

# HONEYVILLE Conveyor Supports

**Model**  
4624C

Dealer Name: \_\_\_\_\_

Dealer Order #: \_\_\_\_\_

Project Name: \_\_\_\_\_

Honeyville Order #: \_\_\_\_\_

Length (ft): \_\_\_\_\_

*Honeyville Metal, Inc.*

4200 S 900 W  
Topeka, IN 46571



## TABLE OF CONTENTS

Table of Contents .....	1-1
Introduction.....	2-1
Parts List .....	3-1
Assembly.....	4-1
Installation.....	5-1
Warranty .....	6-1
Certificate of Quality .....	6-2



## INTRODUCTION

Thank you for purchasing a Honeyville Conveyor Support. This manual will provide step by step procedures that will provide a smooth assembly process for your conveyor support.

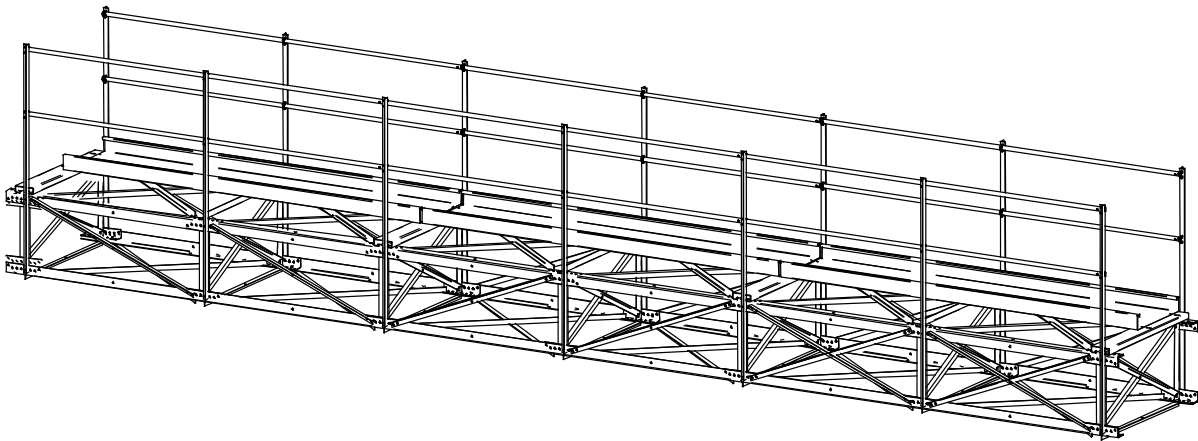
This structure is designed to support a conveyor (drag type or U-trough type) and also provide a 24" wide walkway for service personnel. This walkway provides industry standard handrailing and adequate toe kick protection for a safe access to the conveyor for qualified service personnel.

Safety equipment should be used at all times; fall protection gear should be worn by service or inspection personnel when performing tasks on equipment located on this support structure.

Honeyville Conveyor Supports have been designed to meet the following conditions:

- 40' clear span fully loaded without any additional cable trusses or support posts.
- 140 lbs. per running foot loading on structure. This is the combined weight of the conveyor and the product being conveyed.
- Additional snow load of 55 lbs. per square foot.
- Wind loading of 110 mph.
- Designed to be installed in horizontal position +/- 10°.

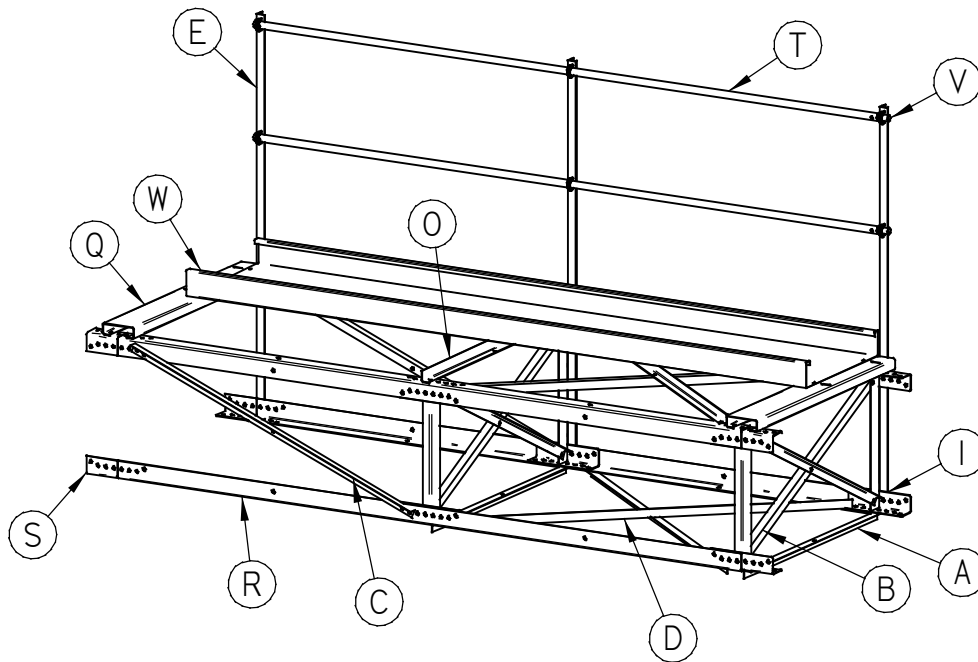
This support structure has been certified by an independent engineering firm (PES Associates, Inc.) to meet the conditions stated.



