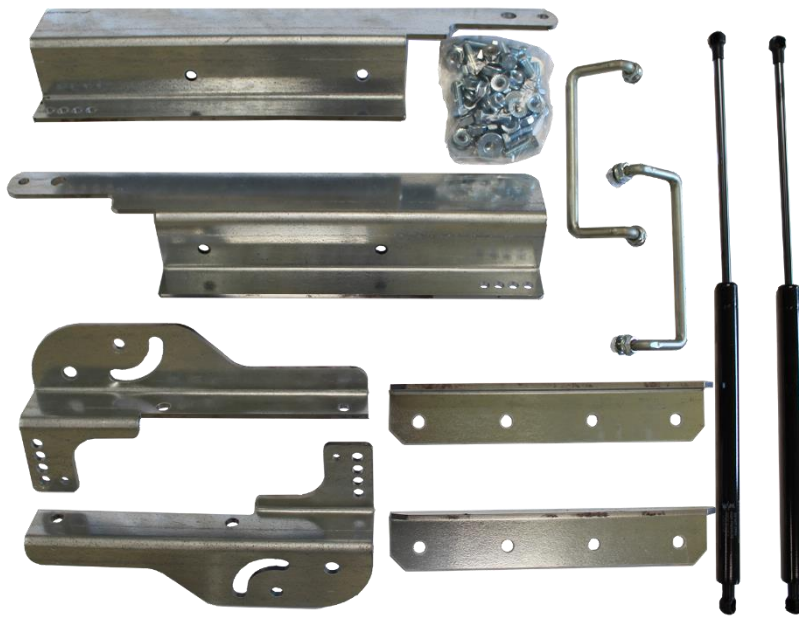


# Model GSGK – Gas Spring Gate Kit

## Installation Manual

(Conveyors or Stands not Included with Kit)



Note: Neither stands nor conveyors are included with the gate kit.



## Safety and Operation Procedures



1. Read the entire manual before assembly or operation of the gate. Gates may create a safety hazard if assembled or used improperly.
2. Make sure the swing path of the gate is clear before opening or closing.
3. Only lift or lower the gate using the handles.
4. The gate is “lift assisted”, a slight surge may occur when opening.
5. Do not release the gate when opening or closing until it is in its final position.
6. Keep hands clear of the gate pivot and closing stop.

