

H-Series Catwalk Installation

Supplement for GSI Stack Dryers Built
with Stiffeners

Instruction Manual

PNEG-1744

Date: **09-24-20**

G S I G R O U P



PNEG-1744

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1. Introduction

Please note that the original catwalk installation instructions (included in **CATM-01-5** and **CATH-01-5**) were written for Farm Fans (FFI) dryers supported with buttresses. This supplement contains catwalk installation instructions for dryers built with “stiffeners”. Please follow this supplement when installing a catwalk on a dryer with stiffeners. You will be referred back to the original manual when necessary. Please study the table included for specifications that are specific to your particular size of equipment. Install the catwalk on each module prior to lifting modules into place.

NOTES

Catwalk Support Assembly at Stiffener

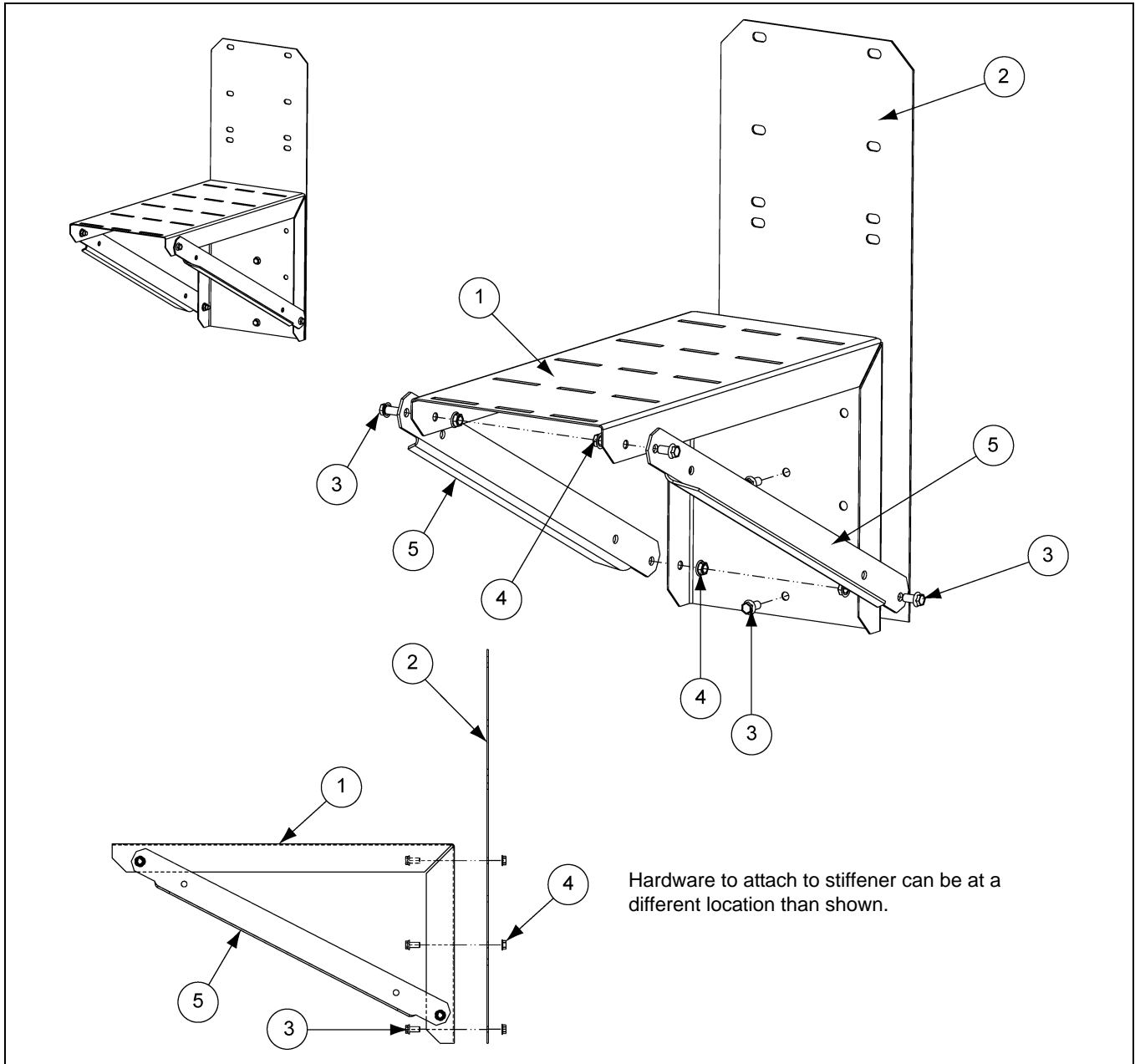


Figure 2A

Catwalk Support Assembly at Stiffener Parts List (D04-0499)

Ref #	Part #	Description	Qty
1	D01-2468	Support at Stiffener	1
2	D01-2469	Stiffener Adapter Plate	1
3	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	7
4	S-968	Flange Nut 3/8"-16 ZN Grade 5	7
5	401-4718-3	Brace at Stiffener	2