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**PARTS LIST**



SOME PARTS NO SHOWN FOR CLARITY.

Item	Part No.	Description	Size
A	CWAS-4624	1-1/2" x 1-1/2" x 1/8" Galv Angle	44-1/2"
B	CWBS-4624	1-1/2" x 1-1/2" x 1/8" Galv Angle	47-1/2"
C	CWCS-4624	1-1/2" x 1-1/2" x 1/8" Galv Angle	58"
D	CWDS-4624	1-1/2" x 1-1/2" x 1/8" Galv Angle	66-1/2"
E	CWES-4624	1-1/2" x 1-1/2" x 1/4" Galv Angle	68-1/2"
I	CWIW-4624	12" x 24" Connector	
O	CWOC-4624	1-1/2" x 2" Formed Angle	46"
Q	CWQC-4624	2" x 6" Formed Channel	46"
R	CWRT-4624120	3" x 3" Main Rail	119-15/16"
S	CWST-4624	3" x 3" Rail End	5-15/16"
T	CWTS-240	1-1/4" Tubing	20'
V	CWVS-1	1-1/16" Tubing	4"
W	CWGS1001	24" Grip-Strut	119-1/4"
	HWMB508008	1/2"-13 x 1" Hex Grade 5 Machine Bolt	
	HWWN1008	1/2"-13 Whiz Nut	
	HWCB50612	3/8"-16 x 1 1/2" Grade 5 Carriage Bolt	
	HWWN1006	3/8"-16 Whiz Nut	
	HWDS1000	#12 x 3/4" Self-Drilling Screw	
	HWUB052235	5/16" x 1-3/8" x 2-3/16" U-Bolt	
	HWNT0205	5/16"-18 Nut	





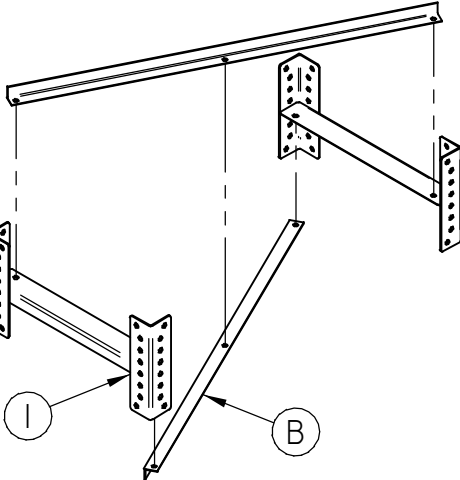
# ASSEMBLY

**Note:**

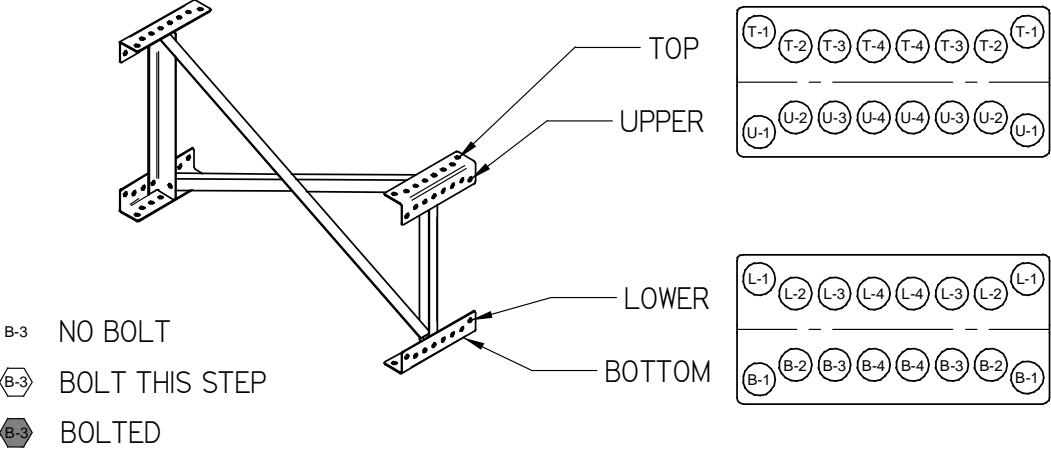
Finger tighten only all nuts until instructed otherwise.  
Use 1/2"-13 x 1" bolts unless specified differently.

**Step 1**

Position "I" connectors so they face the same direction.  
Bolt "B" to "I".  
Bolt "B" together through center holes.



