



IMPORTANT: *Read all instructions BEFORE STARTING ASSEMBLY.*

Refer to Bulk Feed Tank manual for additional assembly information. These instructions apply only to the assembly of the 10° roof.

IMPORTANT: *All tanks with 10° roofs must be assembled vertically to avoid damage to component parts.*

General Assembly Instructions

1. Assemble top sidewall sheets. (Refer to Bulk Feed Tank manual.)

NOTE: *Top ring is special 16 gauge (Color Code Blue).*

2. Beginning with the second vertical row of holes (clockwise) from the sidewall vertical seam, assemble an eave support bracket, spacers and an eave seal angle to the top sidewall sheet. On every third vertical row of holes thereafter, attach another eave support bracket with spacers. Refer to [Figure 1 on Page 2](#) and [Figure 2 on Page 3](#) for assembly diagrams and details. Be sure to caulk all areas indicated.
3. Assemble roof panels to the eave support brackets, eave seal angles and peak ring. Roof panel seams are located at each eave support bracket. Note roof panel overlap and caulking detail. Roof panels must be supported at 10° angle during assembly. Remove supports when roof assembly is complete.
4. Assemble guardrail brackets to the top sidewall sheets, starting again with the second vertical row of holes (clockwise) from the sidewall vertical seam. Every fourth vertical row of holes thereafter, attach another guardrail bracket.
5. Assemble guardrail posts to guardrail brackets. Refer to guardrail and safety cage assembly diagram in [Figure 5 on Page 6](#) and [Figure 6 on Page 7](#) for details.
6. Assemble guardrail tubes and toe boards to guardrail posts. (None at ladder location.)



