

Rem

1

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: ALL

DATE: 02/03/94

SUBJECT: PRODUCT REGISTRATION

Item 1: FOR YOUR PROTECTION

Warranty registration and inspection forms must be completed in full and returned to Rem Manufacturing for each Grain Vac. This will legally protect you from any liabilities, should the operator sustain any damage while using the Grain Vac.

Effective immediately, Rem Manufacturing will not process any warranty claims against machines that are not registered with a complete warranty registration form, at Rem. Enclosed is a sample of this form for your records. You will find these forms in the front of each Grain Vac operators manual.

Item 2: WARRANTY POLICY

You will find these policies in the front of every operator's manual. Please read this over carefully, sign at the bottom, and return it to Rem.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

2

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 552 & 1026

DATE: 02/25/03

SUBJECT: SERVICE TIPS FOR SHEAR SPROCKET ASSEMBLY

You will find this part on page 5 in your 552 parts manual and on page 6 in your 1026.

The hub and sprocket are machined with limited clearance. Once the pin has sheared and the sprocket has spun on the hub, it can burr the material if the vac is left running, so that the sprocket almost becomes welded onto the hub, and has no shearing action at all. This in turn causes damage to the chain, gearbox, and auger.

The problem can be easily solved by removing the snap ring and tapping the pin back out of the sprocket. Then pull off the sprocket. (You may have to tap it off from the back.) If the teeth show signs of wear or hooking, the sprocket assembly should be replaced to avoid further damage. Also inspect the hub and clean off any scars or burrs with a file. If the parts are smooth, wipe a new layer of grease on the contact areas of the hub and sprocket before reinstalling the sprocket. Reverse the entire procedure to reassemble, and your grain vac is ready to go.

Note: The machining on the sprocket is different on both sides; the largest machined area goes next to the hub. This service procedure should be done annually.

For 1026 models with serial numbers 0001 to 1152, we recommend that you update to the #60 assembly for longer wear. To changeover to this heavier duty assembly, you would require part #38-104261 (Auger Drive changeover kit); refer to page 6B, item #53.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

3

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: ALL

DATE: 02/01/94

SUBJECT: HOSE CHARACTERISTICS AND APPLICATIONS

1. Part number 38-104113, 7" X 7 foot aluminium tube, with a 22" stainless steel flexible section at one end. This hose is most commonly used to enter the bin, once the grain level is low enough that clean up is required. This unit has the least amount of friction and therefore promotes the best capacity of all our hoses, and shows wear the least.

2. Part number 38-104112, 7" X 7 foot stainless steel flexible hose, gives you good capacity with limited flexibility. This is most commonly used for direct loading from bins through small doorways, where the solid hose will be difficult to handle. Often this hose is used in combination with the aluminium hose and the bin load out nozzle to reach piles far back in the bin.

3. Part number 20-101442, 6" X 7 foot steel flexible hose is used for extra length and manageability. It can be added onto the 7" flexible hose to give you a total of 21 feet of reach.

4. Part number 20-102016, 6" X 12 foot rubber flexible hose offers the most flexibility of all the standard hoses, and is used specifically for bin cleaning together with the clean up nozzle. You will notice that, due to the increased friction caused by the rubber, your capacity drops.

OPTIONS:

1. Part number 3420-06-0002, 6" X 10 foot lightweight rubber hose is available to offer you maximum flexibility. This hose also creates slower capacity than the steel, due to friction, much like the heavy duty rubber hose.

2. Part number 38-104312, 7" X 10 foot solid aluminium tube. These sections are used for increasing the vac's reach to handle product that is beyond limits of standard hose configurations.

Regards,

Jody Duclos

Jody Duclos

Sales & Marketing Manager

Ph: 1-800-667-7420 ☐ Fax: 306-773-1188 ☐ P.O. Box 1207 ☐ Swift Current, SK ☐ Canada, S9H 3X4

Website: www.remmanufacturing.com **E-mail:** remsales@rem.sk.ca

Rem

4

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: ALL

DATE: 03/05/94

SUBJECT: HOSE OPERATION, STORAGE AND WARRANTY

OPERATION AND STORAGE

All hoses used repeatedly in situations where they are required to bend or curve at the ends will show steady signs of wear, so be sure to exercise common sense and care when such corners are required.

If the machine spends its entire life outside, both the rubber and steel hoses should be stored inside.

If the machine is stored inside, the rubber flexible hose should be laid out straight to help prevent cracking and checking on the rubber between the corrugated ribs.

WARRANTY: Rem's obligation under warranty is limited to the supplying of replacement parts in exchange for any parts which are defective due to factory workmanship or material. If a hose is faulty, the warranty compensation must come from the original manufacturer who supplies Rem with the material. We do our very best to supply you with the best quality of hoses possible.

Obviously, we will not issue warranty on a hose that is worn out. Should the hose wrapping peel, a warranty inspection will be done by a Rem representative.

Credit for the labour required on a warranty situation will be issued at the company's discretion.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Ph: 1-800-667-7420 □ Fax: 306-773-1188 □ P.O. Box 1207 □ Swift Current, SK □ Canada, S9H 3X4
Website: www.remmanufacturing.com **E-mail:** remsales@rem.sk.ca

Rem

5

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 1026

DATE: 04/13/94

SUBJECT: REPLACEMENT AND SERVICE TIPS FOR AUGERS

Augers on your 1026 are made up of three separate sections: lower, middle, and upper. Here are some tips on successful replacement and maintenance of these augers. Augers are set at both hinged points to ensure proper locking of auger drives during operation. Failure to set the augers properly may result in the connector weldments skipping, causing damage to auger flying.

To set the lower auger, install flying by placing the auger shaft through the bearing on the bottom of the auger tube. You are now ready for your first measurement. Using a straight edge at the top of the tube, line the auger up with the tube flange. It should be flush with the end, or within 1/32". If this is not so, the auger must be removed, and an external 1 1/8" snap ring put on the end to bring the auger up to measurement. Once this step is satisfactory, you may tighten the set screws on the bottom bearing, using Locktight.

The middle section requires a similar procedure. On the bottom end of your auger, the flat surface on the connector hub should be flush with the auger tube. You can move it by adjusting the auger back and forth. To move this auger, you have to loosen the setscrews on the middle auger supports. When the auger is in place, be sure to secure the setscrews using Locktight.

Also, double check the connector hub to ensure that it is set in time. Turn the auger so that the cutoff is at the top (12:00 position) - the back tooth on the connector hub should be at the 9:00 position. If this setting is out, you may have plugging problems in your auger.

When setting the top auger, it is important to ensure proper alignment of the connector hub. To do this, fold out your top section and lock it in place - do not raise the auger. Remove the lock collar at the end of the auger tube and tap the auger shaft in until it meets up with the connector hub. Lock the collar and secure with the setscrew, again, using Locktight.

These procedures are necessary to correctly align the auger, and should be done whenever the augers are removed for replacement or repair. See drawing for details.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime.

Regards,

Jody Duclos

Jody Duclos

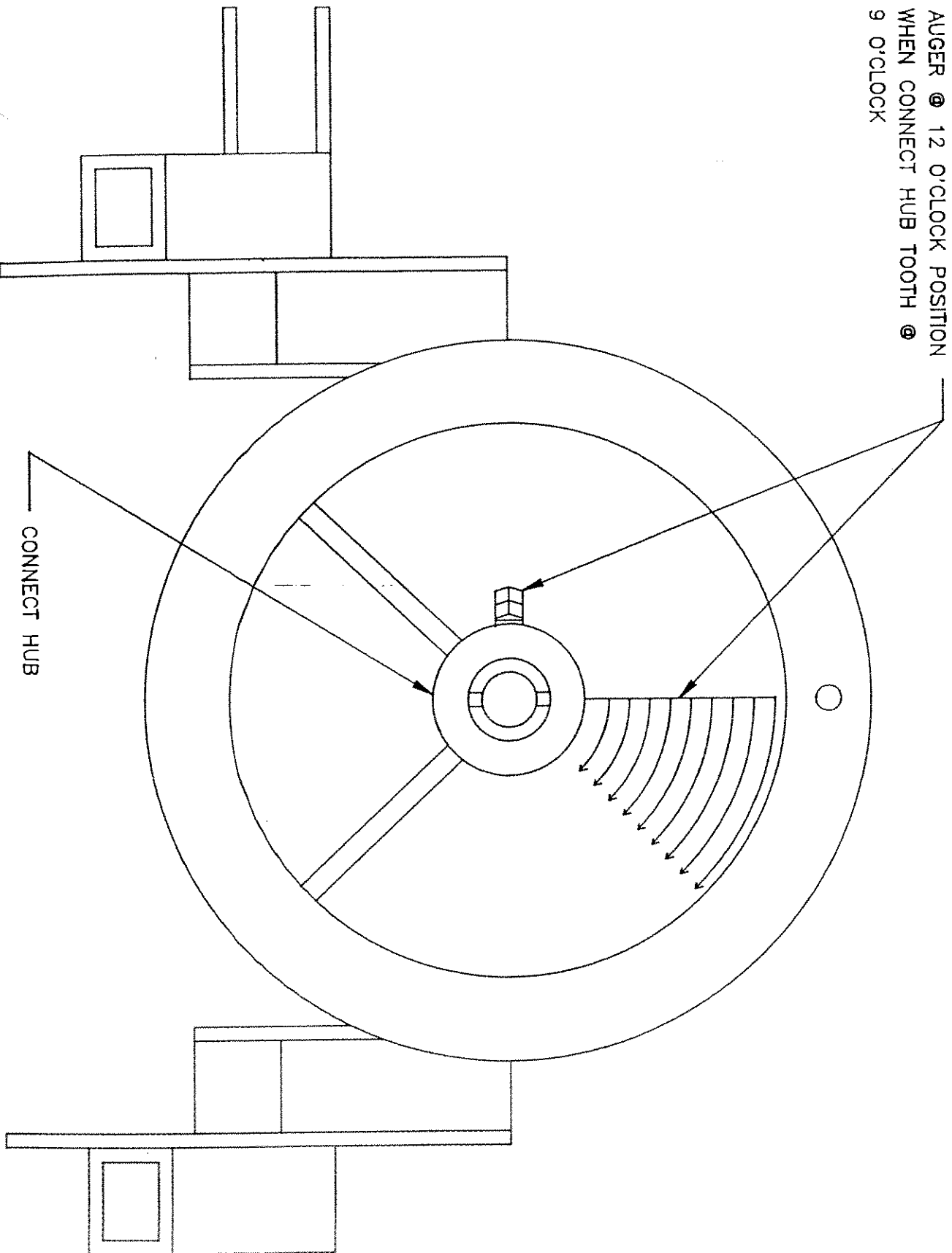
Sales & Marketing Manager

Ph: 1-800-667-7420 □ Fax: 306-773-1188 □ P.O. Box 1207 □ Swift Current, SK □ Canada, S9H 3X4

Website: www.remmanufacturing.com **E-mail:** remsales@rem.sk.ca

MIDDLE AUGER

AUGER @ 12 O'CLOCK POSITION
WHEN CONNECT HUB TOOTH @
9 O'CLOCK



Rem

6

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 1026

DATE: 06/01/03

SUBJECT: SHEAR PINS

All 1026 Grain Vac units up to serial number 1152 originally contained a #50 chain, and the shear pin for that chain assembly is 1/4 X 1 1/4". If your customer has updated to the #60 assembly, (part #38-104261), or if the serial number is 1153+, the shear pin is 5/16 X 1".

Should your customer wish to use the 5/16" pin rather than 1/4", carefully drill out the existing hole to 5/16". A drill press should be used to ensure proper alignment of the pin for installation. The snap ring may need to be turned so that the thin part is nearest to the hole.

This shear pin is manufactured by Rem specifically for use on the Rem Grain Vac, and should be purchased from Rem Manufacturing. We have had some cases where warranty is denied, due to the complications caused by replacing the shear pin with alternatives.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

7

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 1026

DATE: 10/01/95

SUBJECT: DUMPER BODY

In many cases on our vacs, we see premature wear on the dumper body. The dumper body at the end of the auger is the air lock on the machine. To maintain this air lock the grain must push the dumper door open. If the spring's tension does not close the doors, the air sucks down the auger, causing vacuum loss.

The springs on both dumper doors are adjustable and should be checked periodically to maintain the tension required. Proper tension may vary on different units as some dumper door hinges are more secure. The springs need only draw the doors to a closed position when the Grain Vac is not in operation.

If the springs are too tight the grain will pressurize slightly in the top of the dumper and cause it to wear.

Periodic inspection of the dumper door springs (02-20083-0) will help to keep your vac running efficiently.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

8

SERVICE BULLETIN

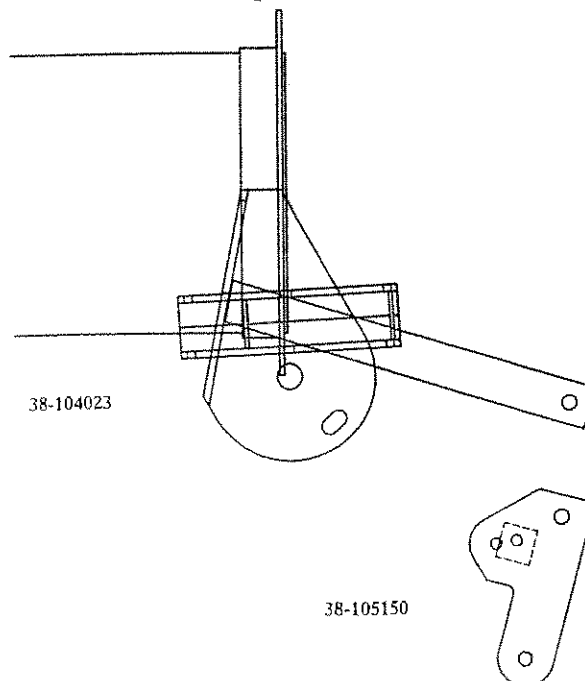
PRODUCT: GRAIN VAC

MODEL: 1026

DATE: 04/1/96

SUBJECT: MIDDLE AUGER TUBE 38-104023

We have changed the 1026 middle auger clevis to allow the customer to adjust the amount of force required for moving the unloading auger in and out of transport positions. Now when your customer orders part # 38-104023, he will require the update kit, part number 38-105150. See drawing for details.



Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

David Gleim
Customer Service Supervisor

Rem

9

SERVICE BULLETIN

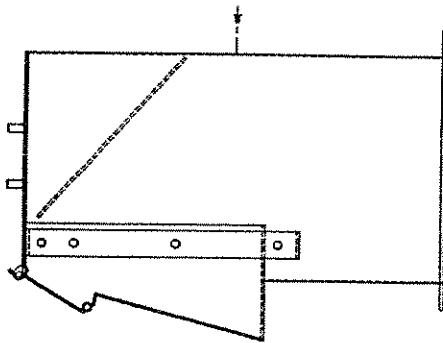
PRODUCT: GRAIN VAC

MODEL: 1026

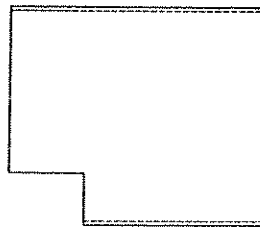
DATE: 04/01/96

SUBJECT: DUMPER REPLACEMENT

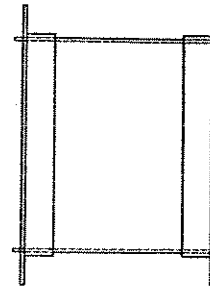
We have developed a new dumper with a replaceable ultra-high molecular weight polyethylene liner, which increases life over our original steel configuration. If your customer wants to replace his 1026 dumper, he will require the new assembly, part number 38-105165-7, along with the adaptor kit, part number 38-104781. See drawing for more information.