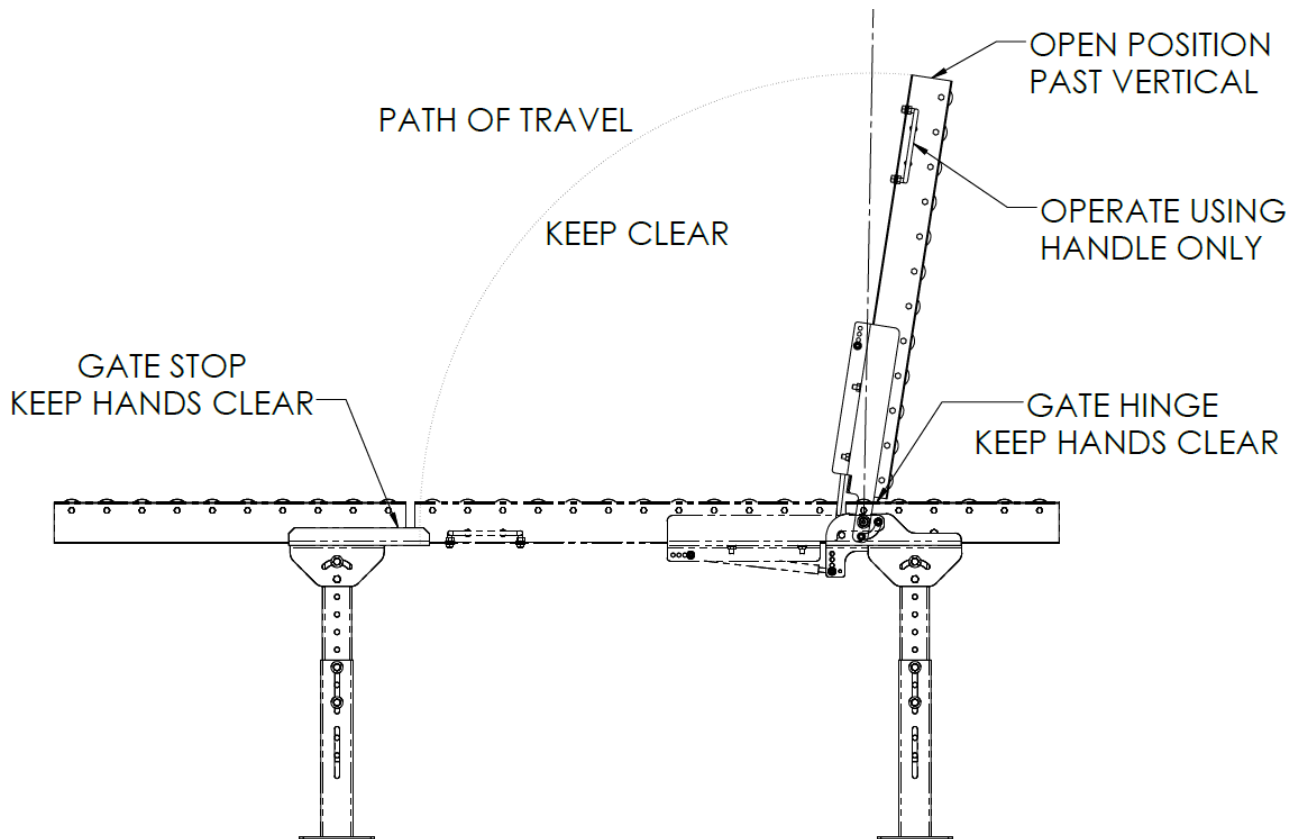
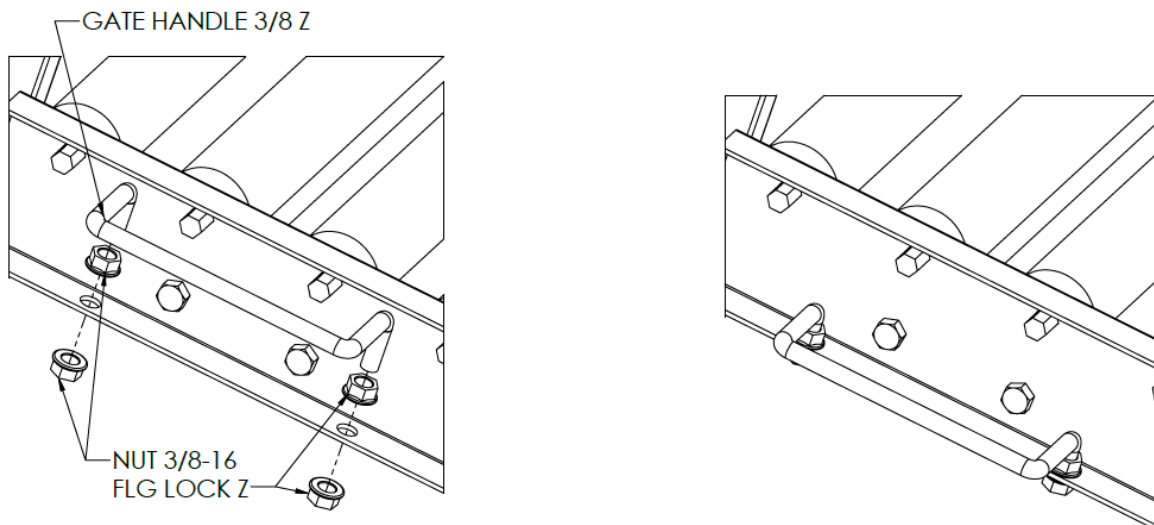


