

RR-300 & RR-400 Skid Assembly Manual



Save this manual for future reference. If skid is pre-assembled, leave this manual with unit for future reference



Heavy Article. Need Machine to Lift.

500-600 lbs

Tools needed for assembly

- ① **9/16" socket wrench**
- ① **9/16" wrench**
- ① **3/4" wrench**
- ① **3/4" socket wrench**
- ① **Socket wrench extension**
- ① **3/16" Allen wrench**
- ① **1/4" Allen wrench**

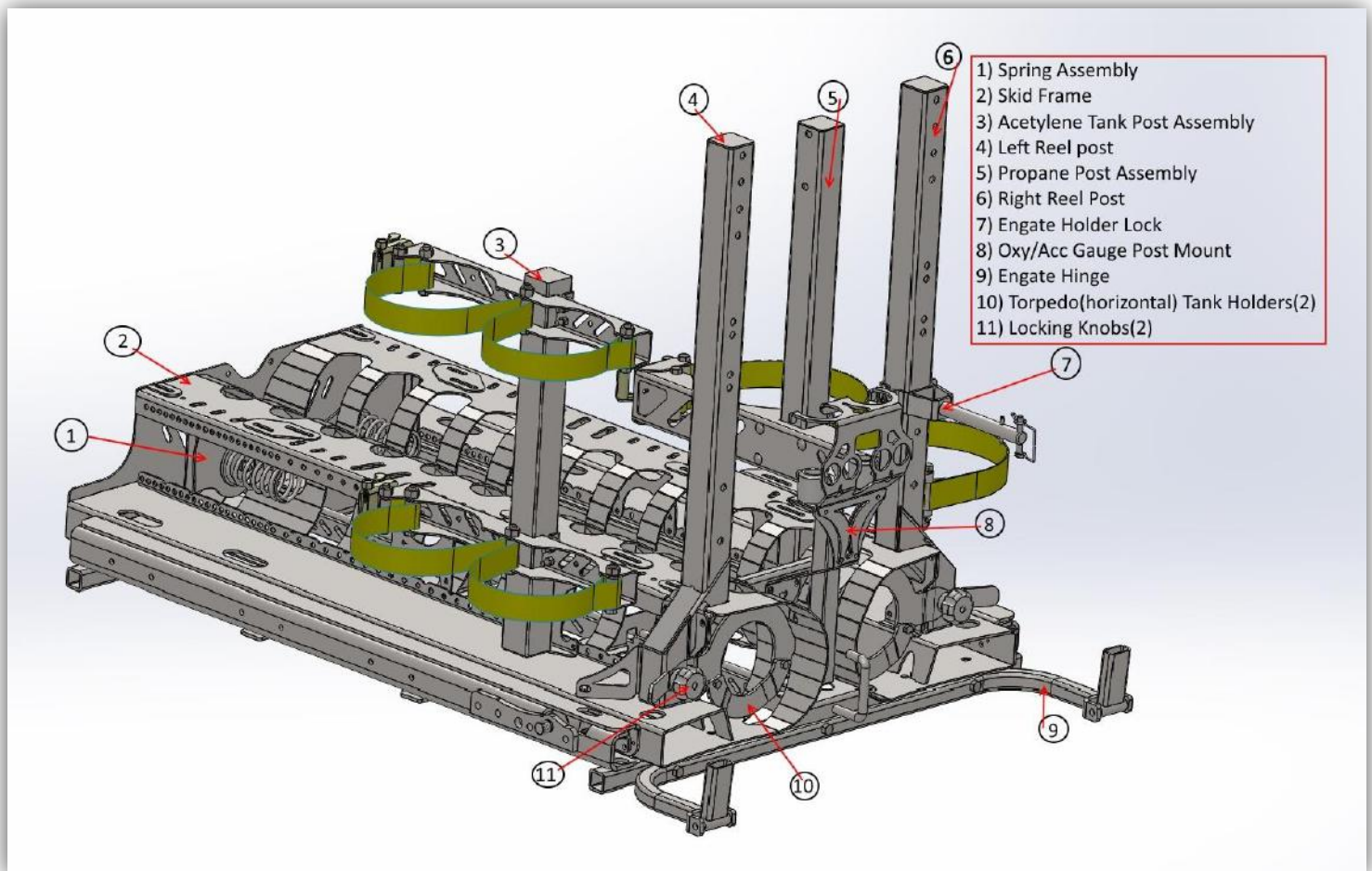
DESCRIPTION	QUANTITY	Part Number
Mainframe(skid)	1	SR4160
Propane Post	1	PR-20DB
Acetylene tank post	1	AR28X2
Oxy tank holder	2	TH-60
Oxy/acetylene gauge cover	1	GR0014
Oxy/acetylene gauge post	1	GP1400
Acetylene tank post strap	2	S0260-2
Propane post strap	1	S0272-1
Left reel post	1	LRP-4560
Right reel post	1	RRP-4560
Spring assembly	2	VAL32215
Endgate Holder	1	PN-018
Endgate Hinge	1	EH-34

WARNING!





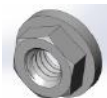
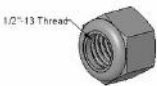

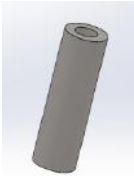


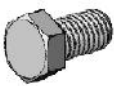



- ! Safety is important! Read and respect the following rules
- ! IMPORTANT! Use proper tools and methods when assembling this equipment
- ! Illustrations in this manual may not always be correct. Read instructions carefully
- ! Heavy article needs machine to lift. Safety shoes are recommended.
- ! Some sharp edges. Gloves are recommended
- ! Read all instructions before you start
- ! Recheck all bolts after assembly to ensure tightness.

We are not responsible for damage caused by improper installation and/or installation methods on this equipment
We are not responsible for injury caused by installation and/or use of this equipment

