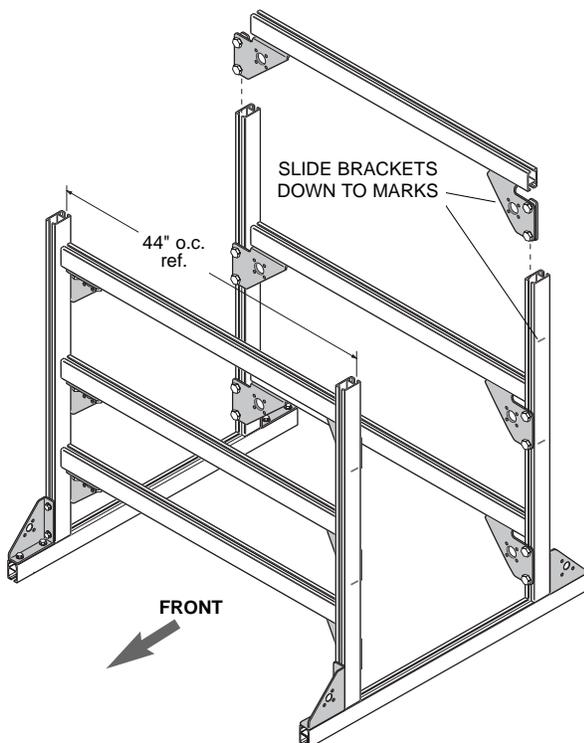


Figure 7.
INSTALLING CROSS RAILS

7. Install cross rails from Step 5 by sliding brackets down uprights until bottom of brackets are on marks made in Step 6. Finger tighten bolts to hold on marks (Fig. 7).

8. Push side frames together tight against cross rails (uprights 44" o.c.) and fully tighten all bolts.

9. Tip assembled frame on its side and install casters (Fig. 8). Secure with wrench supplied.

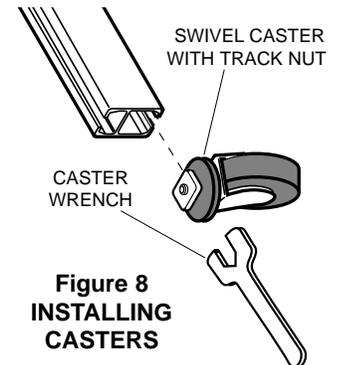


Figure 8
INSTALLING CASTERS

10. Stand frame upright. Mark cross rails with desired spacing of roller conveyors, Six on each level. Consider the size and type of bins which will be used on the cart.

11. Install the roller conveyor sections on the cross rails by inserting the **E-Z NUT** into the slot in the rail, aligning the conveyor with the mark, and finger tightening the bolt while making sure the **E-Z NUT** turns in the rail for maximum grip. Ensure conveyor channel ends are equal distance from cross rails (conveyor centered on rails). Fully tighten bolts when conveyor sections are properly placed (See Figures 9 & 9a).

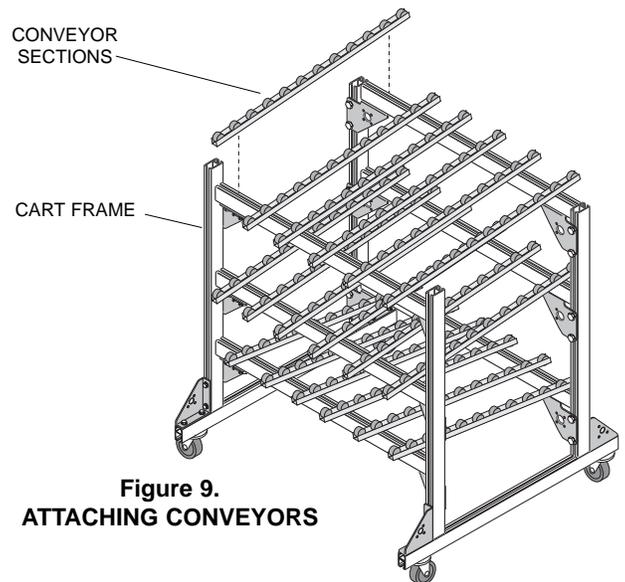


Figure 9.
ATTACHING CONVEYORS

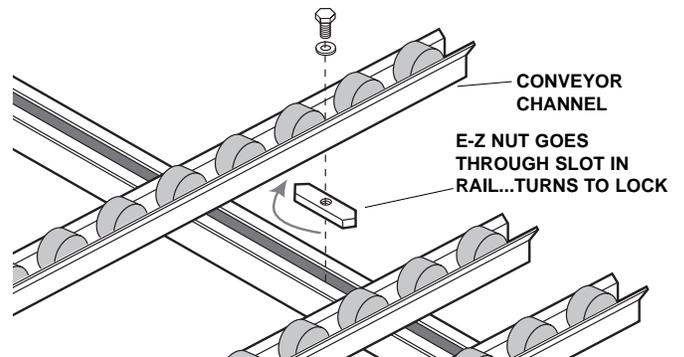


Figure 9a.
E-Z NUT DETAIL

12. Install stop/guard brackets onto uprights of frame. Slide brackets onto uprights from top (Fig. 10). The top of stop brackets should be positioned 0.75" ABOVE the end rollers on the low end. The top of the guard brackets should be positioned 0.0625" BELOW the end rollers on the high end.

