

TYPICAL  
CANTILEVER  
INSTALL  
INFO

## OPERATION

### DEXCO

### Cantilever Racks

#### OPERATION AND MAINTENANCE

- Do not add arms to uprights or modify racks in any way without contacting our engineering department.
- Never climb or stand on racks. Always use appropriate safety equipment to service racks.
- Place loads onto rack vertically. Do not push or slide loads into position. Train operators to set loads gently onto racks, and not drop them.
- Do not overload rack arms, uprights, or decking (if applicable). Each rack system is custom designed to meet the load specifications that were established at time of purchase. Do not exceed these loads without contacting our engineering department.
- Train equipment operators to avoid rack contact. A rack system's useable lifespan is directly related to operator care.
- Be sure to keep all aisles clear of debris. Do not store materials in aisles. Workers and/or customers should stay clear of aisles while equipment is present.
- If racks become damaged, remove loads immediately and do not use that section of rack until the damaged components can be repaired or replaced.

## MAINTENANCE

### DEXCO

#### Cantilever Racks

##### OPERATION AND MAINTENANCE

- Maintenance should be performed on a regular basis, preferably semi-annually, but at least annually.
- Check all connections for missing or loose bolts. Replace any bolt or nut that is missing or has been damaged. Tighten any bolts that may have come loose. Typical torque values for hot dipped galvanized A325 bolts are: 1/2" diameter = 75 - 100 ft-lbs 3/4" diameter = 250 - 350 ft-lbs
- Check all arms for damage. Replace any arm that has been bent by fork contact or being overloaded. Any arm that falls below horizontal when loaded must be replaced. Also, any arm that has been bent horizontally more than 3 degrees should be replaced. Do not attempt to straighten a bent arm.
- Inspect welds on arms and bases for cracks or damage.
- Inspect horizontal and diagonal bracing for damage. Replace any angles or flat bar straps that have been bent or broken.
- Inspect anchors and tighten as necessary.
- Inspect rack for plumb. Rack uprights should be vertical to within 1 inch per 20 feet of height when unloaded. Shim under the bases or columns as necessary.



Ross Technology Corp.  
**ROSS**  
 P.O. Box 646,  
 Leola, Pa. 17540  
 PH (717) 669-2200 FX (717) 669-2281

**TOLERANCES**

Angular (Deg/Min)	± 0' 30"
Linear (Frac)	± 1/16
Linear (Dec)	X ± .1
	XX ± .06
	XXX ± .031

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**Finishing Information**

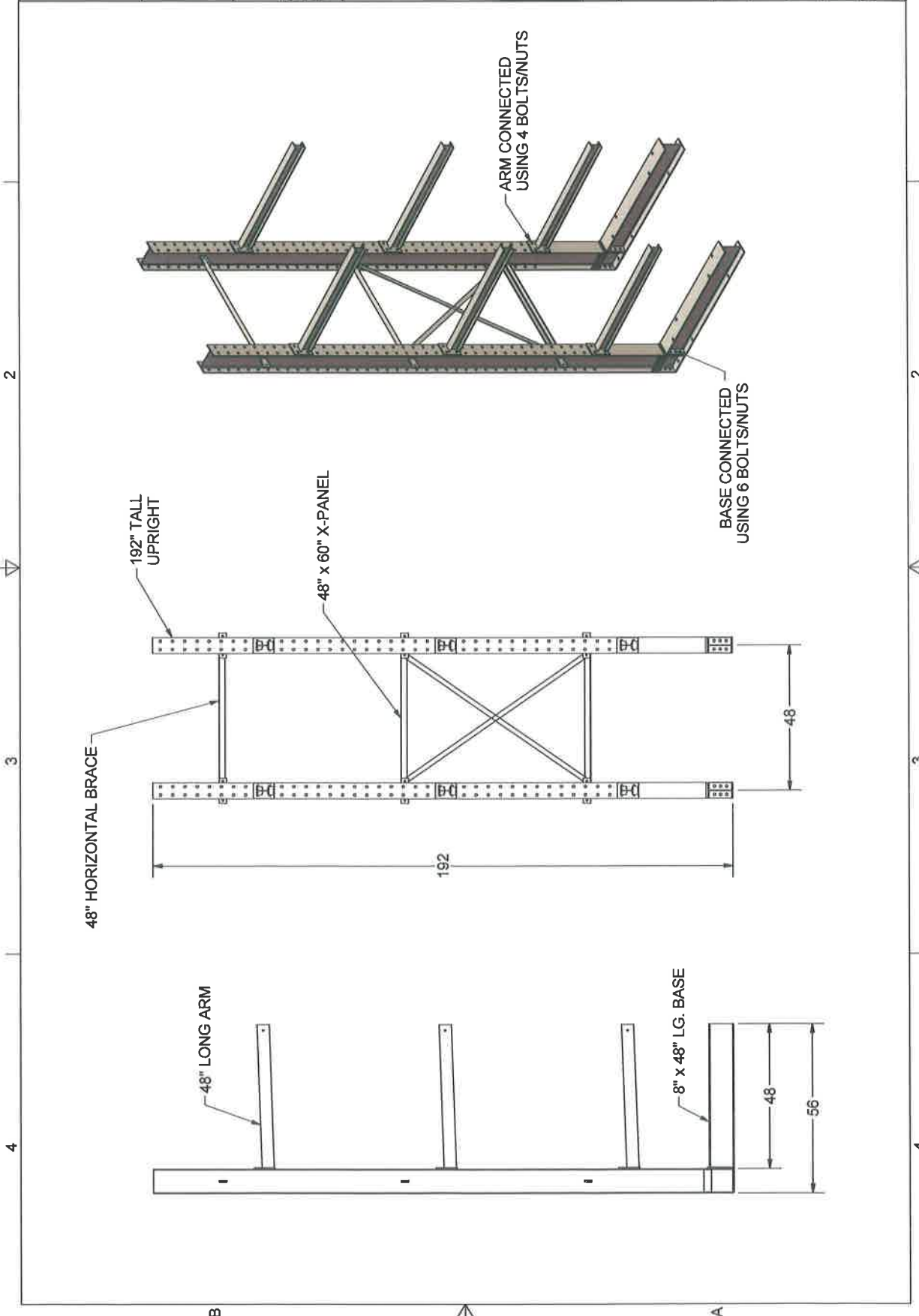
**dexco**  
 STRUCTURAL STEEL  
 BEAM-RIGGING SYSTEMS