38-105165-7



38-105167



38-104781
Adaptor Kit

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

David Gleim
Customer Service Supervisor

Rem

#10

SERVICE BULLETIN

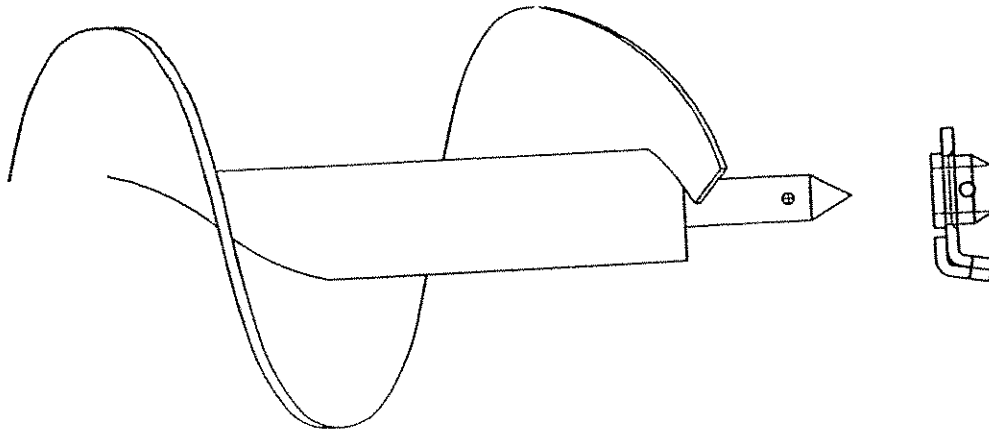
PRODUCT: GRAIN VAC

MODEL: 1026

DATE: 04/01/96

SUBJECT: CONNECTOR HUB

We have increased the diameter of the auger drive connector hub's steel pin from a 1/4" to 5/16". When your customer orders a Connector Hub, part number 38-104066, he will have to drill out the shaft ends of his middle auger, part number 38-104061, to accommodate the new sizing. See drawing for more details.



Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,



David Gleim
Customer Service Supervisor

Rem

#11

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 1026A

DATE: 05/30/96

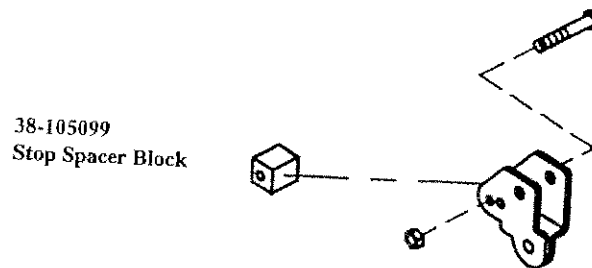
SUBJECT: AUGER LIFT SPRINGS ADJUSTMENT

As many of you are aware, our 1026A model Grain Vac features adjustable auger lift assist springs. If a customer purchases an industrial auger kit to field install, the weight difference in the auger will increase the effort required to elevate; your customer will benefit from adjusting the tension on the springs to make the operation more comfortable for him/her.

The stop spacer block, part number 38-105099 can be reset as follows:

1. Elevate the auger
2. Loosen the 3/8x2" bolt (do not remove)
3. Rotate the block by 1/4 turn either way
- CAUTION: WATCH OUT FOR YOUR FINGERS!**
4. Tighten the bolt

Refer to page 9 and 9A in your 1026A parts catalog for a complete diagram of this assembly, and bulleting # 8 for model 1026 application. See drawing for details.



Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

David Gleim
Customer Service Supervisor

Rem

#12

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 1026B

DATE: 03/09/99

SUBJECT: GEARBOX PLUGS

To affected Rem Grain Vac Dealers. We have had one incident where the gearbox plugs on the 1026B Grain Vac were reversed. We have narrowed down the cause to a factor that may have affected the first 1026B production run in 1999. We feel it is in your customer=s best interest to ensure that the machine you have purchased (see serial number below) is not affected. Please check the plugs according to this drawing: the vent plug should be on the highest level, and the solid plug on the lower. See attached diagram for details.

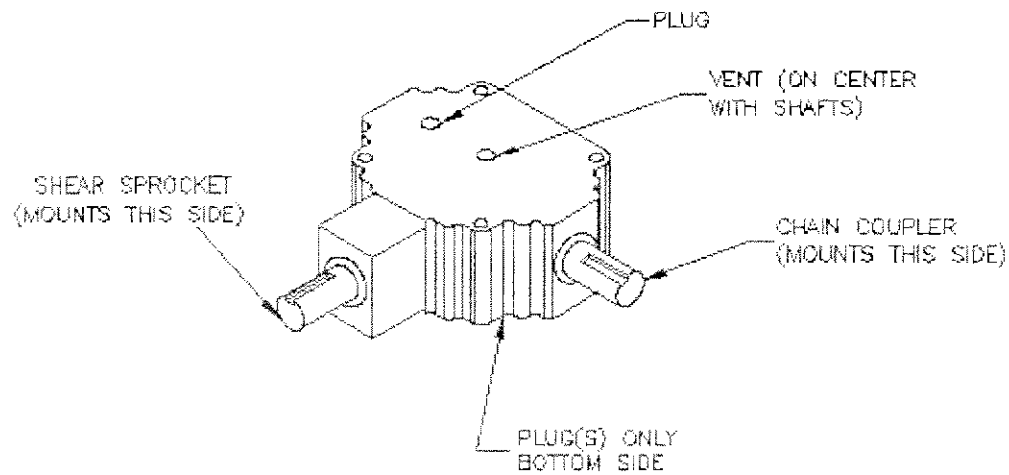
Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

1026B GEARBOX (PLUG & VENT LOCATIONS)



Rem

#13

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2100

DATE: 01/09/01

SUBJECT: USE OF TELESCOPING INLET NOZZLE, PART NUMBER 38-104966

When using the telescoping inlet nozzle, we recommend not attaching it directly to the machine. Our suggested hook up would be to use a short stainless steel flex (38-105143 7" by 22") first. You would then use the telescoping tube (38-104966), and then after that we would suggest using a 7" by 76" (38-104112) stainless steel flex pipe; all depending on your application. If you attach the telescoping inlet nozzle directly to the unit, the vibration and weight of the other hoses may cause the rivets to pull out of the aluminum casting resulting in a failure.

Failure to follow these suggestions will decrease the life of the telescoping inlet nozzle considerably.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

#14

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2100

DATE: 02/25/03

SUBJECT: OPERATING SPEED TIPS

The operating speed of the model 2100 Grain Vac has more impact on performance than previous models due to the increase in suction power. Clean, heavy grains require no alteration in operating technique, however, very light or chaffy grains may cause plugging in the body of the machine.

For optimum capacity* and performance, follow these operating speed guidelines:

FULL BIN LOAD-OUT	LIGHT OR CHAFFY GRAIN	800 PTO RPM
	CLEAN, HEAVY GRAIN	1000 PTO RPM
FINAL BIN CLEAN-UP	LIGHT OR CHAFFY GRAIN	800 PTO RPM
	CLEAN, HEAVY GRAIN	1000 PTO RPM

Alternately, if you feel that you must run your 2100 Grain Vac at full 1000 PTO RPM, we offer an air relief valve to facilitate operation. This sliding door can be added to existing machines with some modification. Order using part number 38-108992 (manufacturer=s suggested retail \$90.00).

**A note about CAPACITY vs. SPEED: Extensive testing proves that running your 2100 Grain Vac at the slower rpm in light or chaffy grains will actually maximize your capacity. Faster operating speed does not necessarily mean faster results!*

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

#15

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2100

DATE: 11/26/03

SUBJECT: AUGER FLYTING ASSEMBLY PROCEDURE

Augers on Grain Vacs are made up of three separate sections: lower, middle and upper. Here are some tips on successful replacement and maintenance of these augers.

Augers are set at both hinge points to ensure proper locking of auger drives during operation. Failure to set the augers properly may result in the connector weldments skipping, causing damage to auger flyting.

- 1) To set the lower auger, install flyting by placing the auger shaft through the bearing on the bottom of the auger tube.
- 2) You are now ready for your first measurement. Using a straight edge at the bottom of the tube, line up the auger with the tube flange. It should be flush with the end, or within 1/32". If this is not so, the auger must be removed, and an external 1 1/4" snap ring or washers put on the end to bring the auger up to measurement.
- 3) Once this step is satisfactory, you may tighten the set screws and eccentric lockcollar on the bottom bearing, using Blue Locktight.
- 4) The middle section requires a similar procedure. On the bottom end of the 2nd section auger flyting the flat surface on the connector hub should be flush with the auger tube.
- 5) Double check the connector hub to ensure that it is set in time. Turn the auger so that the cut-off is at the top (12:00 position) – the back tooth on the connector hub should be at the 9:00 position. If this setting is out, you may have plugging problems in the auger.
- 6) When setting the top auger, it is important to ensure proper alignment of the connector hub. To do this, fold out the 2nd section and lock it into the 1st section to lock into the 2nd section.
- 7) Shove the 3rd section flyting as close to the dumper end of the tube as possible to ensure maximum clearance between 2nd/3rd section and tighten setscrew just enough to keep auger from sliding in tube.
- 8) Check alignment of 2nd/3rd auger flyting within their tubes with a straight edge to ensure the gap between the two are a minimum of 1/16" when they close together.

- 9) Check alignment of 2nd/3rd with straight edge to ensure gaps will be a minimum of 1/16" when closed together.
- 10) Close and lock 2nd to 3rd auger and loosen setscrews on end dumper bearing and slide 3rd auger section flying ahead until 1/31" – 1/16" optimum gap is achieved. Optimum gap is measured from face of hub on 2nd to 3rd section hub face.
- 11) Tighten screws and lock collar on end dump bearing. If less than 1/16" use putty to ensure what gap is. Place putty on face of 2nd section hub and close 3rd section so it locks into place. The putty on face of 2nd section will be reduced to what the gap is between 2nd and 3rd auger section hub faces when closed.
- 12) To ensure all auger sections mesh properly, check end dump doors to ensure they are not pushed open or bent from auger pushing up due to misalignment.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

#16

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: ALL

DATE: 04/15/04

SUBJECT: T-TENSION ADJUST ASSEMBLY-PLATED, PART NUMBER 20-101209
which is part of Kit # 20-104213

The t-tension adjust assembly-plated part for the hose clamp is now upgraded by engineering to a new design. There is a kit available to replace the t-tension part for ten hose clamps. The new design is called the hose clamp retro fit kit; part number is 38-109887. The hose clamp retro fit kit comes equipped with a drawing, parts needed and a drill bit for the assembly.

Thank you for your cooperation and assistance in this matter. If you have any questions or concerns, please call us anytime at 1-800-667-7420 or 1-306-773-0644 or by fax at 1-306-773-1188 or E-mail: remsales@rem.sk.ca.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

#17

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2500

DATE: 03/25/06

SUBJECT: WELD CONNECT HUB

We have found that the drive dogs on all Rem grain vacs should be ground off as indicated on the attached drawings. This allows the auger sections to mesh much better.

In some extreme cases the top auger bearing and flange will push out the top because the drive dogs will hit point to point.

Once you grind these as indicated, the customer will experience less problems.

If you have any questions, please call our service department at 1-800-667-7420. Thank you for your assistance on this matter.

Regards,

Jody Duclos

Jody Duclos
Sales Manager

Rem

#18

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 06/01/07

SUBJECT: GALVINIZED HOSE SET UP

The new 3700 Rem VAC has been able to out perform all of our expectations and we have some new information that we'd like to share.

When hooking directly to the bottom of a sump on a large bin, extra precautions need to be taken.

1. First, hook up the short steel flex hose, then hook up the telescoping nozzle, then hook up the 8 foot steel flex to the bin sump. It works best to leave the telescoping clamp slightly loose so that it can slip back and forth allowing the vac to move and not put any extra stress on the hoses.
2. Turn on the aeration to get air into the grain.

If you have any questions, please contact us at 1-800-667-7420.

Regards,

Jody Duclos

Jody Duclos
Sales & Marketing Manager

Rem

#19

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 06/12/07

SUBJECT: BOLTS ON AUGER SHAFT

In some cases the bolts holding the drive shafts in place on the auger flyting have loosened.

Please check to be sure that they are snug. Put a center punch indent at the edge of the threads and nut to help out in the locking of the uni-torq nuts.

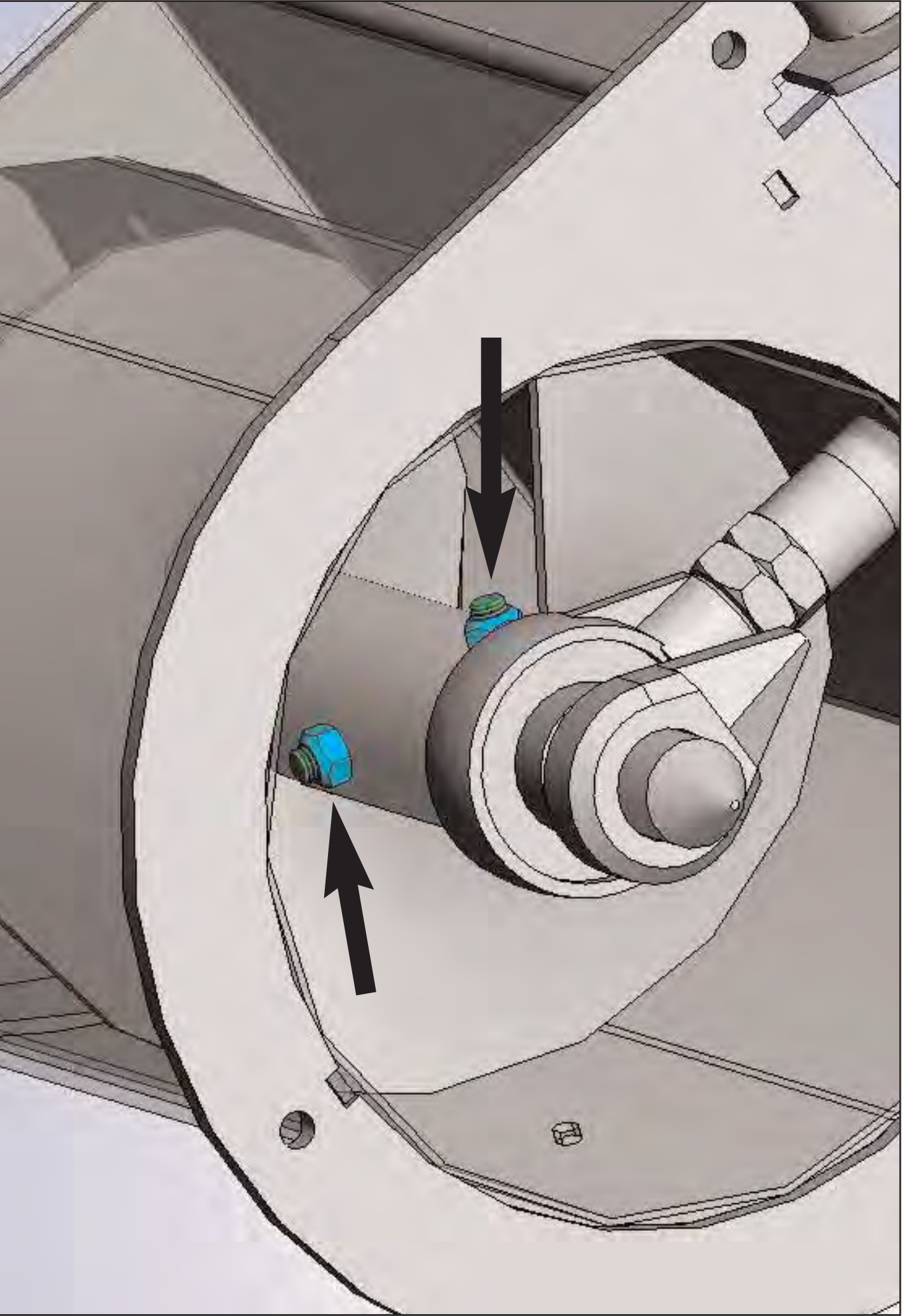
If you have any questions, please contact us at 1-800-667-7420.

