

## 4" and 5" Air Systems

4" - 700 Bu/Hr  
5" - 1200 Bu/Hr  
5" - 1700 Bu/Hr

Owner's Manual

PNEG-1811

Date: 04-08-11

**DMC**

BY THE

**GSI GROUP**



PNEG-1811



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### 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 its 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** indicates a hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING** indicates a hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION**, used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.



**NOTICE** is used to address practices not related to personal injury.

## 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 which 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.

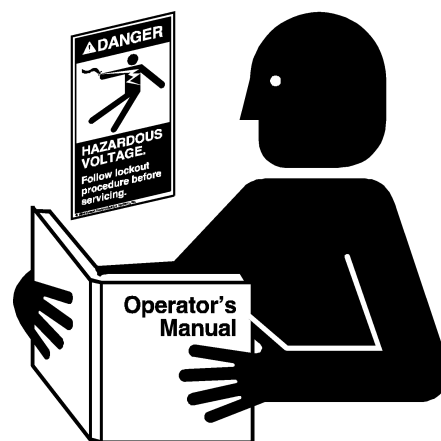
### Follow Safety Instructions

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.



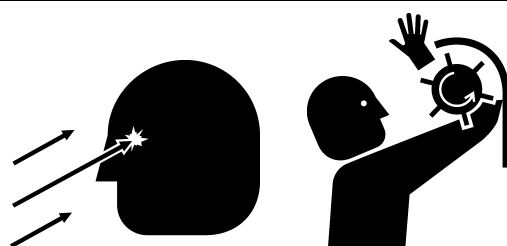
**Read and Understand Manual**

### Stay Clear of Moving Parts and Air Valves

Keep hands and feet away from moving parts. Be sure all people are clear of the equipment before start-up. Wear close fitting clothing.

Keep all shields and covers in place at all times.

Stay clear of air blast for valve. Always wear safety glasses to protect your eyes.



**Flying Debris**

**Rotating Parts**

## 1. Safety

### Install and Use Equipment Properly

Ground all electrical equipment as well as the bin itself.

Disconnect all power before servicing or opening control box, adjusting, lubricating the equipment, or opening the control box inner panel.

All electrical hook-ups should be in accordance with local and National Electrical Code.

If 3 phase power is used, identify wild leg and wire according to electrical diagram.

Never use plastic tubing for any lines carrying grain.



### 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.



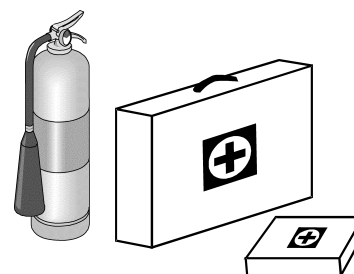
**Maintain Equipment  
and Work Area**

### 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.

Long hair should be tied up and back.

Safety glasses should be worn at all times to protect eyes from debris.

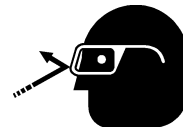
Wear gloves to protect your hands from sharp edges on plastic or steel parts.

Wear steel toe boots to help protect your feet from falling debris. Tuck in any loose or dangling shoe strings.

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

Wear 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 Toe Boots****Respirator****Hard Hat****Fall Protection**

## 2. Decals

Install safety decals on components as shown in this section. Always ensure that safety decals are in a place, easily readable and in good condition. If a decal cannot be easily read for any reason or has been painted over, replace it immediately. Contact your dealer or the manufacturer to order a replacement decal free of charge.

For decal replacements contact GSI at:

### GSI Decals

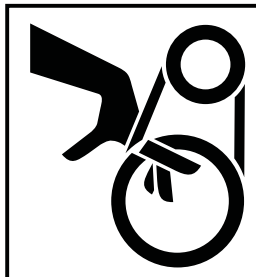
1004 E. Illinois St.  
Assumption, IL. 62510  
Phone: 1-217-226-4421



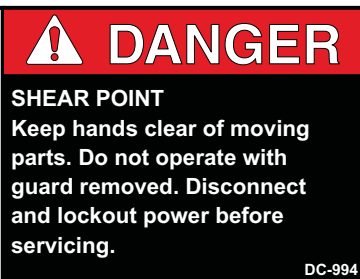
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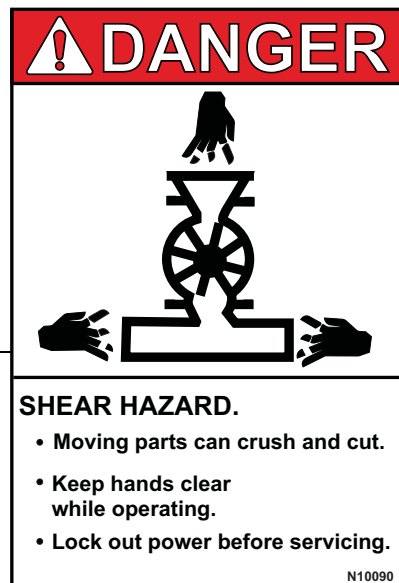
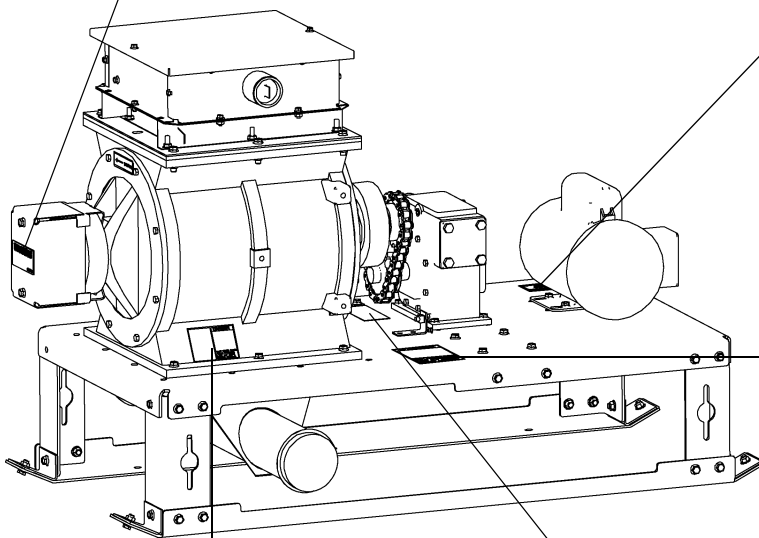
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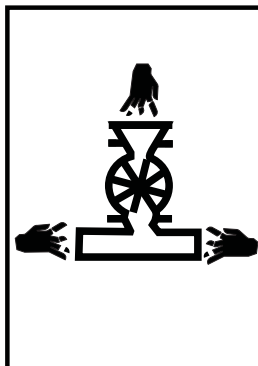


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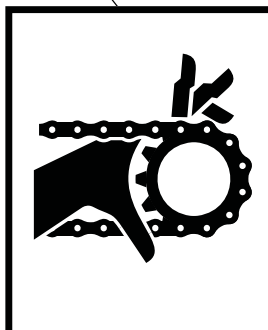
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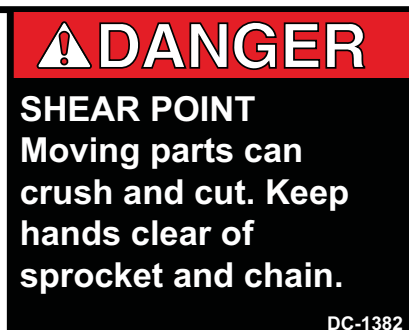
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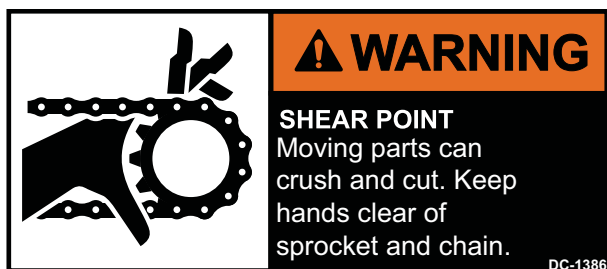


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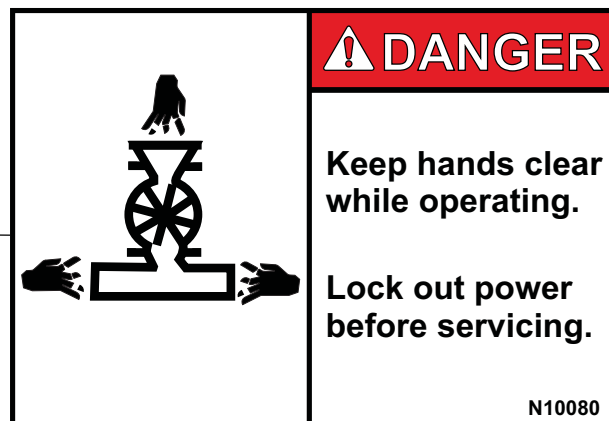
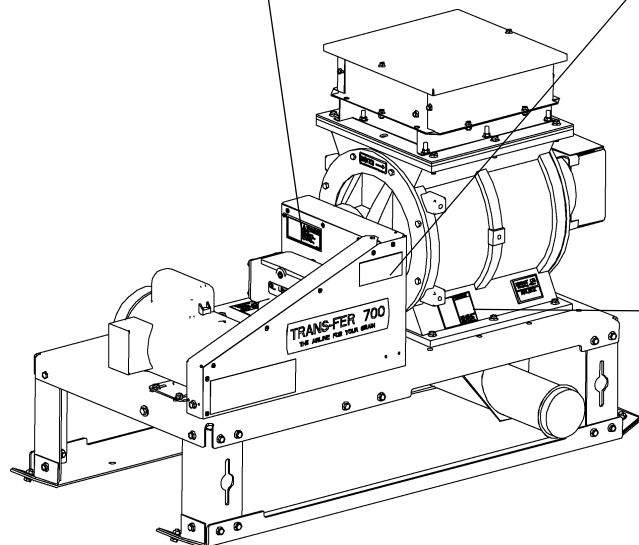




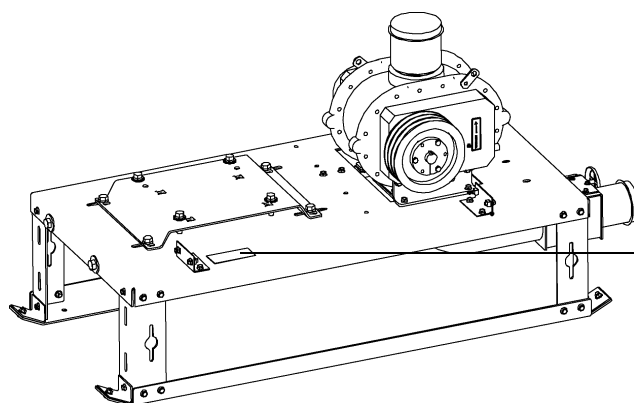
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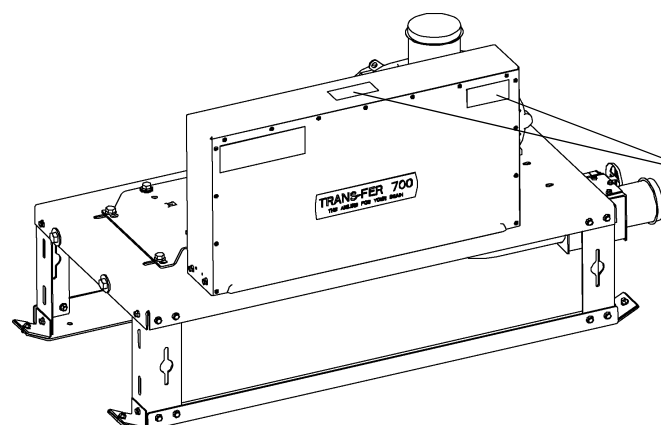
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N10080



DC-994



DC-995

### 3. Maintenance

## Maintenance Schedule

Initial Start-Up	
1. Roots-Flo blower	1. Oil level with middle of sight glass (DMC # MS5389 synthetic oil).
2. Roots blower	2. Oil level to check plug.*
3. Airlock gearbox	3. Oil level to check plug (SAE 90).
4. Air filter	4. Installed properly.
5. V-Belts	5. Tensioned and aligned.
6. Chain	6. Tensioned and aligned.
7. Tubing system	7. All couplers tight. All tubing connections have good fit. Tubing laid out straight. Elbows fitting properly.
After First 10 Hours and Daily	
1. Air filter	1. Check for excessive dust build-up.
2. V-Belts	2. Check tension alignment.
3. Tubing	3. Check all connections for leaks and signs of separating.
Weekly	
1. Chain	1. Oil
2. Blowers and gearbox	2. Check oil levels.
1500 Hours (Synthetic Oil) - 500 Hours (Standard Oil)	
1. Roots-Flo and duraflow	1. Drain oil and replace with 1.5 Qts. of DMC # MS5389 synthetic oil. (Fill to middle of sight glass.)
2. Roots blower	2. Replace with 1.5 Qts. of part # MS5389. Add oil to both ends of blower. (Fill to middle of both sight glasses.)
Extended Shut Down	
Disconnect main power unit.	
1. Blower	1. Remove inlet assembly and spray oil on lobes while rotating by hand, to prevent rust. Keep hands and objects out of blower. Re-install inlet assembly.
2. Airlock	2. Coat interior with oil, while rotating by hand, to prevent rust. Re-install weather cover.
3. Chain	3. Oil chain to prevent rust.