**Explanation of Hole Naming:**

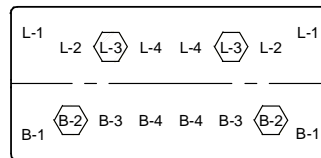
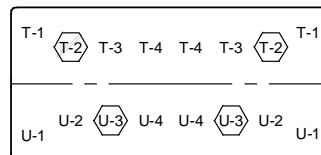
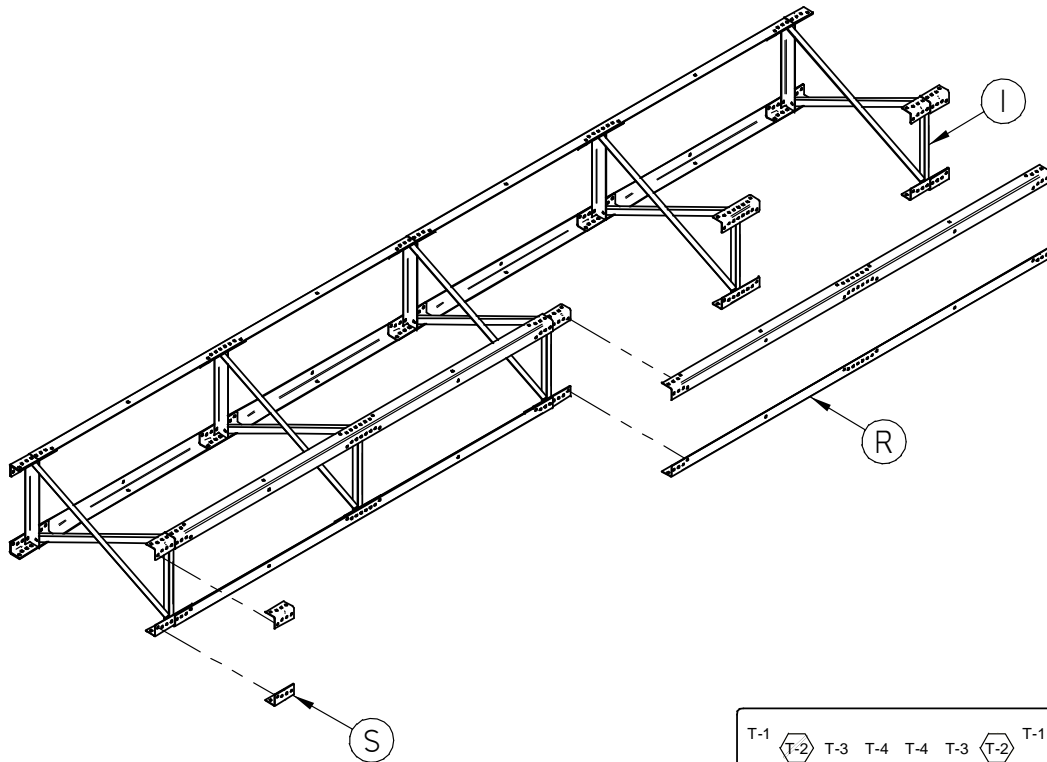


**Step 2**

Bolt "R" to "I" through holes T-2, U-3, L-3, and B-2.

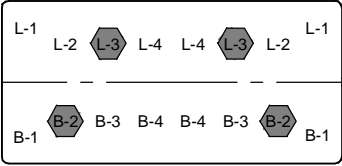
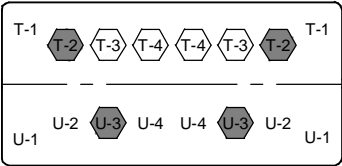
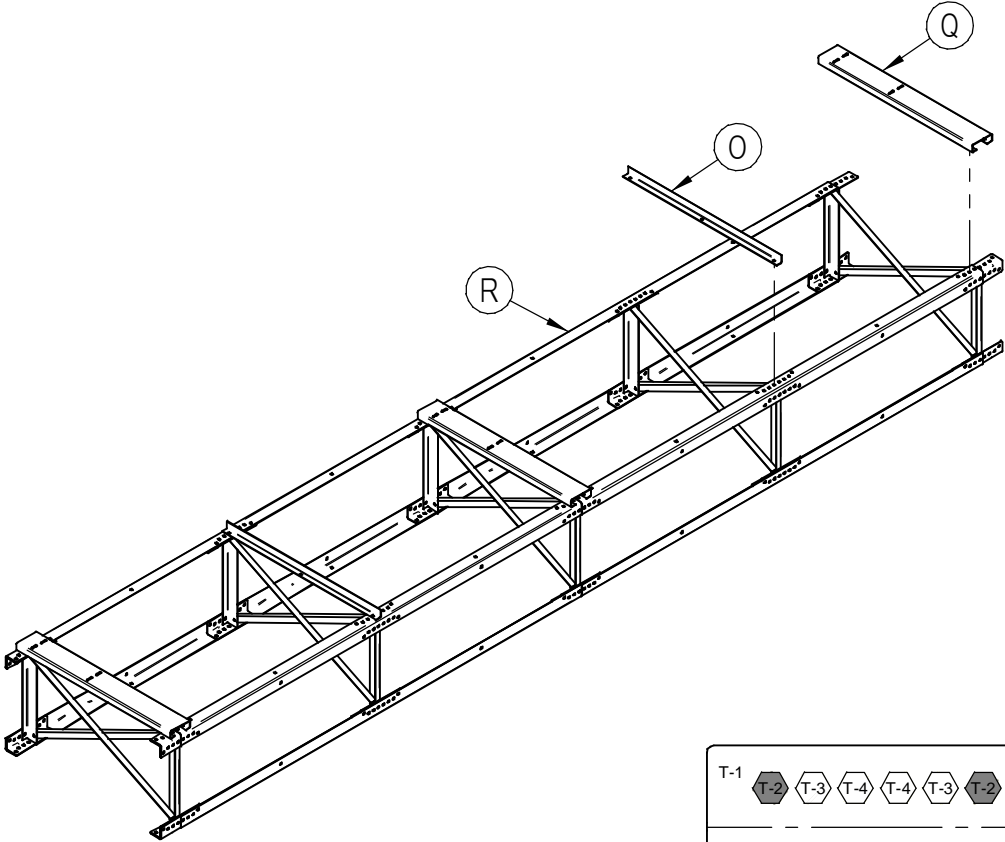
All "I" connectors should face the same direction.

