

# ASSEMBLY INSTRUCTIONS

## GRAVITY FEED STAND

### DESCRIPTION

The **Gravity Feed Stand** provides a readily adjustable parts and hardware bin supply system with two levels of gravity feed conveyors sloping toward the workplace. Slope and spacing of conveyors can be adjusted for optimum performance with various sizes and weights of bins. Bin boxes are not included. **Maximum rated capacity is 300 lbs.**

### NOTE:

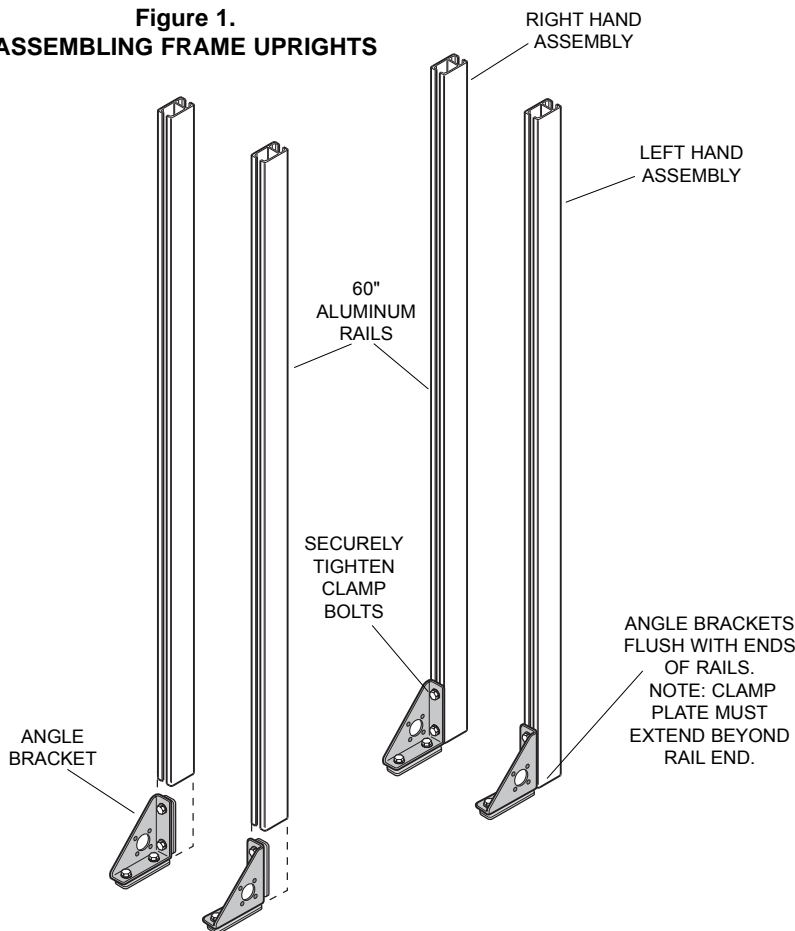
Prior to assembly, become familiar with the following instructions and names of components.

### ASSEMBLY

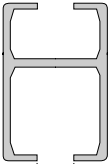
1. Locate four angle brackets and four 60" aluminum rails. Install angle brackets to rails by sliding clamp plates into aluminum rails. Position so that bottom of angle bracket is flush with end of rail (Fig 1). Make sure there are two right hand assemblies and two left hand assemblies and shown in illustration. Tighten track nuts to secure angle brackets to rails.



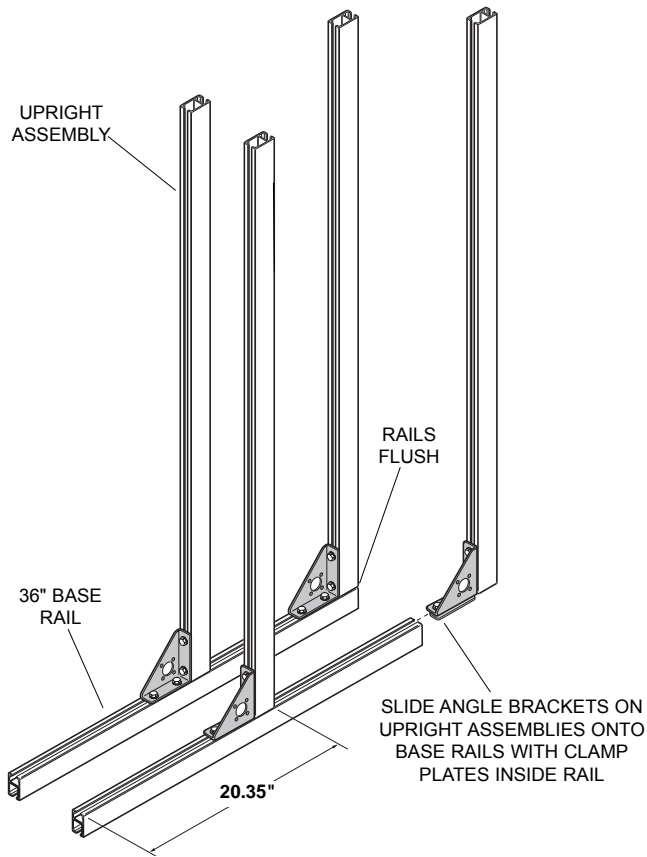
**Figure 1.**  
**ASSEMBLING FRAME UPRIGHTS**