Dryer Catwalk Layouts

14' Long Dryer Catwalk Layout

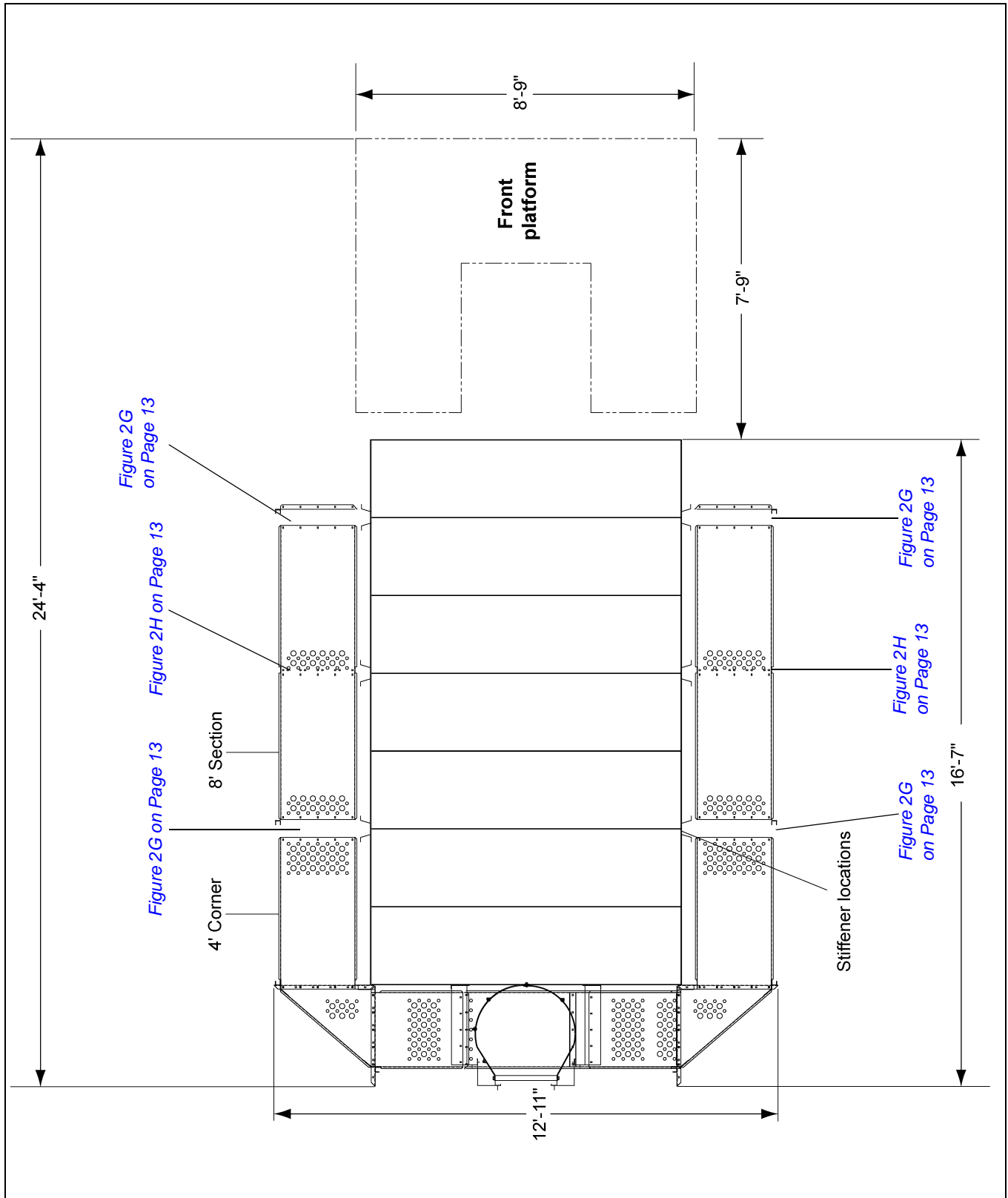


Figure 2B

18' Long Dryer Catwalk Layout

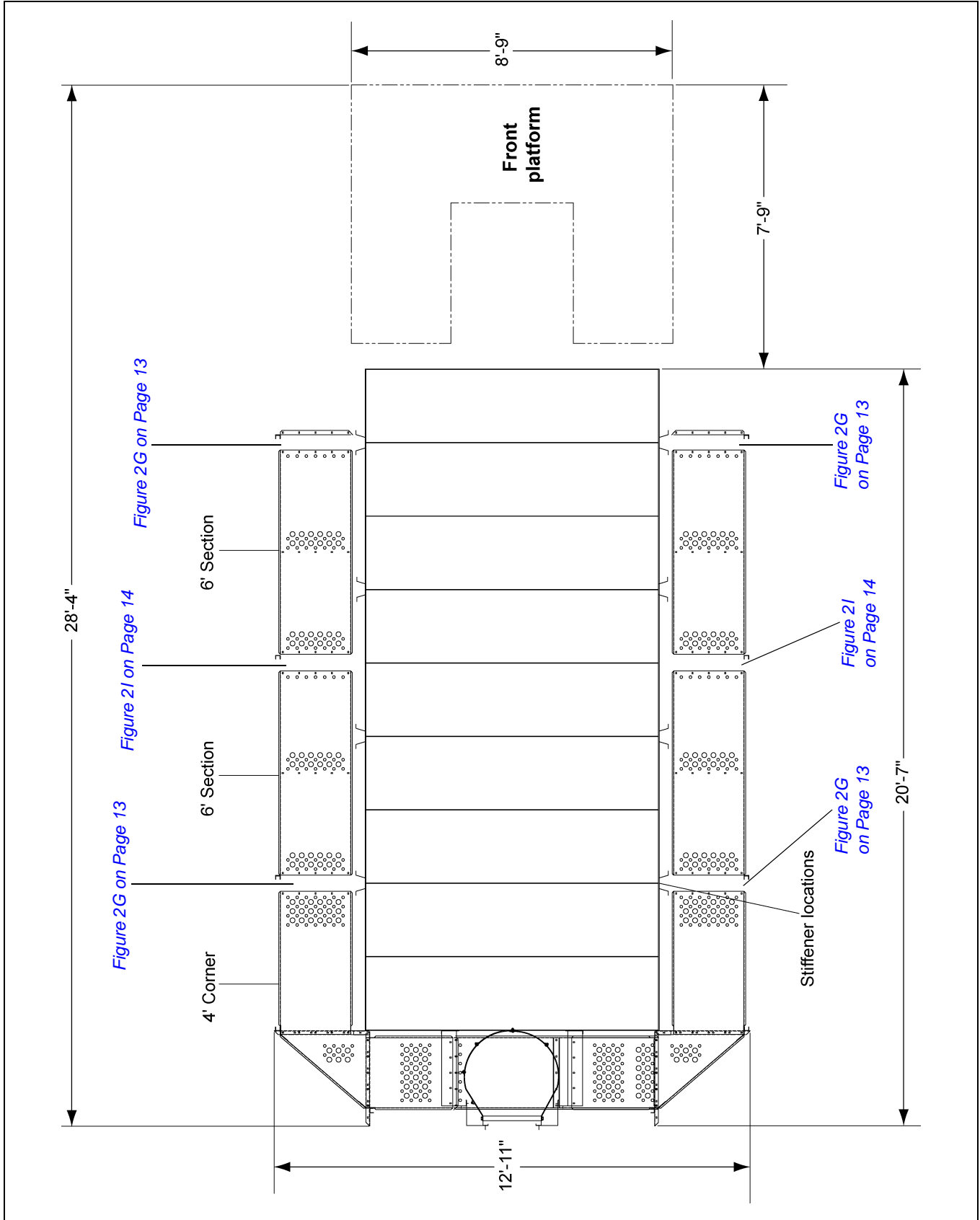


Figure 2C

20' Long Dryer Catwalk Layout

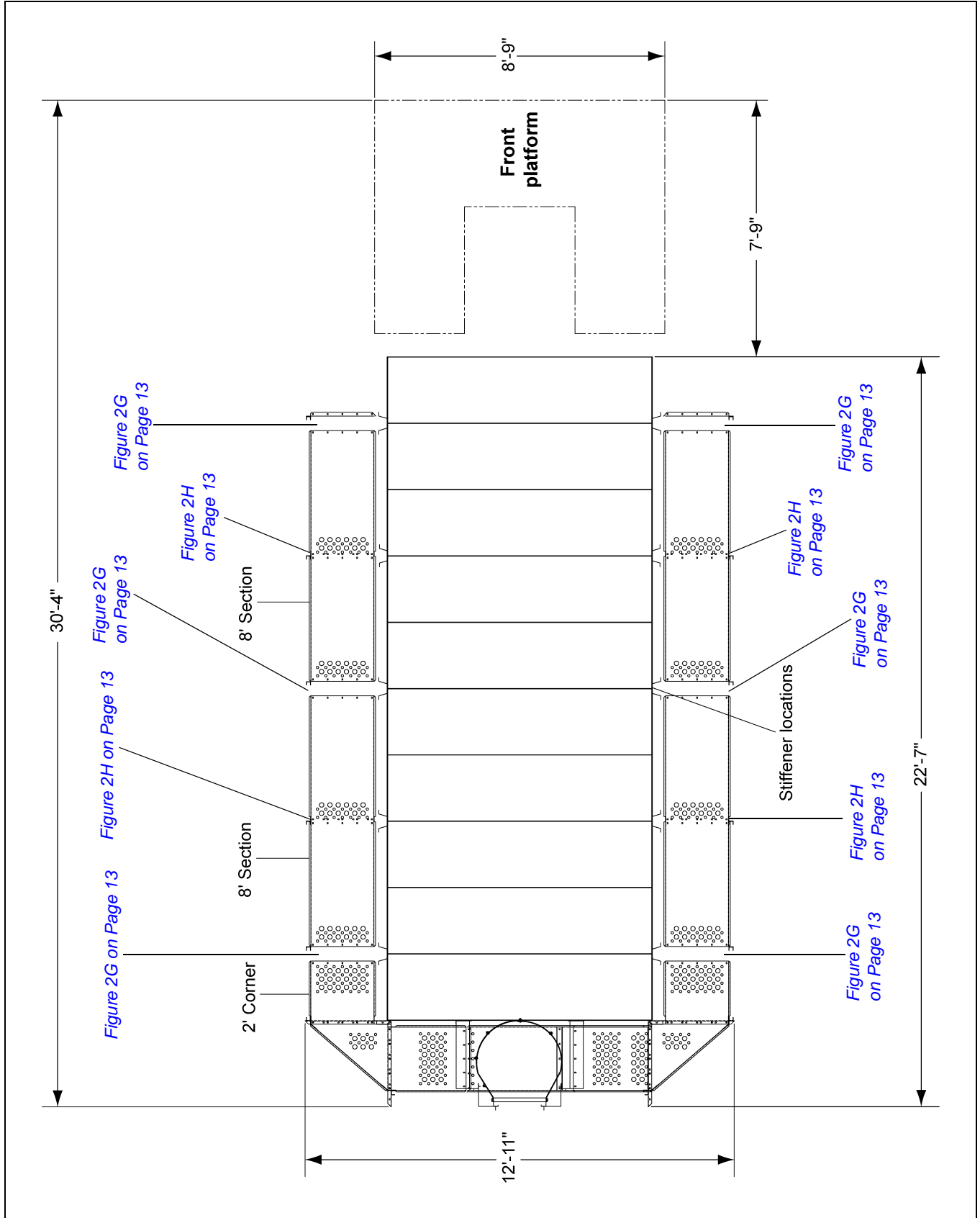


Figure 2D

22' Long Dryer Catwalk Layout

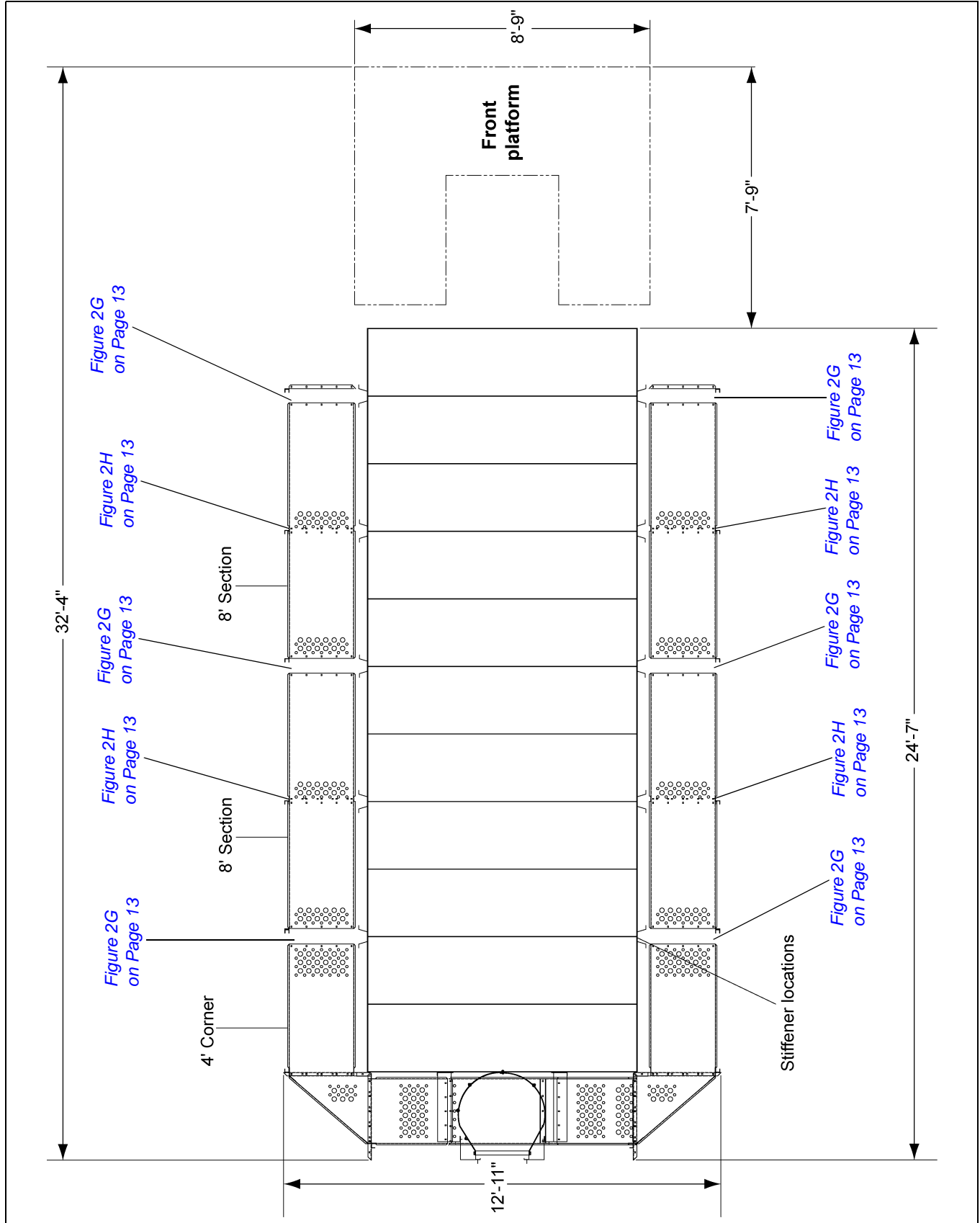


Figure 2E

26' Long Dryer Catwalk Layout

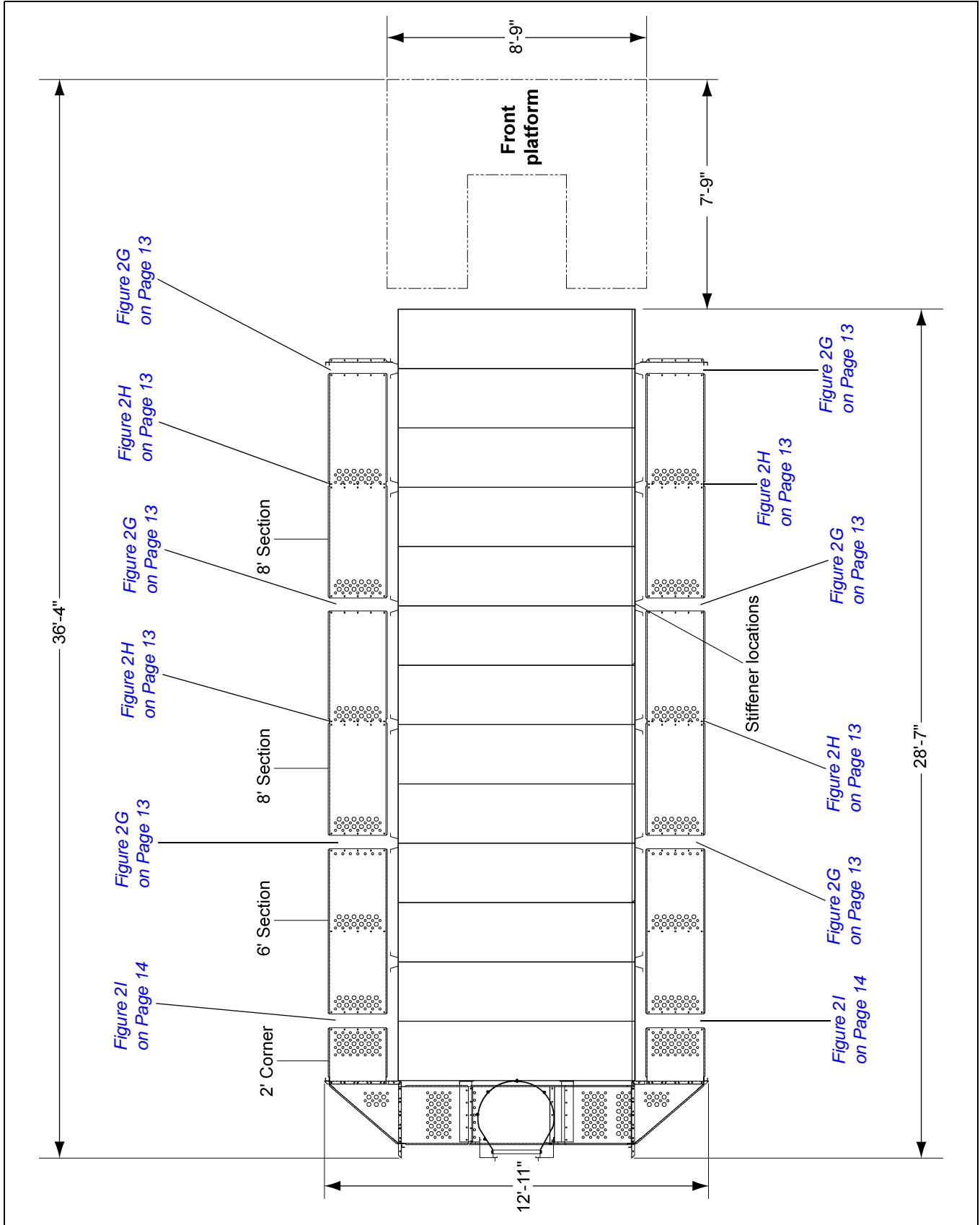


Figure 2F

2. Dryer Dimensions, Stiffener and Catwalk Locations

Dryer Size vs Support Attachments Needed

Dryer Length	# of Modules	Corner Length	6' Catwalk Sections	8' Catwalk Sections	Figure 2G on Page 13	Figure 2H on Page 13	Figure 2I on Page 14
14'	2	4'	0	2	4	2	0
	3	4'	0	4	8	4	0
18'	2	4'	4	0	4	0	2
	3	4'	8	0	8	0	4
20'	2	2'	0	4	6	4	0
	3	2'	0	8	12	8	0
22'	2	4'	0	4	6	4	0
	3	4'	0	8	12	8	0
26'	2	2'	2	4	6	4	2
	3	2'	4	8	12	8	4

[Figure 2G on Page 13](#) = D01-2425. Used at the edges of both 6' and 8' catwalk sections.

[Figure 2H on Page 13](#) = D01-2437. Used at center of 8' catwalk sections. Note that 6' catwalk sections do not require center supports.

[Figure 2I on Page 14](#) = Support for catwalk edge locations without a stiffener. (As seen [on Page 14](#) of layout for new stiffener supports.)

