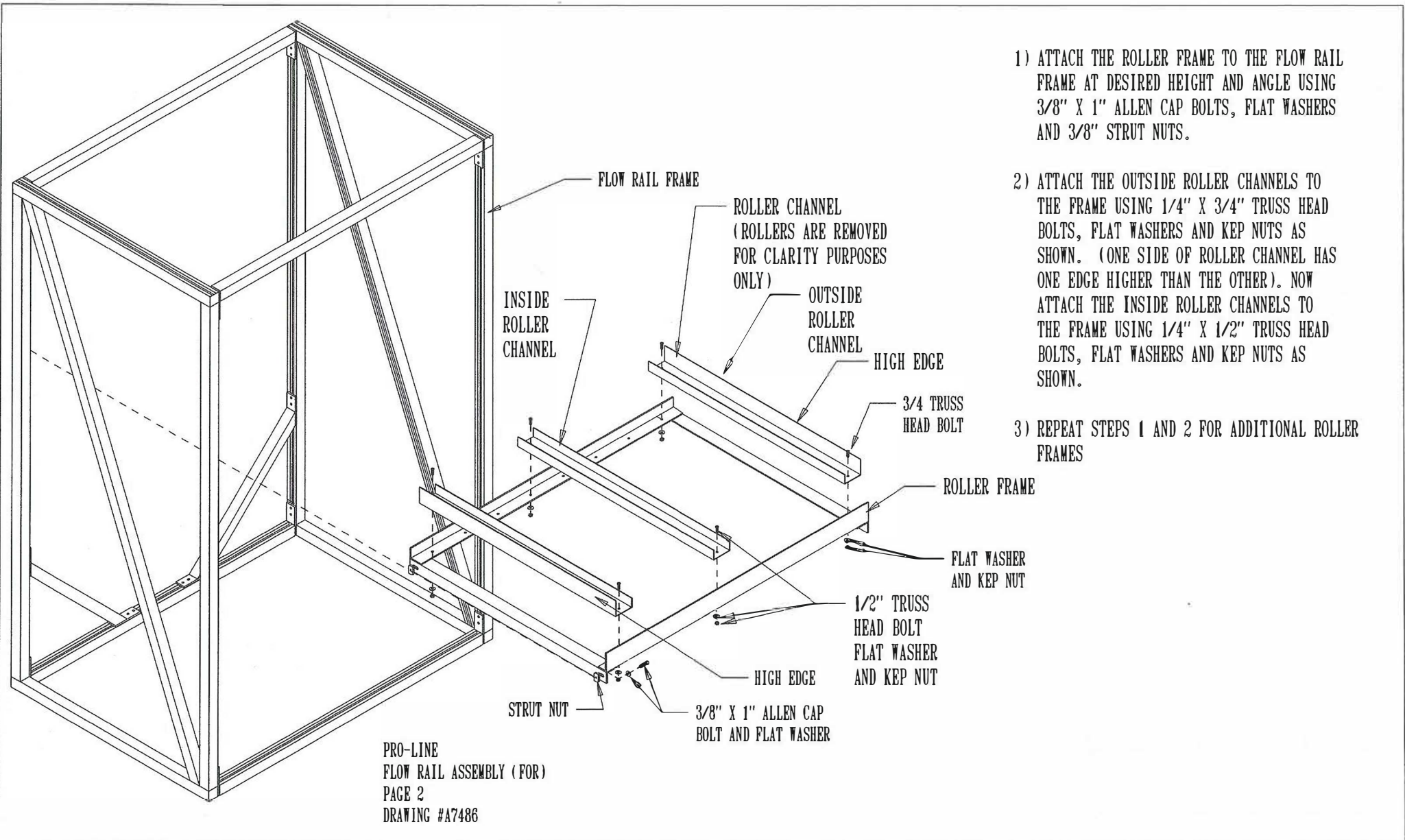


Gravity Flow Racks Assembly Guide

SMS-08-V80-FOR4836



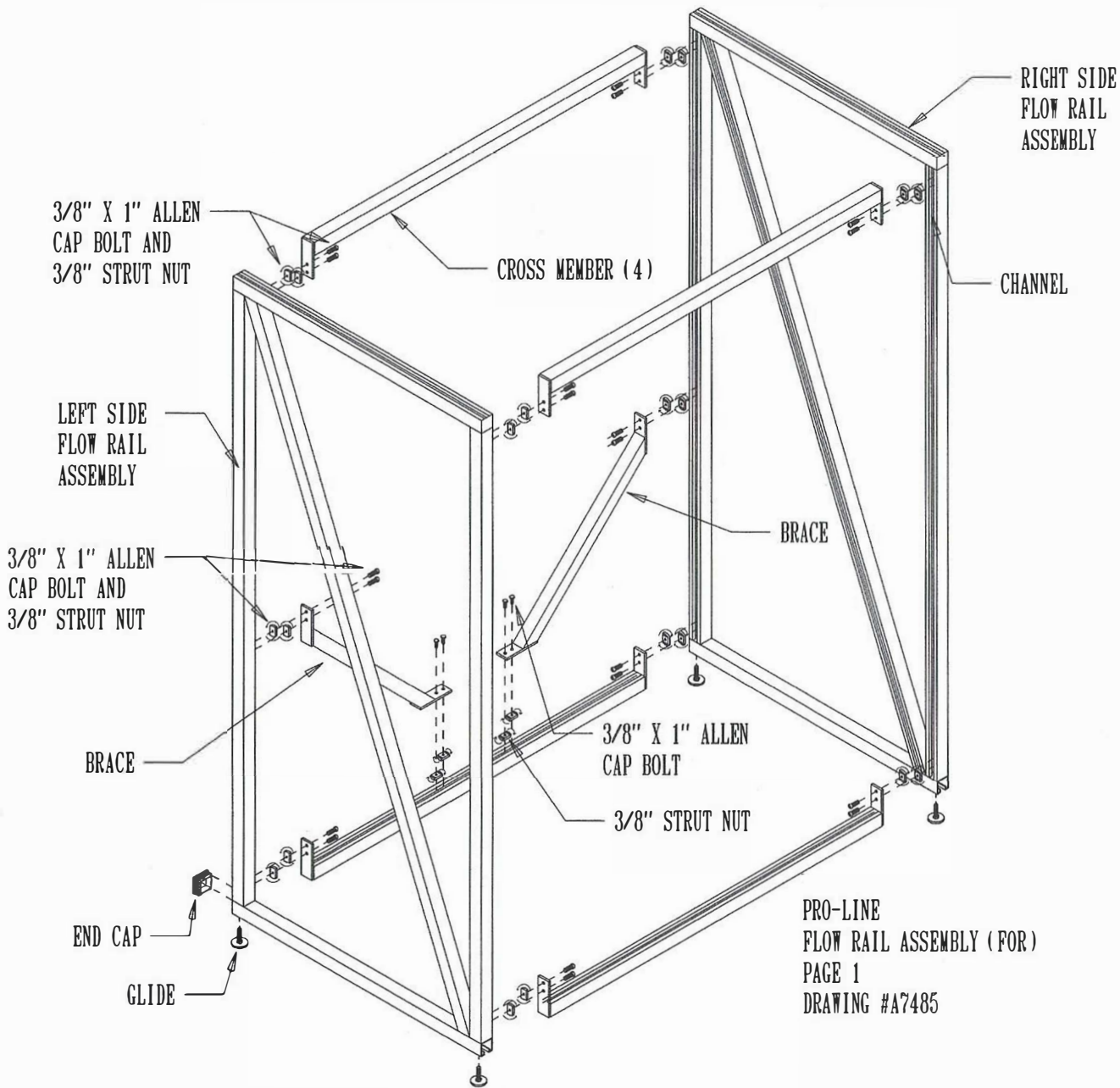
1) ATTACH THE ROLLER FRAME TO THE FLOW RAIL FRAME AT DESIRED HEIGHT AND ANGLE USING 3/8" X 1" ALLEN CAP BOLTS, FLAT WASHERS AND 3/8" STRUT NUTS.

2) ATTACH THE OUTSIDE ROLLER CHANNELS TO THE FRAME USING 1/4" X 3/4" TRUSS HEAD BOLTS, FLAT WASHERS AND KEP NUTS AS SHOWN. (ONE SIDE OF ROLLER CHANNEL HAS ONE EDGE HIGHER THAN THE OTHER). NOW ATTACH THE INSIDE ROLLER CHANNELS TO THE FRAME USING 1/4" X 1/2" TRUSS HEAD BOLTS, FLAT WASHERS AND KEP NUTS AS SHOWN.

3) REPEAT STEPS 1 AND 2 FOR ADDITIONAL ROLLER FRAMES

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1) SPIN THE LEVELLING GLIDES INTO THE BOTTOM OF EACH CORNER OF THE FLOW RAIL SIDE ASSEMBLIES THEN WITH A RUBBER HAMMER OR Mallet TAP THE END CAPS INTO THE SIDE ASSEMBLIES AS SHOWN.