Regards,



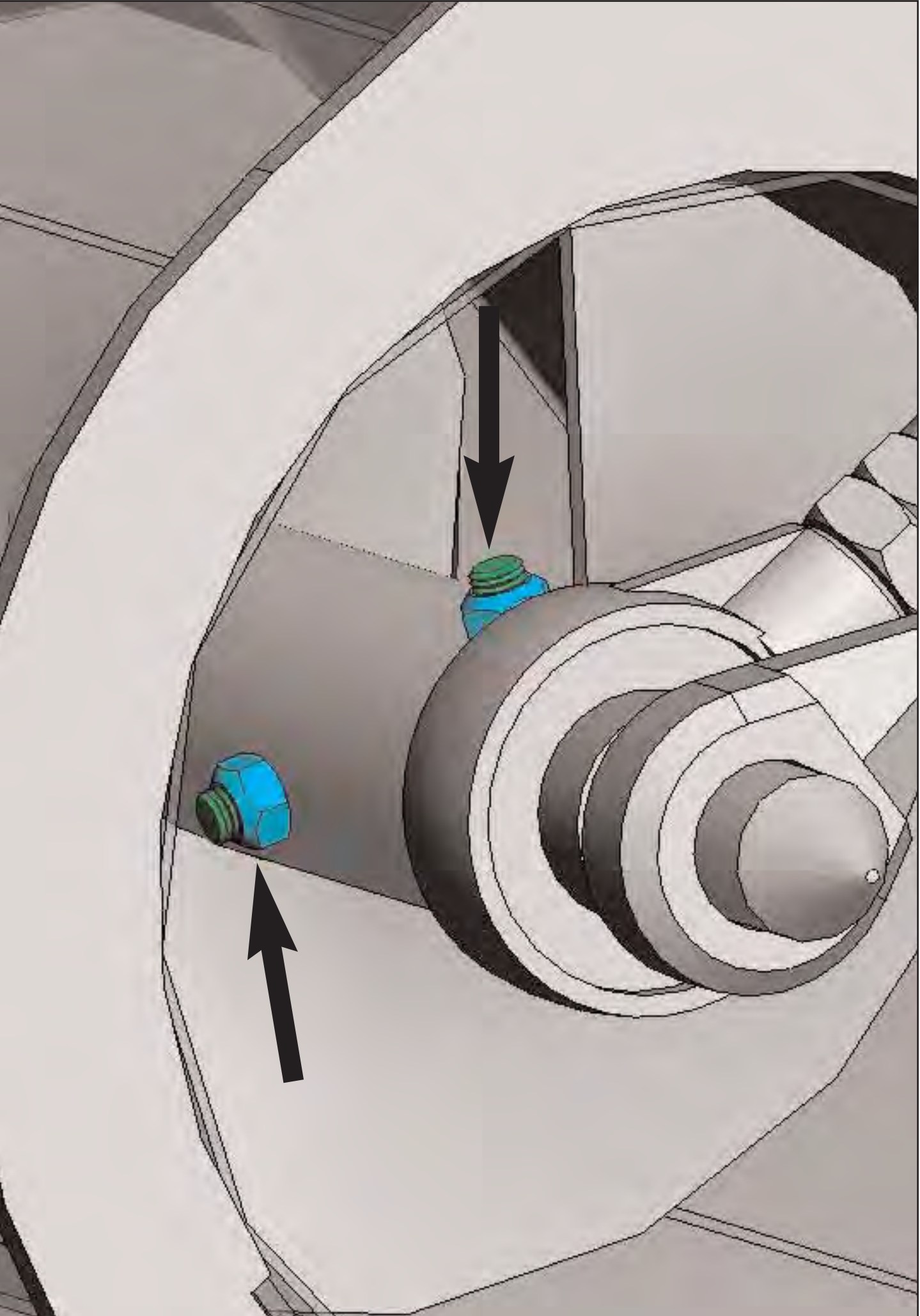
Jody Duclos
Sales & Marketing Manager

Grain VAC 3700: AUGER BOLT INSPECTION



SERVICE BULLETIN FIGURE 1

Grain VAC 3700: AUGER BOLT INSPECTION



SERVICE BULLETIN FIGURE 2

Rem

20

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 09/06/07

SUBJECT: DRIVELINE

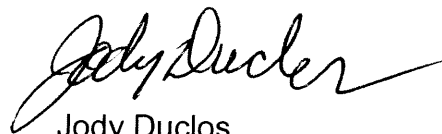
The Rem 3700 grainvac has been specially engineered so that the friction clutch will slip if heavy loads are applied to it. Reasons for this slipping are as follows.

1. Quick hard engagement of PTO. Tractor RPM should be set as low as possible before engaging PTO. You should also feather the PTO engagement so the PTO engages slowly.
2. PTO brake on the tractor is too aggressive. We are finding that the tractor PTO brake will stop the PTO from turning instantly. The clutch is designed to slip in this harsh circumstance. Make sure the tractor is idled down as far as possible before disengaging the PTO. If needed, the owner can purchase a free wheeling clutch to install in the driveline. This allows the vac to spin freely until it stops on its own. The part number is 7100-39-4619 and retails for \$455.00
3. The automatic air throttle is designed to take the extra load off of the PTO when moving smaller amounts of grain and maximum air. If you lock or hold it open to the maximum, you could cause the clutch to slip. You should allow the throttle to move freely on its own unless you are trying to decrease suction by locking it to the closed position.

Friction clutches will not be a warranty item for these reasons.

If you have any questions about this, please feel free to call us any time at 1-800-667-7420.

Regards,



Jody Duclos
Sales Manager

Rem

21

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 12/11/07

SUBJECT: AUGER DRIVE CHAIN & GUARD

ATTENTION: SERVICE MANAGER

Directions to reduce the heat and premature failure of the auger drive chain.

To change the guard, simply unlatch, move down and slide off the hinge pivot pins. You will have to remove the latch and install on the new vented guard assembly.

You must also remove and replace the auger drive chain. To do this you may be required to release the tensioner assembly. Install the new o-ring type chain and adjust the chain tension as required.

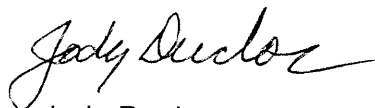
Be sure to check sprocket and idler alignment, if this is good, re-install the new vented guard assembly to complete this task.

Please submit warranty claim for labor on the installation.

If you have any questions, please call our service department at 1-800-667-7420.

Thank you for your assistance on this matter.

Regards,

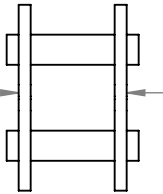


Jody Duclos
Sales Manager

NO	PART NUMBER	SZ	DESCRIPTION	QTY.
1	7300-05-1080	C	CHAIN-ROLLER-RIVETED # 80 O-RING	5 FT

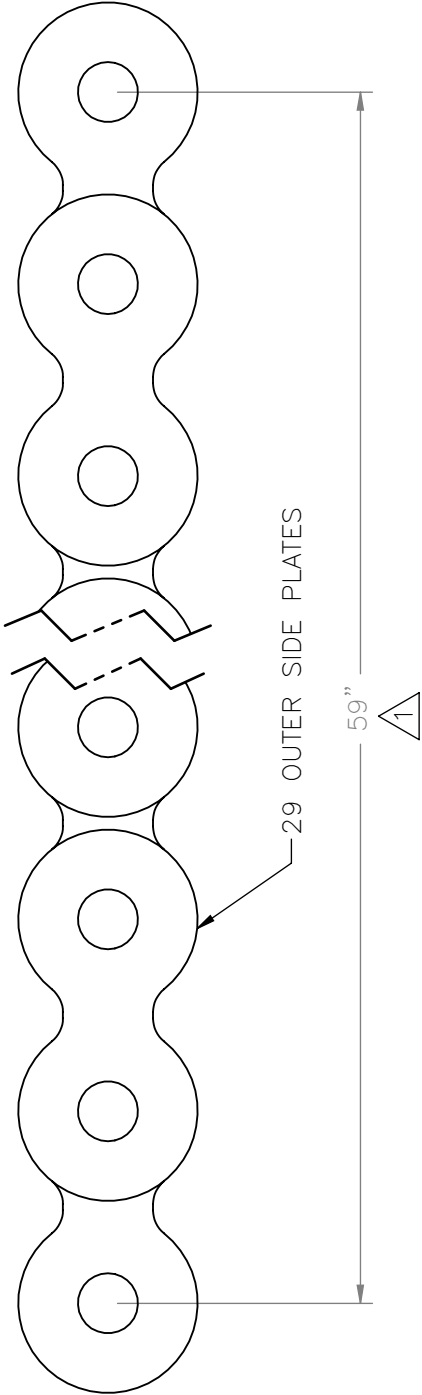
INSTALLING O-RING CHAIN

NOTE: COMPRESS THE LINKS JUST ENOUGH TO INSERT THE COTTER PIN. OVER COMPRESSING WILL DAMAGED THE O-RINGS AND THUS RESULT IN CHAIN FAILURE



INSTALL NEW DECAL

REMOVE OLD "OIL DAILY" DECAL
CLEAN GUARD SURFACE TO ENSURE OIL AND DIRT FREE
APPLY NEW DECAL. (9005-55-0182)



MAINTAINING O-RING CHAIN

- Use any SAE 10W oil to lightly lubricate O-ring chain, as per vac manual. DO NOT lubricate when chain is hot.
- **DO NOT** use other fluids such as WD-40 because it can damage the O-rings and wash away factory lubricant.
- Cold start-ups below -20C are not recommended. This can damage the O-rings and thus reduce chain life.

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Rem

22

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 12/20/07

SUBJECT: DRIVELINE HALF SHAFT WITH OVERRUNNING CLUTCH

TO: GRAIN VAC 3700 CUSTOMER

Rem Enterprises is now offering a new driveline half shaft for the 3700 Grain VAC, which has an overrunning clutch built into the design. This implement half shaft works to absorb the inertia created by the aggressive clutch brake that your tractor may have.

Replacement is simple as sliding apart the current driveline and then sliding it back together again with the new half shaft.

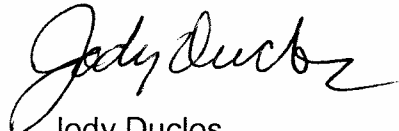
Current price of this unit is \$370.00 plus freight. For our current owners of 3700 units, Rem is willing to offer this Half Shaft for only \$240.50 + freight to any customer who wants to take advantage of this offer.

This program will end on April 30th, 2008.

To order this replacement, contact your local dealer and reference part number 7100-39-6708.

Please contact your local Rem Dealer or Representative for further details.

Regards,



Jody Duclos
Sales Manager

Rem

23

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 02/21/08

SUBJECT: FLIGHTING

TO: GRAIN VAC 3700 CUSTOMER

Following Rem Enterprises commitment to continuous improvement, we would like to communicate a dealer- or end user-implemented upgrade to the GrainVAC 3700.

Continuous R&D monitoring and testing combined with customer feedback has shown that removing a portion of the left-hand flighting at the upper end of the top auger section may improve material flow characteristics out of the spring-loaded end dump door, with possible additional benefits of reduced upper flighting wear.

The attached drawing indicates which portion of the short LH flighting to remove. Using a hand torch or grinder, it may be possible to eliminate the indicated material without removing the flighting from the auger tube, although caution should be used, along with all appropriate personal protective equipment and safety precautions.

Additionally, dealers or end users can reduce backpressure on grain exiting the end dump by adjusting the spring tension so the end dump door just closes when the GrainVAC 3700 is not running, the auger is fully extended, and the door is held open 3 inches and allowed to swing closed. Excess tension is not required.

Regards,



Jody Duclos
Sales Manager

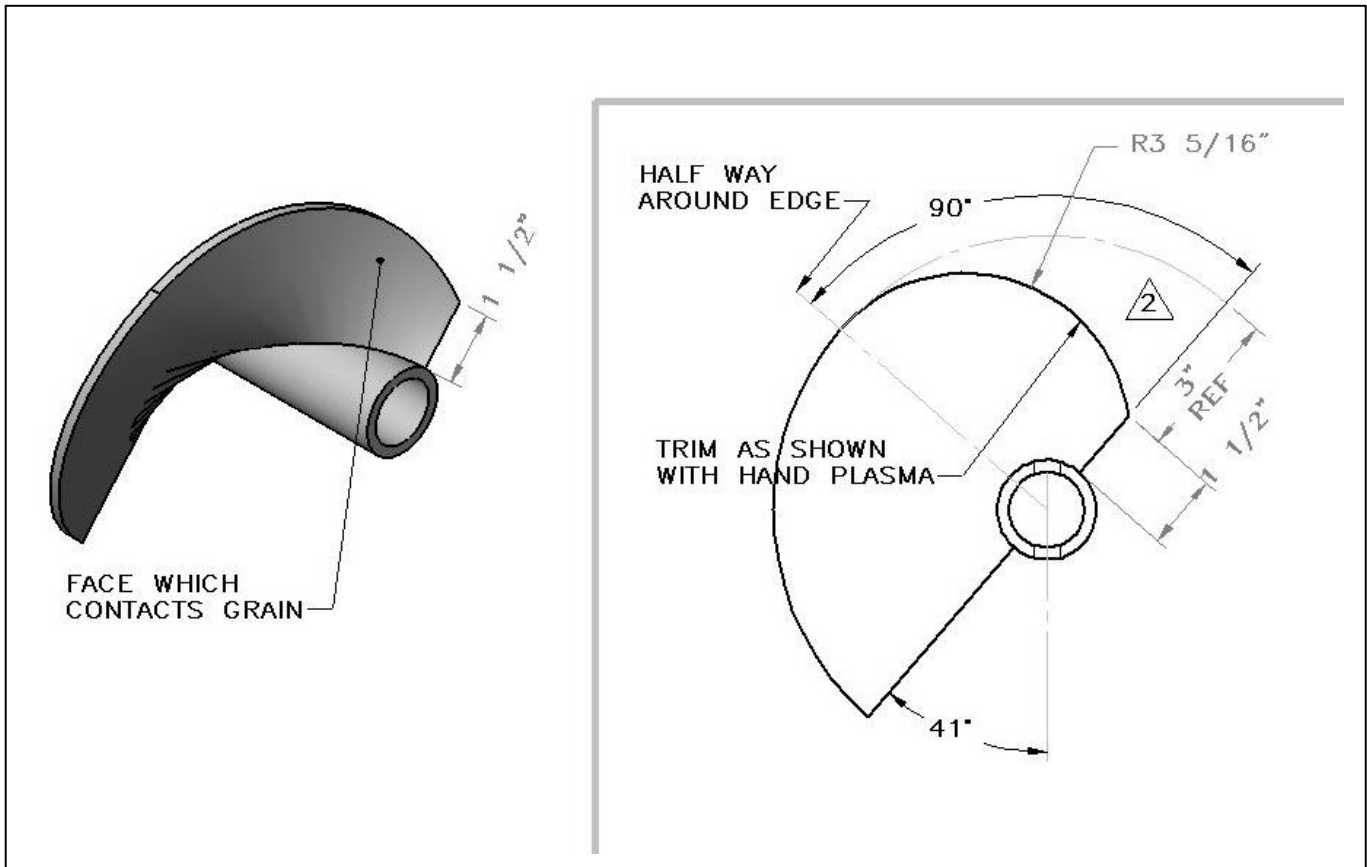


Figure 1

Rem

#24

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 02/22/08

SUBJECT: AIR THROTTLE GUSSETS

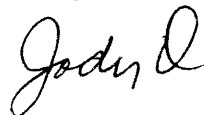
TO: GRAIN VAC 3700 CUSTOMER

Following Rem Enterprises commitment to continuous improvement, we would like to communicate a dealer- or end user-implemented upgrade to the Grain VAC 3700. Continuous R&D monitoring and testing combined with customer feedback has shown that in certain conditions, while moving certain grains, a build-up of chaff, dust, and other fine material may tend to occur on the inside of the rotating drum screen, 55-110914 (page 9/9a in manual). While VAC operation will continue as normal, the end user may notice a vibration from the resulting imbalance in the rotating drum. This imbalance, over time, may possibly cause fatigue in the air throttle housing, 55-111060 (page 9/9a in manual). In order to prevent weld failure due to this fatigue, it is required that you install the no-cost Throttle Body Gusset Kit, 55-111631.

Using common hand tools, it may be possible to install the bolt-in gussets without removing the drum or air throttle from the VAC body, although caution should be used, along with all appropriate personal protective equipment and safety precautions.

Additionally, end users can prevent vibration in the drum by periodically removing chaff build-up using an air or water wand.