Figure 1

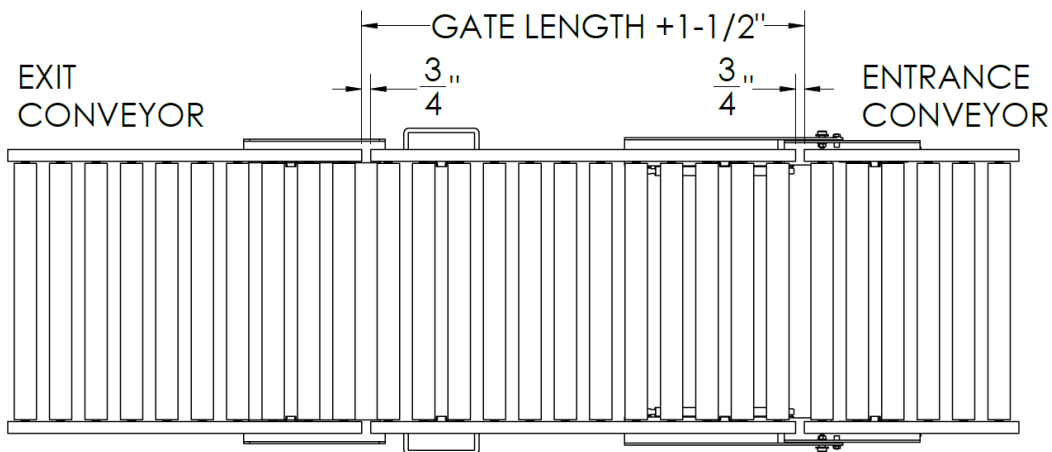
## Assembly Instructions

1. Tools Required
  - a. 1/4" Hex Key (Allen) Wrench
  - b. Drive Ratchet with 1/2" and 9/16" Sockets
  - c. 1/2" and 9/16" Combination Wrenches
  - d. Multi-Purpose Grease
2. Attach Gate Handles to both sides of the conveyor gate (sold separately) using (4) 3/8-16 flange nuts provided. Mounting holes are provided.



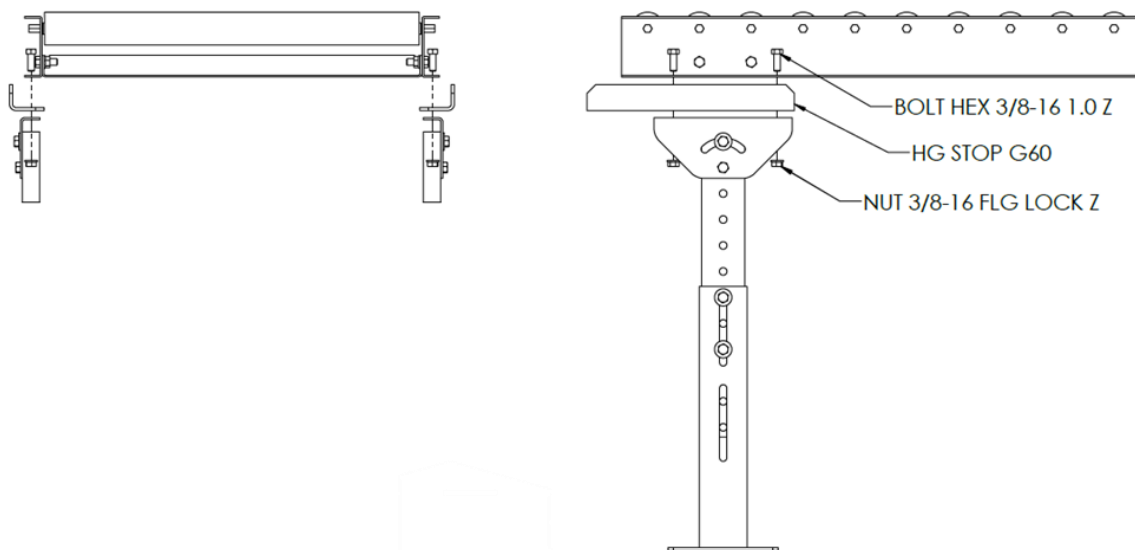
*Figure 2*

3. Both entrance and exit conveyors must be set-up and mounted to floor supports. The distance between the entrance and exit conveyors must be 1-1/2" longer than the length of the conveyor gate. For a 36" gate the opening must be 37-1/2".



*Figure 3*

4. Mount Stop Angles to the bottom flange of the exit conveyor. The brackets are installed between the conveyor and the H-stand support. Use (2) 3/8-16 flange nuts and (2) 3/8-16x1" hex bolts that were provided with the supports.



*Figure 4*

5. Mount the left hand and right-hand Pivot Brackets to the entrance conveyor (not included). The brackets are installed between the conveyor and the H-stand support. Use (2) 3/8-16 flange nuts and (2) 3/8-16x1" hex bolts that were provided with the supports. Hand tighten.

