



Installation Instructions

Layer Picker Rail Assembly Installation

This sheet provides instructions to install a rail guide assembly. The rail guide keeps the truck and layer picker running parallel between the guide rails in a pick line. With the proper truck clearance, the truck can travel from one end to the other with minimal steering required. Cased loads on pallets or slipsheets are stacked alongside the pick line against either side of the rail.

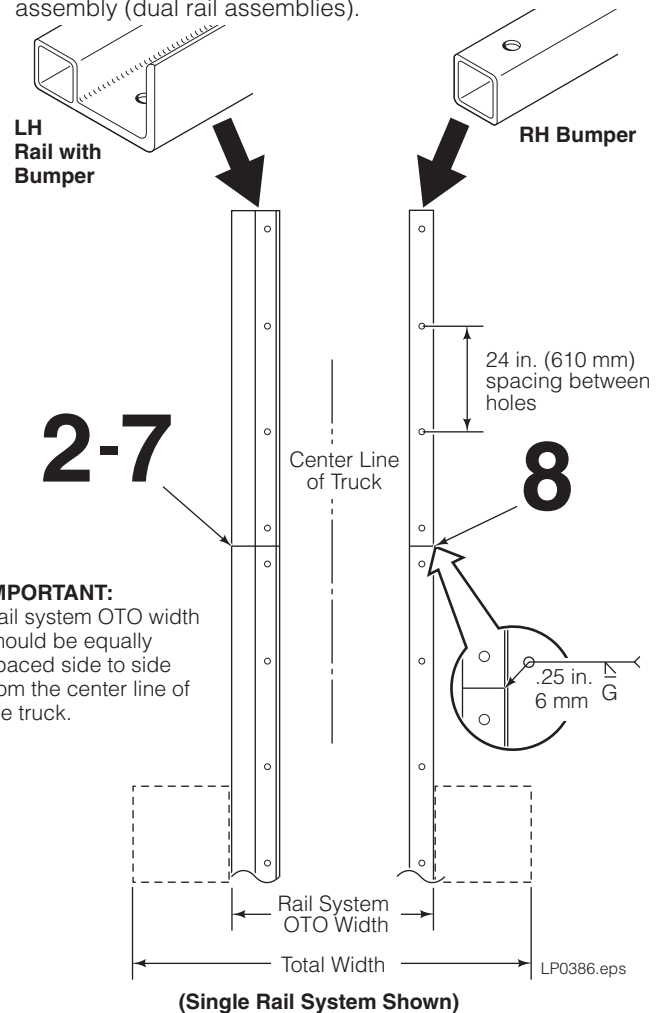
- 1 Determine a location where the rail assembly will be installed. The location should account for desired length and total width (refer to note below).
- 2 Position the LH rails and/or bumpers with the ends touching, keeping the rails straight.
- 3 Preheat the ends to 70°F (21°C) minimum and tack weld the ends. Use the recommended weld procedures listed below.
- 4 Check the alignment of the rails/bumpers, realign as required.
- 5 Finish-weld the rail/bumper joints using the following weld procedures.
 - Protect the tube holes from splatter.
 - Preheat rail base metal to 150°F (66°C). Monitor at locations shown using suitable temperature indicating devices.
 - Weld rail joints together. Run the weld around the rail joints. Overlap the start position to eliminate arc craters. Use one of the following weld methods:

	FCAW (Flux-Cored Arc Weld)	SMAW (Shielded Metal Arc Welding)
Electrode	E701-1 ■	AWS E-7018
Electrode Diameter	.06 in. (1.5 mm)	.15 in. (4 mm)
Gas	100% CO2 @ 30-45 CFH	—
Amperage	Per Manufacturers Recommendation	Per Manufacturers Recommendation

- Do not use electrodes exposed to moisture without first redrying them at 200 °F (75 °C) for two hours.
- Apply weld using a close arc. Do not oscillate or use wash bead pattern. Cool metal at normal air cool.

- 6 Remove slag and inspect welds for defects.

NOTE: Arc craters, undercut, overlap and porosity are not permitted. Repair any defect as required.
- 7 Grind all welds to smooth transitions between sections.
- 8 Repeat steps 2 through 7 for the RH bumper or RH rail assembly (dual rail assemblies).



IMPORTANT:
Rail system OTO width should be equally spaced side to side from the center line of the truck.

NOTE: Total width = Truck tire track width + (load depth x 2) + roller system width + LH rail/bumper width + RH rail/bumper width + (layer picker arm thickness x 2)

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- 9 Position the LH rail/bumper assembly allowing room for loads.
- 10 Mark the floor with the LH rail/bumper assembly hole locations.
- 11 Cascade recommends using a .75 in. diameter x 5.25 in. length anchors. Using a .75 in. (19.05 mm) diameter carbide drill, drill the marked locations to a depth as necessary to secure the rail(s) to the concrete. Clear holes of dust by using compressed air or a wire brush and vacuum.
- 12 Align LH rail/bumper assembly and drilled holes to install anchors:

Sleeve Anchor – Place anchor through rail or bumper and into floor hole. Tap until washer is against rail. Finger tighten and then use a wrench to tighten to 90 ft.-lbs. (122 Nm).