### IMPORTANT ASSEMBLY NOTES

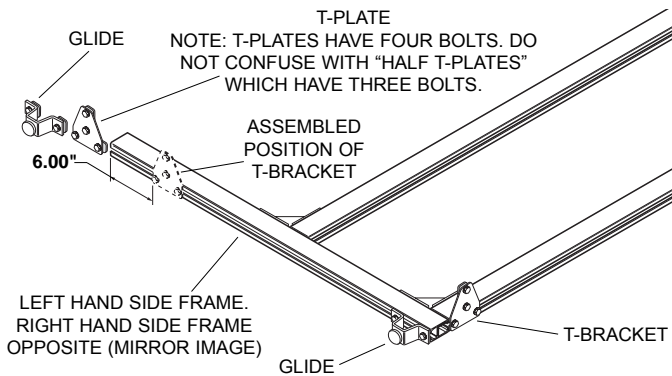
1. Components are assembled using the Hubbell Workplace Solutions "ALIGN – SET – TIGHTEN" system. Brackets are clamped to aluminum extrusions with track nuts (single bolt) or clamp bars (two bolts) inside one of the two cavities. **Always install single bolt track nuts with widest dimension perpendicular 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 upright assemblies to 36" base rails as shown in Fig. 3. As in Step 1, make sure there is a right hand and a left hand (mirror image) assembly. Wrench tighten to secure.



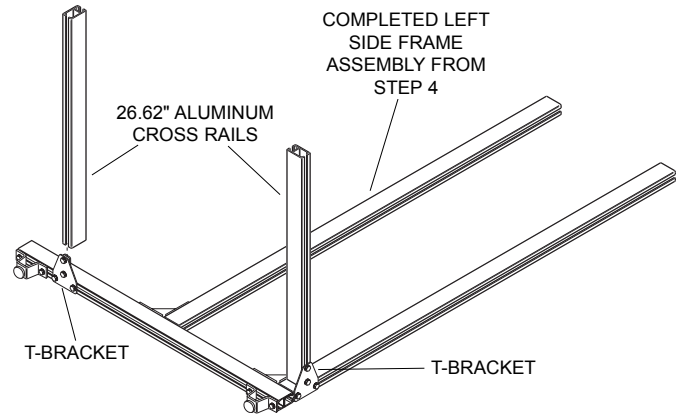
**Figure 2.**  
**ASSEMBLING SIDE FRAMES**

- Lay left hand side frame on floor with webs in angle brackets down. Slide one T-plate onto 60" rail so that edge of plate is flush with side of 36" base rail. Install second T-plate and two glide assemblies on base rail as shown in Figure 3. Repeat for right hand side frame. Make sure two finished assemblies are mirror images. Securely tighten clamp bolts.



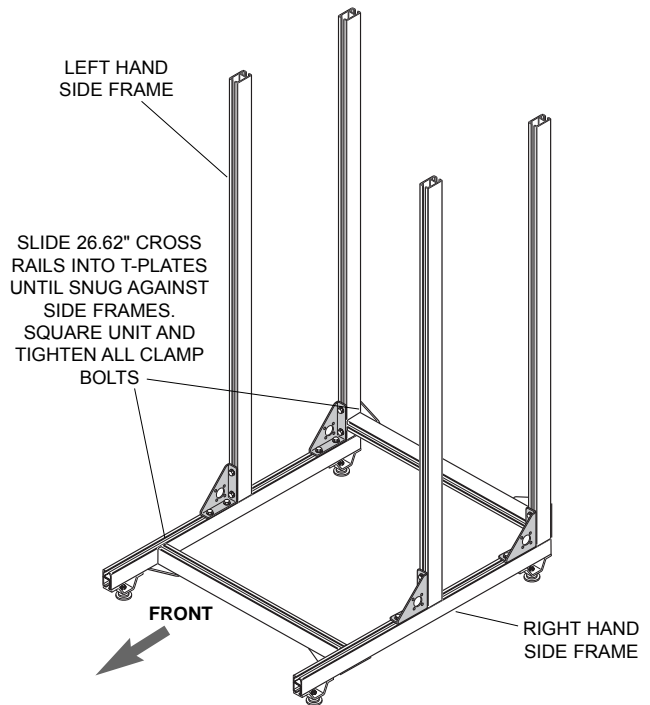
**Figure 3.**  
**ASSEMBLING T-PLATES TO SIDE FRAMES**