If you are at an end of the conveyor support, bolt "S" to "I".



**Step 3**

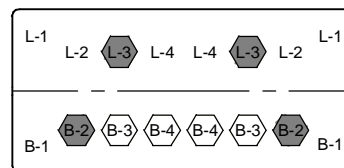
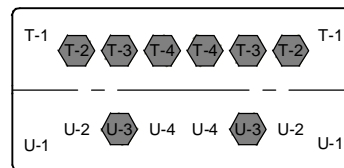
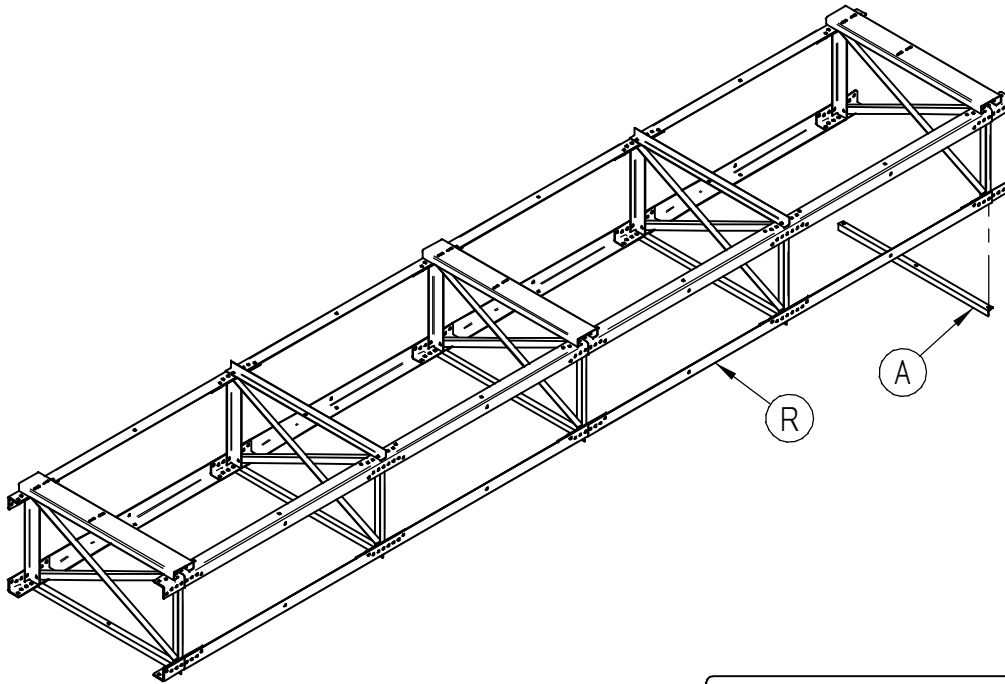
Bolt "Q" to "R" above each "R" splice through hole T-3.  
Bolt "O" to "R" between "R" splices through hole T-4.  
Bolt through all remaining holes T-3 and T-4.



