Series II Incline Chain Conveyor

Installation and Operation Manual

PNEG-1187

Date: **12-21-20**

PNEG-1187

Use of the Equipment Information page will help you identify the equipment in the case that you need to call your dealer or installer. This information should be filled out and kept on record.

Equipment Information

Model Number:_____

Serial Number:_____

Date Purchased: _____

Dealer/Distributor Name and Phone Number:

_____

_____

_____

_____

Material Handling

1004 E. Illinois St.
Assumption, IL 62510-0020
Phone: 1-217-226-4421
Fax: 1-217-226-4420
www.gsiag.com

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.

Contents

1. Introduction

READ THIS MANUAL carefully to learn how to properly use and install equipment. Failure to do so could result in personal injury or equipment damage.

INSPECT the shipment immediately upon arrival. The customer is responsible for ensuring that all quantities are correct. The customer should report and note any damage or shortage on the bill of lading to justify their claim to the transport company.

THIS MANUAL SHOULD BE CONSIDERED a permanent part of your equipment and should be easily accessible when needed.

This warranty provides you the assurance that the company will back its products when defects appear within the warranty period. In some circumstances, the company also provides field improvements, often without charge to the customer, even if the product is out of warranty. Should the equipment be abused, or modified to change its performance beyond the factory specifications, the warranty will become void and field improvements may be denied.

Safety Guidelines

This manual contains information that is important for you, the owner/operator, to know and understand. This information relates to protecting ***personal safety*** and ***preventing equipment problems***. It is the responsibility of the owner/operator to inform anyone operating or working in the area of this equipment of these safety guidelines. To help you recognize this information, we use the symbols that are defined below. Please read the manual and pay attention to these sections. Failure to read this manual and it's safety instructions is a misuse of the equipment and may lead to serious injury or death.

This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

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

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

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

CAUTION This symbol indicates a potentially hazardous situation which, if not avoided, **may result in property damage.**

Operate Unload Equipment Properly

Operate Unload Equipment Safely

- Untrained operators subject themselves and others to **SERIOUS INJURY** or **DEATH**. **NEVER** allow untrained personnel to operate this equipment.
- **NEVER** work alone.
- Keep children and other unqualified personnel out of the working area at **ALL** times. Refer to the **Start-Up** section of this manual for diagrams of the work area.
- Make sure **ALL** equipment is locked in position before operating.
- **NEVER** start equipment until **ALL** persons are clear of the work area.
- Keep hands and feet away from the auger intake and other moving parts.
- **NEVER** attempt to assist machinery operation or to remove trash from equipment while in operation.
- Be sure all operators are adequately rested and prepared to perform all functions of operating this equipment.
- **NEVER** allow any person intoxicated or under the influence of alcohol or drugs to operate the equipment.
- Make sure someone is nearby who is aware of the proper shut down sequence in the event of an accident or emergency.
- **ALWAYS** think before acting. **NEVER** act impulsively around the equipment.
- **NEVER** allow anyone inside a bin, truck or wagon which is being unloaded by an auger or conveyor. Flowing grain can trap and suffocate in seconds.
- Use ample overhead lighting after sunset to light the work area.
- Keep area around intake free of obstacles such as electrical cords, blocks, etc., that might trip workers.
- **NEVER** drive, stand or walk under the equipment.
- Use caution not to hit the auger when positioning the load.
- **ALWAYS** lock out **ALL** power to the equipment when finished unloading a bin.
- Be aware of pinch points. A pinch point is a narrow area between two surfaces that is likely to trap or catch objects and so is a potential safety hazard.

Safety Instructions

Our foremost concern is your safety and the safety of others associated with this equipment. We want to keep you as a customer. This manual is to help you understand safe operating procedures and some problems that may be encountered by the operator and other personnel.

As owner and/or operator, it is your responsibility to know what requirements, hazards, and precautions exist, and to inform all personnel associated with the equipment or in the area. Safety precautions may be required from the personnel. Avoid any alterations to the equipment. Such alterations may produce a very dangerous situation where SERIOUS INJURY or DEATH may occur.

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.

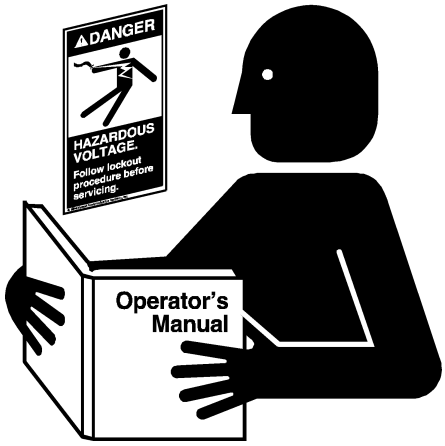
Follow Safety Instructions

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.

Keep your machinery in proper working condition. Unauthorized modifications to the machine may impair the function and/or safety and affect machine life.

If you do not understand any part of this manual or need assistance, contact your dealer.



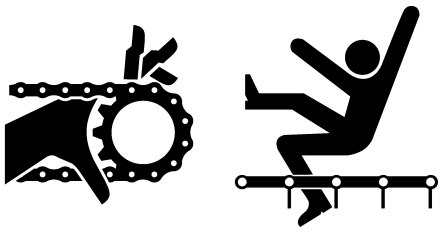
Read and Understand Manual

Stay Clear of Moving Parts

Entanglement in rotating impeller arms will cause serious injury or death.

Keep all shields and covers in place at all times.

Wear close fitting clothing. Stop and lock out power source before making adjustments, cleaning, or maintaining equipment.



Entanglement Hazard

Operate Motor Properly

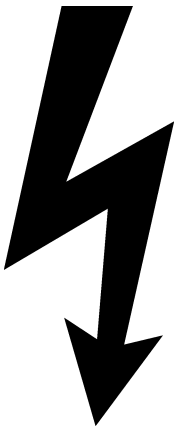
In an emergency, shut down the power source.

Turn OFF and lock out all power sources before performing any maintenance.

Do not operate electric motor equipped units until motors are properly grounded.

Disconnect power on electrical driven units 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/or drive components.



Electric Shock Hazard

Practice Safe Maintenance

Understand service procedures before doing work. Keep area clean and dry.

Never lubricate, service, or adjust machine while it is in operation. Keep hands, feet, and clothing away from rotating parts.

Keep all parts in good condition and properly installed. Fix damage immediately. Replace worn or broken parts. Remove any built-up grease, oil, and debris.

Maintain Equipment and Work Area

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.

Do all work outside or in a well-ventilated area.
Dispose of paint and solvent properly.
Remove paint before welding or heating:

- 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.

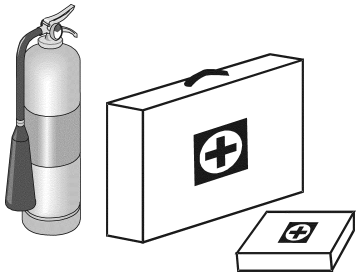
Breathing Hazard

Prepare for Emergencies

Be prepared if fire starts.

Keep a first aid kit and fire extinguisher handy.

Keep emergency numbers for doctors, ambulance service, hospital, and fire department near your telephone.



Keep Emergency Equipment Quickly Accessible

Wear Protective Clothing

Wear close-fitting clothing and safety equipment appropriate to the job.

Remove all jewelry.

Tie long hair up and back.

Wear safety glasses at all times to protect eyes from debris.

Wear gloves to protect your hands from sharp edges on plastic or steel parts.

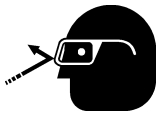
Wear steel-toed boots to help protect your feet from falling debris. Tuck in any loose or dangling shoestrings.

A respirator may be needed to prevent breathing potentially toxic fumes and dust.

Wear a hard hat to help protect your head.

Wear appropriate fall protection equipment when working at elevations greater than six feet (6').