WELD IN ACCORDANCE  
 WITH STRUCTURAL WELDING CODE  
 AWS D1.1

DRAWING TITLE  
**EXAMPLE ELEVATION**

DATE	6/26/2017	SCALE	
P.O. NUMBER		WORK ORDER #	
DRAWN BY	CH	CHECKED BY	
SHEET NUMBER	1	REVISION	

DRAWING NUMBER  
**RA021759**



# LUMBERYARD CANTILEVER RACK BRACE PATTERNS

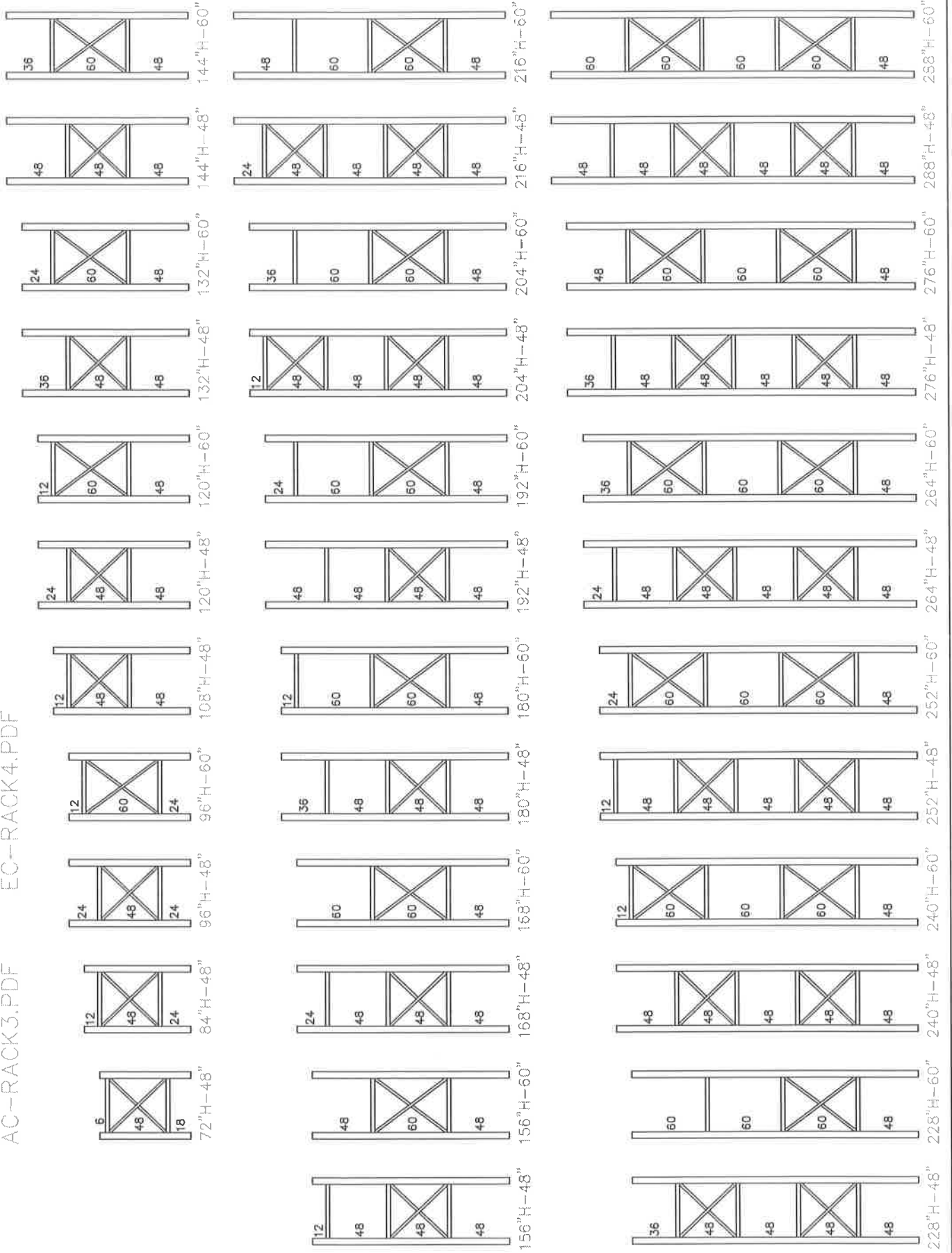
AC--RACK3.PDF

EC--RACK4.PDF

RA-008-029

DISK JPO-11 10/12/95

RCV A: CHANGED MINIMUM ARM ELEVATION NOTE 1/3/99  
 REV:B:3/10/09 REMOVED ARM ELEVATION NOTE



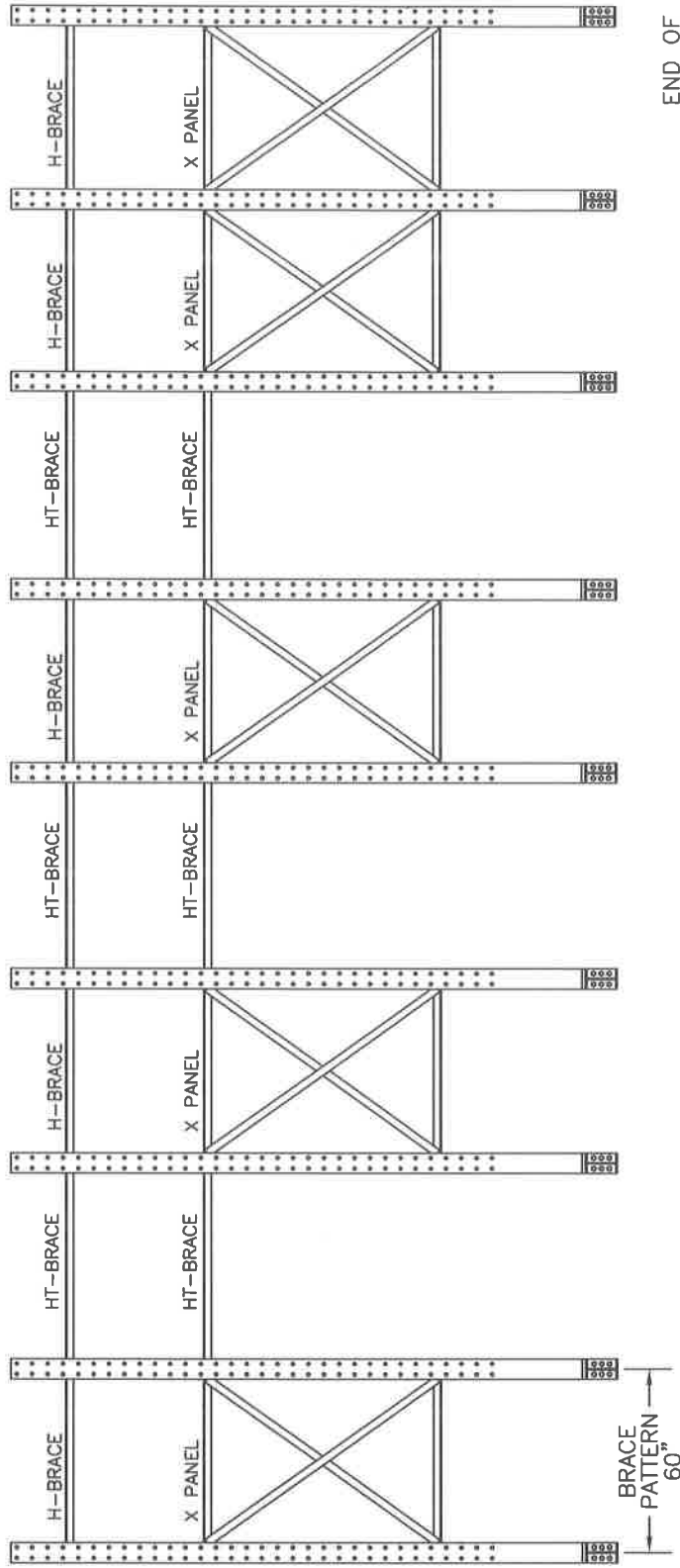
H-BRACES HAVE HOLES IN ENDS

HT -BRACES HAVE SLOTS IN ENDS TO ALLOW FOR TOLERANCE

H-BRACE CONNECTION

TYPE "S" OR "H" BRACE

(2) 1/2" x 1 1/2" BOLTS



UPRIGHT

X PANEL CONNECTION

TYPE "H" PANEL

(4) 1/2" x 1 3/4" BOLTS

UPRIGHT BRACING PATTERN  
WOULD CONTINUE FOR ROW

END OF ROW

ELEVATION AT END OF ROW WITH ODD NUMBER OF UPRIGHTS  
(NOTE LAST THREE UPRIGHTS ARE BRACED TOGETHER)

TYPICAL FRONT ELEVATION OF ROW

TOLERANCES UNLESS NOTED:

ANGULAR (DEC/FAC) ± 2'

ANGULAR (DEG/MIN) ± 30"