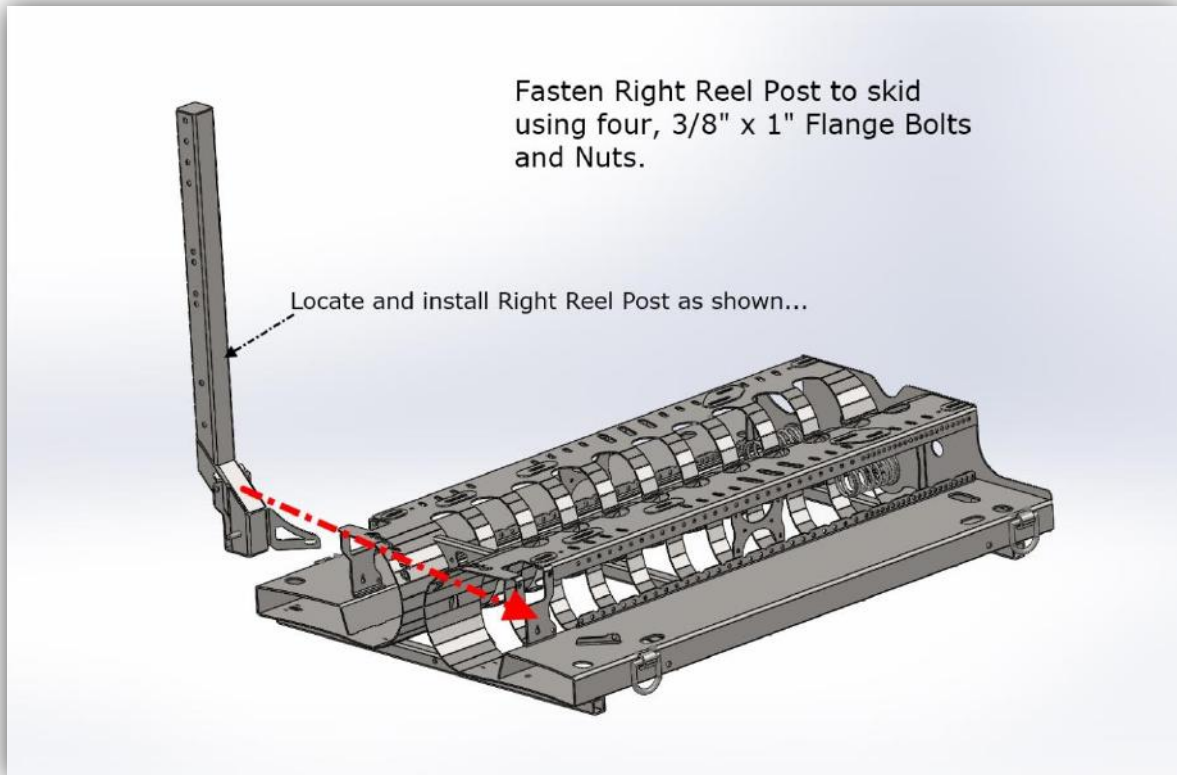
Step 1: Parts, equipment and Hardware: Open all packaging and ensure all of the following parts are included.
Contact call center if any are missing.



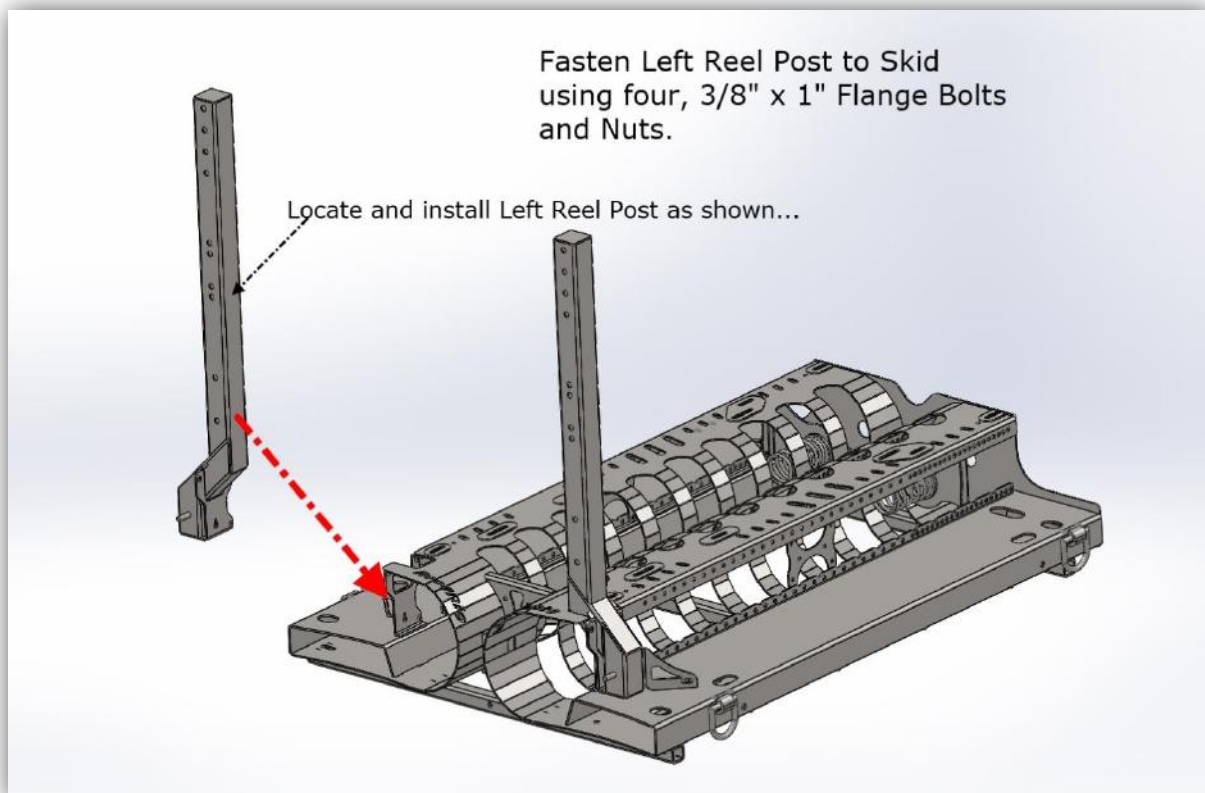
Hardware:

Quantity	Description		Designation
10	½" X 3 ½" Hex bolts		Bolts supplied to secure Alumareels™ to posts.
6	½" X 4 ½" Hex bolts		Bolts used to secure Alumareels™ to posts & strap for propane post. (2 are longer bolts provided for oxygen/acetylene reel.)
8	½" X 3 ¼" Hex bolts		Bolts used to secure holding straps for tanks.
3	1/2" x 3 1/2" Hex Bolts		Bolts used to secure endgate hinge.
3	1/2" Flange nuts		Used with bolts to secure endgate hinge.
12	½" self locking nut		Nuts for bolts used to secure holding straps.
8	Plastic bushing(small)		Bushing used with Acetylene post straps.
4	Plastic Bushings(large)		Bushings used with propane post strap.
24	3/8" X 1" Flange bolts		Bolts used to secure posts to skid base. Includes bolts to secure welder to skid.
27	3/8" Flange nuts		Used with bolts to secure posts. Includes nuts for bolts . Used to secure ratchets.
6	1/4 " X 1/2" Hex bolts		Bolts used to secure ratchet strap.
4	5/16" X ½" cap screws		Screws to secure oxy/acetylene gauge guard.
2	Plastic knob		Knob to secure oxygen tank holder.
6	1/4" Flange nuts		Nuts used to secure ratchet strap.
3	72" Strap		Used to fasten Propane Tanks