**Step 4**

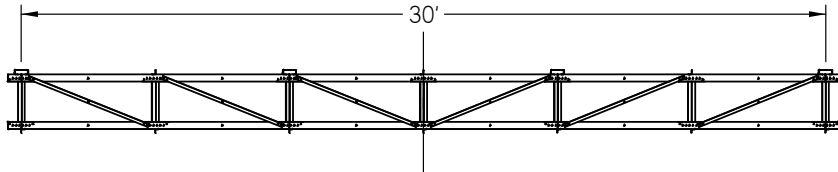
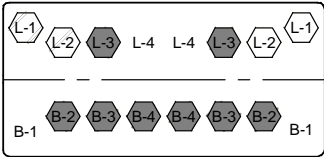
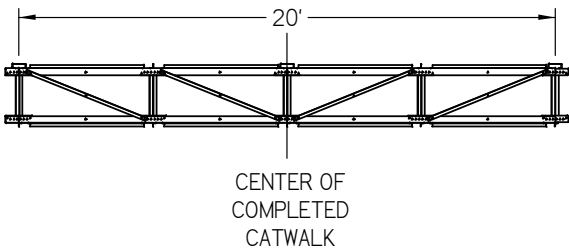
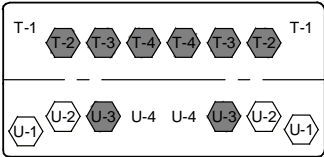
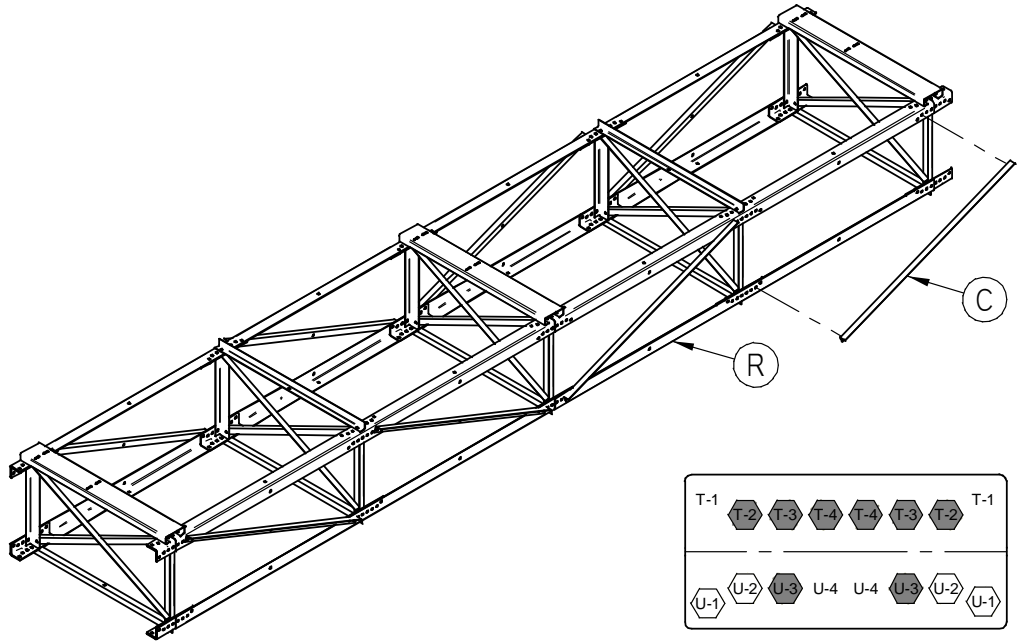
Bolt "A" to "R" through hole B-4.

Bolt through all remaining holes B-3 and B-4.



**Step 5**

Starting at the center and following the diagram for proper placement, bolt "C" to "R" through holes U-1, U-2, L-1, and L-2.  
Bolt through all remaining holes U-1, U-2, L-1, and L-2.



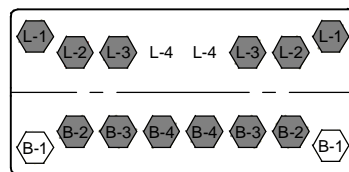
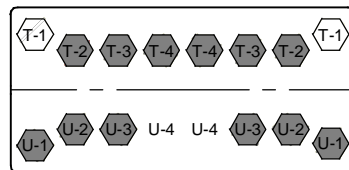
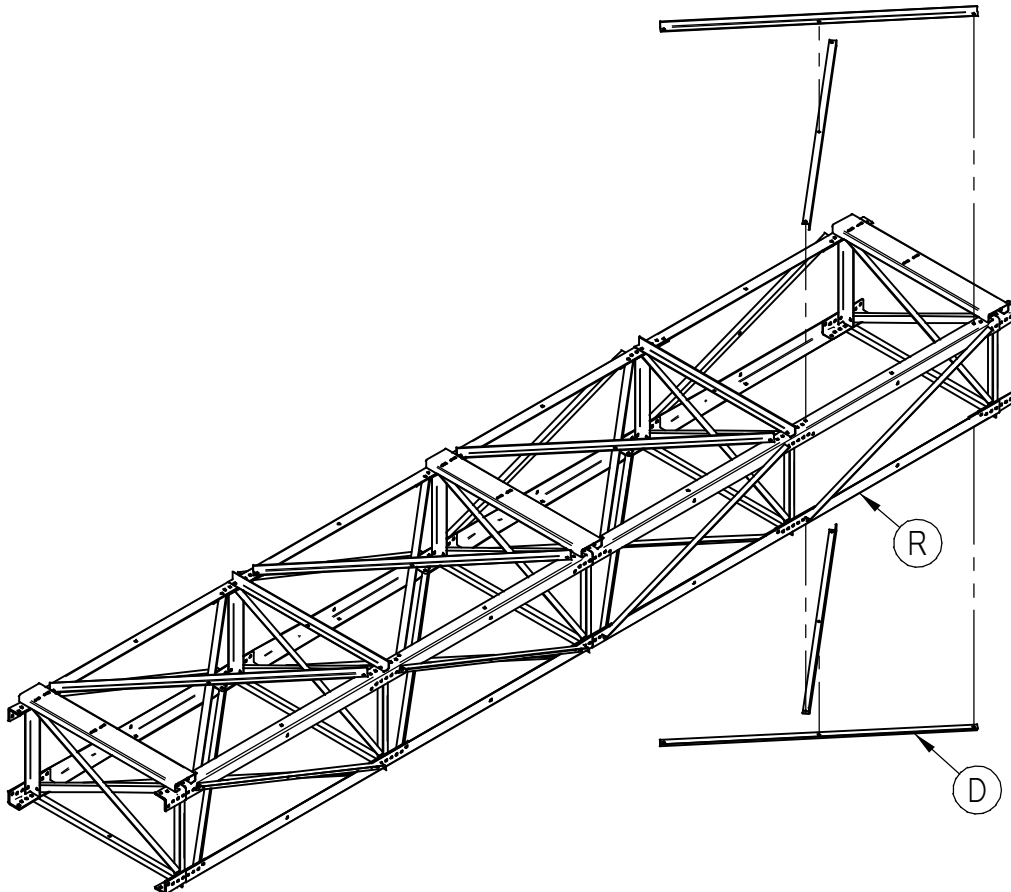
"C" ANGLES LEFT OF CENTER ARE ANGLED LEFT SIDE HIGH, RIGHT SIDE LOW.