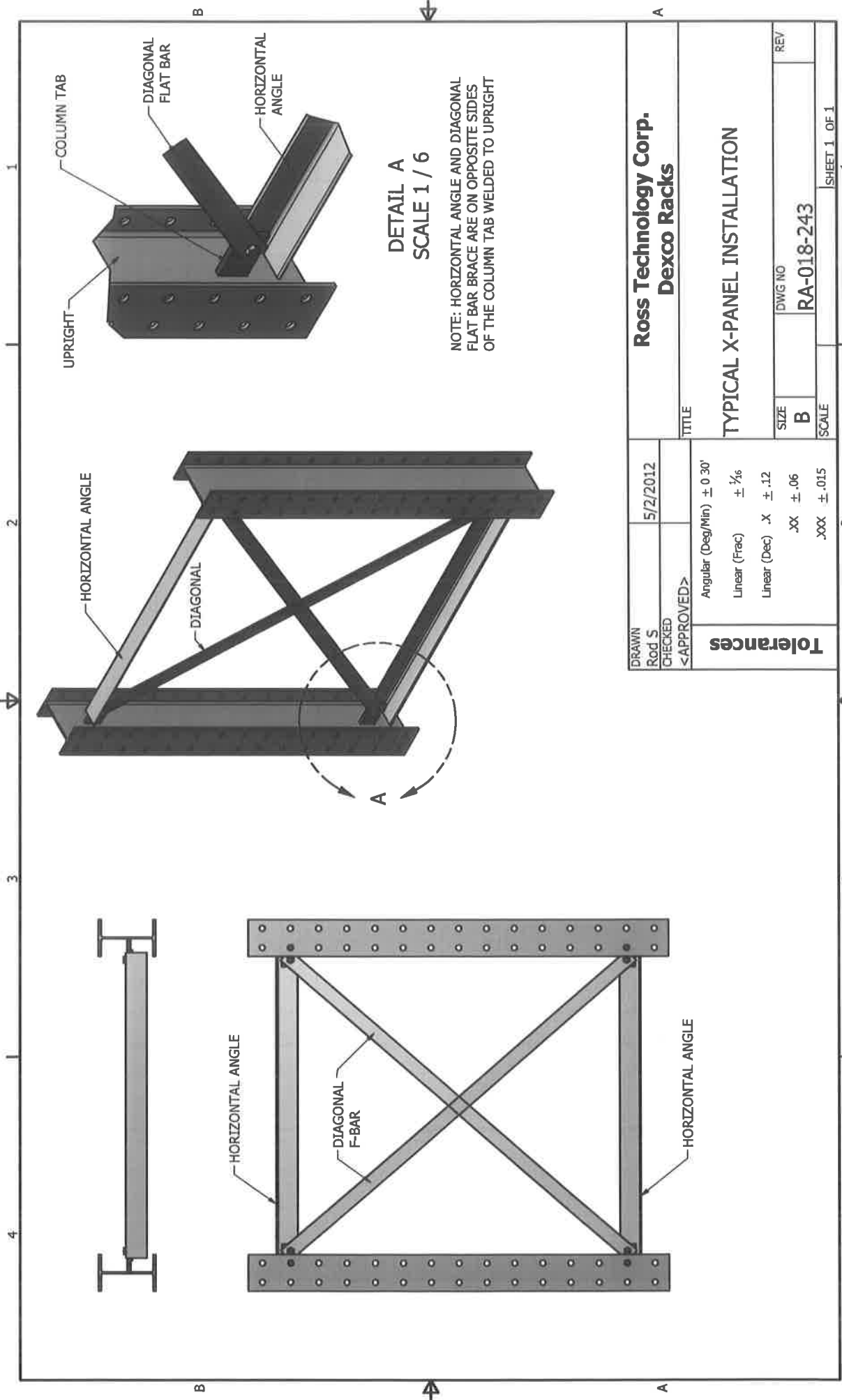
LINEAR (FRAC) ± N/A

LINEAR (DEC.) .0-± N/A

.00-± N/A

.000-± N/A

<b>DEXCO INC.</b>		LEOLA, PA. 17540	
		CUSTOMER	
SCALE	N/A	DATE	4/18/13
TITLE			
		TYP RACK ELEVATION VIEW	
DR. BY	ROD	WORK ORDER NO.	106870
CH. BY		REV.	
APP. BY		DISK NO.	
		DWG. NO.	RA018668



**DETAIL A**  
SCALE 1 / 6

NOTE: HORIZONTAL ANGLE AND DIAGONAL FLAT BAR ARE ON OPPOSITE SIDES OF THE COLUMN TAB WELDED TO UPRIGHT

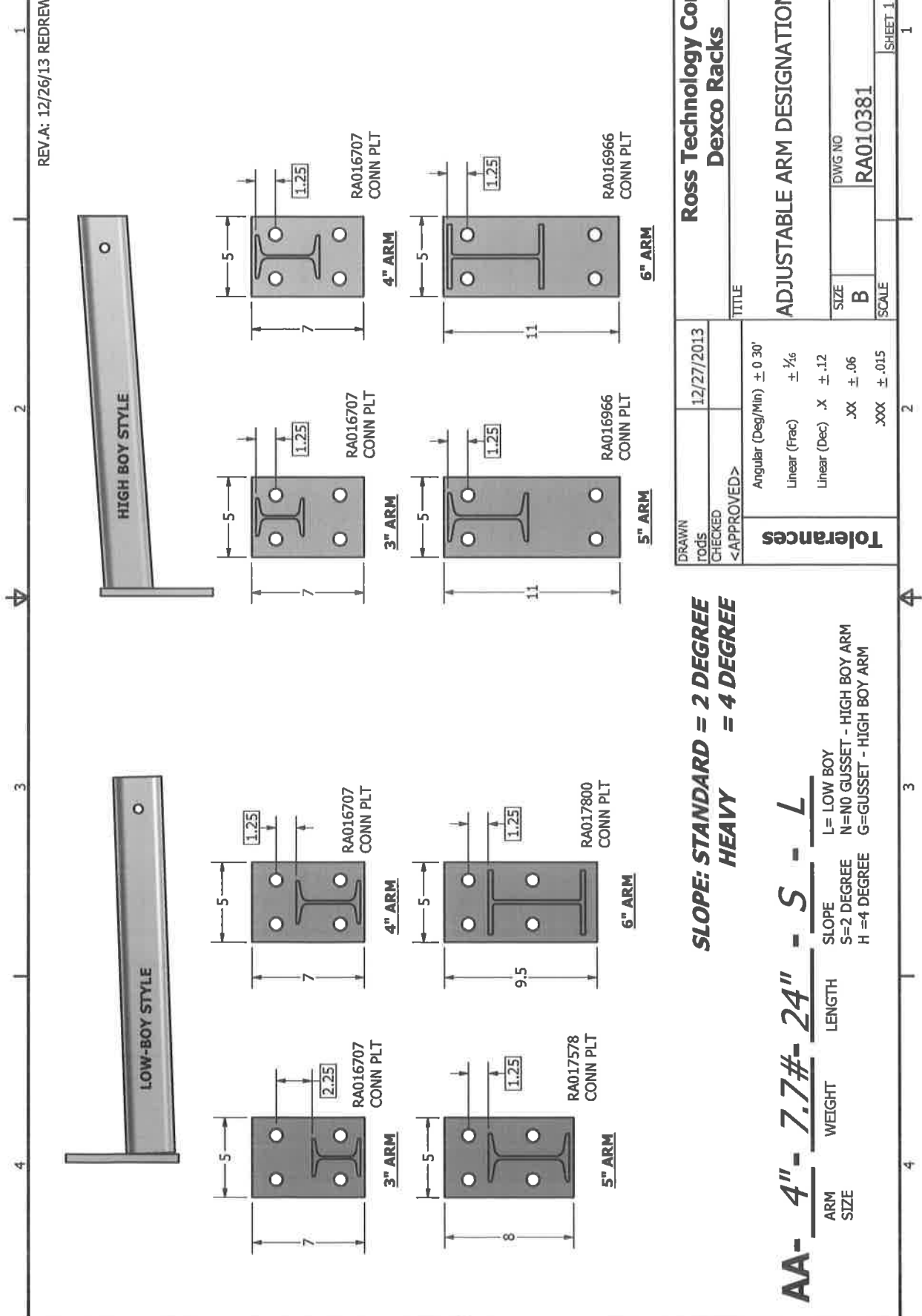
**Ross Technology Corp.**  
**Dexco Racks**