10° Roof Assembly Instructions

10° Roof Assembly

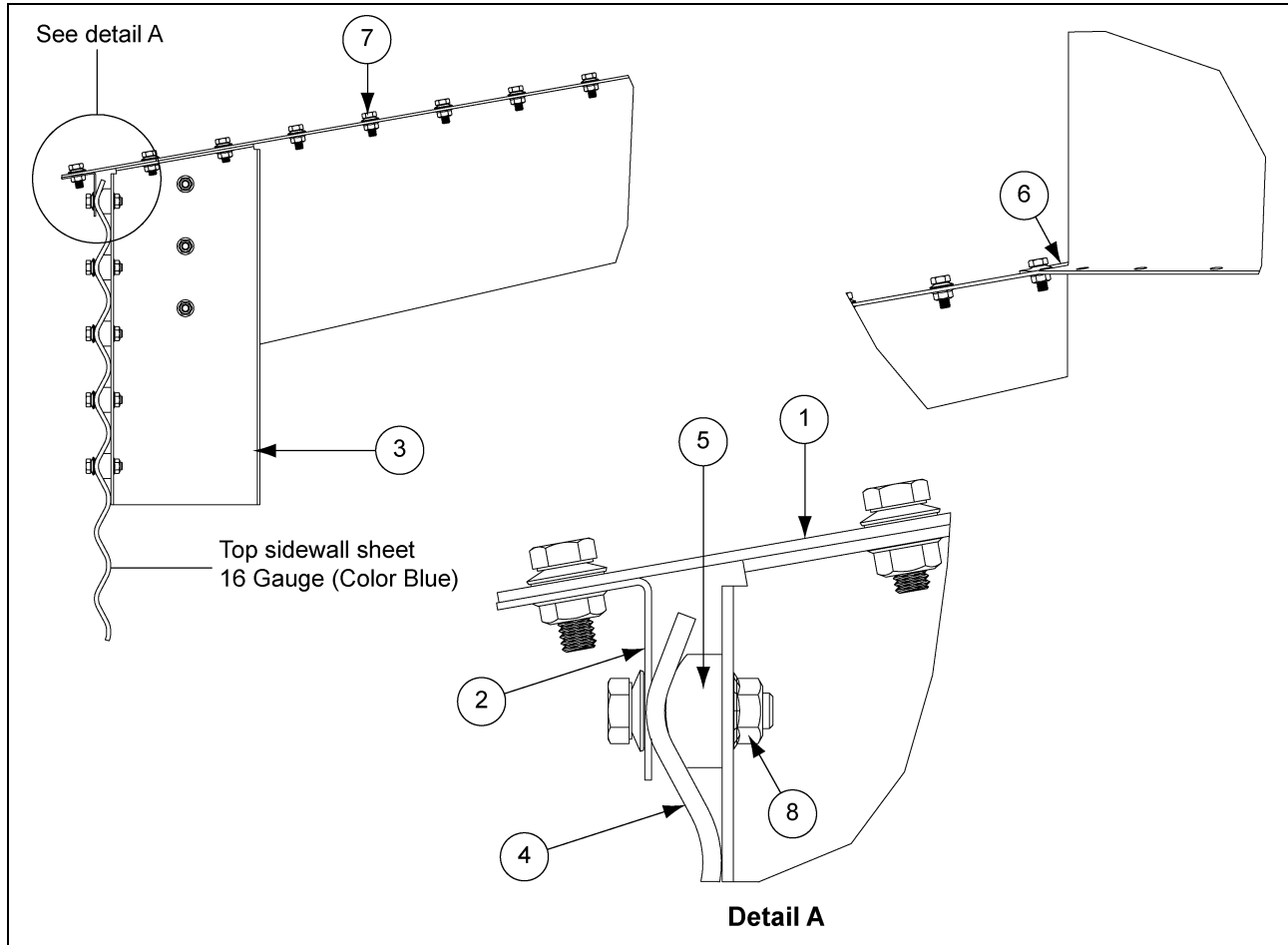


Figure 1

10° Roof Assembly Parts List

Bin Diameter	Ref #	Part #	Description
9'	1	BLK-11389	10° Roof Panel
12'		BLK-11431	
15'		BLK-11432	
18'		BLK-11390	
All	2	BLK-11392	Eave Seal Angle
9' and 12'	3	BLK-11394	Eave Support Bracket
15' and 18'		BLK-11395	
9' and 12'	4	SS-6911	Top Sidewall Sheet
15' and 18'		HT-6910	
All	5	S-7041	Spacer
9'	6	BLK-11393	Peak Ring
12'		BLK-11436	
15'		BLK-11433	
18'		BLK-11401	
All	7	S-275	Bolt, HH Bin 5/16"-18 x 3/4" YDP Grade 5
All	8	S-3611	Flange Nut 5/16"-18 YDP Grade 2

10° Roof Assembly (Continued)