Wedge Anchor – Place nut on threaded end with washer to protect threads. Place anchor through rail or bumper into floor hole. Tap into place. Finger tighten and then use a wrench to tighten to 85 ft.-lbs. (115 Nm).

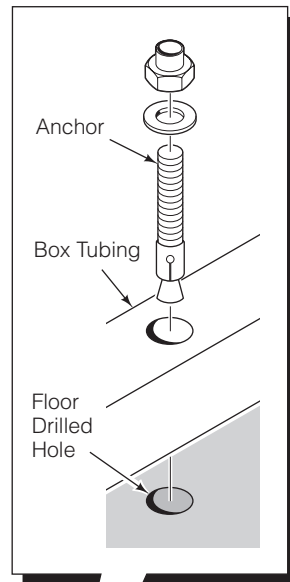
- 13 Repeat steps 10 through 12 for the RH bumper or RH rail assembly (dual rail assemblies). Width between rails is determined by taking the truck tire outside-to-outside width and adding one of the following:

Single Rail Systems – 6.5 in. (165 mm). **NOTE:** The truck should be 6 in. (152 mm) from the rail and .5 in (13 mm) from the bumper

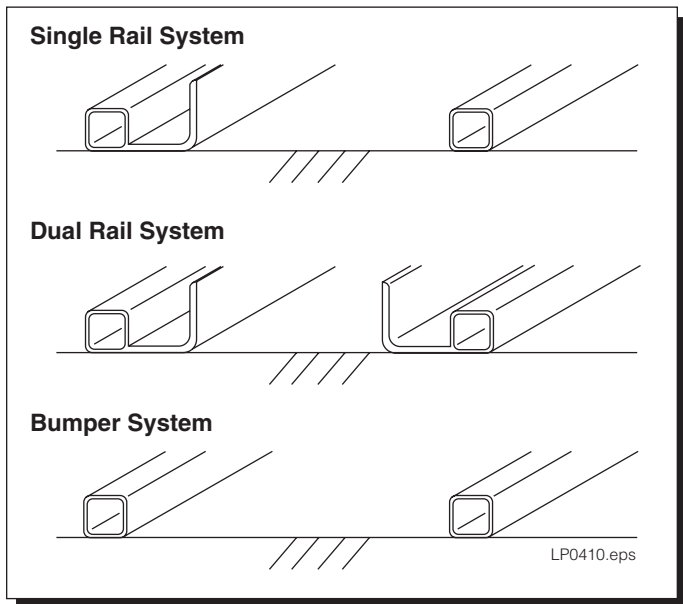
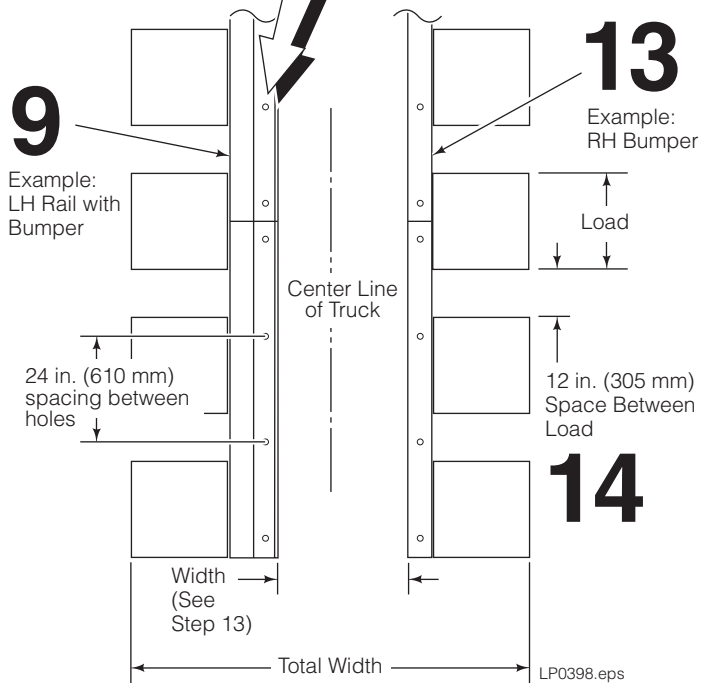
Dual Rail Systems – 12 in. (305 mm)

Bumper Systems (no rails) – 1 in. (25 mm)

IMPORTANT: Rail system width should be equally spaced side to side from the center line of the truck.



10,
11,
12



- 14 For linear load placement, allow 12 in. (305 mm) space between loads.

(Single Rail System Shown)

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