

Series II Bucket Elevator

Assembly Manual

PNEG-681

Version: 2.2

Date: **12-21-20**



Use of the equipment information page will help you identify the equipment in the case that you need to notify the company. For this reason, this information should be filled out and kept on record.

Equipment Information

Model Number: _____

Serial Number: _____

RPM: _____

Head Pulley Diameter: _____

Discharge Height: _____

Horsepower: _____

GSI Group

1004 E. Illinois St.
Assumption, IL. 62510
Phone: 1-217-226-4421

Date Purchased: _____

Dealer Name and Phone Number: _____

All information, illustrations, photos and specifications in this manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

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1. Introduction

Thank you for choosing a GSI product. It has been designed to provide excellent performance and service for many years.

This manual covers general information about installing the GSI Bucket Elevator.

Due to the large variety of equipment features offered, this manual cannot cover every aspect of installation with this manual. This manual provides suggested and recommended methods for installing the product. GSI recommends you retain a qualified contractor to provide on-site expertise.

GSI is not responsible for the installation of this product.

General Safety Statements

1. Our primary concern is your safety and the safety of others associated with the use of this product. All personnel responsible for installing, operating or maintaining this equipment should read and understand this manual. It is the responsibility of the owner to make this manual available to the person or persons involved with this equipment.
2. Guards and safety labels have been installed prior to leaving the manufacturing plant. These should not to be removed, altered or defaced in any way.
3. Modifications to equipment may cause extremely dangerous situations that could result in damage to the equipment as well as serious injury or death. Never modify the equipment.
4. GSI recommends that you contact the local power company to have a representative survey the installation to ensure wiring is compatible with their system and adequate power is supplied to the unit.

Receiving Inspection

1. Carefully inspect the shipment for damage as soon as it is received and verify that the quantity of parts or packages actually received corresponds to the quantity shown on the packing slip.
2. Report any discrepancies, shortages or damages to the delivering carrier as soon as possible.
3. The manufacturer's responsibility for damage to the equipment ends when the carrier accepts the equipment for delivery. Refer to the bill of lading for more detailed information.
4. Save all paperwork and documentation furnished with any of the elevator components.

Pre-Installation Notifications

1. GSI is the manufacturer and vendor of the elevator and is responsible only for the optional accessories also manufactured by GSI.
2. The elevator has not been designed to support other equipment such as cleaners, distributors or spouting. Separate structures must be provided for any accessory equipment.
3. This installation manual should be used for reference only.
4. The owner/user/installer of this equipment is responsible for consulting and retaining a civil or structural engineer regarding the design, construction and supervision of the entire installation, including the elevator foundation and the guying cable and/or bracing system.
5. GSI Bucket Elevators are designed to be vertically self-supporting when erected but must be supported or guyed against wind loads.

Safety Guidelines

Safety guidelines are general-to-specific safety rules that must be followed at all times. This manual is written to help you understand safe operating procedures and problems that can be encountered by the operator and other personnel when using this equipment. Save these safety guidelines for future reference.

As owner or operator, you are responsible for understanding the requirements, hazards, and precautions that exist and to inform others as required. Unqualified persons must stay out of the work area at all times.

Alterations must not be made to the equipment. Alterations can produce dangerous situations resulting in **SERIOUS INJURY** or **DEATH**.

This equipment must be installed in accordance with the current installation codes and applicable regulations, which must be carefully followed in all cases. Authorities having jurisdiction must be consulted before installations are made.

When necessary, you must consider the installation location relative to electrical, fuel and water utilities.

Personnel operating or working around equipment must read this manual. This manual must be delivered with equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

ST-0001-3

Cautionary Symbols Definitions

Cautionary symbols appear in this manual and on product decals. The symbols alert the user of potential safety hazards, prohibited activities and mandatory actions. To help you recognize this information, we use the symbols that are defined below.



This symbol indicates an imminently hazardous situation which, if not avoided, **will result in serious injury or death.**



This symbol indicates a potentially hazardous situation which, if not avoided, **can result in serious injury or death.**



This symbol indicates a potentially hazardous situation which, if not avoided, **can result in minor or moderate injury.**



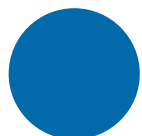
This symbol is used to address practices not related to personal injury.



This symbol indicates a general hazard.



This symbol indicates a prohibited activity.



This symbol indicates a mandatory action.

ST-0005-2

Safety Cautions

Use Personal Protective Equipment

- Use appropriate personal protective equipment:

Eye Protection



Respiratory Protection



Foot Protection



Hearing Protection



Head Protection



Fall Protection



Hand Protection



- Wear clothing appropriate to the job.
- Remove all jewelry.
- Tie long hair up and back.

ST-0004-1

Follow Safety Instructions

- Carefully read all safety messages in this manual and safety signs on your machine. Keep signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from the manufacturer.
- Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.
- If you do not understand any part of this manual or need assistance, contact your dealer.



ST-0002-1

2. Safety

Maintain Equipment and Work Area

- Understand service procedures before doing work. Keep area clean and dry.
- Never service equipment while it is operating. Keep hands, feet, and clothing away from moving parts
- Keep your equipment in proper working condition. Replace worn or broken parts immediately.



ST-0003-1

Sharp Edge Hazard

- This product has sharp edges, which can cause serious injury.
- To avoid injury, handle sharp edges with caution and always use proper protective clothing and equipment.



ST-0036-2

Stay Clear of Rotating Parts

- Do not service equipment while it is in operation.
- Entanglement in rotating parts or exposed belts will cause serious injury or death.
- Keep all shields and covers in place at all times.
- Lock-out power source before making adjustments, cleaning, or maintaining equipment.



ST-0072-1

Stay Clear of Moving Parts

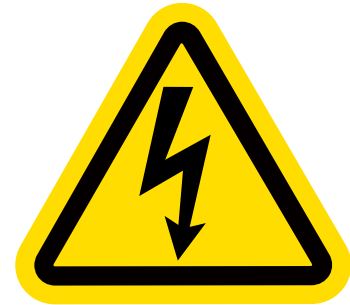
- Entanglement in rotating sprocket or moving chain will cause serious injury or death.
- Keep all guards and covers in place at all times.
- Lock-out power source before making adjustments, cleaning, or maintaining equipment.



ST-0076-1

Operate Motor Properly

- All electrical connections must be made in accordance with applicable local codes (National Electrical Code for the US, Canadian Electric Code, or EN60204 along with applicable European Directives for Europe). Make sure equipment and bins are properly grounded.
- Lock-out power before resetting motor overloads.
- Do not repetitively stop and start the drive in order to free a plugged condition. Jogging the drive in this manner can damage the equipment and drive components.



ST-0009-3

Fall Hazard

- Keep access door closed while on a platform to avoid falls.
- Always use proper personal protective equipment and proper clothing when using equipment. Failure to follow safety precautions can result in severe injury or death.



ST-0042-2

Stay Clear of Hoisted Equipment

- Always use proper lifting or hoisting equipment when assembling or disassembling equipment.
- Do not walk or stand under hoisted equipment.
- Always use sturdy and stable supports when needed for installation. Not following these safety precautions creates the risk of falling equipment, which can crush personnel and cause serious injury or death.



ST-0047-1

2. Safety

Fall Hazard

- Ladders, stairways and platforms are for use by competent and trained personnel only. Do not allow children or other unauthorized persons to have access to the equipment.
- Access to the equipment must be restricted by the use of security fencing and lockable gates.
- Lower sections of ladders must be fitted with a lockable safety gate to prevent unauthorized access.
- Make sure that hot surfaces have had adequate time to cool before working on or in the equipment.
- Lock out and tag out power supplies and fuel supplies to all equipment.
- Do not attach lifting equipment to ladders or platforms.
- Do not go outside of the safety rails provided on elevated platforms.
- Do not work at heights during high winds, rain, snow, or ice storms.



ST-0056-1

Toxic Fume and Dust Hazard

- Do all work outside or in a well-ventilated area. Dispose of paint and solvent properly.
- Remove paint before welding or heating:
 - Avoid potentially toxic fumes and dust. Hazardous fumes can be generated when paint is heated by welding, soldering, or using a torch.
 - If you sand or grind paint, avoid breathing the dust. Wear an approved respirator.
 - If you use solvent or paint-stripper, remove stripper with soap and water before welding.
 - Remove solvent or stripper containers and other flammable material from area. Allow fumes to disperse at least 15 minutes before welding or heating.



ST-0043-2

3. Safety Decals

Safety decals should be read and understood by all people in the grain handling area. Safety decals have been affixed to the equipment to warn of danger to people and of possible equipment damage. These decals must not be removed, tampered with, painted over or obscured in any way. If labels are damaged or become unreadable, replacement labels are available from the manufacturer.

If a decal is damaged or is missing, contact:

GSI Decals

1004 E. Illinois St.
Assumption, IL. 62510
Phone: 1-217-226-4421

A free replacement decal will be sent to you. (Refer to DC number on the decal.)



GSI Group 217-226-4421

! WARNING
Thrown or flying objects. Eye protection required.

DC-1198

1 DC-1198



GSI Group 217-226-4421

! WARNING
Platform collapse can cause serious injury. Do not exceed 500 lb. maximum load.

DC-1378

4 DC-1378



GSI Group Inc. 217-226-4421

! WARNING
CRUSH HAZARD
Keep hands clear of moving parts. Do not operate with guard removed.
Disconnect and lockout power before servicing.

DC-1199

2 DC-1199



GSI Group Inc. 217-226-4421

! WARNING
SHEAR POINT
Keep hands clear of moving parts. Do not operate with guard removed. Disconnect and lockout power before servicing.

DC-995

5 DC-995



GSI Group Inc. 217-226-4421

! DANGER
Explosion release will cause severe injury or death. Avoid area around explosion vent during operation.

DC-1377

3 DC-1377



GSI Group Inc. 217-226-4421

! DANGER
SHEAR POINT
Keep hands clear of moving parts. Do not operate with guard removed. Disconnect and lockout power before servicing.

DC-994

6 DC-994



GSI Group 217-226-4421

! WARNING

Moving side plate.
Auto equipment can
start at any time.
Disconnect and lockout
before servicing.

DC-1248

7 DC-1248

! DANGER

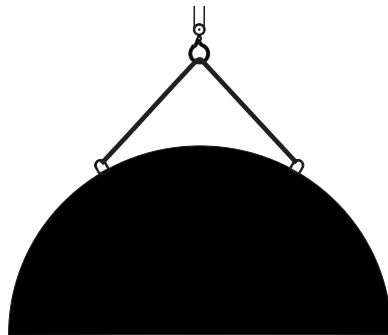


High voltage.
Will cause serious
injury or death.
Lockout power
before servicing.

DC-1224

8 DC-1224

! DANGER



Lift Bonnet Only.
Correct



Incorrect

CRUSH HAZARD.