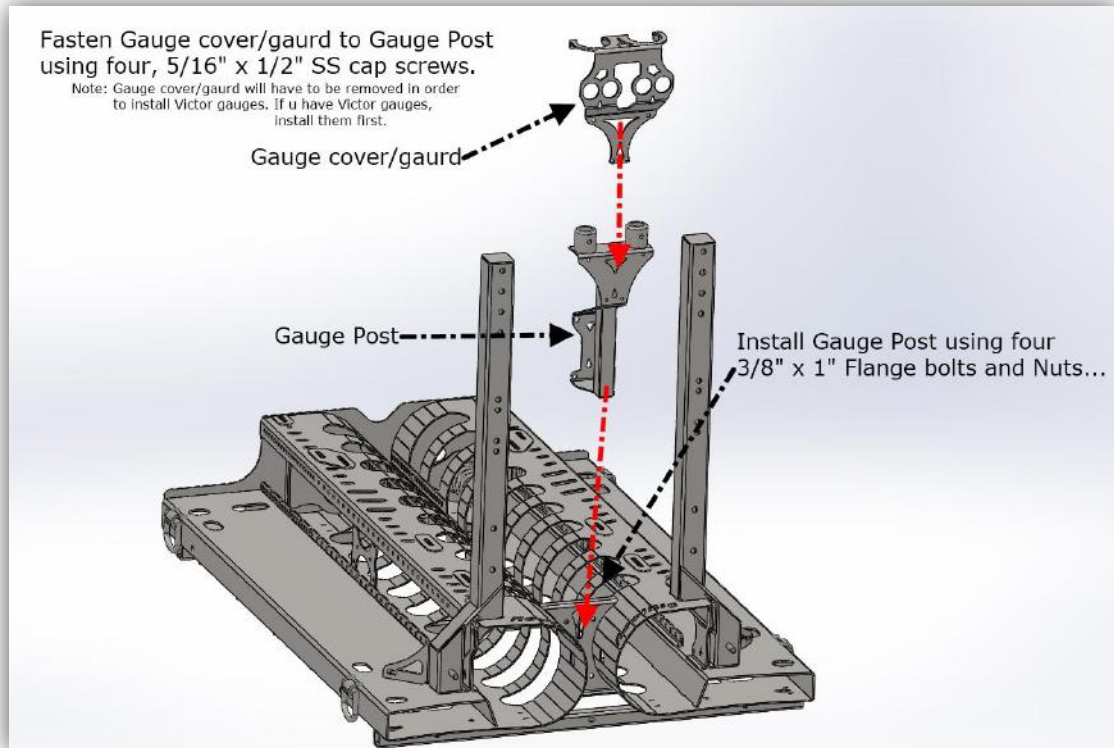
Step 2: Identify the right welding reel post and secure it to the main skid base.



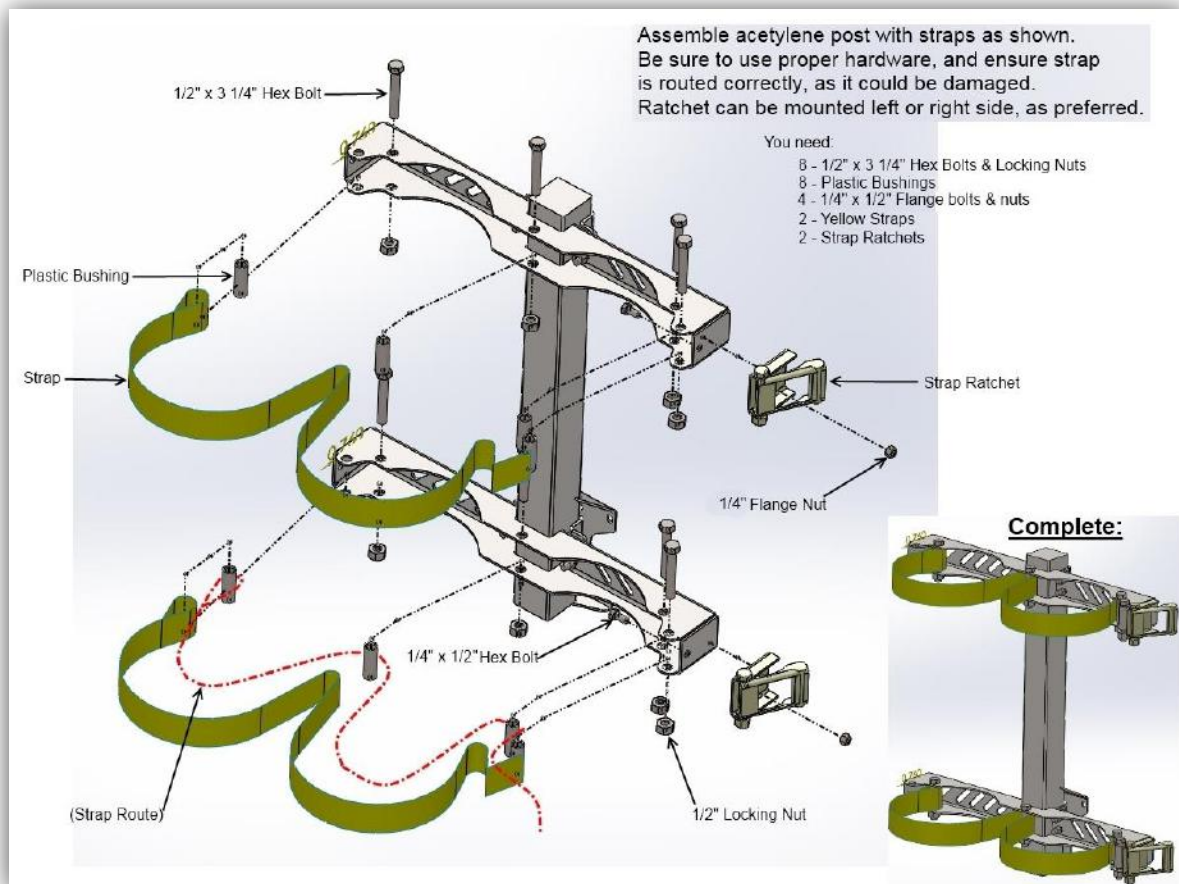
Step 3: Identify the left welding reel post and secure it to the skid base



Step 4: Identify the oxygen/ acetylene gauge cover/guard and the oxygen acetylene gauge post. Secure the guard to the post, and the post to the skid base. The gauge post should have two aluminum gauge mounts labelled 'oxygen & acetylene' already installed.