Eye Protection



Gloves

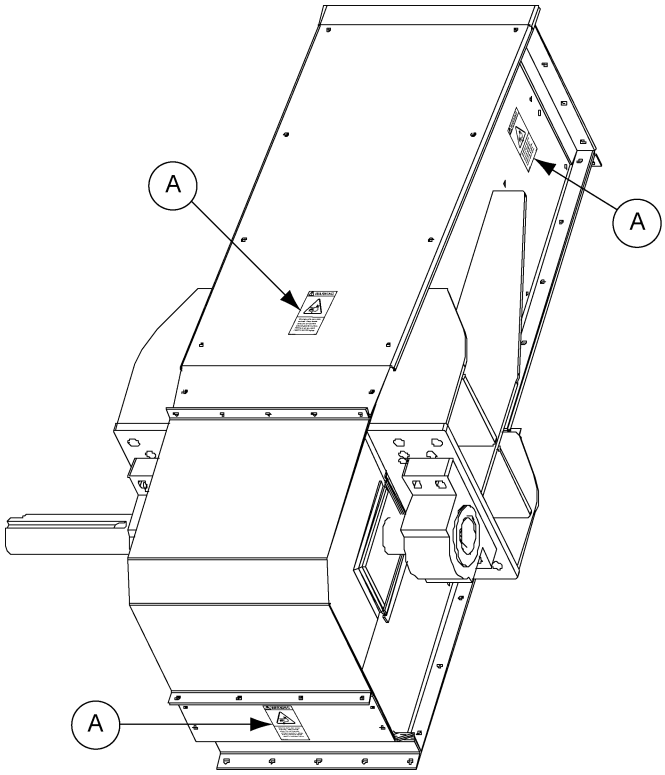
Steel-Toed Boots

Respirator

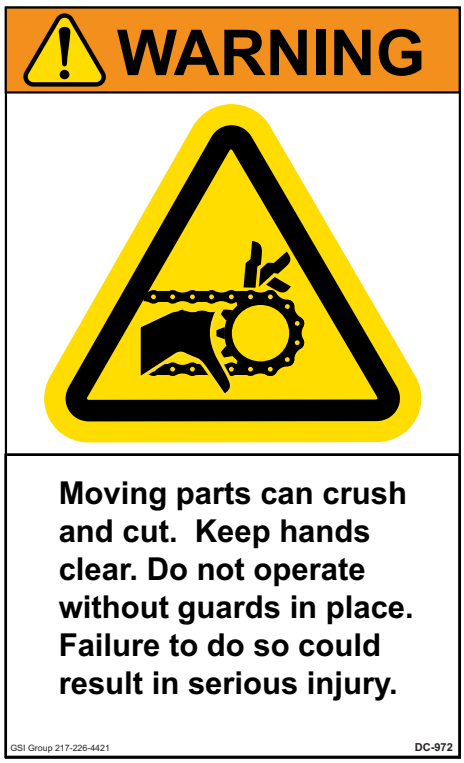
Hard Hat

Fall Protection

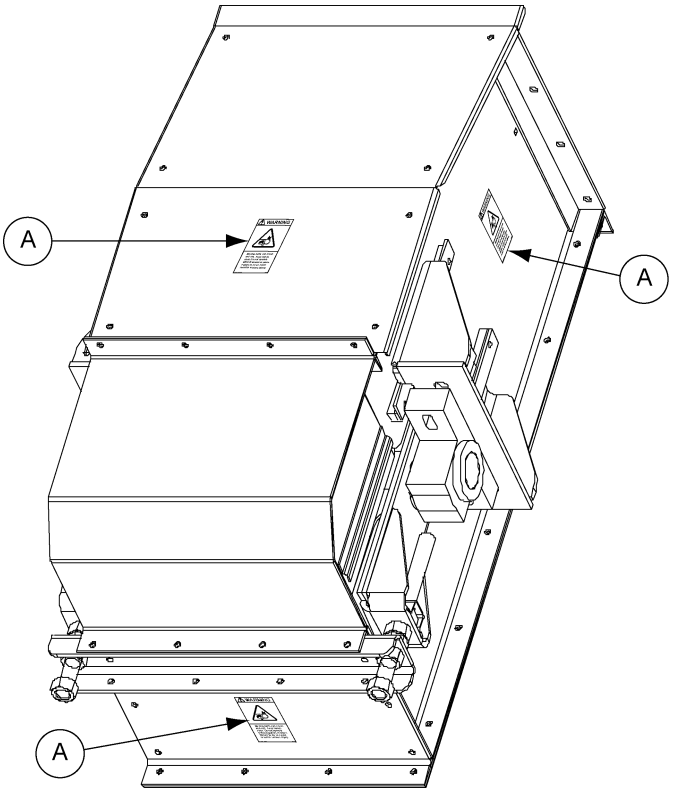
Head Section Decal Locations



A

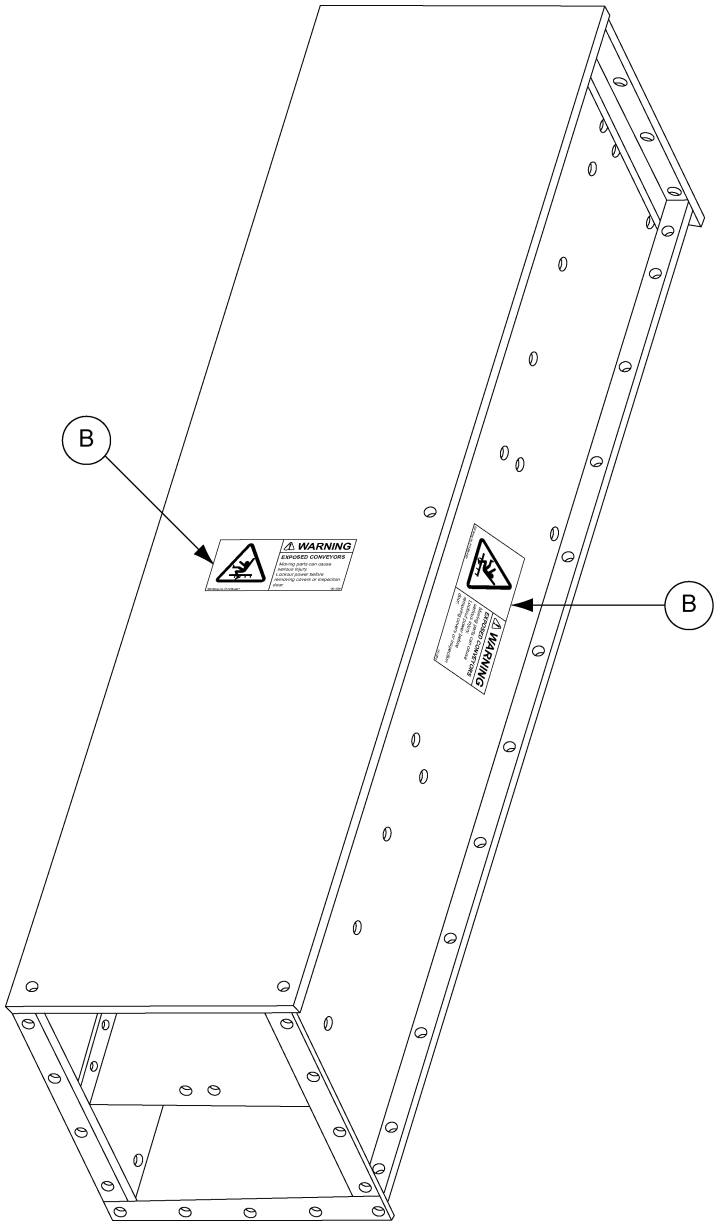


Tail Section Decal Locations



A

Trough Section Decal Locations



⚠ WARNING

EXPOSED CONVEYORS

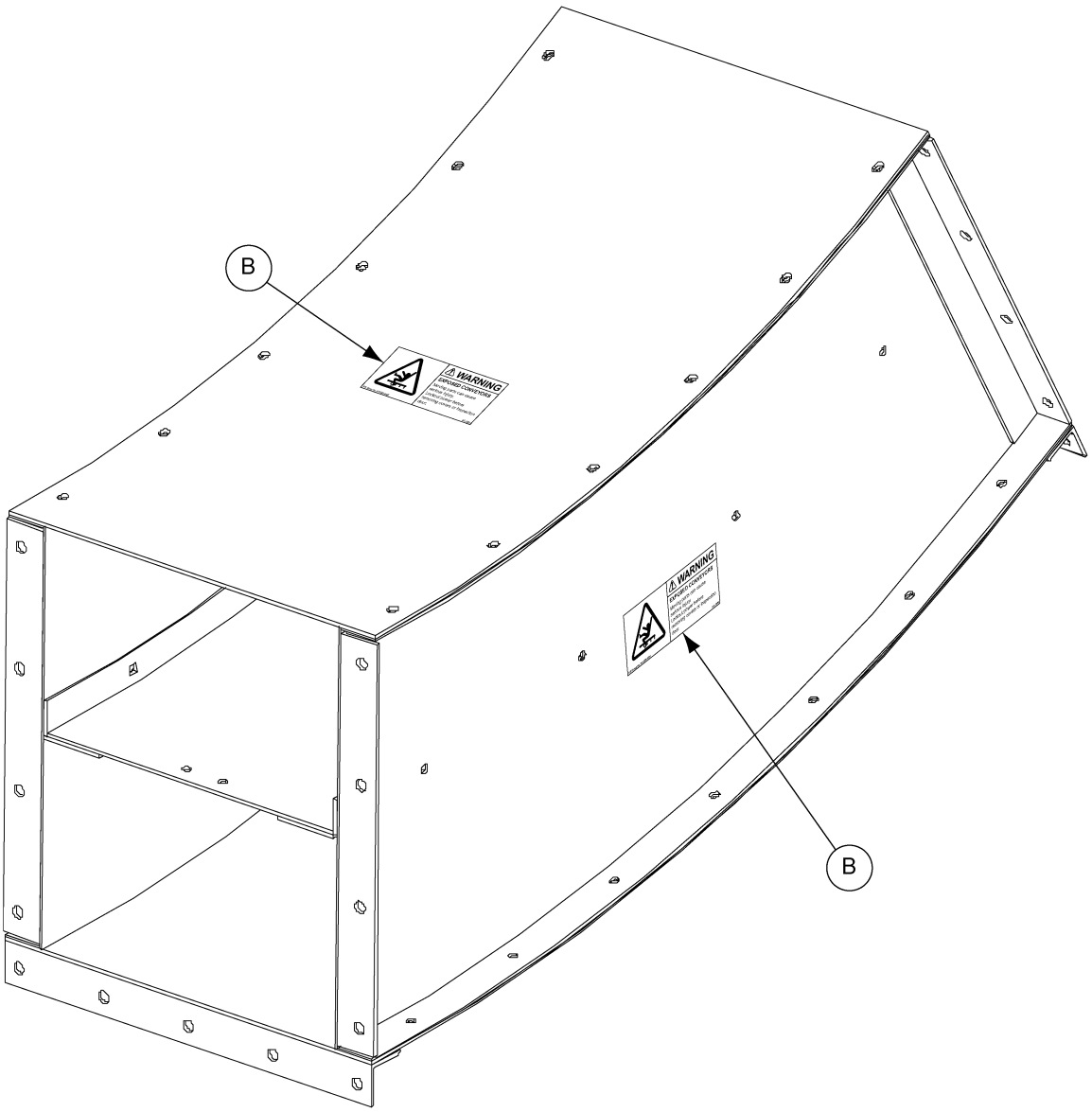
Moving parts can cause serious injury.
Lockout power before removing covers or inspection door.

