6" & 8"
POWER SWEEP AUGER

OWNER'S & OPERATOR'S MANUAL

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Hutchinson/Mayrath

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Limited Warranty: (a) For a period of (1) year after receipt of goods by the original consumer buyer, Hutchinson/Mayrath will supply free of charge replacement parts for parts that prove defective in workmanship or material. Defective parts must be returned freight prepaid to a specified Hutchinson/Mayrath location. Only Hutchinson/Mayrath original repair parts may be used for warranty repairs.
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(1) Improper assembly, including failure to properly install all safety equipment.
(2) Improper installation.
(3) Unauthorized alternations of goods.
(4) Goods operated when obviously in need of repair.
(5) Use of unauthorized repair parts.
(6) Irresponsible operation.
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SAFETY

GENERAL SAFETY STATEMENT

This manual was written with the safety of the operator and others who work with the equipment as our prime concern. The instructions presented will help the reader learn SAFE day to day work practices. We want you as our partner in safety.

It is your responsibility as an owner, operator or supervisor to know what specific safety requirements and precautions exist and to make these known to all other personnel working with the equipment or in the area, so that they too may safely perform their duties and avoid any potentially hazardous situations.

Please remember safety equipment provides important protection for persons around a grain handling system that is in operation. Be sure ALL safety shields and protection devices are installed and properly maintained. If any shields or guards are damaged or missing, contact your dealer to obtain the correct items.

Avoid any alterations of the equipment. Such alterations may create a dangerous situation where serious injury or death may occur.

SAFETY ALERT SYMBOL

The symbol shown below is used to call your attention to instructions concerning you personal safety. Watch this symbol - it points out important safety precautions. It means “ATTENTION! Become alert! Your personal safety is involved!” Read the message that follows and be alert to the possibility of personal injury or death.

BE ALERT!

YOUR SAFETY IS INVOLVED

WARNING

Anyone who will operate or work around this machine shall first read this manual! This manual must be delivered with the equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

TABLE OF CONTENTS

OPERATOR QUALIFICATIONS

Operation of this auger shall be limited to competent and experienced persons. In addition, anyone who will operate or work around an auger must use good common sense. In order to be qualified, they must also know and meet all other requirements, such as:

1. Some regulations specify that no one under the age of 16 may operate power machinery. This includes this auger. It is your responsibility to know what these regulations are in your area or situation.
2. Current OSHA regulations state in part: At the time of initial assignment and at least annually thereafter, the employer shall instruct every employee in safe operation and servicing of all equipment with which the employee is, or will be involved.*
3. Unqualified persons are to stay out of the work area. See Page 5.
4. A person who has not read and understood all operating and safety instructions is not qualified to operate the machine.

***Federal Occupational Safety & Health Standards for Agriculture Subpart D, Section 1928.57 (a) (6).**

SIGN-OFF SHEET

As a requirement of OSHA, it is necessary for the employer to train the employee in the safe operation and safety procedures with this auger. We include this sign off sheet for your convenience and personal record keeping.

DATE	EMPLOYER SIGNATURE	EMPLOYEE SIGNATURE

MACHINE INSPECTION

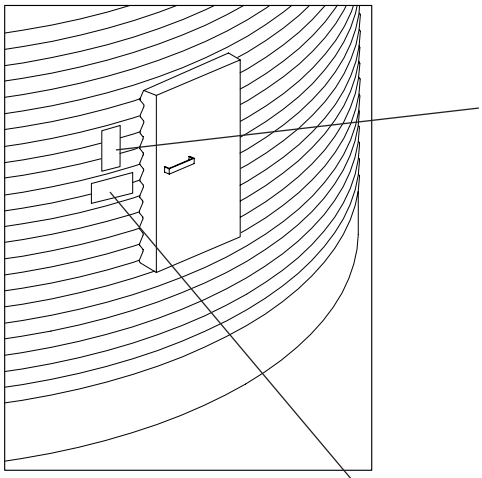
After delivery of your new auger and/or completion of assembly and before each use, inspection of the machine is mandatory. Use the assembly instructions in this manual as a reference to determine that the auger is assembled properly. This inspection should include, but not be limited to:

1. Check to see that all guards listed in the assembly instructions are in place, secured and functional.
2. Check all safety signs (decals) and replace any that are worn, missing or illegible. The safety signs are listed in the back of this manual. Safety signs may be obtained from your dealer or ordered from the factory.
3. Are all fasteners tight?
4. Check oil levels in gearboxes. See “Lubrication” on Page 12 for oil fill information.
5. Check winch and cable for security and operation. There should be at least three complete wraps of cable around the winch drum when in the full down position.
6. Check all chains and belts for proper adjustment.

INSPECT SAFETY DECALS

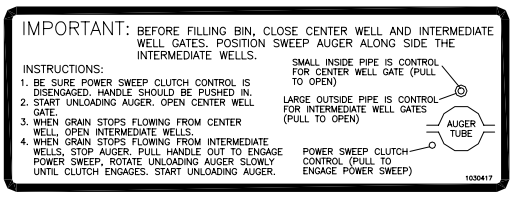
Check components as specified below to ensure that safety decals are present and in good condition. If a decal cannot be easily read for any reason or has been painted over, replace it immediately. Decals may be ordered through you dealer.

DANGER Decals, No. 1002303 and 1002304 were supplied with the bin unloading equipment. These safety signs should be applied to the side of the bin near the bin opening, so they can be viewed by people entering into the bin or storage building.



Danger Decal,
Part No. 1002303
Side of Bin, Near Bin Opening

Danger Decal, Part No. 1002304
Also Applied to Sweep Flight Shield and to Bin Flange



Important Decal, Part No. 1030417
Applied to Bin Flange

Part No. 1002305
Applied to Bin Flange

Safety Decals and their locations can also be found on Page P-1.

DESIGNATED WORK AREA

Before starting the auger, a designated work area should be established around it.

Under no circumstances should persons not involved in the operation be allowed to trespass into the work area.

It shall be the duty of all operators to see that children and/or other persons stay out of the work areas! Trespass into the work area by anyone not involved in the actual operation, or trespass into a hazardous area by anyone, shall result in an immediate shut down by the operator.

It shall be the responsibility of all operators to see that the work area has secure footing, is clean and free of all debris and tools which might cause accidental tripping and/or falling.

OPERATING PROCEDURES

OPERATING INSTRUCTIONS

The horizontal unloading kit includes a section of flanged tubing (with flight and stubs) which bolts to the flange on the unloading tube. The drive motor is mounted on top of the flanged tube. All mounts are designed to take the proper size motor. On direct belt drive units, the head bearing is sealed and self-aligning and drive parts include auger sheave and "B" belts for dependable service. On reducer drive units, the reducer is mounted to the head plate of the auger housing. Drive parts include reducer, input shaft sheave and "B" belts for dependable service.

Our augers are well made and we are proud of our line of equipment. We would like you, as our customer, to do your part in using caution and good judgement in using our equipment, as well as any other machinery.

DO NOT enter the grain bin unless all power driven equipment has been shut down and locked out.

ELECTRIC MOTOR DRIVES

Always use a motor with required H.P. suggested in the table on Page 6. Use a motor that operates at 1750 RPM. Electric motors and controls shall be installed by a qualified electrician and must meet the standards set by the National Electrical Code and all local and state codes.

A magnetic starter should be used to protect your motor when starting and stopping. It should stop the motor in case of power interruption, conductor fault, low voltage, circuit interruption or motor overload. Then the motor must be restarted manually. Some motors have built-in thermal overload protection. If this type motor is used, use only those with manual reset.

Reset and motor starting controls must be located so that the operator has full view of the entire operation.

A main power disconnect switch capable of being locked only in the OFF position shall be provided. This shall be locked whenever work is being done on the Horizontal Bin Unloading Auger.

OPERATING PROCEDURES

HORSEPOWER CHART

Bin Dia.	Horizontal Head		25 Degree Head		Vertical Head		Lowboy Head	
	6"	8"	6"	8"	6"	8"	6"	8"
15 ft	3 hp	3 hp	3 hp	5 hp	3 hp	5 hp	6" x 20 ft	8" x 20 ft
18 ft	3 hp	3 hp	3 hp	5 hp	3 hp	5 hp	5 hp	7 1/2 hp
21 ft	3 hp	5 hp	5 hp	5 hp	5 hp	7 1/2 hp	**All Others,** Up to 36 ft	
24 ft	3 hp	5 hp	5 hp	5 hp	5 hp	7 1/2 hp		
27 ft	5 hp	5 hp	5 hp	5 hp	5 hp	7 1/2 hp		
30 ft	5 hp	5 hp	5 hp	7 1/2 hp	7 1/2 hp	7 1/2 hp	7 1/2 hp	10 hp
33 ft	5 hp	5 hp	5 hp	7 1/2 hp	7 1/2 hp	7 1/2 hp		
36 ft	5 hp	5 hp	5 hp	7 1/2 hp	7 1/2 hp	7 1/2 hp		
39 ft	—	7 1/2 hp	—	10 hp	—	—	—	—
42 ft	—	7 1/2 hp	—	10 hp	—	—	—	—
48 ft	—	7 1/2 hp	—	10 hp	—	—	—	—

The horsepower recommendations are based on clean, dry shelled corn or wheat. High moisture grain (above 15%) will require greater power.

The maximum possible capacity will be less with high moisture grain than with dry grain.
Use the table above to determine size of motor required.

FLIGHT SPEED INFORMATION

Proper auger flight speed is important for efficient operation of the Power Sweep.

1. If the flight speed is too fast, excessive wear will result (See table below).
2. If the flight speed is too slow and the auger flighting is permitted to "load-up", high torque will be required to turn the auger flighting, and damage to the unit can result. Use the bin well slide gate to control the amount of grain fed into the auger (See table above).

Disconnect power before resetting motor overloads. Make certain electric motor is grounded.

	Horizontal Head		25 Degree Head		Vertical Head		Lowboy Head	
	6"	8"	6"	8"	6"	8"	6"	8"
Motor Pulley Dia.*	3.5" O.D.	3.5" O.D.	3.5" O.D.	3.5" O.D.	4.5" O.D.	4.5" O.D.	3.5" O.D.	4.5" O.D.
Driven Pulley Dia.	12" O.D.	15" O.D.	12" O.D.	15" O.D.	12" O.D.	12" O.D.	12" O.D.	15" O.D.
Unloading Auger Speed (RPM)	490	390	490	390	440	440	620	510
Sweep Auger Speed	290	230	290	230	260	260	366	301

*** Motor pulleys are <u>not</u> furnished with the auger.**

START-UP INFORMATION

Make certain everyone is clear before operating equipment.

The operator shall be aware of any unusual vibrations, noises and the loosening of any fasteners.

Keep all safety shields and devices in place.

Keep hands, feet and clothing away from moving parts.

Shut off and lock out power to adjust, service or clean.

Never enter the bin while the power sweep auger is in operation. Never attempt to control the operation of the sweep auger by pushing on the operating sweep auger with shovels, brooms or other devices. DO NOT attempt to restrain movement of the sweep auger by attaching ropes, bars or other devices to be held by an operator.

During the operation of the auger, one person shall be in a position to monitor the operation. Inspect the drive before adding power and know how to shut down in an emergency (See Page 11). Visually inspect the auger periodically during operation. **DO NOT** leave the unit operating unattended.

IMPORTANT: BEFORE FILLING BIN

1. Close the center well and the intermediate well gates. Push the control pipes to close (See Figure 5 on page 9).
2. Disconnect power to the sweep drive power head.
3. Position the sweep auger along side the intermediate wells.

BREAK-IN INFORMATION

An auger should go though a “break-in” period when it is new or after it sets idle for a season. The auger should first be run at partial capacity until the screw becomes polished and smooth before attempting full capacity. A failure will most likely occur when it is run full before it has “polished up”. It is recommended that several hundred bushels of grain be augered at partial capacity to polish the screw.

Never operate the auger when empty for any length of time, as excessive wear will result. If at all possible do not stop or start the auger under load, especially before the flight and tube become well polished, as this may cause the auger to “freeze-up”.

1. If the flight speed is in excess of what is recommended, excessive wear will result.
2. If the flight speed is slow and the auger flighting is permitted to “load up”, high torque will be required to turn the auger flighting and damage to the unit can result. Use the bin well slide gates to control the amount of grain fed into the auger.

OPERATING CAPACITIES

The performance of augers can vary greatly due to operating conditions. Different materials, moisture content, amount of foreign matter, methods of feeding and speed all play a role in the performance of the auger. Twenty-five (25%) moisture could cut capacity back by as much as 40% under some conditions.

OPERATING PROCEDURES

FULL LOAD OPERATING PROCEDURES

Operation of the unload auger will generally include moving grain into or out of grain storage structures. Grain will enter the auger through a dump hopper or through bin wells in grain bins. There are flow control devices included with these components that should be used to control grain flow rates into the auger.

DO NOT enter the bin if the grain has bridged or has not flowed normally out of the bin, such as shown in Figure 1 or Figure 2, the grain may suddenly break loose and bury causing suffocation.

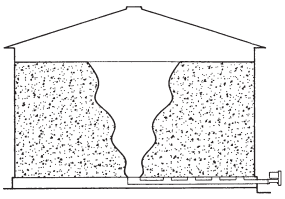


FIG. 1
(ABNORMAL FLOW)

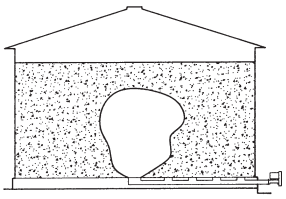


FIG. 2
("BRIDGING")

DO NOT enter the grain bin unless all power driven equipment has been shut down and locked out.

NEVER enter the grain bin unless monitored by another person.