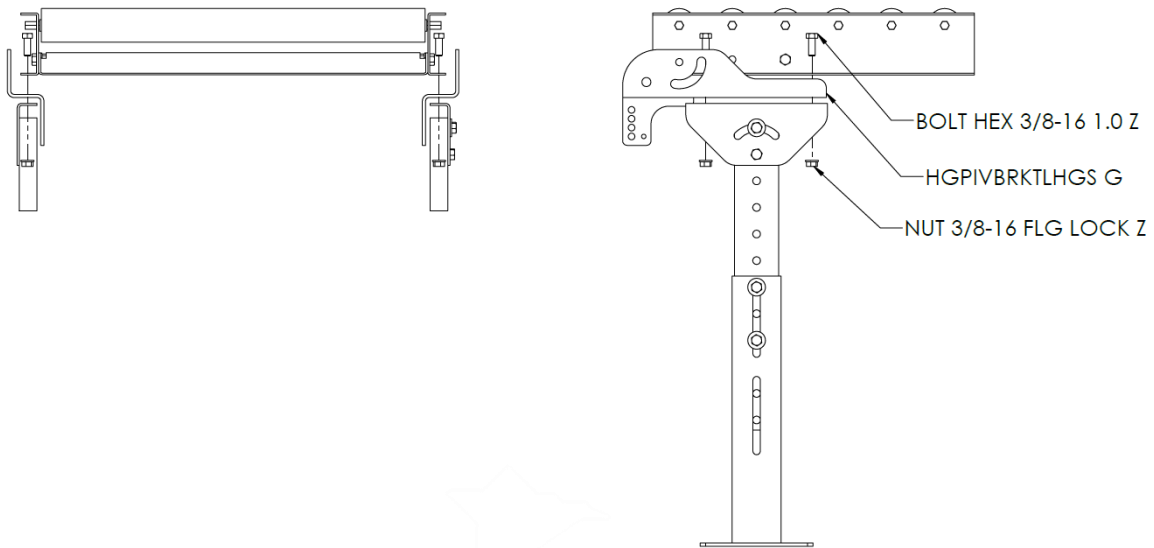


Figure 5

6. Mount the left hand and right-hand Hinge Brackets to the gate conveyor (not included). Use (2) 3/8-16 flange nuts and (2) 3/8-16x1” hex bolts that are provided. Hand tighten.

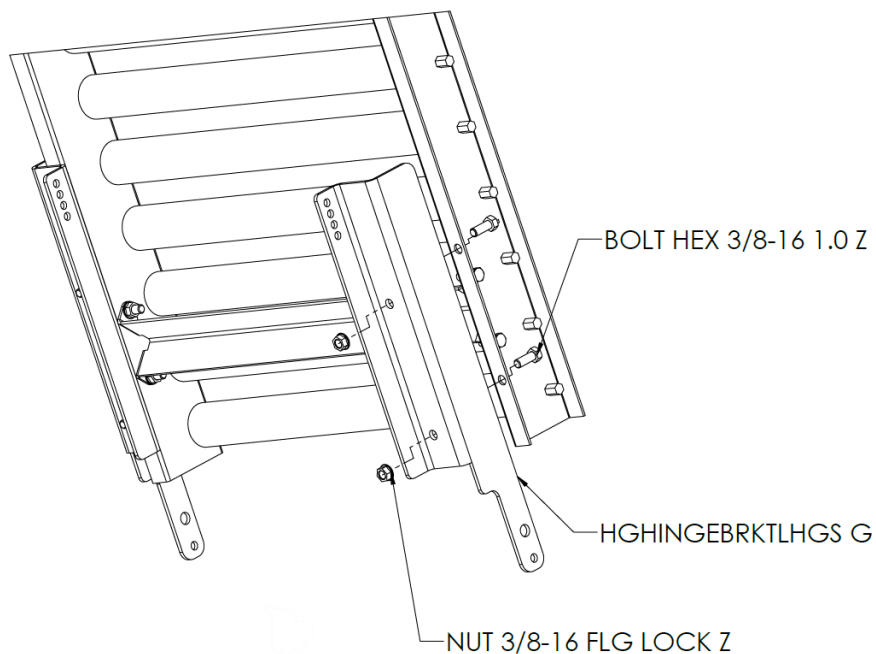
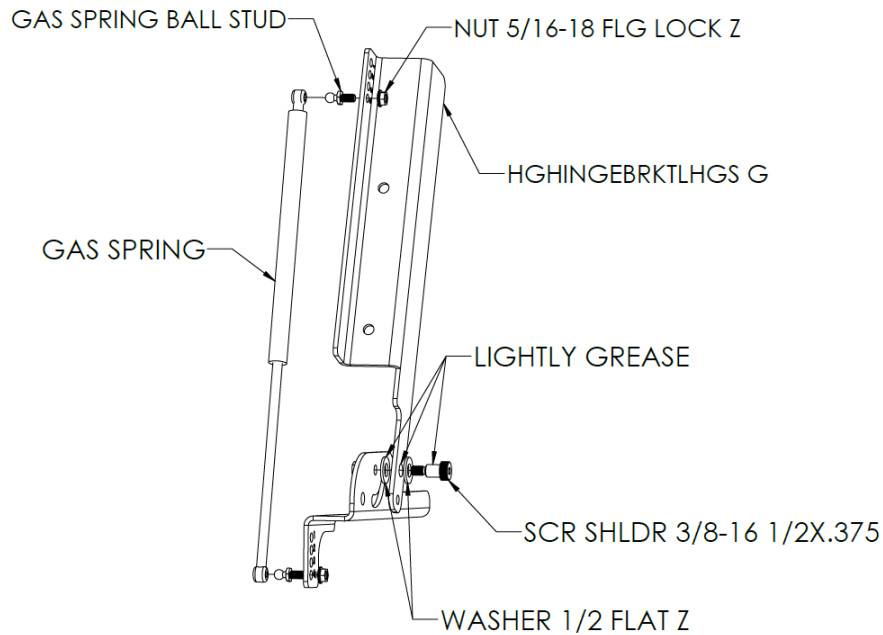