## Air System Capacities (Dry Shelled Corn)

Effective Length (Feet)	700 Bu/Hr 4" System (Roots)			1200 Bu/Hr 5" System (Roots)		1700 Bu/Hr 5" System (Roots-Flo)		
	10 HP Motor	15 HP Motor	20 HP Motor	20 HP Motor	30 HP Motor	20 HP Motor	30 HP Motor	40 HP Motor
50	525	800	850	1100	1300	1200	1600	1800
100	500	775	825	1075	1275	1175	1575	1775
150	475	750	800	1050	1250	1150	1550	1750
200	450	700	750	1000	1200	1100	1500	1700
250	400	650	700	925	1125	1025	1400	1600
300	350	575	625	825	1025	925	1275	1450
350	275	475	525	700	900	800	1100	1275
400	200	350	400	550	750	650	900	1050
450	-	-	225	350	550	450	650	775
500	-	-	-	-	-	-	-	400

Effective tube length is determined by adding the horizontal length, twice the vertical height and 10' for every elbow of 45° or greater. Add 5' for each elbow less than 45°. Use the horizontal run and add the vertical rise of inclined systems to calculate the effective length.

## Capacity Chart (4" and 5" Systems)

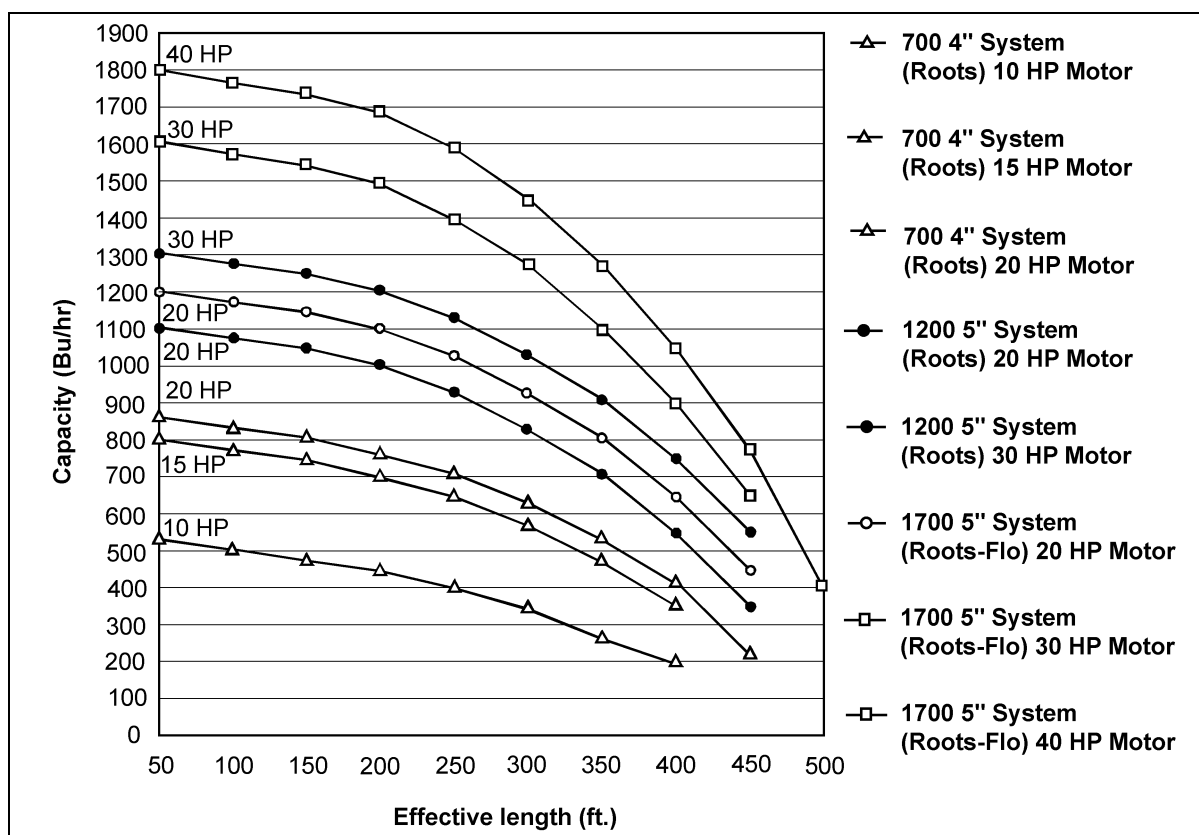


Figure 4A

### Air System Installation Instructions

1. Determine the most convenient location for the airlock and blower. Take into consideration the direction of the prevailing winds. It is important to locate the blower in as clean an environment as possible. This greatly reduces the maintenance requirements on the air filter system. When the distance between the airlock and blower is over 10', it is best to use galvanized pipe with short flex hose on the ends to couple the units together to keep airflow restrictions to a minimum.
2. The noise level of the blower unit can be reduced by placing the unit behind a wall, barrier or in a small building. If this is done, make sure that the building has adequate ventilation for both air intake and cooling of the blower and motor.
3. The grain discharge chute on the airlock is assembled at the factory so that grain movement is at 90° to the length of the skid. This orientation can be changed by removing the mounting hardware at the base of the airlock and rotating the discharge chute to the preferred direction. Be sure to keep the gasket in place between the skid and the discharge chute. Note that the airlock itself is sealed to the skid surface and does not need to be moved to redirect the discharge chute.

**NOTE:** *A minimum of 10' is needed between the airlock discharge and the first elbow in the system.*

4. Determine the best routing of the galvanized steel pipe from the airlock to the storage areas. Use galvanized elbows for changing the grain direction. This will give better performance and longer life than flex hose.
  5. Bolt the tube mounting brackets to the desired location using at least two (2) mounting brackets on the vertical wall and two (2) on the roof of the grain bin. The mounting brackets can be formed to match existing hole patterns in the bin.
  6. Determine the number and degree of arc required in the elbows. The 90° and 60° elbows are standard - different lengths of arc can be cut from these standard elbows. [\(See Page 15.\)](#)
- NOTE:** *A minimum of 8' between elbows is required for proper operation.*
7. Cut the steel tubing to the required length and fasten it together with compression couplings. The ends must be cut square to fit properly. Make sure that the stainless steel gasket protecting sleeve is placed over the joint before tightening the coupler. Tighten the three (3) bolts on the coupler evenly or until the coupler flanges butt together. [\(See Page 66.\)](#)
  8. The steel tubing can be laid underground, on top of the ground or placed on blocks. If placed on blocks, the tubing must be supported every 15'. If placed underground, the tube should enter and exit the ground at a 45° angle and be coated with a protective tar to prevent corrosion.
  9. Measure the distance between the airlock and blower. Use flex hose or a combination of flex hose and galvanized tubing to connect the units together. Note that the grain discharge chute on the airlock is tapered and that grain can discharge in either direction.
  10. Install all tubing required to transfer grain to the storage areas.
  11. To attach the deadhead deflector to the tubing, simply slide the deadhead deflector onto the tubing and tighten the clamp provided. Flexible galvanized tubing can be attached to the deadhead down spout if needed. If a cyclone is used, an elbow and mounting brackets are needed.

12. Select a location to mount the electrical control box that is accessible and easily reached should shut down of unit be necessary. It should be close enough to the blower to run the 30' of rubber pressure hose between the blower and the control box. Otherwise, a longer length of hose must be ordered.
13. Before wiring or operating the Air System unit, read the control box description [on Pages 20-22](#) to understand the operation of the Air System control box. If the control box is to be wired to remote equipment, review the wiring diagrams [on Pages 24-28](#) for proper hook-up.