Regards,



Jody Duclos
Sales Manager

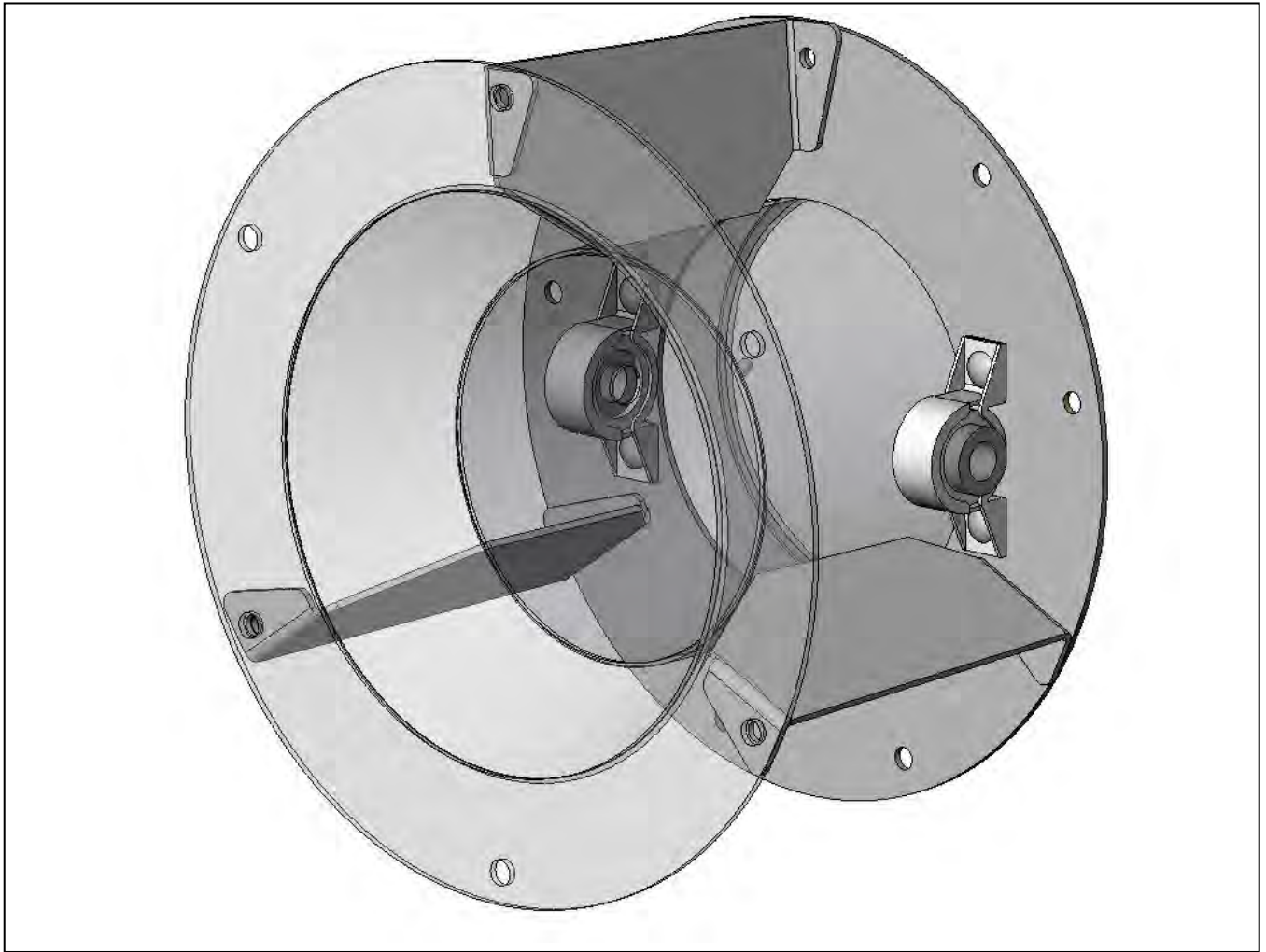


Figure 1

Rem

25

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2700

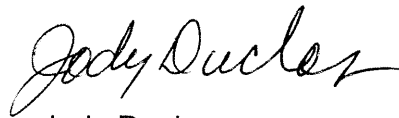
DATE: 10/01/08

SUBJECT: ALIGNING THE REAR IDLER BELT (PART # 3306-00-0001)

If you're experiencing problems with misalignment of the rear idler belt, please see the instructions attached.

If you have any questions please call us directly.

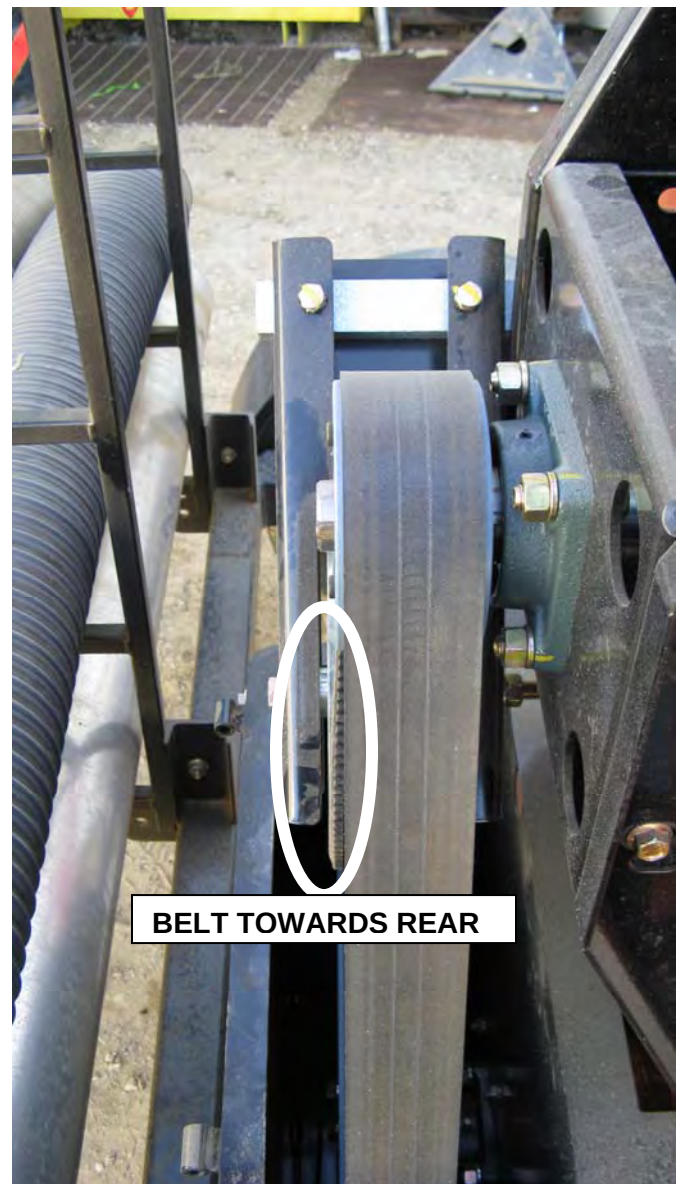
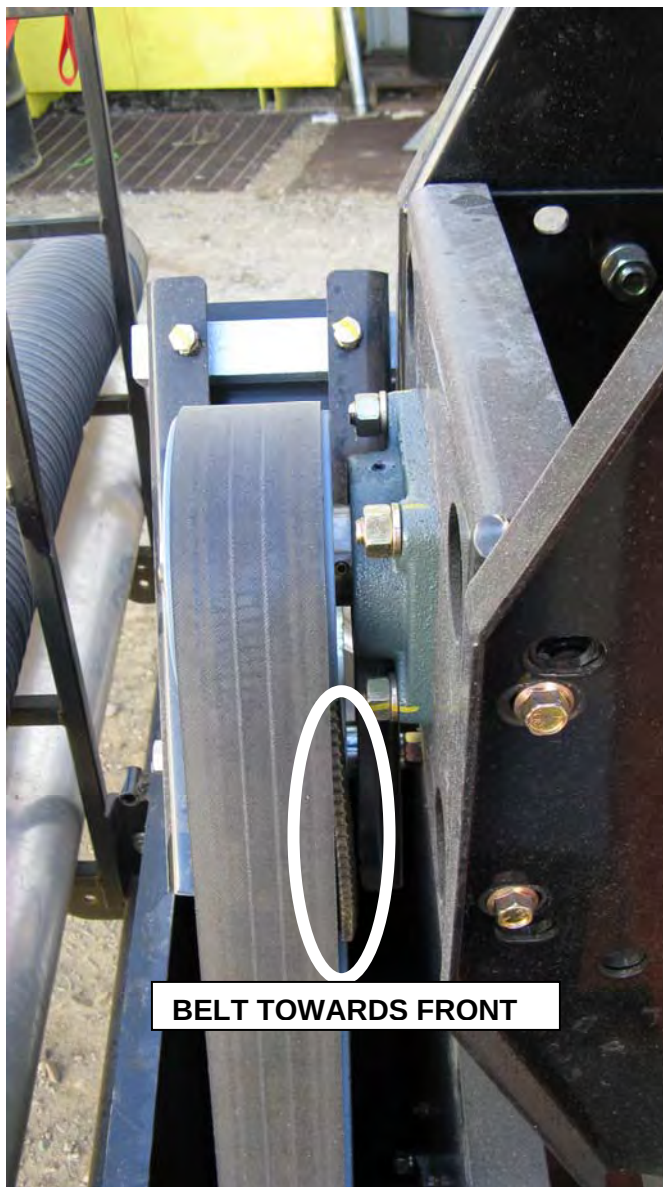
Regards,



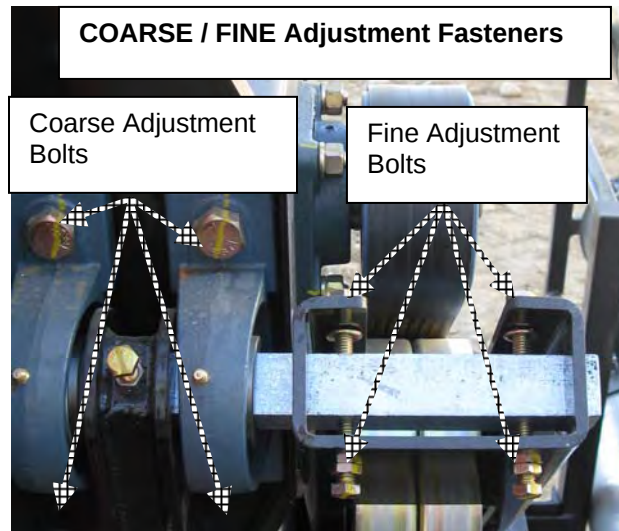
Jody Duclos
Sales Manager

Rem Grain Vac 2700 Bulletin # 25 - Blower Drive Belt Idler Pulley Alignment Procedure

1. DO NOT proceed until you are able to locate an operator's manual for this model and serial number of grain vac and familiarize yourself with the operation and maintenance of the unit. Follow ALL the operating, maintenance and safety information in the Grain Vac Operator's Manual, with particular attention to Section 2.4, "Maintenance Safety".
2. Complete this procedure when replacing any components on the blower drive assembly which may affect belt alignment. Observe the belt idler square shaft for wear, and remove and rotate shaft end-to-end or around axis, or replace as required.
3. Open or remove the rear guard and, observe the blower drive belt from the inlet side of the vac. Rotate the assembly by hand in the normal direction of travel and note whether the belt, WHERE IT PASSES OVER THE IDLER PULLEY, may ride towards the FRONT or the REAR of the vac. This is most easily observed by **sighting over the tight side of the belt**, and noting a curve or "bow" in the belt on the slack side where it passes over the pulley. See photos below.

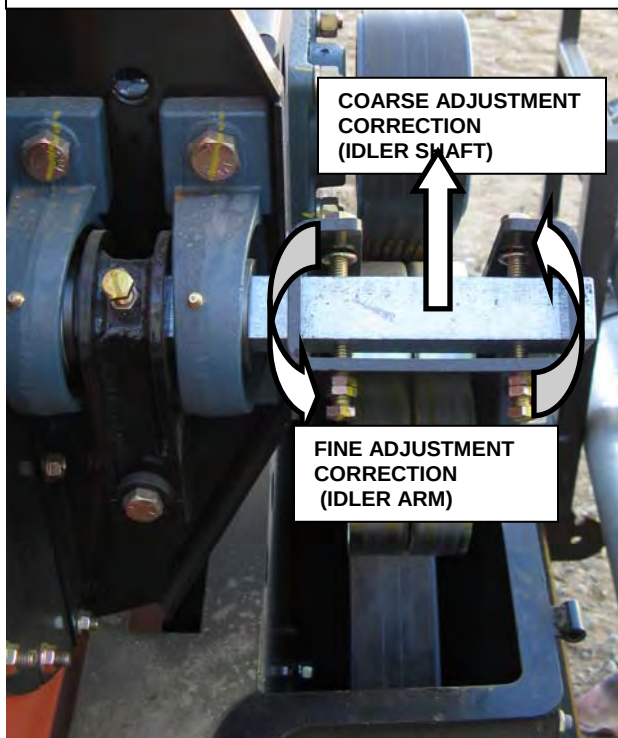


4. Fine adjustment of the idler pulley is achieved by loosening the four 3/8" jam nuts (9/16" wrench) at the top of the box-shaped idler arm, and then using the 3/8" bolts (9/16" wrench) which secure the arm to the square shaft, to twist the arm in the desired direction.
5. Coarse adjustment of the idler pulley is achieved by loosening the four 5/8" bolts (15/16" wrench) that secure the square-bore bearings to the blower h-bracket, and then, while raising or lowering the outer end of the square shaft, re-tightening these bolts.

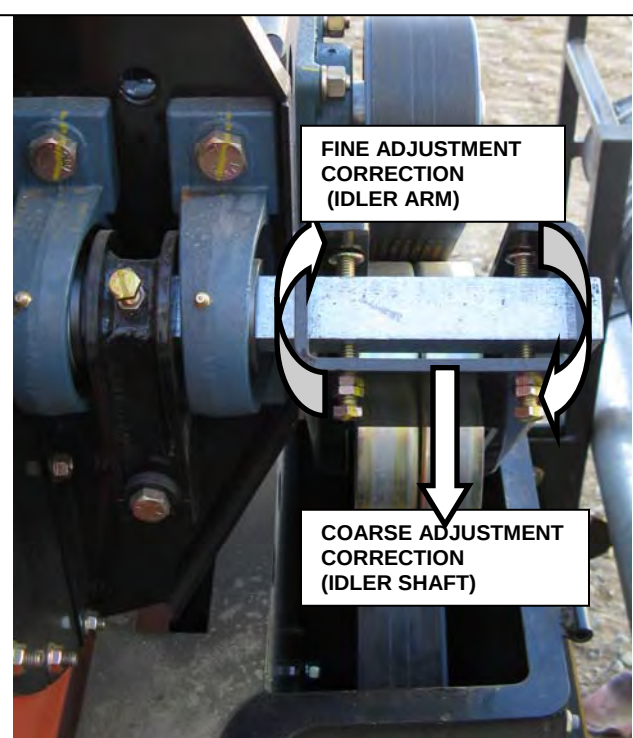


6. If the belt is misaligned as shown, first make the FINE adjustment. If the belt remains misaligned in the same direction, then complete the COARSE adjustment. After completing the coarse adjustment, it may be necessary to repeat the fine adjustment.
7. Following alignment, retighten all fasteners, and rotate the assembly in the normal direction of travel to ensure the belt, where it passes over the idler pulley, is not visible to either side of the belt on the tight side, as per the first photo.

Adjustment for Belt Riding Towards REAR



Adjustments to correct belt riding towards FRONT



Rem

26

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2700

DATE: 10/28/08

SUBJECT: DRUM PROBLEMS

If your Rem 2700 Grain VAC seems to be blowing grain out the exhaust or building up in the screen, you need to follow the attached instructions.

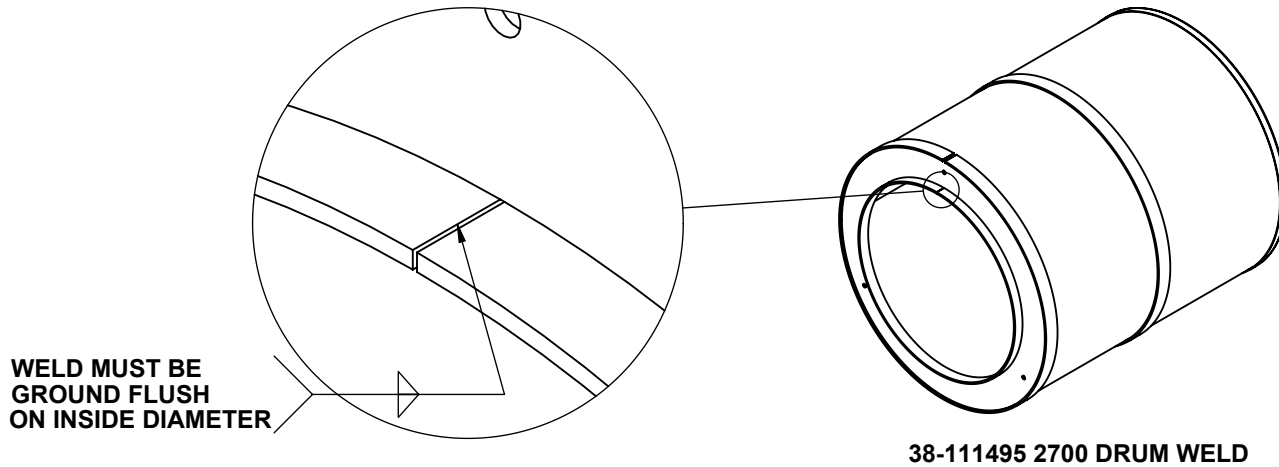
If you have any questions, please call our service department at 1-800-667-7420.
Thank you for your assistance on this matter.