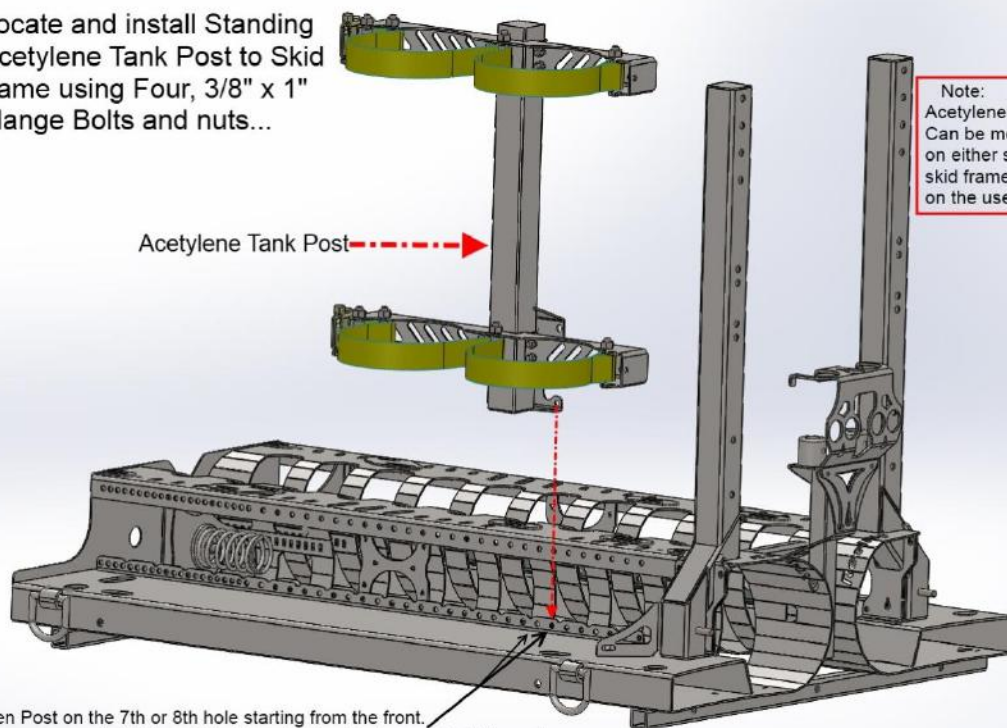


Step 5: Identify the acetylene tank post, straps and ratchets and install straps on post.



Step 7: Secure acetylene tank post to skid base.

Locate and install Standing Acetylene Tank Post to Skid frame using Four, 3/8" x 1" Flange Bolts and nuts...

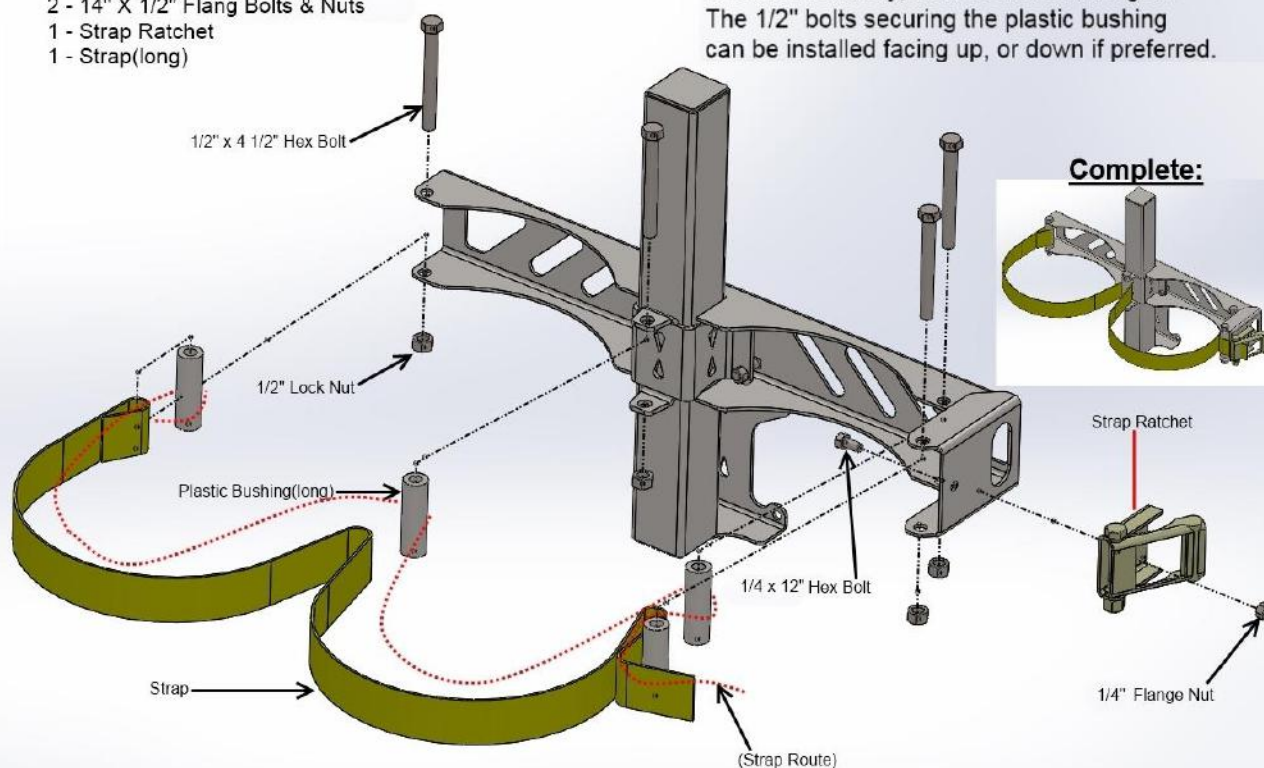


Step 8: Identify the propane tank/ reel post, strap and ratchet and install strap on post.

You Need:

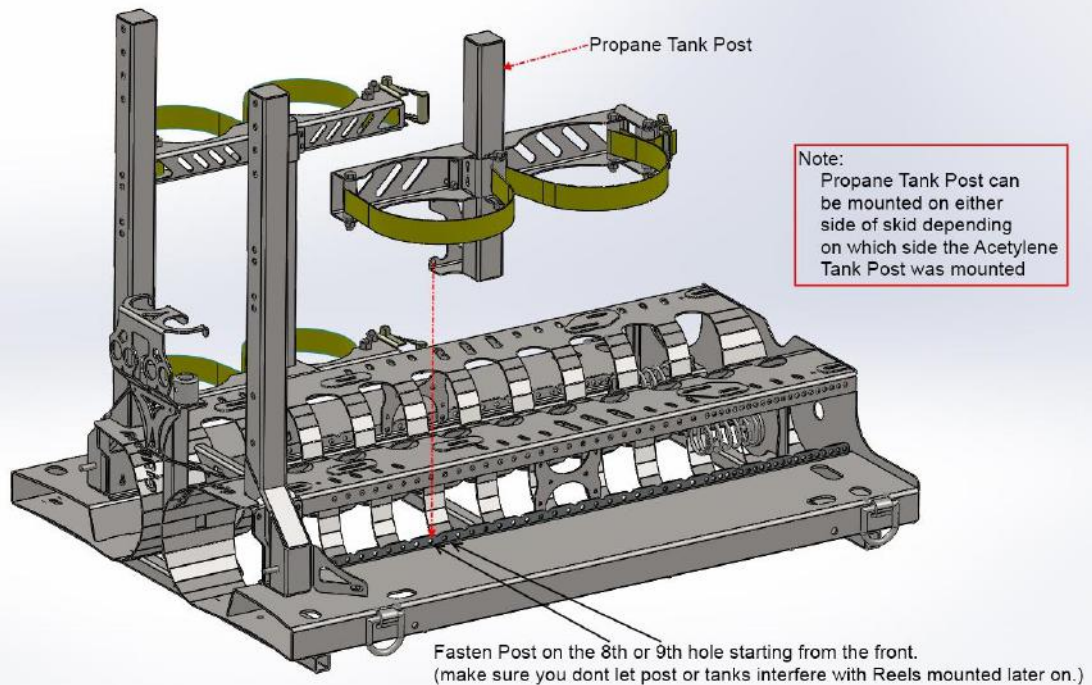
- 4 - 1/2" x 4 1/2" Hex bolts & Lock Nuts
- 4 - Plastic Bushings(long)
- 2 - 1/4" x 1/2" Flange Bolts & Nuts
- 1 - Strap Ratchet
- 1 - Strap(long)

Assemble propane post with strap as shown. Be sure to use proper hardware, and ensure strap is routed correctly, as it could be damaged. The 1/2" bolts securing the plastic bushing can be installed facing up, or down if preferred.