## Air System Capacities (Dry Shelled Corn)

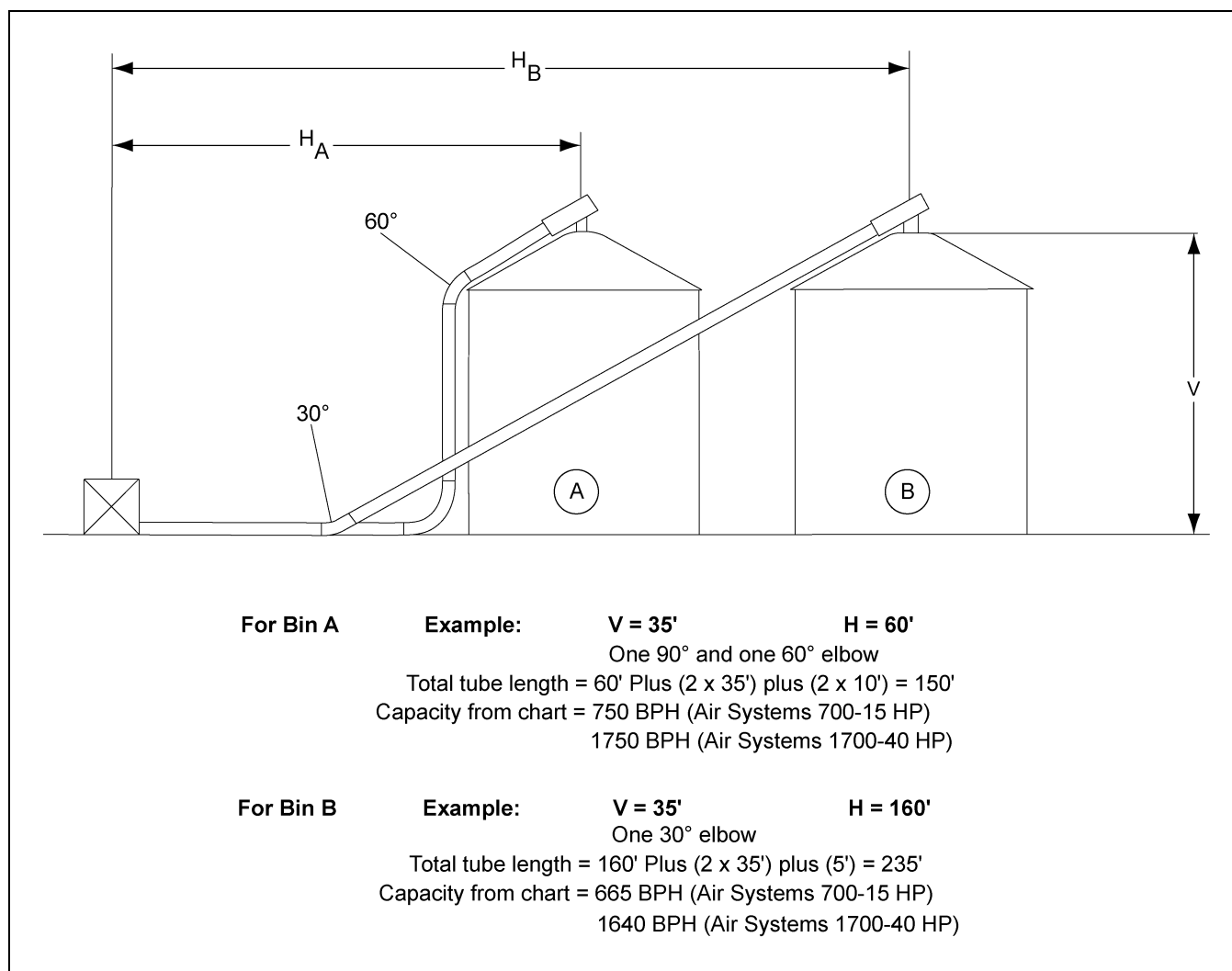


Figure 5A

## 5. Installation

### Air System Tubing Dimensions

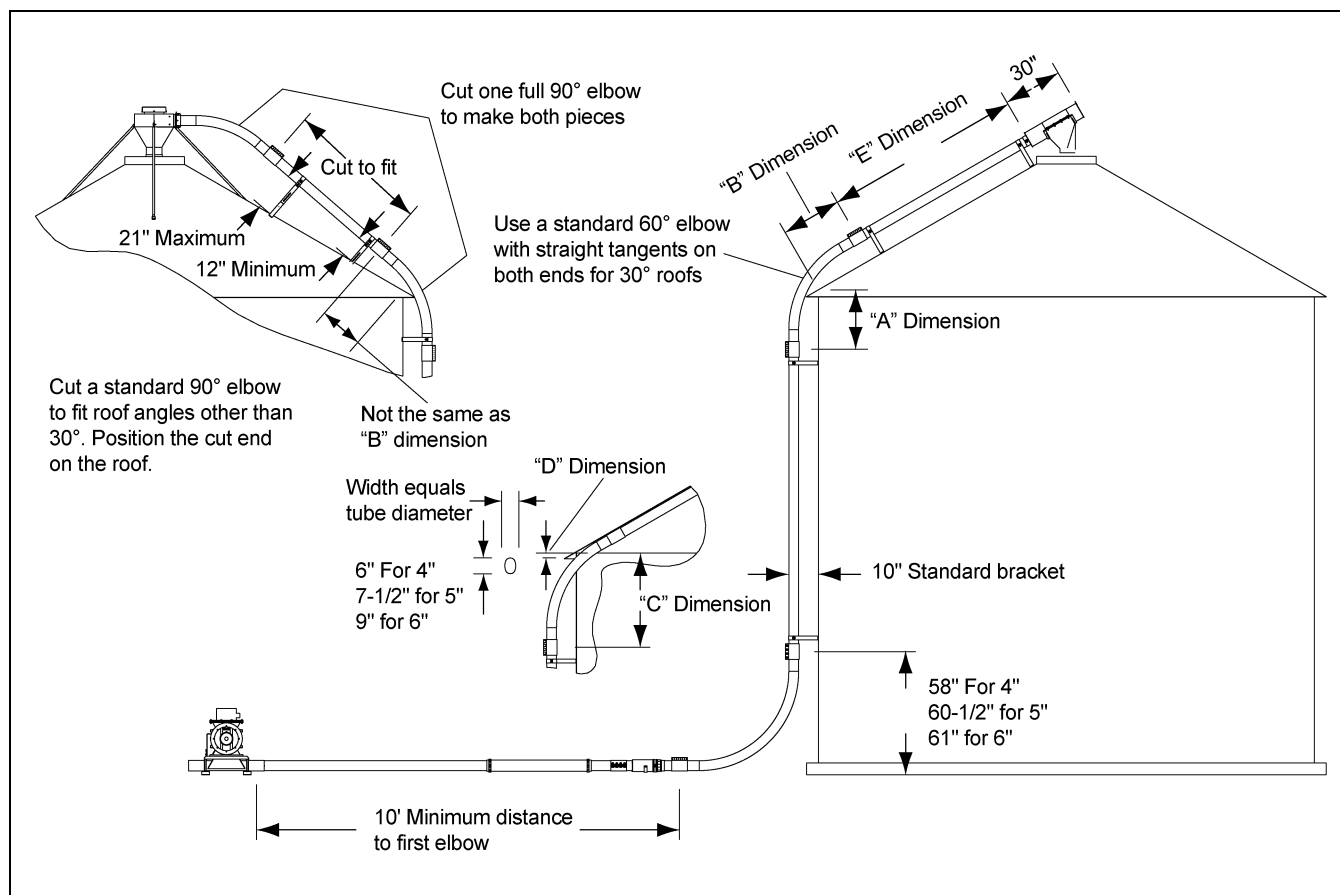


Figure 5B

System Size	Roof Angle	Reference Dimension												
		A	B	C	D	E *								
						18' Diameter	21' Diameter	24' Diameter	27' Diameter	30' Diameter	33' Diameter	36' Diameter	42' Diameter	48' Diameter
4"	25	31"	23"	47-1/2"	5-3/4"	7' 1"	8' 9"	10' 5"	12' 1"	13' 9"	15' 5"	17' 1"	20' 5"	23' 9"
	30	29"	29"	46"	3-1/2"	7' 1"	8' 9"	10' 5"	12' 1"	13' 9"	15' 5"	17' 1"	20' 5"	23' 9"
	35	27"	19"	45"	2-1/2"	8' 6"	10' 2"	11' 10"	13' 6"	15' 2"	16' 10"	18' 6"	21' 10"	25' 2"
5"	25	32-1/2"	22-1/2"	50"	4-1/2"	7'	8' 9"	10' 6"	12' 3"	14'	15' 9"	17' 6"	21'	24' 6"
	30	30-1/2"	30-1/2"	49"	3-1/4"	6' 10"	8' 7"	10' 4"	12' 1"	13' 10"	15' 7"	17' 4"	20' 10"	24' 4"
	35	28-1/2"	18-1/2"	48"	2-1/4"	8' 6"	10' 3"	12'	13' 9"	15' 6"	17' 3"	19'	22' 6"	26'
6"	25	32-1/4"	22-1/4"	51"	4-1/2"	7' 3"	9' 1"	10' 11"	12' 9"	14' 7"	16' 5"	18' 3"	21' 11"	25' 7"
	30	30-1/4"	30"	50"	3"	7' 1"	8' 11"	10' 9"	12' 7"	14' 5"	16' 3"	18' 1"	21' 9"	25' 5"
	35	28-1/4"	18"	49"	2"	8' 8"	10' 6"	12' 4"	14' 2"	16'	17' 10"	19' 9"	22' 4"	27'

**NOTE:** Add 10" to "E" dimension if roof elbow has been cut from a 90° elbow.

# Elbow Angle Measurements

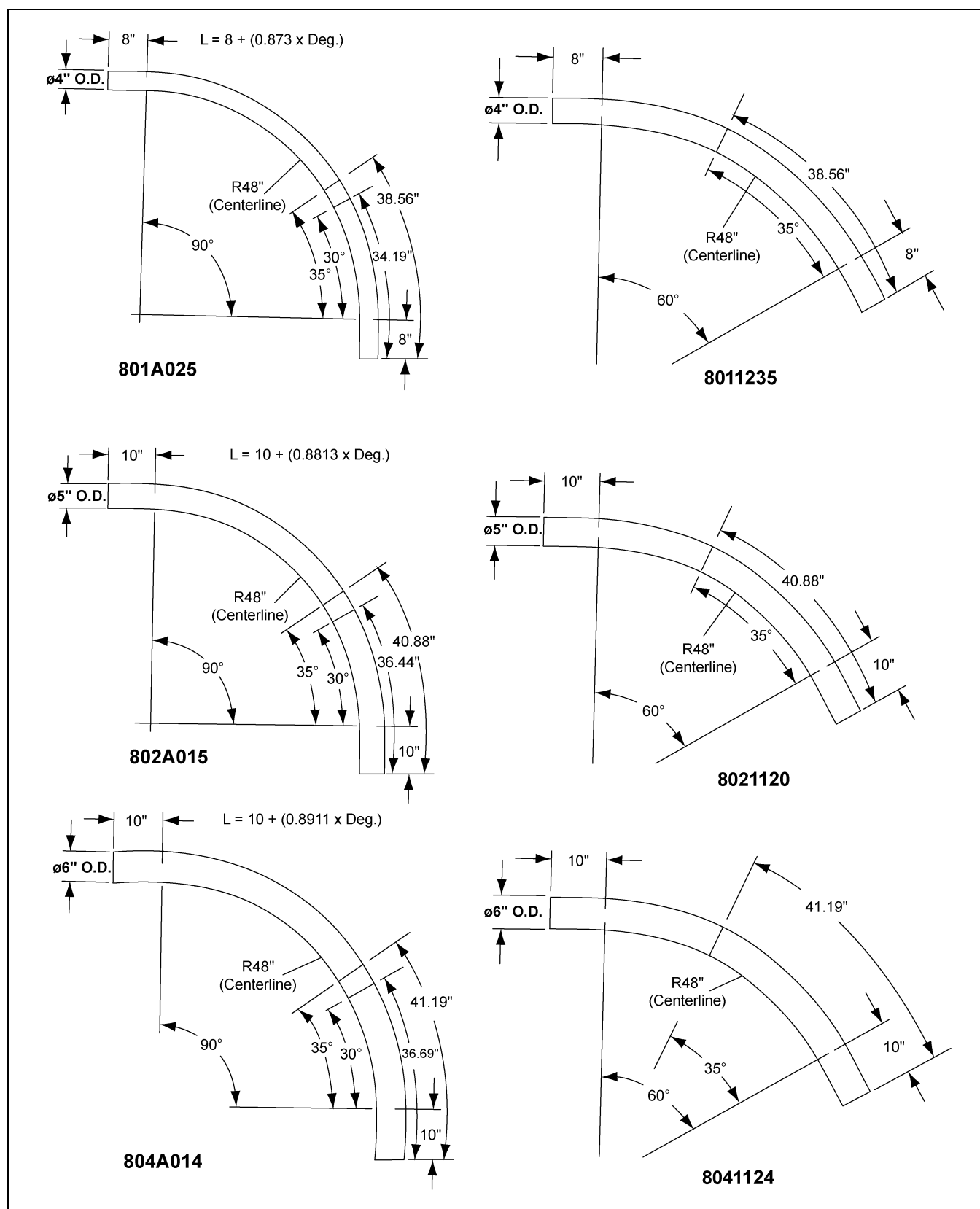


Figure 6A

### Air System Set-Up Procedures

1. The air filter extension tube and housing are connected to the blower inlet by a compression coupler. For extended filter life, if the pneumatic system is being operated in extremely dirty conditions, a longer extension tube can be used between the blower inlet and the air filter. BE SURE the air filter is positioned so that routine inspection and service can be performed.
2. Place the air filter element with pre-filter on the base and cover with the filter canister using the 3/8" wing nut and washer. The wing nut does not need to be more than finger tight. *(See Figure 7A, Figure 7B and Figure 7C.)*

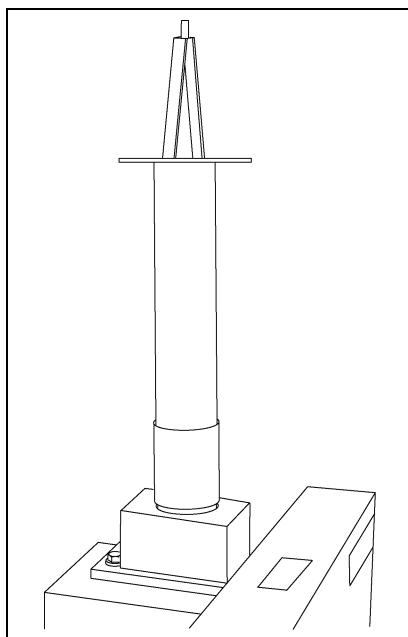


Figure 7A

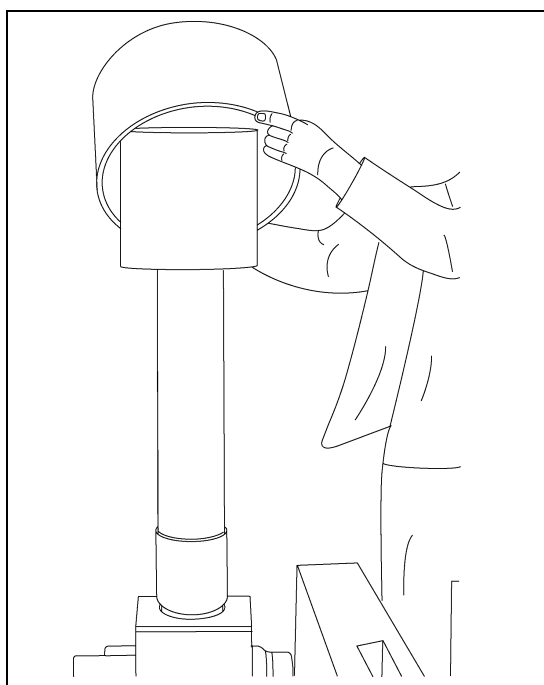


Figure 7B

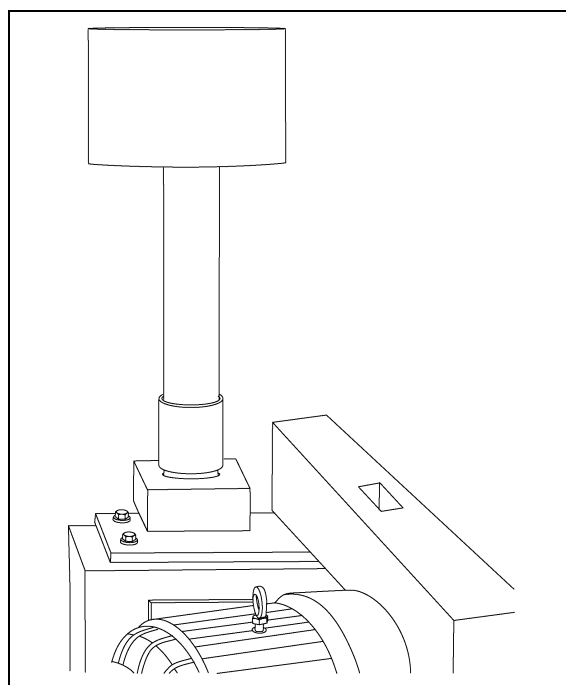


Figure 7C



3. Check the motor nameplate for the correct motor frame size. Remove the hardware shipped in the motor mounting plate. Locate the motor on the mounting plate using the hole pattern, which aligns with the motor base. Bolt the motor securely to the mounting plate with the supplied hardware that was previously removed. Loosen the four (4) 1/2" flange head bolts, which secure the motor mounting plate to the blower base. (See Figure 7D.)