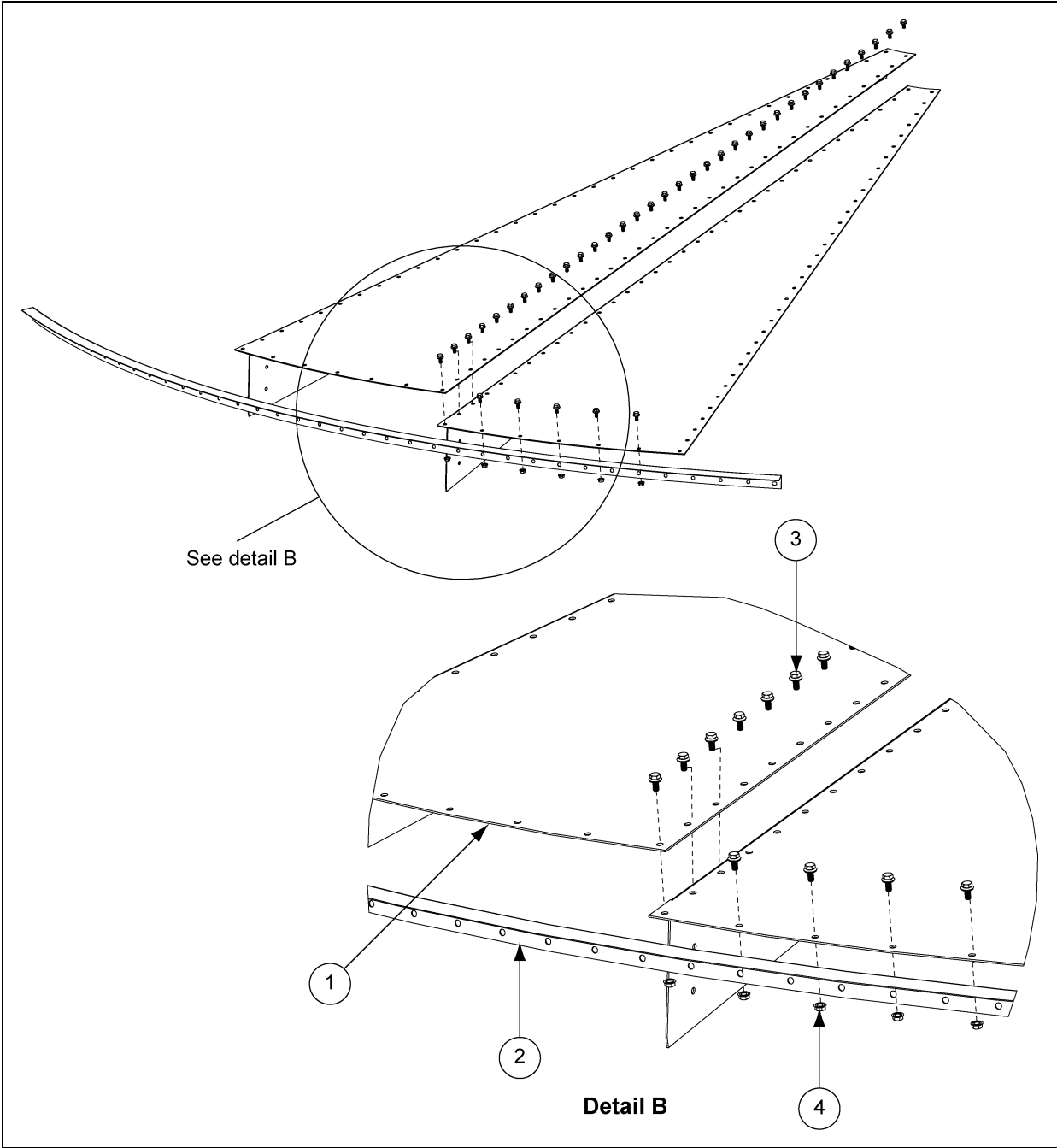


Figure 2

10° Roof Assembly Parts List

Ref #	Part #	Description
1	BLK-11390	18' 10° Roof Panel
2	BLK-11392	Eave Seal Angle
3	S-275	Bolt, HH Bin 5/16"-18 x 3/4" YDP Grade 5
4	S-3611	Flange Nut 5/16"-18 YDP Grade 2

10° Roof Assembly Instructions

Ladder Section Assembly

Two (2) splice plates are required to attach each additional ladder section. The head of the bolt should be to the inside of the ladder with the splice plate on the outside as shown in [Figure 3](#). Use 5/16" x 3/4" bolts for all connections.

NOTE: With most installations, the last ladder section to reach the concrete will need to be cut to fit. (See [Figure 4](#) on [Page 5](#).)