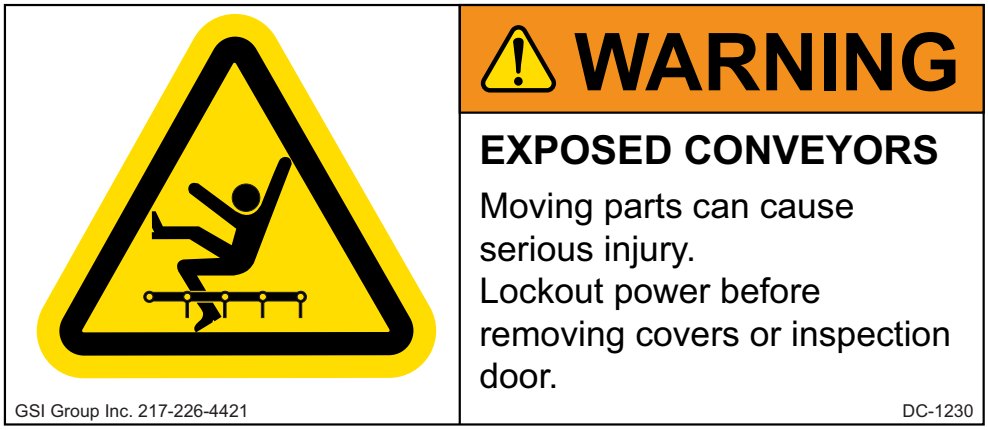
GSI Group Inc. 217-226-4421

DC-1230

B

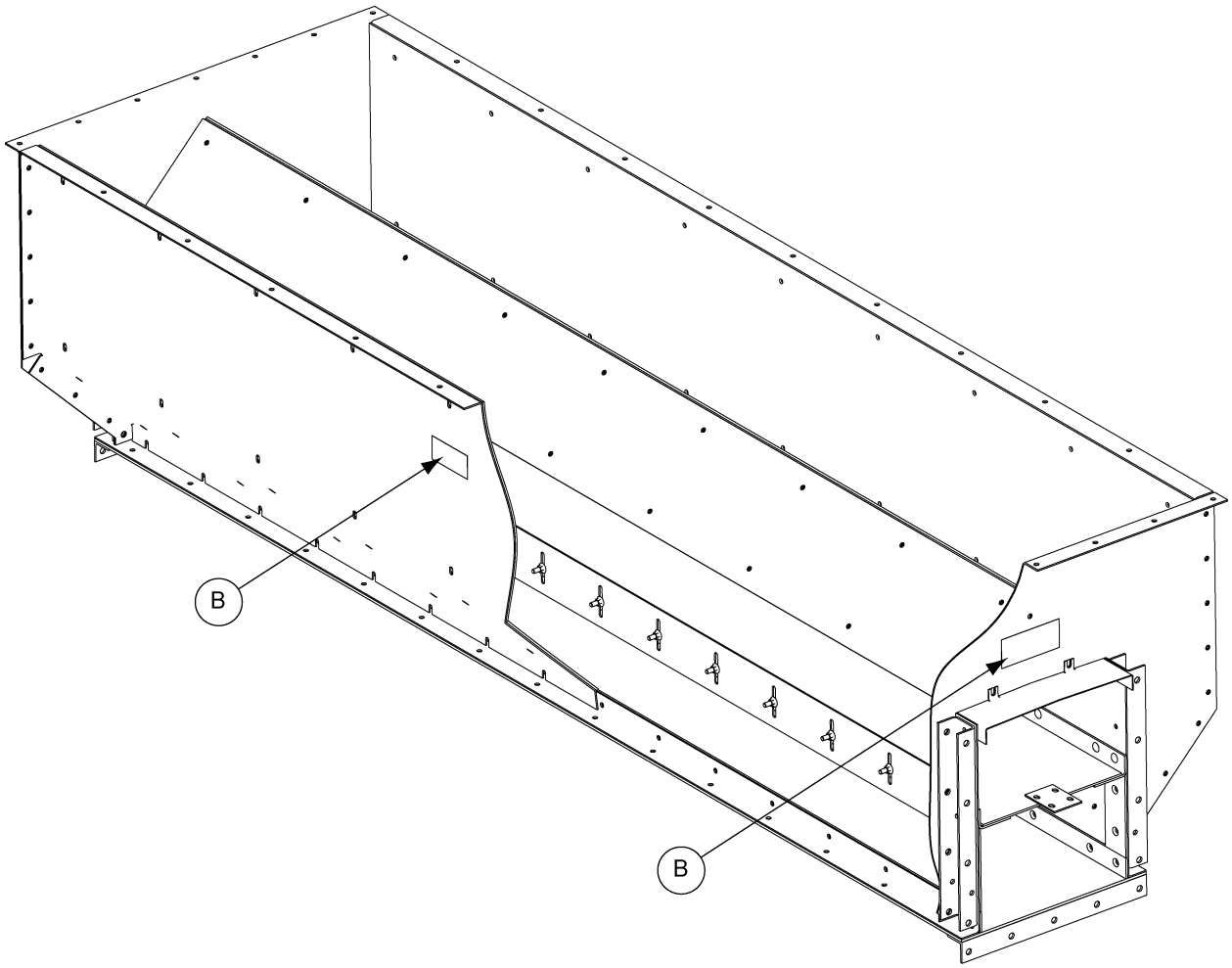
Bend Section Decal Location

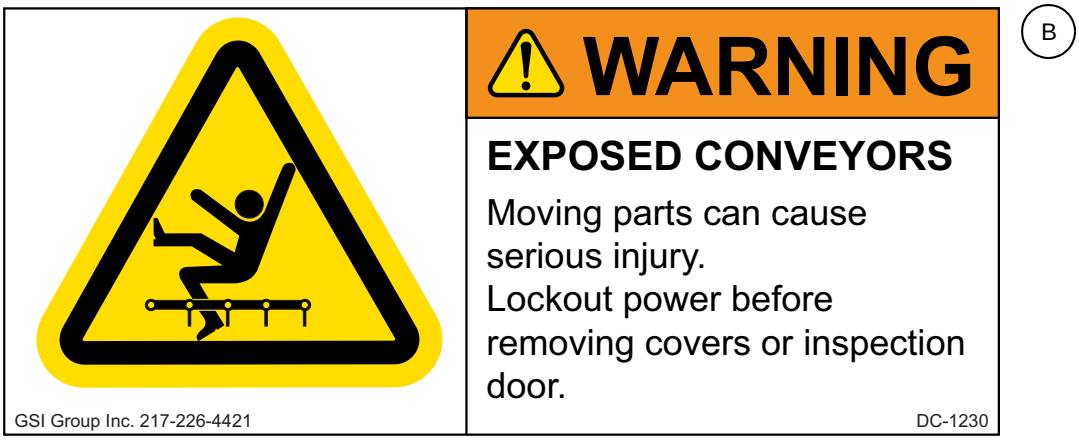




B

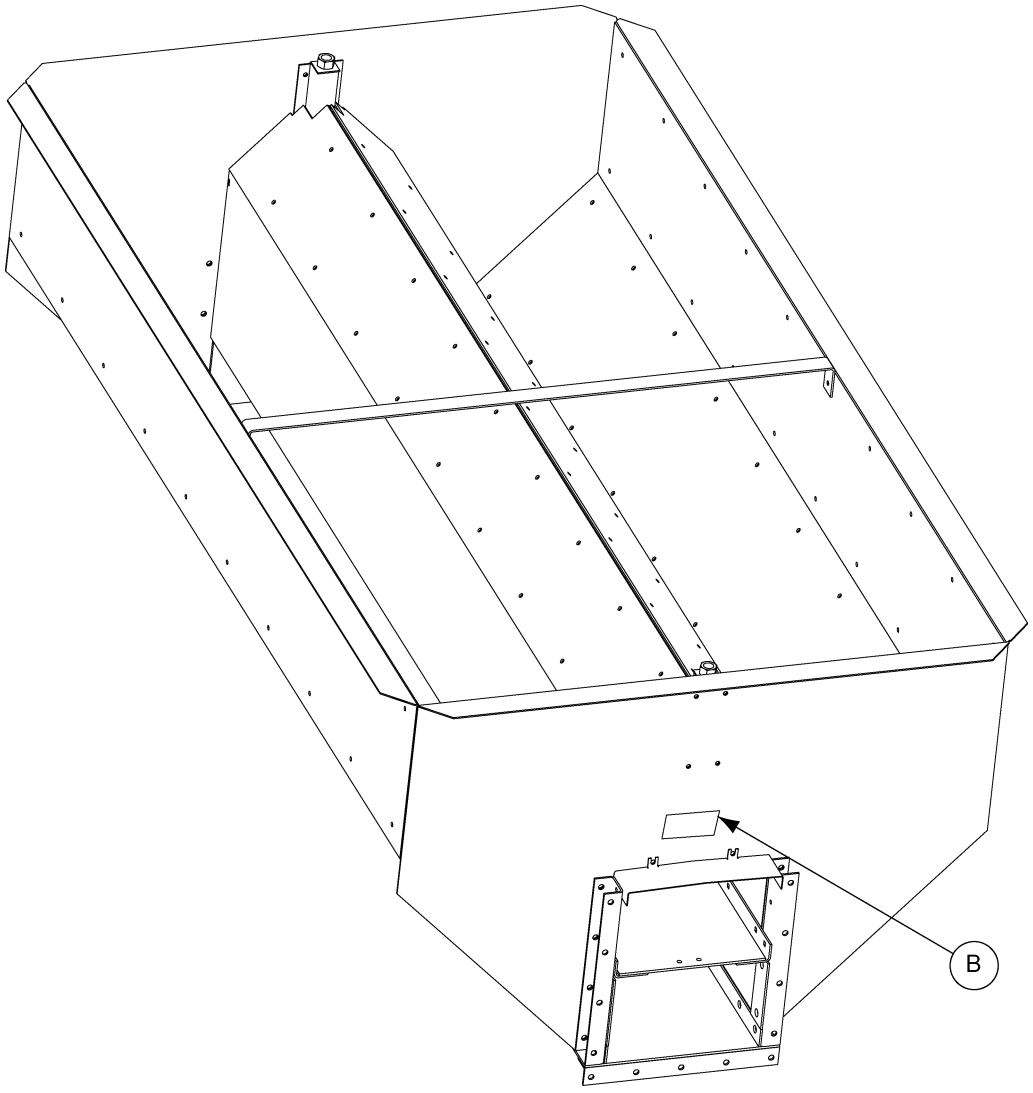
Bypass Inlet Decal Location

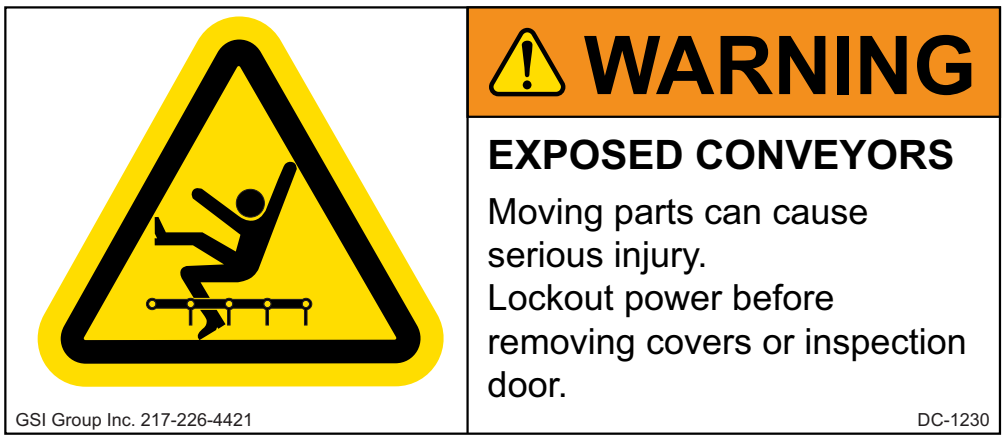




B

Bypass Dump Hopper Location





B

The head, tail and intermediate sections of the chain conveyor are shipped pre-assembled direct from the factory.