**TYPICAL X-PANEL INSTALLATION**

DRAWN	5/2/2012	TITLE	
ROD S		TYPICAL X-PANEL INSTALLATION	
CHECKED		SIZE	DWG NO
<APPROVED>		<b>B</b>	<b>RA-018-243</b>
Tolerances		SCALE	REV
Angular (Deg/Min)	± 0.30'		
Linear (Frac)	± 1/16		
Linear (Dec)	.X ± .12		
	.XX ± .06		
	.XXX ± .015		



REV.A: 12/26/13 REDREW DRAWING



DRAWN Jods		12/27/2013	TITLE	
CHECKED <APPROVED>			ROSS Technology Corp. Dexco Racks	
Tolerances		Angular (Deg/Min) ± 0.30'	ADJUSTABLE ARM DESIGNATION	
		Linear (Frac) ± 1/16	SIZE	REV
		Linear (Dec) .X ± .12	B	A
		.XX ± .06	DWG NO	
		.XXX ± .015	RA010381	
			SCALE	SHEET 1 OF 1

**SLOPE: STANDARD = 2 DEGREE  
HEAVY = 4 DEGREE**

**AA- 4"- 7.7#- 24" - S - L**

ARM SIZE      WEIGHT      LENGTH      SLOPE

L= LOW BOY      S=2 DEGREE      N=NO GUSSET - HIGH BOY ARM      H =4 DEGREE

G=GUSSET - HIGH BOY ARM

Ross Technology Corp.  
**ROSS**  
 P.O. Box 646,  
 6065 Pa. 17531  
 PA 17145-0646

**TOLERANCES**

Angular (Degrees)	± 0°30'
Linear (Inch)	± .116
Linear (Diac)	X ± .1
	XX ± .06
	XXX ± .031

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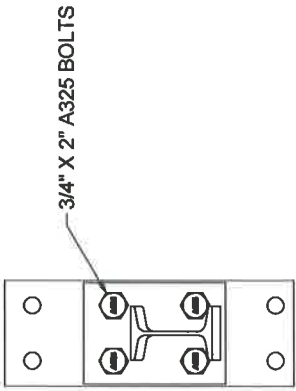


WELD IN ACCORDANCE WITH STRUCTURAL WELDING CODE AWS D1.1

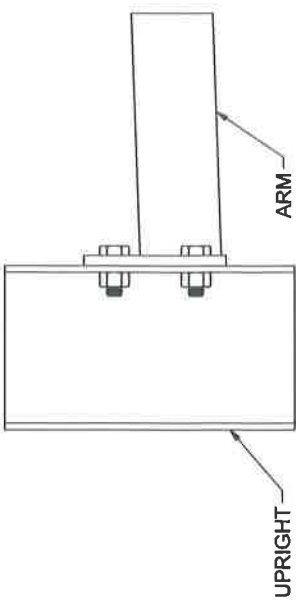
**TYP 4" ARM CONNECTION VIEWS**

DATE	SCALE
12/12/2019	
P.O. NUMBER	WORK ORDER #
DRAWN BY WP	CHECKED BY
SHEET NUMBER 8	REVISION

DRAWING NUMBER  
**RA024522**



USE 3/4" X 2" A325 BOLTS  
 4 REQUIRED PER 4" ARM  
 TORQUE BOLTS TO 250-350 FT LBS



**4 INCH ARM TO UPRIGHT CONNECTION**

Ross Technology Corp.  
**ROSS**  
 P.O. Box 646  
 Leeds, Pa 17540  
 (717) 862-2200 (a 717) 862-2221

**TOLERANCES**

Angular (Degrees)	± 0.30
Linear (Fit)	± 0.16
Linear (Dial)	X ± 1
	XX ± .06
	XXX ± .031

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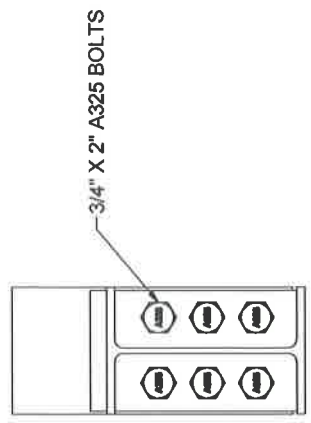
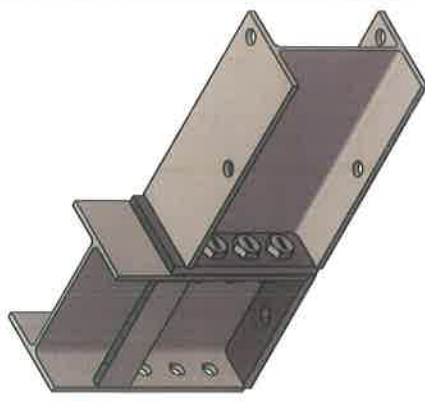


**dexco**  
 STRUCTURAL STEEL  
 FABRICATING SYSTEMS

WELD IN ACCORDANCE  
 WITH STRUCTURAL WELDING CODE  
 AWS D11.1

**DRAWING TITLE**  
 TYPICAL 8" BASE  
 CONNECTION  
 VIEWS

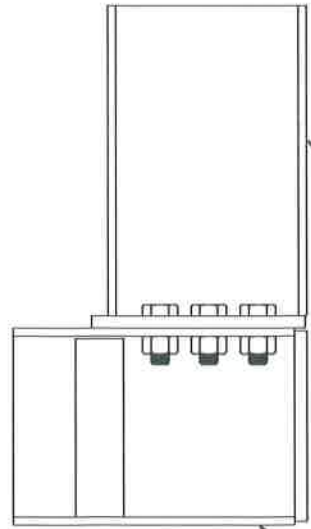
DATE	SCALE
12/12/2019	
P.O. NUMBER	WORK ORDER #
DRAWN BY WP	CHECKED BY
SHEET NUMBER 1	REVISION
DRAWING NUMBER RA024522	



3/4" X 2" A325 BOLTS

USE 3/4" X 2" A325 BOLTS  
 6 REQUIRED PER 8" BASE

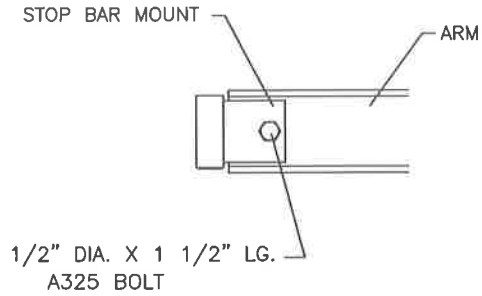
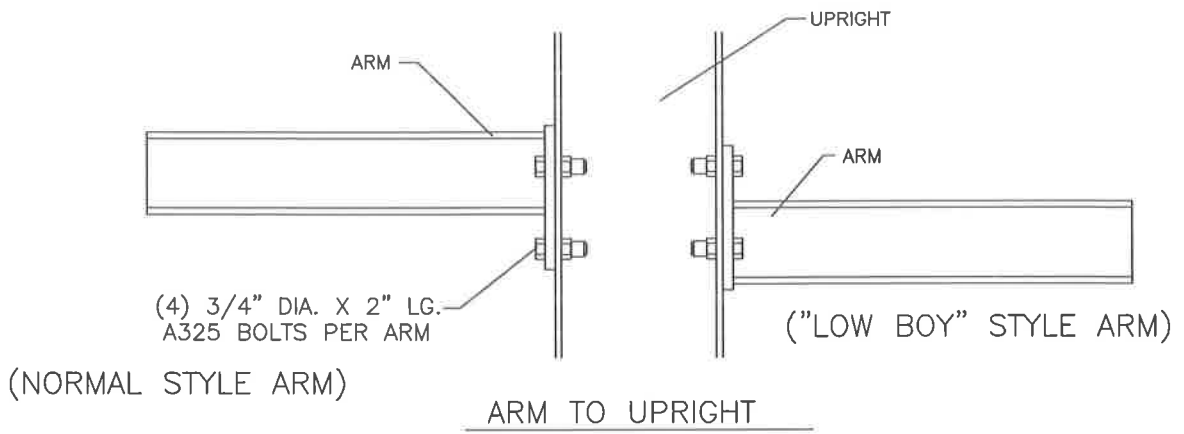
TORQUE BOLTS TO 250-350 FT LBS