CENTER OF COMPLETED CATWALK

"C" ANGLES RIGHT OF CENTER ARE ANGLED LEFT SIDE LOW, RIGHT SIDE HIGH.

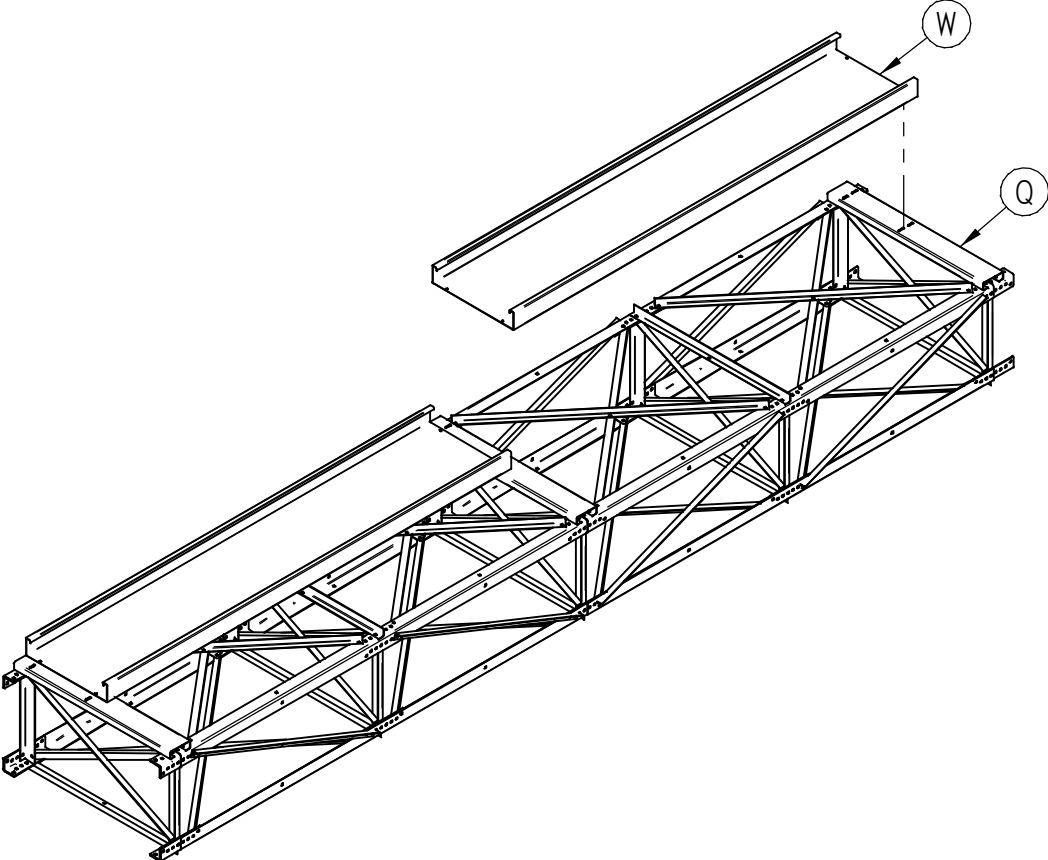
**Step 6**

Bolt "D" to "R" through holes T-1 and B-1.  
Bolt through all remaining holes T-1 and B-1.