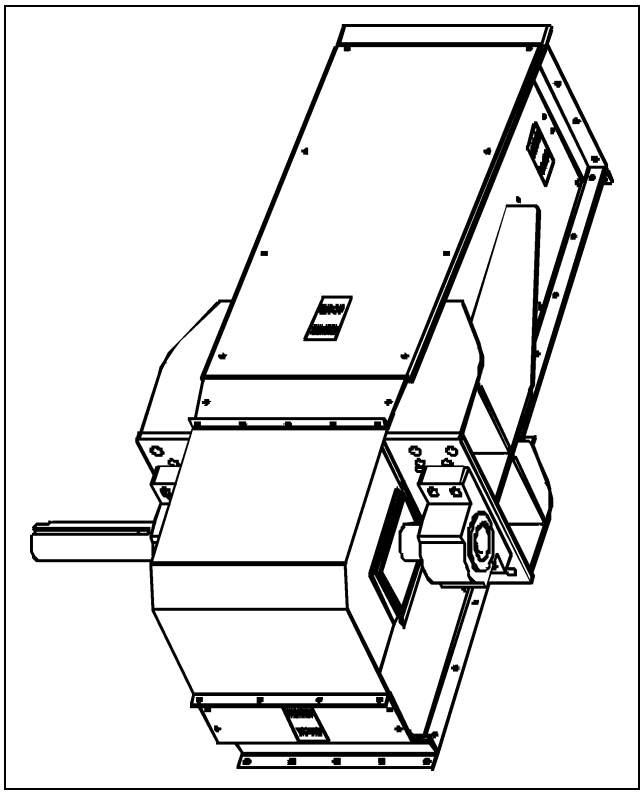


Figure 4A *Head Assembly*

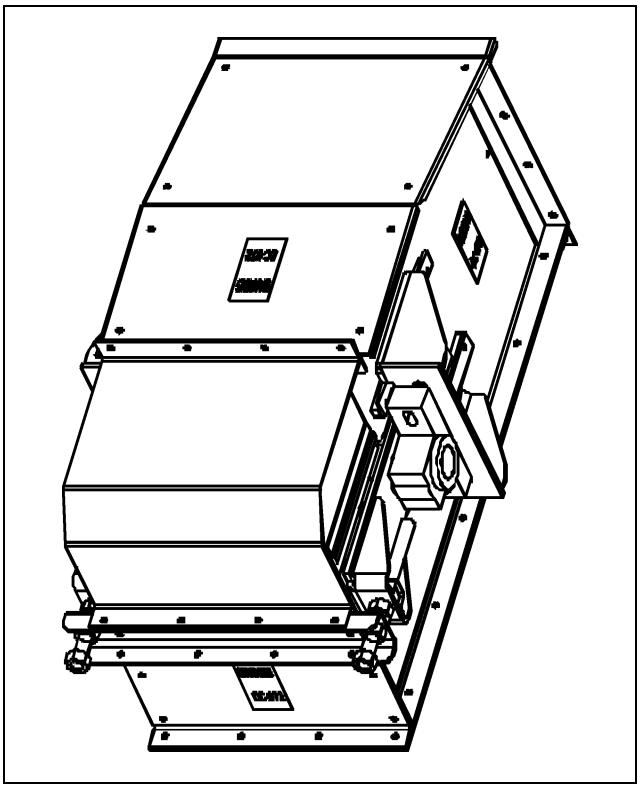


Figure 4C *Tail Assembly*

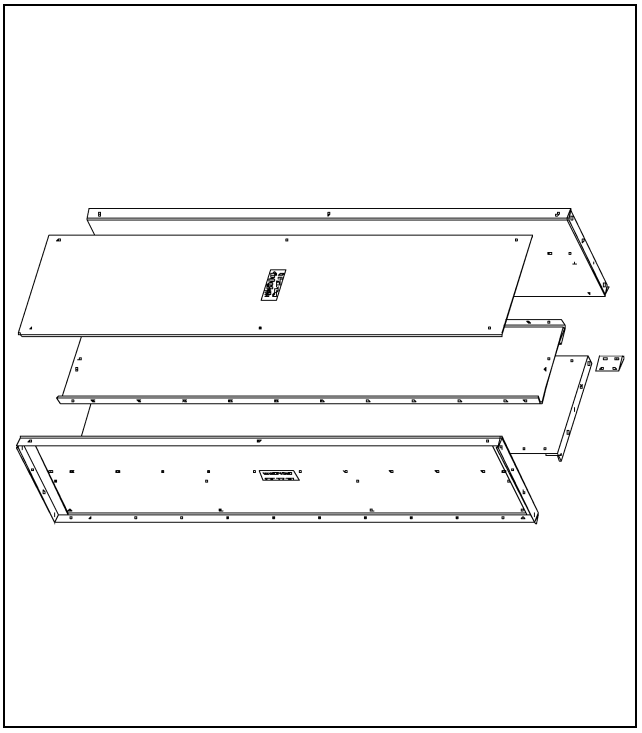


Figure 4B *Intermediate Trough Assembly with Center Pan*

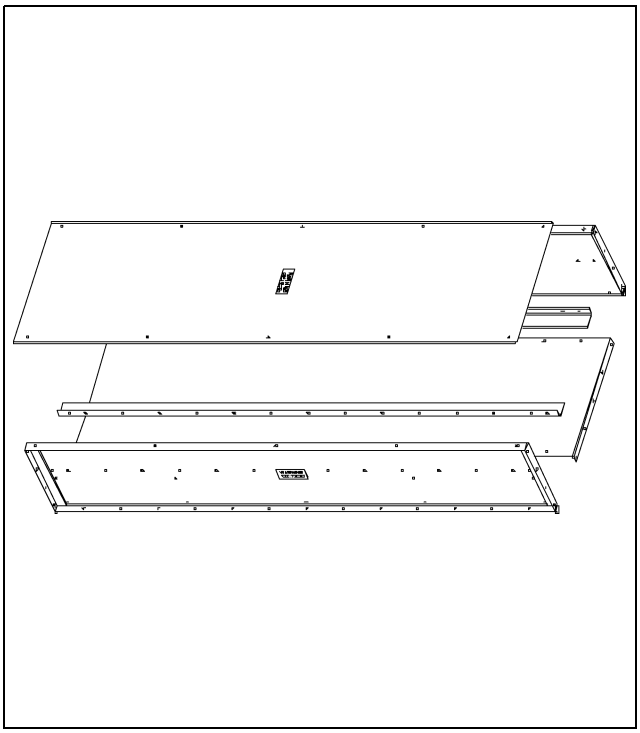


Figure 4D *Intermediate Trough Assembly with Slide Rails*

Intermediate Trough Section Assembly

Before assembling conveyor trough sections together remove covers. It is recommended that you store the covers in a protected area in order to minimize any possible damage. Remember to retain factory shipped hardware for conveyor cover installation.

Intermediate trough sections are supplied in standard ten foot (10') lengths. Depending on the application and individual specifications however, shorter sections may be required to accommodate a given overall length.

Intermediate sections are supplied with slide rails or a center pan (A). The sections with slide rails are always used on the horizontal portion of the conveyor. The sections with the center pans are required on the inclined portion of the conveyor, but can be used on horizontal as well.

NOTE: *It is critical for straightness of the conveyor that the sides and bottom flanges are aligned flush. Also, it is important that the inside dimensions of the box measure equidistant from side-to-side both top and bottom of the trough box (Dimension 1 = Dimension 2).* *(See Figure 4E.)*

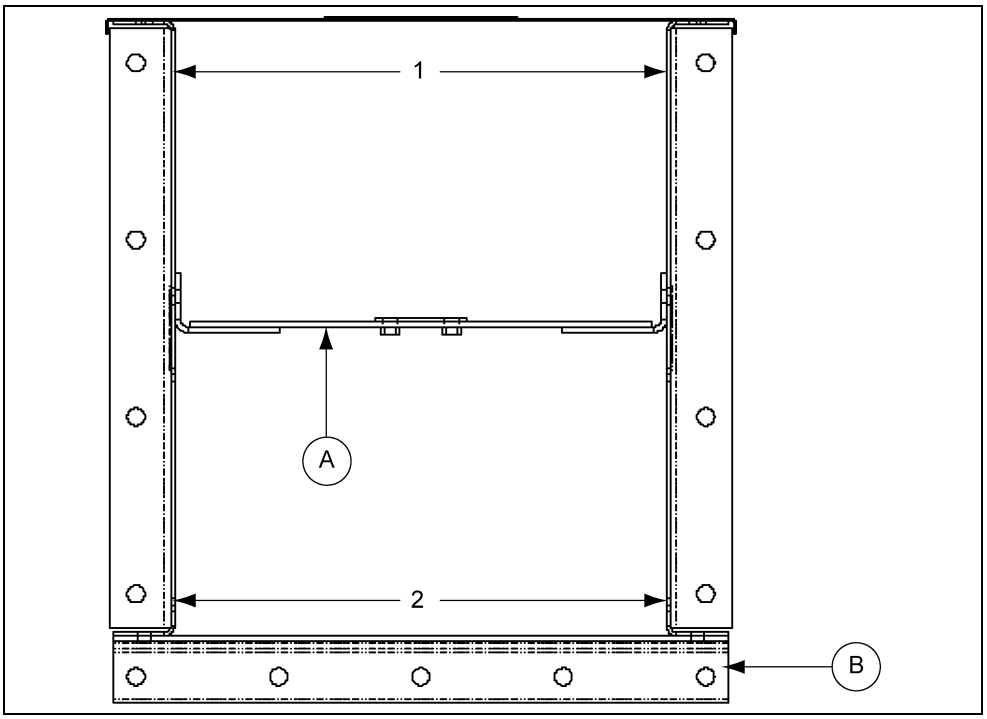


Figure 4E *Center Pan Trough Section Shown*

Ref #	Description
A	Center Pan
B	Bottom Plate

During assembly of each trough section to the next section, carefully inspect each flange joint to ensure that the inside bottom and center pan/slide rail side surfaces of the trough are flush. A chalk line is helpful during this phase of the assembly to ensure the proper alignment of the trough surfaces. The maximum run-out in any direction should be +/- 1/4". This proper alignment will minimize wear on flights and other potential damage to the conveyor. Make sure that the conveyor is level in horizontal applications.

Proceed by attaching the head and tail assemblies using the same alignment procedures and precautions noted in the preceding paragraph.

Cover Assembly Installation

Before installing the covers, an adhesive back foam strip may be applied to provide a seal against the elements. Starting at the tail assembly, place the tail section cover on top of the tail section assembly. Apply the adhesive back foam strip (A) to the top surface of the protruding lip before installing the next cover. *(See Figure 4F.)* This recommended installation sequence helps ensure that water will shed away from cover seam connections.

When an inlet is on the conveyor, a cover section may have to be cut accordingly to accommodate the inlet. For installation of an inlet, see inlet assembly and installation on *Page 18*.