Regards,

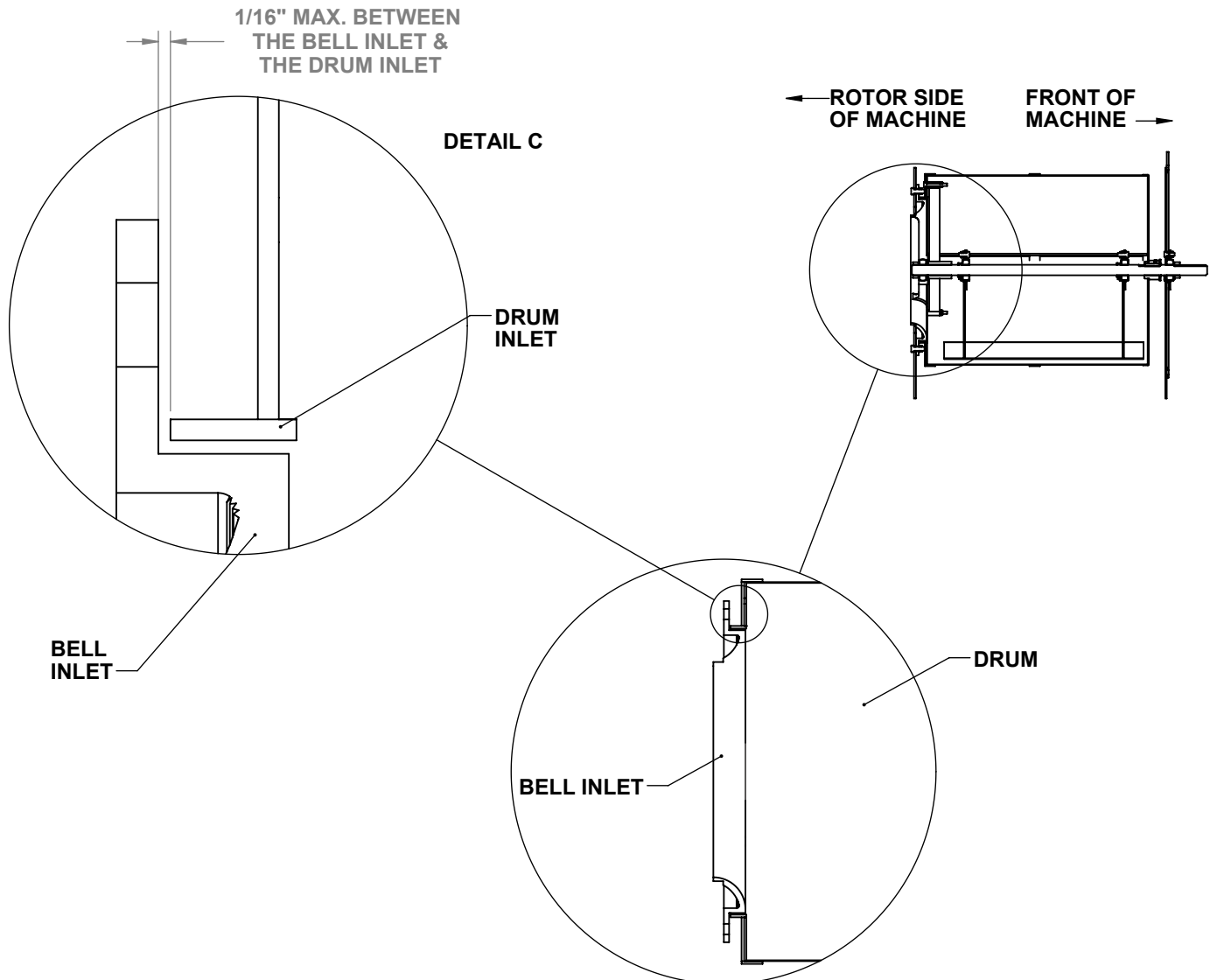


David Jensen
Customer Service

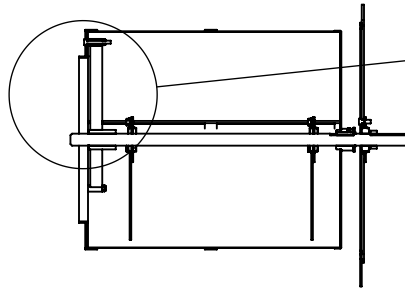
1. INSPECT THE DRUM WELDMENT INLET RING TO SEE IF THERE IS A GAP. IT MUST BE WELDED TO CLOSE THE GAP; AND THEN GRIND INSIDE OF THE DRUM INLET LIP TO ENSURE IT DOES NOT HIT THE OVERLAPPING CAST INLET.



2. AS FOR INSTALLATION OF THE DRUM, IN ORDER TO AVOID FILLING OF THE DRUM WITH MATERIAL, WHAT WE REQUIRE IS A MAXIMUM OF 1/16" DISTANCE BETWEEN THE DRUM INLET AND THE CAST INLET (SEE DETAIL "C").



3. IF THE DRUM BOTTOMS OUT BEFORE YOU ARE ABLE TO ATTAIN THIS SPACE, INSERT WASHERS ON THE BOLTS HOLDING THE DRUM CENTER WELD TO THE DRUM (SEE DETAIL "D") TO ALLOW MORE SPACE FOR YOU TO MOVE THE DRUM CLOSER TO THE CAST INLET.



LOCATION FOR WASHERS
TO SPACE DRUM CENTER
WELD FROM DRUM BODY.

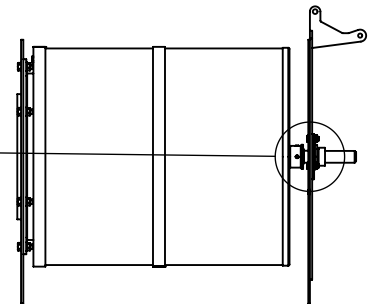
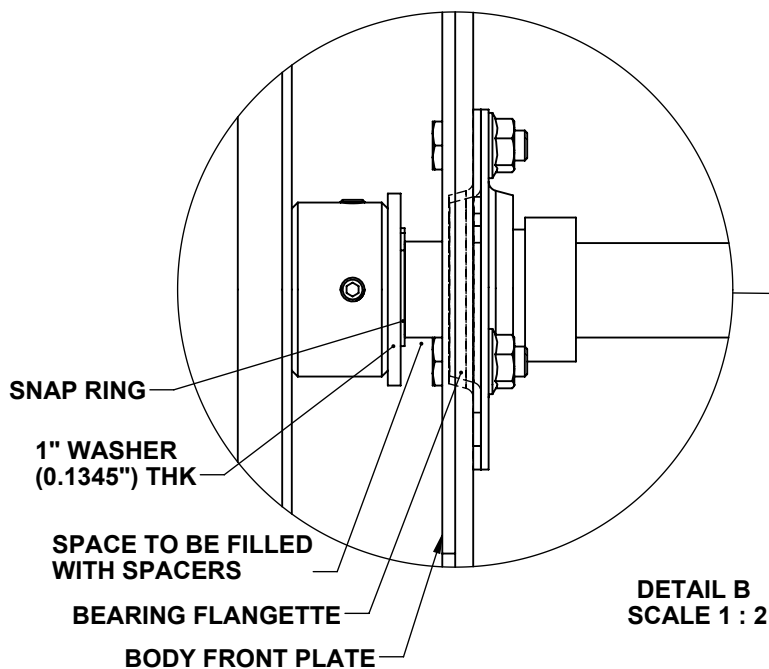
NYLOCK
NUT

WHIZ
BOLT

DRUM
CENTER
WELD

DETAIL D
SCALE 1 : 3

4. ON THE OTHER SIDE OF THE DRUM (SEE DETAIL "B"), THE 5/32" SPACE BETWEEN THE SNAP RING AND THE DRUM HUB SHOULD BE FILLED BY A 1" SAE WASHER (0.1345" THICK, OR MAKE UP WITH STACKING THINNER WASHERS), ONCE THE DISTANCE IS SET THE HUB SET SCREWS SHOULD BE TIGHTENED USING BLUE LOCKTITE AND TORQUEING THEM TO 69 INCH LBS. THE SPACE LEFT BETWEEN THE SNAP RING & THE FLANGETTE OF THE BEARING MOUNTED IN THE FRONT PLATE OF THE VAC SHOULD BE FILLED BY SPACERS/WASHERS SO THE DRUM CANNOT BECOME LOOSE AND MOVE AWAY FROM THE CAST INLET.



Rem

27

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2700

DATE: 09/28/09

SUBJECT: HINGE STOPPERS

These hinge stoppers were implemented because we found that when lowering the augers, the cylinder between the middle and upper auger section was at the very end of it's range when retracted and on occasion would over centre causing the third auger section to come closer to the second auger section hitting the exhaust while lowering.

The blocks in this kit hold the third auger tube at the correct consistent angle to miss the exhaust and still be in the correct alignment to hit the cradle.

What We Will Do: The Customer Service Department at Rem will send out the hinge stopper kit free of charge.

What You Should Do: The Rem Dealer should order the kit for any machine with the serial number up to RM-2700-0660. Part Number to order is; 38-111693.

Reimbursement: The hinge stopper kit is sent out no charge, so no warranty paperwork needs to be completed.

Thank you for your continued cooperation.

Sincerely,



David Jensen
Customer Service Supervisor

Rem

#28

SERVICE BULLETIN

PRODUCT: REM GRAIN VAC

MODEL: 2700

DATE: 10/08/09

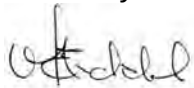
SUBJECT: BLOWER HOUSING REPAIR KIT – 38-112160

It has come to our attention that in some cases, a crack may develop on the back of the Blower Housing on your REM 2700 Grain Vac.

The upgrade kit will include an detailed instructional video, written instructions on how to perform the upgrade to fix the crack and install a reinforcing plate.

Call or email with any questions at parts@rem.sk.ca 1-800-667-7420

Sincerely,



Mike Erdahl
Customer Service Representative

Rem

29

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2700

DATE: 02/17/2010

SUBJECT: DRIVE DOGS ON THE AUGER SECTIONS

It has been found that in rare cases, the drive dogs on the auger sections have been installed incorrectly. This may cause the customer to experience frequent shear pin breakage and/or the top auger to push out the top bearing on the air lock further causing the augers not to engage properly.

Your satisfaction with your Rem 2700 GrainVac is very important to us, so we are announcing a program to fix this problem.

What We Will Do: Your Rem Dealer will adjust the drive dogs to the proper location and re-align the augers if necessary. (See pictures on page 2)

What You Should Do: Inspect your Rem 2700 GrainVac to determine if the problem exists. If you find that your Rem 2700 GrainVac has this problem, please contact your Rem dealer and schedule an appointment for this repair. By scheduling an appointment, your dealer can ensure that the necessary parts will be available on your scheduled appointment date.

Reimbursement: If your Rem dealer performs the related repairs, they will be reimbursed under the normal warranty protocol.

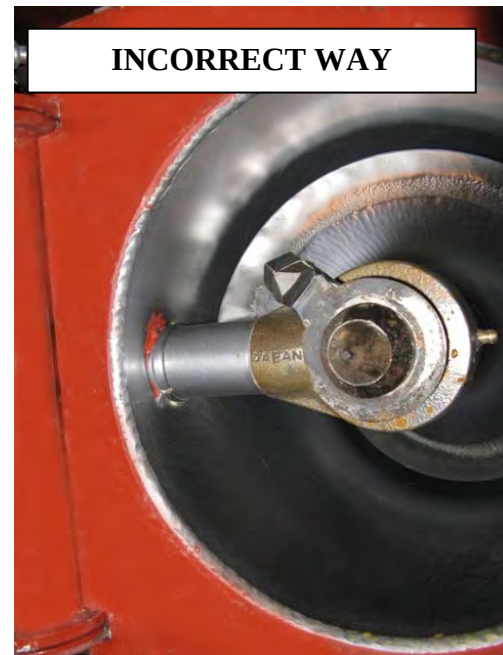
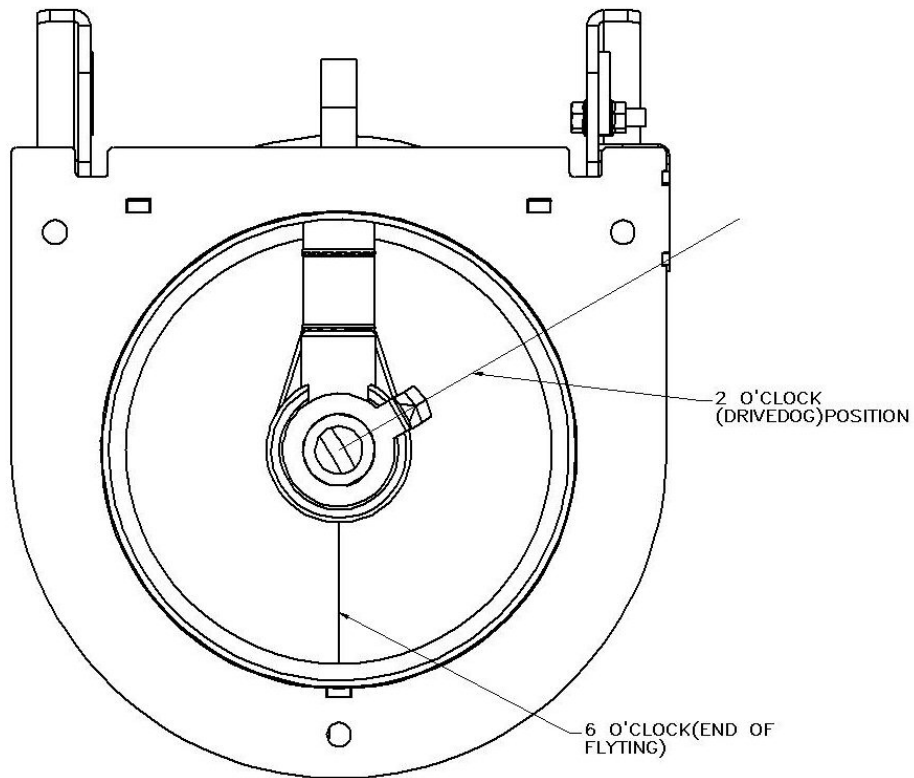
If you have any questions, please call our service department at 1-800-667-7420.

Thank you for your continued cooperation.

Sincerely,



David Jensen
Customer Service Supervisor



Rem

30

SERVICE BULLETIN

PRODUCT: GRAIN VAC

MODEL: 2700

DATE: 02/23/2010

SUBJECT: GRAIN DEFLECTOR & BRACKET

Letter sent to customers (that we have received a warranty registration) below:

Dear Rem 2700 GrainVac Owners,

It has been found that Rem 2700 GrainVacs that have serial numbers from 0100 to 0500 did not have the Grain Deflector installed from the factory. This may cause grain flow issues in certain grains.

Your satisfaction with your Rem 2700 GrainVac is very important to us, so we are announcing a program to fix this problem.

What We Will Do: We will send out a deflector kit at no charge to you to install on your machine.

What You Should Do: Inspect your Rem 2700 GrainVac to see if you already have the deflector installed. If you do not have one, please contact your Rem Dealer and one will be sent to you for immediate installation. The Rem Part numbers you will need to order are 1 of 3703-04-0031, and 1 of 38-111675.

Reimbursement: Rem dealer's will be reimbursed for the deflector kit under normal warranty protocol. If labor is incurred by the dealer to install the kits, one quarter of an hour will be paid out at normal warranty rates.

If you have any questions about this bulletin, please feel free to contact me anytime at 1-800-667-7420.