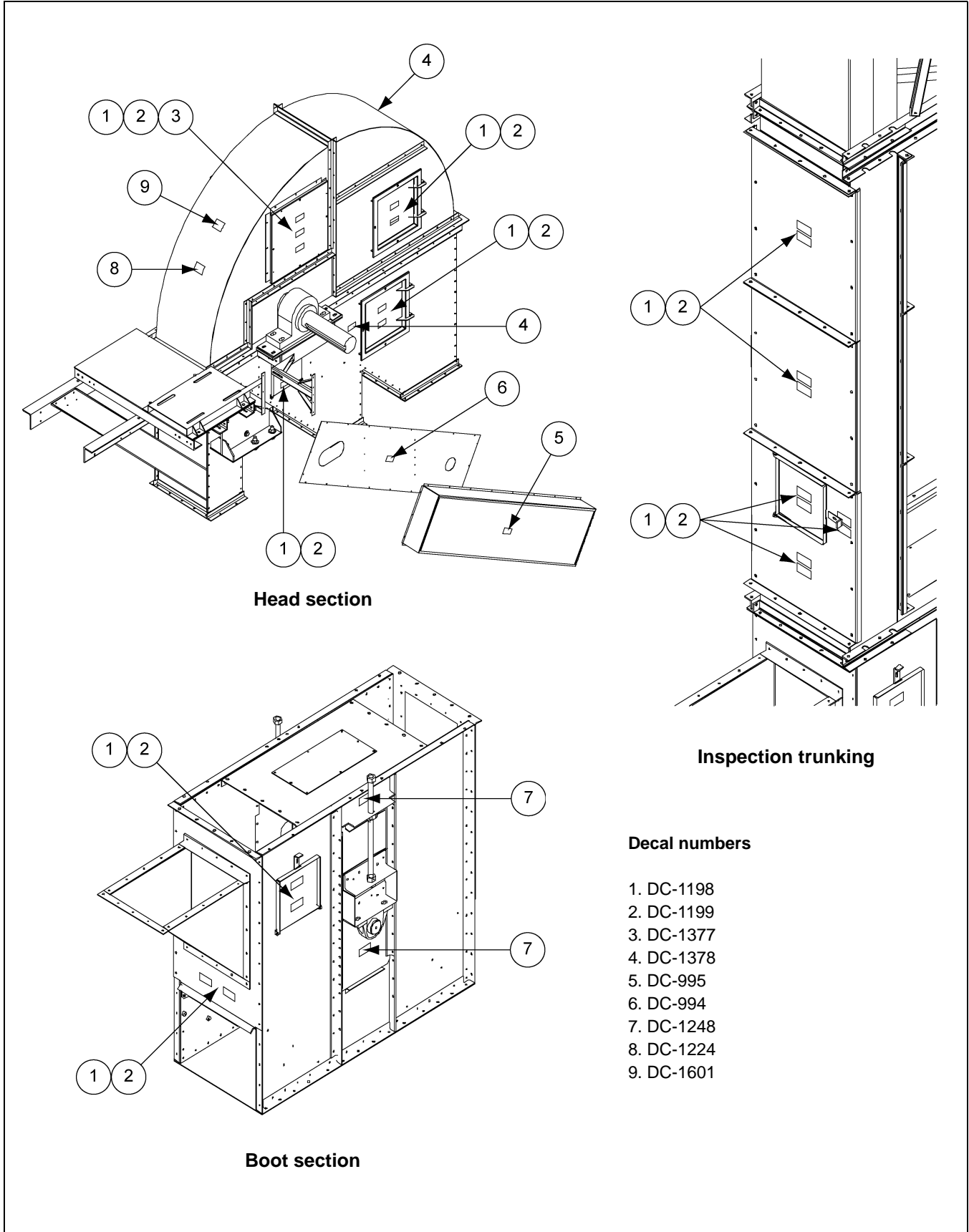
Failure of U-Lug Welds can occur from over stress.
Lift only Bonnet section with U-Lugs.
Death or serious injury can occur.
**DO NOT Lift Bonnet and Lower Head Sections
assembled together.**

GSI Group 217-226-4421

DC-1601

9 DC-1601

Decal Placement



Part Identification

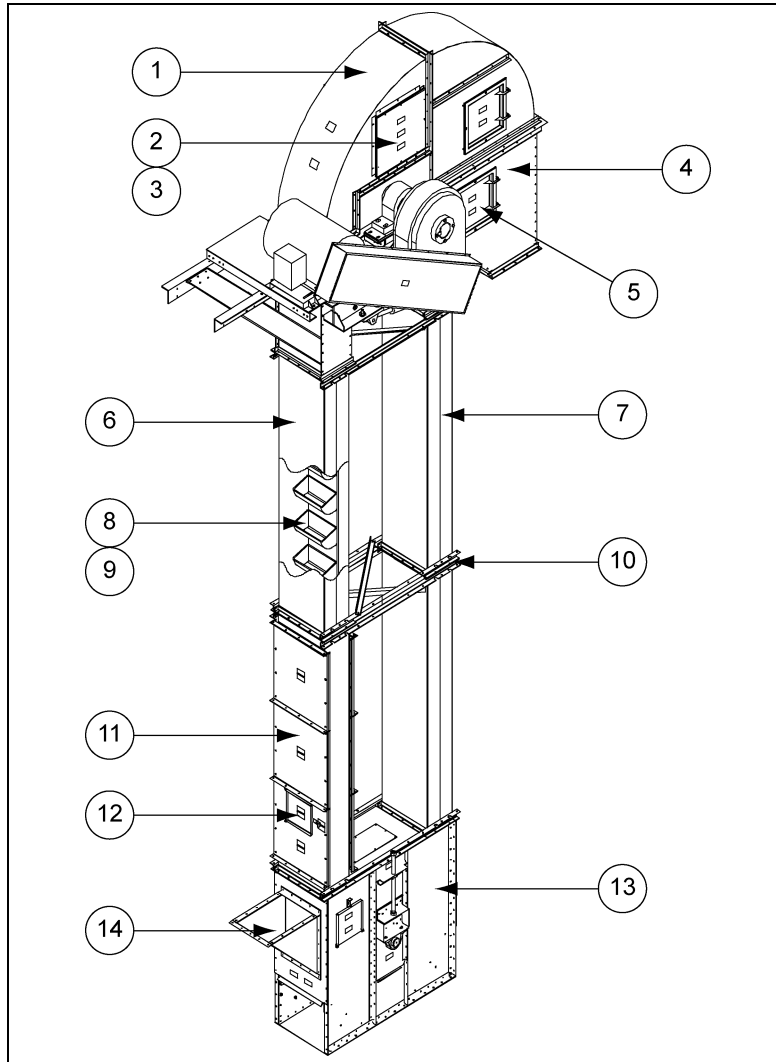


Figure 4A

Ref #	Description
1	Bonnet
2	Pressure Relief Panel (One Each Side)
3	Head Pulley
4	Lower Head Section
5	Inspection Door
6	Up-Leg Trunking
7	Down-Leg Trunking
8	Belt
9	Buckets
10	Tie Angles
11	Inspection Section
12	Inspection Door
13	Boot Section
14	Upside Hopper (Downside Hopper Optional)

5. Bucket Elevator Foundation

1. The bucket elevator foundation must be designed by a qualified civil engineer and installed by a qualified contractor.
2. Always consider the additional weight of live loads, dead loads, wind loads and soil bearing loads.
3. Always provide for proper moisture run-off on the top of the foundation.

Boot sections are pre-assembled at the factory. Boot inlet hoppers are typically shipped separately.

1. Before installing boot on foundation, examine boot for damage or loose hardware. Do not attempt to install if parts are damaged.
2. Proper position of boot is critical for successful installation. Boot inlet section can be installed as an up-leg or a down-leg inlet.
3. Identify the up and down side of boot. (See Figure 6A.)

NOTE: The up-leg inlet position is approximately six inches (6") higher than the down-leg side.

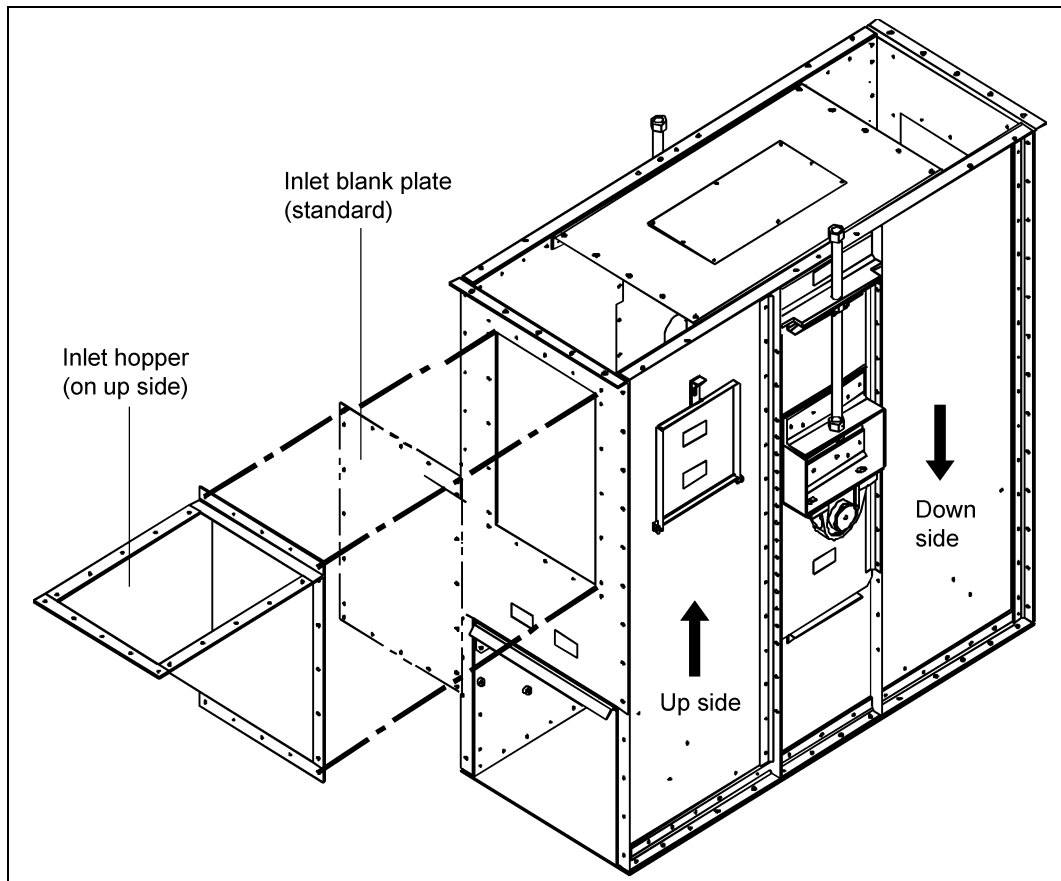


Figure 6A Boot Section

Attaching Boot to Foundation

1. Remove the nuts and inlet blank plates to attach boot inlet hopper.
2. Anchor and level boot. Boot must be level and plumb. There are a variety of ways to accomplish this. GSI recommends that you shim to the perimeter, secure with hold-downs and grout the base.
3. Set boot in place.
4. Level in all directions prior to anchoring.
5. Use anchor bolts and mounting brackets (not supplied) to secure boot to foundation.
6. Check boot levelness and plumbness periodically throughout the installation process to ensure proper elevator erection.

6. Boot Section

Inspection Sections

The inspection section of the GSI Bucket Elevator has been designed for easy installation and maintenance.

1. The removable panels can be installed in any order, to allow for the installation of inspection doors at any preferred locations.

NOTE: *Typical installations often place the inspection section directly above the boot on the up-leg side as the first trunking section.*

NOTE: *Installation will vary and depend on the configuration and application.*

NOTE: *Along with the inspection section, you will receive installation hardware and two (2) tie angles. Units containing 42" diameter pulleys and larger, will include a cross tie on the legs, which will be included. (See Figure 6B below and Figure 7A on Page 19.)*

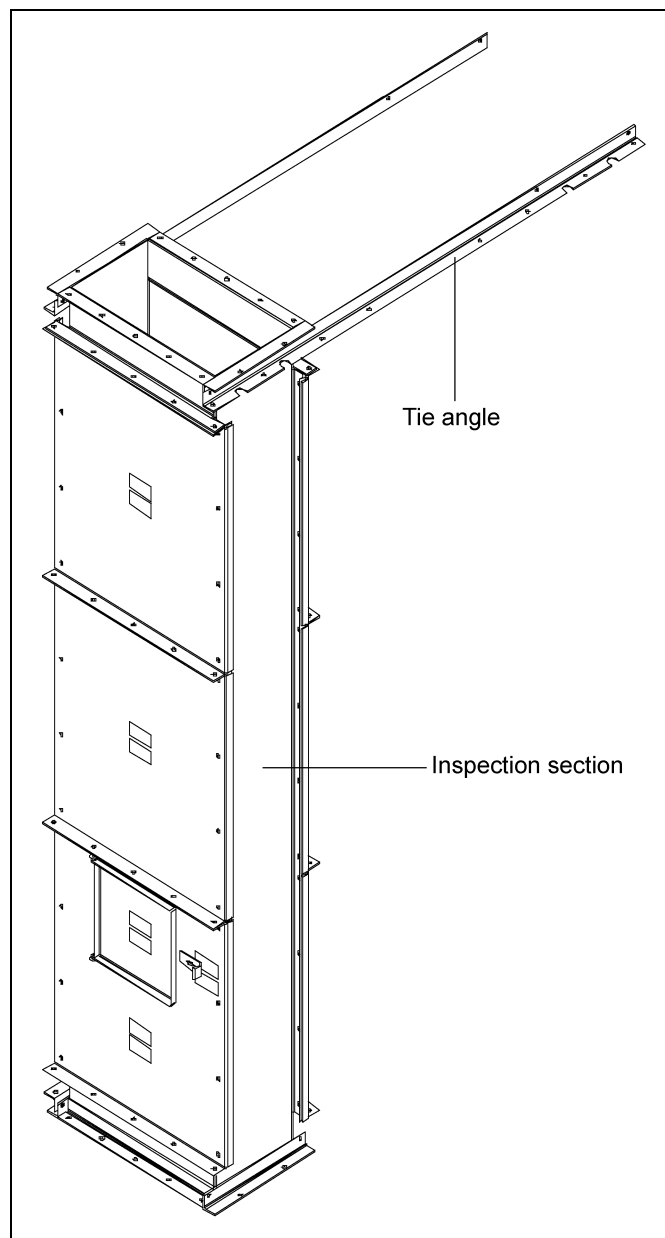


Figure 6B *Inspection Section*

Standard Trunking

Standard trunking sections may be fabricated from painted or galvanized steel.