2) LOOSELY ATTACH THE 3/8" X 1" ALLEN CAP BOLTS AND 3/8" STRUT NUTS TO EACH OF THE (4) CROSS MEMBERS (SPIN THE STRUT NUTS ON APPROXIMATELY 2 - 3 TURNS). NOTE BE CERTAIN THE "TEETH" ON THE STRUT NUTS ARE FACING TOWARDS THE HEAD OF THE BOLT WHEN ATTACHING.

BEFORE YOU PROCEED TO THE NEXT STEP VERIFY THE PROPER ORIENTATION OF THE TWO FLOW RAIL ASSEMBLIES.

3) PUSH THE STRUT NUT ASSEMBLY INTO THE CHANNEL ON THE STRUT AS SHOWN AND TIGHTEN, BE CERTAIN THAT THE "TEETH" ON THE STRUT NUT "GRIP" THE INSIDE RIBS OF THE STRUT BEFORE YOU FULLY TIGHTEN.

4) LOOSELY ATTACH 3/8" X 1" ALLEN CAP BOLTS AND STRUT NUTS TO BOTH SIDES OF EACH OF THE BRACES. PUSH THEM INTO THE STRUT ON THE SIDE ASSEMBLY AND LOWER THE BRACE DOWN TO THE BOTTOM CROSS MEMBER. ATTACH THE BRACE TO THE CROSS MEMBER FIRST THEN TIGHTEN THE ALLEN CAP BOLTS AT THE OTHER END OF THE BRACE TO COMPLETE THE OUTER FRAME.

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