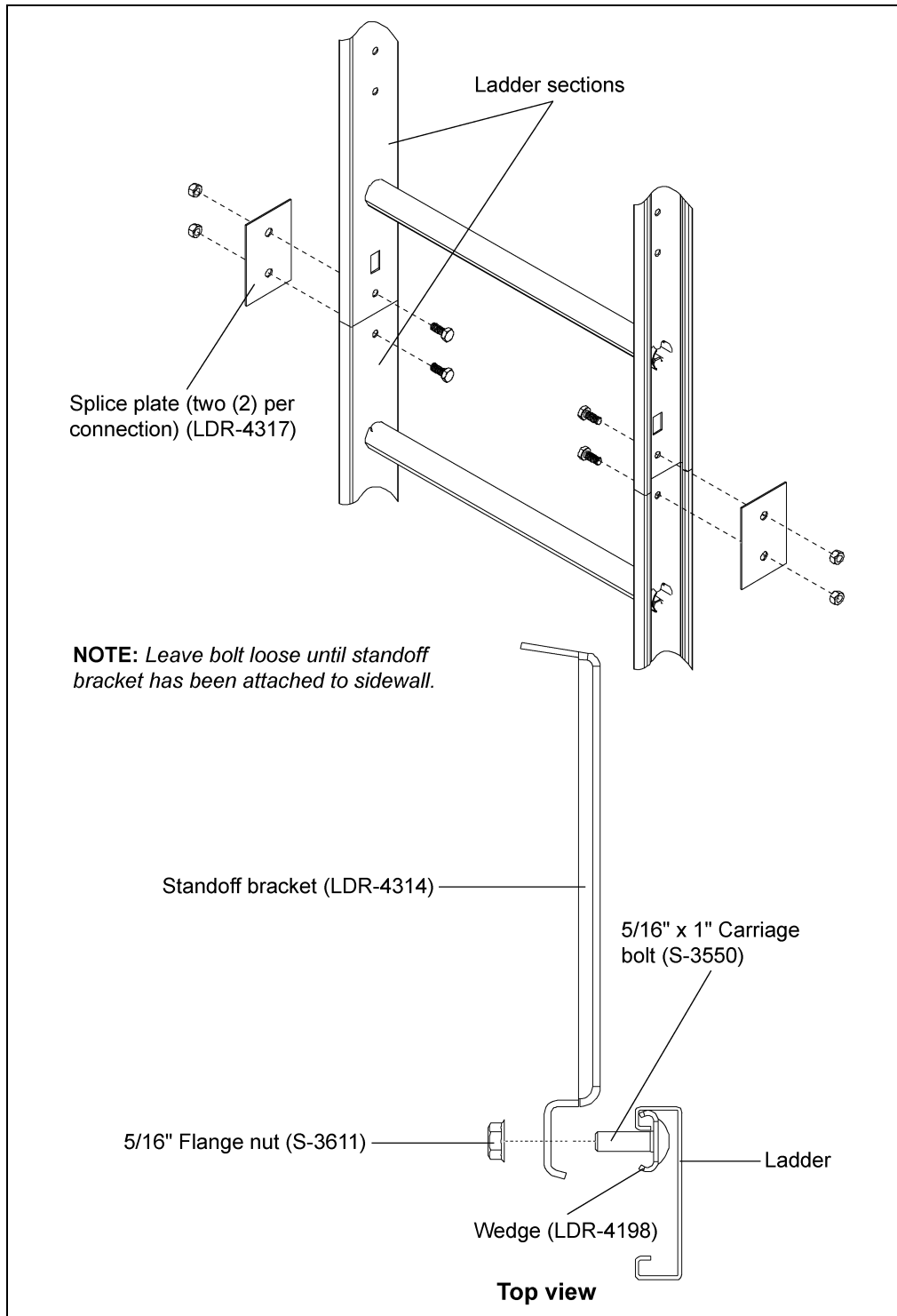


Figure 3

Ladder Section Assembly (Continued)