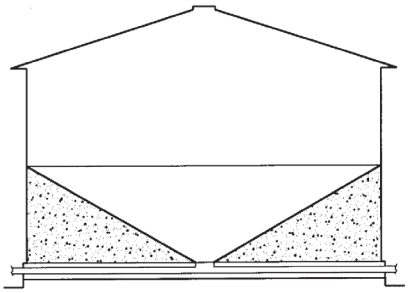


FIG. 3
(NORMAL FLOW)

If intermediate wells are being used, they should be opened after grain has stopped flowing into the center well and before the sweep auger is engaged. See Figure 4. Shut down and lock out the unload auger before engaging the sweep auger.

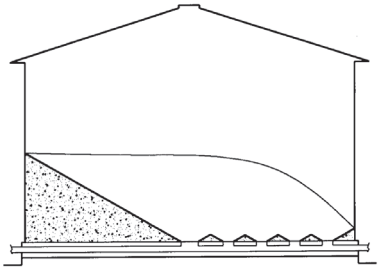


FIG. 4

NORMAL OPERATION

1. Start the unloading auger. The motor is located on the drive head on the power tube. A horsepower chart on page 6 includes motor size and bin diameter.
2. Open the center well gate which is connected to the small pipe on the top center of the auger tube (the "center well control pipe"). See Figure 5. Open gradually until the desired flow is established. It should not be necessary to open the gate more than 3 to 6 inches. Always close the center well gate and allow the unloader to clean out before stopping the unloader. When restarting, open the center well gate to the previous position immediately after starting the unloader.

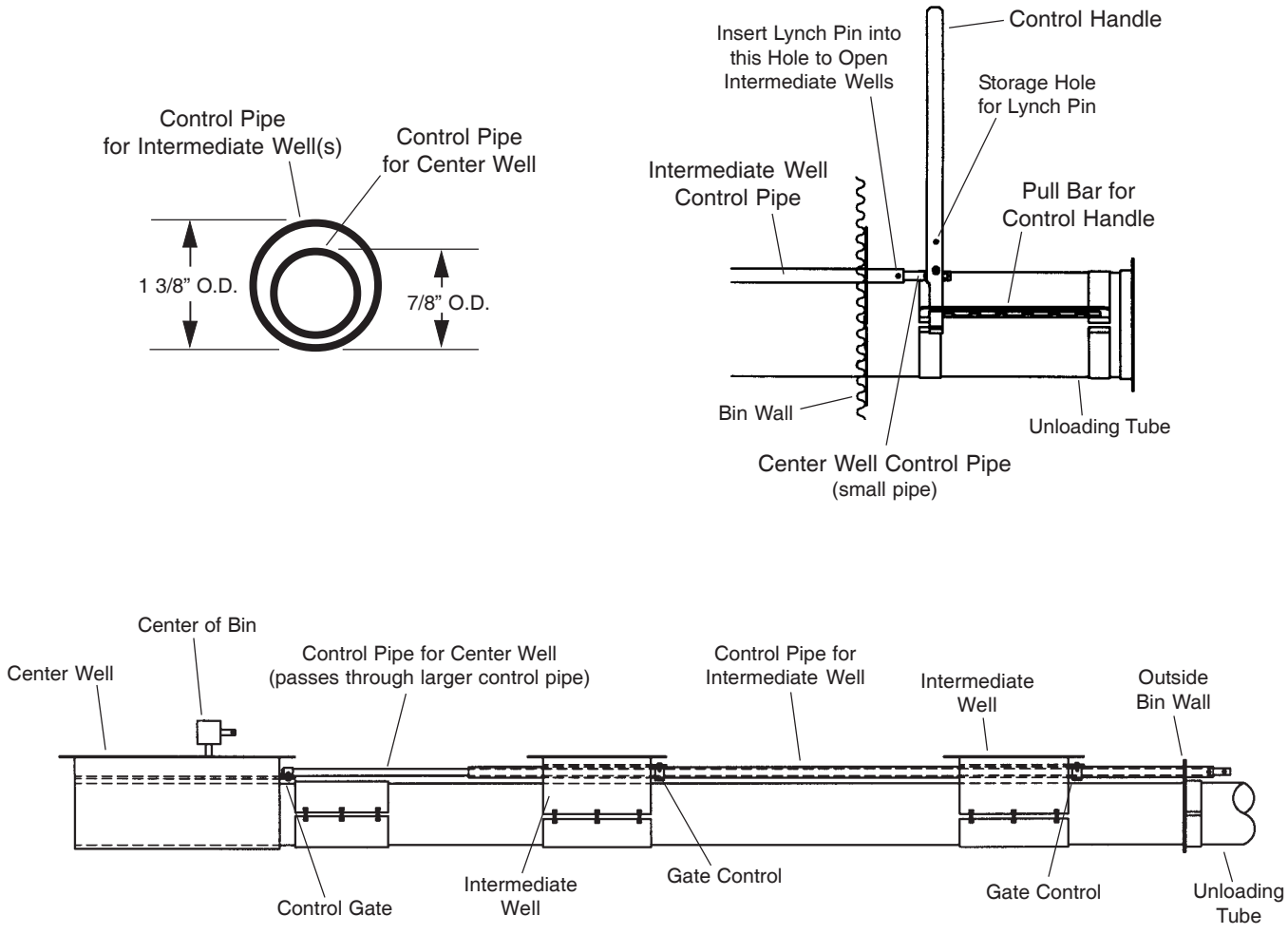


FIG. 5

OPERATING PROCEDURES

NORMAL OPERATION - CONT.

3. When the natural gravity-flow of grain to the center well stops, close the center well gate and insert lynch pin through the intermediate well(s) control pipe (see Fig. 5 on previous page).)

   Now you will be able to open the intermediate well(s). Open gradually until the desired flow is established. It should not be necessary to open the gates more than 2 to 4 inches (the remaining grain should appear as shown in Fig. 6.

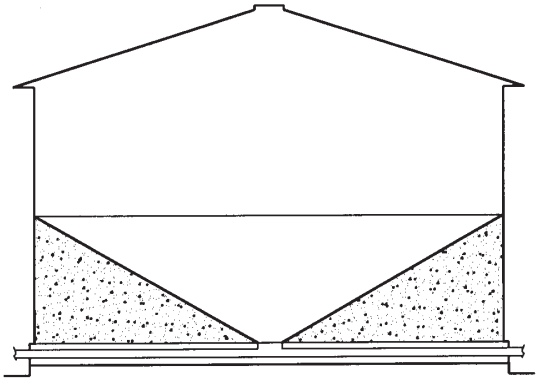


FIG. 6

4. When grain flow stops, shut down the unloader and lock-out. The grain remaining should appear as shown in Fig. 7.

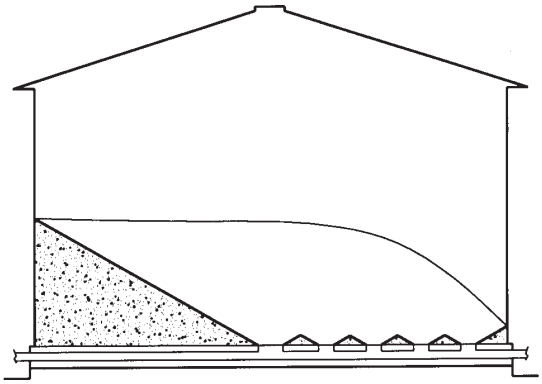


FIG. 7

5. With electric power to the Power Sweep motor locked-out, open a belt drive guard and rotate the large sheave while pulling on the clutch control (the clutch control is the single pipe control at the lower right of the auger tube, the pipe will move as the clutch engages).

6. Restore the power and start the Power Sweep motor. The sweep auger will start as the unloading auger is started.

   Open the center well full open to more readily recieve grain from the sweep.

   The sweep auger will remain on the floor and clear most grain in one pass. A second pass will clear additional grain before final clean-out.

7. Shut down the unloader and lock out the main power.

KEEP OUT OF BIN WHILE SWEEP IS IN OPERATION.

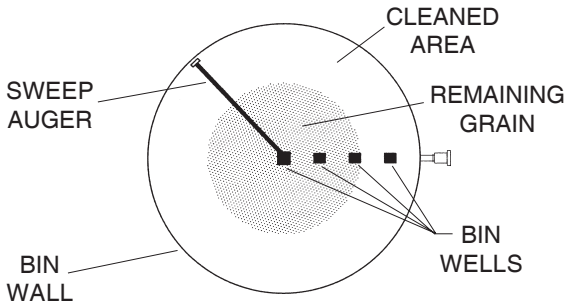
RAPIDLY TRAVELING SWEEP AUGER.

FINAL CLEANOUT

The following procedure is recommended for cleaning the floor of the bin after the sweep auger has removed as much grain as possible.

1. Clean (scoop and sweep by hand) the outer area of the floor into a circular pile towards the center of the bin (See Figure 8).
2. Clear everyone out of the bin.

DO NOT enter the grain bin unless all power driven equipment has been shut down and locked out.

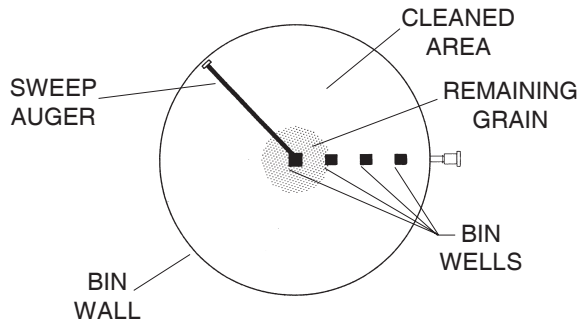


TOP VIEW OF BIN

FIG. 8

FINAL CLEANOUT - CONT.

3. After making sure everyone is outside the bin and clear of the equipment, start the unloading auger. In a short time, the circular pile towards the center of the bin will have been removed.
4. Stop the equipment and lock out.
5. Scoop and sweep by hand the remaining floor area to the center of the bin. See Figure 9.



TOP VIEW OF BIN

FIG. 9

6. Clear everyone out of the bin.
7. Repeat steps 3, 4, 5 and 6 until all grain has been removed from the bin.

Keep out of the bin while sweep is in operation. Rapidly traveling sweep auger. The sweep auger will move rapidly around the bin when the bin is nearly empty.

Stay clear of the under floor unloader at the bin wells. The underfloor unloader is exposed at these locations in the bin floor.

SHUTDOWN

NORMAL SHUTDOWN

Make certain that the bin well slide gates are closed to permit the unloading tube to clean out before stopping the unit. Before the operator leaves the work area, the power source shall be locked out.

EMERGENCY SHUTDOWN

Should the auger be immediately shutdown under load, disconnect and lockout the power source. Close the bin wells.

NOTE: Starting the unit under load may result in damage to the auger. Such damage is considered abuse of the equipment.

Reconnect power source and clear auger gradually.

Whenever you must service or adjust your equipment, make sure to stop motor and lockout your power source!

LOCKOUT

If the operator must leave the work area, or whenever servicing or adjusting, the bin unloading auger must be stopped and the power source turned off. Precaution should be made to prevent anyone from operating the auger when the operator is absent from the work area.

IMPORTANT: Use a main power disconnect switch capable of being locked only in the off position.

OPERATING PROCEDURES

CLEAN-UP

1. Check to see that all guards listed in the assembly instructions are in place and secured and functional.
2. Check all safety signs and replace any that are worn, missing or illegible. The safety signs are listed in the parts section of this manual. Safety signs may be obtained from your dealer or ordered from the factory.

LUBRICATION

1. Lubricate the sweep universal joint each time the grain bin has been emptied.
2. The gearboxes in the center bin well are lubricated at the factory. Check the oil level by removing the plug in the side of the gearboxes. The oil must be up to the plug level. Check oil level each time the bin has been emptied. Use SAE 90 weight multipurpose gear oil.
3. Add two ounces of multi-purpose gun grease to the sweep end wheel drive chains during assembly and each time the bin has been emptied.

Never clean, adjust or lubricate a machine that is in operation.

TROUBLE SHOOTING

AUGER VIBRATION...
Driving belt may be overtightened, putting head stub and drive shaft in a bind.

LOW CAPACITY...
The unloading auger may not be getting enough grain. The bin well may have bridged over, restricting flow.

The center well gate may not be open enough.

Check auger speed. Speeds slower than the recommended speed will result in low capacity.

PLUGS...
The unloading auger may be getting too much grain, causing “jamming” inside the housing. Close the center well gate appropriately to restrict flow.

The drive motor may be too small or wired improperly.

Assure the auger is free of foreign material, such as sacks, tarp corners, etc. A plug of the discharge end of the auger will cause an unload auger plug.