Figure 6

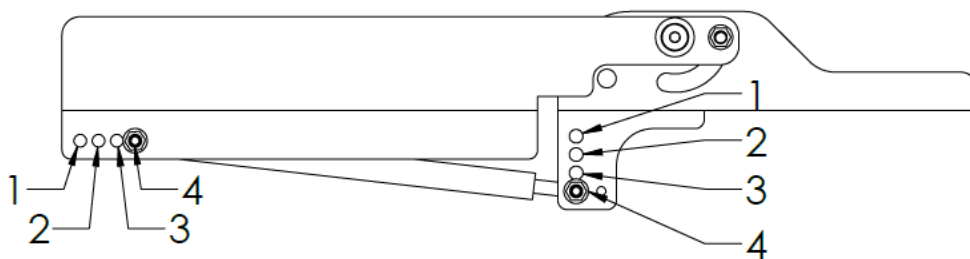
7. Attach the Hinge Brackets to the Pivot Brackets:
  - a. Lightly grease the faces of both 1/2" flat washers and the body of the shoulder bolt.
  - b. With two people holding the gate in position attach the hardware as shown.
  - c. Secure with 3/8-16 flange nut and tighten both sides.



*Figure 7*

8. Open gate fully and attach gas spring ball studs using 5/16-18 flange nuts provided, two per side per side. Attach gas spring by snapping the sockets onto ball studs. Use the following chart for standard conveyor gate configurations.

