AIR PRESSURE TO BE INSTALLED FROM THE TOP - DURING INSTALL.
VERIFY PIGTAIL LOOP DOES NOT CATCH ON MANIPULATOR OR THE BUILD DURING FULL ROTATION.

480/60/3 POWER TO BE INSTALLED FROM THE TOP - DURING INSTALL.
VERIFY PIGTAIL LOOP DOES NOT CATCH ON MANIPULATOR OR THE BUILDING DURING FULL ROTATION.

THE FOLLOWING IS A NON-COMPREHENSIVE LIST OF ITEMS SUGGESTED FOR INSTALLING THE TPA 25. IT IS THE INSTALLER'S RESPONSIBILITY TO UNDERSTAND THE INSTALLATION PROCESS AND THE TOOLS REQUIRED PRIOR TO PERFORMING THE WORK.

- 3/4" HEX WRENCH
- MACHINIST LEVEL & BUBBLE LEVEL
- CHALK TO MARK PEDESTAL LOCATION
- 3" HEX WRENCH
- TORQUE WRENCH
- DRILL
- 1 7/8" HEX WRENCH
- HAMMER DRILL
- BANDING SHEAR FOR PALLETS DISASSEMBLY
- 2 1/4" HEX WRENCH
- 1" CONCRETE BIT
- FISH TAPE FOR ROUTING HOSES
- 1 1/2" HEX WRENCH
- VACUUM TO CLEAR ANCHOR BOLT HOLES
- 5/8" X 3" L - EYE BOLTS FOR LIFTING PEDESTAL
- 1 1/16" HEX WRENCH
- EXTENSION CORDS
- SLINGS
- 3/4" ALLEN HEX
- LADDER
- PERSONAL PROTECTIVE EQUIPMENT
- 5/8" ALLEN HEX
- MAN LIFT
- RECOMMENDED 8,000 LB FOR LIFT OR CRANE TO LIFT THE TPA 25 INTO POSITION (NO TOOL)
- 3/8" ALLEN HEX
- PLUMBING TOOLS
- 5/16" ALLEN HEX
- ELECTRICAL TOOLS/ HOLE PUNCH
- WILTON 65160 B-CLAMPS
- LAYOUT PRINT & TAPE MEASURE

ALL SPECIFIED NOTES AND REQUIREMENTS ARE TYPICAL. REFER TO EACH PROJECT PROFILE DRAWING FOR AND CUSTOM FEATURES.

ALL DESIGNS, SKETCHES AND DRAWINGS ARE THE PROPERTY OF POSITECH CORPORATION LETTING, OR ALLOWING TO BE LET, THE KNOWLEDGE FOR DESIGN AND/OR FABRICATION FROM SAID DESIGNS, SKETCHES OR DRAWINGS WITHOUT THE WRITTEN CONSENT OF POSITECH CORPORATION IS EXPRESSLY FORBIDDEN.
ARMS MUST BE LEVEL BEFORE LIFTING
TIE ARM WITH STRAP TO HOLD THE 2ND ARM FOLDED BACK

NO GROUTING IS NEEDED TO INSTALL THIS PEDESTAL:
1. BE SURE TO PLACE THE WASHERS UNDER THE JACKS - ON THE CONCRETE.
2. SEAT THE ANCHOR BOLTS BEFORE LEVELING.
3. LEVEL THE PEDESTAL BEFORE INSTALLING THE MANIPULATOR.
4. PLACE A LEVEL ON THE BEARING MOUNTING SURFACE TO LEVEL THE PEDESTAL.

APPROXIMATE CENTER OF GRAVITY
APPROXIMATE WEIGHT TO BE LIFTED IS 3,000 LBS

SEAT BOLTS AT 250-350 FT-LBS (340-476 N-M)
LOosen AND THEN torque TO 250 FT-LBS (340 N-M)
RECHECK AFTER ONE WEEK OF SERVICE
CHECK EVERY PERIODIC EVALUATION

SECTION C-C
PLACE A 1 X 6 OVER FORK TO PROTECT PAINT

PLACE CARDBOARD ON FORK TO PROTECT PAINT

CLA P OPENING

STACK OF 2 X 6 BANDED TOGETHER

CLAMP OPENING

CLAMP ARMS TO FORK

FRAME TUBE TO FORK

CLAMP POWER UNIT

DETAIL J
10.8 APPROXIMATE CENTER OF GRAVITY
APPROXIMATE WEIGHT TO BE LIFTED IS 3,000 LBS

ARMS MUST BE LEVEL BEFORE LIFTING

TIE ARM WITH STRAP TO HOLD THE 2ND ARM FOLDED BACK

SECTION E-E
SCALE 1 : 12

15/16 HEX ON BEARING BOLTS
(5/8-18 THREAD)

3 3/4 HEX ON LEVELING JACK JAM NUT (2-12 THREAD)

1 7/8 HEX ON BOLT
(1 1/4-7 THREAD)

3 HEX ON LEVELING JACK JAM NUT (2-12 THREAD)

TORQUING THE BEARING BOLTS:
1. SEQUENCE FOR THE FIRST 10 BOLTS SHOWN.
2. ADD SERVICE GRADE THREAD LOCKER TO THE BOLTS.
3. TORQUE THE BOLTS TO 28 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.
4. TORQUE THE BOLTS TO 56 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.
5. FINAL TORQUE THE BOLTS TO 83 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.