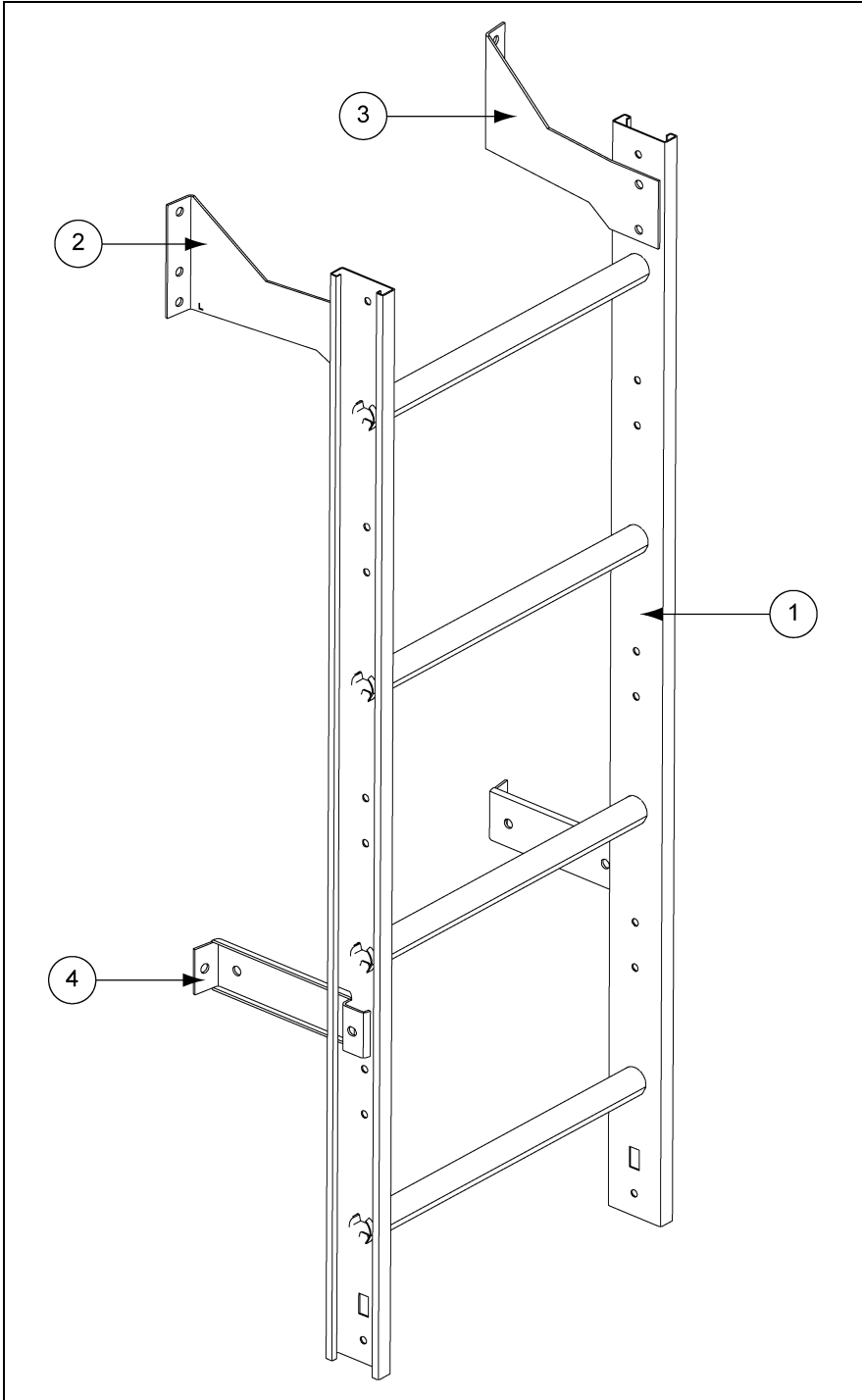


Figure 4

Ref #	Part #	Description	Qty
1	4FOOTRF	4' Ladder Section	1
2	LDR-4346	Placement Bracket New Ladder L.H.	1
3	LDR-4347	Placement Bracket New Ladder R.H.	1
4	LDR-4314	Ladder Standoff Roll Formed	2