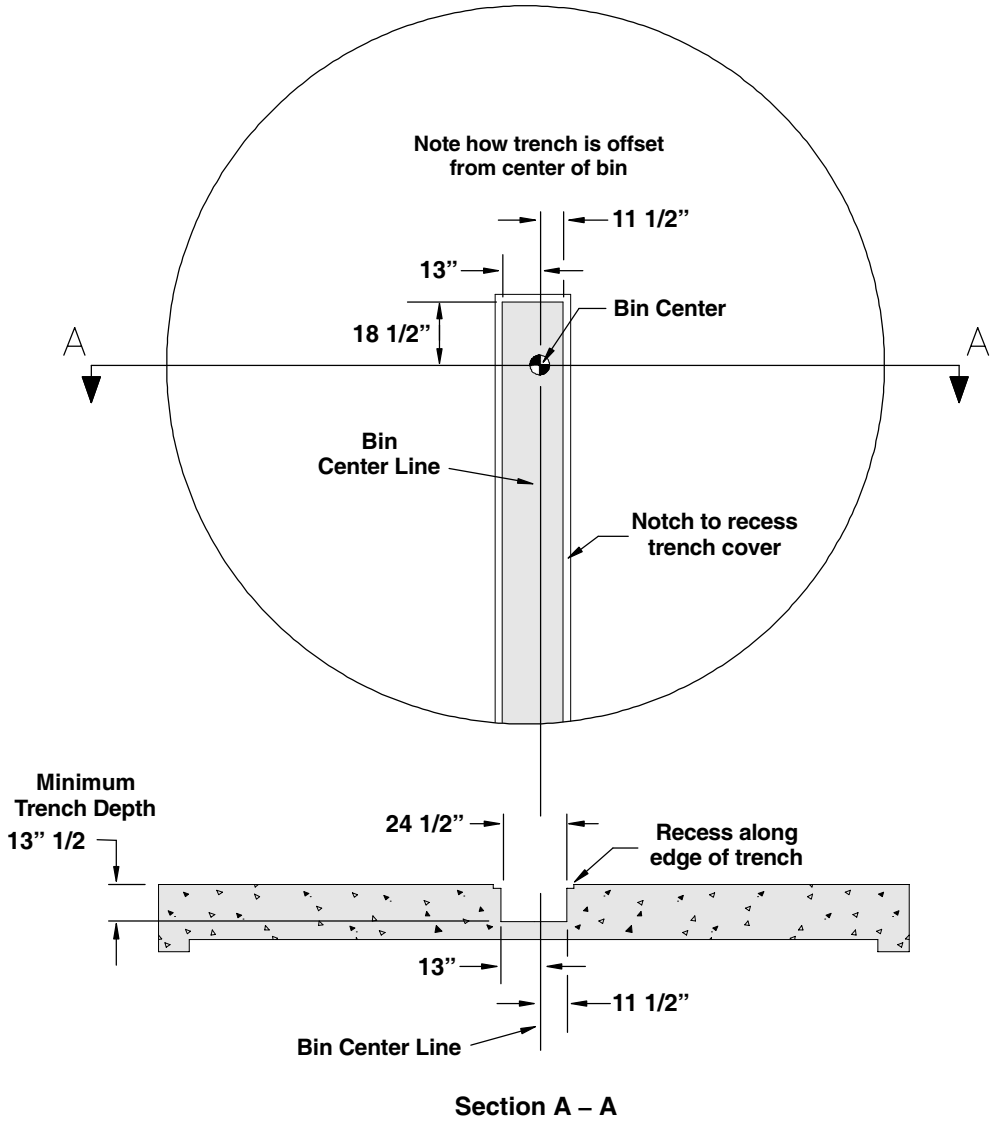
SWEEP FLIGHT AND BACK SHIELD NOT MOVING...
Check clearance between back shield and bin floor for excessive drag. Adjust shield up to clear metal floor splices or cracks in concrete floors.

Check the sweep wheel. After extensive use, the wheel material may have worn down to where the wheel diameter is no longer large enough to move the sweep properly. Order replacement wheel or wheel parts from your dealer or the factory.

The grain may have gone out of condition due to moisture or insect activity and has become hard or caked. Stop the sweep auger and lock out the power before entering the bin to correct this or any other problem requiring bin entry.

CONCRETE TRENCH LAYOUT POWER SWEEPS

Concrete should not be poured around the unloading auger components. For installation of augers into grain bins with concrete floors, a pre-formed trench should be made in the floor that will accept the auger, wells and controls, See Fig. 10 for minimum trench dimensions and relative position of the trench to the center of the bin.



Section A – A

FIG. 10

NOTE: The off-set design of the center well requires that the trench be off-set also, so that the vertical shaft between the gearboxes is located in the center of the bin.

A recess should be formed around the outer top of the trench for material used to cover the trench. The depth required for this recess depends on thickness of material used to cover the trench. One fourth inch thick steel plate is often used.

UNLOADING AUGER AND BIN WELLS

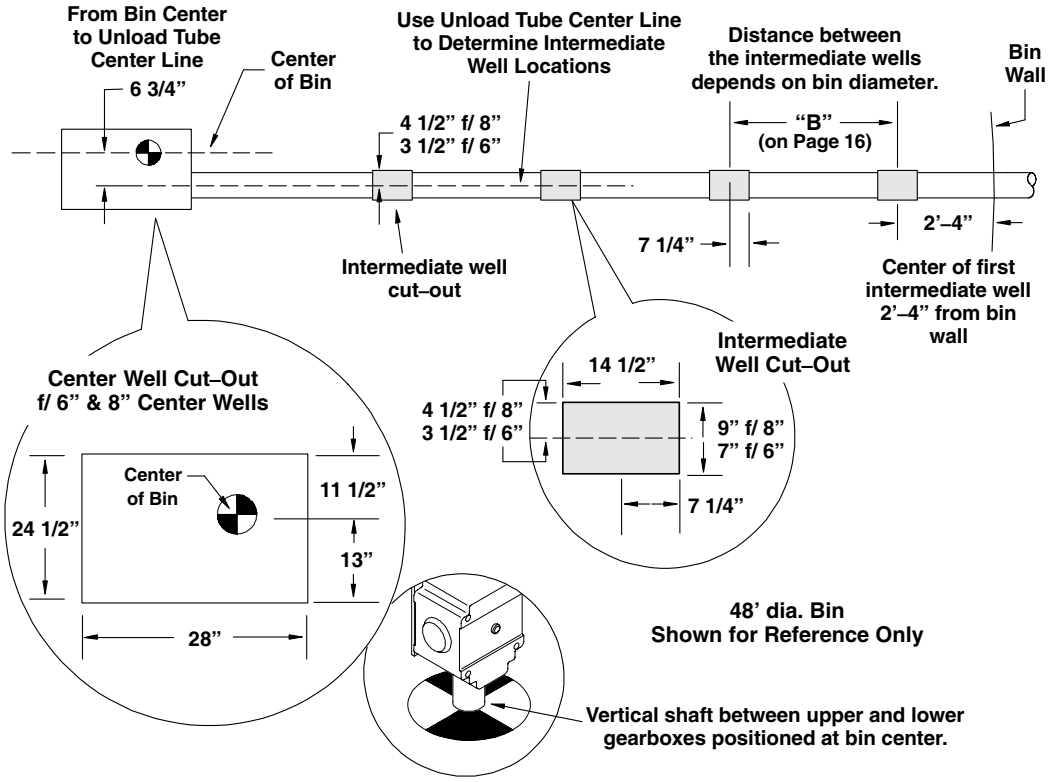
For bins with raised metal floors, it is necessary to cut openings in the floor for the center well and intermediate wells. Make sure the metal floor is at least 13" above the concrete base so there is space for the wells.

It will be convenient to complete assembly of the bin floor as the unloading auger is being installed for better access to components under the floor.

1. Locate the center of the bin and make a cut-out in the bin floor for the center well (See Figure 11). When positioning the center bin well into place, locate the vertical shaft from the top gearbox at bin center.

   Place suitable supports under the center well to hold it in position.

TOP VIEW OF CUT-OUTS FOR CENTER AND INTERMEDIATE WELLS IN BIN FLOOR



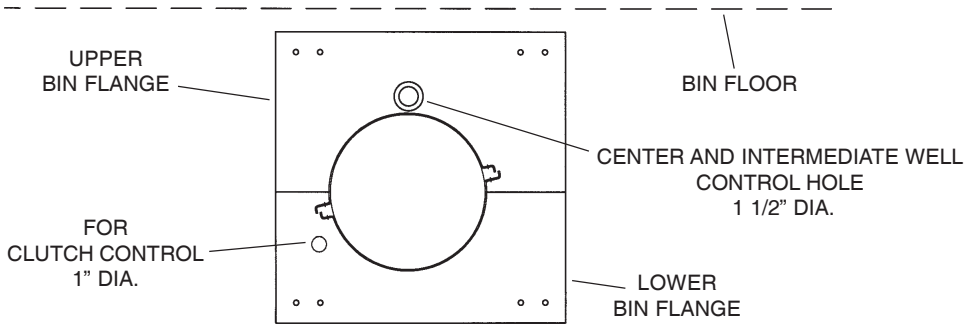
The distances between the bin wall, the intermediate well(s) and the center well should all be equal. Different diameter bins may require more than one intermediate well.

Refer to Figure 14 and the Chart on Page 16 for correct measurements.

FIG. 11

UNLOADING AUGER AND BIN WELLS - CONT.

2. Use the bin flange as a template to locate and mark the opening's to be cut out of the bin wall for the unloading tube, the center and intermediate well control pipes, and the clutch control pipe (locate the tube opening the same distance below the floor as the auger tube connection on the center well).
   A. After marking the appropriate locations, cut an opening through the bin wall for the unloading tube.
   B. Cut a 1 1/2" dia. hole for the center and intermediate well control pipes (See Figure 12).
   C. Cut a 1" dia. hole for the clutch control rod, located on the lower right of the flange (See Figure 12).



Locate unloading tube hole the same distance below the floor as the auger tube connection on the center bin well.

FIG. 12

3. Slide the unloading tube through the bin wall and connect tube to the center bin well. Secure using a 12" long connecting band, 5/16 x 1 1/2" bolts and locknuts. The unloading tube should be tight against the tube extending from the center well.

Attach the bin flange to the auger tube as shown in Fig. 13. Loosely secure the bin flange using two (2) 5/16 x 1 1/2" bolts and locknuts (tighten only enough to allow the flange to slide on the tube).

Position the flange against the bin wall and using the existing holes in the flange as a template, drill an 11/32" dia. hole at each of the four corners.

Slide the flange against the bin wall and insert a 5/16 x 1 1/2" bolt through the two lower corners. Position the Decal Plate on the upper section of the bin flange and insert two 5/16 x 1 1/2" bolts through the plate, the flange and bin wall. Secure the four bolts using the locknuts provided.

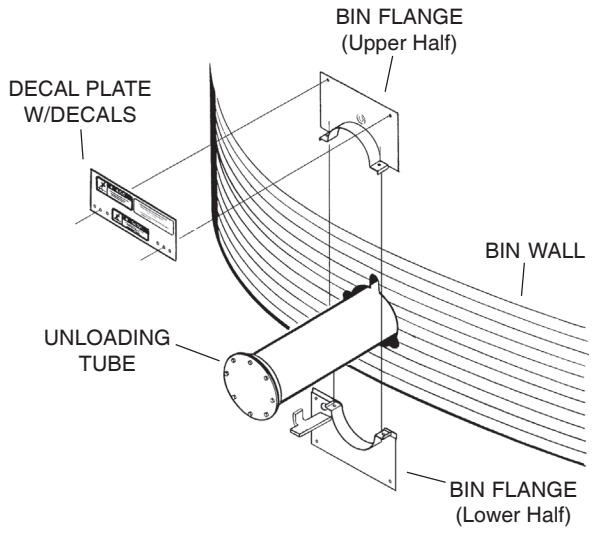


FIG. 13

ASSEMBLY INSTRUCTIONS

UNLOADING AUGER AND BIN WELLS - CONT.

4. Cut openings in the bin floor for the intermediate wells (See Fig. 11 on Page 14). The number of wells depends on bin size. The distances between the bin wall and the intermediate wells and the center well should be equal (See Chart and Fig. 14 below).

   Place the intermediate wells directly over the unloading tube. Mark the tube and cut openings in the tube for each well. Leave at least 1/2" of tube extending inside the well on all four sides. Make sure the inside of the tube is smooth where the cuts are made and retrieve all pieces of the cut material from inside the tube.

   Make sure the intermediate wells are positioned so the gate opens toward the bin wall. Place the support material under the unloading tube at each bin well.

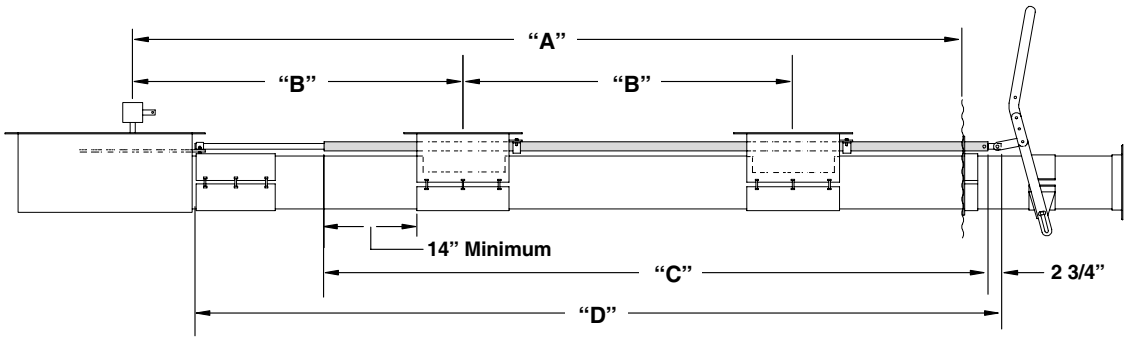
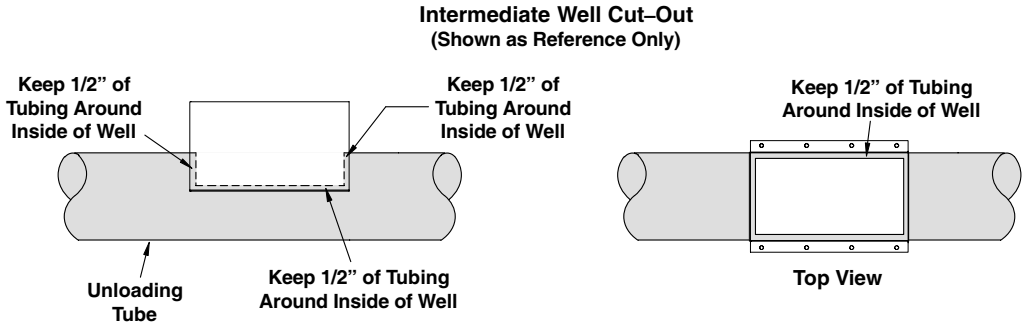


FIG. 14



Bin Diameter	Number of Intermediate Wells	Distance from Center of Bin to Wall (A)	Distance Between Wells (B)	Length of Int. Well Control Pipe (C)	Length of Center Well Control Pipe (D)	Length of Clutch Control Pipe (Not Shown)
15 ft	1	7'–6"	3'–9"	5'–9"	7'–0"	10'–0"
18 ft	1	9'–0"	4'–6"	6'–6"	8'–6"	11'–6"
21 ft	2	10'–6"	3'–6"	9'–0"	10'–0"	13'–0"
24 ft	2	12'–0"	4'–0"	10'–0"	11'–6"	14'–6"
27 ft	2	13'–6"	4'–6"	11'–0"	13'–0"	16'–0"
30 ft	2	15'–0"	5'–0"	12'–0"	14'–6"	17'–6"
33 ft	3	16'–6"	4'–1 1/2"	14'–5"	16'–6"	19'–6"
36 ft	3	18'–0"	4'–6"	15'–6"	17'–6"	20'–6"
39 ft	3	19'–6"	5'–0"	16'–5"	19'–0"	22'–0"
42 ft	4	21'–0"	4'–3"	19'–0"	20'–6"	23'–6"
48 ft	4	24'–0"	5'–2"	21'–2"	23'–6"	26'–6"

UNLOADING AUGER AND BIN WELLS - CONT.