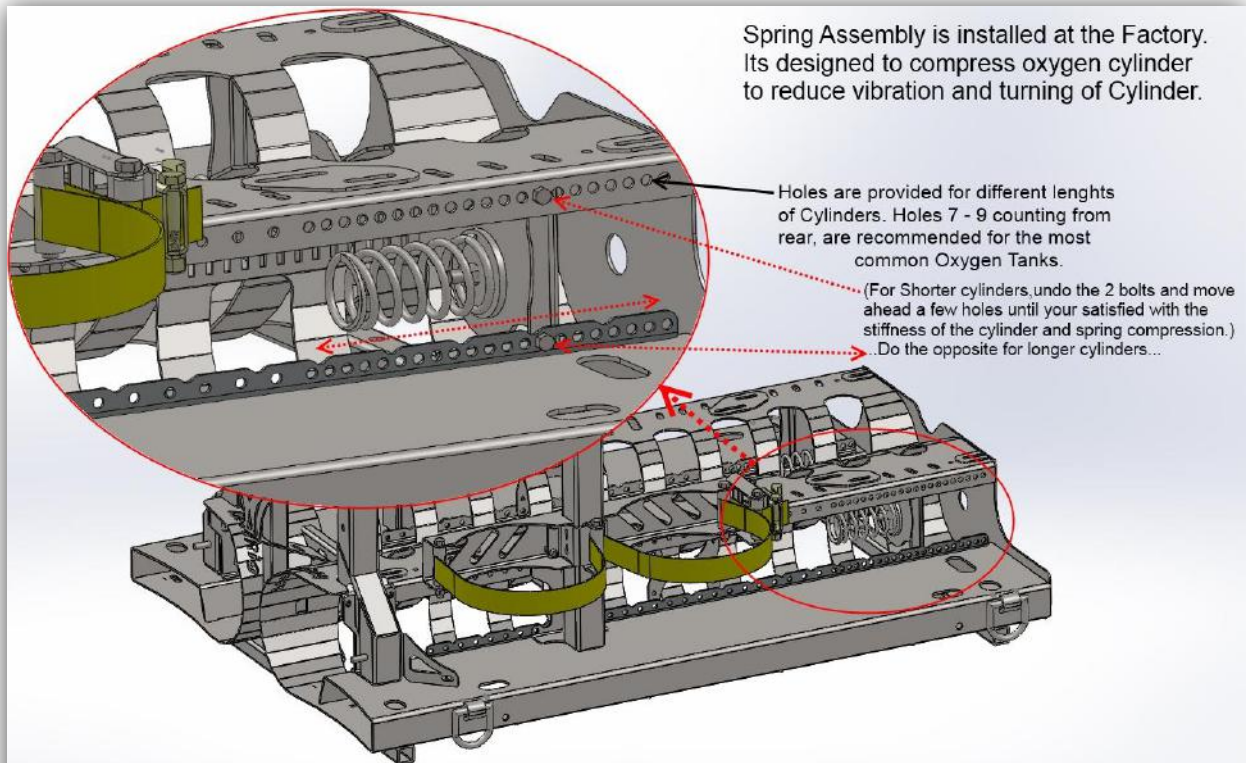


Step 9: Secure propane tank/ reel post to skid base

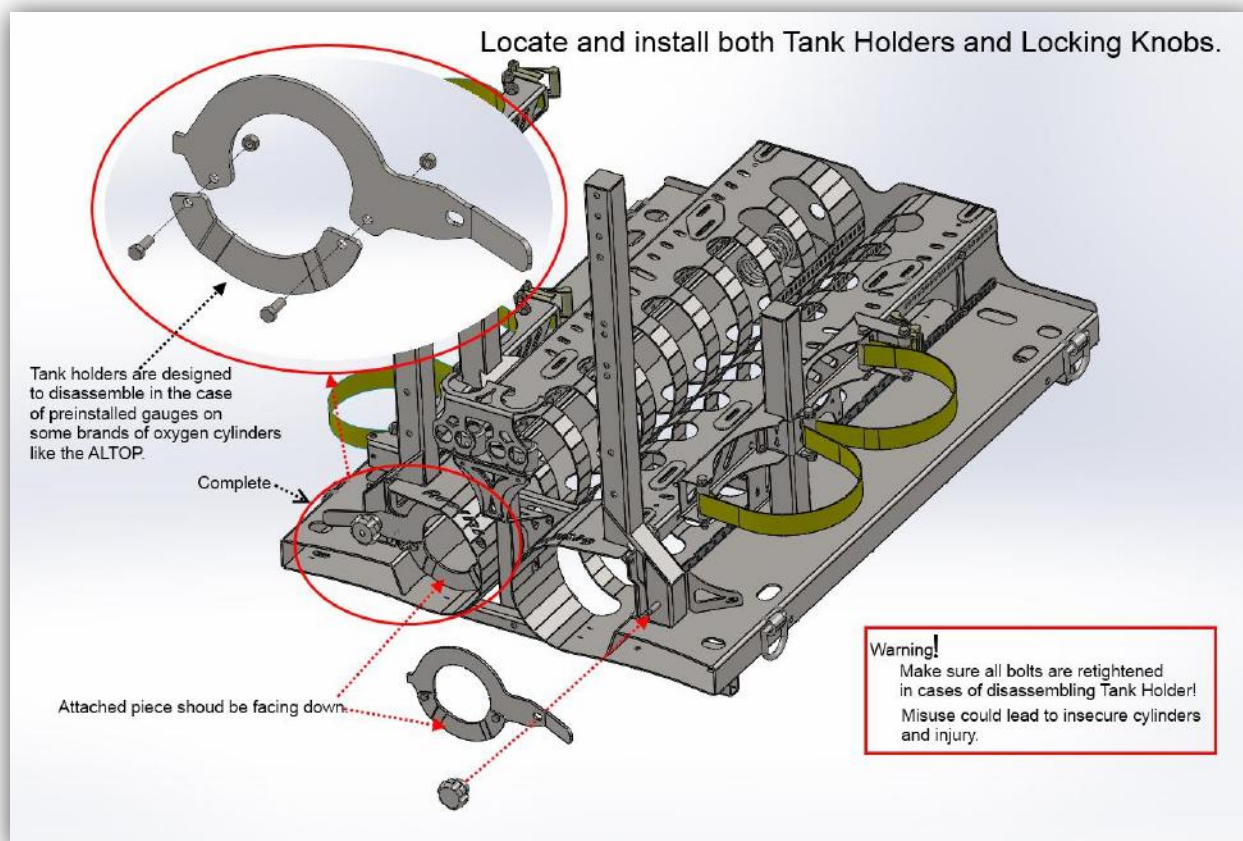
Install Propane Tank Post to Skid Frame using four, 3/8" x 1" Flange Bolts & Flange Nuts.