Guardrail and Safety Cage Assembly

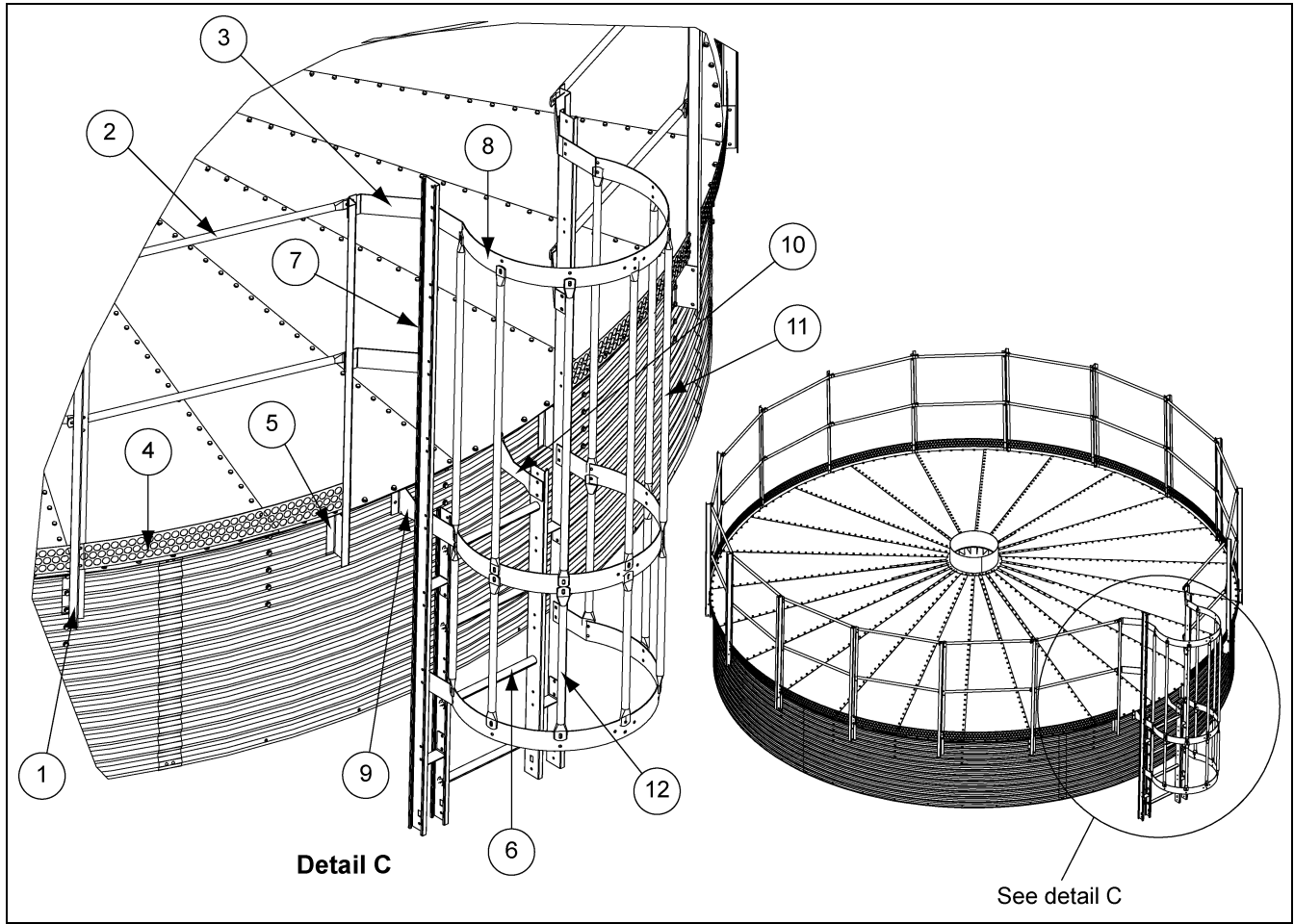


Figure 5

Guardrail and Safety Cage Assembly Parts List

Ref #	Part #	Description
1	BLK-11445	10° Roof Guardrail Post
2	BLK-11443	10° Roof Guardrail Tube
3	BLK-13440	10° Roof Safety Cage Tie Strap
4	BLK-11444	10° Roof Guardrail Toe Board
5	BLK-11442	10° Roof Guardrail Bracket
6	4FOOTRF	4' Ladder Section
7	8FOOTRFB	8'-4" Top Ladder Rail
8	LDR-4201	Safety Cage Hoop Half
9	LDR-4346	Placement Bracket New Ladder L.H.
10	LDR-4347	Placement Bracket New Ladder R.H.
11	LS-6713	48" Safety Cage Vertical Support
12	LS-6714	24" Safety Cage Vertical Support