5. Once all wells have been properly positioned and installed, slide the "unloading flight" **(squared end towards center of bin)** into the unloading tube connecting it to the drive shaft on the center bin well gearbox.

   The flight will align itself with the tapered end of the drive shaft, although it may be necessary to rotate the flight a little in order to align the squared ends.

6. Attach the intermediate bin well gate(s) to the 1 3/8" O.D. control pipe:

   A. Shut the intermediate bin well gate(s).

   B. Check length of control pipe by sliding it into place.

   C. Drill a 3/8" dia. hole through one side of the 1 3/8" O.D. control pipe. The dimple of the control gate clamp will fit into this hole when clamped to the control gate.

   D. Fasten the control gate clamp to the control gate and control pipe. Secure in place using two (2) 5/16" x 1" long bolts, lock washers and nuts (See Fig. 15).

   For intermediate bin wells welded to the unloading tube (See Fig. 15A), adjust location of gate on control pipe by using the setscrew in the collar. Make sure setscrew is tightened when finished.

INTERMEDIATE BIN WELL CONTROL GATE

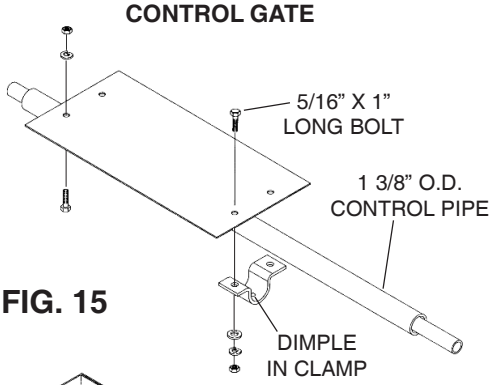


FIG. 15

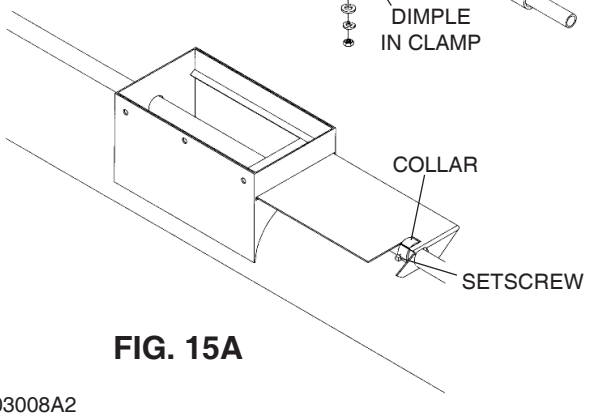


FIG. 15A

7. Attach the center well gate(s) to the 7/8" O.D. control pipe:

   A. Shut the center control gate.

   B. Check length of control pipe by sliding it through the control pipe of the intermediate well(s). When the control pipe is fastened to the control gate clamp, the center well control pipe should extend past the intermediate well control pipe a minimum of 2 3/4" (See Fig. 14 on Page 16).

   C. Attach the control gate to the control pipe by sliding a 5/16" x 1 3/4" roll pin through the clamp and control pipe.

   D. Fasten clamp to top side of control gate using two (2) 5/16" x 3/4" carriage bolts, flat washers, lock washers and nuts. Install the nuts so they secure the roll pin in place (See Fig. 16).

CENTER BIN WELL CONTROL GATE

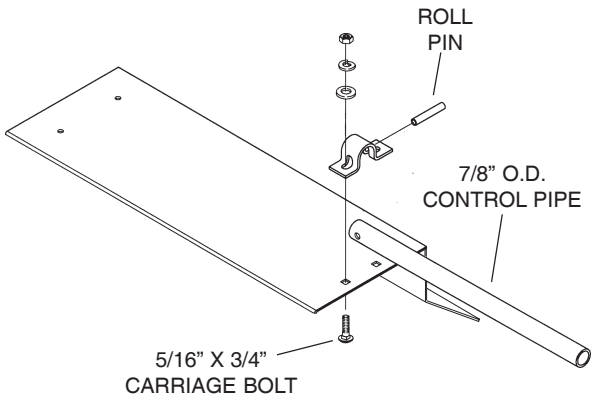


FIG. 16

UNLOADING AUGER AND BIN WELLS - CONT.

6” and 8” Augers

8. Install control lever assembly onto the unloading tube (See Fig. 17).
   A. Attach “control rod pull bar” to the unloading auger housing using the 8” x 2” wide half-bands and 5/16 x 1 1/2” bolts and locknuts, **insert bolts from bottom and install nuts on top** (the bands need to be rotated as shown in the orientation detail below, note that when rotated, the edge of the pull bar is 1/4” above the top of the tube). Position edge of half-band 4” from bin flange as shown below.
   B. Install the control rod handle by inserting the bent end through the notched slot in the pull bar (the bent end of the handle should point away from the unloading tube). Slide the pivot tube attached to the handle, over the 7/8” control pipe and secure using two 5/16 x 1 1/2” bolts and locknuts (the bolts will pass through the sides of the control pipe with the pivot tube sandwiched between them).
   C. Store lynch pin in extra hole on control lever. When it is necessary to open the intermediate bin well gate(s), the lynch pin will need to be installed through the holes in the intermediate and the center well control pipes. Check gate operation by separately pulling on the control pipes, control gates should slide freely.

6” and 8” Augers

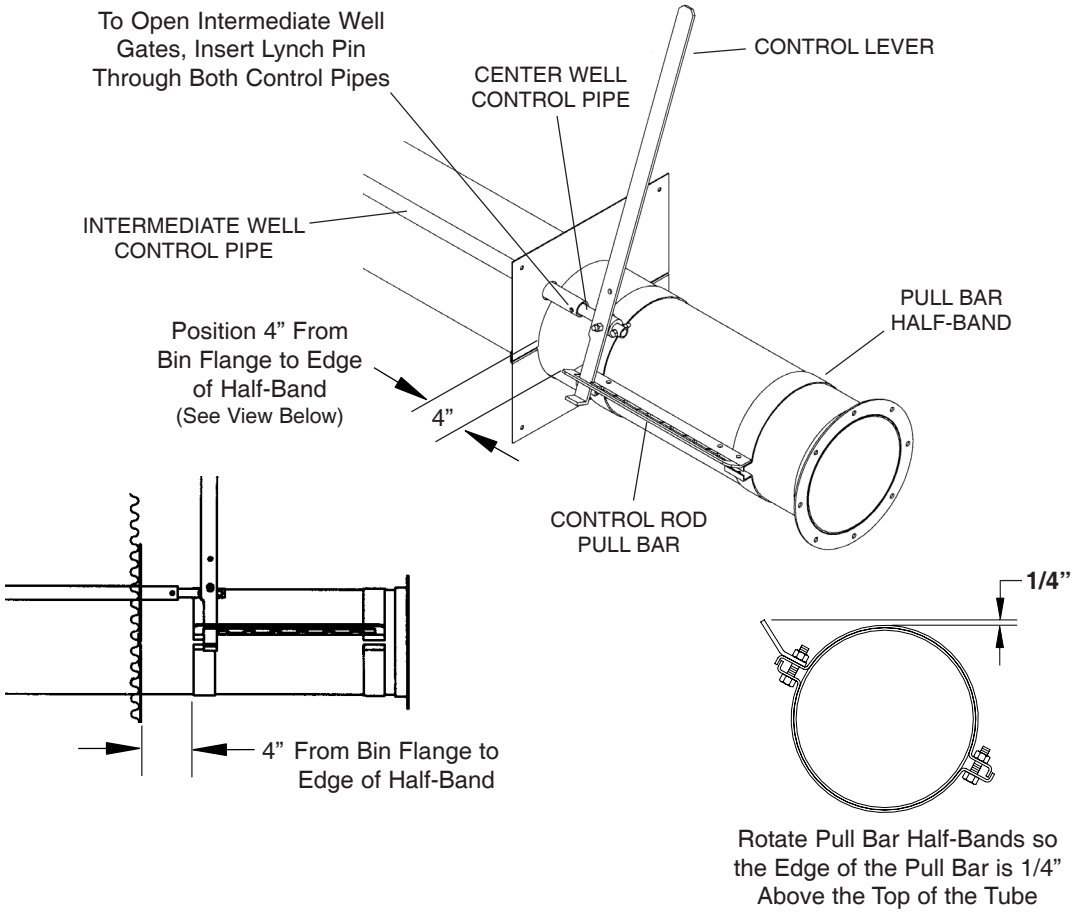
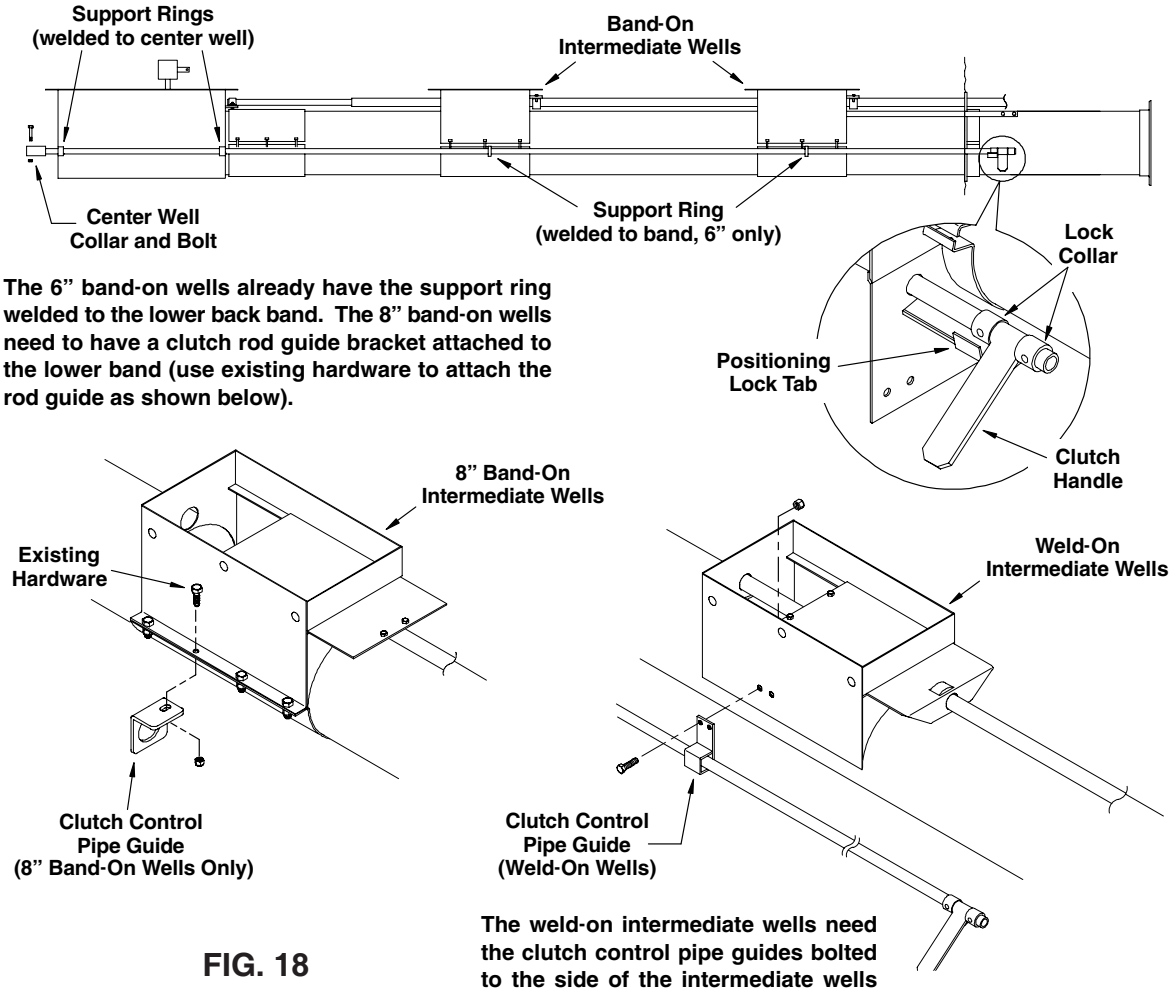


FIG. 17

UNLOADING AUGER AND BIN WELLS - CONT.