Truss Bracket Attachments for Channel Supports

Truss Bracket, Catwalk Section Edge Locations

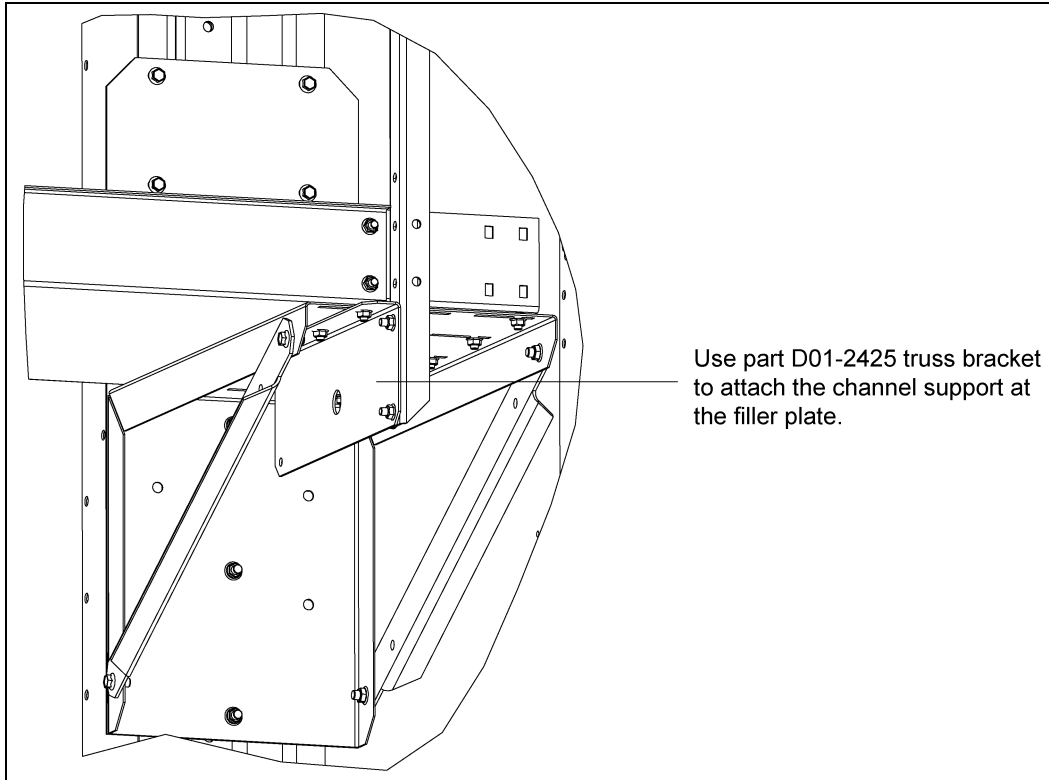


Figure 2G

Truss Bracket, Catwalk 8' Section Center Locations

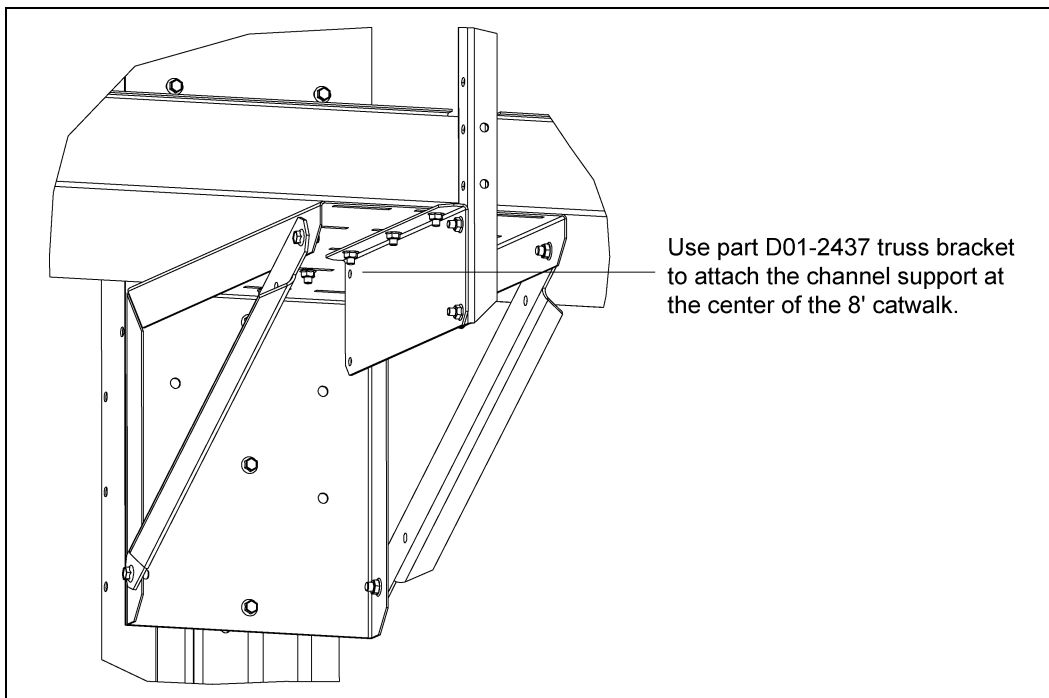


Figure 2H

Catwalk Support Installation for Locations with No Stiffeners

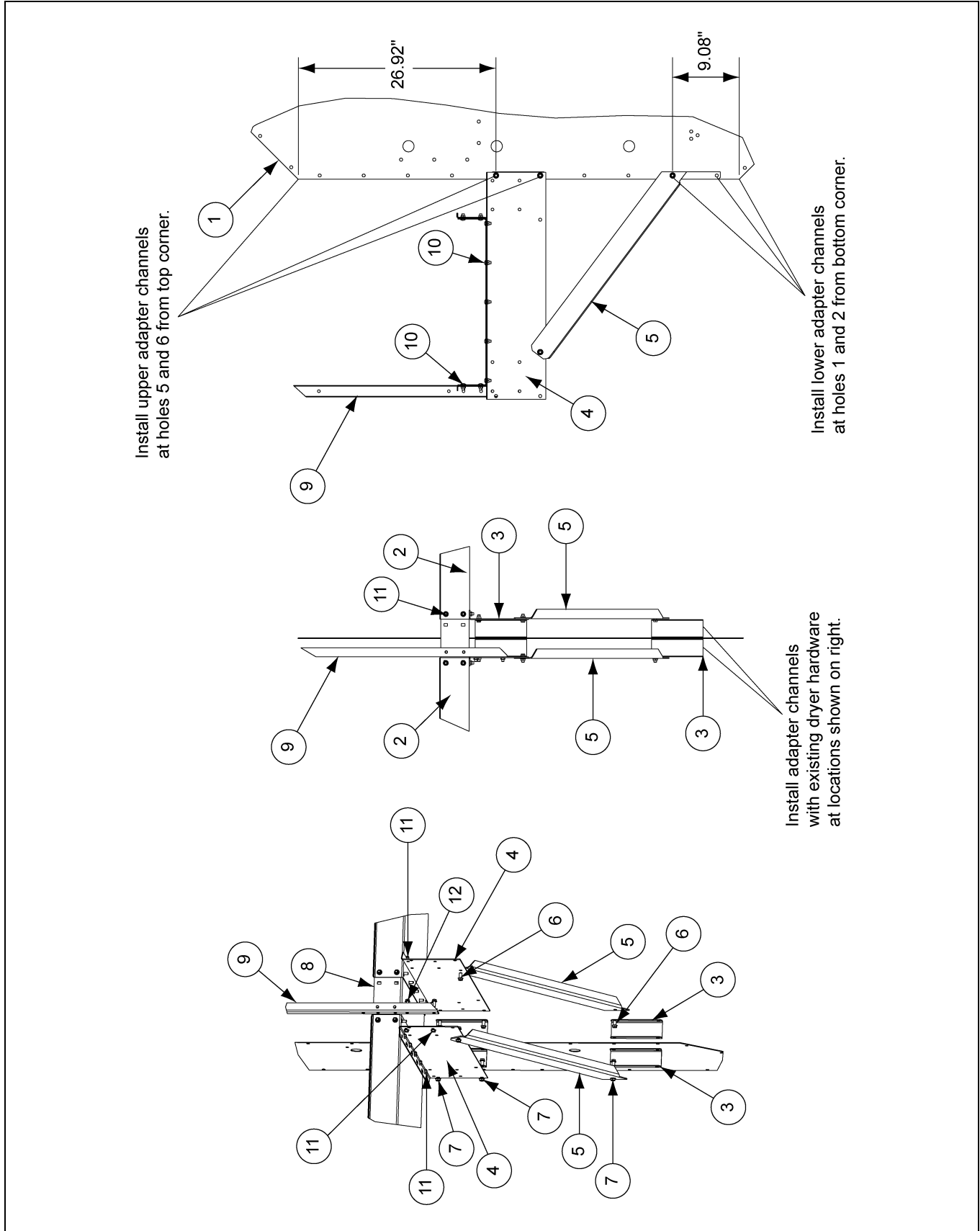


Figure 2I Typical Catwalk Support Installation where no Stiffener is Installed

2. Dryer Dimensions, Stiffener and Catwalk Locations

Catwalk Support Installation for Locations with No Stiffeners Parts List

Ref #	Part #	Description	Qty
1	D31-0055	Column Bulkhead	1
2	401-4713-4	Catwalk Section	1
3	401-4753-0	Adapter Channel Support	4
4	401-4717-5	Support Angle	2
5	401-4719-1	Brace at Dryer	2
6	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	8
7	S-968	Flange Nut 3/8"-16 ZN Grade 5	8
8	401-4720-9	Filler Plate	1
9	325-2091-8	Channel - Support	1
10	S-7645	Carriage Bolt 5/16"-18 x 3/4" ZN Grade 5	20
11	S-3611	Flange Nut 5/16"-18 ZN YDP	22
12	S-6606	Flange Bolt 5/16"-18 x 3/4" ZN Grade 5	2