BASE

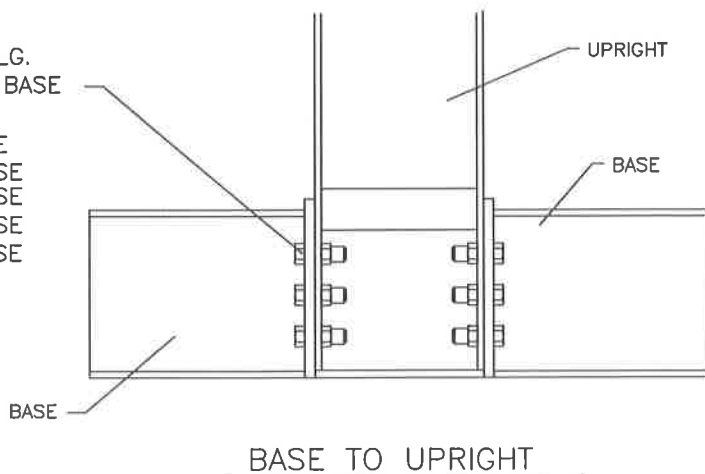
UPRIGHT

**8 INCH BASE TO UPRIGHT CONNECTION**



STOP BAR SOCKET TO ARM CONNECTION

- 3/4" DIA. X 2" LG. A325 BOLTS PER BASE
- (6) PER 8" BASE
  - (8) PER 10" BASE
  - (10) PER 12" BASE
  - (12) PER 14" BASE
  - (14) PER 16" BASE
  - (16) PER 18" BASE



TOLERANCES UNLESS NOTED:

ANGULAR (DEC./FRAC)	± .2°
ANGULAR (DEG./MIN)	± 30'
LINEAR (FRAC)	± N/A
LINEAR (DEC.)	0-± N/A .00-± N/A .000-± N/A

**DEXCO INC.** LEOLA, PA. 17540

CUSTOMER: AC-RACK1.PDF

TITLE

TYP. RACK ASSY. DETAILS

DR. BY ROD

CH. BY

APP. BY

DATE 3/24/08

SCALE N/A

WORK ORDER NO.

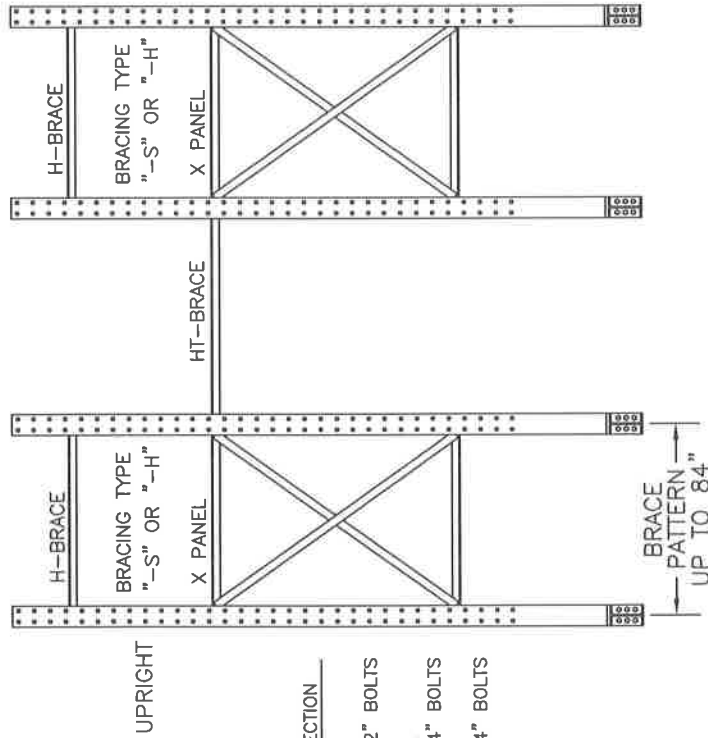
REV.

DISK NO.

DWG. NO. RA016709

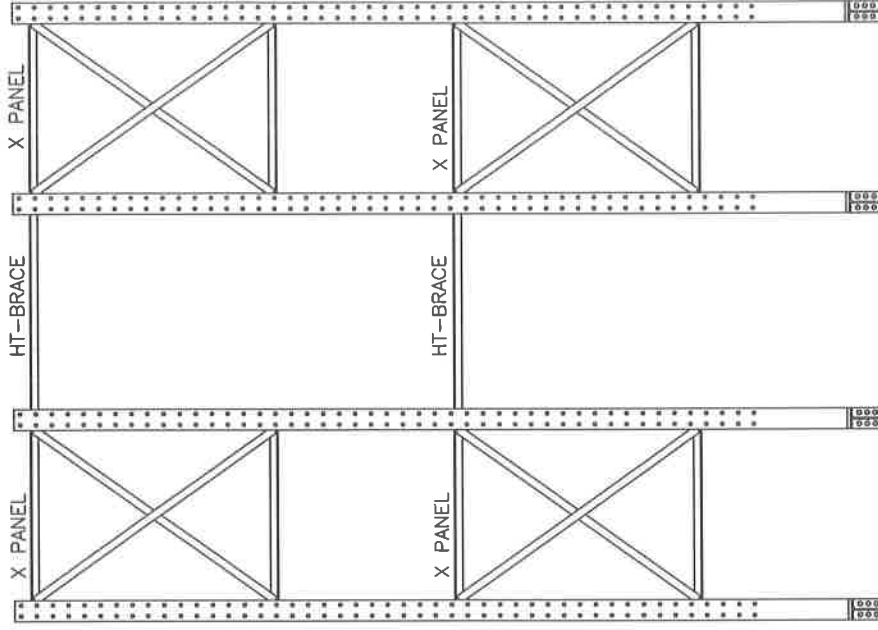
HT-BRACE (1) ONE USED AT  
EACH X-PANEL ELEVATION  
BETWEEN PAIRS OF UPRIGHTS

H-BRACE CONNECTION  
TYPE "S" OR "H" BRACE  
(2) 1/2" X 1 1/2" BOLTS



FRONT ELEVATION  
X-PANEL & H-BRACE  
(SHORTER COLUMNS)

BRACING PATTERNS VARY ON UPRIGHT COLUMNS  
DEPENDING UPON THE HEIGHT OF THE UPRIGHTS  
(REFER TO DWG RA008029 FOR INDIVIDUAL HGT PATTERNS)