9. Install control pipe for clutch to center well (See Fig. 18).
   A. For intermediate bin wells that are welded to the unloading housing, bolt the clutch control pipe brackets to the well using two 5/16" x 3/4" bolts and nylon locknuts. For band-on intermediate wells, the 6" wells already have a clutch guide support ring welded to the bottom half-band. The 8" band-on wells use a clutch guide bracket that is bolted onto the bottom half-band. Use the existing hardware from the half-band to attach the bracket to the bottom side of the flange (the bracket can be attached to any one of the existing bolts, See Fig. 18 below).
   B. Slide the clutch control pipe through the bin flange and the support rings (or control pipe brackets) on the intermediate and center wells. Slide control pipe into the collar at the bottom rear of the center well.
   C. Bolt control pipe to the collar using a 5/16" x 1 1/2" bolt, lockwasher and non-lock nut.
   D. Attach clutch control handle to outer end of the clutch control rod by installing a lock collar on both sides of the handle. Pull clutch control rod to fully engage the clutch in the center well, then position the control handle on the outside of the position lock tab and tighten the lock collars on both sides of the handle.
   E. Check operation of clutch by pulling the handle to engage the clutch and then pushing the handle to disengage. Control pipe should slide freely. Lock control pipe into the engaged or disengaged position by positioning the handle on the appropriate side of the positioning lock tab (See Fig. 18).

6" and 8" AUGERS



The 6" band-on wells already have the support ring welded to the lower back band. The 8" band-on wells need to have a clutch rod guide bracket attached to the lower band (use existing hardware to attach the rod guide as shown below).

The weld-on intermediate wells need the clutch control pipe guides bolted to the side of the intermediate wells (both 6" & 8" augers).

FIG. 18

ASSEMBLY INSTRUCTIONS

SWEEP FLIGHT AND BACK SHIELD

10. Assemble the flight and shield to the sweep wheel (See Fig. 19). **(Note: if there are three (3) sections of flights and shields, the shield that measures 86 1/4" long MUST be placed in the middle).**

    Add a multi-purpose grease to the sweep wheel drive enclosure (See "Lubrication" Section on Page 12).

    A. Slide bushing (Ref. No. 2 in Fig. 19) onto the sweep wheel stub so that the hole in the bushing is closest to the wheel (align the bushing with the slot in the wheel stub).

    B. Slide the flight (Ref. no. 3) onto the bushing and sweep wheel stub. Note the two holes at the end of the flight shaft, using the hole closest to the end of the flight, bolt the flight, bushing and wheel stub together using a 3/8" x 2 1/2" bolt and nylon locknut.

    C. Fasten the shield (Ref. No. 4) to the sweep wheel using four (4) 5/16" x 3/4" bolts, flat washers and nylon locknuts.

11. If your sweep has more than one section, bolt sections of shields and flights together as follows:

    A. Install the flight stub (Ref. No. 6) into the end of the flight previously attached to the sweep wheel. Secure using two (2) 7/16" x 2 1/2" bolts and nylon locknuts for 6" Power Sweeps, or two (2) 1/2" x 3" bolts and nylon locknuts for 8" Power Sweeps.

    B. Slide the shield bearing hanger (Ref. No. 7) onto the flight stub and bolt the next section of flight to the stub using two (2) 7/16" x 2 1/2" bolts and nylon locknuts for 6" Power Sweeps, or two (2) 1/2" x 3" bolts and nylon locknuts for 8" Power Sweeps.

    C. Use four (4) 5/16 x 3/4" bolts, flat washers and nylon locknuts in the top and outside holes of the shield splice (Ref. No. 5) to attach it to the end of the shield previously bolted to the sweep wheel (the splice will mount to the auger side of the shield). Place the next length of shield on top of the splice and align the mounting holes, secure using four (4) 5/16" x 3/4" bolts, flat washers and nylon locknuts.

    D. Install the the shield bearing hanger bracket (Ref. No. 7) to the auger side of the shields and secure using four (4) 5/16 x 1" bolts, flatwashers and nylon locknuts.

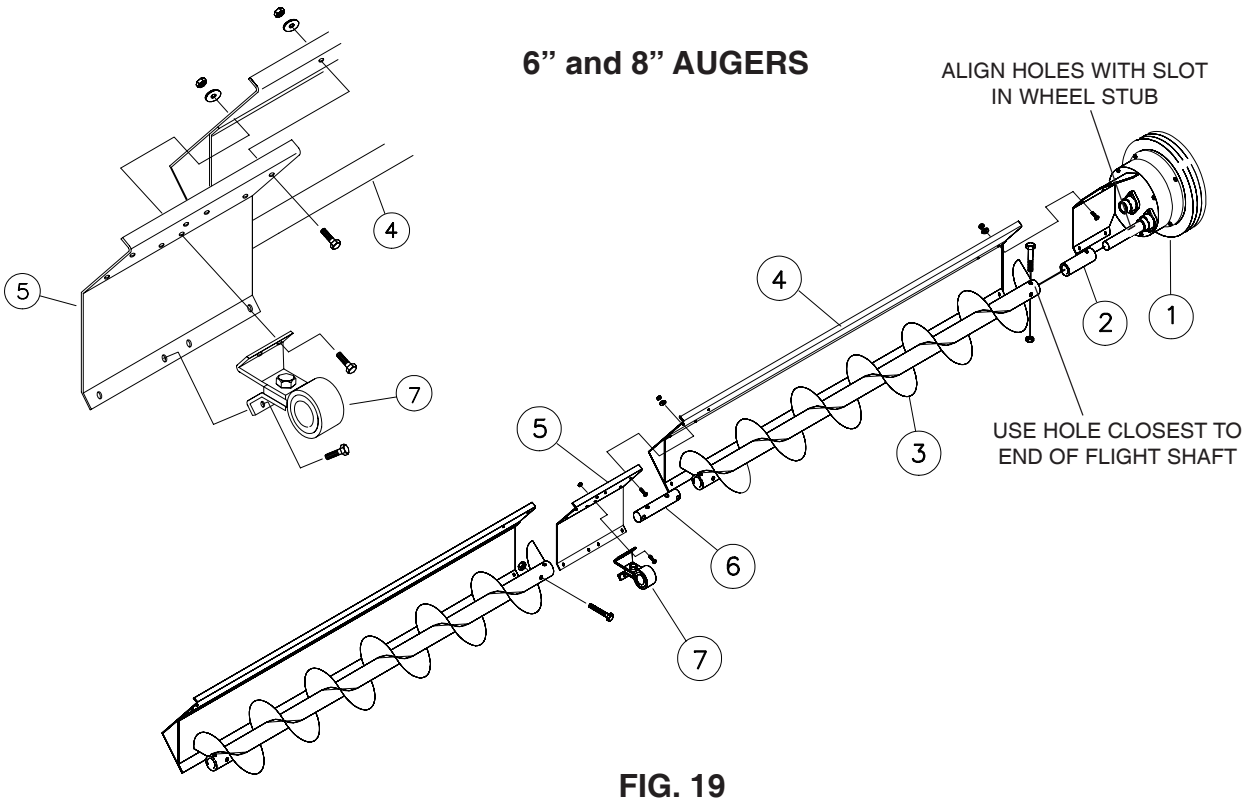


FIG. 19

SWEEP FLIGHT AND BACK SHIELD - CONT.

12. Attach the sweep shields and flight to the center well gearbox (See Fig. 20).

    A. Attach the sweep shield pivot bracket to the bracket mounted on the gearbox using one (1) 5/8 x 1 1/2" bolt and nylon locknut (the pivot bracket will mount to the outside of the gearbox bracket).

    B. Align the sweep flight with the stub on the gearbox and at the same time, position the sweep shield over the pivot bracket (the bracket will be positioned on the auger side of the sweep shield). Determine if adjustment is needed for the flight and shield to properly align with their respective mounting holes (the flight coupler at the sweep wheel end is slotted for adjustment, the pivot bracket has two sets of holes to assist with adjustment as well).

    C. Bolt the sweep shield to the pivot bracket using four (4) 3/8" x 1 1/4" carriage bolts, flat washers and nylon locknuts (the bolts will pass through from the auger side).

    Bolt the sweep flight to the gearbox stub using two (2) 7/16" x 2 1/2" bolts and nylon locknuts for the 6" Power Sweeps, or 1/2" x 3" bolts and nylon locknuts for the 8" Power Sweeps.

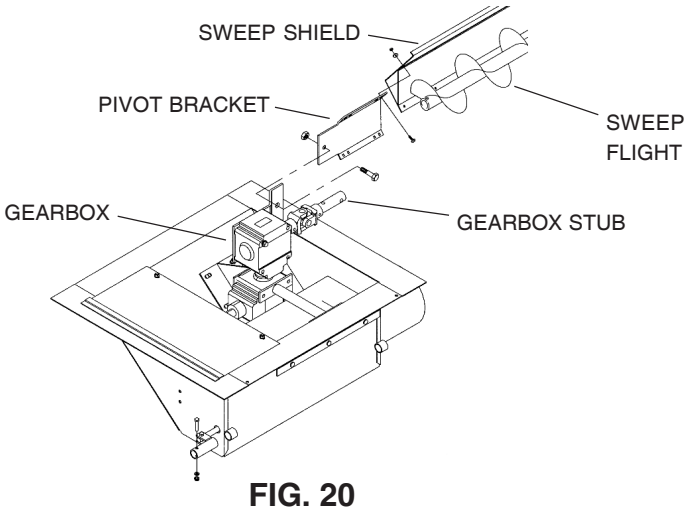


FIG. 20

13. If your sweep has multiple sweep sections, it will be necessary to create a "crown" at the mid-way point of the shields. After sweep shields have been installed, loosen the bolts on all shield splices and the bolt securing the pivot bracket to the gearbox.

    Place a spacer board under the shields at the mid-way point in order to achieve a 1" crown, then retighten the bolts (on 3 section sweep shields, the spacer board will be placed under the middle of the center shield, thus raising the entire length of the center shield to achieve the 1" crown).

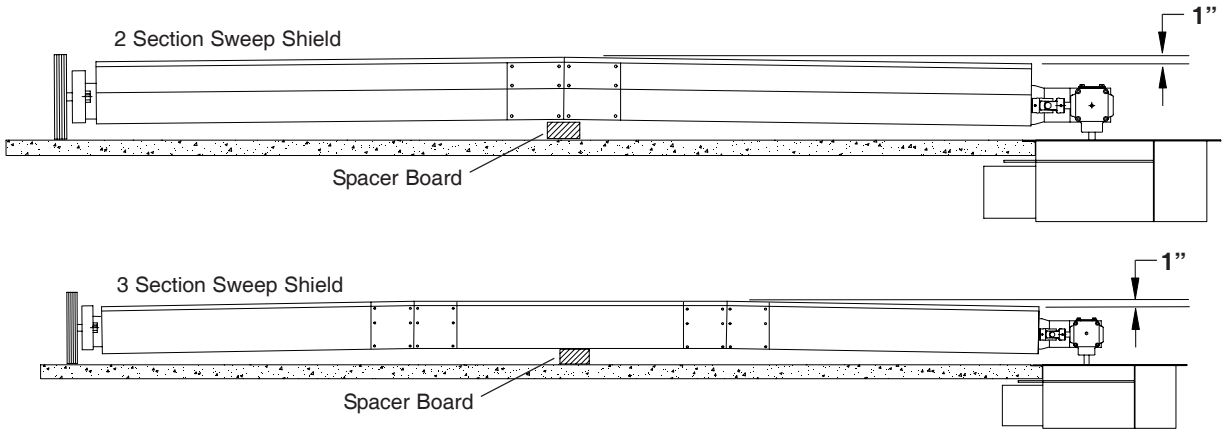


FIG. 21

BOLT KITS (WELD-ON WELLS, 6" AUGER)

BOLT KIT for 6" POWER SWEEP (1 SECTION - 1 WELL) with WELDED WELLS 15' to 18' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33151	Nut, non-lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	2	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	2	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	6	

BOLT KIT for 6" POWER SWEEP (1 SECTION - 2 WELLS) with WELDED WELLS 21' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33151	Nut, non-lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	4	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	6	

BOLT KITS (WELD-ON WELLS, 6" AUGER)

BOLT KIT for 6" POWER SWEEP (2 SECTIONS - 2 WELLS) with WELDED WELLS 24' to 30' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Binwell Gate Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
1002253	Bolt, 7/16-14 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	4	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	6	

BOLT KIT for 6" POWER SWEEP (2 SECTIONS - 3 WELLS) with WELDED WELLS 33' to 39' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	6	to Intermediate Well
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
1002253	Bolt, 7/16-14 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	6	

BOLT KITS (WELD-ON WELLS, 6" AUGER)

BOLT KIT for 6" POWER SWEEP (3 SECTIONS - 4 WELLS) with WELDED WELLS 42' to 48' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Binwell Gate Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	8	to Intermediate Well
33046	Bolt, 5/16-18 x 1" G5 PLT	8	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	16	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	24	
33023	Washer, flat 5/16 PLT	24	
1002253	Bolt, 7/16-14 x 3" G5 PLT	8	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	8	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	6	

BOLT KIT for 6" POWER SWEEP (1 SECTION) with BAND-ON WELLS

15' to 21' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	

BOLT KITS (BAND-ON WELLS, 6" AUGER)

BOLT KIT for 6" POWER SWEEP (2 SECTIONS) with BAND-ON WELLS

24' to 39' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
1002253	Bolt, 7/16-14 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	4	

BOLT KIT for 6" POWER SWEEP (3 SECTIONS) with BAND-ON WELLS 42' TO 48' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
1002253	Bolt HHCS 7/16-14 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33137	Nut, nylon lock, 7/16-14 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33046	Bolt, 5/16-18 x 1" G5 PLT	8	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	16	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	24	
33023	Washer, flat 5/16 PLT	24	
1002253	Bolt, 7/16-14 x 3" G5 PLT	8	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	8	

BOLT KITS (BAND-ON WELLS, 8" AUGER)

BOLT KIT for 8" POWER SWEEP (1 SECTION) with BAND-ON WELLS

15' to 21' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/2-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	

BOLT KIT for 8" POWER SWEEP (2 SECTION) with BAND-ON WELLS 24' to 39' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/2-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
33091	Bolt, 1/2-13 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33138	Nut, nylon lock 1/2-13 PLT	4	

BOLT KITS (BAND-ON WELLS, 8" AUGER)