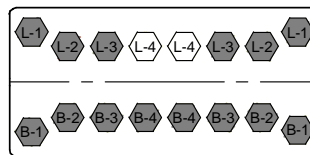
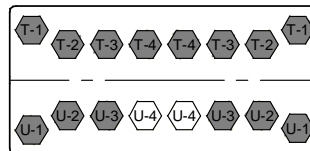
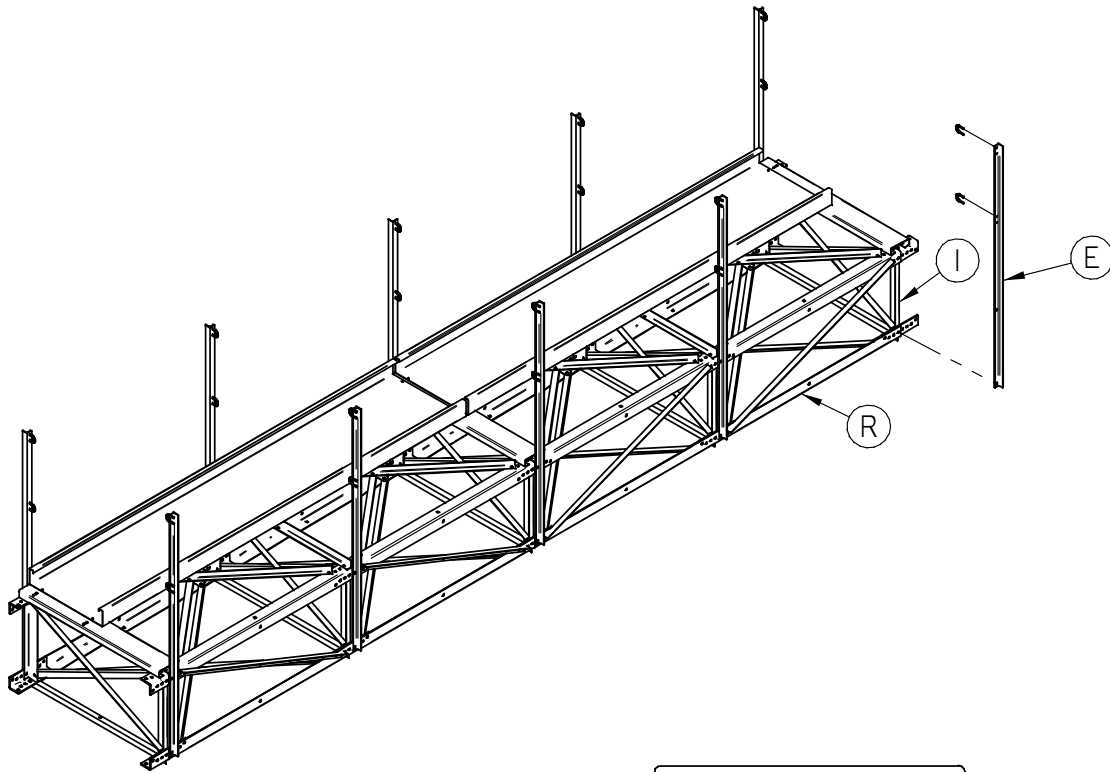
**Step 7**

Using 3/8"-16 x 1 1/2" carriage bolts,  
bolt "W" to "Q" through the slots in the grate.



**Step 8**

Loosely bolt 5/16"-18 x 1 3/8" U-bolts to top of "E".  
Bolt "E" to "R" through holes U-4 and L-4.  
Use the hole in which "I" is only single thickness.  
Bolt through all remaining holes U-4 and L-4.