Catwalk Locations

Middle Module Location

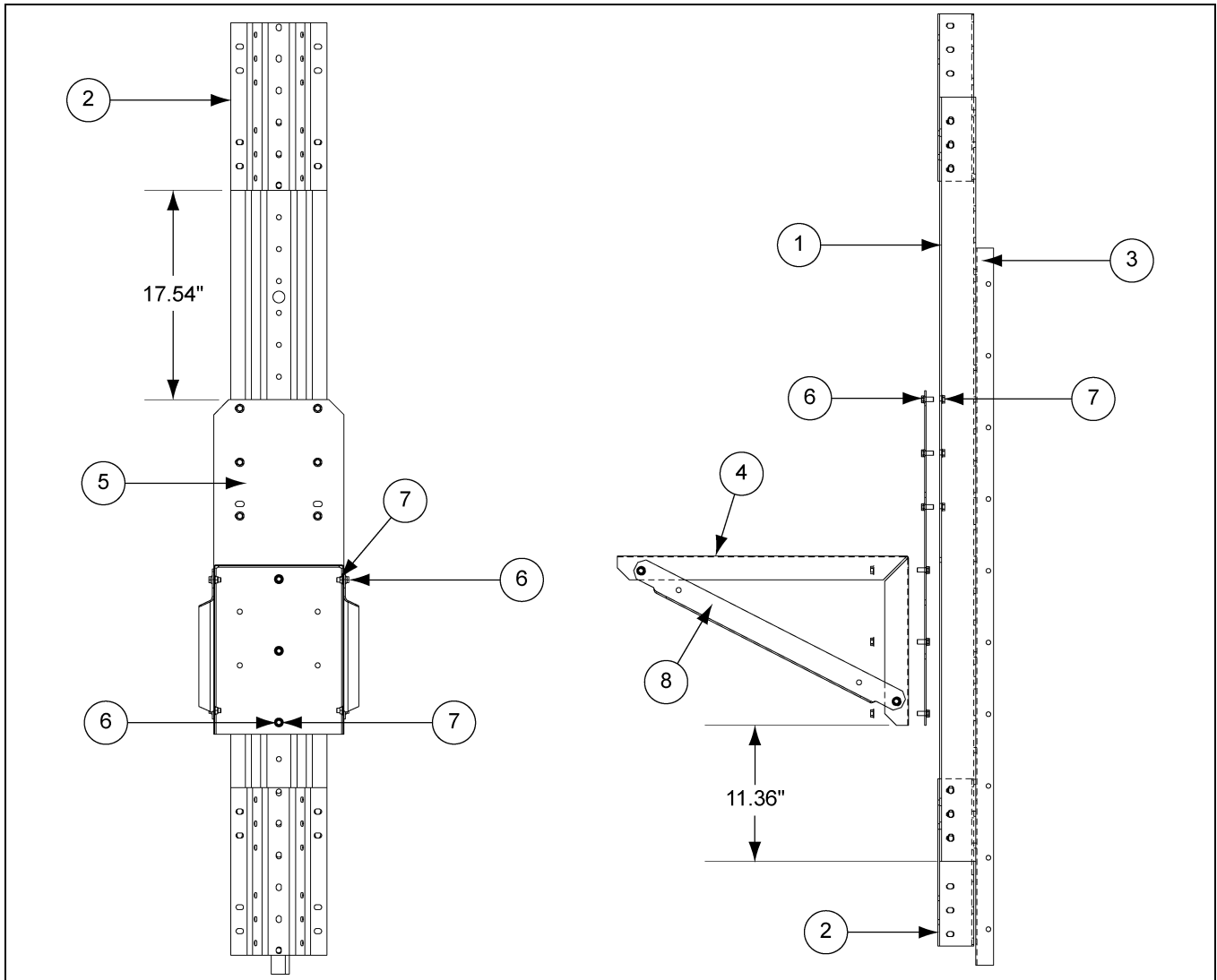


Figure 2J Location of Catwalk for Middle Module

Middle Module Location Parts List

Ref #	Part #	Description	Qty
1	SS-692308	9-5 Gauge 2 Ring	1
2	SS-7053	N.S. 8 Gauge Splice	2
3	D01-0872	Stiffener Attach Angle	1
4	D01-2468	Support at Stiffener	1
5	D01-2469	Stiffener Adapter Plate	1
6	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	13
7	S-968	Flange Nut 3/8"-16 ZN Grade 5	13
8	401-4718-3	Brace at Stiffener	2

Top Module Location

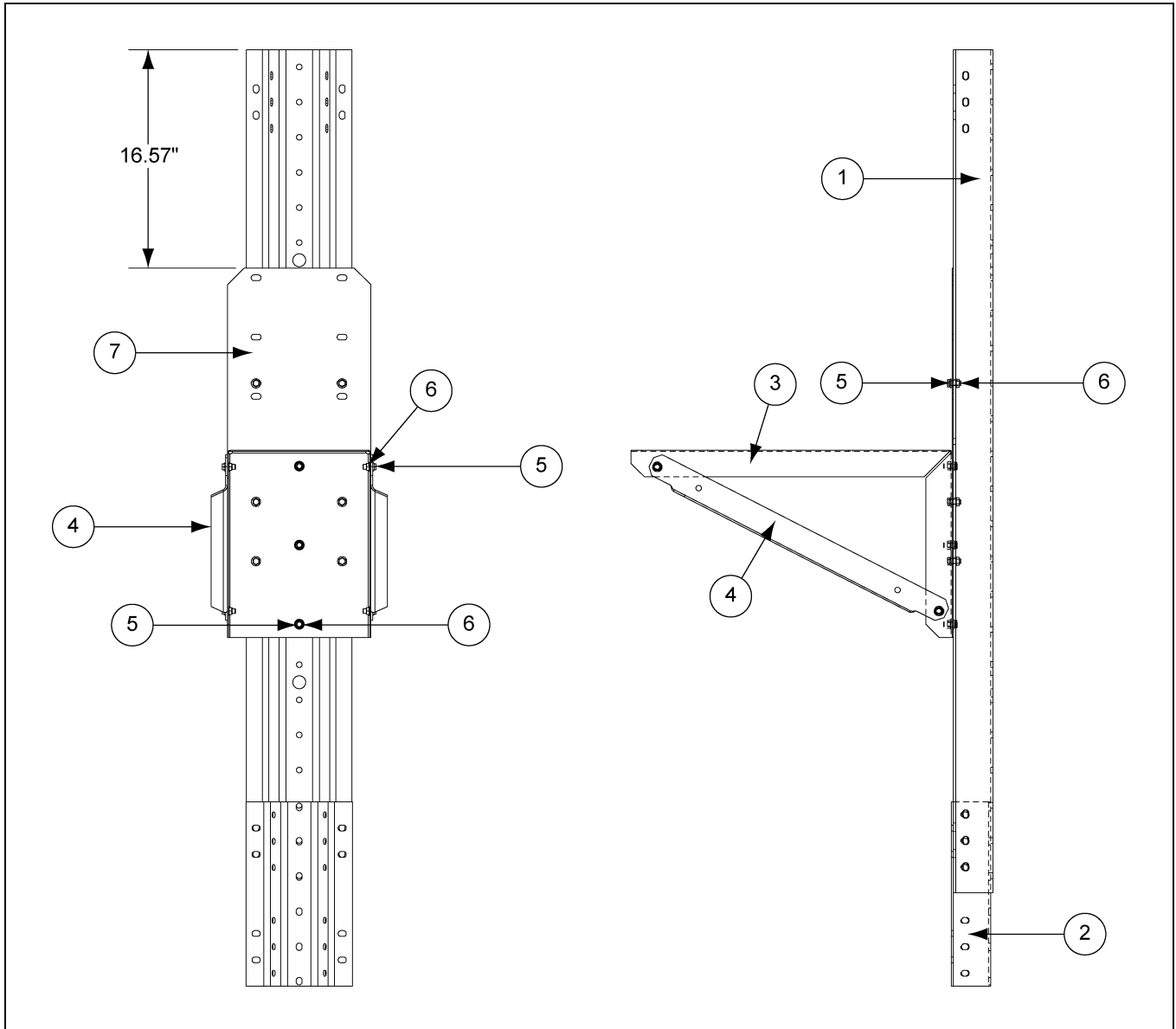


Figure 2K Location of Catwalk for Top Module

Top Module Location Parts List

Ref #	Part #	Description	Qty
1	SS-692308	9-5 Gauge 2 Ring	1
2	SS-7053	N.S. 8 Gauge Splice	1
3	D01-2468	Support at Stiffener	1
4	401-4718-3	Brace at Stiffener	2
5	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	13
6	S-968	Flange Nut 3/8"-16 ZN Grade 5	13
7	D01-2469	Stiffener Adapter Plate	1