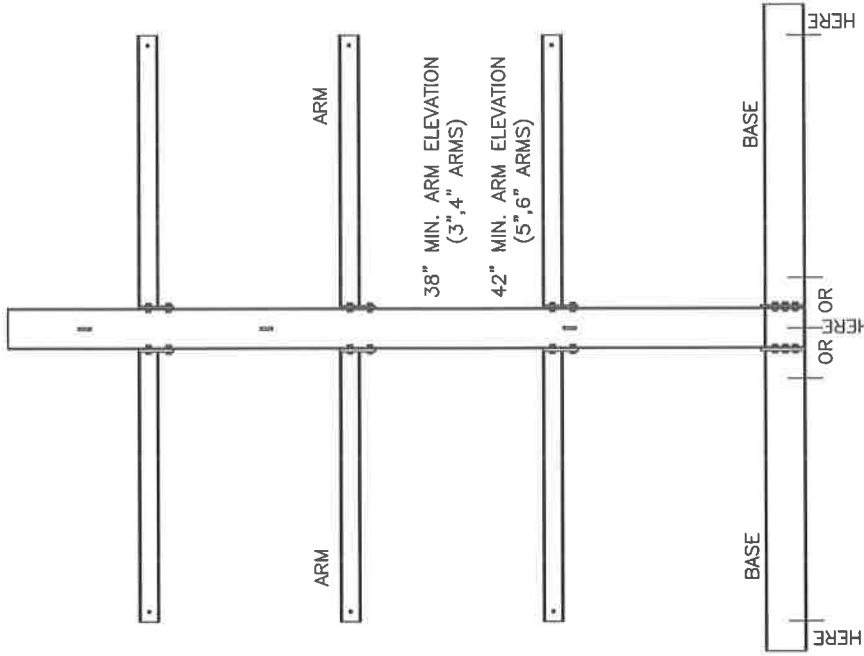


FRONT ELEVATION  
(2) X-PANELS  
(TALLER COLUMNS)

TOLERANCES UNLESS NOTED:		ANGULAR (DEC/FRAC) ± 2'		SCALE N/A		CUSTOMER AC-RACK2.PDF	
ANGULAR (DEG/MIN) ± 30'		LINEAR (FRAC) ± N/A		DATE 3/24/08		TITLE	
LINEAR (DEC.) .0-± N/A		DR. BY ROD		TYP. RACK ASSY. DETAILS		DWG. NO. RA016709A	
.00-± N/A		CH. BY		WORK ORDER NO.		DISK NO.	
.000-± N/A		APP. BY		REV.		LEOLA, PA. 17540	

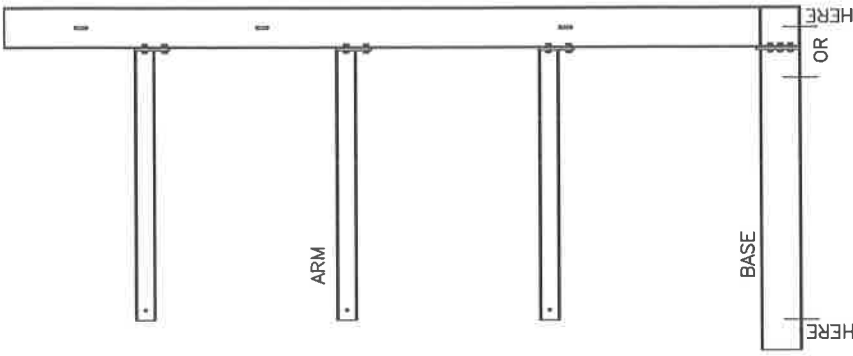
DEXCO INC.

UPRIGHT



DOUBLE SIDE ELEVATION

UPRIGHT



SINGLE SIDE ELEVATION

ANCHOR BOLTS

5/8" DIA. ANCHOR BOLTS,  
 MIN. (3) PER DBL. SIDED  
 ONE @ EA. END OF BASE, ONE @ COLUMN AREA  
 MIN. (2) PER SINGLE SIDED,  
 ONE @ END OF BASE, ONE @ COLUMN AREA

TOLERANCES UNLESS NOTED:

ANGULAR (DEC/FRAC)	± 2'
ANGULAR (DEG/MIN)	± 30'
LINEAR (FRAC)	± N/A
LINEAR (DEC.)	.0-± N/A
	.00-± N/A
	.000-± N/A

**DEXCO INC.** LEOLA, PA. 17540

CUSTOMER AC-RACK4.PDF

SCALE N/A DATE 3/24/08

TITLE TYP. RACK ASSY. DETAILS

DR. BY ROD CH. BY WORK ORDER NO. REV. DISK NO. DWG. NO.

APP. BY RA016709B

Ross Technology Corp.  
**ROSS**  
 P.O. Box 646,  
 Leola, Pa. 17540  
 PH (717) 656-2200 FAX (717) 656-2285

**TOLERANCES**

Angular (Deg/Min)	± 0' 30"
Linear (Fins)	± 1/16
Linear (Dec)	X ± .1
	XX ± .06
	XXX ± .031

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**Finishing Information**

**dexco**  
 STRUCTURAL STEEL  
 CLEAN PAINTING SYSTEMS

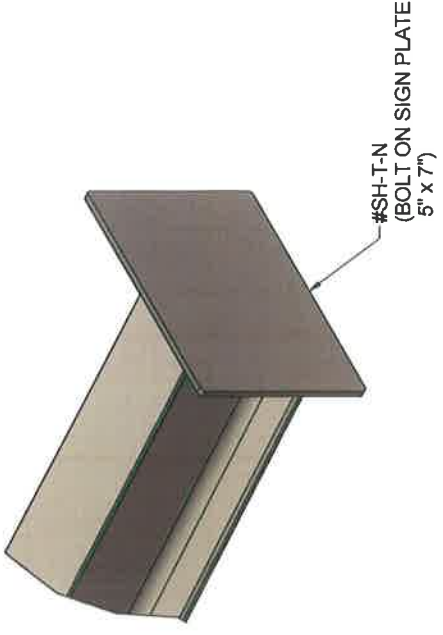
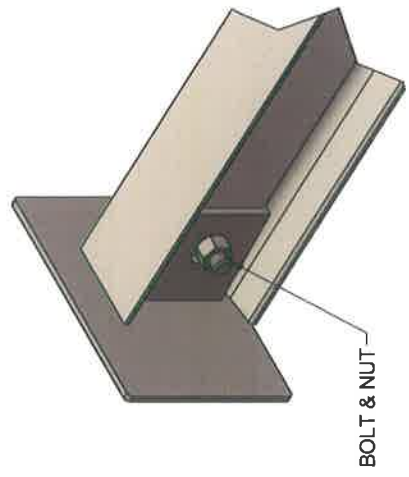
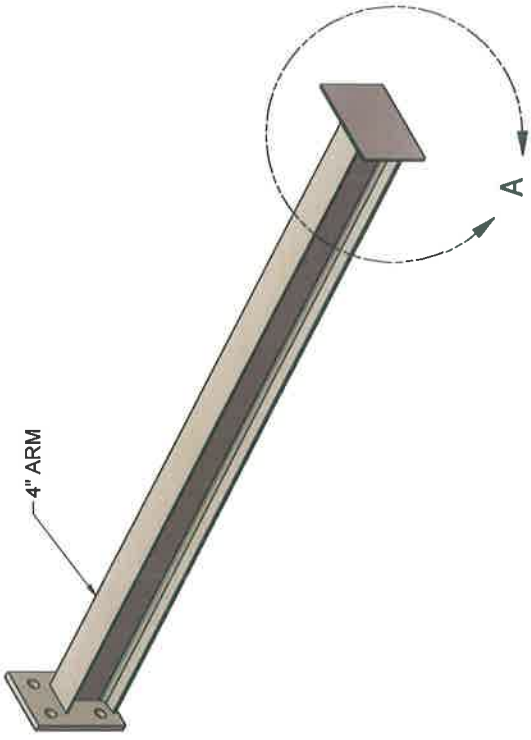
WELD IN ACCORDANCE  
 WITH STRUCTURAL WELDING CODE  
 AWS D1.1