- Install 26.62" aluminum cross rails onto T-plates on left hand side frame assembly (Fig. 4). Make sure cross rails are tight against frame members and securely tighten clamp bolts.



**Figure 4.**  
**JOINING SIDE FRAMES**

- Stand left hand side frame with cross rails upright (Fig. 5). Assemble cross rails to right hand side frame. Square completed assembly and securely tighten clamp bolts.

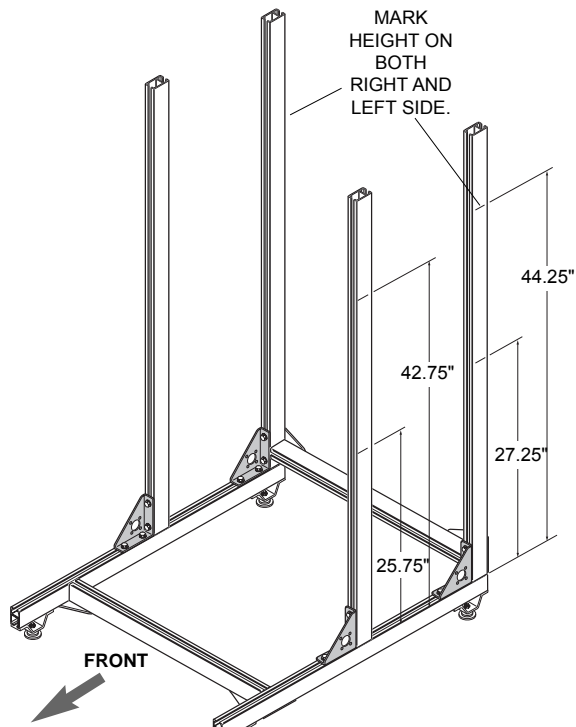


**Figure 5.**  
**ASSEMBLING FRAME**

- Mark heights of four cross conveyor support cross rails on uprights of both side frames (Fig 6). Note that support rails on front uprights are installed lower than corresponding support rails on back uprights so that bins will roll to front on roller conveyors.

**NOTE:**

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

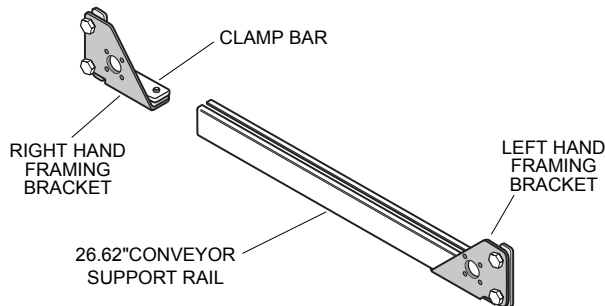


**Figure 6.**  
**MARKING CONVEYOR SUPPORT RAIL LOCATIONS**

7. Locate remaining four 26.62" long rails, four left hand framing brackets and four right hand framing brackets. Assemble framing brackets to rails. Finger tighten (Fig. 7).

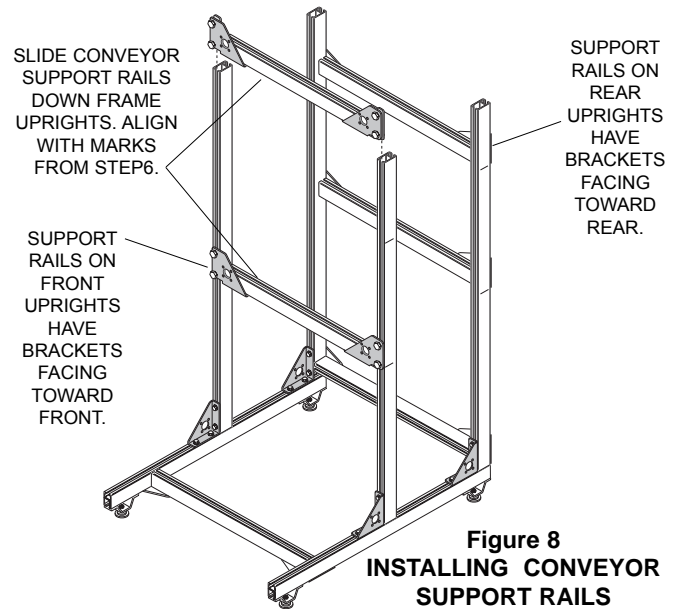
**NOTE:**

Conveyor support rails (below) are 26.62; long aluminum extrusions. Conveyor reinforcing rails are formed steel and either 34.5" or 39.0" long.