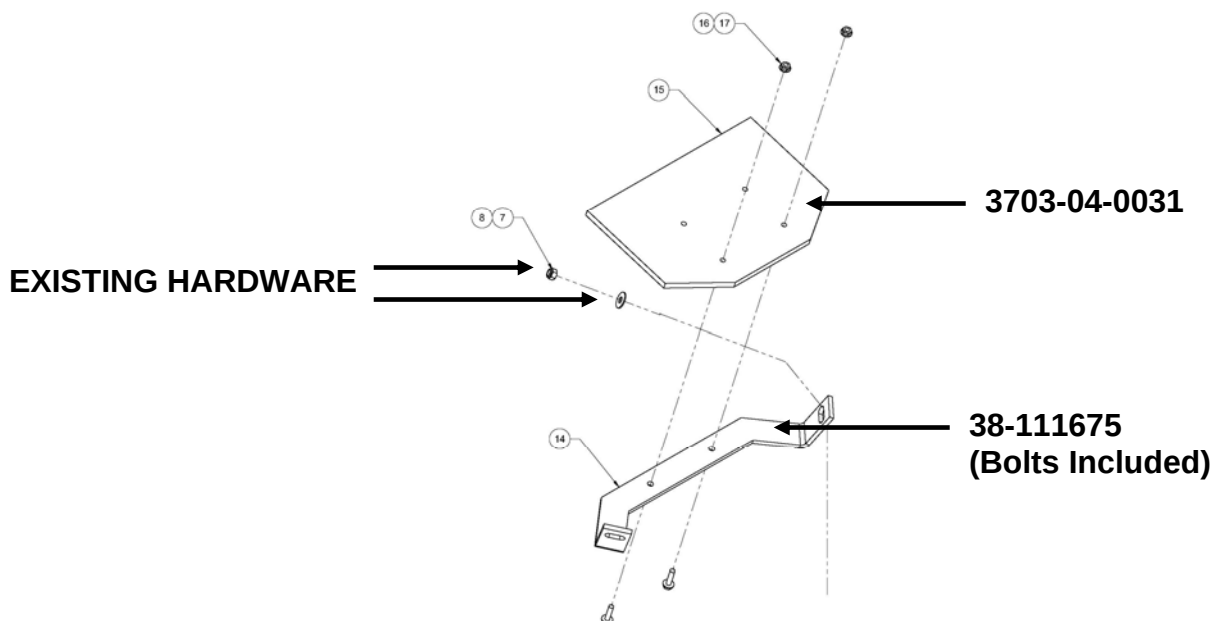
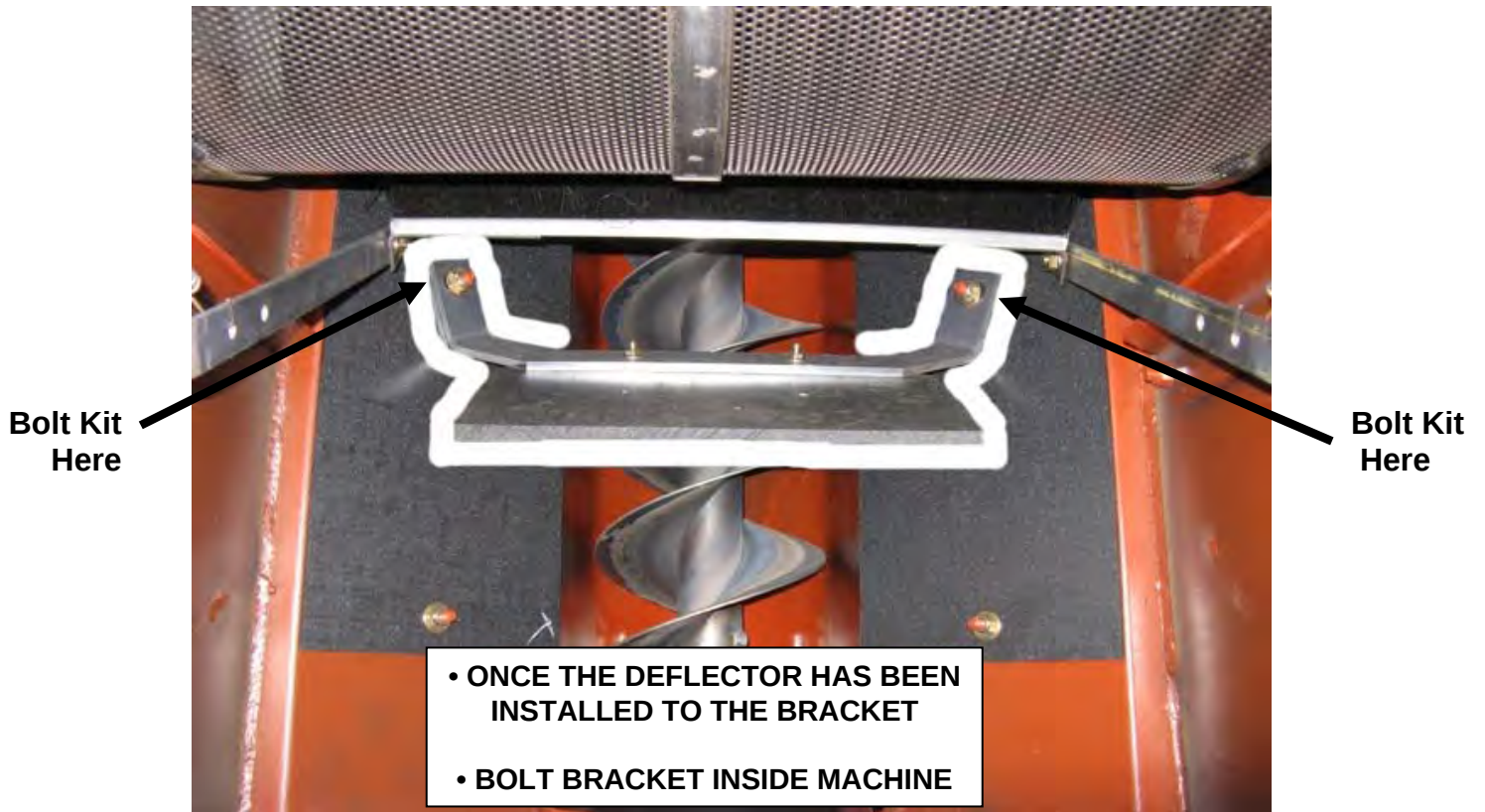
Thank you for your continued cooperation.

Sincerely,



David Jensen
Customer Service Supervisor

INSTALLED BRACKET AND DEFLECTOR SHOWN HERE





☒ AWARENESS

☐ MANDATORY

SERVICE BULLETIN

#31

PRODUCT: GRAIN VAC

MODEL: 2700

DATE: 06/23/2010

SUBJECT: SPRING LOADED DRIVE DOG UPGRADE

It has been found that in some cases, the drive dogs on the auger drive of the 2700 GrainVac will contact each other, causing the middle and top auger flightings to push out through the airlock bearing. Other symptoms of this problem are:

1. Repeated shear pin breakage.
2. Loud clunking or banging in the auger tube.
3. Top or middle auger flighting not turning.

What we will do: Customer satisfaction with our Rem 2700 GrainVac is very important to us, so we have developed a new spring-loaded drive dog kit to alleviate these problems.

What you should do: If your customer has experienced the above problem, please order the upgrade kit, part number 38-112273. It will contain the parts required to complete the upgrade as well as a short instructional DVD.

Reimbursement: Labour to install the upgrade will be paid out at maximum of 2 hours at your regular shop rate. Upon completion, please submit a **warranty claim with pictures** of the new kit installed and the serial number as reference.

If you have any questions, please call our service department at 1-800-667-7420. Thank you for your continued cooperation.

Regards,

David Jensen
Customer Service Supervisor

☐ AWARENESS

☒ MANDATORY



SERVICE BULLETIN

#32

PRODUCT: GRAIN VAC

MODEL: 3700

DATE: 07/06/2010

SUBJECT: HYDRAULIC CYLINDER STOP KIT (PART NUMBER: 55-112406)

It has been found that the current top cylinder spacer interferes with the hinge mechanism and may cause the cylinder shaft to break.

What we will do:

Customer satisfaction with the 3700 GrainVac is very important to us, so we have developed a new cylinder spacer that will not interfere with the hinge mechanism. The cylinder spacer will be automatically sent out to dealers.

What you should do:

This service bulletin is mandatory, so please contact your customer and let them know that we are providing them with a solution. {See below steps 1 to 4}

Reimbursement:

Labour to install the upgrade will be paid out at a maximum of 1/2 hr at your regular shop rate. Upon completion, please submit a warranty claim. **Please be advised that warranty will not be paid on broken cylinders after December 1st, 2010.**

Instructions:

1. Detach the top cylinder linkage pin from the top auger tube.
2. Remove the clevis from the cylinder shaft.
3. Fit the cylinder spacer over the shaft as shown in figure 1.
4. Carefully bend the tabs over the end of the cylinder as shown in figure1.

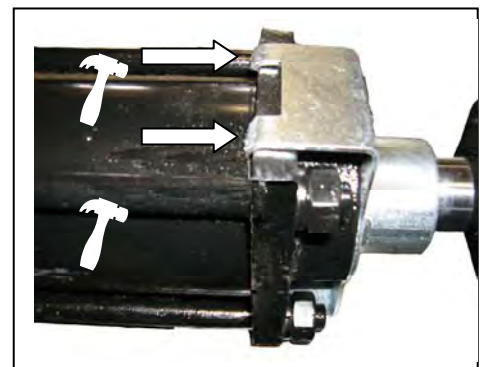


Figure 1

If you have any questions, please call our service department at 1-800-667-7420.

Regards,

A handwritten signature in cursive script that reads "David Jensen".

David Jensen
Customer Service Supervisor

☒ AWARENESS

☐ MANDATORY



SERVICE BULLETIN

#33

PRODUCT: GRAIN VAC

MODEL: 2100, 2500 & 2700

DATE: 03/1/2011

SUBJECT: SHEAR PIN BREAKAGE

Problem: It has come to our attention that some customers are experiencing excessive shear pin breakage. This problem will occur if the customer installs a regular bolt from the front of the shear sprocket assembly. When installed like this, it will shear the bolt on the threads instead of the shank of the bolt.

Solution: If a shear pin breaks, only replace it with Rem replacement shear pins, (part # 38-112427 kit includes 10 shear pins). It allows you to install the shear bolt from the front.

What We Will Do: We have custom manufactured a shear bolt with the shank of the bolt longer and the threads shorter.

What You Should Do: If your customer has experienced the above problem, please order the shear bolt kit, and advise your customer that these pins can be installed from the front.

If you have any questions, please call our service department at 1-800-667-7420. Thank you for your continued cooperation.

Regards,

A handwritten signature in cursive script that reads "David Jensen".

David Jensen
Customer Service Supervisor

☒ AWARENESS

☐ MANDATORY

Rem

SERVICE BULLETIN

#34

PRODUCT: GrainVac

MODEL: 2700

DATE: 10/18/2011

SUBJECT: SPRING LOADED DRIVE PIN SYSTEM

If your customer has the spring loaded drive pin system on their Rem 2700 GrainVac and is experiencing repeated shearpin breakage, clunking or banging in the auger tube, or is burning the front drive belt, they may need to ensure that the drive pins are properly engaging.

What we will do: A longer, heavy duty drive dog spring has been developed to alleviate these issues.

What you should do:

1. Order two new drive dog springs, part number 6777-02-0070.
2. Remove the bolt from the back of the drive dog assembly. You will have to hold onto the drive pin with a vise grip in order to properly secure the removal of the pin. Replace pin if damaged, part number 38-112488.
3. Remove the pin and the old spring. Ensure that the barrel is empty. If there are washers inside, they need to be removed.
4. Install the new spring and drive pin. If your old pin is in working order, put a drop of red loctite on the bolt and thread it into place. If you are using the current pin, part number 38-112488, you do not require loctite.
5. Adjust the bolt so that the drive pin is sticking out past the auger washer by 5/8" as shown in the picture.
6. Ensure that the drive pins plunge into the chamber properly.
7. Make sure that your augers are properly adjusted. Apply a straight edge to the bottom of each auger tube and take note of how much gap is in between the end of the tube and the face of the drive dog.
The gap should be consistent through each section of flyting. If there is not a gap, you may need to loosen off the set screws from the bearing and realign from the bottom section up.



Reimbursement: Labour to install the new spring and possible pin at a maximum of 1 hour at your regular shop rate. Upon completion, please submit a **warranty claim** of the new spring loaded drive pin install and the serial number as reference.

If you have any questions or require assistance please contact your area Sales Representative.

Ph: 1-800-667-7420 Fax: 306-773-1188 P.O. Box 1207 Swift Current, SK Canada, S9H 3X4
Website: <http://myrem.info> **E-mail:** remsales@rem.sk.ca

☐ AWARENESS



☒ MANDATORY

PRODUCT SAFETY BULLETIN #35

PRODUCT: GrainVac

MODEL: 2700

SERIAL: ALL

DATE: 06/20/2012

URGENT: PTO SHAFT IMPLEMENT HUB FAILURE

It has come to our attention that PTO shafts with potentially faulty clutch hubs may have been installed on the Rem model 2700 GrainVacs.

The safety risk has been identified as hairline cracks in the hub on the implement end of the PTO shaft that could result in complete failure. Based on failure tests conducted by the PTO shaft manufacturer it appears that the potential for failure is low. However, if failure were to happen, the implement end of the shaft could disengage from the Vac causing the half shaft to leave the machine at high velocity, creating **a real and substantial risk of damage, personal injury or even death.**

You are required to inspect all Rem 2700 GrainVacs sold or on hand.

What you should do:

1. Inspect all sold or in-stock 2700 GrainVacs. End users that own units for which a warranty registration has been received will be contacted directly. You must remove the PTO shaft to adequately inspect it. It is essential that you chip the paint away in the region of the keyway and use a magnifying glass or other suitable equipment to detect hairline cracks.
2. Look for cracks or damage on the implement end hub along the edges of the keyway.
3. If cracks or damage are found, call our parts department immediately to order a clutch hub kit. The part number of the clutch hub kit is 7100-37-0276, and installation instructions are included in the kit. Please have the serial number of the unit available when you call. Rem will provide you with the information to file the warranty claim and receive reimbursement.

Upon completion, please fill out the warranty claim with pictures of the damaged hub and the serial number of the machine.

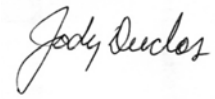
What we will do:

If you require any assistance in identifying a potentially cracked hub, please contact our service department and we will be happy to assist you. Once the warranty claim and required pictures have been received, Rem will reimburse as outlined in the warranty claim.

Ph: 1-800-667-7420 Fax: 306-773-1188 P.O. Box 1207 Swift Current, SK Canada, S9H 3X4
Website: <http://myrem.info> **E-mail:** remsales@rem.sk.ca

Rem takes safety very seriously. It is mandatory that all 2700 GrainVacs are inspected very carefully and that immediate corrective action be taken if defects are found. We will be pleased to provide any assistance you require in ensuring customer safety.

Sincerely,



Jody Duclos
Sales Manager





PTO SHAFT IMPLEMENT HUB FAILURE WARRANTY PROCEDURE

As noted in Product Safety Bulletin #35, there is a possibility of failure in some 2700 PTO clutch hubs. We are committed to resolve any hub issues that arise as a result of this service bulletin.

After inspection of your 2700 GrainVac (please refer to bulletin for instructions on inspecting the clutch hub):

1. Please find enclosed your clutch hub kit including installation instructions. Please follow the instructions closely when replacing the clutch hub.
2. Please take pictures of the GrainVac serial number and the cracked hub, then set aside the old clutch hub as it may need to be returned. Cracked clutch hubs can not be used.
3. On completion of the clutch hub replacement, dealer's may submit warranty claims online with accompanying pictures, or the claims may be mailed or faxed directly to Rem Enterprises Inc. Individual owners will need to submit claims through their dealer, or direct to Rem via fax or mail.

Rem will reimburse you a total of a \$70.00 which shall cover any and all costs beyond the clutch hub kit associated with this safety bulletin.

Rem takes safety very seriously. It is mandatory that all 2700 GrainVacs are inspected very carefully and that immediate corrective action be taken if defects are found. We will be pleased to provide any assistance you require in ensuring your safety.

Sincerely,

A handwritten signature in black ink that reads "Jody Duclos".