IMPORTANT: Galvanized steel trunking **MUST** have the riveted (huck bolted) seams located to the inside, facing each other on the up-leg and the down-leg. (See Figure 7B.)

NOTE: Trunking sections come complete with appropriate hardware and two (2) tie angles. Units containing 42" diameter or larger pulleys have a cross tie angle included for additional support.

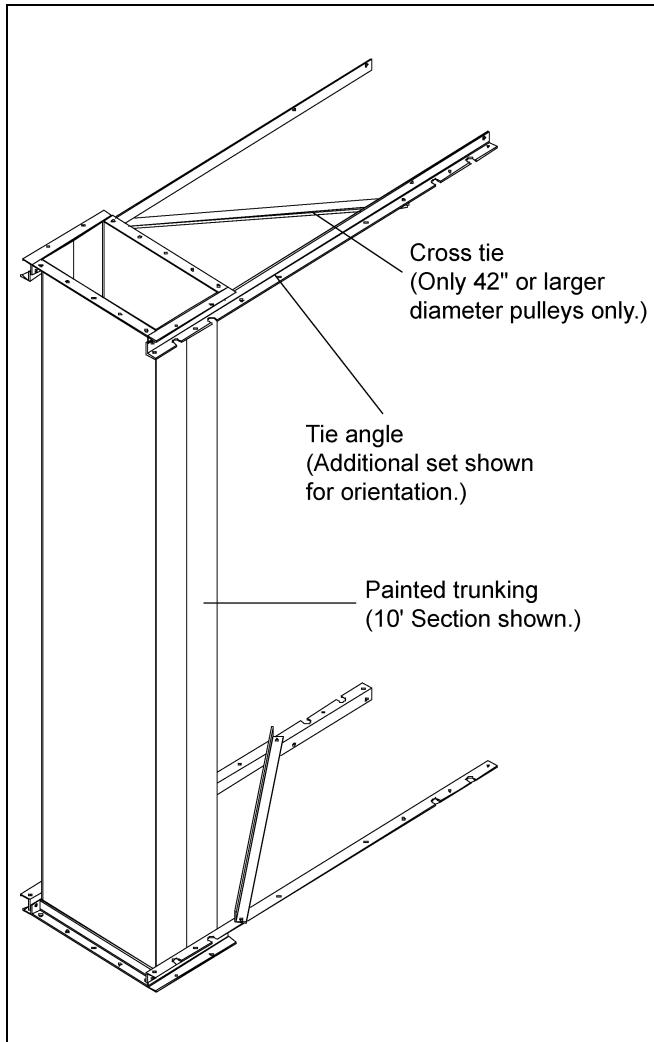


Figure 7A Painted Trunking

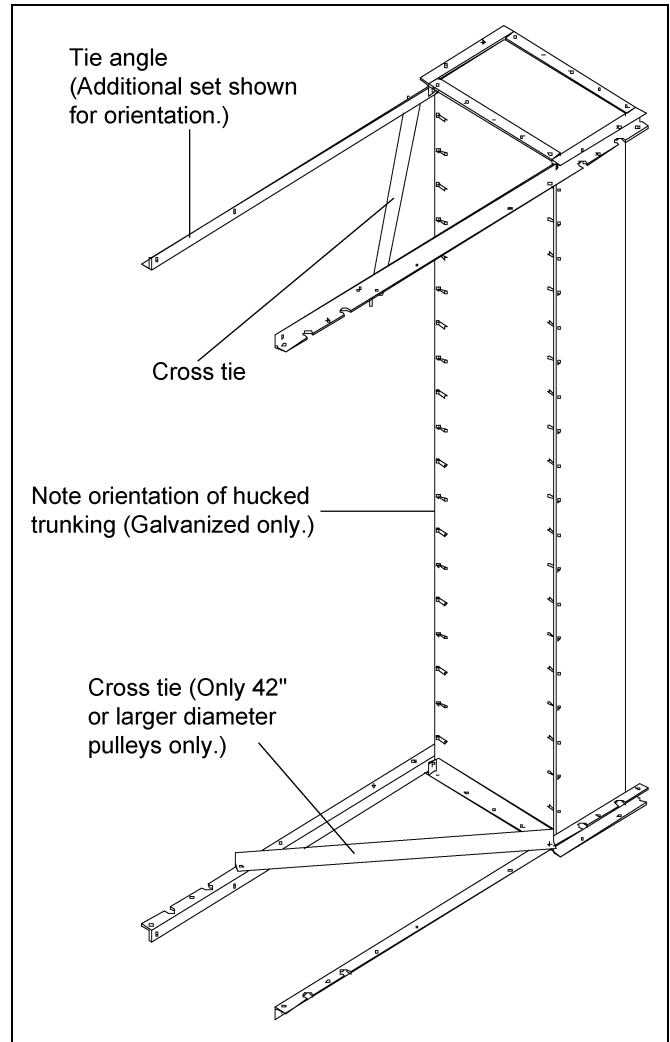


Figure 7B Galvanized Trunking

7. Trunking

Pressure Relief Trunking

Pressure relief trunking is standard trunking that has been modified to include two (2) panels specifically designed for pressure relief.

NOTE: *This unit requires special attention to the relief panel. This area must be inspected for damage to the panel, frame and particularly the hardware. DO NOT INSTALL TRUNKING IF THERE IS ANY APPARENT DAMAGE OR DEFECT.*

1. These panels will be located on the short sides of the trunking directly opposite of each other and centered on ten foot (10') sections of trunking.
2. Two (2) tie angles are included with the mounting hardware.
3. Systems utilizing 42" diameter and larger pulleys require the installation of a cross tie located on the legs. (See Figure 7C.)



Remove all shipping bolts in the pressure relief panels prior to operating any bucket elevator.

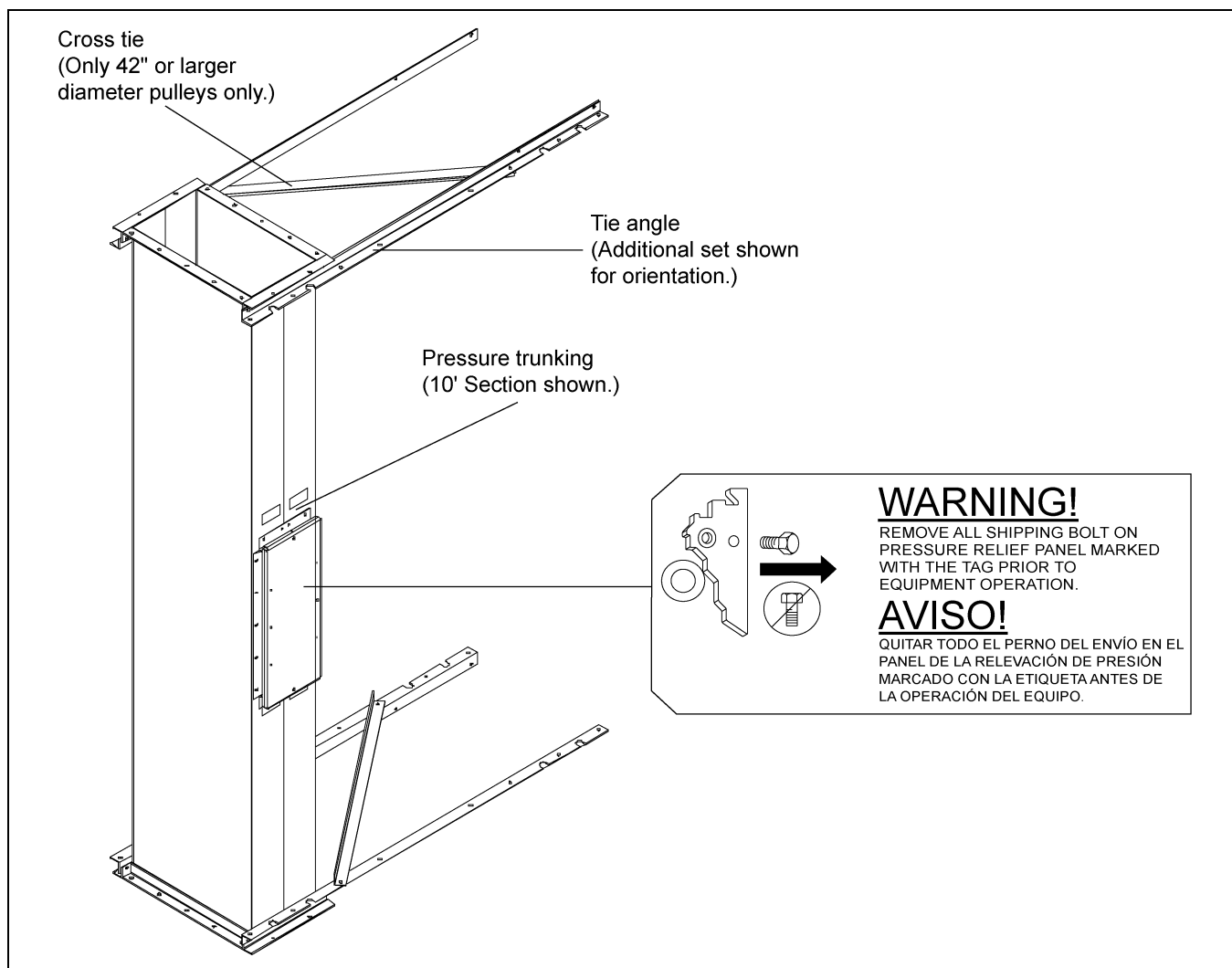


Figure 7C Pressure Relief Trunking

Trunking Installation

Prior to any trunking installation, inspect for damage to equipment. Immediately repair or replace defective item(s).

NOTE: Always assemble trunking sections on a level surface.

1. Section together to make double trunking.
2. Attach tie angle to single trunking as shown in [Figure 7D](#). (If 42" diameter or larger install cross tie angle.)
3. Multiple sections can be ground assembled.
4. Make sure sections are assembled straight, without twist.
5. Caulk all mating companion angle surfaces to ensure water and dust resistance.

NOTE: Do NOT assemble more than thirty (30) linear feet at any time.

NOTE: It is important to maintain plumb and square trunking in all directions.

- Guy and plumb trunking in all directions after installing each section.
- Check levels through legging installation process.
- Check all connecting hardware is secure after each installation.

NOTE: Attachment bolt holes in the tie angles are intentionally tight for the 1/2" diameter bolts. This helps ensure more precise plumbing of the trunking. Never drill these holes out for easier installation.



NEVER drill out attachment holes for easier installation of the 1/2" diameter bolts. If bolts are hindered going through hole, thread bolts through to reduce chances of damaging threads.

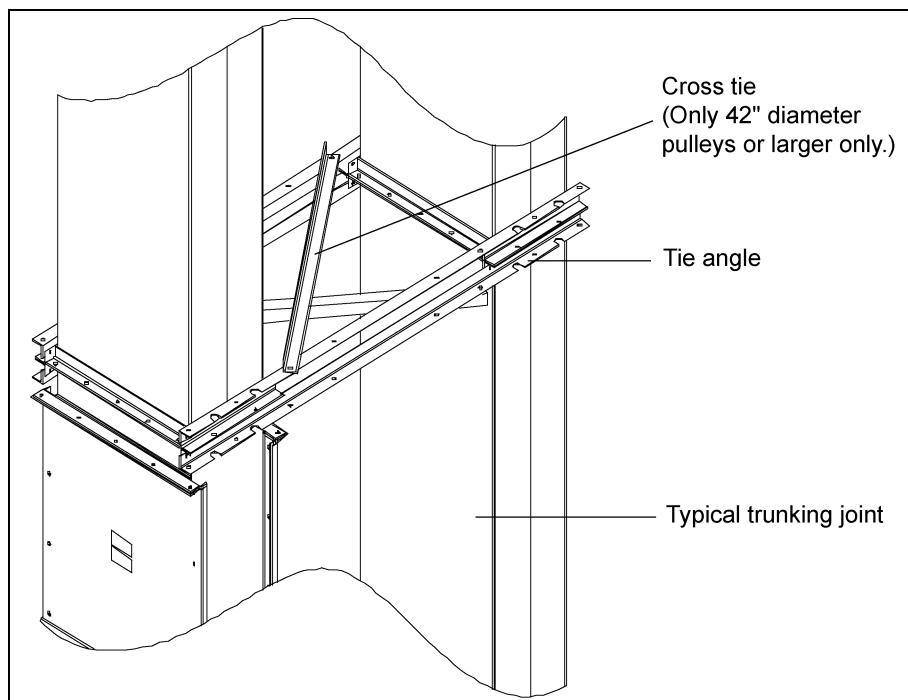


Figure 7D Trunking Joint

8. Lower Head Section

The Bucket Elevator lower head section is primarily assembled at the factory.