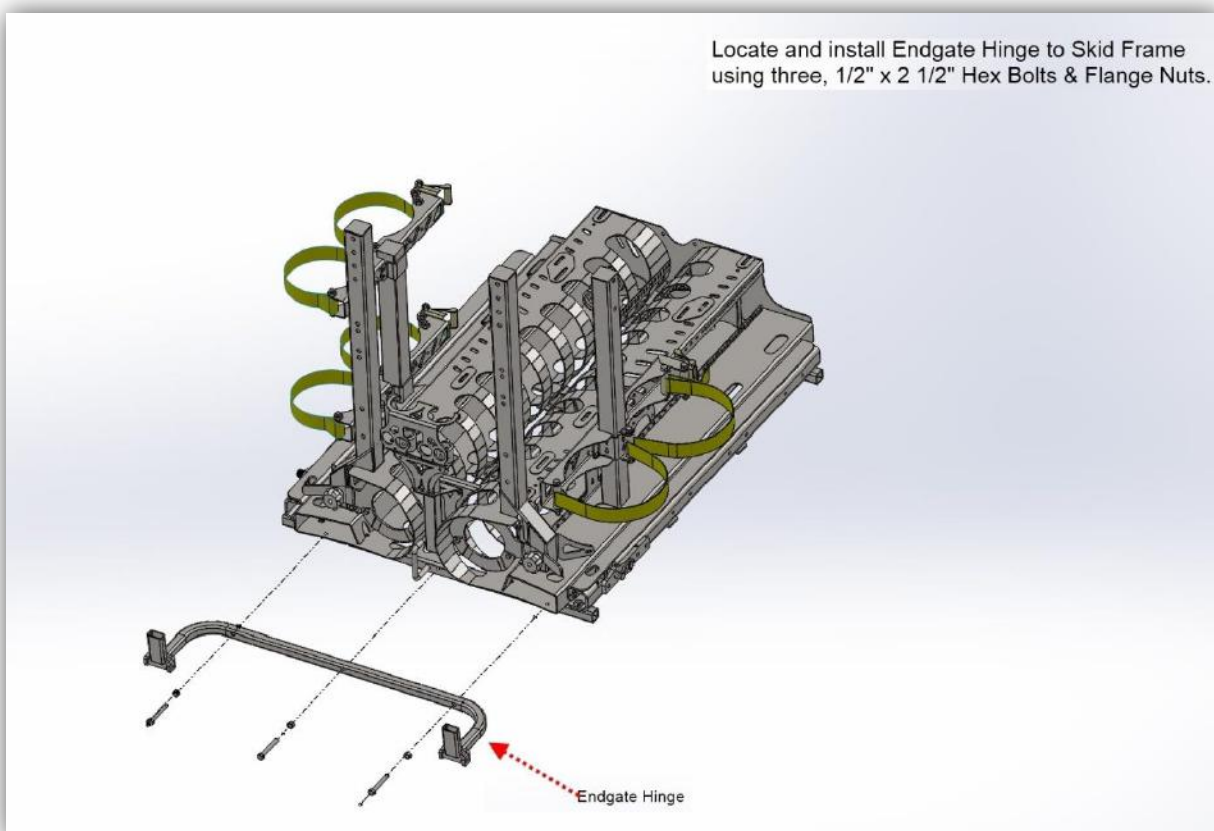
Step 10: Identify and adjust Spring.



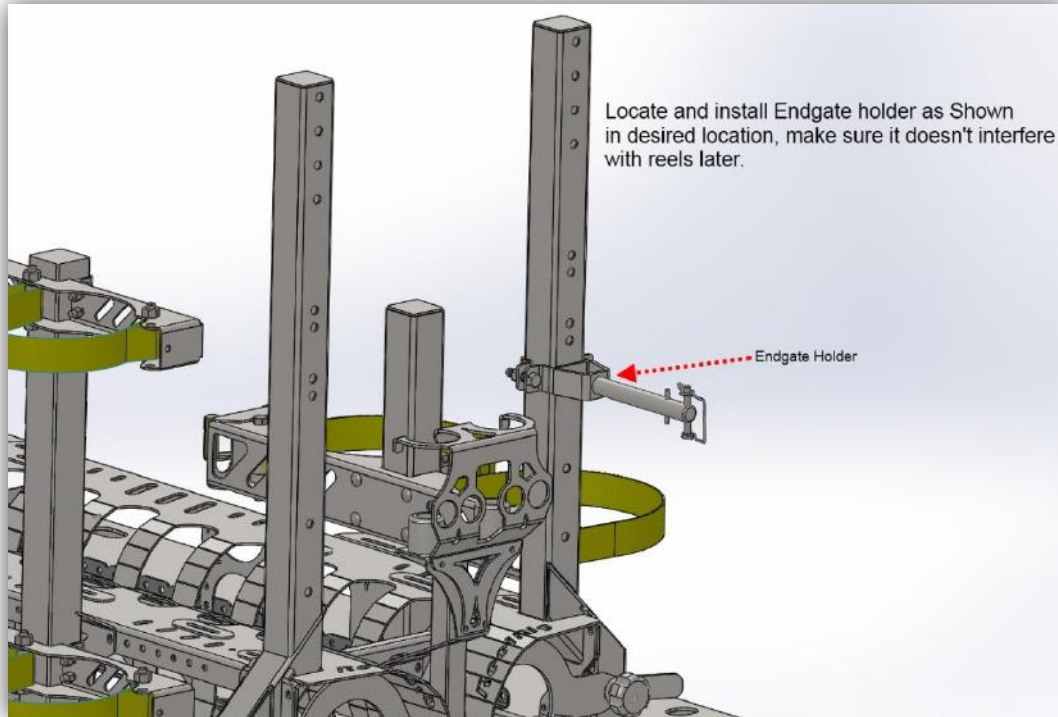
Step 11: Identify and install the oxygen tank holders. The removable half moon on the holder should be facing down. Right and left tank holders are provided.



Step 12: Identify and install endgate hinge. It should be assembled and include necessary hardware. Be sure to have the correct side facing up, as shown.



Step 13: Identify and install the endgate holder. This part is included and designed to hold the endgate in place when it is in the up or stored position. It can be mounted on either the left or right post at the desired height, providing it doesn't interfere with any cord reels that may be installed.