**Figure 7.**  
**INSTALLING FRAMING BRACKETS**

8. Install conveyor support rails by sliding brackets down uprights until bottom of brackets are on marks made in Step 6. Finger tighten bolts to hold on marks (Fig. 8, next column).
9. Push side frames together tight against support rails and fully tighten all bolts.
10. Mark conveyor support rails with desired spacing of roller conveyors, four on each level. Consider the size and type of bins which will be used on the stand.
11. Locate four 34.5" and four 39.0" steel conveyor reinforcing



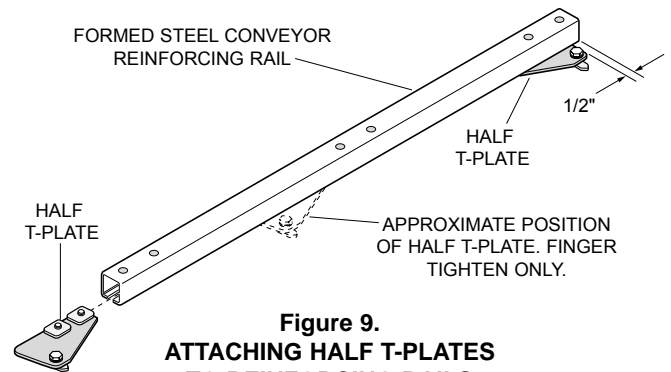
**Figure 8**  
**INSTALLING CONVEYOR SUPPORT RAILS**

rails. Install *Half T-plates* (Fig. 9). Finger tighten trak nuts so half T-plates can be adjusted to fit frame.

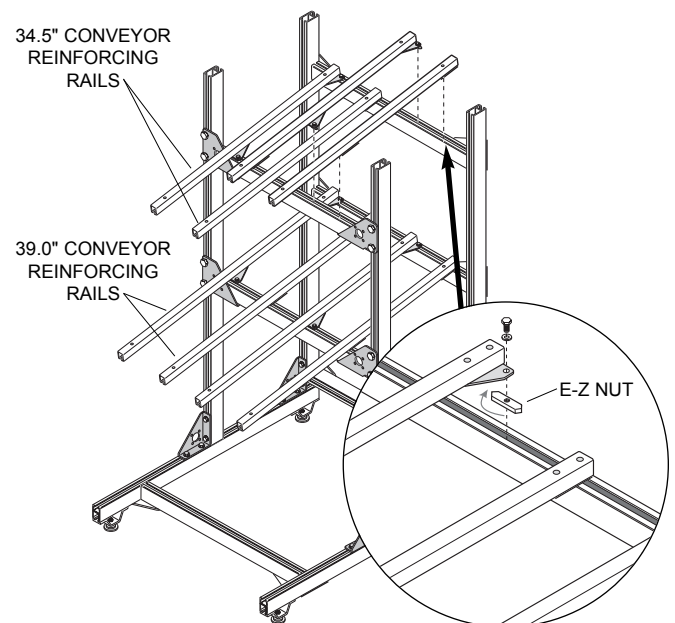
**NOTE:**

Assemble reinforcing rails in pairs with half T-plates facing to right on one set and to left on other set.