DRAWING TITLE

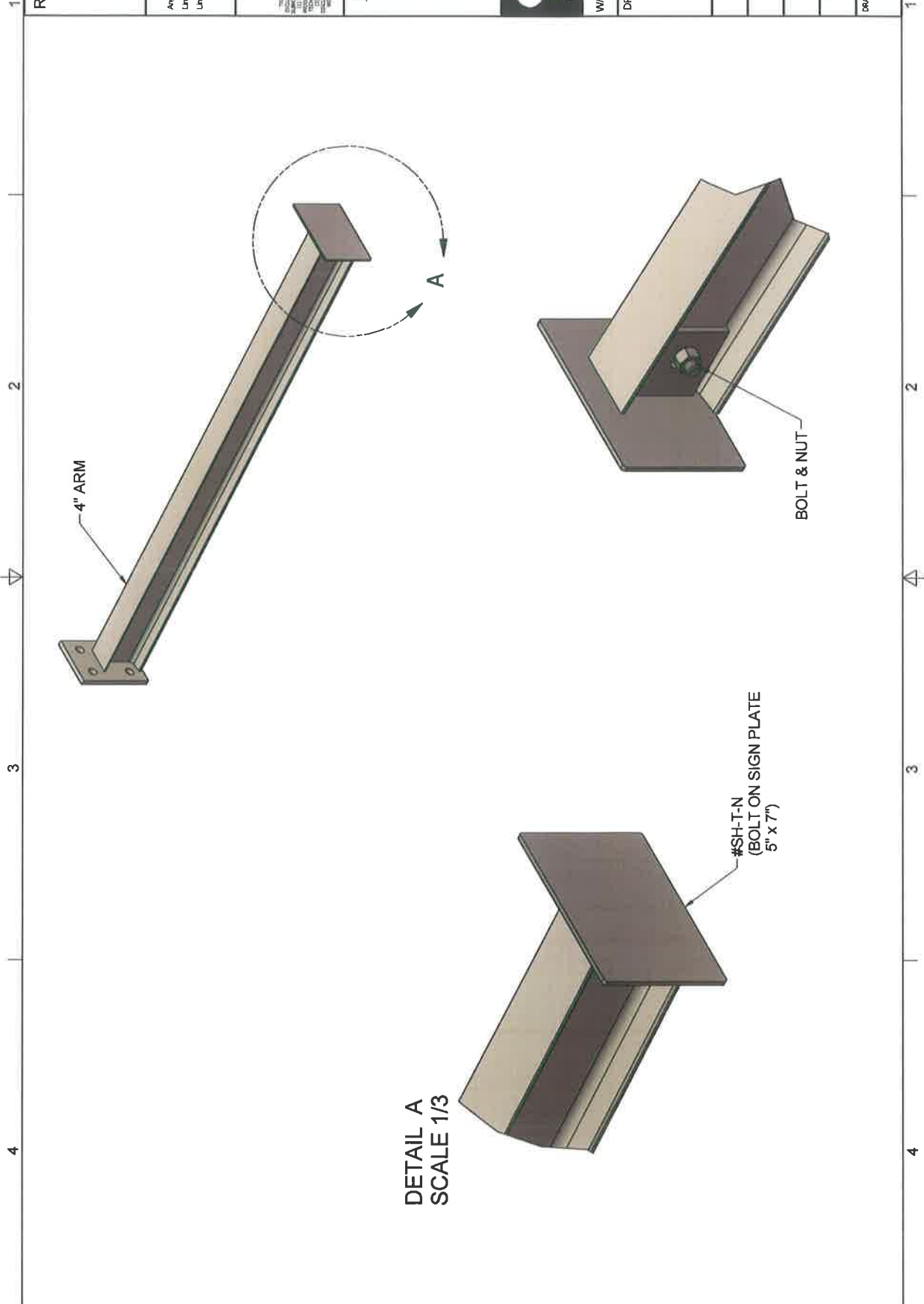
**ARM/SIGN PLATE  
 REPRESENTATION**

DATE	3/13/2017	SCALE	-
P.O. NUMBER	-	WORK ORDER #	-
DRAWN BY	CM	CHECKED BY	-
SHEET NUMBER	1	REVISION	-

DRAWING NUMBER  
 RA021775



**DETAIL A  
 SCALE 1/3**



Ross Technology Corp.  
**ROSS**  
 P.O. Box 646,  
 10000 Pk 1157A  
 Dallas, TX 75246-0646  
 PH (972) 412-2200 FX (972) 412-2201

**TOLERANCES**

Angular (Deg/Min)	± 0'30"
Linear (Frac)	± 1/16
Linear (Dec)	X ± .1
	XX ± .06
	XXX ± .031

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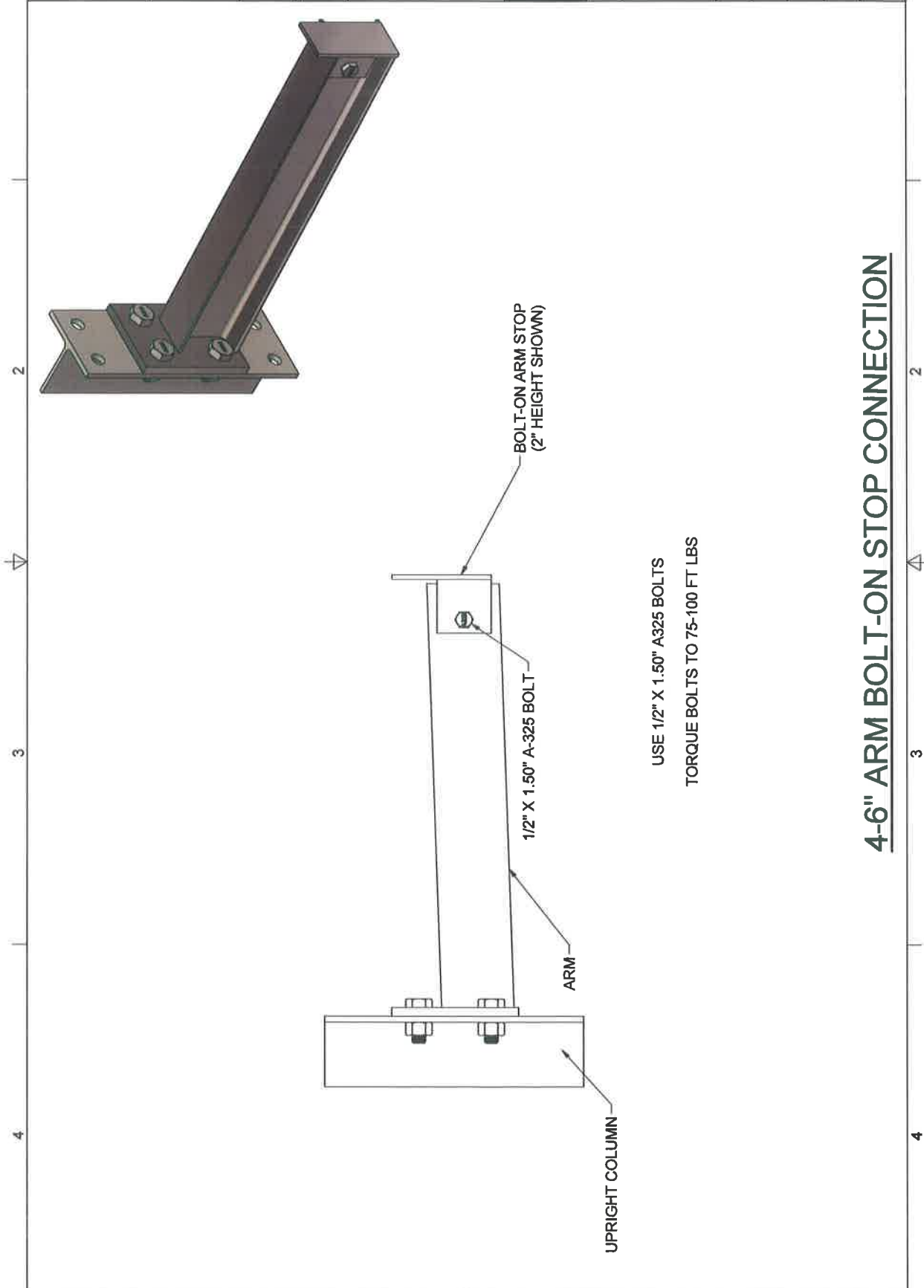