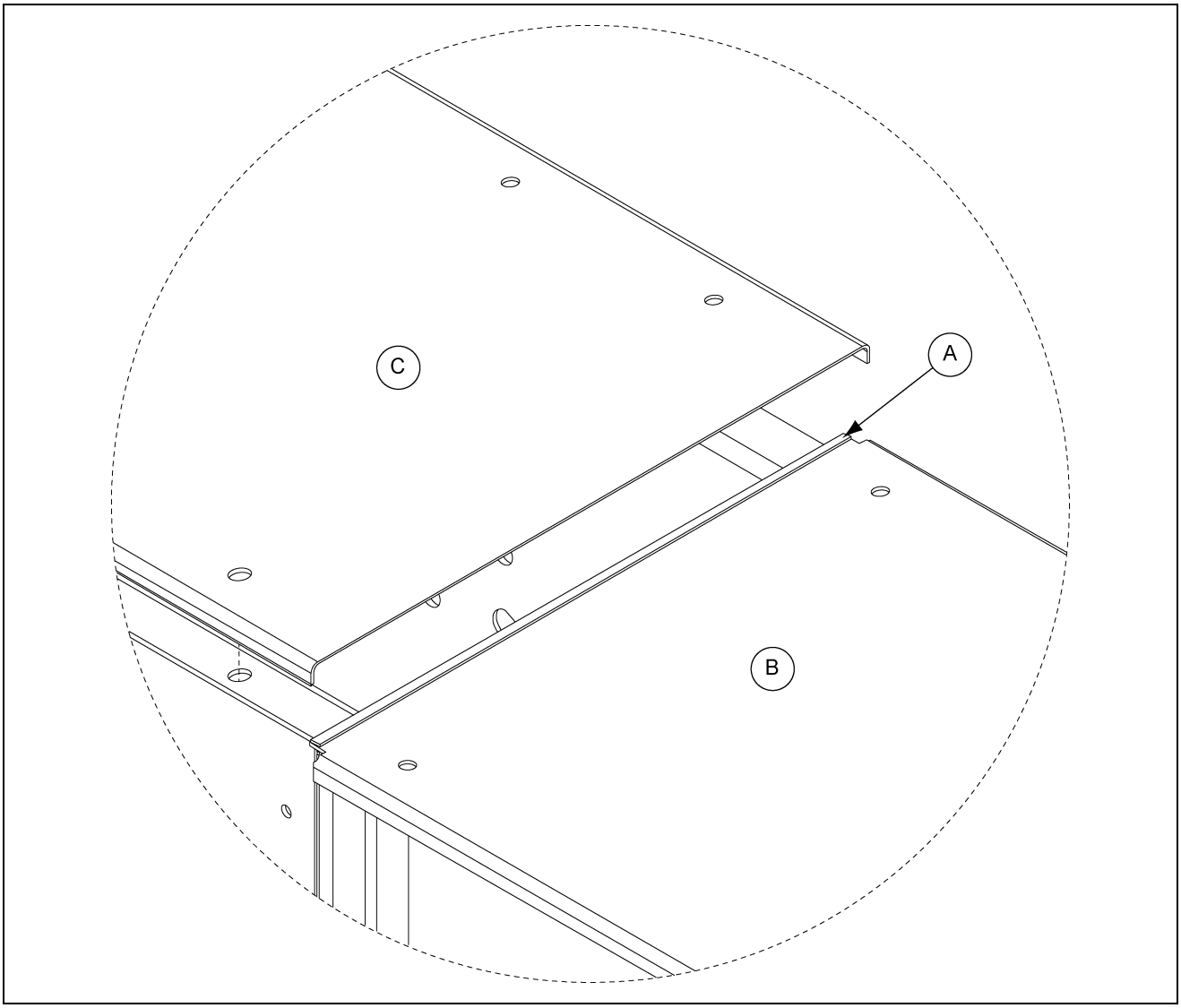


Figure 4F *Foam Strip Placement*

Ref #	Description
A	Foam Strip
B	Tail
C	Intermediate

Inlet Assembly and Installation

Inlets mounted too close to the tail may allow grain to come in contact with the sprocket and chain. This could cause excessive damage to the grain being conveyed. The minimum distance from tail splice joint to the nearest edge of the inlet assembly should be 6" on a horizontal application. On a sloped application, the minimum distance from the tail to the first inlet needs to increase to allow grain to enter the bottom of the conveyor in front of the tail. Keeping grain out of the tail minimizes grain damage and risk of equipment damage.

If the conveyor is control fed and has a center pan, another opening in the center pan should start at the edge of the inlet and extend a distance of twice the inlet opening, towards the tail. The width of the opening should be determined by starting the opening a distance *(See Note below)* from the inside edge of the conveyor. *(See Figure 4G.)*

The inlet can be attached with continuous weld seams. If intermittently welded, it is important to use caulking or sealing around the inlet area in order to seal the unit.

Similarly, it is recommended that if inlets are welded onto the conveyor, this procedure should occur prior to installation of motor and/or other electrical devices. By not following this precaution, owner assumes all risks associated with this type of installation.

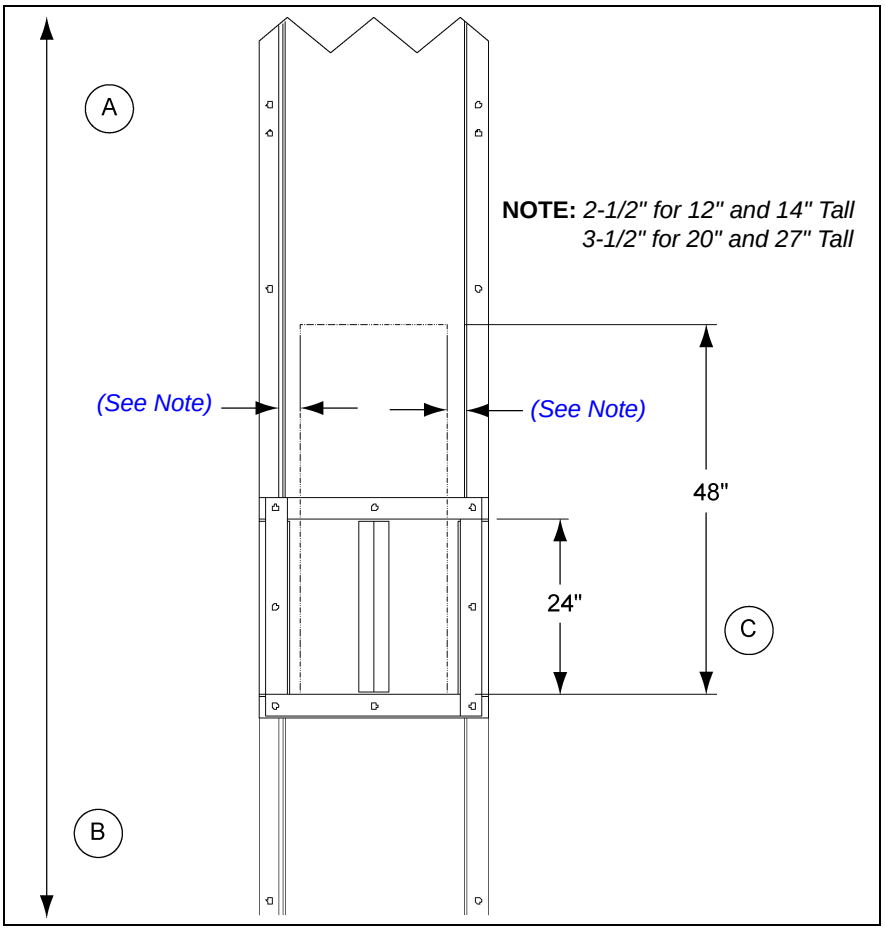


Figure 4G *Inlet Assembly*

Ref #	Description
A	Tail
B	Head
C	Inlet Opening

Drag Chain Assembly Installation

All chain supplied with new conveyors will be installed in a like manner, regardless of type. Correct total chain length has been determined for the installation by the manufacturer. The conveyor drag chain is shipped with flights pre-assembled from factory in approximate ten foot (10') and five foot (5') lengths (refer to packing list). The chain may be installed at any time during conveyor assembly.