12. Install conveyor reinforcing rail assemblies (Step 11) to



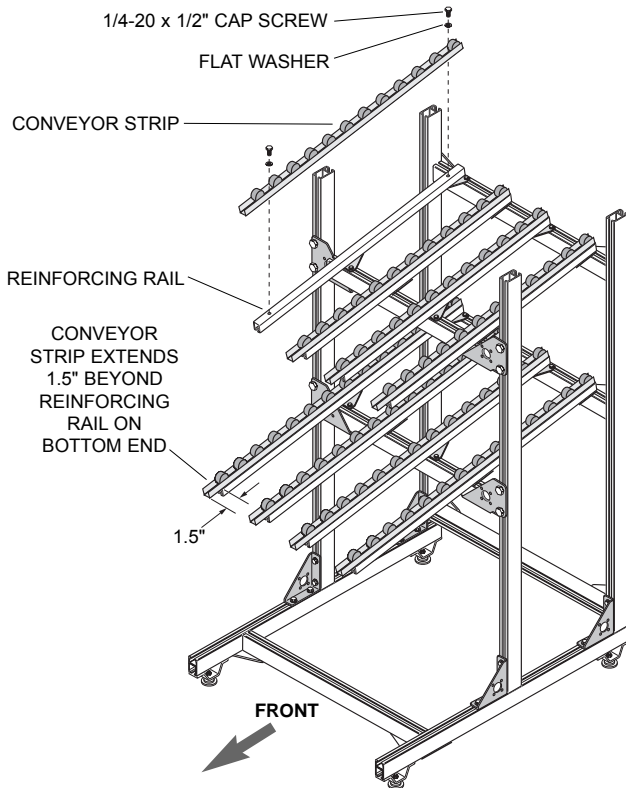
**Figure 9.**  
**ATTACHING HALF T-PLATES TO REINFORCING RAILS**



**Figure 10.**  
**ATTACHING CONVEYOR REINFORCING RAILS**

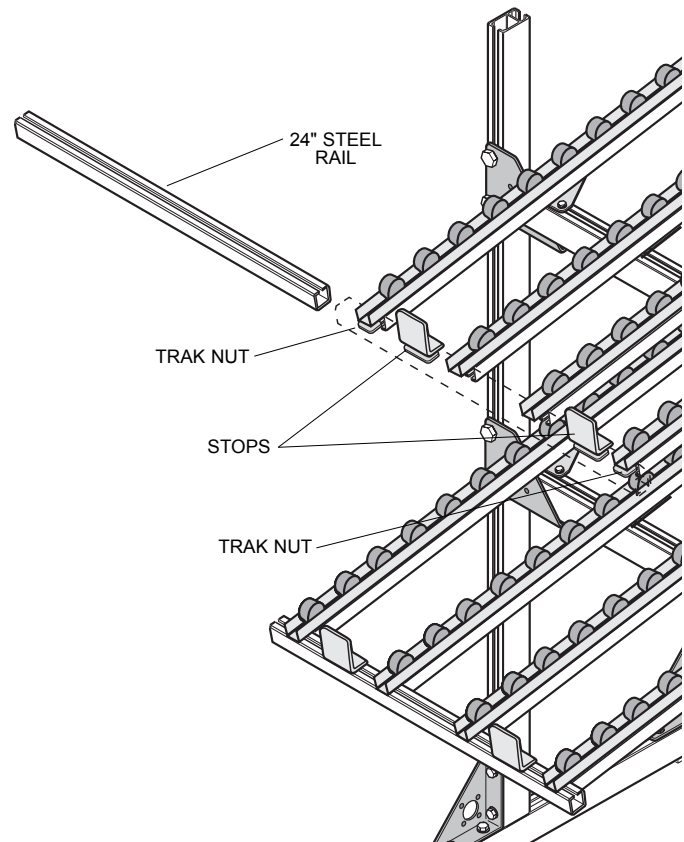
conveyor support rails using *E-Z NUTS*™ (Fig. 10). Shorter rails go on top. End of reinforcing rails at front of stand should be flush with side of support rails. Install in pairs with half T-plates facing in.

13. Install conveyor strips on reinforcing rails using 1/4-20 x 1/2" hex head cap screws and flat washers. Insert screws through slots in conveyor and into tapped holes in rails. Back (top) ends of conveyor strip and rail should be flush. Lower end of conveyor should extend 1.5" beyond end of reinforcing rail (Fig. 11).



**Figure 11.**  
**INSTALLING CONVEYOR STRIPS**

14. Install trak nuts into end slots (overhanging portion) of two outer conveyor strips on each level. Trak nuts should be on lower side with screw head on top (Fig. 12).
15. Install 24" steel rails on lower ends of conveyors by sliding rail onto trak nut, then inserting clamp bar of one stop into rail. Continue sliding rail across front of conveyors until second stop, located between third and fourth conveyor strip, can be inserted. Complete installation by sliding rail onto trak nut on fourth conveyor. Center rail on conveyors and tighten trak nuts. Position stops midway between conveyor strips and securely tighten screws. Repeat above to install remaining 24" steel rail on other conveyor level (FIG. 12).



**Figure 12.**  
**INSTALLING FRONT RAILS AND STOPS**

16. Install end caps in all exposed ends of rails. Note that end caps for aluminum rails are slightly larger than caps for steel rails.
17. Check to make sure all bolts are tight and that unit is square (all four casters firmly on floor). Adjust as necessary.
18. 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.



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