BOLT KIT for 8" POWER SWEEP (3 SECTION) with BAND-ON WELLS 42' to 48' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/2-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33046	Bolt, 5/16-18 x 1" G5 PLT	8	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	16	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	24	
33023	Washer, flat 5/16 PLT	24	
33091	Bolt, 1/2-13 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33138	Nut, nylon lock 1/2-13 PLT	4	

BOLT KIT for 8" POWER SWEEP (1 SECTION - 1 WELL) with WELDED WELLS 15' to 18' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/2-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Well Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	2	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	2	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	8	

BOLT KITS (WELD-ON WELLS,8" AUGER)

BOLT KIT for 8" POWER SWEEP (1 SECTION - 2 WELLS) with WELDED WELLS 21' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/2-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Well Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	4	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	8	

BOLT KIT for 8" POWER SWEEP (2 SECTIONS - 2 WELLS) with WELDED WELLS 24' to 30' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/1-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	4	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	8	
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
1002253	Bolt, 7/16-14 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	4	

BOLT KITS (WELD-ON WELLS, 8" AUGER)

BOLT KIT for 8" POWER SWEEP (2 SECTIONS - 3 WELLS) with WELDED WELLS 33' to 39' BIN DIAMETERS

Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/1-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	6	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	6	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	8	
33046	Bolt, 5/16-18 x 1" G5 PLT	4	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	12	
33023	Washer, flat 5/16 PLT	12	
1002253	Bolt, 7/16-14 x 3" G5 PLT	4	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	4	

BOLT KIT for 8" POWER SWEEP (3 SECTIONS - 4 WELLS) with WELDED WELLS 42' to 48' BIN DIAMETERS

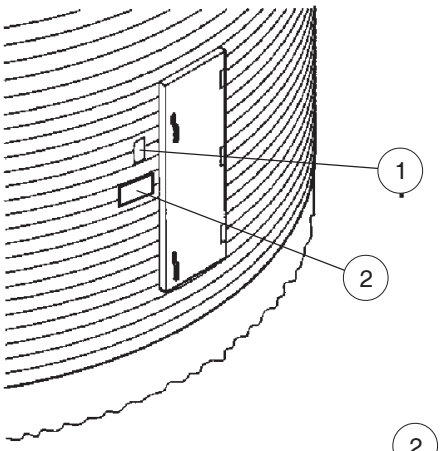
Part No.	Description	Qty.	Where Used
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	3	Connecting Band at Center Well
33151	Nut, non-lock, 5/16-18" PLT	3	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Flange Clamp Bands
33151	Nut, non-lock, 5/16-18" PLT	2	
1002245	Bolt, Carriage, 5/16-18 x 1 1/2" G5 PLT	4	Sweep Shield to Pivot Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
33276	Bolt HHCS 5/8-11 x 1 1/2" G5 PLT	1	Gearbox Bracket to Pivot Bracket
33139	Nut, nylon lock, 5/8-11 PLT	1	
33091	Bolt HHCS 1/1-13 x 2 1/2" G5 PLT	2	Sweep Flight to Gearbox Stub
33138	Nut, nylon lock, 1/2-13 PLT	2	
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	4	Pull Bar Bracket to Half-Band
33151	Nut, non-lock, 5/16-18" PLT	4	
1002238	Bolt, Carriage, 5/16-18 x 3/4" G5 PLT	2	Center Well Control Gate
33023	Washer, 5/16" flat PLT	2	to Control Pipe
33135	Nut, nylon lock 5/16-18 PLT	2	
33243	Pin, roll 5/16" x 1 3/4"	1	
1023968	Lock collar, 7/8" bore	2	Clutch Control Handle to Control Pipe
4736	Bolt, 5/16-18 x 1 1/2" HHCS G5 PLT	2	Bin Well Control Rod Handle
33135	Nut, nylon lock, 5/16-18" PLT	2	to Control Rod
1016747	Pin, lynch .312 - 1 3/4" LG PLT	1	Intermediate Control Pipe to Center Control Pipe
33375	Bolt HHCS 3/8-16 x 2 1/2" G5 PLT	1	Sweep Flight to Sweep Wheel Stub
33136	Nut, nylon lock, 3/8-16 PLT	1	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	4	Sweep Shield to Sweep Wheel Bracket
33023	Washer, 5/16" flat PLT	4	
33135	Nut, nylon lock 5/16-18 PLT	4	
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	Clutch Control Pipe Guide
33135	Nut, nylon lock 5/16-18 PLT	8	to Intermediate Well
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	8	End Cap to Auger Housing
33151	Nut, non- lock 5/16-18 PLT	8	
33046	Bolt, 5/16-18 x 1" G5 PLT	8	Sweep Shields to Splice Plate
4701-1	Bolt, 5/16-18 x 3/4" G5 PLT	16	and Bearing Assembly
33135	Nut, nylon lock 5/16-18 PLT	24	
33023	Washer, flat 5/16 PLT	24	
1002253	Bolt, 7/16-14 x 3" G5 PLT	8	Sweep Flights to Intermediate Stub
33137	Nut, nylon lock 7/16-14 PLT	8	

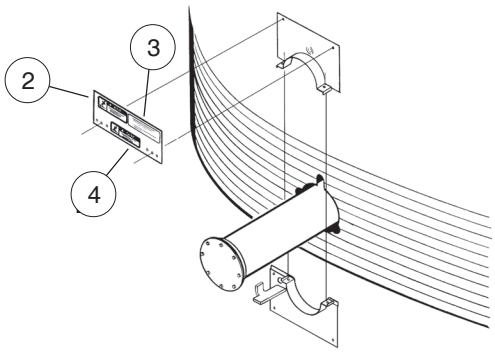
6” and 8” Sweep Auger
Parts List and Parts Identification Index

SAFETY DECALS

Check components as specified below to ensure that safety decals are present and in good condition. If a decal cannot be easily read for any reason or has been painted over, replace it immediately. Decals may be ordered through you dealer.

DANGER Decal's No's. 1002303 & 1002304 were supplied with the bin unloading equipment. These safety signs should be applied to the side of the bin near the bin opening, so they can be viewed by people entering into the bin or storage building.





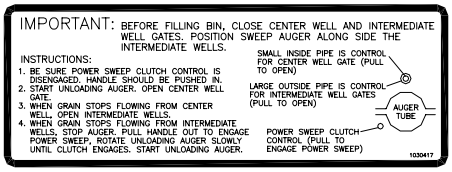
1

2

Decal No. 2 is also included with the Sweep Shields

3

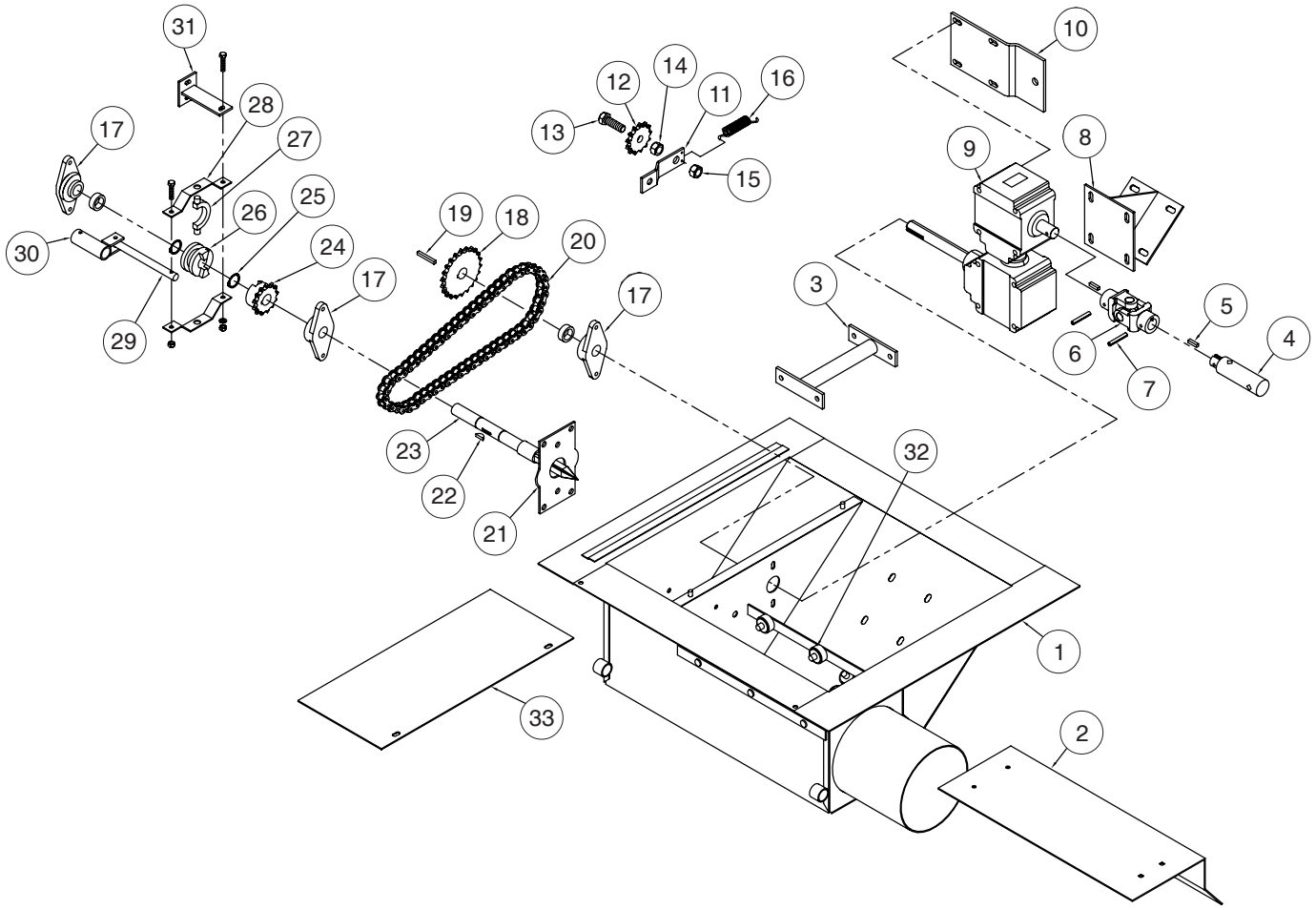
4



REF. #	PART #	DESCRIPTION	SIZE
1	1002303	DANGER - Rotating Flighting	4" x 7"
2	1002304	DANGER - Keep Out of Bin (Rapidly Traveling Sweep Auger)	1-3/4" x 7-1/2"
3	1002305	DANGER - Keep Out of Bin (Unloading Operations)	2-3/4" x 7-1/2"
4	1030417	IMPORTANT - Before Filling Bin, Close Center and Intermediate Wells	2-3/4" x 7-1/2"

PARTS LIST

CENTER WELL COMPONENTS



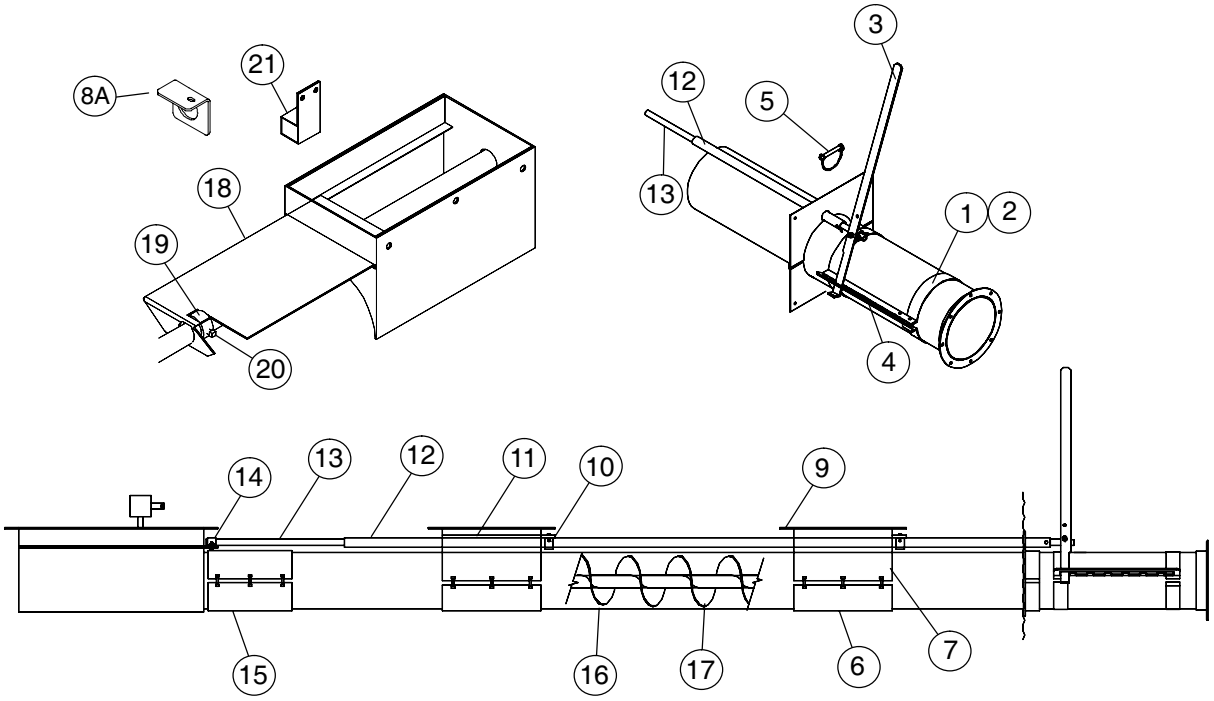
REF. #	PART #	DESCRIPTION
1	1030110	6” Power Well Weldment
(1)	1029970	8” Power Well Weldment
2	1030086	6” & 8” Slide Gate
3	6095A1	6” & 8” Inside Mount Brkt. for Gearbox
4	1016644	6” Stub for U-Joint
(4)	1016684	8” Stub for U-Joint
5	4020A1	Square Key, 1/4” x 1” long
6	1013677	Universal Joint, 1” to 1” (5” long)
7	6386C	Roll Pin, 5/16” x 2” long

CENTER WELL COMPONENTS - CONT.