1. The installation hardware used to attach the head section to the trunking system is included with the shipment.
2. The drive is shipped separately from the lower head section.
3. Inspect all parts for damage and to ensure that all hardware is secure prior to proceeding with installation. (See Figure 8A.)

Head Bonnet Section

The bonnet has been designed in two-piece construction to allow the front (discharge) side to slide forward and clamp in place for maintenance to the belt, buckets, pulley, etc.

1. The rear (up-leg) side bonnet on 30" Bucket Elevators and larger sizes includes factory installed pressure relief panels. These panels should be carefully inspected for damage including screws and washers.
2. Pressure relief vent door should not be altered in any way, except to remove shipping bolts.
3. Motor mount and torque arm must be adjusted to fit the drive package per supplied detail.
4. Hardware used to attach bonnet section to head section is included. (See Figure 8B on Page 23.)



Use bonnet section 'U-lugs' to lift *ONLY* the bonnet section.



NEVER lift or lower the bonnet section together with the lower head section.



Remove all shipping bolts in the pressure relief panels prior to operating any bucket elevator.

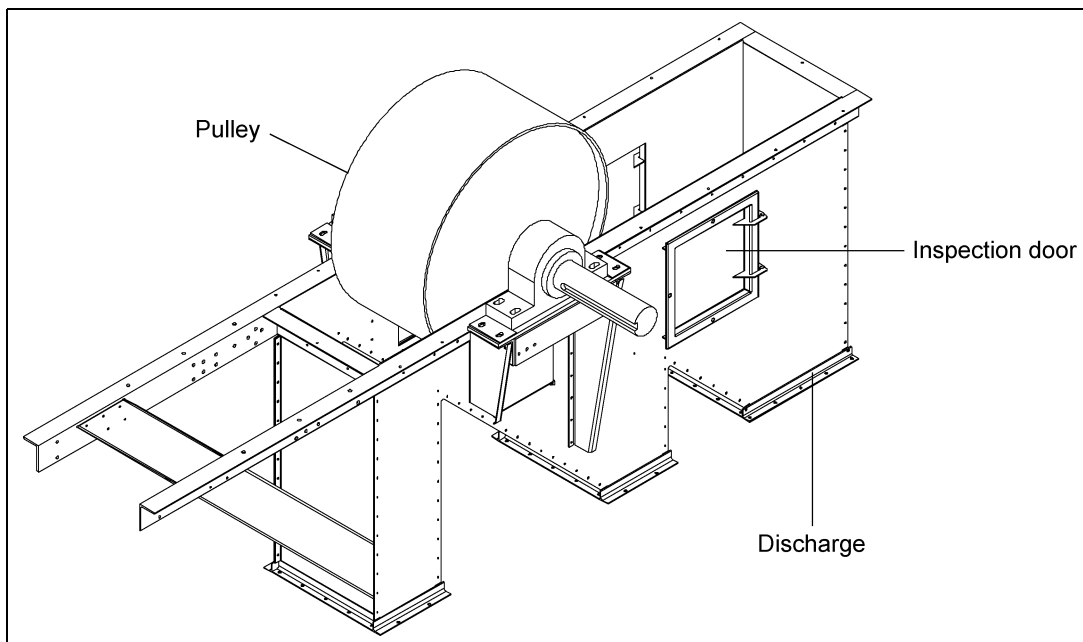
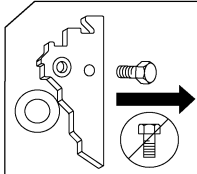


Figure 8A Lower Head Section

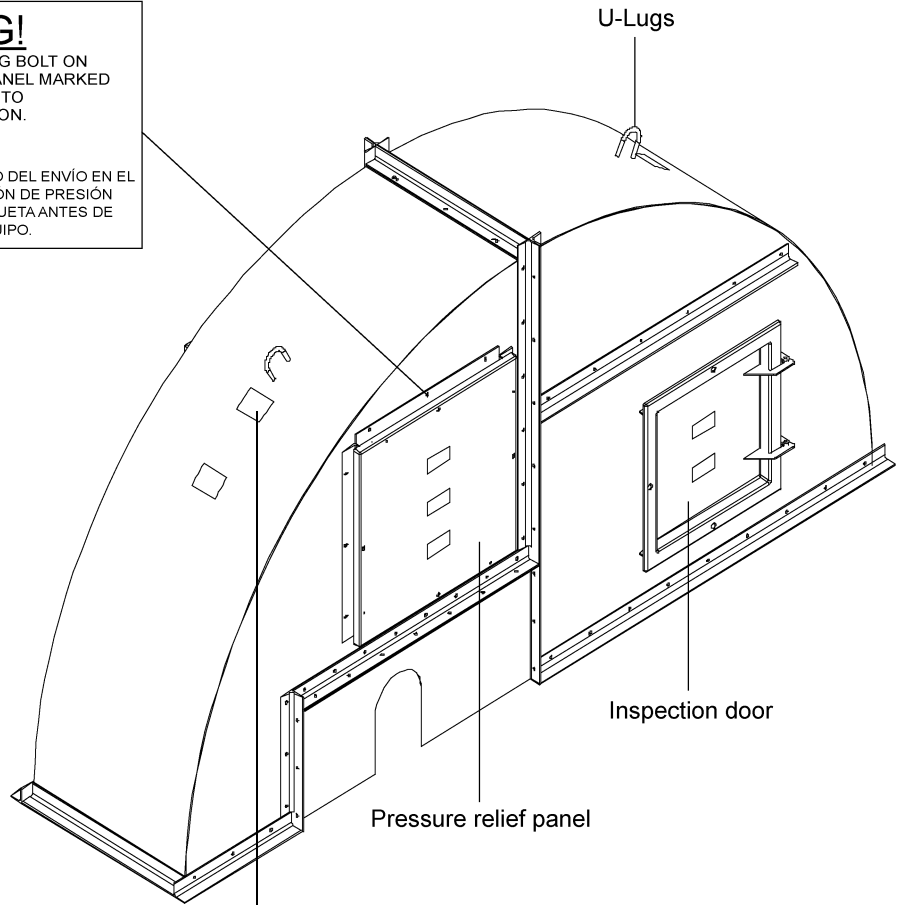


WARNING!

REMOVE ALL SHIPPING BOLT ON PRESSURE RELIEF PANEL MARKED WITH THE TAG PRIOR TO EQUIPMENT OPERATION.

AVISO!

QUITAR TODO EL PERNO DEL ENVÍO EN EL PANEL DE LA RELEVACIÓN DE PRESIÓN MARCADO CON LA ETIQUETA ANTES DE LA OPERACIÓN DEL EQUIPO.



 DANGER	
 Lift Bonnet Only. Correct	 Incorrect
<p>CRUSH HAZARD. Failure of U-Lug Welds can occur from over stress. Lift only Bonnet section with U-Lugs. Death or serious injury can occur. DO NOT Lift Bonnet and Lower Head Sections assembled together.</p>	
<small>CSI Group 217-226-4421</small>	<small>DC-1601</small>

Figure 8B Head Bonnet

9. Maintaining Plumbness

To ensure proper bucket elevator plumbness, set up two (2) transits, one in each direction. Refer to [Figure 9A](#) for proper tolerance in elevator erection.

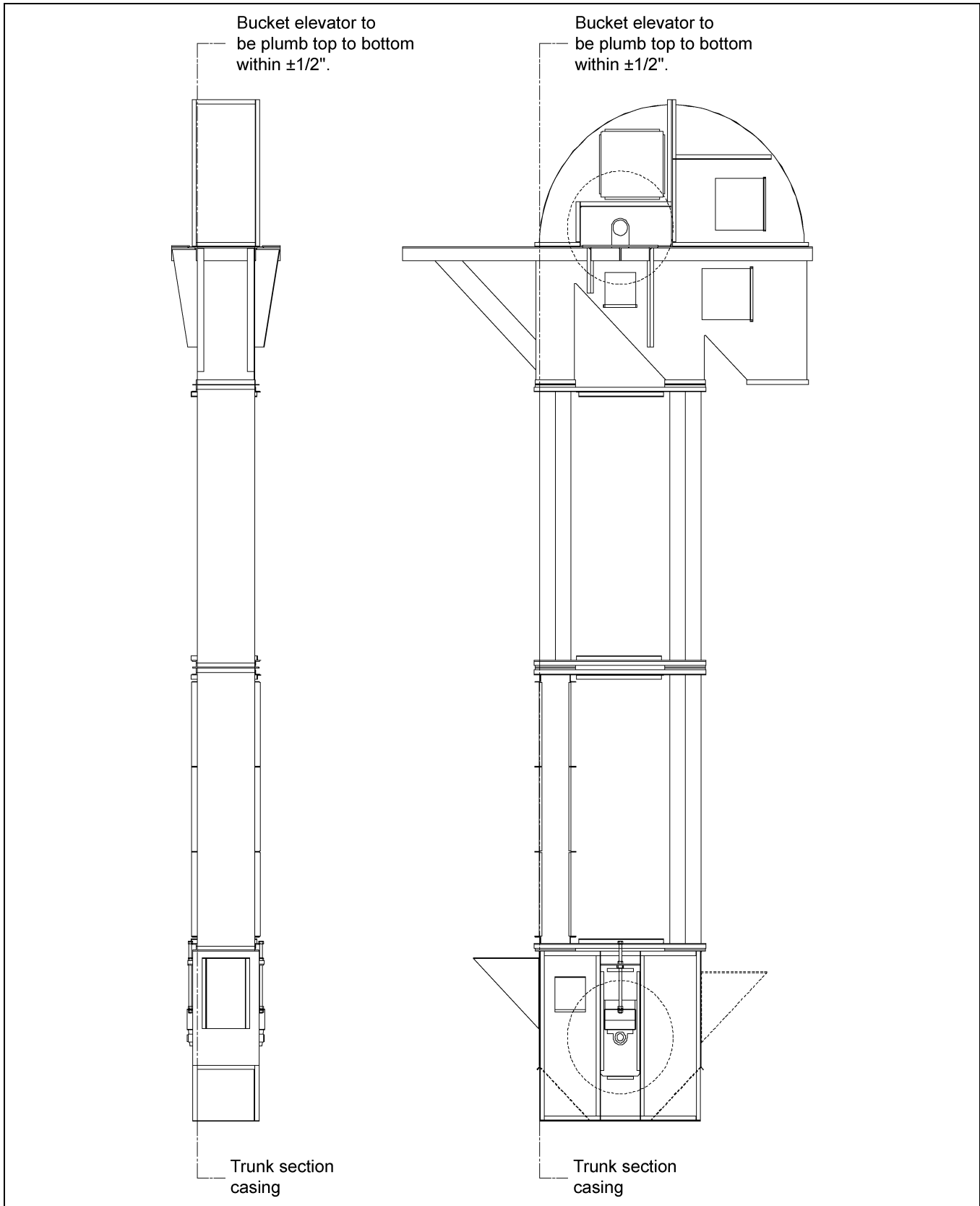


Figure 9A Plumbing Tolerance

Belts

The belt for the elevator leg has been specifically chosen based on leg height, grain, weight, pulley diameter, etc.

The belt has been pre-punched to accommodate special buckets with specific spacing.

Installing the belt can be accomplished several different ways. GSI recommends the following:

1. Prior to installing the belt, raise the boot pulley to its upper most point to allow for proper tensioning.
2. On shorter installations, consider assembling the buckets to the belt before installing the belt. While this may be less time consuming, the additional weight of the buckets and connecting hardware may make the belt more difficult to handle.
3. Feed belt up through the inspection section, over the head pulley, through the down-leg, around the boot pulley and back up to the splice.



To prevent the belt from rolling over the top, anchor the upper end securely.

Splicing

After connecting the ends of the belt together, a winching device such as a come-a-long may be required.

GSI recommends splicing the belt by overlapping the belts or by using the bar splice method.

1. When overlap splicing, draw a 5' minimum of the belt coming up from the bottom of the boot over belt hanging down from head. *(See Figure 10A.)*
2. An alternative method, the bar splice (not included) is accomplished by turning the ends of the belt out and affixing the manufactured bar splice components per the manufacturer's recommendations.