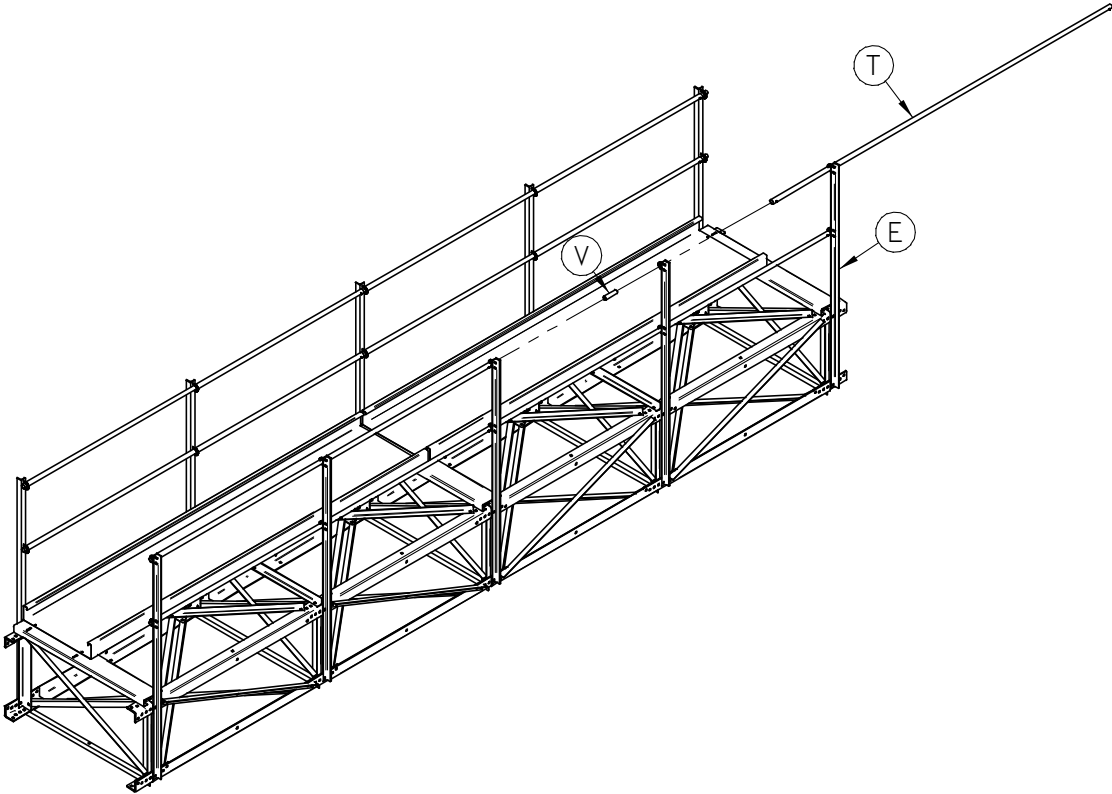


**Step 9**

Square up the conveyor support.  
Tighten all bolts.

**Step 10**

Insert "T" into U-bolts on "E".  
At splices, insert "V" halfway into "T",  
and fasten using #12 x 3/4" self-drilling screws.  
Tighten U-bolts.





## INSTALLATION

### ***Lifting***

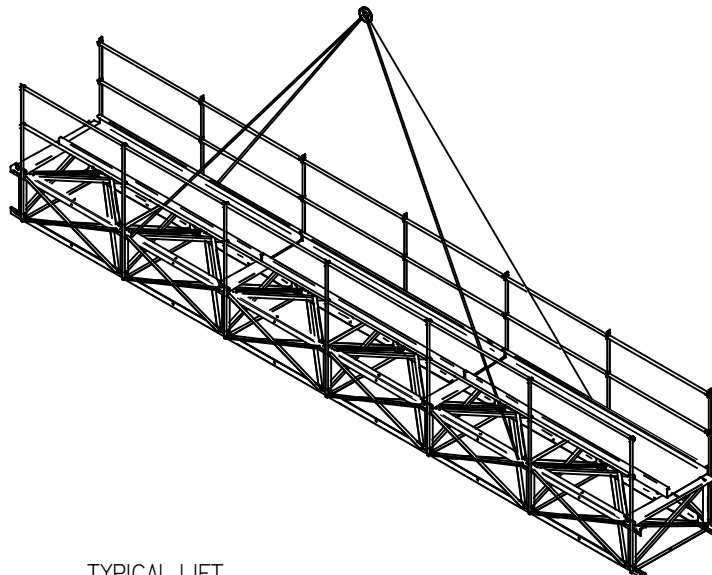
Use of a four-way cable spreader is recommended for lifting assembled conveyor support. Do not lift directly from the handrails or posts supporting the handrails.

### ***Support***

The 4624C Conveyor Support is designed to be supported near each end and intermittently every 40'.

### ***Safety***

All persons in the vicinity of the conveyor support while the conveyor support is being lifted must wear adequate safety gear.



TYPICAL LIFT



## WARRANTY

The full extent of the warranty supplied by Honeyville Metal, Inc. is to correct any defects in material and/or workmanship on the products manufactured only by Honeyville Metal, Inc. This warranty period extends for **one year** from the date the product arrives on the site where installation will take place. Honeyville Metal, Inc. retains the right to review and/or adjust the time period for those products that may be held in inventory at a dealer's warehouse. Honeyville Metal, Inc. retains the final authority on determining if a product is within the warranty period and if full replacement of that product is required to retain the integrity of our products reputation and meet the customer's expectations. Honeyville Metal, Inc. will not furnish labor for replacement of any defective product or components of a product. Any product that is determined defective by both Honeyville Metal, Inc. and the end user who purchased the product may not be returned to Honeyville Metal, Inc. without the receipt of Return Authorization. Returned products must be shipped to Honeyville Metal, Inc. prepaid unless instructed otherwise and must be clearly marked with a Return Merchandise Authorization (RMA) number that needs to be obtained prior to the return shipment. This warranty supplied by Honeyville Metal, Inc. excludes damage to products while in transit to the destination on all public forms of transportation except the trucking equipment owned and operated by Honeyville Metal, Inc. This warranty does not cover performance guarantees on products, only defects in material and/or workmanship as prior statement. Honeyville Metal, Inc. does honor vendor warranties that extend beyond the one year period and will pass warranty coverage on to the purchaser of that vendor product.

## CERTIFICATE OF QUALITY

Every effort has been made to make this equipment the best value you can obtain for your money. All the components have been inspected and assembled. The complete system has been tested to insure proper operation. We sincerely hope this equipment and our efforts meet with your approval. The full extent of Honeyville Metal, Inc. warranty is to correct any defects in material or workmanship in those products manufactured by Honeyville Metal, Inc. Motors and drives, and all electrical and air control parts carry a one-year warranty.

**READ INSTRUCTIONS CAREFULLY BEFORE OPERATING!**

THIS UNIT WAS FINAL INSPECTED AND PACKED BY \_\_\_\_\_