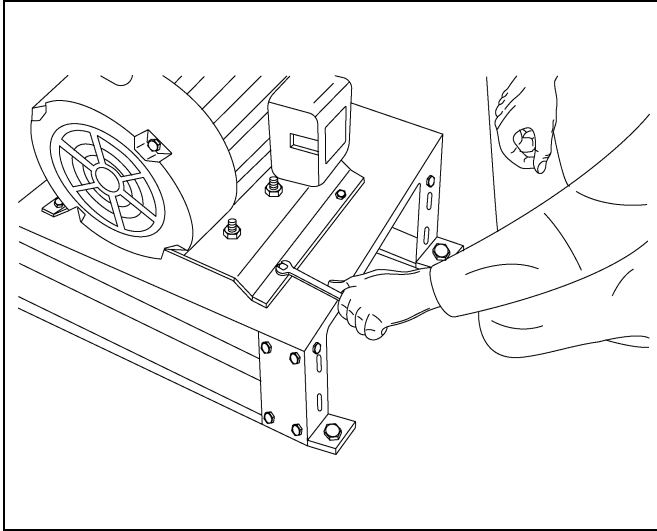


Figure 7D

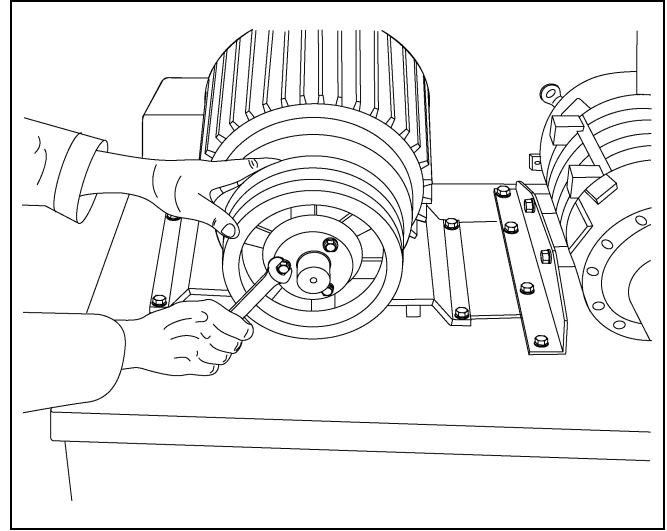


Figure 7E

4. Place the specified pulley onto the motor and align it with the blower pulley. (See Figure 7E.)
5. Place the matching set of V-belts on the pulleys. Tighten the belts by evenly turning the cap screws clockwise. Belts should have 3/8" deflection at 10 pounds pressure per belt. (See Figure 7F and Figure 7G.)

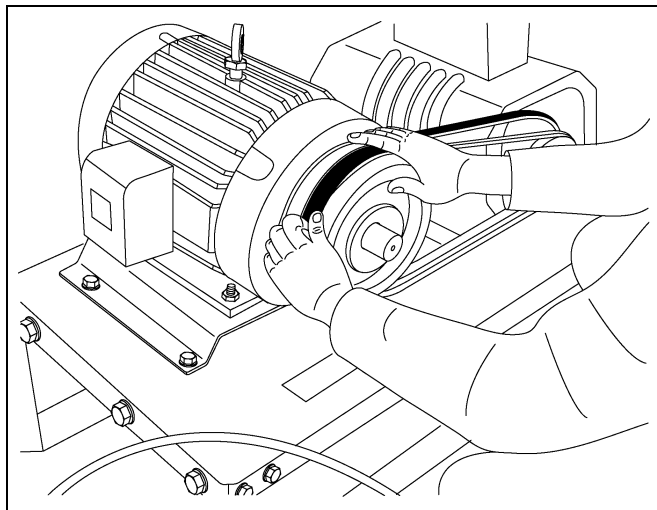


Figure 7F

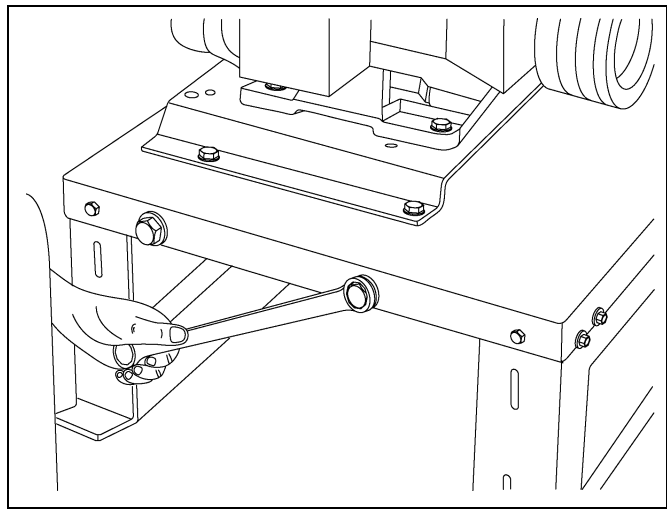


Figure 7G



**Too much tension on belts will cause blower damage.**

## 7. Assembly

6. Keeping the motor in proper alignment is necessary and can be accomplished by using an open end wrench to turn the nut on the take-up bolt closest to the rear of the motor. This nut is located behind the flange of the blower base. Adjust if necessary. Tighten the four (4) flange head bolts that secure the motor mounting plate to the blower base. Re-install drive shield. (See Figure 7H.)

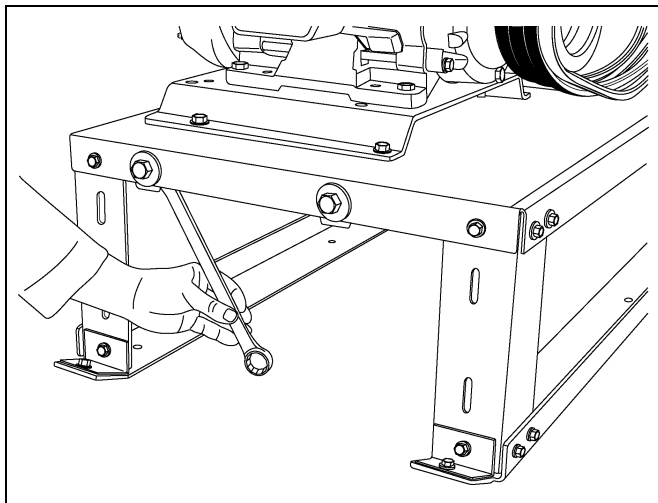


Figure 7H

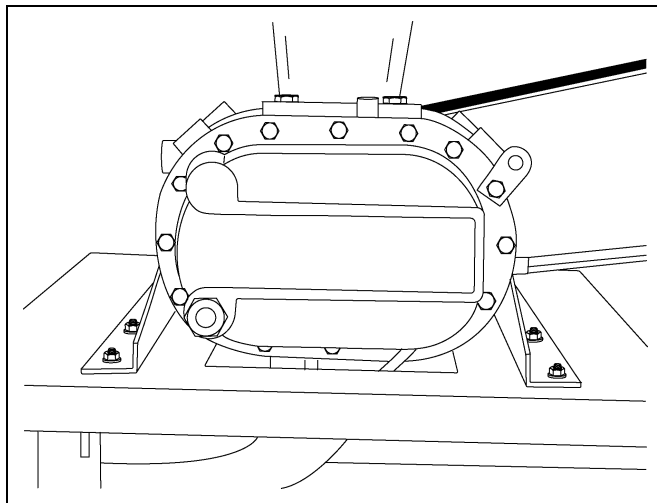


Figure 7I



**Rotate the motor by hand and listen for any rubbing or knocking by either the motor or the blower. When the motor is wired, it must be checked for CCW rotation.**

7. The oil level should be at the center of the sight glass on the blower. Add part # MS5389 if required. DO NOT operate blower until correct oil level is indicated. The 4" roots blower has sight glasses on both ends. Be sure oil levels are indicated on both sight glasses. (See Figure 7I.)
8. Using four (4) 5/16" x 3/4" flange head bolts, mount the motor to the airlock deck. Place the specified pulley on to the motor shaft and align to pulley on gearbox. (See Figure 7J.)

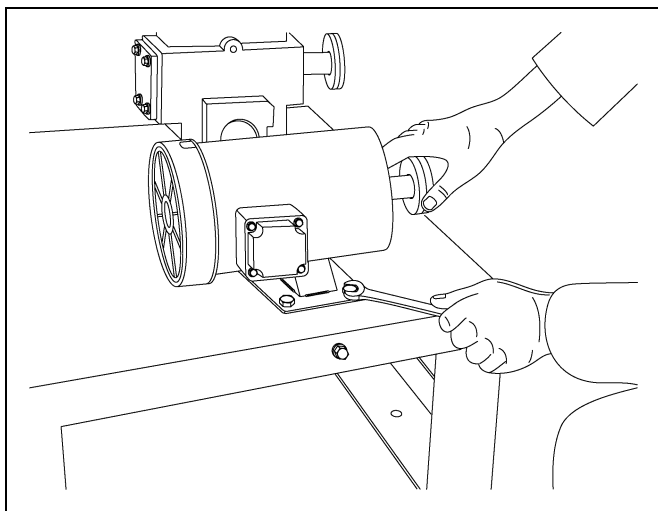


Figure 7J

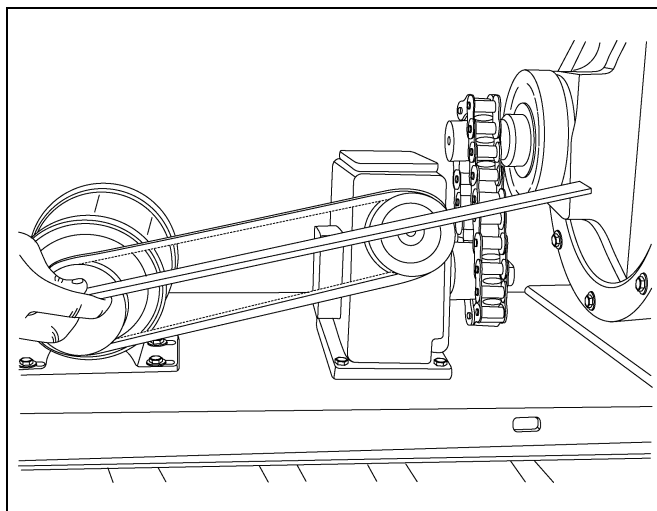


Figure 7K

9. Next, place the A-24 belt onto the pulleys. (See Figure 7K.) Tighten the belt to its proper tension of 3/8" deflection at 10 pounds of pressure by pulling motor away from gearbox. Tighten the four (4) 5/16" flange bolts on the motor base. Replace the belt shield.

10. Check the oil level in the gearbox by removing the plug and noting if the oil is at this level. Add SAE 80-90 gear lubricant if required. *(See Figure 7L.)*