NOTE: *Lacing and other specific types of belt splicing are NOT recommended.*

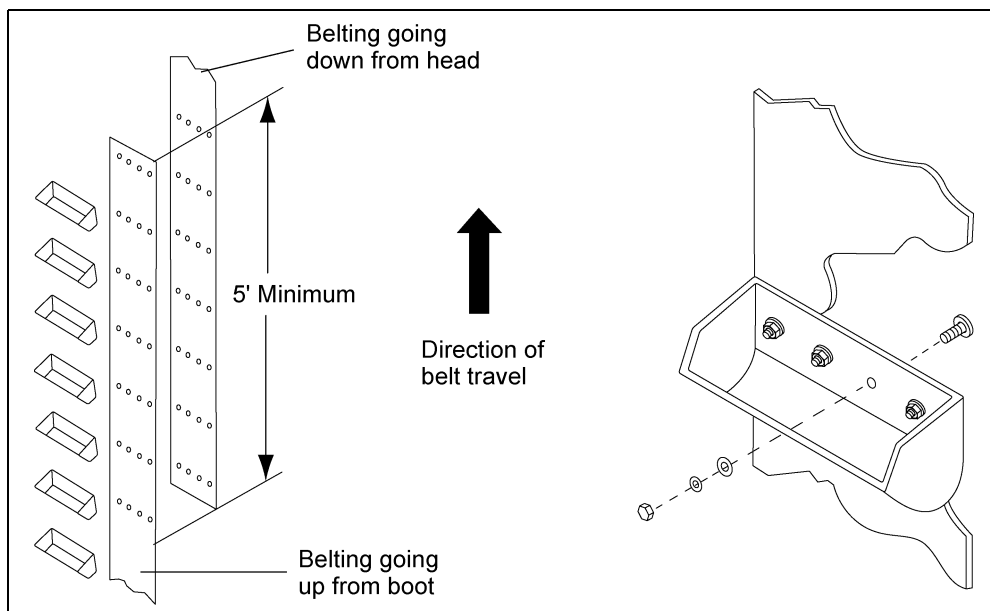


Figure 10A *Belt Splicing*

10. Belting, Splicing and Buckets

Buckets

Buckets are attached to belting using elevator bolts pushed through the belting back side, through the elevator bucket, a flat (fender) washer, a lock washer and a nut.

1. Secure bucket by tightening nut to slightly indent belt back with bolt head.
2. Remember to leave buckets off near the splice area, if installing buckets prior to belt installation.
(See Figure 10A on Page 25.)



DO NOT OVER TIGHTEN BOLTS.

Torque requirements are as follows:

- 50" pounds for 1/4" bolts
- 96" pounds for 5/16" bolts
- 180" pounds for 3/8" bolts



Over tightening can lead to breakage.

3. ALWAYS re-check bolts for correct torque after initial start-up and periodically thereafter.

Belt Slack Removal

Remove any slack in belt after splice connection by lowering boot pulley. It is important that the boot pulley and shaft are checked and maintained to be horizontally level.

Manual Screw Take-Ups

1. Turn the take-up screws on each side of the boot to control the boot pulley position.
2. After each adjustment, ALWAYS lock each take-up screw in position with the lock nut provided.

Gravity Take-Ups

Weight provides the tensioning method for gravity take-up.

NOTE: *The weight box may not require any additional weight because the weight of the belt, cups, weight box assembly and boot pulley assembly provide adequate tensioning in the belt to eliminate slippage at the head pulley.*

If additional weight is needed:

1. Add weights (not included) - Do not use increments of greater than 100 pounds.
2. Equally distribute weight from side to side for proper belt tracking.
3. Use the bearing plate adjustment screws to level the boot pulley after any needed weight is added.

10. Belting, Splicing and Buckets

4. Loosen the bolts attaching the channels of the weight frame assembly to the bearing plate assembly before adjusting the bearing screws.
5. After adjustments have been made, re-tighten bolts and snug the bearing plate adjustment screw lock nuts. (See Figure 10B.)

NOTE: Lowering the bearing plate which the belt is tracking towards on the boot pulley should cause the belt to track back towards the center of the pulley. Inversely, raising the bearing plate which the belt is tracking away from will also center the belt.

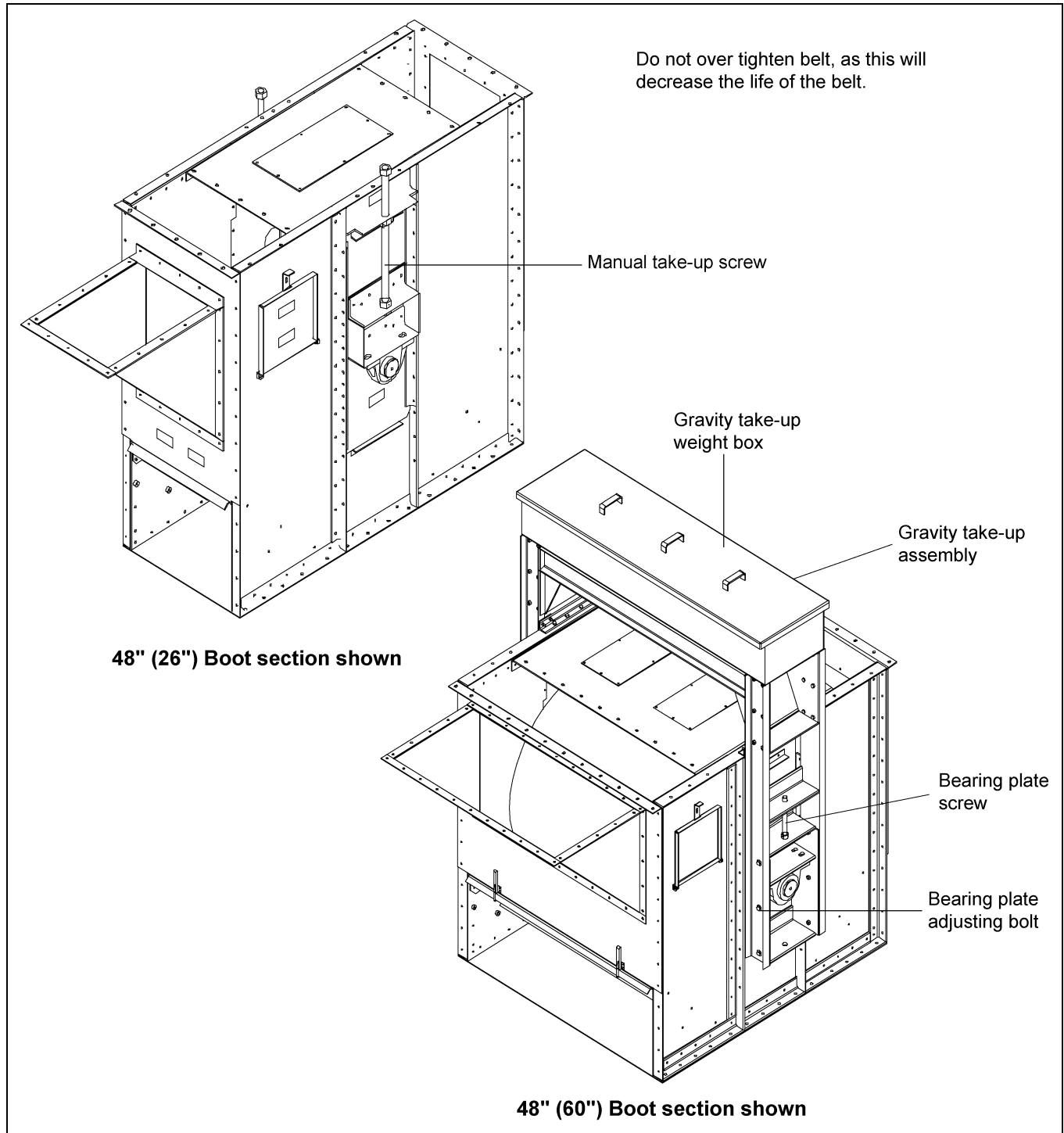


Figure 10B Take-Ups

11. Drive Motor and Motor Mount

Drive

The following assembly instructions are for standard drives as purchased with the elevator. The standard drive is designed using the Dodge Torque Arm II shaft mount reducer. Details for this application are included in the appendix section [on Page 38](#).

If you purchased a special drive or drive components from another source, refer to manuals supplied with these materials.

1. The drive assembly is designed so that the same components fit a left or right hand drive application.
2. If facing the head side, the reducer is between you and the head and the head discharge is on the right hand side of you, then you have a right hand drive application.
3. If the head discharge is on the left side of you, then you have a left hand drive application.

The [Figure 11A below and Figure 11B on Page 29](#) shown for a right hand application.

Motor Mount Assembly

1. Locate the side of the motor mount which has two (2) decals affixed. ([See Figure 11A.](#)) One decal will have “L.H.” for left hand and one will have “R.H.” for right hand.
2. Place the motor mount with decals facing away from the pulley towards the end of the head bearing angles.
3. Note the horsepower, class rating and drive application side on the decals. Follow the indication line next to those numbers to where it points down to the bottom of the motor mount.
4. Slide the motor mount in or out while keeping the decal correctly aligned with the outside toe of the head bearing angle. ([See Figure 11B on Page 29.](#)) This will align the holes in the head bearing angles to the proper holes in the motor mount assembly.
5. Using the proper hardware, bolt the motor mount down to the head bearing angles. ([See Figure 11A.](#))

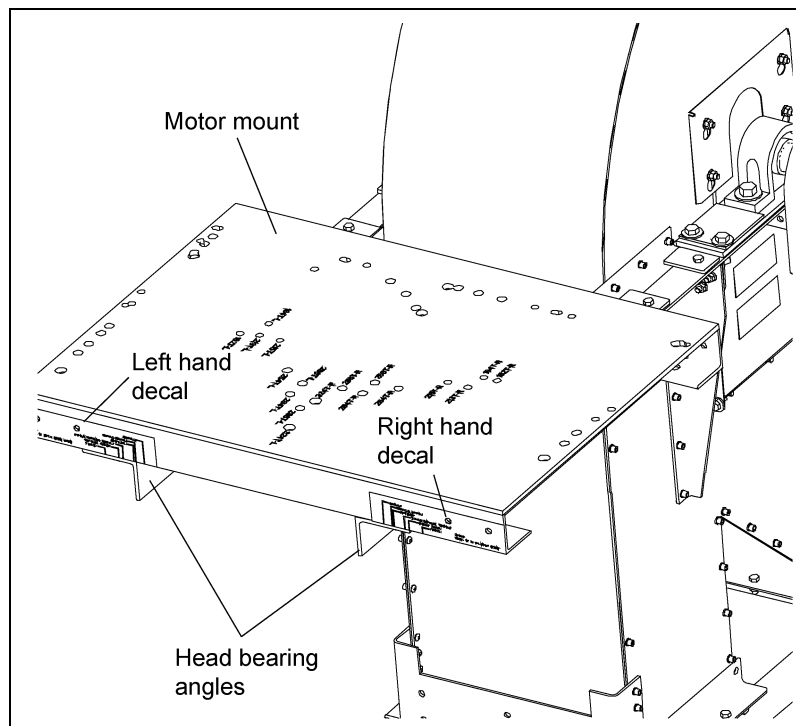


Figure 11A Motor Mount Plate

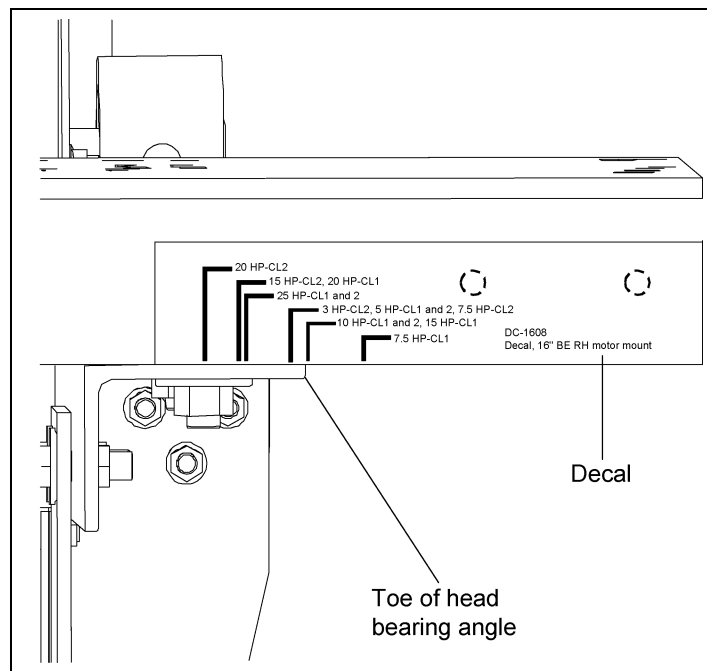


Figure 11B Right Hand Motor Placement Decals

Slide Base

1. Place the motor slide base upon top of the motor mount, with respect to the drive application side.
2. Place the motor onto the motor slide base and position the motor as close as possible toward the pulley.

NOTE: The slide base will fit in only one set of holes. (See Figure 11C.)

3. Position the tensioning bolt so that tightening pulls the motor AWAY from the pulley.
4. Using the proper hardware, bolt the slide base to the motor mount.