Guardrail and Safety Cage Assembly (Continued)

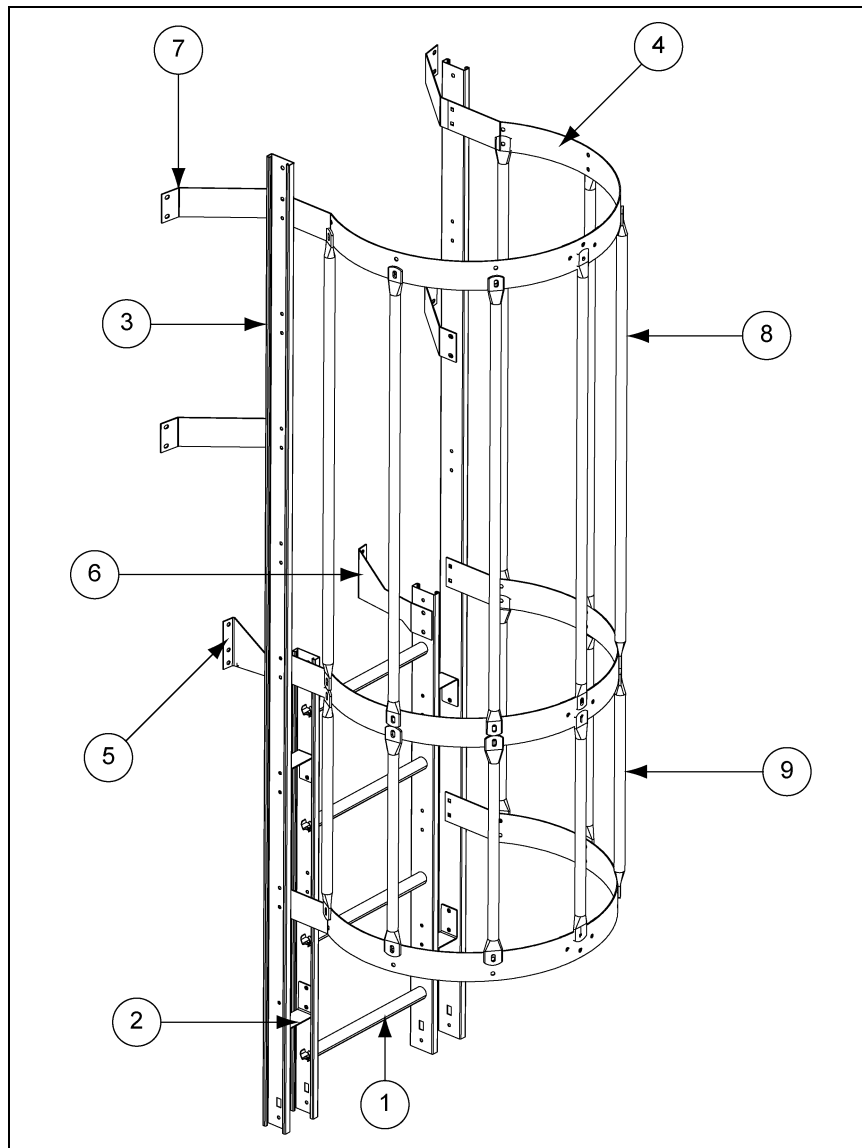


Figure 6

Guardrail and Safety Cage Assembly Parts List

Ref #	Part #	Description	Qty
1	4FOOTRF	4' Ladder Section	1
2	LDR-4403	Safety Cage Extension Rail Spacer	4
3	8FOOTRFB	8'-4" Top Ladder Rail	2
4	LDR-4201	Safety Cage Hoop Half	6
5	LDR-4346	Placement Bracket New Ladder L.H.	1
6	LDR-4347	Placement Bracket New Ladder R.H.	1
7	BLK-13440	10° Roof Safety Cage Tie Strap	4
8	LS-6713	48" Safety Cage Vertical Support	7
9	LS-6714	24" Safety Cage Vertical Support	7