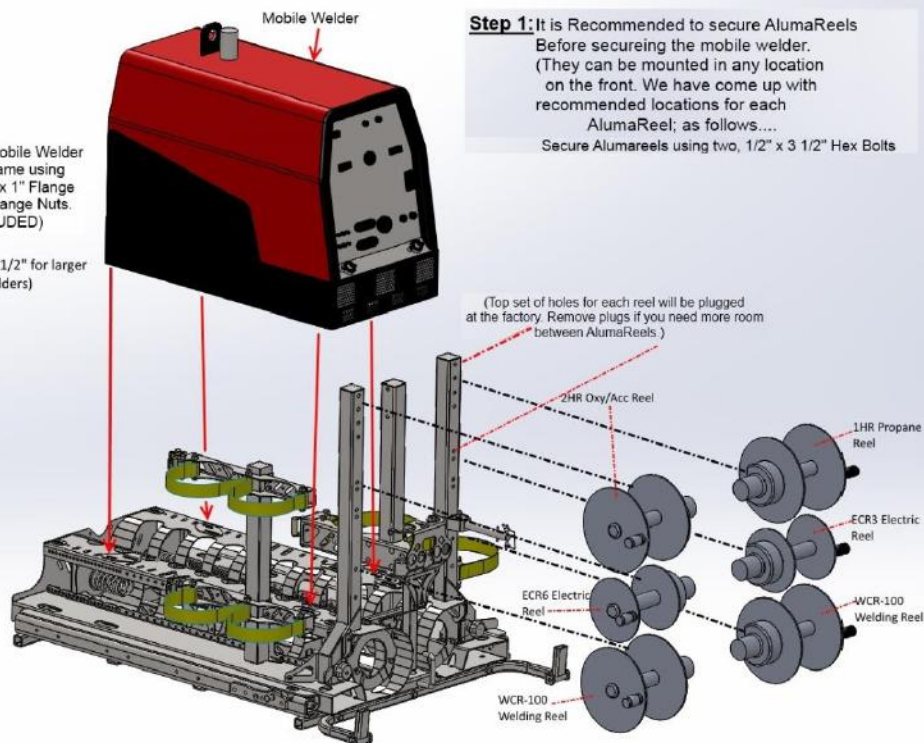
Additional Instruction:

Mounting Alumareels & Mobile Welder:

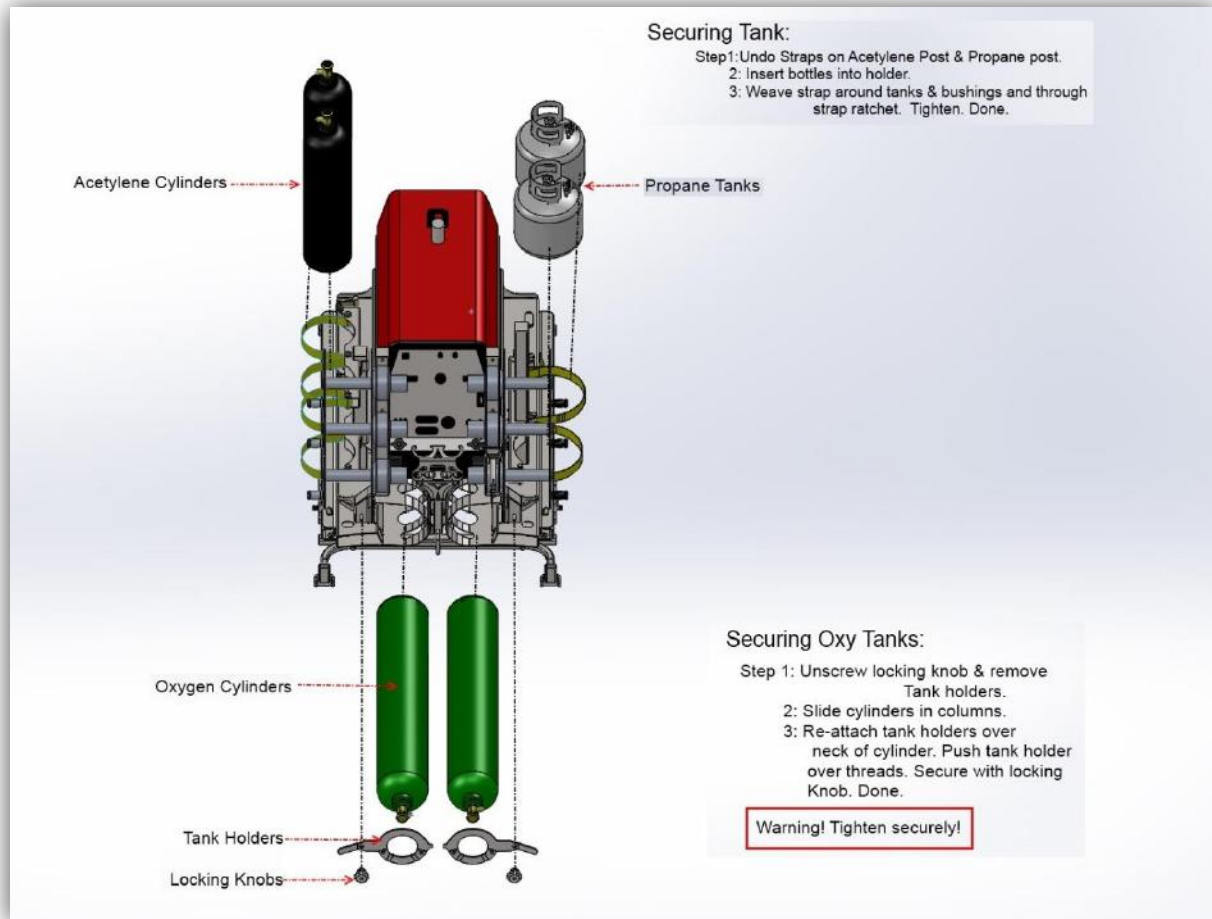
Step 2:

Secure Mobile Welder To skid frame using four, 3/8" x 1" Flange Bolts & Flange Nuts. (INCLUDED)

(1/2" x 1 1/2" for larger Welders)