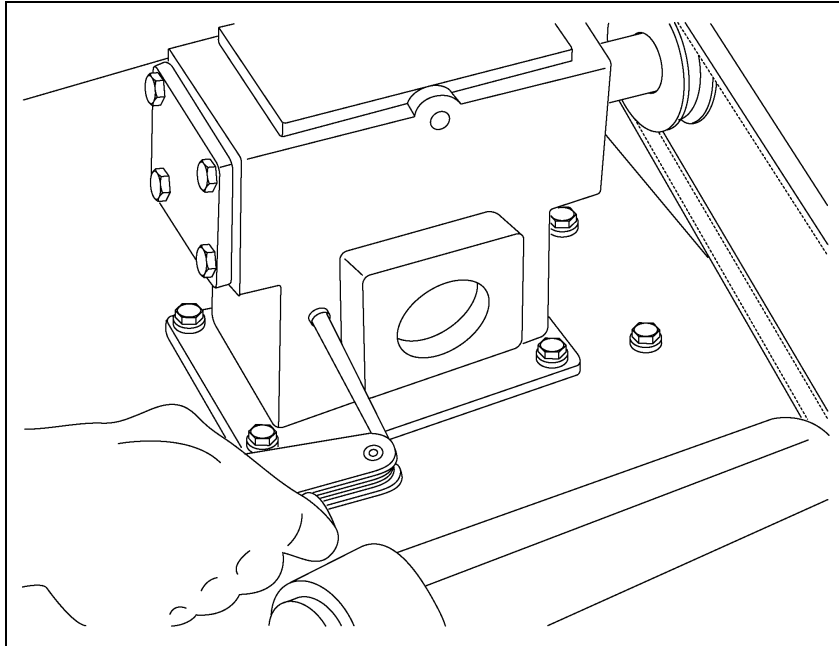


Figure 7L

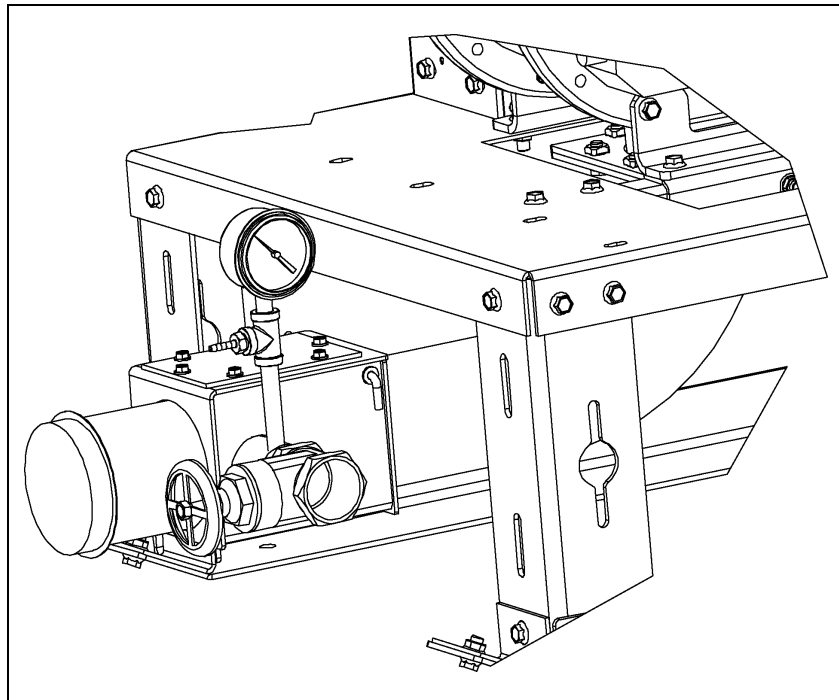


Figure 7M

11. Remove 1/4" pipe plug in gate valve pipe. Install gauge assembly and attach air hose. *(See Figure 7M.)*

**THE SET-UP OF THE PNEUMATIC AIR SYSTEM IS NOW COMPLETE.**

### Air System Control Box Definitions

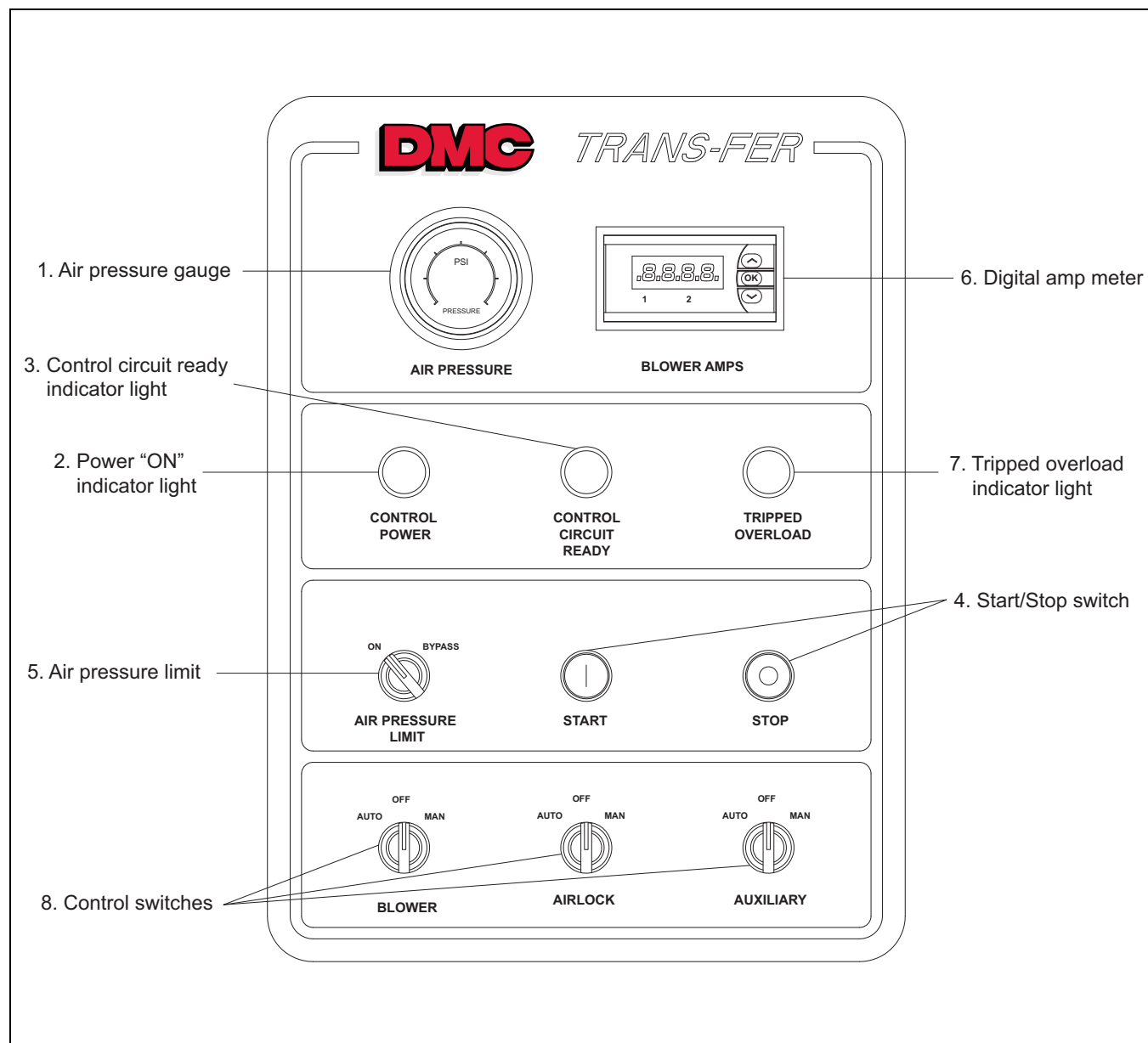


Figure 7N

## Control Overview

The redesigned control box for air systems now incorporates short circuit protection for each motor branch circuit. This is provided with circuit breakers which are the same as used in the portable dryers. In addition, the contactors and overloads are now IEC style controls (portable dryer parts also). This removes the need for separate thermal heater strips for the overloads. Be aware that the power connections to the new style box are different. The incoming power still enters at the lower right bottom of the box. The output power for the motors and remote control connections now exit the bottom of the box.



**Confirm that the overloads are set to the values shown on the “Overload Set Chart” on Page 23 before operating the system.**

The remaining operations are the same as the previous control box design.

1. **Air Pressure Gauge:** This gauge indicates the system air pressure.
2. **Power “ON” Indicator Light:** This lamp will illuminate when power is supplied to the control box.
3. **Control Circuit Ready Indicator Light:** This lamp will illuminate when the Start button has been pushed and all control circuits are completed. When lit and in the automatic mode, the air system will run whenever it receives a signal to start.
4. **Start/Stop Switch:** The Start button must be pushed before any part of the Air System can be run. Pushing the Stop button will immediately stop all functions.
5. **Air Pressure Limit Control Switch:** When in the “ON” position, this switch will allow the air pressure switch to immediately shut down the air system whenever the air pressure exceeds preset conditions.
6. **Amp Meter:** The amp meter measures the current flow to the blower motor.
7. **Tripped Overload Indicator Light:** This lamp will illuminate when any of the motor thermal overloads in the control box has tripped. The overloads for all three (3) circuits (aux, airlock and blower) must have thermal overloads installed to operate the system. See thermal unit chart [on Page 23](#).
8. **Control Switches:** The operation of the blower, airlock and auxiliary equipment of the air system is controlled by placing these switches in the “AUTO”, “MANUAL” or “OFF” position.
9. **Automatic Control Terminals:** When the air system is ready to run (i.e., the control ready light is ON), the system can then be started and run by completing the circuit between terminals 1 and 2. The blower, airlock or auxiliary equipment will not run in the automatic mode unless terminals 1 and 2 are connected. For example, a closing set of contacts in a dryer control box would complete the circuit between terminals 1 and 2 and automatically start the air system. ([See Figure 70 on Page 22.](#))



**No voltage should be supplied to terminals 1 and 2. See the diagrams on Pages 24-28.**

## 7. Assembly

10. **Remote Shut Down Control:** A remote piece of equipment can be caused to shut down with the air system by putting terminals 3 and 4 in series with the control circuit of the remote equipment. This circuit has a maximum current rating of 10 amps. The circuit between terminals 3 and 4 is closed whenever the control circuit ready light is ON, regardless of the position of the control switches ("AUTO", "OFF" or "ON"). See the diagram on [Page 24](#) and [Page 33](#).