The UHMW paddles are notched to go around the sprockets on each end. Install the chain so that the notch is next to the center pan or rails and the UHMW paddles are in front of the welded chain flights in the direction of chain travel. *(See Figures 4H, 4I and 4J.)* Connect chain lengths together using connecting links and/or pins.

Tighten the drag chain assembly using the take-up screws located on each side of the tail section or on the take-up head. Tighten the chain until the paddles on the return side stand up. Do not over tighten. As long as the chain stands up on the return side and releases from the head sprocket under load then the tension is adequate. After the chain is tight, check that the head and tail shafts are square to the box sides. If the shafts are not square, loosen the tighter of the two (2) adjuster screws until the shafts are square. Lock the adjuster screws by tightening the hex nuts against the cross-ways “C” channel.

With the chain now on the sprockets, rotate the chain at least one complete revolution. Check to see that the chain and its paddles are not catching on flanges or rubbing on the trough sides. Ensure a break-in period whereby the chain is allowed to run and seat itself. After running the chain for an adequate period of time, stop the machine and disconnect and lock out the power source. Re-tighten the chain as necessary and remove any excess chain. Repeat this process as necessary.

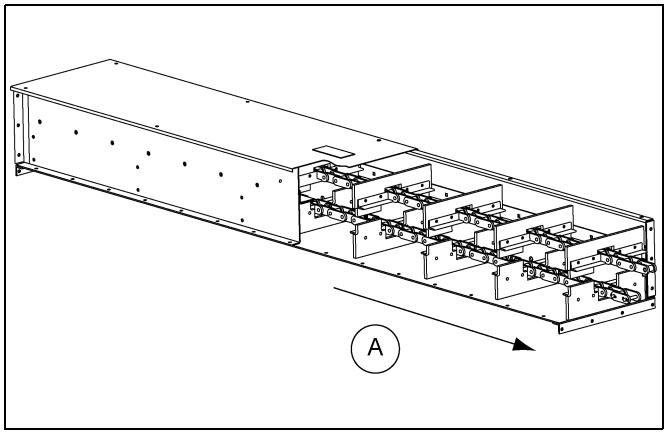


Figure 4H *81X Chain Assembly (12 x 12, 16 x 12, 16 x 14 and 21 x 14)*

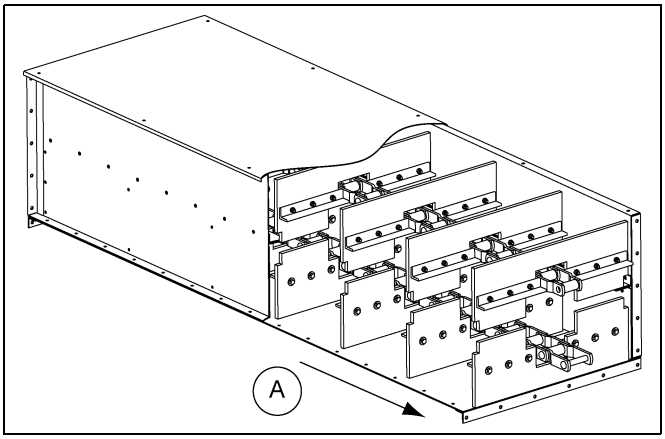


Figure 4J *6" Pitch Chain Assembly (36 x 27)*

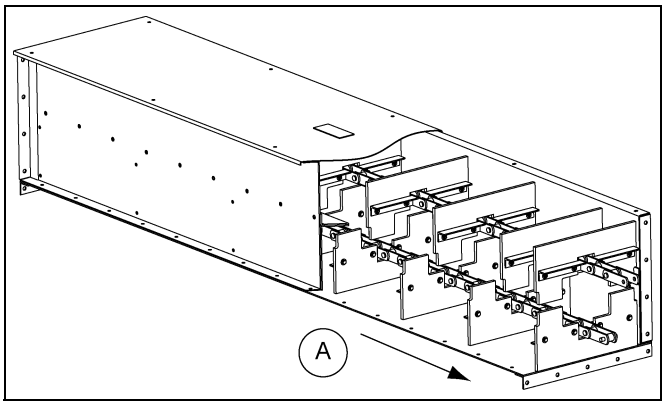


Figure 4I *4" Pitch Roller Chain Assembly (16 x 20, 20 x 20, 26 x 20, 32 x 20 and 26 x 27)*