20' Catwalk Layout

Catwalk Front Guard Rails - Dryer Top Module

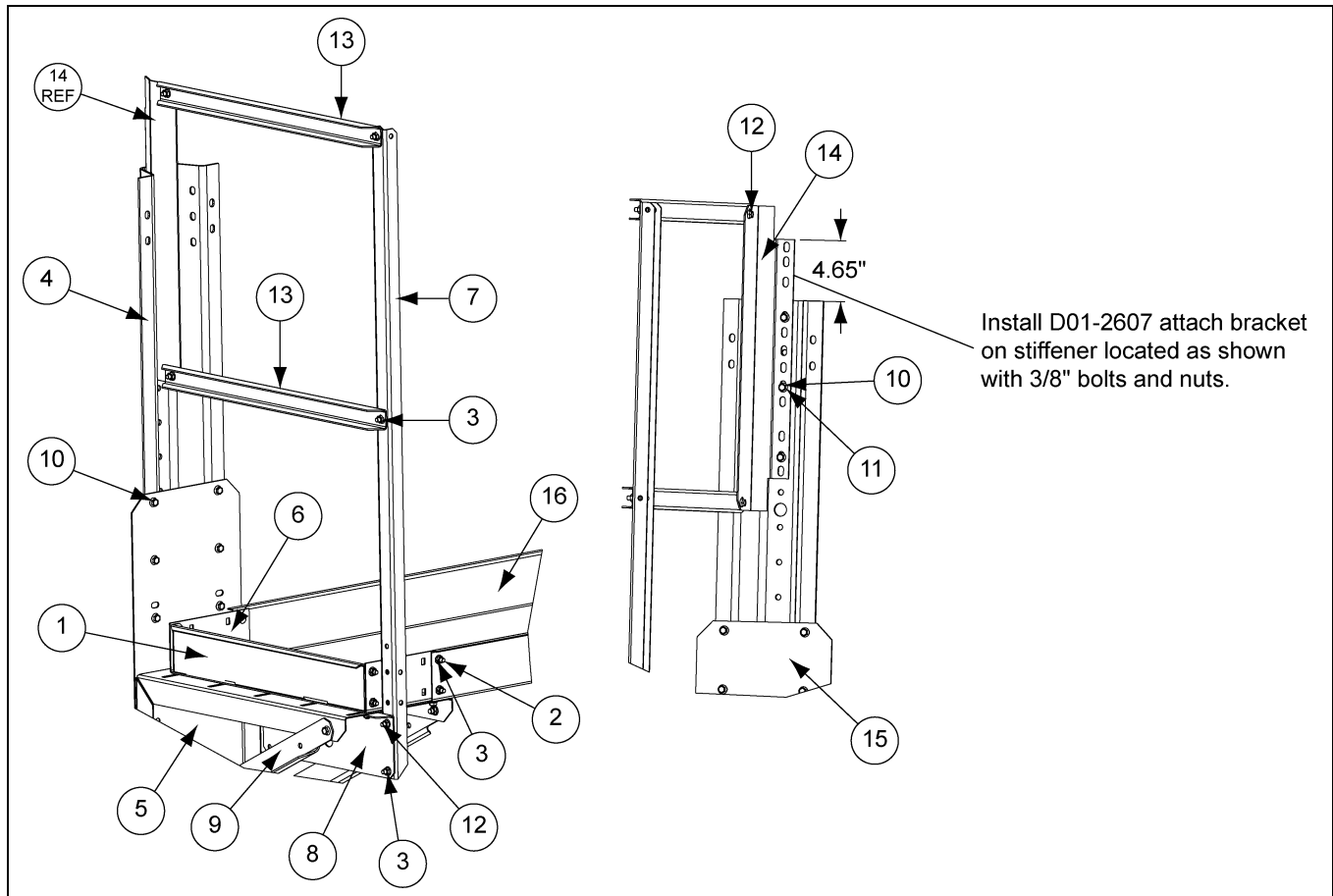


Figure 2L

Catwalk Front Guard Rails - Dryer Top Module Parts List

Ref #	Part #	Description	Qty
1	401-4744-9	End Cap, Catwalk H/M Modules	1
2	S-7645	Carriage Bolt 5/16"-18 x 3/4" ZN Grade 5	20
3	S-3611	Flange Nut 5/16"-18 YDP Grade 2	26
4	SS-692308	9-5 Gauge 2 Ring	1
5	D01-2468	Support at Stiffener	1
6	401-4720-9	Filler Plate	1
7	325-2091-8	Channel - Support	1
8	D01-2425	Truss Bracket - Catwalk	1
9	401-4718-3	Brace at Stiffener	2
10	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	16
11	S-968	Flange Nut 3/8"-16 ZN Grade 5	16
12	S-6606	Flange Bolt 5/16"-18 x 3/4" ZN Grade 5	6
13	D01-2606	Guard Rail, Standard Front - Catwalk	2
14	D01-2607	Attach Bracket, Front Catwalk Guard Rail	1
15	D01-2469	Stiffener Adapter Plate	1
16	401-4713-4	Catwalk Section	1