**Jody Duclos
Sales Manager**

rementerprisesinc.com

Rem Enterprises Inc.
2180 Oman Drive (P.O. Box 1207)
Swift Current, SK, Canada
S9H 3X4

toll free: 1.800.667.7420
phone: 1.306.773.0644
fax: 1.306.773.1188



☐ AWARENESS

☒ MANDATORY

SERVICE BULLETIN

#36

PRODUCT: GRAIN VAC

MODEL: VRX

DATE: 05/27/2013

SUBJECT: DRIVE DOG BOLT REPLACEMENT

It has come to our attention that we have received and installed some faulty bolts on the GrainVac VRX.

What We Will Do: We will send you the proper hardware for every machine you have purchased. Rem will process warranty claims for parts and no more than 15 minutes of labor per unit.

What You Should Do: Remove the ¼" by 3" bolt holding the drive dog in place on the top of the bottom auger flyting and the same bolt from the top of the middle flyting. You have to replace them with ¼" by 3" Grade 8 bolts and ¼" Nyloc nuts. Since they are Nyloc nuts, and the hub runs on a hex shaft, there is no need to over tighten the nuts.

Deadline: It is very important that these bolts be changed quickly. Rem will give everyone until June 30, 2013 to perform the actions necessary in this bulletin and submit claims for parts and labor.

If you have any questions, please call our service department at 1-800-667-7420. Thank you for your continued cooperation.

Regards,

Jody Duclos
Sales Manager



☐ AWARENESS

☒ MANDATORY

SERVICE BULLETIN

#37

PRODUCT: GRAIN VAC

MODEL: VRX

DATE: 08/16/13

SUBJECT: POTENTIAL TO SHEAR DRIVE DOG SHEAR BOLTS

The GrainVac VRX has greatly exceeded our expectations on full bin load out by being able to achieve 6500 bushels per hour in certain conditions! As a result, there is a potential to shear the bolts that hold the drive dogs in place on the bottom and middle flying sections when moving grain during full bin load out. In this circumstance, the auger will actually continue to operate. However, there is a possibility at a later date that the auger could slide out of the tube unexpectedly.

What REM will do:

REM will send 5/16" bolt kits to you for machines in the field and any that you have in stock.

What you need to do:

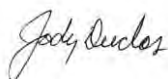
Ensure that all GrainVac VRX's in your inventory and ones that you have sold to customers get this update. Once the work is complete, please submit a warranty claim for the kit and labor to install it.

WARNING

Before operating, maintaining, adjusting or unplugging the GrainVac, place all the controls in neutral, stop the engine, disengage the PTO, set the park brake, remove the ignition key and wait for all the moving parts to stop.

1. Remove the middle flying by removing the drive dog at the bearing end. Slide the flying out of the auger tube. Drill out the drive dog to 21/64" using a drill press. Place the drive dog back onto the hex shaft, line up the holes, then drill through the drive dog and shaft with a 21/64" drill bit. Remove the drive dog, reinstall the flying back into place and fasten the drive dog back onto the shaft with the new hardware provided.
2. Remove the bottom flying by removing the two bearing hangar bolts found at the top of the bottom auger tube. Lift the flying out of the machine. Remove the drive dog from the top end of the flying. Drill out the hole on drive dog to 21/64" using a drill press. Place the drive dog back onto the hex shaft, line up the holes, then drill through the drive dog and shaft with a 21/64" drill bit. Reinstall the flying back into place and fasten the drive dog back onto the shaft with the new 5/16" hardware provided. Do not remove the drive dog from the gearbox end as it's already at 5/16".

Regards,

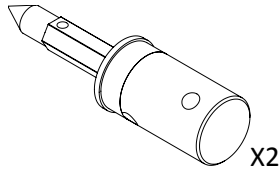
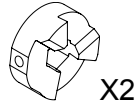
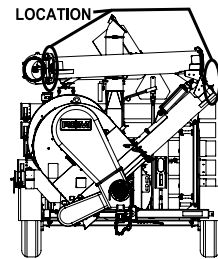


Sales Manager

Ph: 1-800-667-7420 Fax: 306-773-1188 P.O. Box 1207 Swift Current, SK Canada S9H 3X4

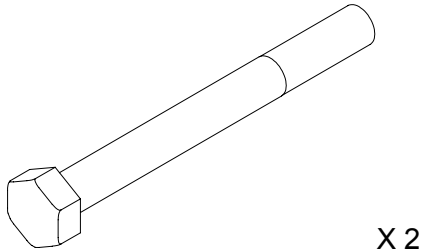
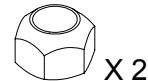
Website: www.grainvac.com e-mail: remsales@rem.sk.ca

PARTS AFFECTED:

45-112989 LOWER HEX
SHAFT (QTY 2)45-112984 HEX DRIVE
DOG (QTY 2)

LOCATION

RETROFIT PACKAGE CONTENTS:

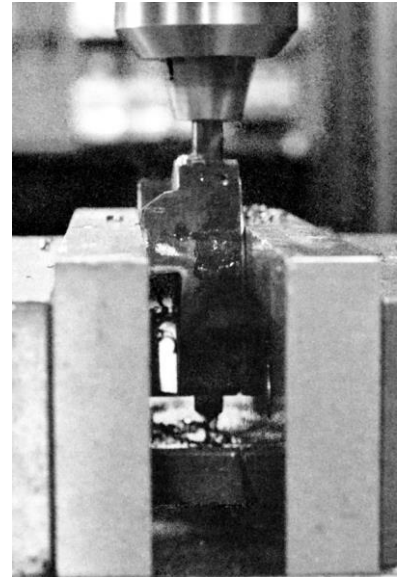
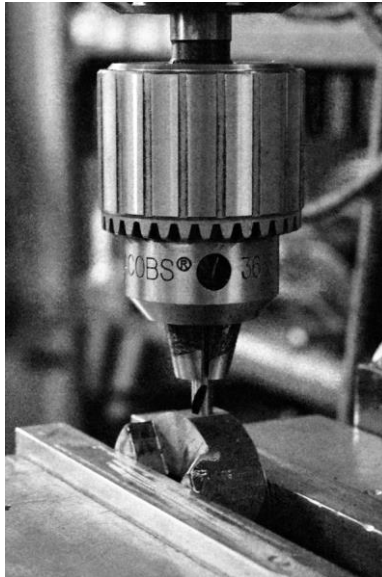
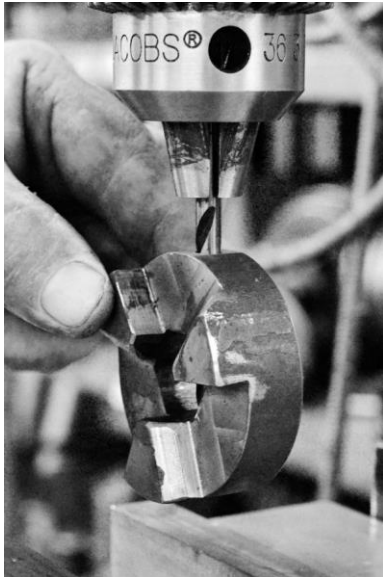
4001-32C3130 BOLT HEX 5/16 X 3" GR8
(QTY 2)4055-02C0230 NUT OVAL LOCK 5/16"
GRC (QTY 2)**⚠ WARNING**

Before operating, maintaining, adjusting or unplugging the GrainVac, place all the controls in neutral, stop the engine, disengage the PTO, set the park brake, remove the ignition key and wait for all the moving parts to stop.

1. Remove the middle flying by removing the drive dog at the bearing end. Slide the flying out of the auger tube.
2. Remove the bottom flying by removing the two bearing hanger bolts found at the top of the bottom auger tube. Lift the flying out of the machine. Remove the drive dog from the top end of the flying. **Do not remove the drive dog from the gearbox end as it's already at 5/16".**

DRIVE DOG 5/16" BOLT RETROFIT INSTRUCTIONS

3. Drill out the drive dogs to 21/64" using a drill press. To ensure the hole in the drive dog aligned with the drill bit:



- a. Place a 17/64" bit in the chuck and slide the drive dog onto the drill bit.
- b. Lower the spindle, align the vise, and clamp the drive dog. Raise and lower the spindle and check that the 17/64" bit passes through the drive dog without deflecting. Check that there is enough clearance for a 21/64" drill bit. Readjust positioning if necessary. Once aligned do not move the vise.
- c. Replace the 17/64" drill bit with a 21/64" drill bit and drill through the drive dog.
4. Place the drive dog backs onto the hex shafts and line up the holes.
5. Drill through the hex shaft with a 21/64" drill bit using the drive dog holes as a guide.



6. Remove the drive dogs from the hex shafts and reinstall the flying.
7. Fasten the drive dog back onto the shaft with the new 5/16" hardware provided.

Ph: 1-800-667-7420 Fax: 306-773-1188 P.O. Box 1207 Swift Current, SK Canada S9H 3X4

Website: www.grainvac.com **e-mail:** remsales@rem.sk.ca

SERVICE BULLETIN - #38



☐ General x ☒ Mandatory ☐ Awareness

Product: REM GrainVac **Model:** VRX **Date:** October 3, 2014

Subject: Airlock spring Tension

It has come to our attention that some REM GrainVac VRX airlock spring tension may have been set too loose from the factory. Please make sure that before any of your customers use their REM VRX, they check the airlock spring tension as indicated in the operator's manual

The Air lock doors can be found at the very top end of the discharge auger.

Large Door = 3-4 pounds with the door open one inch.

Small Door = 3 pounds with the door open one inch.

Some of the doors have been found to be less than 1.5 pounds. In certain conditions, this could cause the REM VRX to operate at less than optimum capacity.

The tension can easily be set by moving the spring mount arm accordingly.

The tension can be checked using a digital fish scale.

If you have any questions regarding this bulletin, please call us anytime at 1-877-667-7421.

Jody Duclos

GrainVac Sales Manager

REM – Ag Growth International

201 Industrial Dr. Swift Current, Saskatchewan, Canada S9H 4G5 | Box 1750, S9H 4J8

P: 306.773.7779 | C: 306.772.1750 | F: 306.778.2524 | E: jody@batco-rem.com

www.grainvac.com

www.aggrowth.com

SERVICE BULLETIN - # 39



☐ General ☐ Mandatory ☒ Awareness

Product: GrainVac Model: 2100 - 2700 Date: June 1, 2015

Subject: Hour Meter - Tachometer

The Hour Meter – Tachometer 38-113082 part number is being sold as a P8500-00-0001.

The Sendec Meter Replacement Kit will no longer be available with the instructions.
See below for mounting instructions below:



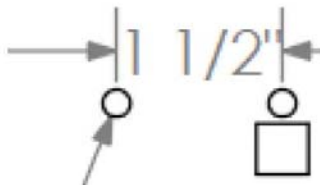
WARNING

Before operating, maintaining, adjusting or unplugging the GrainVac, place all the controls in neutral, stop the engine, disengage the PTO, set the park brake, remove the ignition key and wait for all the moving parts to stop.

Notice to customer:

SenDEC has been updated to a newer model so it may not look like your old meter. You may need to drill a new hole to mount it to your GrainVac.

The older style SenDEC Meters were mounted to holes 1-1/2" apart.



The newer style SenDEC Meters are mounted to holes roughly 1-11/16" apart.

Now that you have the newer model in your hand, you are able to make a decision where and how you'd like to mount your new meter.

SERVICE BULLETIN - # 40



☐ General ☒ Mandatory ☐ Awareness

Product: GrainVac

Model: VR12

Date: July 23, 2015

Subject: Gearbox

The gearbox on the VR12 may slide down on the mount bolts if they are not completely tight. When this happens, the drive dogs move away from each other causing them to disengage or slip.

We have designed a gearbox stopper kit to aid in holding the gearbox up in place so it cannot slide down.

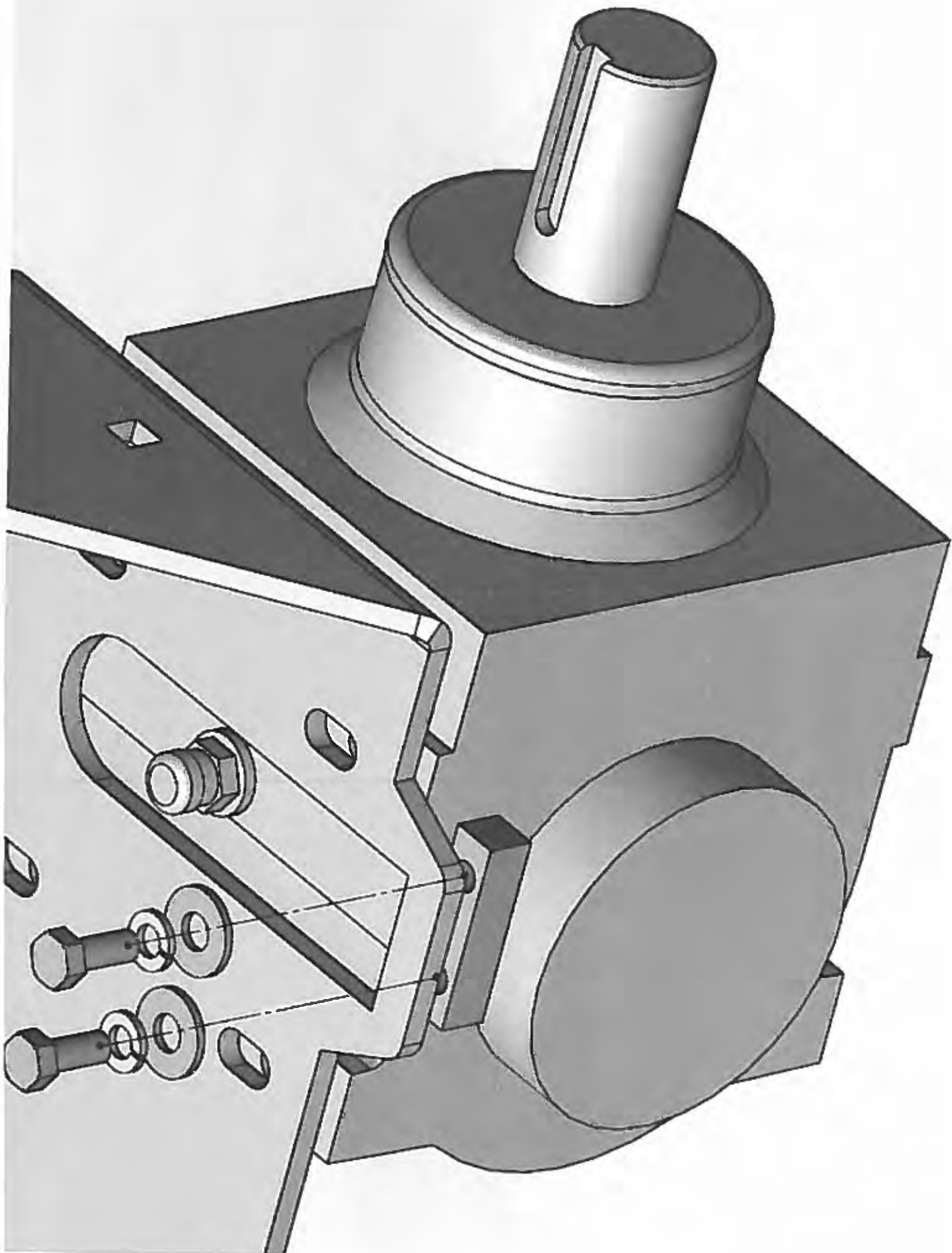
Please install the stopper kit as shown in the attached drawing.

Kits will be sent out to all dealers who ordered VR12 units from the factory.

Thanks for your help.

Jody Duclos
Product Manager
Batco-REM

SEE OTHER SIDE



SERVICE BULLETIN - # 41



☐ General ☐ Mandatory ☒ Awareness

Product: GrainVac Model: VR12 Date: Aug 23, 2016

Subject: Air Throttle Butterfly

It has come to our attention that some VR12 units may have had the air throttle butterfly assembled incorrectly. As a result, customers may see an increase in horsepower go through the GrainVac when operating with a tractor that has more than 130 HP and when operating in high volume air conditions such as clean up or when changing hoses.

See below for pictures of the correct orientation of the air throttle and make adjustments as necessary.

With the air throttle in the **closed** position as shown, your air throttle butterfly should look like this. See Figure 1.