Ref #	Description
A	Direction of Chain Travel Bottom Run

Installing Shaft Mount Reducers

Torque Arm Bracket Installation

The torque arm bracket is pre-punched for ease of installation to the unit. Begin installation by determining the location of the torque arm bracket relative to the range of extension allowed by the shaft mount reducer's torque arm. The bracket will extend on the same side of the conveyor as the head shaft. Remove the four (4) bolts necessary from the bottom of the conveyor plate.

NOTE: *Drill the four (4) holes in the conveyor's bottom to accommodate the 5/8" hardware provided. Attach the torque arm bracket to the conveyor using four (4) 5/8" hardware. DO NOT use the 3/8" bolts previously removed from the conveyor bottom to attach the torque arm to the conveyor.*

Install shaft mount reducer to head shaft per instructions.

Next, match the size of the hardware to the reducer manufacturer's torque arm. Use this hardware to attach the torque arm to the bracket. Tighten all hardware.

NOTE: *When installing torque arm bracket keep angle (1) of torque arm and reducer between -15° and +15° of 90° per manufacturer's recommendations. This angle is shown in Figure 4K.*

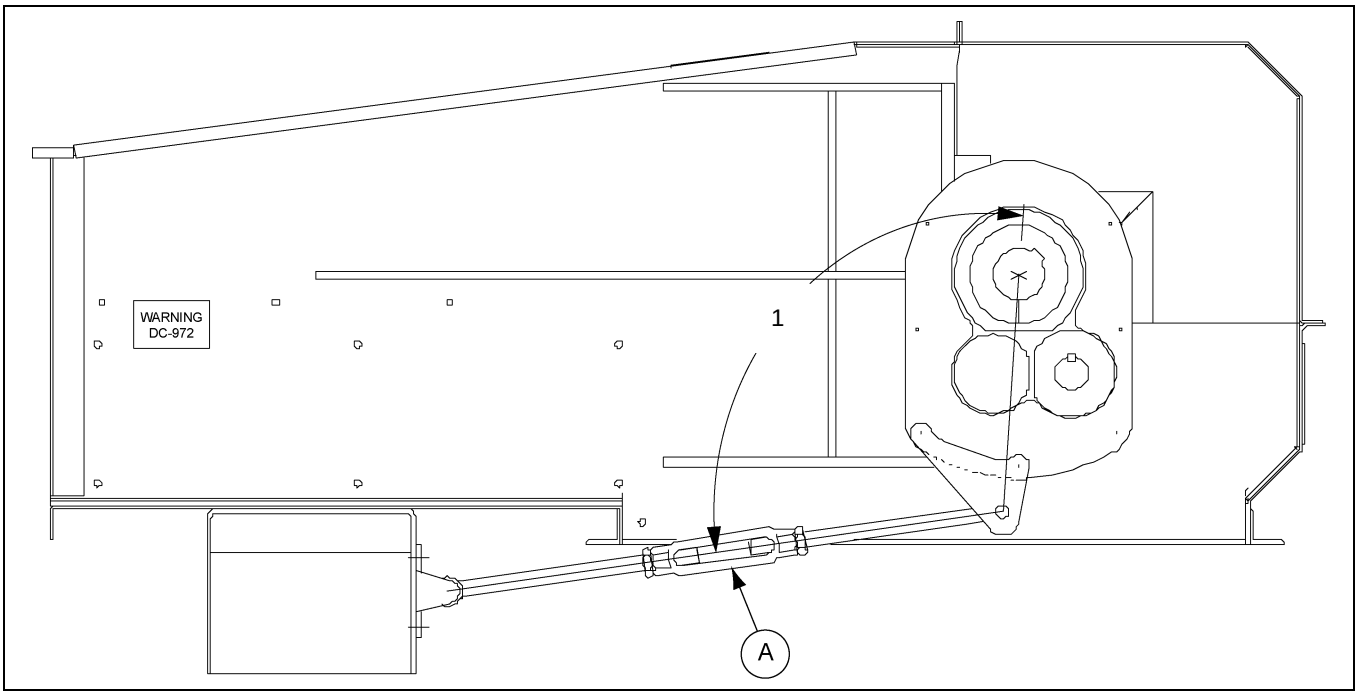


Figure 4K *Torque Arm Bracket Installation*

Ref #	Description
A	Torque Arm

To aid in the installation of the reducer onto the shaft, remove any protective coating film from shaft. Slide the reducer onto the drive shaft extending from the side of the conveyor head section. Using the instructions and hardware supplied with the reducer, assemble it to the conveyor drive shaft.

Assemble motor mount to the reducer. Refer to installation instructions provided with motor mount.

Install the rear panel of the drive guard before mounting the sheaves. The rear panel has four (4) mounting brackets with slotted holes. Attach the lower brackets to the matching reducer assembly bolts. Attach the upper brackets to the matching holes in the front motor mount support.

Assemble the V-belt driven sheave to the input shaft of the shaft mount reducer. Slide the sheave hub onto the shaft and insert the square key. Attach the hub sheave using the supplied retaining screws. The retaining screws pass through the non-threaded holes of the hub and into the sheave. Align the driver and driven sheaves and tighten the retaining screws. Make sure sheaves are as close as possible to motor and gearbox to reduce over hung load. During tightening, it is possible for the sheave to move out of alignment or become out of square. For maximum V-Belt life, the driven sheave should remain both perpendicular to the drive shaft and aligned with the drive sheave. Slip the V-belts over both the driver and driven sheaves.

Adjustment of V-belt tension is achieved by tightening the hex nuts located on the four (4) jack screws of the motor base. Adjust motor base equally at all four (4) bolts to maintain shaft alignment. Belts are designed to fit loose upon installation. When the V-belt tension is correct, tighten the top nut on the jackscrews to lock the motor base in position. Proper tension is 1/64" of deflection per one (1") inch of sheave centers on one side of belt, centered between sheaves.

NOTE: *Too much tension may shorten belt life, damage bearings or break shafts. Check belt tension frequently during the first 24-48 hours of operation.*

Install the front drive guard panel over the four (4) corner mounting studs. Secure with washers and nuts provided.

Fill the shaft mount reducer with the manufacturer's recommended oil. A list of recommended oil can be found in the gear reducer instructions.