### Hole Location Drawing



*Figure 8*

## Standard Gate Hole Location Chart

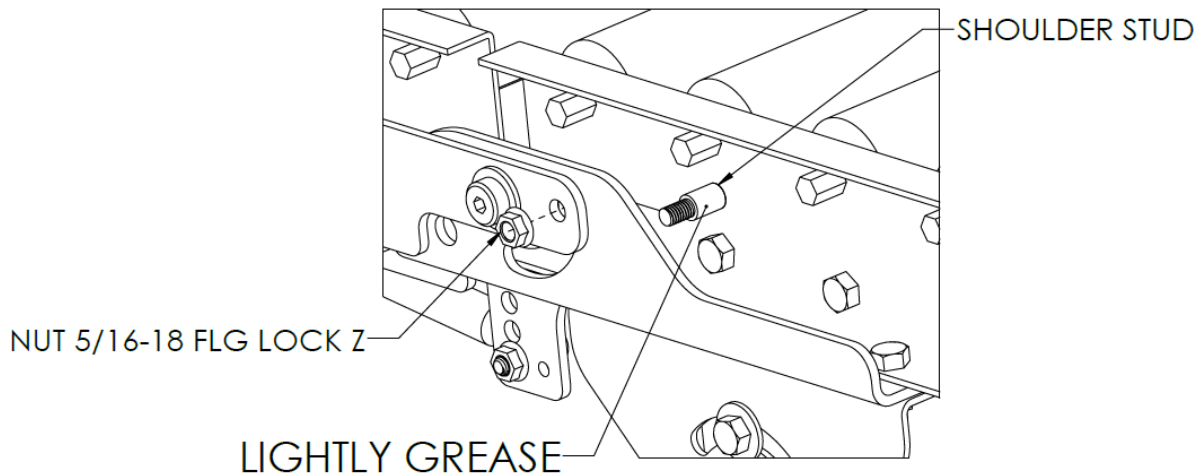
Gate Conveyor	Gas Spring Gate Kit	Mounting Holes
12X10AX03ANC	64053	1
18X16AX03ANC	64053	1
24X20AX03ANC	63402	1
12X10GX03GNC	63402	1
18X16GX03GNC	63402	2
24X20GX03GNC	63402	2
11F03EG15B10NC	63403	1
11F03EG15B16NC	63403	3
11F03EG15B22NC	63404	3
10F03KG03B10NC	63403	3
10F03KG03B16NC	63404	3
10F03KG03B22NC	63404	4

9. For non-standard gate use the following table and reference the conveyor gate length and weight to select the appropriate gate kit. Install ball studs and gas springs using hole location “1” (see figure 8). If “lighter” opening force is desired adjust to hole “2” or higher. CAUTION: Never go below a minimum five-pound lifting force.

## Non-Standard Gate Kit Recommendation

Gas Spring Gate Kit	36” OAL Gate Conveyor Wt.	48” OAL Gate Conveyor Wt.
64053	12 to 20 lbs.	12 to 18 lbs.
63402	21 to 40 lbs.	19 to 36 lbs.
63403	41 to 55 lbs.	37 to 50 lbs.
63404	56 to 84 lbs.	51 to 76 lbs.
64054	85 to 115 lbs.	76 to 105 lbs.

10. Close gate and check for alignment and interference. Make necessary adjustments. Tighten all bolts. Lightly grease body of both Shoulder Studs, mount and secure with 5/16 to 18 flange nuts. NOTE: Remove shoulder studs when replacing or adjusting gas springs. Reinstall shoulder studs after replacement or adjustment is complete.



*Figure 9*

## Parts List

Item	Qty	Part Number	Description
1	12	10616	BOLT HEX 3/8 to 16 1.0 Z
2	2	63328	GAS SPRING 20.12X40LBS
3	4	63379	GAS SPRING BALL STUD
4	2	63400	GATE HANDLE 3/8 Z
5	2	63209	HS STOP G60
6	1	63376	HHINGEBRKTLHGS G
7	1	63377	HHINGEBRKTRHGS G
8	1	63374	HGPIVBRKTLHGS G
9	1	63375	HGPIVBRKTRHGS G
10	2	51345	HOOK STUD
11	22	10631	NUT 3/8 to 16 FLG LOCK Z
12	6	10657	NUT 5/16 to 18 FLG LOCK Z
13	2	50474	SCR SHLDR 3/18 to 16 1/2X.375
14	4	10689	WASHER 1/2 FLAT Z