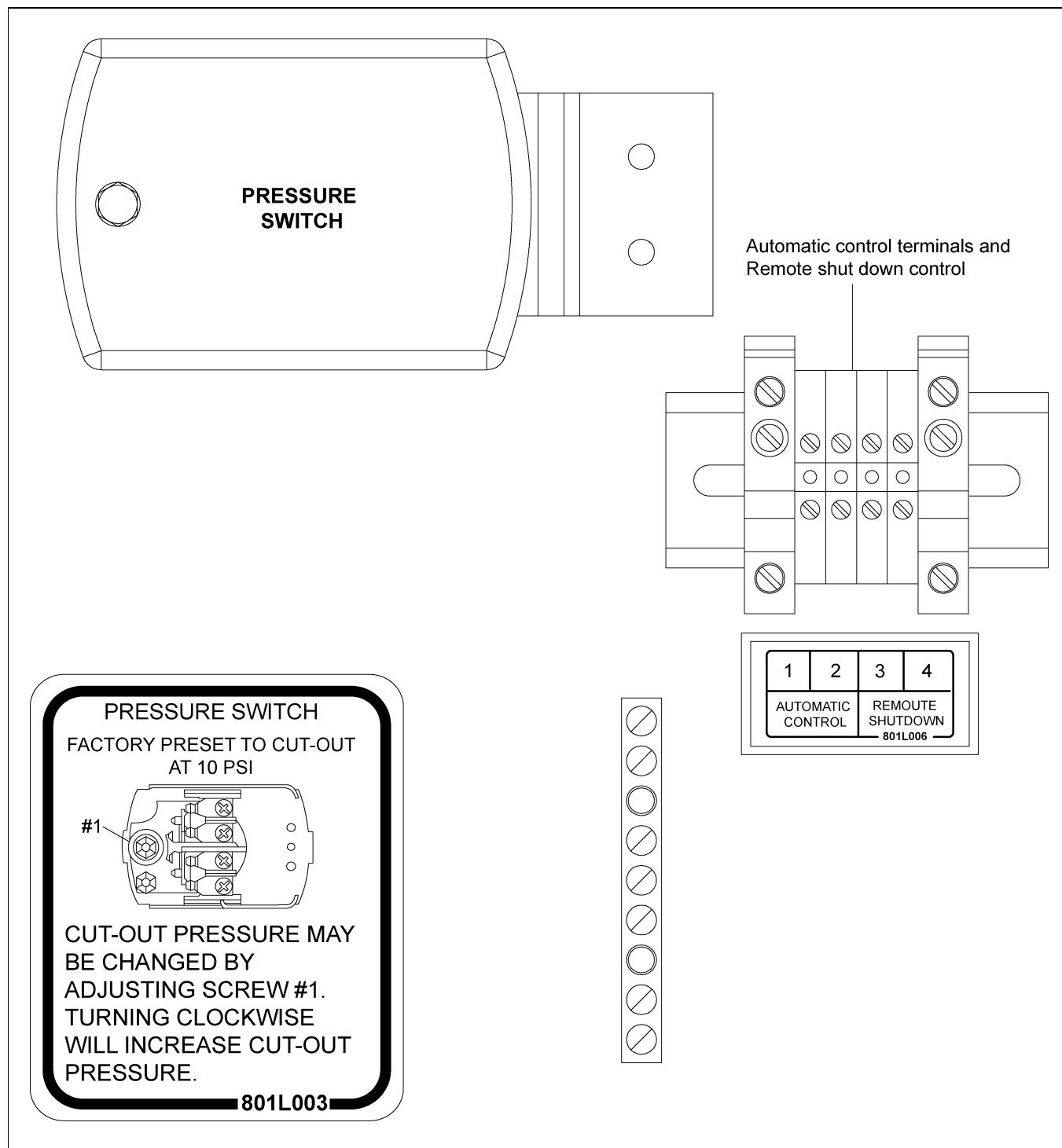


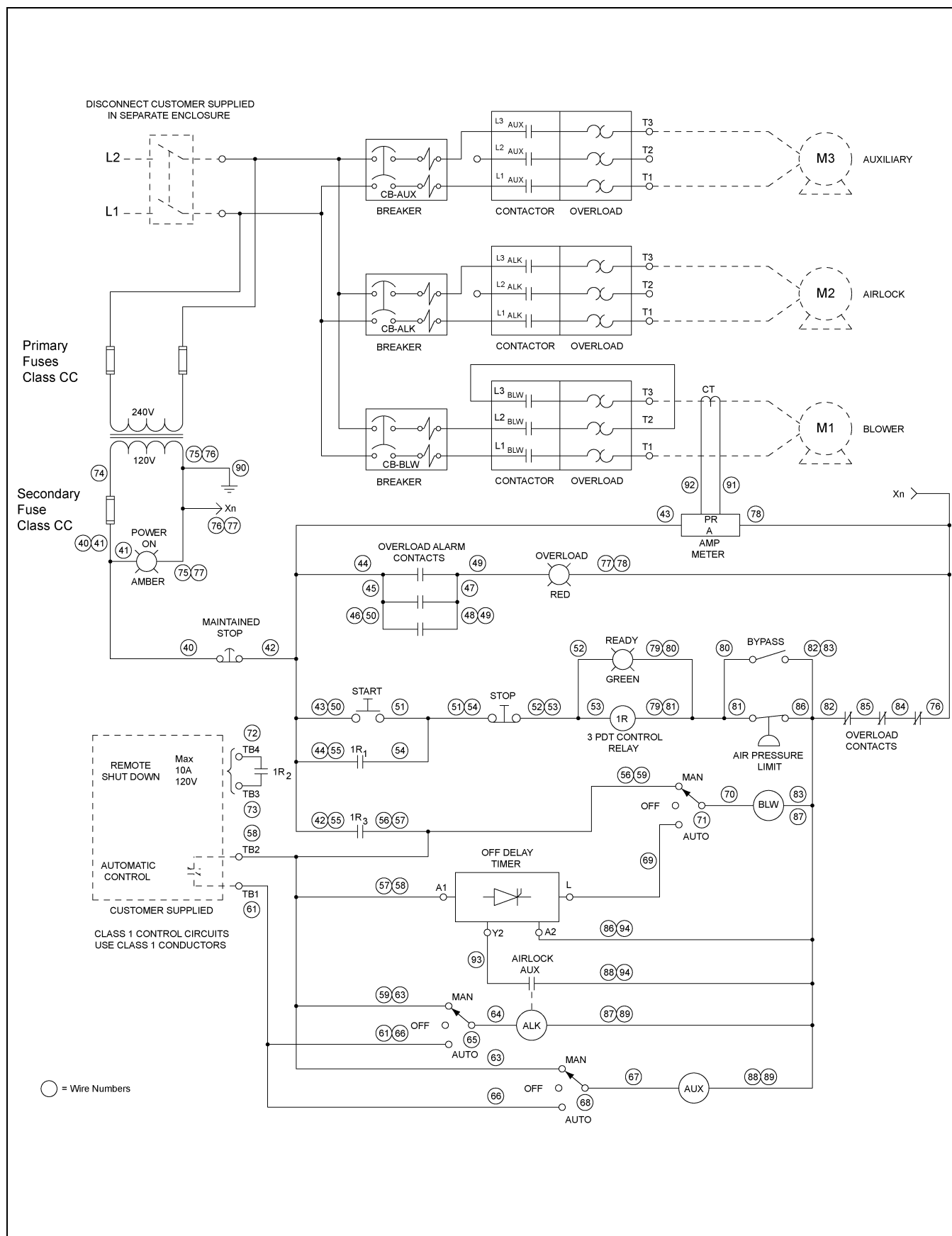
Figure 70 Auto Remote

## 4" and 5" Overload Set Chart

Single Motor	C-8693 Airlock O/L Relay 5.5-8 Amps	C-8694 Auxiliary O/L Relay 7-10 Amps	AS-0741 Airlock O/L Relay 2.5-4 Amps	056-1968-9 Auxiliary O/L Relay 4-6 Amps	056-1945-7 Airlock O/L Relay 1.6-2.5 Amps	056-1945-7 Auxiliary O/L Relay 1.6-2.5 Amps	AS-0777 Blower O/L Relay 9-13 Amps	056-1944-0 Blower O/L Relay 12-18 Amps	056-1943-2 Blower O/L Relay 17-25 Amps	056-2079-4 Blower O/L Relay 25-32 Amps	AS-0752 Blower O/L Relay 37-50 Amps	D03-0984 Blower O/L Relay 48-65 Amps	AS-0757 Blower O/L Relay 48-65 Amps	CH-1062 Blower O/L Relay 63-80 Amps	056-2276-6 Blower O/L Relay 90-150 Amps
AS-0669 Control Package - 10 HP 230V - 1 PH	6.4	8.0									38				
AS-0674 Control Package - 10 HP 230V - 3 PH			3.7	4.8						26					
AS-0678 Control Package - 10 HP 460V - 3 PH					1.7	2.1		13							
AS-0704 Control Package - 10 HP 575V - 3 PH					1.4	1.8	11								
AS-0670 Control Package - 15 HP 230V - 1 PH	6.4	8.0											55		
AS-0675 Control Package - 15 HP 230V - 3 PH			3.7	4.8							42				
AS-0679 Control Package - 15 HP 460V - 3 PH					1.7	2.1			21						
AS-0705 Control Package - 15 HP 575V - 3 PH					1.4	1.8		17							
AS-0676 Control Package - 20 HP 230V - 3 PH			3.7	4.8								54			
AS-0680 Control Package - 20 HP 460V - 3 PH					1.7	2.1				25					
AS-0706 Control Package - 20 HP 575V - 3 PH					1.4	1.8			21						
AS-0677 Control Package - 30 HP 230V - 3 PH			3.7	4.8										75	
AS-0681 Control Package - 30 HP 460V - 3 PH					1.7	2.1					37				
AS-0707 Control Package - 30 HP 575V - 3 PH					1.4	1.8				30					
AS-0671 Control Package - 40 HP 230V - 3 PH			3.7	4.8											95
AS-0682 Control Package - 40 HP 460V - 3 PH					1.7	2.1						51			
AS-0708 Control Package - 40 HP 575V - 3 PH					1.4	1.8					42				
<b>Twin Motor</b>															
AS-0668 Control Package - 10 HP 230V - 1 PH Twin	6.4	8.0									38				
AS-0667 Control Package - 15 HP 230V - 1 PH Twin	6.4	8.0											55		