NOTE:

Stop brackets and guard brackets are identical. Stop brackets are used on the LOW end of the conveyor strips to provide bin stops. Guard brackets are installed on the HIGH end of the strips to prevent injury to people using the cart.

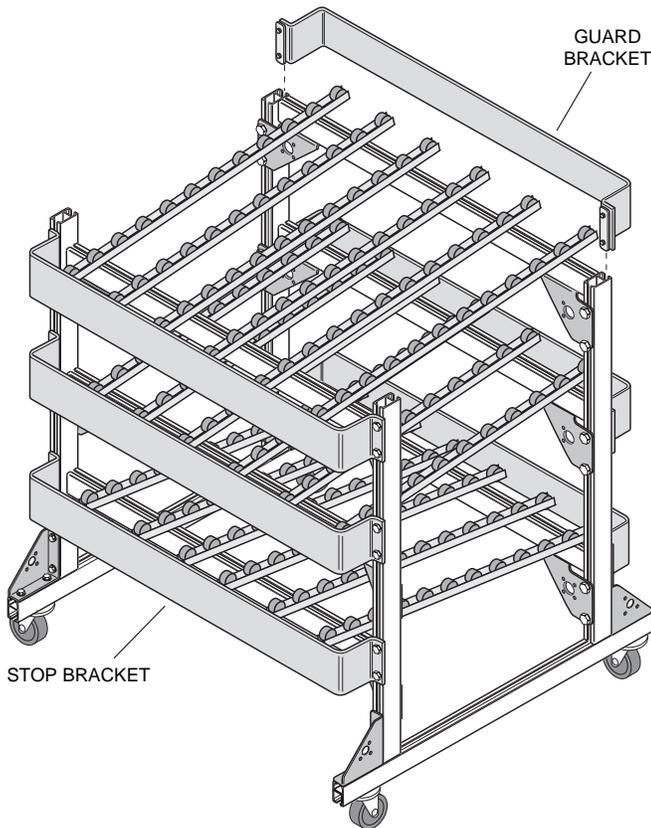


Figure 10.
INSTALLING STOP/GUARD BRACKETS

13. Install end caps on the top of uprights and on each end of 48" base rails.
14. Check to make sure all bolts are tight and that unit is square (all four casters firmly on floor). Adjust as necessary.
15. Test by placing loaded bins on cart, allowing them to roll down against stop. Adjust spacing of conveyor strips and, if required, increase or decrease conveyor slope by raising or lowering cross rails to obtain optimal performance with bin sizes and loads to be used.



Workplace Solutions

INSTALLING OPTIONAL BIN GUIDES

DESCRIPTION

Bin guides are fences that prevent side-to-side movement of the bins while traveling down the roller conveyors and are most often used with smaller bins. They are usually installed in pairs, spaced slightly wider than the bin width. With proper conveyor strip spacing, one bin guide can be used between two bin tracks.

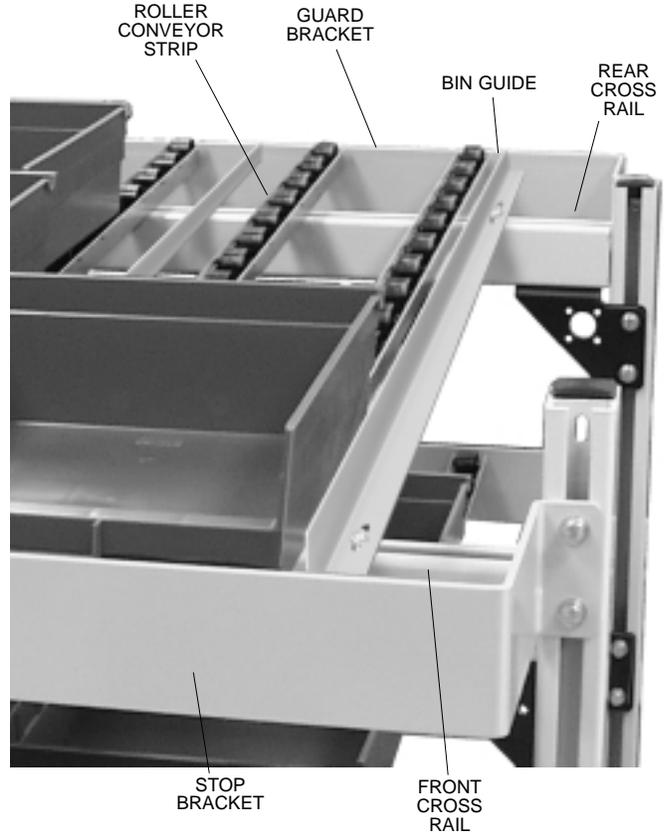


Figure 11.
INSTALLING OPTIONAL BIN GUIDES

INSTALLATION

1. Bin guides are attached using an **E-Z NUT** on each end (refer to Figure 9a). Determine proper spacing for guides and insert **E-Z NUTS** through slots in rails.

NOTE:

For best results, bin guides must be installed parallel with conveyor strips.

2. Finger tighten the bolts making sure the **E-Z NUTS** turn within the rail for a firm grip. Fully tighten bolts when guides are properly positioned.
3. Test by placing bins on cart and reposition conveyor strips and guides for best results.

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