WELD IN ACCORDANCE WITH STRUCTURAL WELDING CODE AWS D1.1

**DRAWING TITLE**  
**BOLT-ON ARM STOP CONNECTIONS FOR 4-6" ARMS**

DATE	12/12/2019	SOLE	
P.O. NUMBER		WORK ORDER #	
DRAWN BY	WP	CHECKED BY	
SHEET NUMBER	14	REVISION	

DRAWING NUMBER  
**RA024522**



USE 1/2" X 1.50" A325 BOLTS  
 TORQUE BOLTS TO 75-100 FT LBS

**4-6" ARM BOLT-ON STOP CONNECTION**



**Ross Technology Corp.**  
**ROSS**  
 P.O. Box 646,  
 Leola, Pa 17540  
 PH (717) 662-2200 FX (717) 662-2281

**TOLERANCES**

Angular (Degrees)	± 0.30
Linear (Inch)	± 1/16
Linear (Diam)	X ± .1
	XX ± .06
	XXX ± .031

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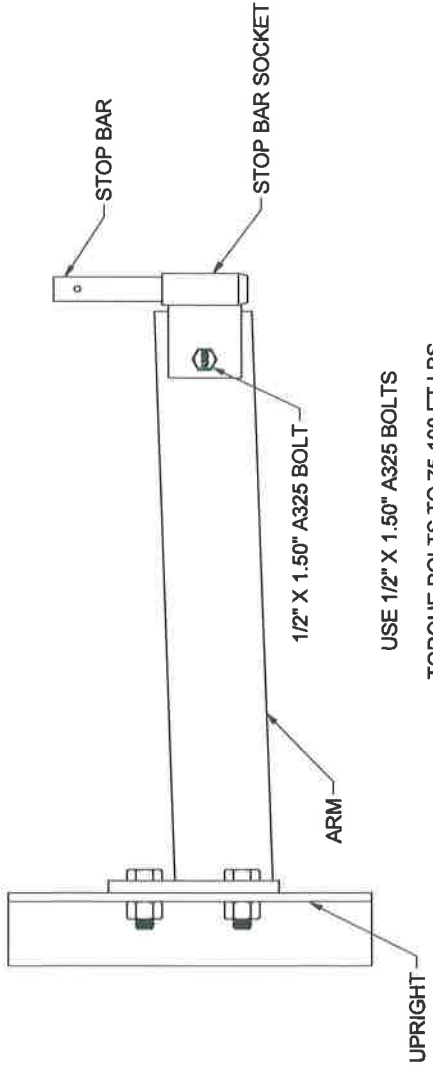


**dexco**  
 STRUCTURAL STEEL  
 I-BEAM PACKING SYSTEMS

WELD IN ACCORDANCE  
 WITH STRUCTURAL WELDING CODE  
 AWS D1.1

**DRAWING TITLE**  
 STOP SOCKET  
 CONNECTIONS  
 FOR 4-6" ARMS

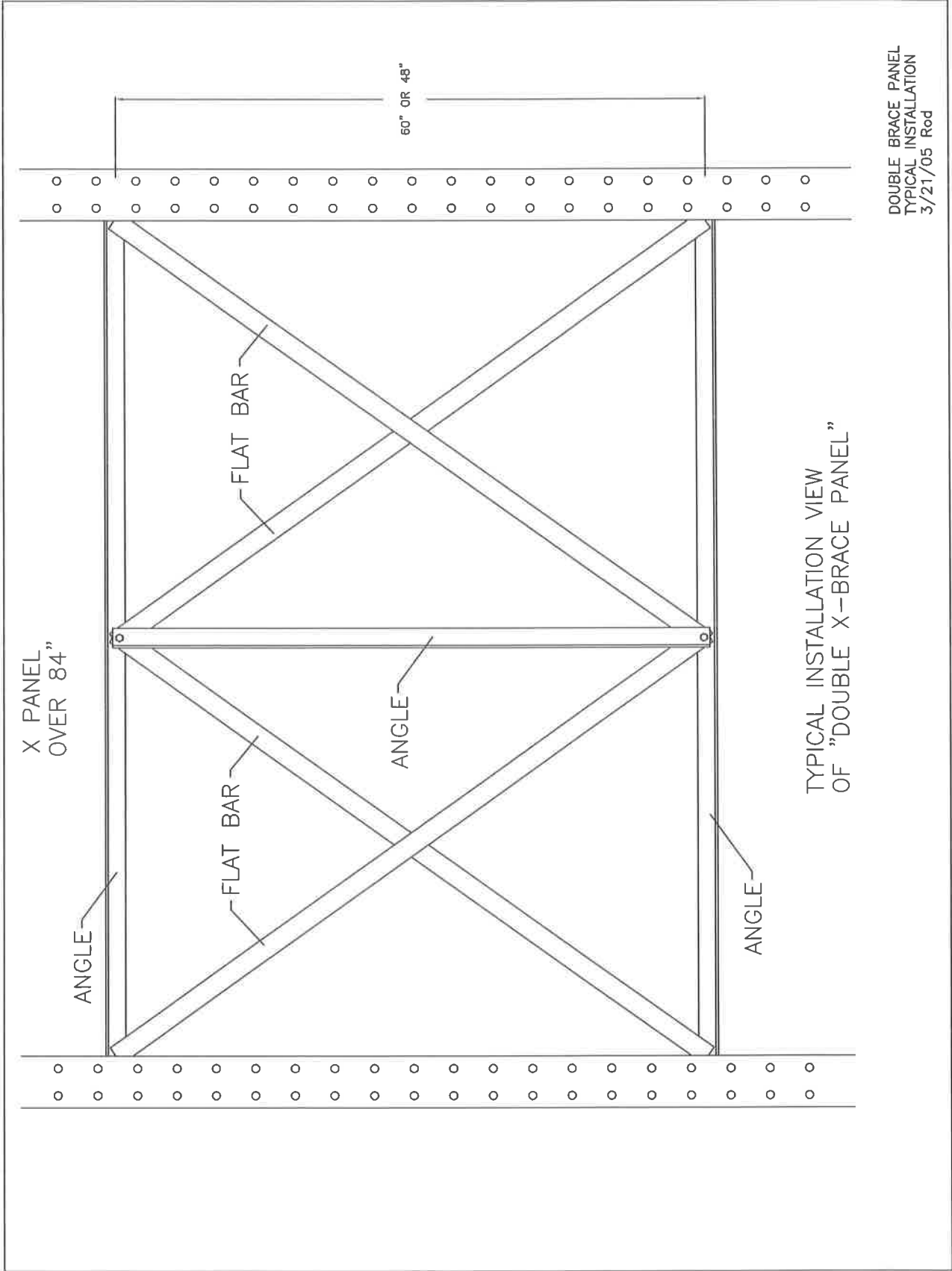
DATE	SCALE
12/12/2019	
P.O. NUMBER	WORK ORDER #
DRAWN BY	CHECKED BY
WJP	
SHEET NUMBER	REVISION
12	
DRAWING NUMBER	
	RA024522



STOP BARS AVAILABLE WITH  
 OR WITHOUT CHAIN

USE 1/2" X 1.50" A325 BOLTS  
 TORQUE BOLTS TO 75-100 FT LBS

**4-6" ARM STOP SOCKET CONNECTION**



DOUBLE BRACE PANEL  
 TYPICAL INSTALLATION  
 3/21/05 Rod

TYPICAL INSTALLATION VIEW  
 OF "DOUBLE X-BRACE PANEL"