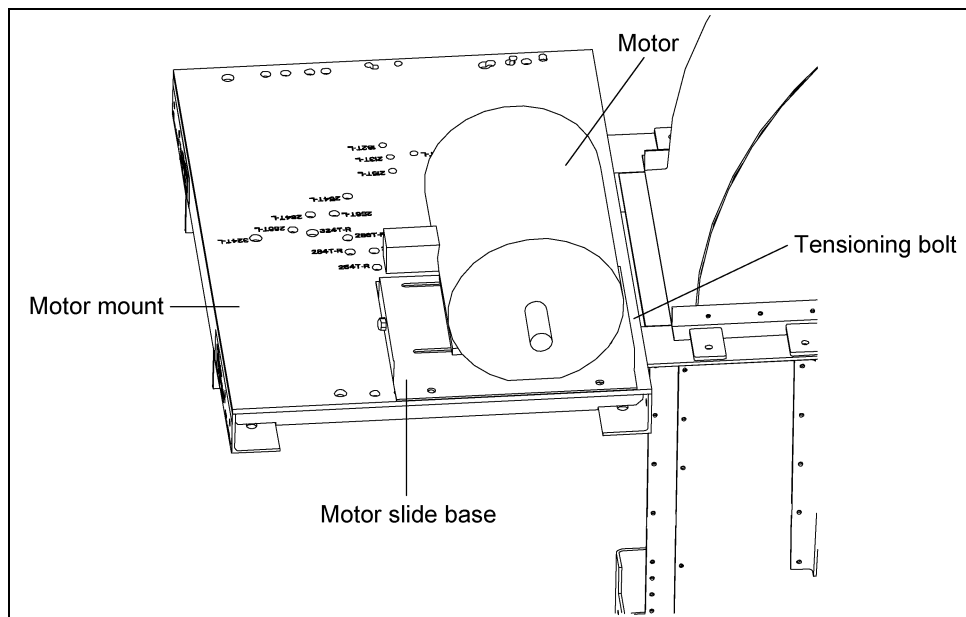


Figure 11C Motor Slide Base

11. Drive Motor and Motor Mount

Torque Arm

1. Place the torque arm tube assembly on the head section by sliding the two (2) gussets of the torque arm assembly between the head bearing angles.
2. Make sure the locking bolts face away from the head section.
3. Attach with the proper hardware. (See [Figure 11D](#) and [Figure 11E](#).)

NOTE: On 16" and 24" elevators, the torque arm tube will slide in and out freely with the motor's torque causing a positive lock situation.

NOTE: In 30" and large elevators, loosen the three (3) locking bolts and place the torque arm foot mounting tube in the torque arm assembly such that the foot mounting bracket is to the side in which the reducer will be mounted. Wait until the reducer is set on the shaft to re-tighten the locking bolts.

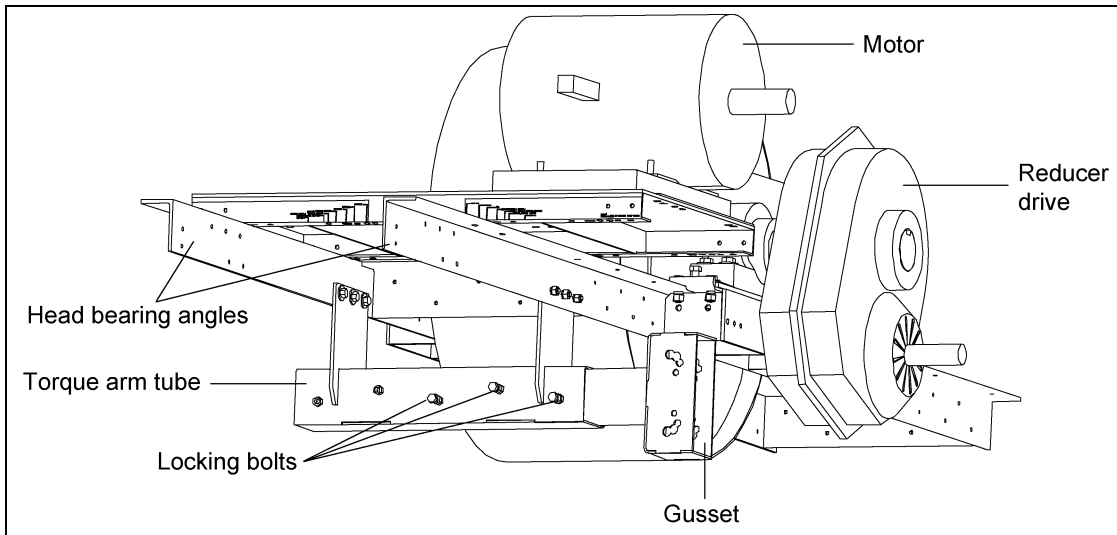


Figure 11D Torque Arm (30"-48")

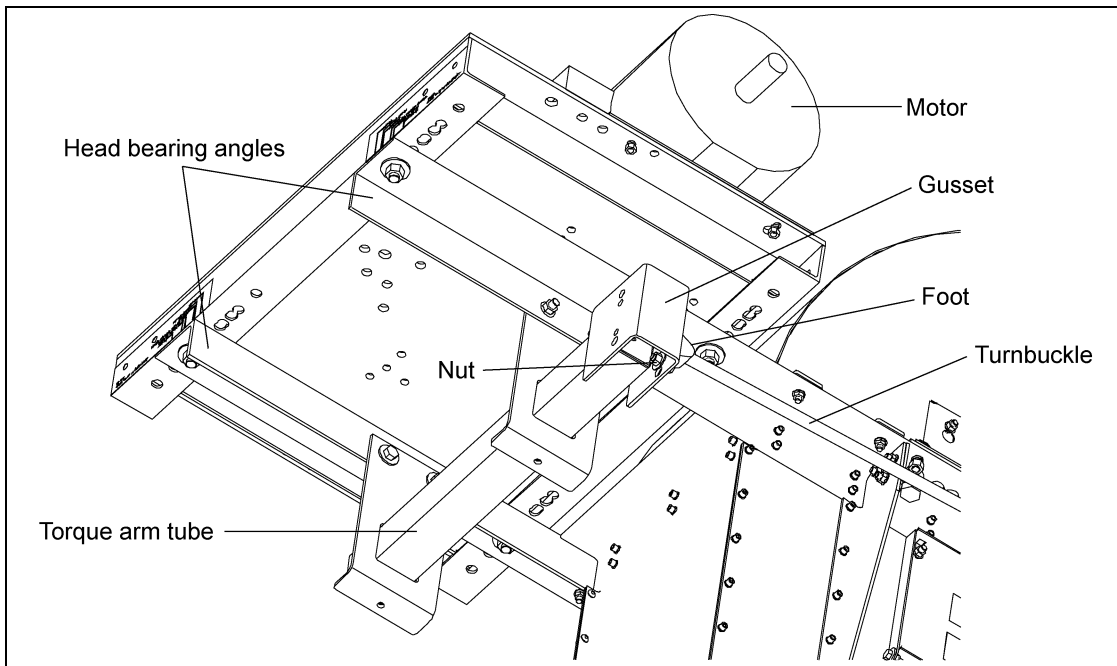


Figure 11E Torque Arm (16"-24")

Shaft Mount Reducer

For reducer assembly, [See Page 38](#) of the Torque Arm II reducer installation appendix which has detailed instructions for the reducer bushing mounting, cooling fans and backstops.

Once the reducer is assembled:

1. Attach the torque arm turnbuckle assembly to the reducer with proper hardware.
2. Attach the torque arm foot to the foot mounting bracket of the torque arm tube using the proper hardware.

Drive Guard

1. Attach the drive guard brackets to the motor mount assembly. ([See Figures 11F-11J on Pages 32-34.](#)) The shorter, broken legs of the brackets will point towards the pulley.
2. Align the guard rear panel of the guard to the brackets. NOTE, in a right hand drive application (as shown in [Figures 11F-11J on Pages 32-34](#)) the flanges of the guard rear panel will face away from the head section, but in a left hand application, the flanges will point towards the head section.

NOTE: *The wider, larger hole in the guard rear panel is intended for the motor output shaft. The guard rear panel will attach only in one orientation.*

3. Once rear panel is bolted on, attach the drive guard struts to the bearing support of the head section and to the rear panel.
4. Using hardware, bolt the two (2) struts together. All brackets are designed to be adjustable.
5. Place sheaves onto the output shaft of the motor and the input shaft of the reducer.
6. Place belts upon the sheaves and tension as needed.

NOTE: *Reducer may need to be rotated, clockwise or counterclockwise, in conjunction with slide base adjustments, to achieve correct center distance for the drive belts. Move the location of the reducer torque arm turnbuckle to achieve this rotation, as needed.*

NOTE: *Belts are designed specifically per application.*

7. With drive belts tensioned and reducer rotated (if necessary), tighten all bolts.
8. Install the safety screen around the motor output shaft by approximating the hole location to the screen and snipping a clearance hole in screen. ([See Figure 11F on Page 32.](#))
9. Attach using proper hardware.
10. Attach belt guard cover, latch and bolt.

NOTE: *Shaft mount reducers are shipped without lubricant.*



NEVER operate the elevator until the gear reducer has been filled with an approved lubricant as noted in the Torque Arm II appendix section on [Page 38](#).

11. With the reducer in vertical position, fill with lubricant until oil runs out of oil level plug.

NOTE: *See the appendix section on [Page 38](#) for volume of oil per reducer size.*