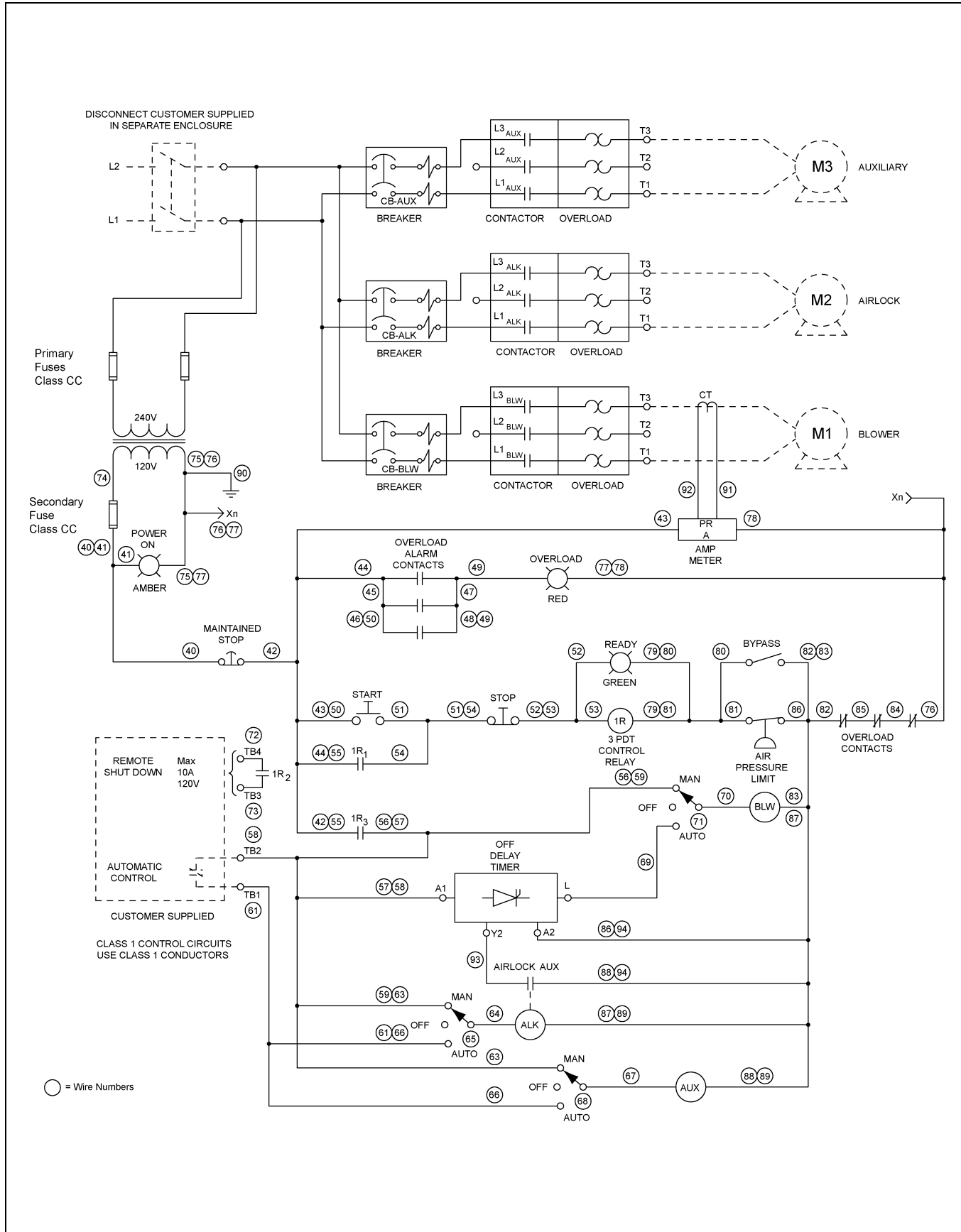
## 9. Schematic Diagrams

### Schematic - 230V 1 PH - 10 HP Standard



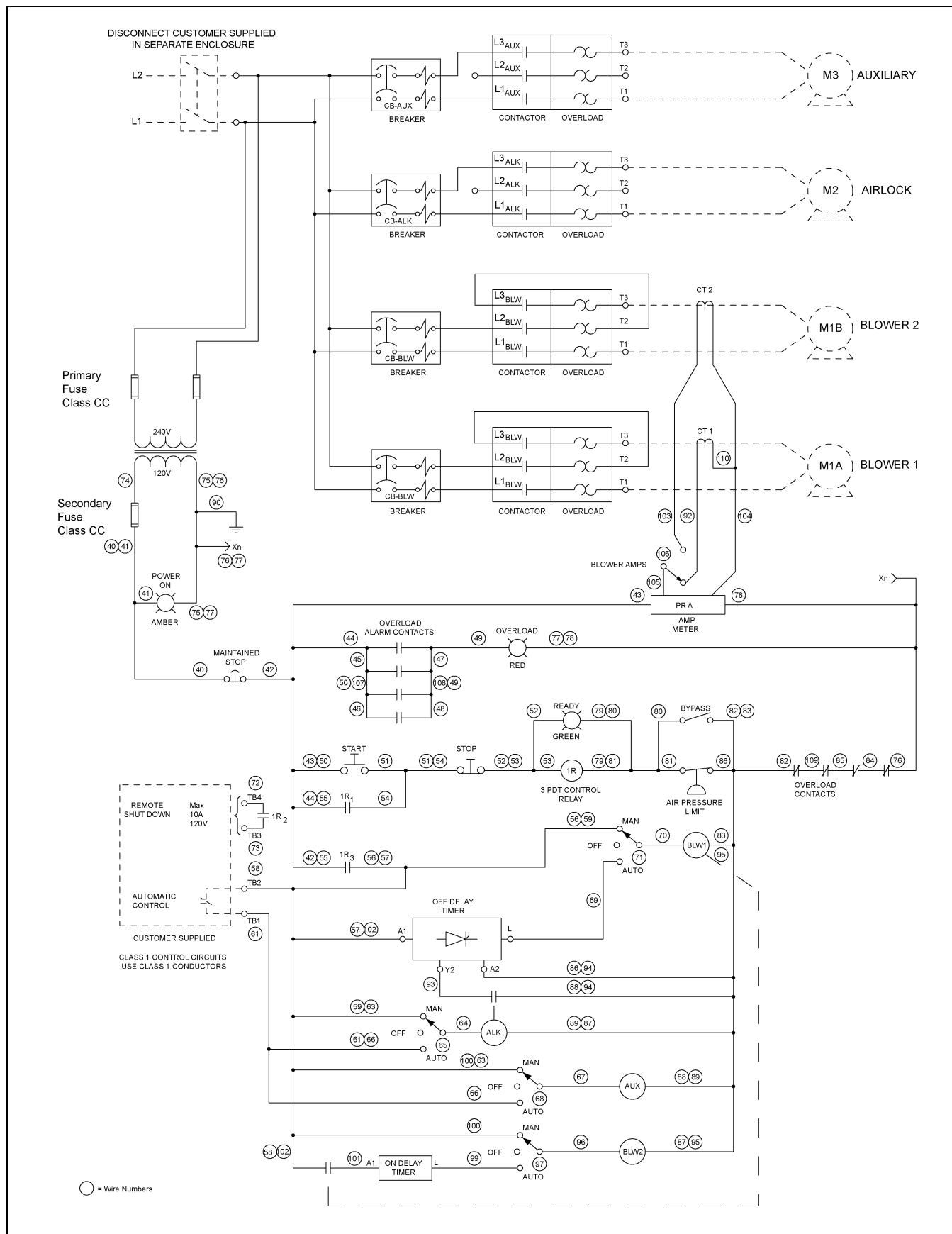


## Schematic - 230V 1 PH - 15 HP Standard

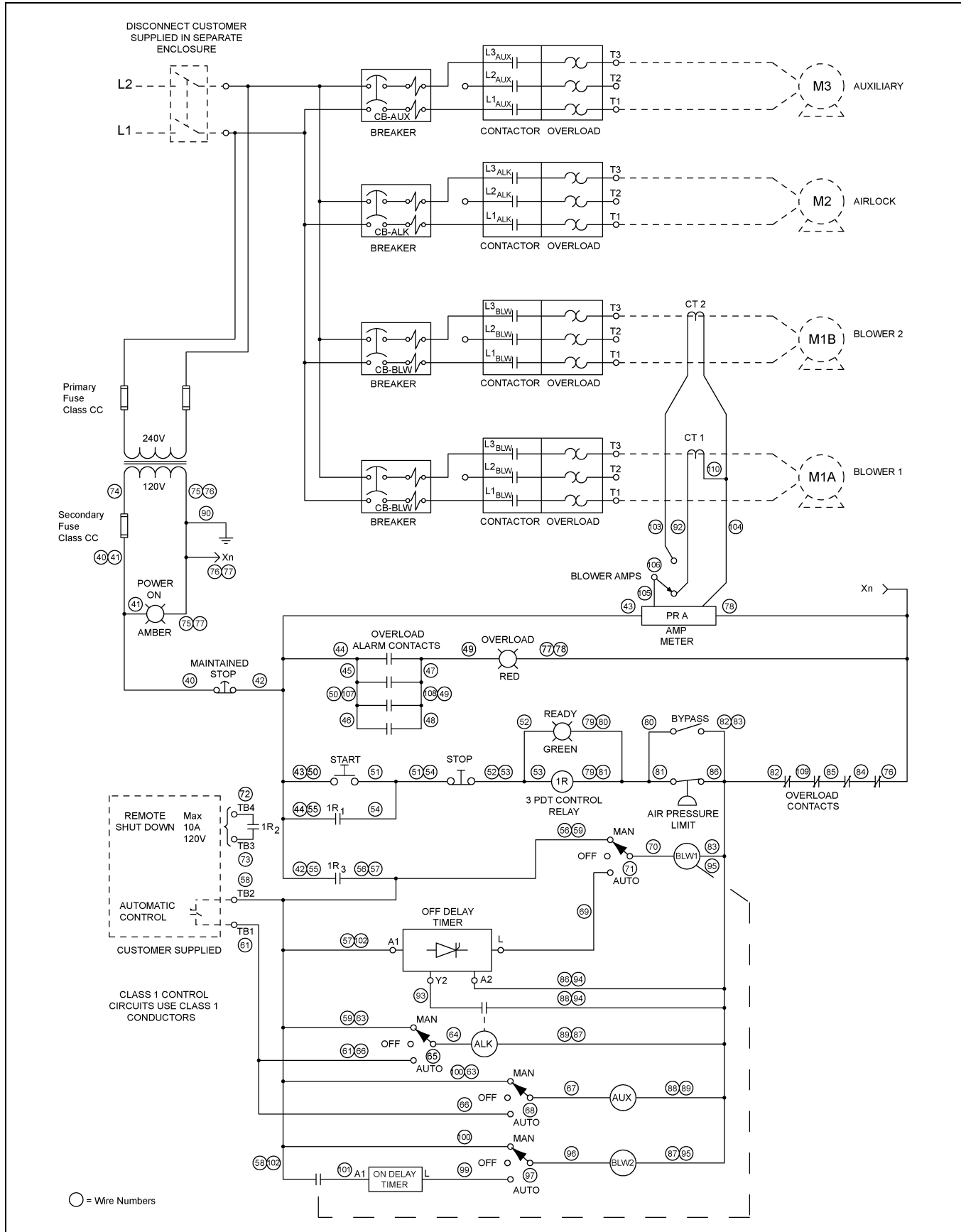


## 9. Schematic Diagrams

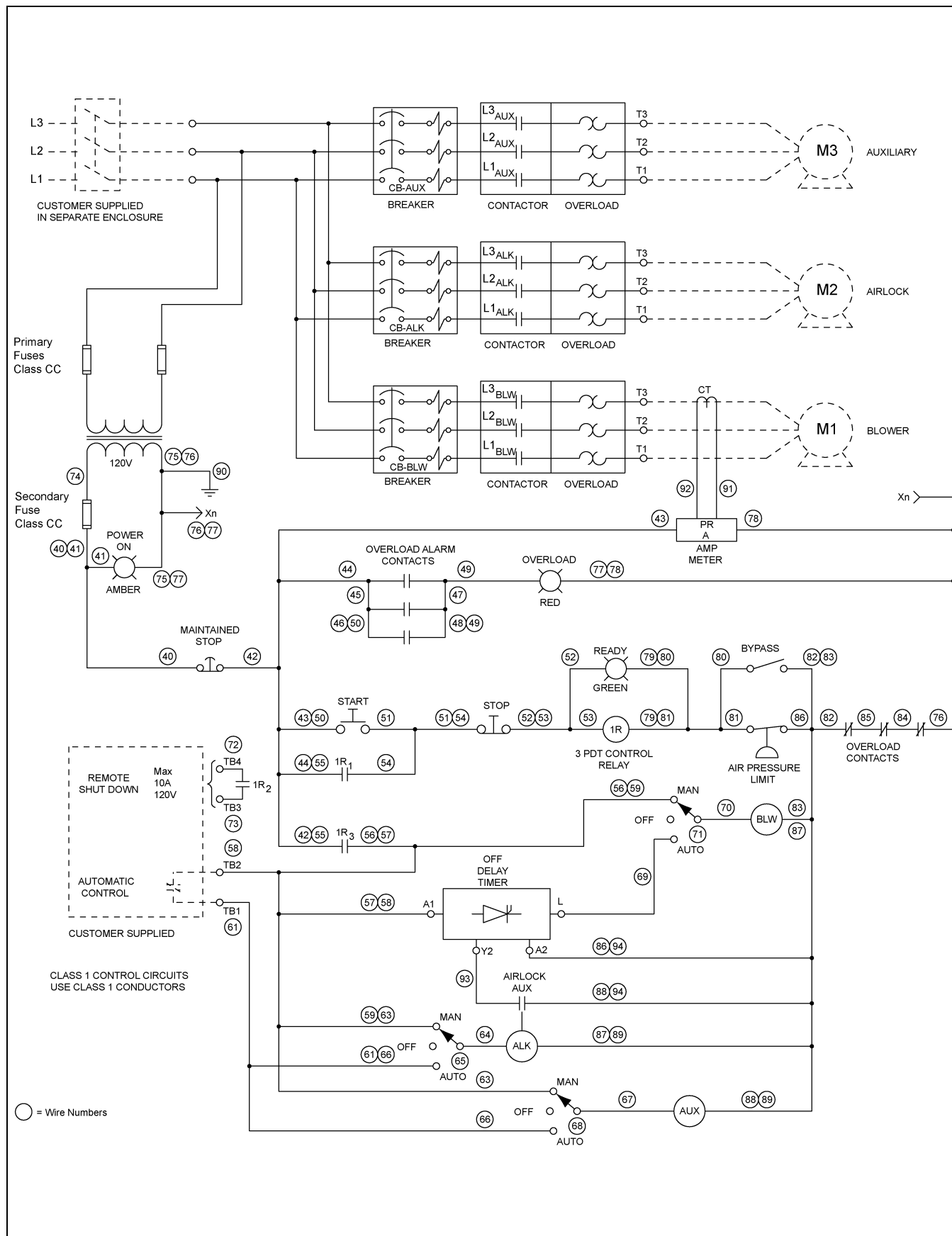
### Schematic - 230V 1 PH - 10 HP Twin



## Schematic - 230V 1 PH - 15 HP Twin



## Schematic - 230V/460V/575V - 3 PH



### Control Box Operational Procedures

#### Automatic operation using the automatic controller unit tied to terminals 1 and 2.

1. Switch all circuit breakers to the "ON" position.
2. Place the Blower, Airlock and Auxiliary Control switches in the "OFF" position.
3. Place the Air Pressure Limit Control switch in the "ON" position (unit will stop when the air pressure reaches 10 PSI).
4. Turn ON the power to the Air Systems control box. The power light should come ON.
5. Push the Start button. The control circuit ready light should come ON.
6. Place the Blower, Airlock and Auxiliary switches in the "AUTO" position.
7. The complete air system will now run when the automatic controller completes the circuit between terminals 1 and 2. When this circuit is broken, the airlock and auxiliary equipment will stop immediately, but the blower will continue to run for an additional 15 seconds to clear the tubing in the system.
8. The airlock, auxiliary equipment and blower will run when the control switches are placed in the "MANUAL" mode. The airlock, auxiliary equipment and blower will stop immediately when switched "OFF".
9. Pushing the Stop button will immediately stop all air system functions as well as any equipment tied to terminals 3 and 4.

#### Operation of the air system WITHOUT an automatic controller tied to terminals 1 and 2.

1. Switch all circuit breakers to the "ON" position.
2. Place the Blower, Airlock and Auxiliary Control switches in the "OFF" position.
3. Place the Air Pressure Limit Control switch in the "ON" position (unit will stop when the air pressure reaches 10 PSI).
4. Turn ON the power to the Air System control box; the power light should come ON.
5. Push the Start button. The control circuit ready light should come ON.
6. The blower, airlock and auxiliary equipment can now be run by placing them in the "MANUAL" position. The airlock, auxiliary equipment and blower will stop immediately when switched OFF.
7. Pushing the Stop button will immediately stop all air system functions as well as any remote equipment tied to terminals 3 and 4.

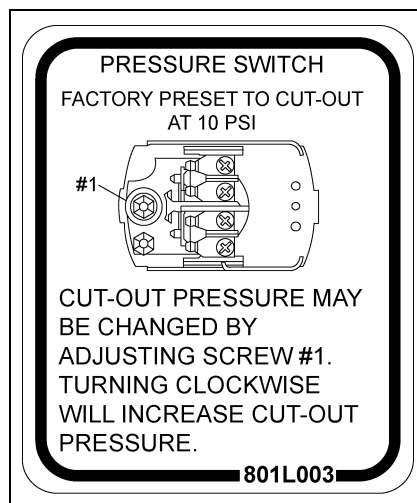
### Air System Operation Guidelines

1. Be aware of the quality of grain that is entering and leaving the air system. Grain damage can occur with any pneumatic system unless care is taken to adjust the velocity of the grain. This can be done by opening or closing the outlet gate valve on the blower outlet of the Air System. Opening the valve will let air out of the tubing system which will slow the velocity of the air and grain in the tubing system. A recommended procedure is to open the valve slowly until the line pressure begins to surge and then to close it by 1/2 turn. This will provide the slowest possible grain velocity for any tubing system. This procedure for adjusting the air velocity should be repeated for each different tubing layout and capacity change.
2. If the tubing system should become plugged, place the air pressure limit switch to the "OFF" position, switch the airlock and auxiliary equipment to "OFF" and the blower to "MANUAL". Note the opening of the outlet gate valve, then open it completely so all the air is exhausted when the blower is started. Push the Start button and the blower will start. Slowly close the outlet gate valve until the grain starts moving and clears the tube. Adjust the valve as explained in [Step 1](#). It should be the same as noted before adjusting. Operate the airlock and auxiliary equipment in "MANUAL" until all grain is out of the system.



***Do not stand next to the exhausted air.***

3. The air pressure limit switch should always be in the "ON" position during routine operation to provide protection to the blower against overload conditions. The air pressure limit is set at the factory to shut down the system at 10 PSI. If adjustment is needed, rotate the adjusting screw counterclockwise to lower the pressure limit or clockwise to increase the pressure limit. A one-half (1/2) turn of the screw will change the pressure limit 1 PSI.



**Figure 10A**

**NOTE:** *If the pressure limit is set below 5 PSI, the switch may not reset and allow the air transfer to run. (See [Figure 10A](#).)*

4. The air filter element should be inspected daily and cleaned when required. Both the poly foam pre-filter and the filter element can be cleaned by blowing air through them or washing them with mild detergent and water. A restricted air filter will cause a system to become plugged. It should always be inspected whenever plugging occurs.
5. The airlock is provided with a housing that incorporates grain shear protection to prevent grain damage.