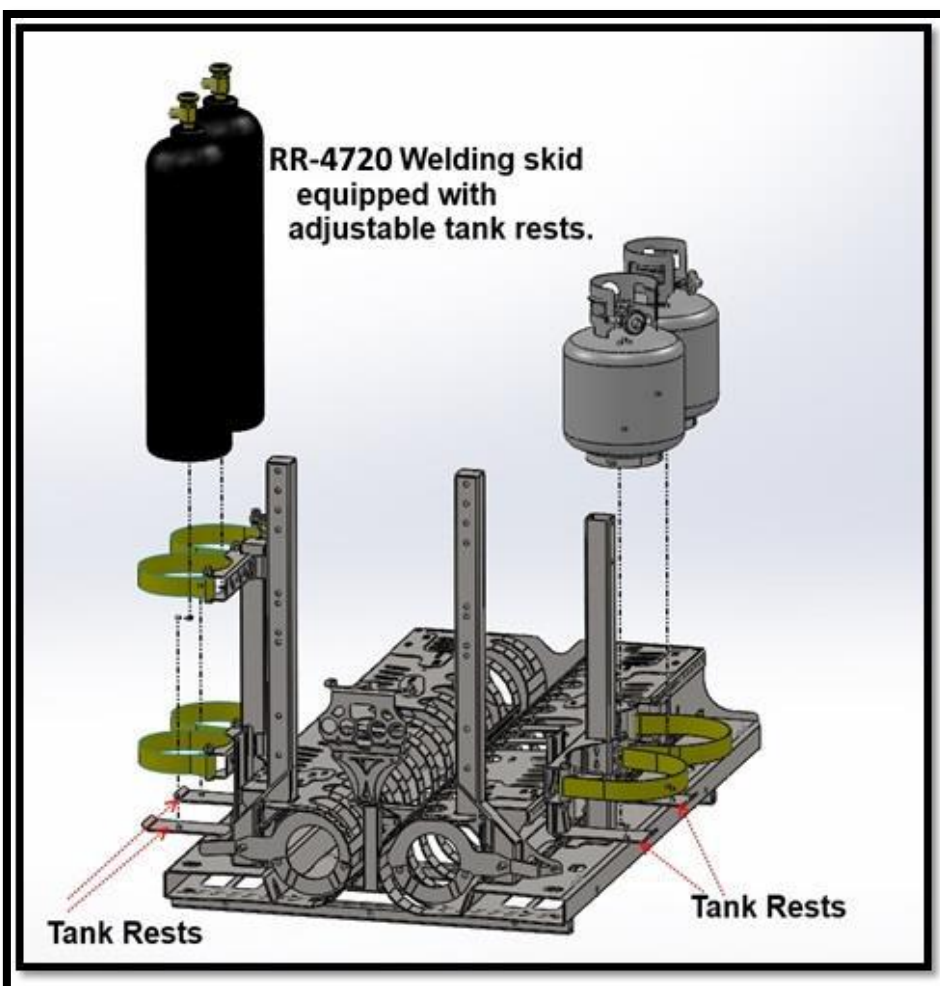
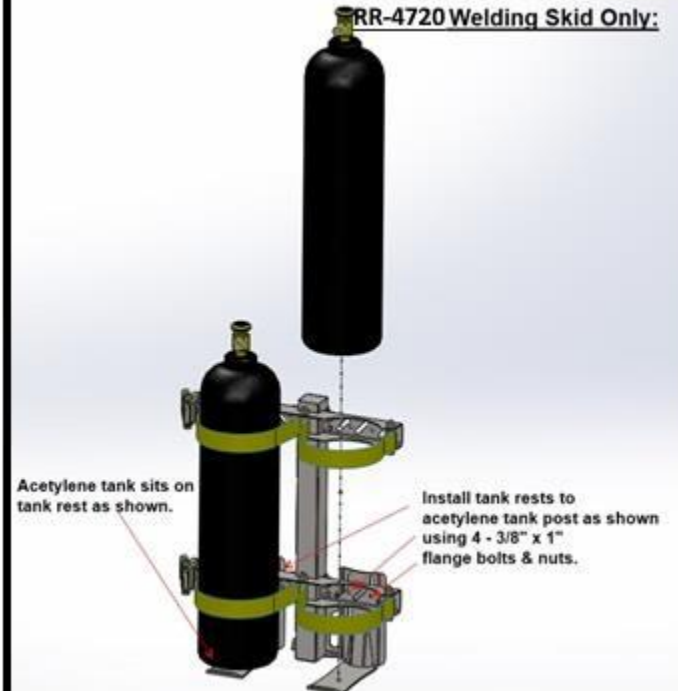
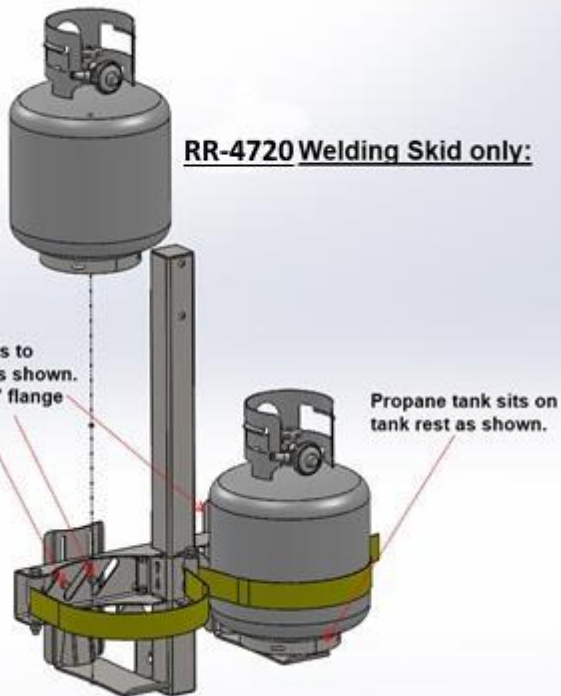
Securing Tanks:



PH: (204) 744 2285 (204) 825 7582

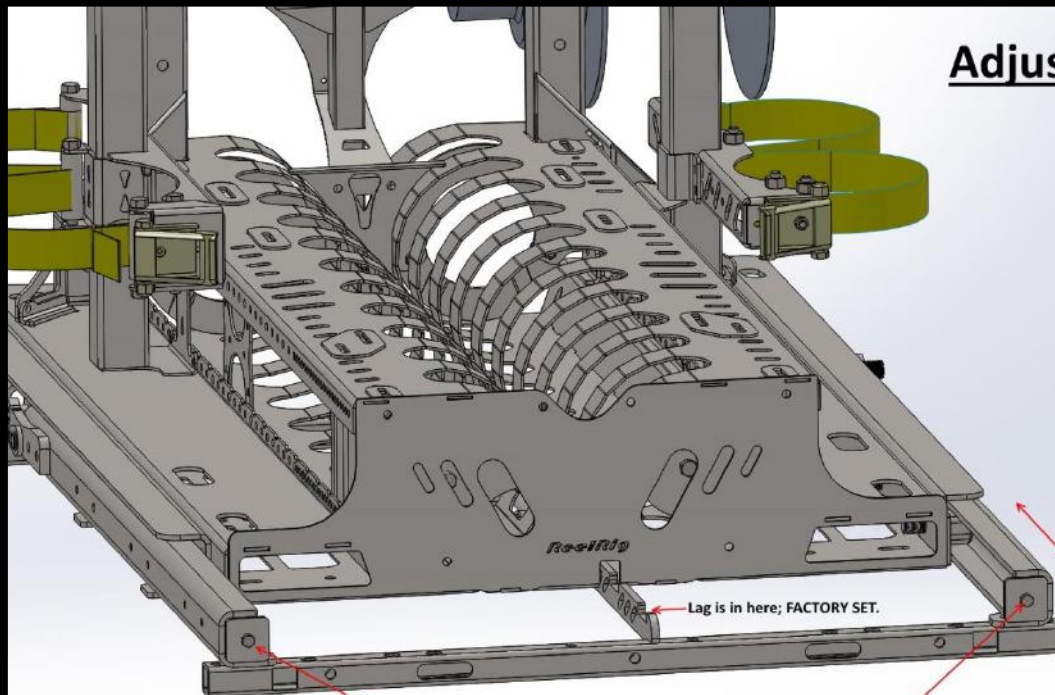
THAT'S HOW WE ROLL

RR-400 Tank Rest Installation:



For Rolling skids only:

Adjusting lag:



1) Locate the two bolts on the rear of the bottom part of the skid; the roller frame.

2) There may be a certain amount of lag when the skid is rolled all the way in and locked. Adjust the lag by screwing the Bolt in or out and locking it with the nut on opposite side of the stop plate.