11. Drive Motor and Motor Mount

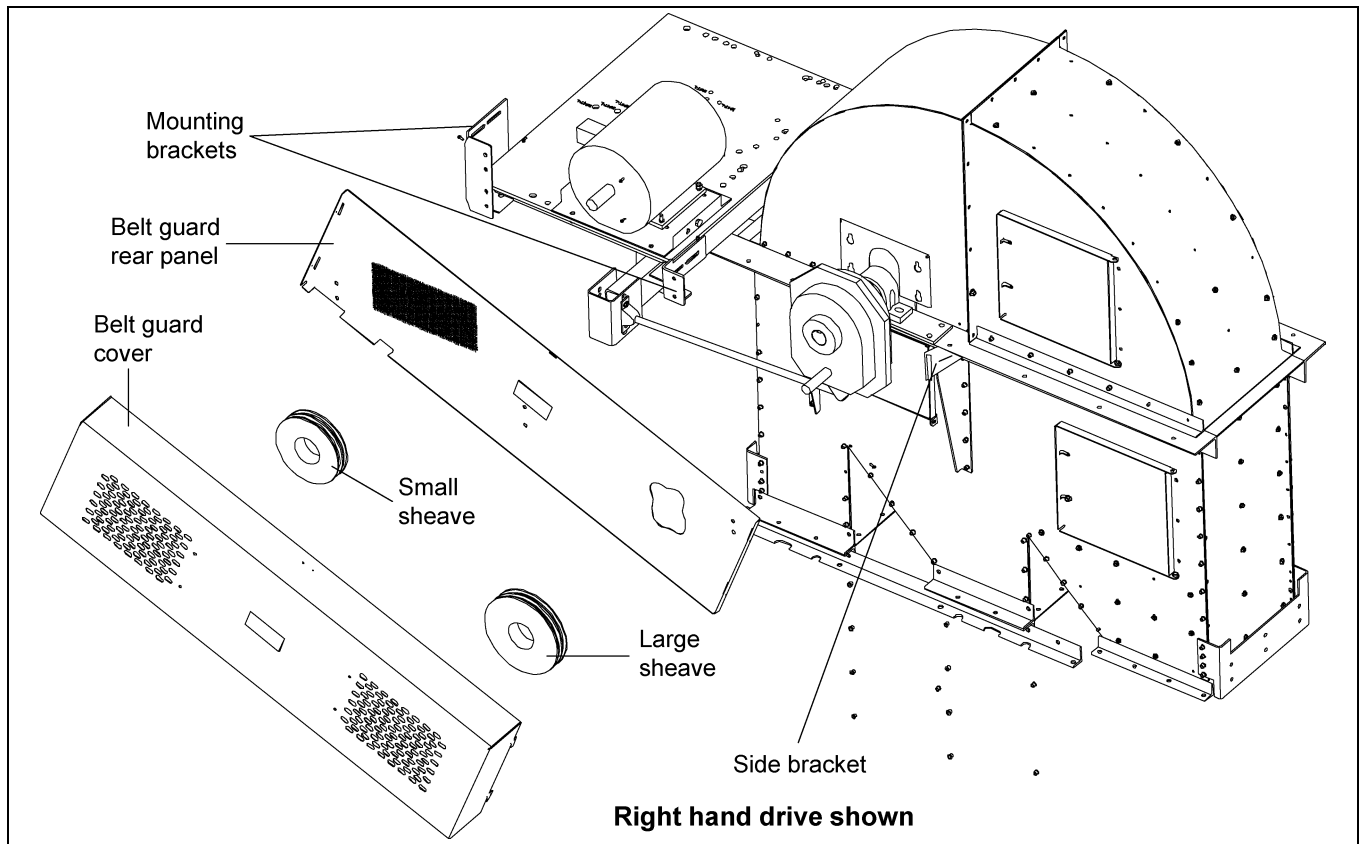


Figure 11F Belt Guard

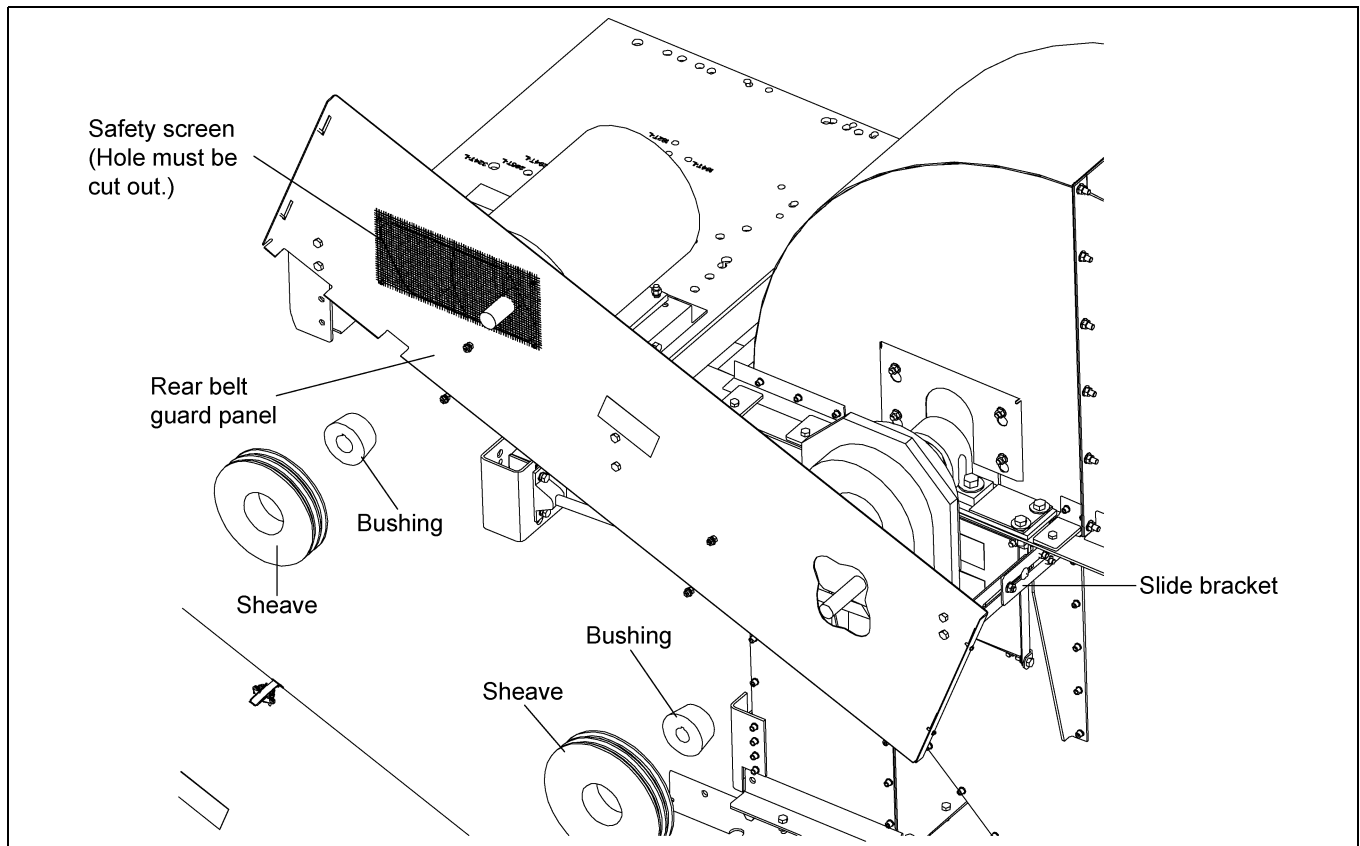


Figure 11G Belt Guard Mounted to Brackets

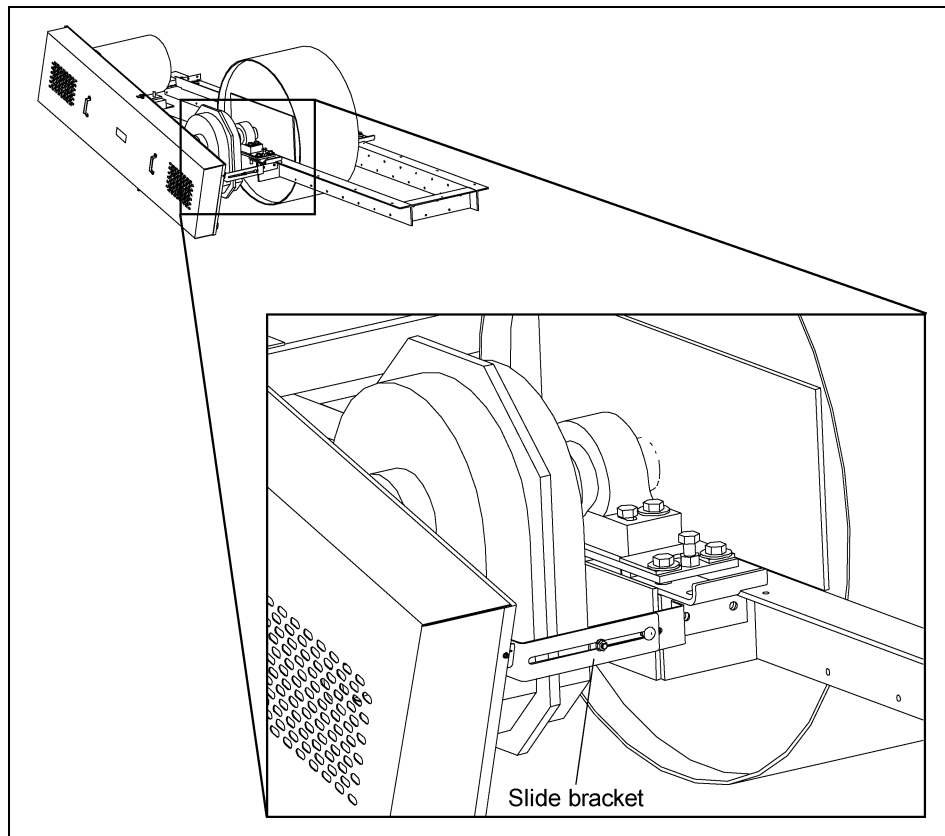
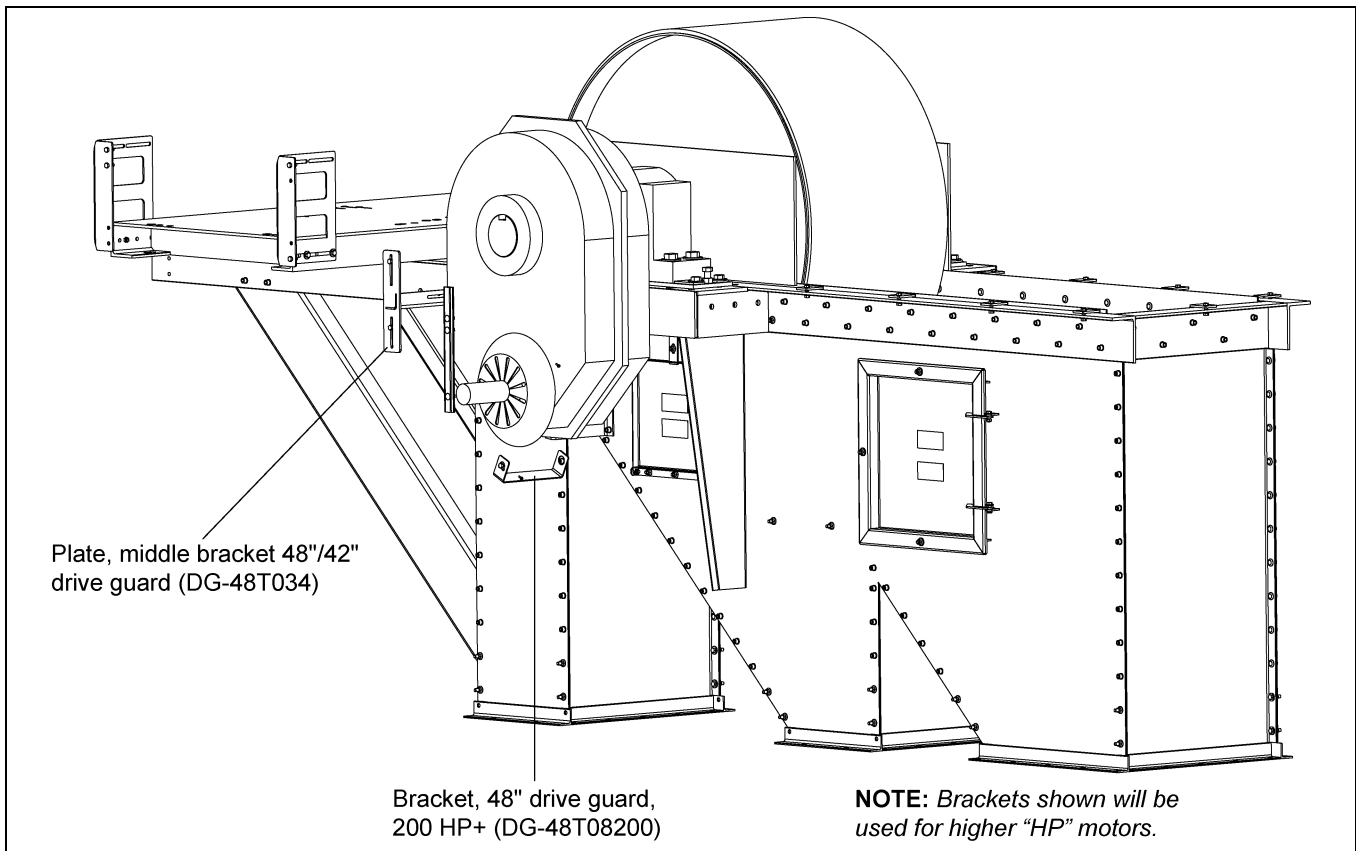


Figure 11H Slide Bracket



Bracket, 48" drive guard,
200 HP+ (DG-48T08200)

NOTE: Brackets shown will be
used for higher "HP" motors.

Figure 11I Brackets - Use for Higher HP Motors

11. Drive Motor and Motor Mount

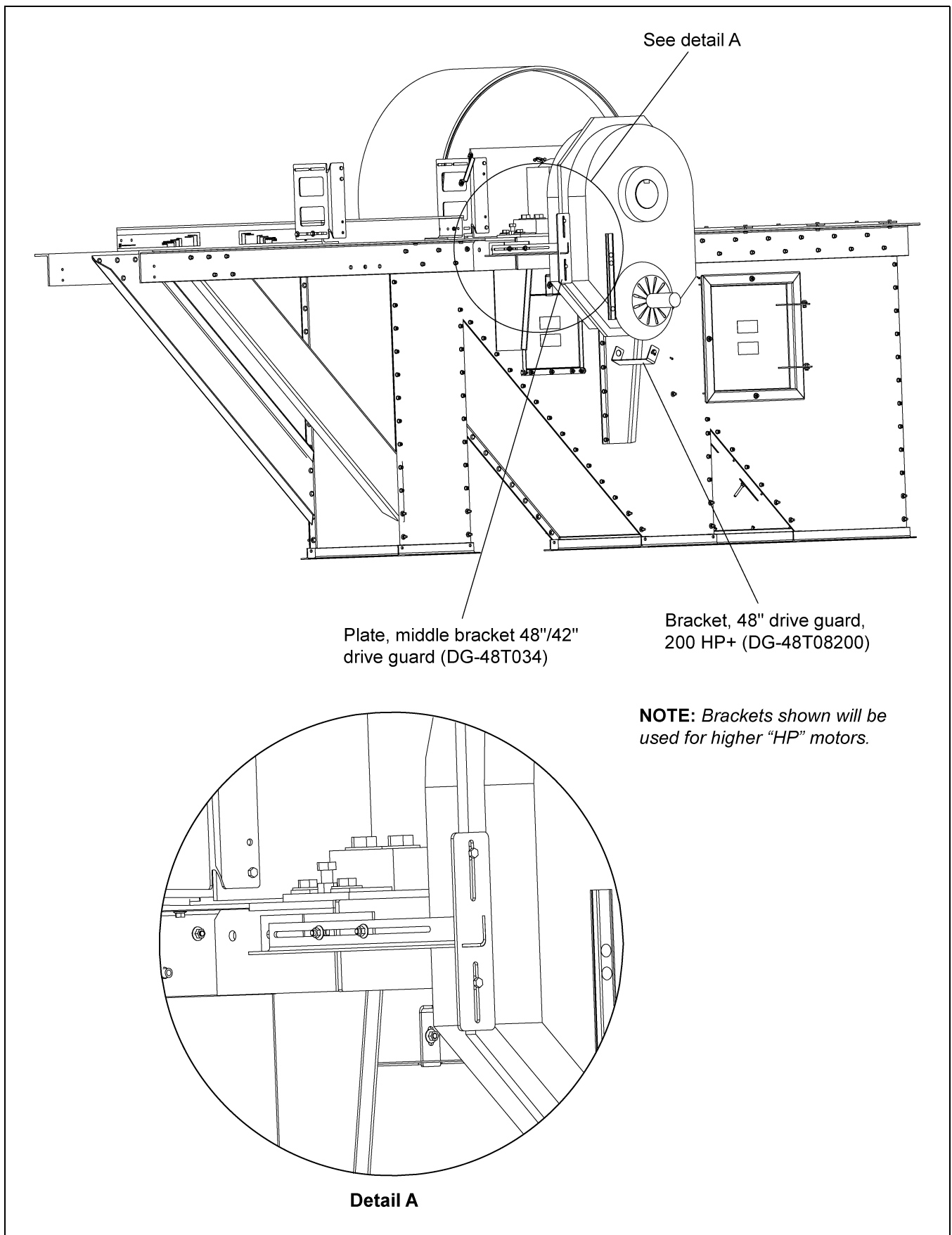


Figure 11J Brackets - Use for Higher HP Motors

Drive Belts

Drive belts are designed to fit loosely upon installation.