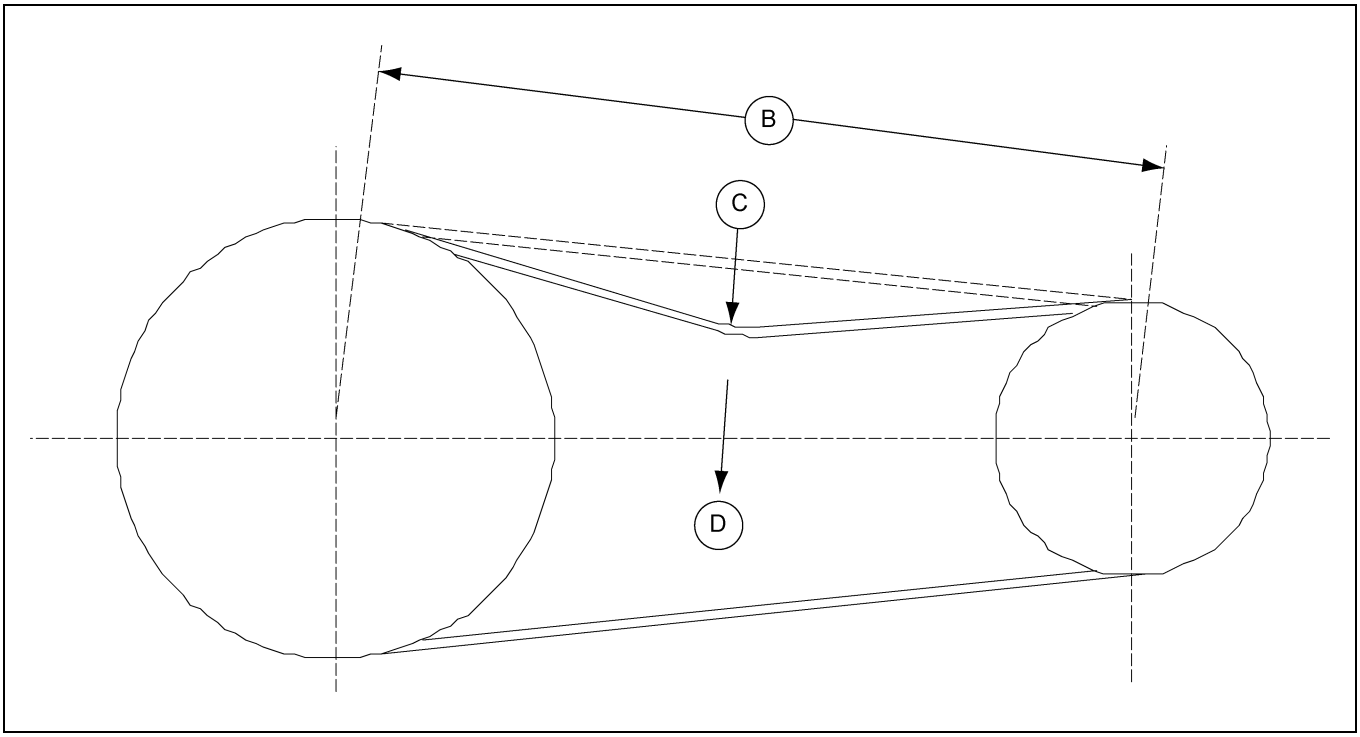


Figure 4L *Belt Deflection*

Ref #	Description
B	Span
C	Belt Deflection 1/64" per Inch of Span
D	Force (From V-Belt Engineering Tables)

Welding

Welding on or to the conveyor may damage the conveyor and its electrical system. If welding is necessary, take proper measures to protect the conveyor. If anything is to be fastened permanently to the conveyor, give careful consideration to the methods of maintenance, removal and replacement of the conveyor and/or its parts that will be required. (Please refer to inlet assembly and installation on *Page 18* for the recommended guidelines.)

Motor

Connect the conveyor motor to a power source according to the motor manufacturer's instructions and recommendations. To avoid injury, certified electrician should perform the motor wiring. A shut off switch should be placed near the motor so that the system may easily be shut down to help prevent accidents during maintenance. It is important to check proper motor shaft rotation before installing drive belts.

Support

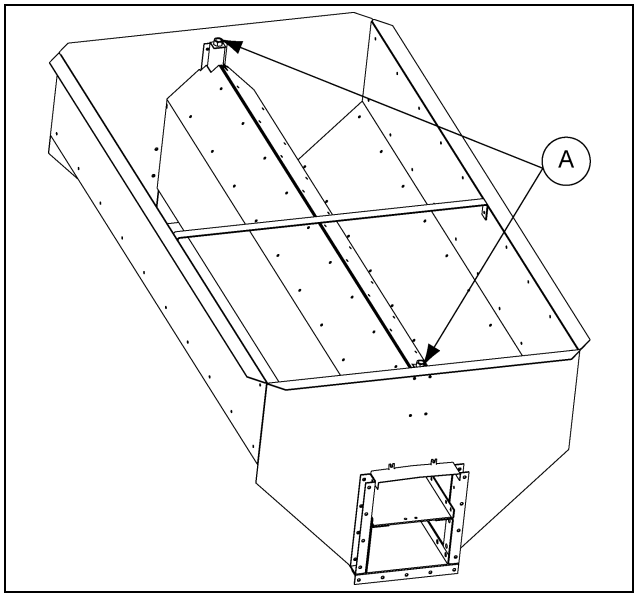
The recommended general guidelines in this area include adequate support for the conveyor assembly to be installed at intervals no greater than 10 feet. It is recommended that supports be installed at vertical portions of flanges leaving bottoms of trough sections clear. By attaching supports in this manner, the removable bottoms are unobstructed for ease of replacement. Support legs are available as an option.

Clearance

A clearance of at least the width of the conveyor is recommended on all sides of the unit. Less clearance may be acceptable however, serious consideration must be given to methods of maintenance, removal and replacement of the conveyor and/or its parts.

Dump Hopper

Dump hoppers come pre-assembled from the factory in 10 foot (10') lengths.The hogback moves vertically with adjustment screws at each end. The dump hopper allows large adjustments in capacity. Dump hoppers must be mounted horizontally. If not mounted horizontally, capacity will be reduced. *(See Figure 5A.)*



Ref #	Description
A	Adjustment screws for moving hogback up and down.

Figure 5A *Dump Hopper*

Standard Bypass Inlets

The bypass inlets come pre-assembled from the factory. The hogback is stationary in bypass inlets, but includes a baffle that allows for small adjustments to capacity. Bypass inlets must be mounted horizontally. If not mounted horizontally, capacity will be reduced. *(See Figure 5B.)*

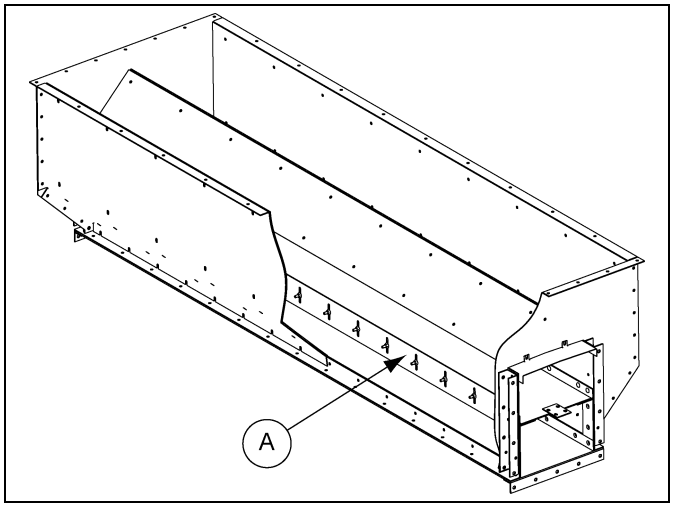


Figure 5B *Standard Bypass Inlets*

Ref #	Description
A	Baffles for small adjustments in capacity.

Care and Maintenance

Before any maintenance is performed to the conveyor, power must be shut off and locked out to prevent accidental start-up.

The care and maintenance section is provided to help extend the useful life of the unit. Like all equipment, the useful life of the conveyor is greatly reduced if it is not used wisely and well maintained.

Please follow the next few simple steps to ensure the safety and longevity of the equipment.

1. Check all bearings and moving parts daily during use.
2. Lubricate bearings according to bearing manufacturer's recommendations.
3. Follow manufacturer's recommendations for gear reducer lubrication and maintenance.
4. Inspect the V-belts periodically for proper tension and wear. V-belts should be replaced as necessary. If replacement or tension adjustment is required, please refer to the shaft mount reducer assembly section *on Page 20*.
5. The drag chain and sprockets should be checked periodically for wear, damage and proper adjustment. Any broken or bent paddles should be replaced or straightened. Should adjustment or replacement of the drag chain be required, refer to the assembly section *on Page 19*.

Storage

If the unit is to be inactive for an extended period, the following procedures are recommended.

1. Thoroughly clean the unit.
2. Loosen the drag chain tension. Doing so relieves the stress placed on the bearings and shafts of the drive and tail sections.
3. Lubricate drag chains, shafts and drive components with a good grade of light machine oil.

Troubleshooting Guide

Problem	Cause	Solution
Low capacity	1. Improper chain speed. 2. Improper feed. 3. Plugging.	1. Check the shaft RPM. 2. Check the grain level at inlet. 3. Check the discharges.
Noisy operation	1. Loose UHMW paddles bottom and /or center pan. 2. Slide rails not aligned. 3. Misalignment at flange connections. 4. Worn drive components. 5. Worn sprocket.	1. Check all bolts on chain and intermediate sections. 2. Check intermediate trough section joints and make flush. 3. Check intermediate trough section joints and make flush. 4. Check oil level and shaft seals; belt misalignment; loose belts. 5. Replace.
Uneven UHMW paddle wear	1. Conveyor misalignment. 2. Sprocket slipped.	1. Check the conveyor alignment. 2. Check set screws on sprockets.
Uneven sprocket wear	1. Worn chain. 2. Improper alignment.	1. Replace chain. *(See Page 19.)* 2. Check the sprocket alignment.

Consult the contractor for added assistance.

NOTES

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:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH HEREIN; SPECIFICALLY, GSI DISCLAIMS ANY AND ALL OTHER WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) ANY PRODUCT MANUFACTURED OR SOLD BY GSI, OR (II) ANY ADVICE, INSTRUCTION, RECOMMENDATION OR SUGGESTION PROVIDED BY AN AGENT, REPRESENTATIVE OR EMPLOYEE OF GSI REGARDING OR RELATED TO THE CONFIGURATION, INSTALLATION, LAYOUT, SUITABILITY FOR A PARTICULAR PURPOSE, OR DESIGN OF SUCH PRODUCTS.

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.

(Limited Warranty - N.A. Grain Products_ revised 01 October 2020)

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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