Catwalk Front Guard Rails - Dryer Middle Module

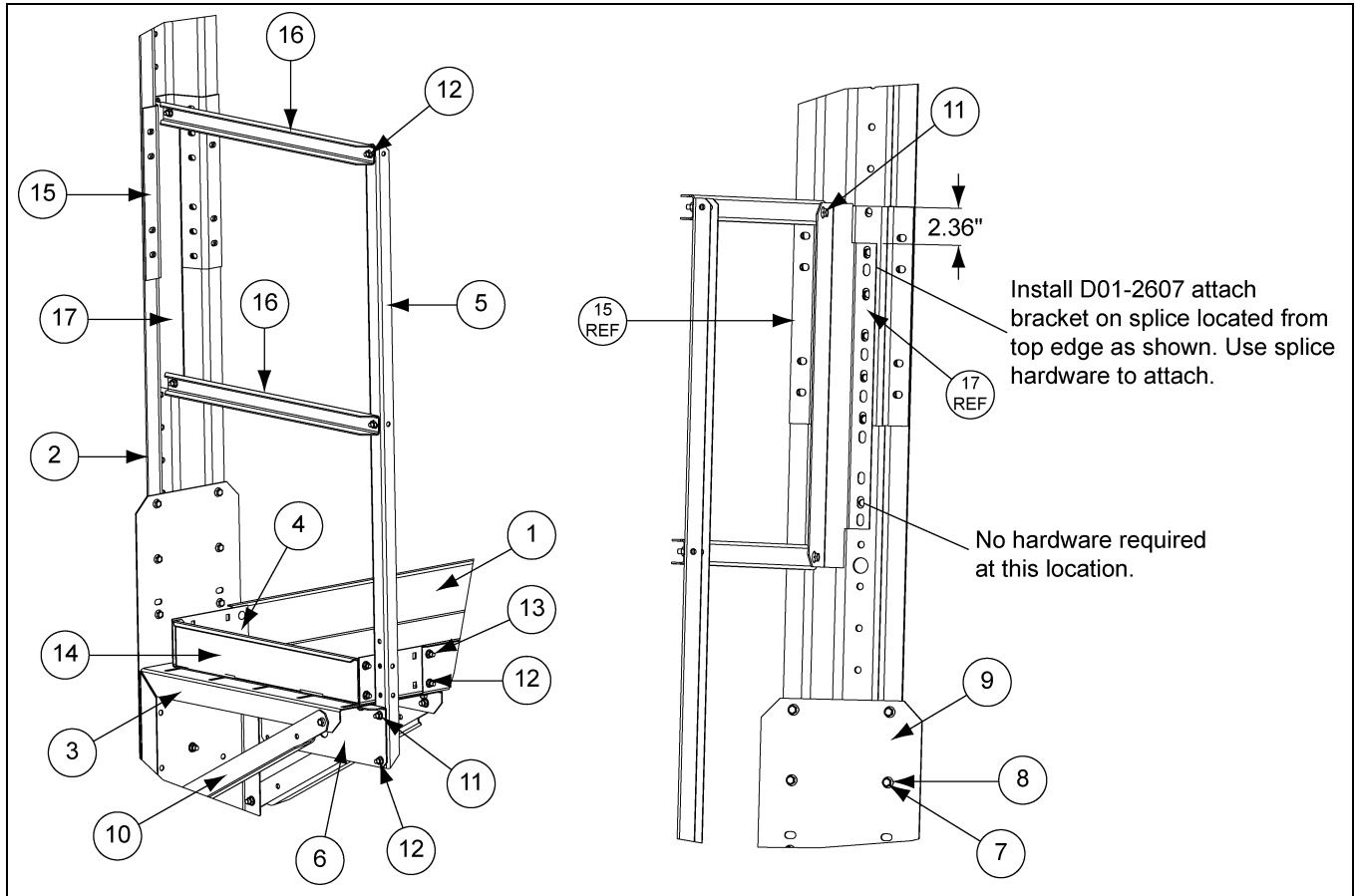


Figure 2M

Catwalk Front Guard Rails - Dryer Middle Module Parts List

Ref #	Part #	Description	Qty
1	401-4713-4	Catwalk Section	1
2	SS-692308	9-5 Gauge 2 Ring	2
3	D01-2468	Support at Stiffener	1
4	401-4720-9	Filler Plate	1
5	325-2091-8	Channel - Support	1
6	D01-2425	Truss Bracket - Catwalk	1
7	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	13
8	S-968	Flange Nut 3/8"-16 ZN Grade 5	13
9	D01-2469	Stiffener Adapter Plate	1
10	401-4718-3	Brace at Stiffener	2
11	S-6606	Flange Bolt 5/16"-18 x 3/4" ZN Grade 5	8
12	S-3611	Flange Nut 5/16"-18 YDP Grade 2	28
13	S-7645	Carriage Bolt 5/16"-18 x 3/4" ZN Grade 5	20
14	401-4744-9	End Cap, Catwalk H/M Modules	1
15	SS-7053	N.S. 8 Gauge Splice	1
16	D01-2606	Guard Rail, Standard Front - Catwalk	2
17	D01-2607	Attach Bracket, Front Catwalk Guard Rail	1

3. Installation Instructions

For **Step 1**, please refer to the instructions included in the original manual. Follow [Step 2](#) in this supplement. Then, return to the original manual for **Steps 4-8**. (Step 3 in the original manual is obsolete for dryers without buttresses.)

Step 2: Build catwalk support assemblies (part numbers: D04-0499, D01-2425 and D01-2437). Refer to [Table on Page 12](#) to determine the number of support assemblies and catwalk platforms needed for the dryer, based upon its length and the number of modules.

Step 3: To install the assemblies on the dryer: A two-stack dryer will have one catwalk on the top module. A three-stack dryer will have one catwalk on the middle module, as well as one on the top module.

NOTE: *There are places where you must install supports where there is no stiffener. (See [Figure 2I on Page 14](#).) To determine if this situation is applicable to the particular dryer, please refer to [Table on Page 12](#), as well as dryer layouts and locate the dryer size.*

Now, return to the original manual for **Steps 4-8**.

To install the catwalk support assembly on the middle module, measure 17.54" from the top of the stiffener to the top of the assembly (D04-0499). Use the hardware referenced in [Figure 2J on Page 16](#).

To install the catwalk support assembly on the top module, measure 16.57" from the top of the stiffener to the top of the assembly (D04-0499). Use the hardware referenced in [Figure 2K on Page 17](#).

Once all supports are in place, install catwalk sections as indicated in [Table on Page 12](#) and dryer catwalk layouts, using the appropriate layout length.

Step 9: On the truss bracket, install the plate with the hole when there is a gap between catwalk sections. See [Figure 2G on Page 13](#) for these connections and [Table on Page 12](#) for the quantities required.

On the truss bracket, install the plate without the hole where the support needs to go in the center of the catwalk. See [Figure 2H on Page 13](#) for these connections and [Table on Page 12](#) for the quantities required.

Go to Step 13 of the existing manual to finish the hand rail installation.

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The GSI Group, LLC. ("GSI") warrants products which it manufactures, to be free of defects in materials and workmanship under normal usage and conditions for a period of 12 months from the date of shipment (or, if shipped by vessel, 14 months from the date of arrival at the port of discharge). If, in GSI's sole judgment, a product is found to have a defect in materials and/or workmanship, GSI will, at its own option and expense, repair or replace the product or refund the purchase price. This Limited Warranty is subject to extension and other terms as set forth below.

Warranty Enhancements: The warranty period for the following products is enhanced as shown below and is in lieu of (and not in addition to) the above stated warranty period. (Warranty Period is from date of shipment.)

	Product	Warranty Period
Storage	Grain Bin Structural Design • Sidewall, roof, doors, platforms and walkarounds • Flooring (when installed using GSI specified floor support system for that floor) • Hopper tanks (BFT, GHT, NCHT, and FCHT)	5 Years
Conditioning	Dryer Structural Design – (Tower, Portable and TopDry) • Includes (frame, portable dryer screens, ladders, access doors and platforms)	5 Years
	All other Dryer parts including: • Electrical (controls, sensors, switches and internal wiring)	2 Years
	All Non-PTO Driven Centrifugal and Axial Fans	3 Years
	Bullseye Controllers	2 Years
Material Handling	Bucket Elevators Structural Design	5 Years
	Towers Structural Design	5 Years
	Catwalks Structural Design	5 Years
	Accessories (stairs, ladders and platforms) Structural Design	5 Years

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