Parts Illustrations

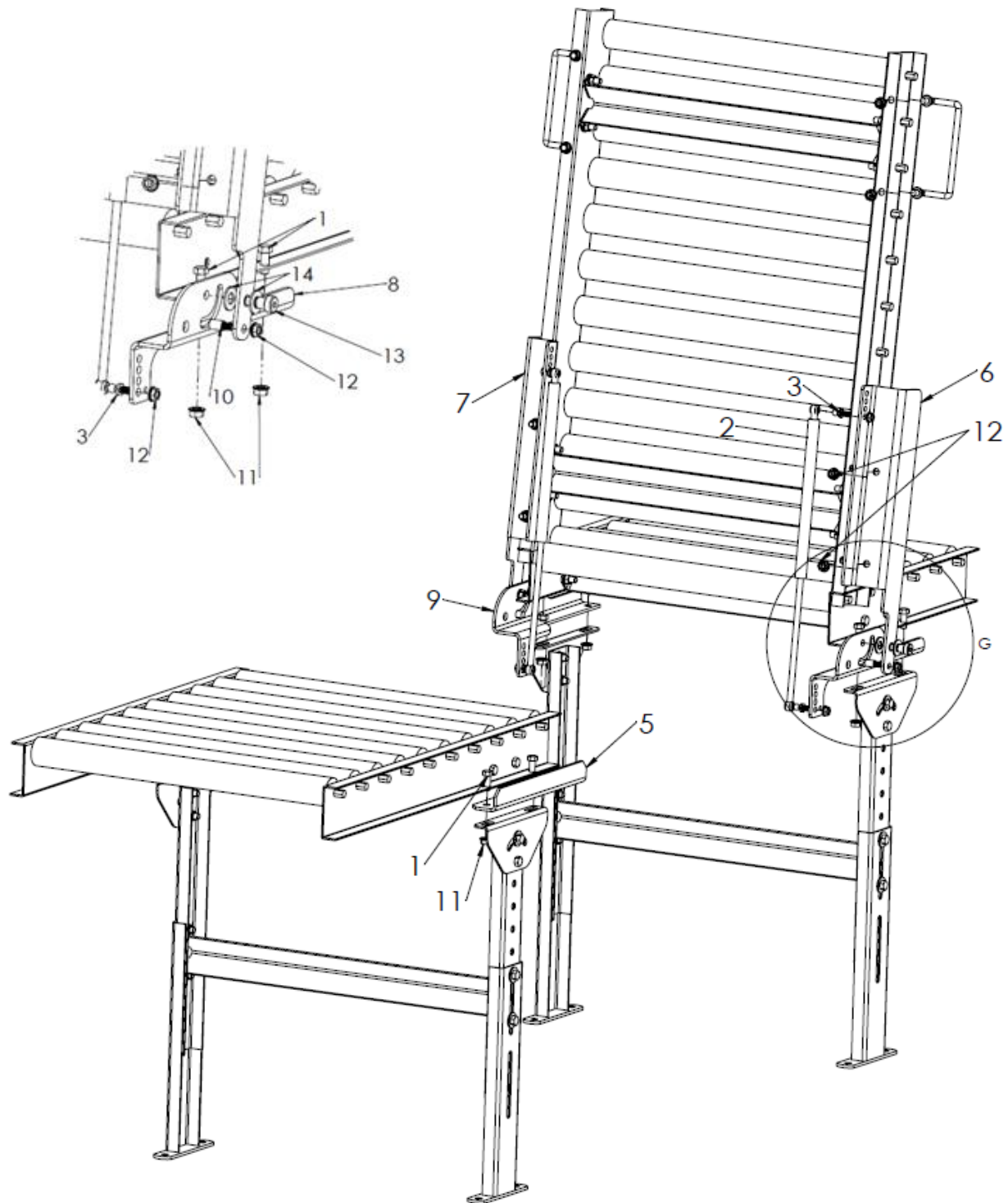


Figure 10

## Trouble Shooting

1. Gate opening effort is too high.
  - a. Check spring hole location per Hole Location Chart
  - b. Increase spring force by changing position of spring (fig 8) hole location 4 will provide the highest force. CAUTION: Never go below a five pound lifting force.
  - c. Replace Gas springs. *Contact Ashland Conveyor Products for correct replacement spring.*
  
2. Gate won't stay in closed position.
  - a. Check spring hole location per Hole Location Chart
  - b. Decrease spring force by changing position of spring (fig 8) location 1 will provide the least amount of force.
  - c. Replace Gas springs. *Contact Ashland Conveyor Products for correct replacement spring.*

## Maintenance

1. Lightly grease components in fig 7 and fig 9 on an annual basis.
2. Replace gas springs if worn. Shoulder studs Fig 9 should be removed when replacing gas springs. Reinstall studs after spring replacement.

## Spare Parts List

Part Number	Description
63398	HGHINGEBRKT SET G60
63399	HGPIVBRKT GS SET G60
59442	GAS SPRING 20.12X20LBS
63328	GAS SPRING 20.12X40LBS
63335	GAS SPRING 20.12X60LBS
63380	GAS SPRING 20.12X90LBS
59443	GAS SPRING 20.12X120LBS
63401	GATE HANDLE KIT