Smooth waves

Pointy waves



Figure 1: Air Throttle Butterfly – Properly Installed

Product: GrainVac Model: VR12 Date: Aug 23, 2016

Subject: Air Throttle Butterfly

When the air throttle is in the **closed** position as shown, and the pointy waves are in this position, your air throttle needs to be disassembled, and the air throttle butterfly needs to be turned 180 degrees. See Figure 2.



Figure 2 – Air Throttle Butterfly – Not Properly Installed

☐ General ☒ Mandatory ☐ Awareness

Product: GrainVac Model: VR12 Date: May 29, 2017

Subject: Oil Bath Fan Bearing Cartridge

Bulletin Information:

REM has designed a new rotor bearing cartridge that is an oil bath. The oil bath bearing cartridge was implemented into VR12 production and used on serial numbers 40060-40080 built in May of 2017.

Details:

If a customer experiences a failed non-oil bath fan bearing cartridge while their unit is still under warranty, please follow these steps.

1. Please have the following information ready before you call:
 - a. Serial number of the unit.
 - b. Picture of the hour meter, and verification the hour meter is actually working.
 - c. Approximate number of bushels and main type of grain the unit has moved.
2. Call REM and speak with customer service. (1-306-773-7779)
3. Two new fans and an oil bath bearing cartridge will be ordered for your customer.
4. A RMA (Return Material Authorization) will be generated for the fans. We ask that all fans replaced be sent back to the nearest AGI warehouse with the serial number of the VR12 clearly written on each of them.
5. Dealers can install the new fans and bearing cartridge and submit a warranty claim for the repair. Note: The credit for the fans will be processed only if the fans have been returned to your closest AGI warehouse.

Below, you will find instructions on the proper maintenance of the new oil bath fan bearing cartridge.

1. VR12 Rotor Bearing Cartridge Oil Bath Maintenance:

To ensure efficient operation, please adhere to the following VR12 rotor bearing cartridge oil bath maintenance schedule:

- 1.1 Checking the rotor bearing cartridge oil level
- 1.2 Inspecting and cleaning the air breather
- 1.3 Changing the rotor bearing cartridge oil

IMPORTANT: The oil level in the VR12 rotor bearing cartridge must be checked **every 40 hours of operation**, and maintained at the recommended level to ensure efficient operation.

IMPORTANT: In clean conditions, the air breather plug should be cleaned at **every 100 hours of operation**, or annually at a minimum. In dusty, dirty operating conditions, the plug must be checked and cleaned as often as it is necessary to keep the plug clean and open.

IMPORTANT: The VR12 rotor bearing cartridge oil must be changed at **every 100 hours of operation**, or annually at a minimum.

Product: GrainVac Model: VR12 Date: May 29, 2017

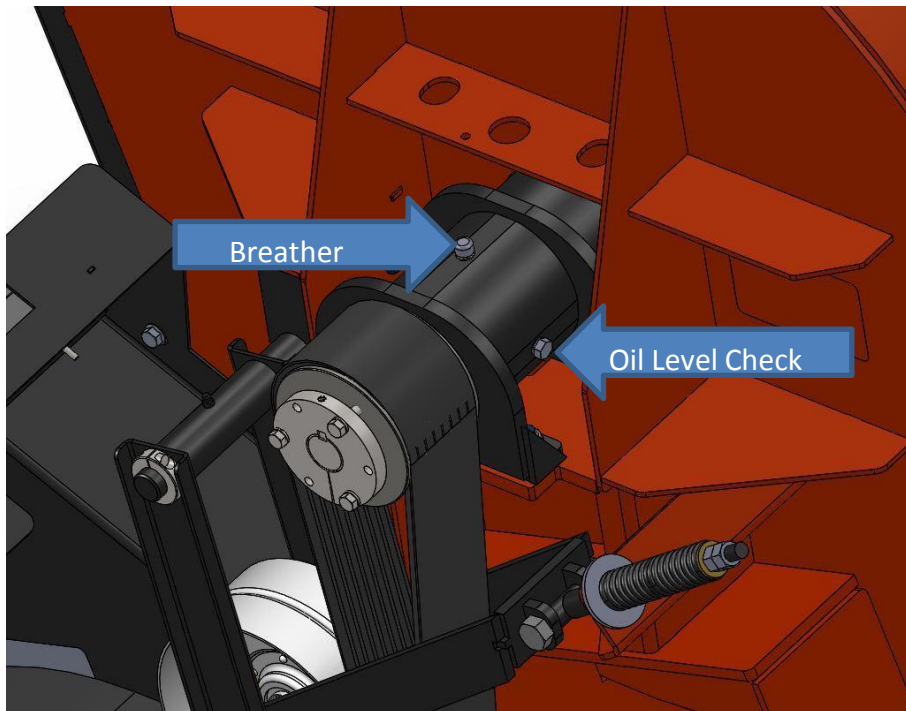
Subject: Oil Bath Fan Bearing Cartridge

⚠ WARNING Before performing any maintenance or adjustment, place all the controls in neutral, stop the engine, disengage the PTO, set the park brake, remove the ignition key, and wait for all the moving parts to stop.

1.1 To Check the Rotor Bearing Cartridge Oil Level:

- The rotor bearing cartridge requires SAE 75W90 synthetic gear oil for top-up (if needed).
 1. Place the VR12 on a flat, even surface that will help ensure that the unit is as level as possible.
 2. Remove the hoses from the hose racks.
 3. Remove the rear upper guard to gain access to the bearing cartridge.
 4. Remove the oil level check plug on the side of the bearing cartridge.

Figure 1: Air Breather and Oil Level Check Plugs



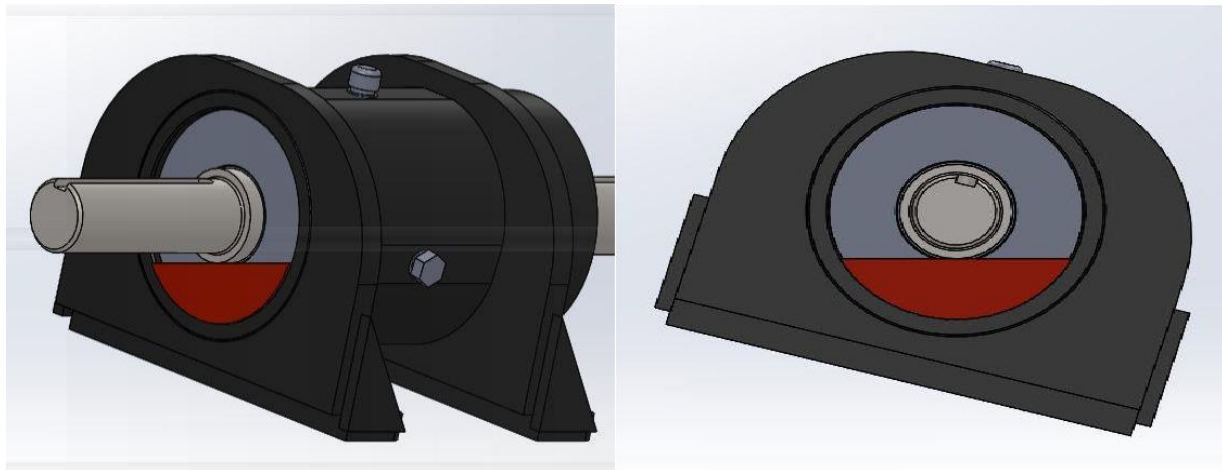
Product: GrainVac **Model:** VR12 **Date:** May 29, 2017

Subject: Oil Bath Fan Bearing Cartridge

5. The oil level should come up to the lower edge of the oil level hole. If necessary, add oil through the breather plug hole (use SAE 75W90 synthetic gear oil) until the correct oil level is reached.

NOTE: The oil level check plug measures the correct oil level while the bearing cartridge is installed, at its installed angle (see Figure 2 below).

Figure 2: Correct Rotor Bearing Cartridge Oil Level



6. Re-Install the air breather and oil level check plugs.

1.2 To Inspect and Clean the Air Breather Plug:

1. Remove the air breather plug (see Figure 1).
2. Wash the plug with solvent.
3. Blow compressed air through the air breather plug passage to ensure that it is open.
4. Reinstall and tighten the air breather plug.

1.3. To Change the Rotor Bearing Cartridge Oil:

- Rotor bearing cartridge oil replacement requires approximately 5 fluid ounces of SAE 75W90 synthetic gear oil.
1. Place the VR12 on a flat, even surface that will help ensure that the unit is as level as possible.
 2. Remove the hoses from the hose racks.

Product: GrainVac **Model:** VR12 **Date:** May 29, 2017

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3. Remove the rear upper guard to gain access to the bearing cartridge.
4. Remove the oil level check plug on the side and the breather plug from the top of the bearing cartridge (see Figure 1).
5. Use a plastic syringe and hose inserted into the breather plug hole to suction the oil out of the bearing cartridge.
6. Inspect the air breather plug, and clean if necessary (see Section 1.2).
7. Slowly fill the bearing cartridge with approximately 5 fluid ounces of SAE 75W90 synthetic gear oil. Stop filling when oil begins to flow out of the oil level check plug hole.
8. Re-install the oil level check plug and the air breather plug.

SERVICE BULLETIN - #43



☐ General ☒ Mandatory ☐ Awareness

Product: GrainVac Model: VR12 Date: June 15, 2017

Subject: Replacement Wear Wrap

Bulletin Information:

REM has designed a new wear wrap for the VR12 Blower housing. The new wear wrap was implemented into VR12 production and used on serial numbers 40081-40100 built in June of 2017.

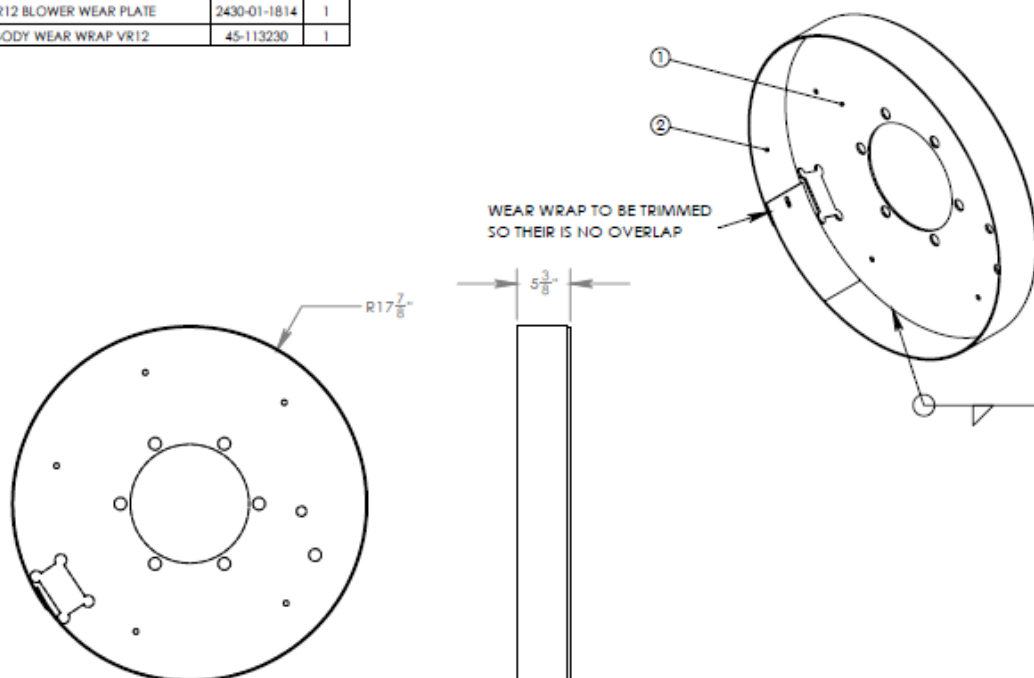
Details:

Instead of ordering part number 45-113264, customers will need to order the new kit Part Number 45-113310.

The kit will include the new wear wrap assembly, new inspection door, and hardware to mount it.

1. To install, insert the new wear wrap assembly into the housing using the inspection door and welded bolts to line it up. Make sure the wear wrap is as far back as possible and not interfering on any welds or bolt heads.
2. Drill through one of the holes in the wear wrap, through the body of the vac.
3. Install one of the countersunk bolts and tighten it into place. The countersunk bolts go from the rear of the machine to the front.
4. Drill the rest of the holes and install the rest of the countersunk bolts.
5. Replace the inspection door with the new one provided.

VR12 BLOWER WEAR PLATE	2430-01-1814	1
BODY WEAR WRAP VR12	45-113230	1

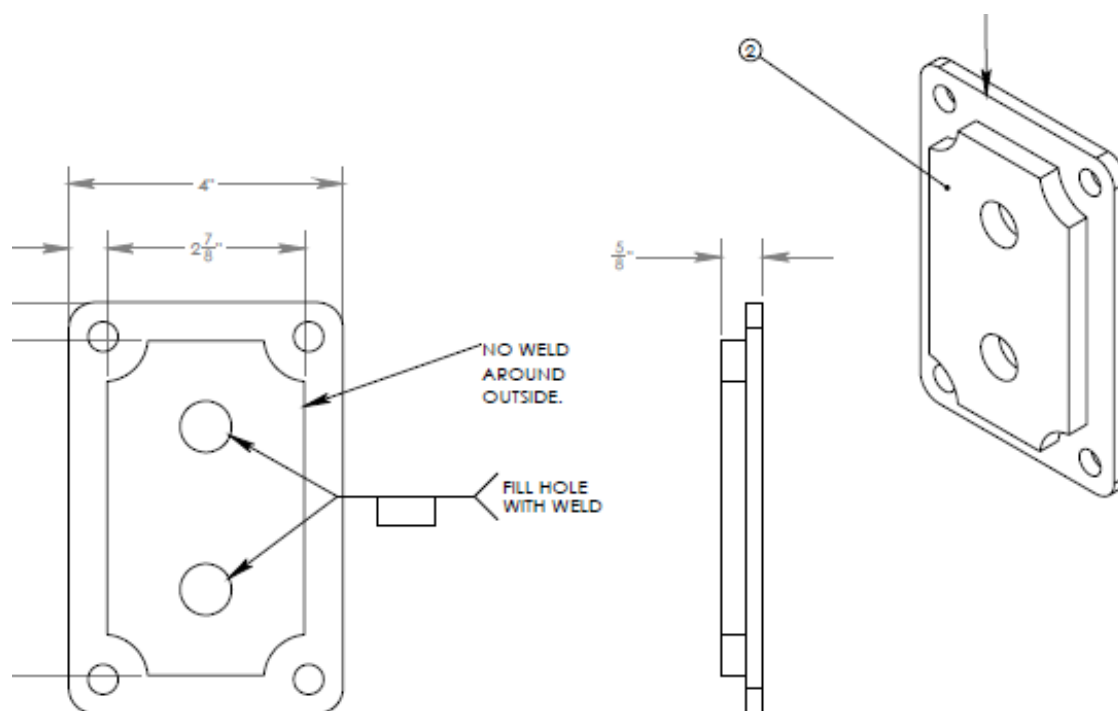


SERVICE BULLETIN - #43



Product: GrainVac Model: VR12 Date: June 15, 2017

Subject: Replacement Wear Wrap



SERVICE BULLETIN - #44



☐ General ☒ Mandatory ☐ Awareness

Product: GrainVac Model: VR12 Date: June 21, 2017

Subject: Air Throttle Weight

Bulletin Information:

It has come to our attention that when towing the REM VR12 GrainVac, the stop for the air throttle weight can become bent. If this happens, there is a possibility for the air throttle to push the wrong way causing it to stay open, when it should be closing.

Details:

If this happens, and the customer is using a tractor that has more than 130 HP, it puts extra stress on the drive components such as the fan drive belt.

Customers should check their VR12 air throttle stop to ensure that it is correctly adjusted.

1. Set the jack on the VR12 so that the unit is sitting level.
2. Check to ensure that the air throttle weight is hanging straight down and gently resting on the stop as shown in figure 1.

Figure 1:



Product: GrainVac **Model:** VR12 **Date:** June 21, 2017

Subject: Air Throttle Weight

3. If the air throttle stop is bent as shown in Figure 2, you will have to use a rubber hammer to tweak it back so that it is just touching the air throttle.

Figure 2:



We suggest that if you are going to tow the VR12 to different locations, that you lock the air throttle into the open position as shown in figure 1, so it cannot rock back and forth causing the stop to bend again.

If you have any questions about this bulletin, please let me know.

Sincerely,

Jody Duclos
Product Manager
Batco-REM