REF. #	PART #	DESCRIPTION
8	1014766	6” & 8” Gearbox Mounting Bracket
9	1015211-3	Double Gearbox Assembly
10	1016619	6” Shield Bracket for gearbox
(10)	1016617	8” Shield Bracket for gearbox
11	1005850	Idler Sprocket Arm
12	6821P	Sprocket, 13 tooth Idler, #50 x 5/8" Bore
13	33244	Bolt, 5/8" x 2" long HHCS
14	D1170	Nut, 5/8" Non-lock
15	1005111	Nut, 5/8" Side Depress Lock
16	6823P	Spring for Idler Sprocket x 5" long
17	6818D	Bearing, 2 Hole Flange, 1" Bore w/Lock Collar
18	6331G	Sprocket, 22 tooth, #50 x 1" Bore
19	8371C	1/4" Square Key x 1-1/2" long
20	1015291	#50 Roller Chain x 44 Pitch (for 6” & 8”)
21	1030004	Bearing mount plate
22	8826G	Key, 1/4" x 1-1/4" long, #21
23	1030005	Clutch Shaft, 1" dia. x 14-5/8" long
24	6830P	Clutch Sprocket, 13 tooth, #50 x 1" Bore (for 6” & 8”)
25	420015	Retaining Ring, (IRR 4100-100)
26	6812P	Sliding Jaw Clutch
27	6828F	Clutch Yoke
28	6828P	Clutch Yoke Bracket
29	6827P	Clutch Control Rod, 5/8" dia. x 6-5/8" long
30	61641	Clutch Control Clevis
31	6826P	Clutch Bracket Weldment
32	51867	Nylon Roller (1 1/2” O.D.)
33	553411	Drive Cover Door

PARTS LIST

UNLOADING TUBE COMPONENTS



REF. #	PART #	DESCRIPTION
1	5048A1	Half Band, 6” galv. x 2” wide
2	5033A1	Half Band, 8” galv. x 2” wide
3	1022410	Control Lever Handle
4	1022413	Pull Bar Bracket
5	1016747	Lynch Pin
7	1030214	6” Intermediate Bin Well Wldmnt.
(7)	1036366	8” Intermediate Bin Well Wldmnt.
8	1014964	6” Back Band Wldmnt.
(8)	8806D	8” Back Band Wldmnt.
8A	1037453	Clutch Bracket (8” band-on only)
9	1015010	6” Top Flange
(9)	1014743	8” Top Flange
10	552406	Clamp f/Intermediate Well Gate
11	1030212	6” Intermediate Well Gate
(11)	1030009	8” Intermediate Well Gate
12	---	Control Rod (1 3/8” O.D.) f/Intermediate Well Gate
(12)	1016728	5’-9” long
(12)	1016960	6’-6” long
(12)	1016961	8’-5” long
(12)	1016729	10’-0” long
(12)	1016962	11’-0” long
(12)	1016963	12’-0” long
(12)	1016964	14’-5” long
(12)	1016965	15’-6” long
(12)	1016730	16’-5” long
(12)	1016731	19’-0” long
(12)	1016732	21’-2” long
13	---	Control Rod (7/8” O.D.) f/Center Well Gate
(13)	52155	7’-0” long
(13)	52156	8’-6” long
(13)	52157	10’-0” long
(13)	52158	11’-6” long
(13)	52159	13’-0” long
(13)	52160	14’-6” long
(13)	52161	16’-0” long
(13)	54393	16’-6” long
(13)	52162	17’-6” long
(13)	52163	19’-0” long
(13)	54394	19’-6” long
(13)	52164	20’-6” long
(13)	53845	21’-0” long
(13)	52165*	1’-0” long extension
(13)	52166*	2’-6” long extension
(13)	52167*	5’-6” long extension

Extensions are used with the 21’-0” control rod (Part # 53845) and require connector 41089.

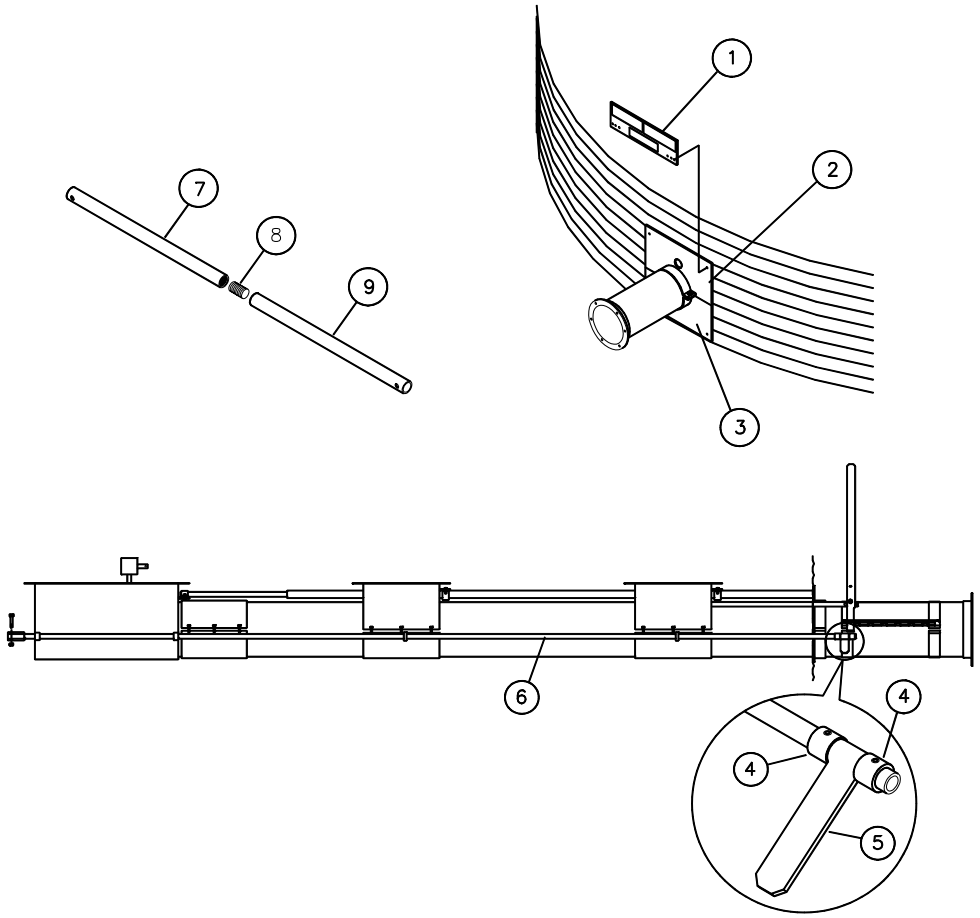
UNLOADING COMPONENTS - CONT.

REF. #	PART #	DESCRIPTION
14	50471A1	Clamp f/Center Well Gate
15	6815P	6” Connecting band x 12” long
(15)	8815P	8” Connecting Band x 12” long
16	---	**6” Unloading Tube (Band-on Wells)**
(16)	6377A91	Unloading Tube f/15’ Bin, 8’ long
(16)	6378A91	Unloading Tube f/18’ Bin, 10’ long
(16)	6379A91	Unloading Tube f/21’ Bin, 11’ long
(16)	6380A91	Unloading Tube f/24’ Bin, 12’-6” long
(16)	6381A91	Unloading Tube f/27’ Bin, 14’ long
(16)	6382A91	Unloading Tube f/30’ Bin, 15’-6” long
(16)	12156	Unloading Tube f/33’ Bin, 17’-6” long
(16)	6384A91	Unloading Tube f/36’ Bin, 18’-6” long
(16)	1030176	Unloading Tube f/39’ Bin, 20’-0” long
(16)	1030177	Unloading Tube f/42’ Bin, 22’-0” long
(16)	1030178	Unloading Tube f/48’ Bin, 25’-0” long
16	---	**8” Unloading Tube (Band-on Wells)**
(16)	6385A91	Unloading Tube f/15’ Bin, 8’ long
(16)	6386A91	Unloading Tube f/18’ Bin, 10’ long
(16)	6387A91	Unloading Tube f/21’ Bin, 11’ long
(16)	6388A91	Unloading Tube f/24’ Bin, 12’-6” long
(16)	6389A91	Unloading Tube f/27’ Bin, 14’ long
(16)	6390A91	Unloading Tube f/30’ Bin, 15’-6” long
(16)	11826	Unloading Tube f/33’ Bin, 17’-6” long
(16)	6392A91	Unloading Tube f/36’ Bin, 18’-6” long
(16)	6942A91	Unloading Tube f/39’ Bin, 20’ long
(16)	6393A91	Unloading Tube f/42’ Bin, 22’ long
(16)	6394A91	Unloading Tube f/48’ Bin, 25’ long
16	---	**6” Unloading Tube (Weld-on Wells)**
(16)	1030137	Unloading Tube f/15’ Bin, 8’ long
(16)	1030138	Unloading Tube f/18’ Bin, 10’ long
(16)	1030139	Unloading Tube f/21’ Bin, 11’ long
(16)	1030140	Unloading Tube f/24’ Bin, 12’-6” long
(16)	1030141	Unloading Tube f/27’ Bin, 14’ long
(16)	1030142	Unloading Tube f/30’ Bin, 15’-6” long
(16)	1030143	Unloading Tube f/33’ Bin, 17’-6” long
(16)	1030144	Unloading Tube f/36’ Bin, 18’-6” long
(16)	1030145	Unloading Tube f/39’ Bin, 20’-0” long
(16)	1030146	Unloading Tube f/42’ Bin, 22’-0” long
(16)	1030147	Unloading Tube f/48’ Bin, 25’-0” long
16	---	**8” Unloading Tube (Weld-on Wells)**
(16)	1030017	Unloading Tube f/15’ Bin, 8’ long
(16)	1030018	Unloading Tube f/18’ Bin, 10’ long
(16)	1030019	Unloading Tube f/21’ Bin, 11’ long
(16)	1030020	Unloading Tube f/24’ Bin, 12’-6” long
(16)	1030021	Unloading Tube f/27’ Bin, 14’ long
(16)	1030022	Unloading Tube f/30’ Bin, 15’-6” long
(16)	1030023	Unloading Tube f/33’ Bin, 17’-6” long
(16)	1030015	Unloading Tube f/36’ Bin, 18’-6” long
(16)	1030024	Unloading Tube f/39’ Bin, 20’ long
(16)	1030025	Unloading Tube f/42’ Bin, 22’ long
(16)	1030026	Unloading Tube f/48’ Bin, 25’ long

REF. #	PART #	DESCRIPTION
17	---	**6” Unloading Flight**
(17)	1030126	Unload Flight f/15’ Bin, 10’-3/4” lg
(17)	1030127	Unload Flight f/18’ Bin, 12’-3/4” lg
(17)	1030128	Unload Flight f/21’ Bin, 13’-3/4” lg
(17)	1030129	Unload Flight f/24’ Bin, 14’-6 3/4” lg
(17)	1030130	Unload Flight f/27’ Bin, 16’-3/4” lg
(17)	1030131	Unload Flight f/30’ Bin, 17’-6 3/4” lg
(17)	1030132	Unload Flight f/33’ Bin, 19’-6 3/4” lg
(17)	1030133	Unload Flight f/36’ Bin, 20’-6 3/4” lg
(17)	1030134	Unload Flight f/39’ Bin, 22’-3/4” lg
(17)	1030135	Unload Flight f/42’ Bin, 24’-3/4” lg
(17)	1030136	Unload Flight f/48’ Bin, 27’-3/4” lg
17	---	**8” Unloading Flight**
(17)	1029974	Unload Flight f/15’ Bin, 10’-3/4” lg
(17)	1029975	Unload Flight f/18’ Bin, 12’-3/4” lg
(17)	1029976	Unload Flight f/21’ Bin, 13’-3/4” lg
(17)	1029977	Unload Flight f/24’ Bin, 14’-6 3/4” lg
(17)	1029978	Unload Flight f/27’ Bin, 16’-3/4” lg
(17)	1029979	Unload Flight f/30’ Bin, 17’-6 3/4” lg
(17)	1029980	Unload Flight f/33’ Bin, 19’-6 3/4” lg
(17)	1029981	Unload Flight f/36’ Bin, 20’-6 3/4” lg
(17)	1029982	Unload Flight f/39’ Bin, 22’-3/4” lg
(17)	1029983	Unload Flight f/42’ Bin, 24’-3/4” lg
(17)	1029984	Unload Flight f/48’ Bin, 27’-3/4” lg
		Weld-On Intermediate Well Components
18	1018507	6” Intermediate Well Gate
(18)	1018218	8” Intermediate Well Gate
19	1018220	Collar for Control Pipe
20	1018221	Setscrew
21	1018216	Clutch Control Guide