Use the motor mount adjustable slide base to properly tension belts to acceptable levels.

Proper tension is $1/64$ " of deflection per, 1" of sheave centers on one side of belt, centered between sheaves. (See [Figure 11K.](#))

NOTE: *Too much tension shortens belt life. Check belt tension frequently during the first 24-48 hours of operation.*

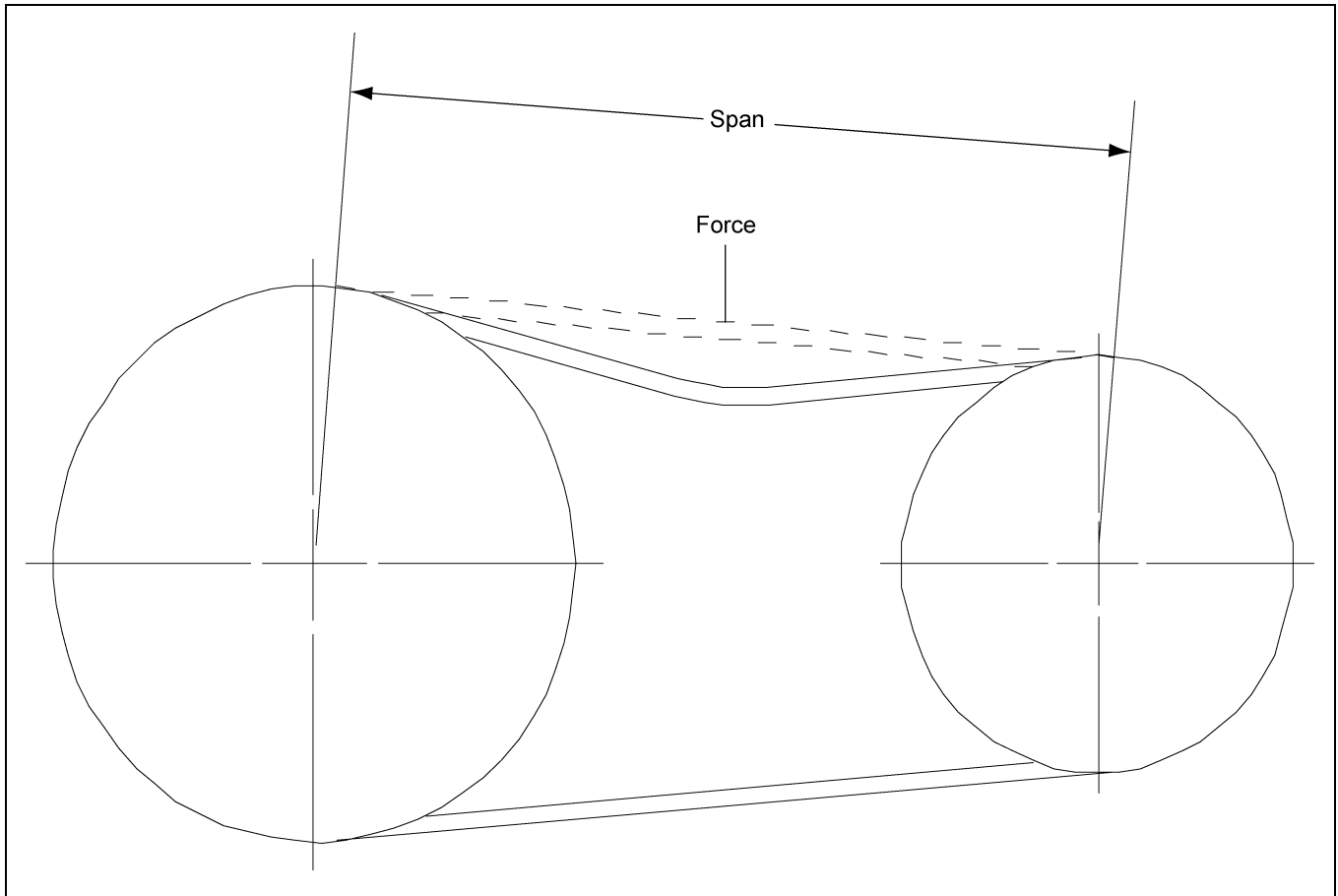


Figure 11K Drive Belt

General Final Checks

1. Adjust the throat plate in the head discharge so there is approximately 1/4" clearance between it and edge of the buckets on the lap splice. (See Figure 12A.)

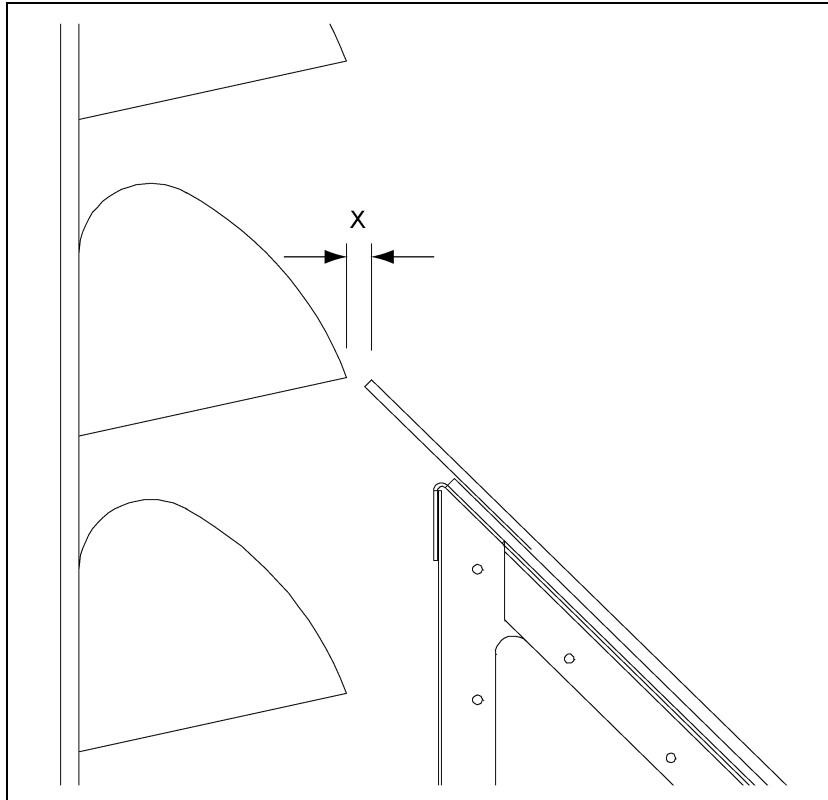


Figure 12A Throat Plate



1. **Check clearance at the lap splice.**
2. **Do a final check of all parts to be sure all hardware is tight and no foreign objects or tools are left inside elevator.**
3. **Check all guards, inspection doors and removable plates to be sure they are in place and secure.**
4. **Tighten the take-up screws on the boot evenly to tighten the belt on the pulley, keeping bottom pulley level and work from side to side in small amounts until belt is tight.**
5. **Rotate by hand or carefully jog drive to check for proper rotation, clearance and operation of entire unit. Make any adjustments necessary.**
6. **Jog the drive a minimum of one complete revolution of belt. If no problems exist, carefully run the bucket elevator.**

Belt Tracking

Tracking of the belt is very important for optimum results.

1. To correct any tracking problems.
 - First adjust the boot bearing plates.
 - Adjust the take-up screws downward on the side that the belt is tracking toward.
2. If this does not correct the problem or if the belt is tracking properly on the boot pulley but not the head pulley, further adjustments to the head pulley may be required.
3. The bearing side that the belt is tracking toward may need to be shimmed to compensate.
 - Loosen the head bearing bolts that go through the head angle.
 - Use the jacking screws to raise the bearing.
 - Place a full shim the bearing base.
 - Back off the screws.
 - Re-tighten the bearing mounting bolts.

NOTE: *Use thin shims to make small adjustments until the belt tracks properly.*

Start-Up

Once you are sure all installations, safety checks, adjustments and lubrications have been completed:

1. Run the elevator for WITHOUT LOAD an initial break-in period of several hours.
2. Look and listen for any irregularities before running any material through the unit.
3. Re-check all moving parts and adjust as needed.
4. Adjust belt for final tension under load as needed.

Maintenance

Regularly scheduled maintenance helps ensure long life and safe operation of the unit.

1. Routine maintenance checks may include general wear, loose nuts and bolts, electrical wiring, contacts, switches, misalignment, guy wire inspection, bearing seals and lubrication and oil content for gearbox.
2. The belt will stretch after installation and may need further adjustment. Expect some stretching during the first few weeks of operation.
3. On manual take-up boots, belt tension should be maintained by turning the boot take-up screws slowly and evenly to maintain proper tracking. When the screw adjustment is completely used, the belt will have to be re-spliced.

NOTE: *Good belt tension is critical for proper traction on the pulley and optimum performance.*

13. Appendix 1 - Reference Information

Information regarding the torque arm, roller bearings and pillow blocks can be downloaded from the Baldor website.

Go to www.baldor.com/support/product_manuals.asp

Enter the required manual number into the search field. See list below.

MN1601 - Dodge Torque-Arm II Speed Reducer Installation

MN3033 - Dodge S-2000 Spherical Roller Bearings

MN3040 - Dodge TAF Pillow Blocks and S-1 Units

Limited Warranty — N.A. Grain Products

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

Conditions and Limitations:

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The sole and exclusive remedy for any claimant is set forth in this Limited Warranty and shall not exceed the amount paid for the product purchased. This Warranty only covers the value of the warranted parts and equipment, and does not cover labor charges for removing or installing defective parts, shipping charges with respect to such parts, any applicable sales or other taxes, or any other charges or expenses not specified in this Warranty. GSI shall not be liable for any other direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. Expenses incurred by or on behalf of a claimant without prior written authorization from the GSI warranty department shall not be reimbursed. This warranty is not transferable and applies only to the original end-user. GSI shall have no obligation or responsibility for any representations or warranties made by or on behalf of any dealer, agent or distributor. Prior to installation, the end-user bears all responsibility to comply with federal, state and local codes which apply to the location and installation of the products.

This Limited Warranty extends solely to products sold by GSI and does not cover any parts, components or materials used in conjunction with the product, that are not sold by GSI. GSI assumes no responsibility for claims resulting from construction defects, unauthorized modifications, corrosion or other cosmetic issues caused by storage, application or environmental conditions. Modifications to products not specifically delineated in the manual accompanying the product at initial sale will void all warranties. This Limited Warranty shall not extend to products or parts which have been damaged by negligent use, misuse, alteration, accident or which have been improperly/inadequately maintained.

Notice Procedure:

In order to make a valid warranty claim a written notice of the claim must be submitted, using the RMA form, within 60 days of discovery of a warrantable nonconformance. The RMA form is found on the OneGSI portal.

Service Parts:

GSI warrants, subject to all other conditions described in this Warranty, Service Parts which it manufactures for a period of 12 months from the date of purchase unless specified in Enhancements above.

This equipment shall be installed in accordance with the current installation codes and applicable regulations, which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.



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