PARTS LIST

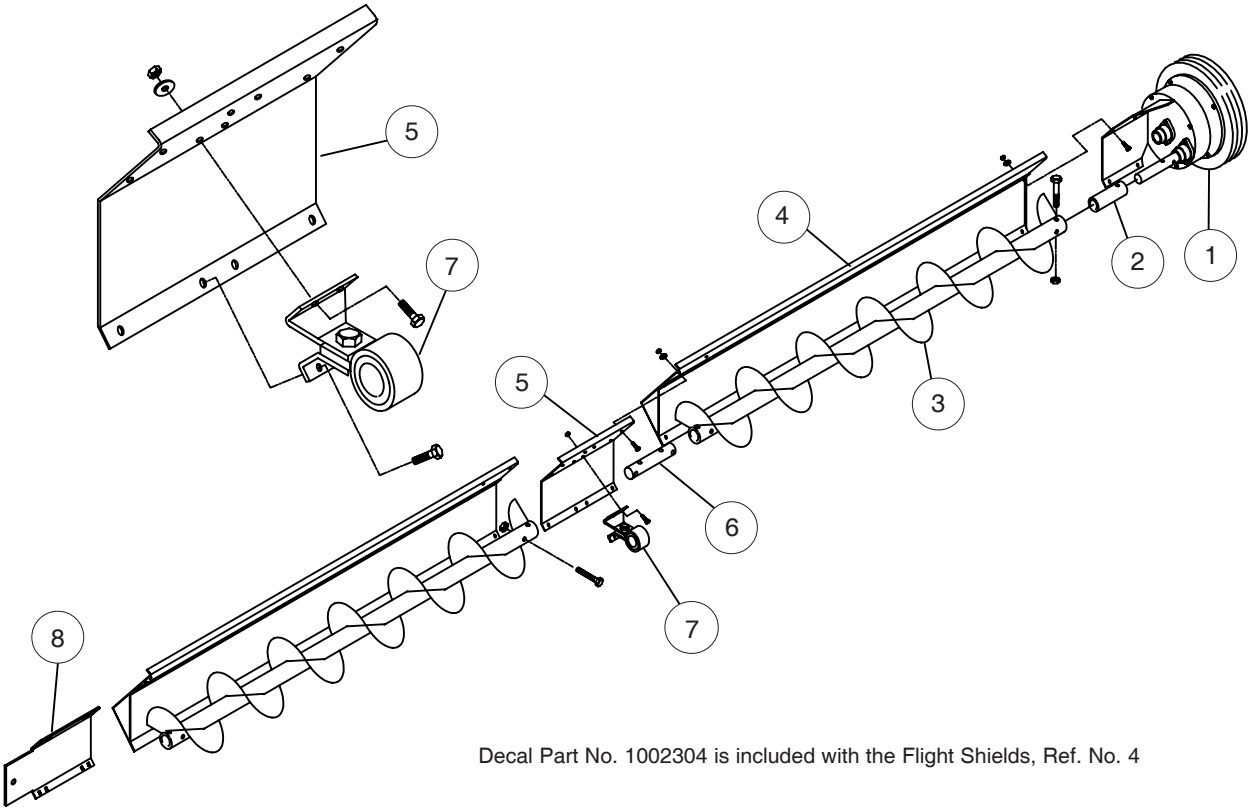
BIN FLANGE & CLUTCH CONTROL COMPONENTS



REF. #	PART #	DESCRIPTION
1	1030421	Decal Plate (See Page P-1 for Decals)
2	1030243	6” Upper Bin Flange
(2)	1030241	8” Upper Bin Flange
3	1030220	6” Lower Bin Flange
(3)	1030095	8” Lower Bin Flange
4	1023968	Control Pipe Lock Collar
5	1023974	Handle, Control Pipe
6	---	Clutch Control Pipe (7/8” O.D.)
(6)	52157	10’-0” long f/15’ Bin
(6)	52158	11’-6” long f/18’ Bin
(6)	52159	13’-0” long f/21’ Bin
(6)	52160	14’-6” long f/24’ Bin
(6)	52161	16’-0” long f/27’ Bin
(6)	52162	17’-6” long f/30’ Bin
(6)	54394	19’-6” long f/33’ Bin
(6)	52164	20’-6” long f/36’ Bin

REF. #	PART #	DESCRIPTION
7	53845	Control Pipe x 21’-0” long f/39’ - 48’ Bin
8	41089	Threaded Rod Connector
9	52165	Control Pipe x 1’-0” long f/39’ Bin
(9)	52166	Control Pipe x 2’-6” long f/42’ Bin
(9)	52167	Control Pipe x 5’-6” long f/48’ Bin
(9)	1018861	Control Pipe x 8’-6” long f/54’ Bin
(9)	1018862	Control pipe x 11’-6” long f/60’ Bin

SWEEP FLIGHT & SHIELD COMPONENTS



Decal Part No. 1002304 is included with the Flight Shields, Ref. No. 4

6" COMPONENTS

REF. #	PART #	DESCRIPTION
1	1030225	Enclosed Sweep Wheel Assy.
2	1015481	Bushing, Sweep Wheel Flight
3	1016749	Flight (4'-4" long)
(3)	1017692	Flight (5'-6" long)
(3)	5262H	Flight (5'-10" long)
(3)	1017696	Flight (7'-0" long)
(3)	1016750	Flight (7'-4" long)
(3)	1017701	Flight (8'-6" long)
(3)	5265H	Flight (8'-10" long)
4	1030195	Flight Shield w/decal (53 1/8" long)
(4)	1030196	Flight Shield w/decal (67 1/8" long)
(4)	1030197	Flight Shield w/decal (71 1/8" long)
(4)	1030198	Flight Shield w/decal (85 1/8" long)
(4)	1030199	Flight Shield w/decal (86 1/4" long)
(4)	1030200	Flight Shield w/decal (89 1/8" long)
(4)	1030201	Flight Shield w/decal (103 1/8" long)
(4)	1030202	Flight Shield w/decal (107 1/8" long)
5	1030222	Shield Splice Plate
6	8393C	Stub, 1 1/4" x 11 1/2" long
7	1030232	Shield Bearing Assy.
--	8379C	Bronze Bushing, 1 1/4" I.D.
8	1030221	Shield to Gearbox Attachment Plate

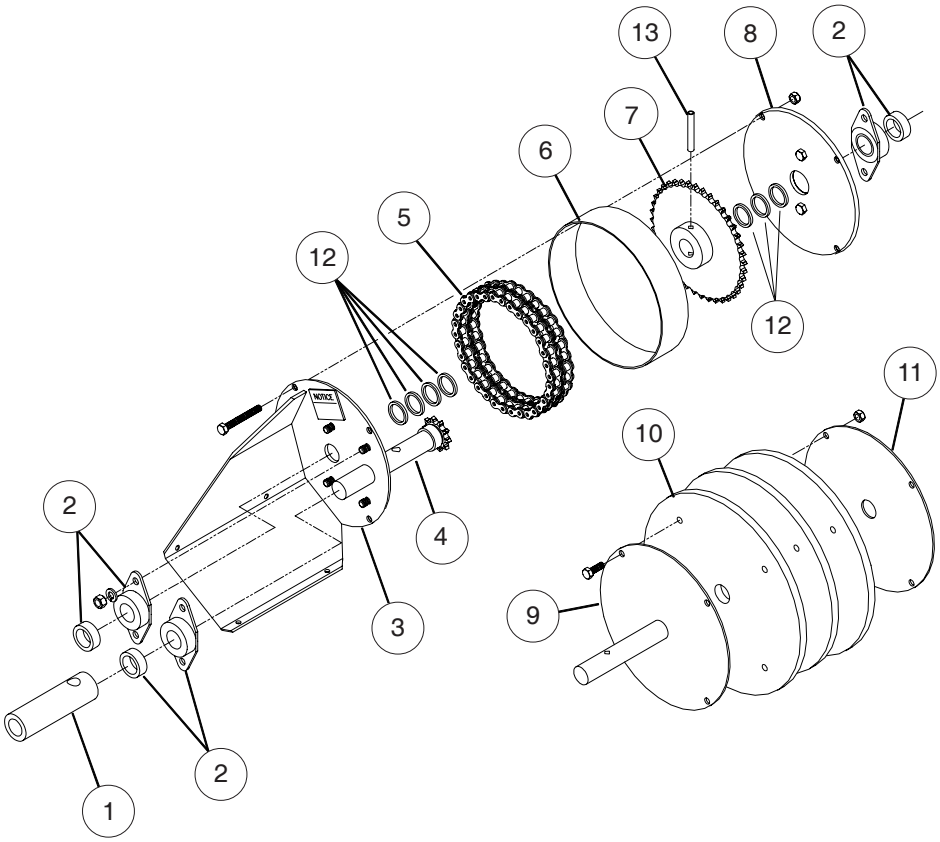
8" COMPONENTS

REF. #	PART #	DESCRIPTION
1	1030082	Enclosed Sweep Wheel Assy.
2	1015477	Bushing, Sweep Wheel Flight
3	1016708	Flight (4'-4" long)
(3)	1017705	Flight (5'-6" long)
(3)	1017607	Flight (7'-0" long)
(3)	1017709	Flight (8'-6" long)
(3)	5342H	Flight (5'-10" long)
(3)	1016622	Flight (7'-4" long)
(3)	5345H	Flight (8'-10" long)
4	1030060	Flight Shield w/decal (53 1/8" long)
(4)	1030061	Flight Shield w/decal (67 1/8" long)
(4)	1030062	Flight Shield w/decal (71 1/8" long)
(4)	1030063	Flight Shield w/decal (85 1/8" long)
(4)	1030064	Flight Shield w/decal (86 1/4" long)
(4)	1030065	Flight Shield w/decal (89 1/8" long)
(4)	1030066	Flight Shield w/decal (103 1/8" long)
(4)	1030103	Flight Shield w/decal (107 1/8" long)
5	1030045	Shield Splice Plate
6	1045D	Stub, 1 1/2" x 11 1/2" long
7	1030096	Shield Bearing Assy.
--	1051D	Bronze Bushing, 1 1/2" I.D.
8	1030042	Shield to Gearbox Attachment Plate

PARTS LIST

REDUCTION SWEEP WHEEL

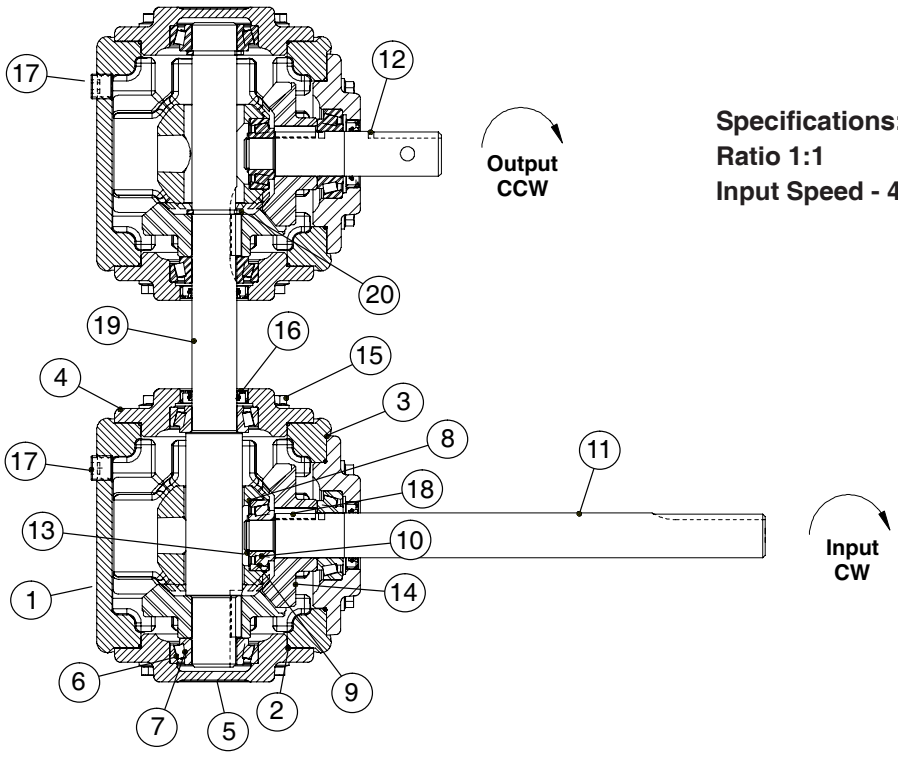
RATIO: 4 TO 1



REF. #	DESCRIPTION	6" WHEEL PART NO.	8" WHEEL PART NO.
1	Bushing, 1" I.D. x 1 1/4" O.D. x 4 3/8" long	1015481	N/A
(1)	Bushing, 1" I.D. x 1 1/2" O.D. x 4 3/8" long	N/A	1015477
2	Two-Hole Flange Bearing, 1" Bore	1015064	1015064
3	Inner Drive Housing	1030224	1030081
4	Sprocket/Shaft Weldment	1015106	1015106
5	#40 Double Roller Chain w/Link, 40 pitch	1015105	1015105
6	Housing Ring with 1/4" NPT zerk	1015051	1015051
7	Sprocket, #40 x 40 tooth	1015059	1015059
8	Outer Drive Housing	1030078	1030078
9	Inner Disk Plate	1030333	1030077
10	Rubber Disk, 11" O.D.	1014370	---
(10)	Rubber Disk, 13" O.D.	---	1017550
11	Outer Disk Plate	1015050	1017546
12	Washer, 1" Nominal x 10 ga.	035594	035594
13	Roll Pin, 5/16" x 2" long	6386C	6386C

GEARBOX

COMPLETE PART NO. 1015211-3



Specifications:
Ratio 1:1
Input Speed - 450 RPM's

Part No's. shown are Weasler Part No's.

Ref. No.	Part No.	Description
1	70-06072	Housing, Machined
2	28-21000	O-Ring
3	19-15203	Gasket Kit
4	70-16041	End Cap, Machined
5	70-16039	End Cap, Machined
6	12-20104	Bearing Cup (L44610)
7	12-20105	Bearing Cone (L44643)
8	19-15201	Shim Kit
9	12-20106	Bearing Cup (LM11710)
10	12-20107	Bearing Cone (LM11749)

Ref. No.	Part No.	Description
11	09-70024	Shaft, Input
12	09-70025	Shaft, Output
13	24-15249	Retaining Ring
14	71-06047	Gear, 19 teeth / DP6
15	11-20439	Bolt, 5/16-18 x 7/8" G5
16	28-11002	Seal (1.00 x 1.50 x .276)
17	11-81029	Pipe Plug, 1/4-18 NPT
18	11-61015	Key, 1/4" sq. x 0.92" long
19	09-70026	Shaft, Cross
20	24-15247	Retaining Ring

Order Weasler Parts at:
Weasler Engineering Inc.
P.O. Box 558
West Bend, WI 53095
ph: 262-338-2161

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