### 6. GUIDELINES FOR OPERATION OF AIR SYSTEMS

- a. Grain in a pneumatic air system running at full capacity will move at about 60% of the air speed. A system operating at low capacities will move grain at 80%-90% of the air speed.
- b. Decreasing the amount of air in the system (opening the hand gate valve) will cause the grain to move slower and also cause the air pressure to rise. (Essentially, the grain is causing the air to “pile up”.)
- c. Increasing the air in a system (closing the gate valve) will increase the grain velocity and lower the pressure.
- d. TYPICAL RUNNING CONDITIONS ARE:
  - A 4" system running full with 15 HP will have a system pressure of 4-5 PSI.
  - A 5" system running full with 30 HP will have a system pressure of 5-6 PSI.
  - A 5" system running full with 40 HP will have a system pressure of 6-7 PSI.

### 7. OPERATION OF TWIN MOTOR TRANSFER OPTION

The twin motor option allows an air system to use two (2) 1 phase motors to provide extra power when 3 phase electricity is not available.

The twin motor control box is different from the standard control box because it has an additional magnetic contactor and an “On-Delay” timer for stagger starting the second motor to minimize voltage drop during the starting operation. It also has a selection switch to display the amperage of each motor.

It is important to use two (2) motors of similar model and size because it is normal for motors to run at slightly different amperages and for one to be more heavily loaded than the other. Using similar motors will minimize this condition.

Check the amperage of each motor periodically by using the selection switch on the control panel. Leave the switch in position to monitor the motor with the highest amperage. It is important to periodically check both motor amperages to ensure that they are sharing the load. For example, if the belts for one motor would start to slip, then the other motor would take on the additional load and become overloaded.

**NOTE:** *Twin drive capacities are approximately 80% of single drive units.*

### 8. RECOMMENDATIONS FOR OFF-SEASON STORAGE

The blower and airlock have precision machined components and must be protected to prevent corrosion and rust from forming on the blower lobes and airlock vanes. These parts should be coated with motor oil after each drying season. (Spray lubricants such as WD-40 do not usually provide adequate protection.)

Both the airlock and blower assemblies should be carefully protected from the weather and the piping system disconnected from the blower and airlock. Remove the transition connection to the airlock inlet and re-install the weather cover shipped with the airlock. This is important to prevent condensation from collecting in the airlock and blower.

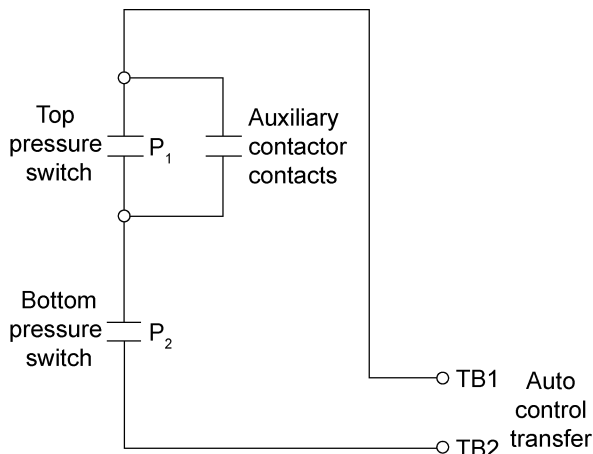
## 11. Hook-Up Diagrams

### Wiring for a surge tank hooked to an Air System

The Air System will start when both  $P_1$  and  $P_2$  are closed. As it empties,  $P_1$  will open but will not stop the unit due to auxiliary contacts being closed. When  $P_2$  opens, the unit will stop.

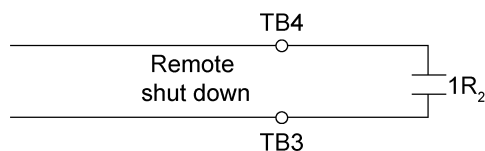
**NOTE:** Be sure the auxiliary switch is in the "AUTO" position.

$P_1$  and  $P_2$  are pressure switches.

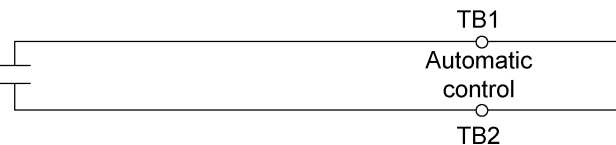


### How to hook-up Air System to remote equipment

Remote equipment control circuit



Any contact that closes upon start and opens on stop. (**NOTE:** This contact must not have any external AC power.)



With the above hook-up, the Air System must be started before the remote equipment. If the Air System is manually turned OFF or turned OFF from high pressure or an overload, the remote equipment will also turn OFF.

TB3 and TB4 will have a closed contact ( $1R_2$ ) as long as the air system has the "ready" indicator (located in the control box) ON. The automatic control TB1 and TB2 requires a closed contact across them to start the air system unit.



## Programming Parameters for PR Electronics 5714A

To begin programming: Turn power ON, then press OK.

Ref #	On Display	Action	Set to Value	End
1	IN	Press either Arrow	CURR	Press OK
2	RANG	Press either Arrow	4-20	Press OK
3	DEC.P	Press either Arrow	<i>See Note 1</i>	Press OK
4	DI.LO	Press either Arrow	0	Press OK
5	DI.HI	Press either Arrow	<i>See Note 2</i>	Press OK
6	EPAS	Press either Arrow	No	Press OK
7	-	END of Inputs		

### NOTES:

1. This parameter determines the location of the decimal point in the displayed value. This should be set to 11.11 for values of 10-99 and 111.1 for values greater than 100.
2. This parameter determines the scale of the displayed value and should be matched to the control transformer range setting such as 30, 60, 120 for H921 or 200 for 721HC.

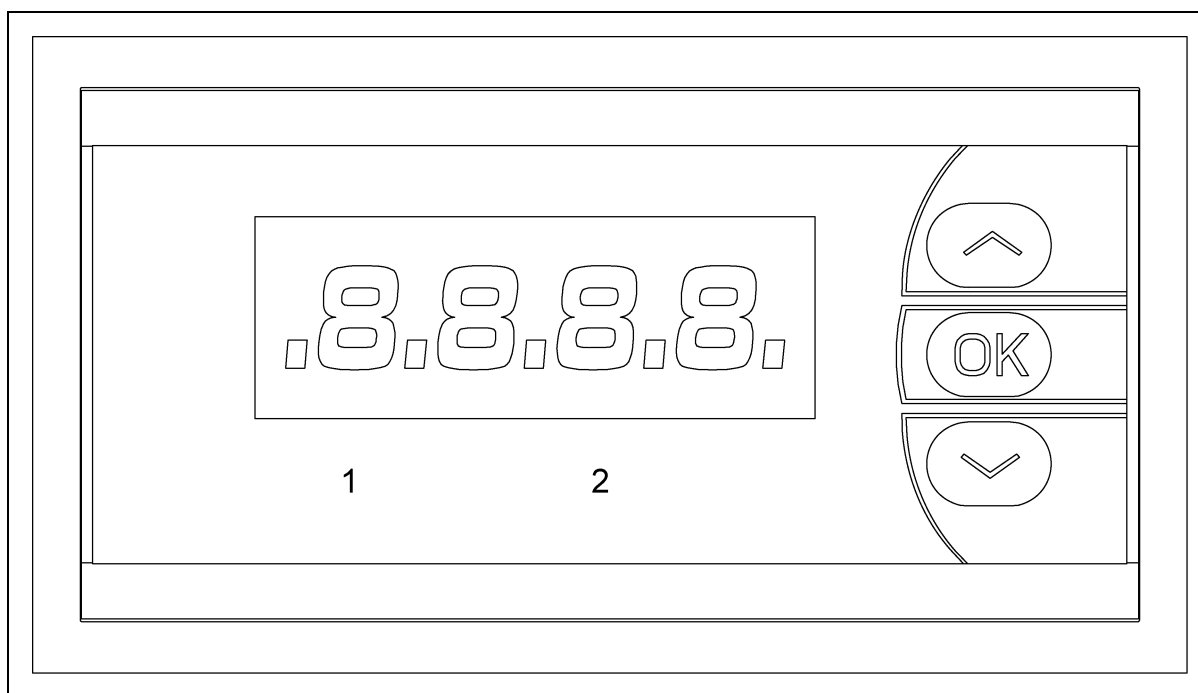
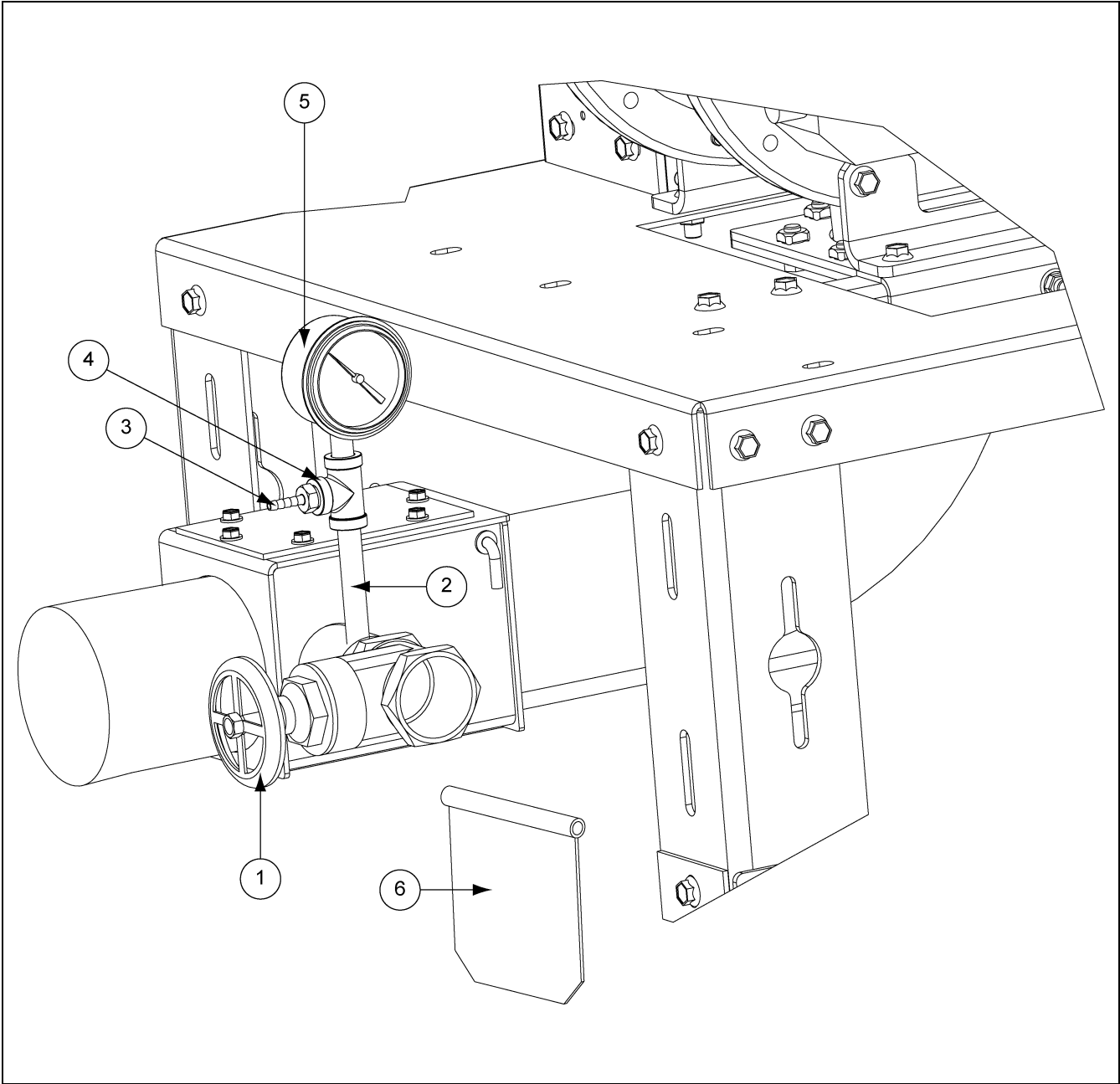


Figure 11A Blower Amps

# NOTES

1. Blower Outlet Parts
2. 4" (700) and 5" (1200) Standard Blower Parts
3. 4" and 5" Twin Blower Parts
4. 5" (1700) High-Capacity Blower Parts
5. 5" (1700) Twin High-Capacity Blower Parts
6. 4" and 5" Blower Filters
7. 4" and 5" Airlock Parts
8. Airlock Inlet Transition Assembly
9. Inner Door Assembly - Standard
10. Inner Door Assembly - Twin
11. Standard Control Panel Assembly 230V - 1 Phase
12. Twin Control Panel Assembly 230V - 1 Phase
13. Standard Control Panel Assembly 10-40 HP 230V - 3 Phase
14. Standard Control Panel Assembly 10-40 HP 460V - 3 Phase
15. Standard Control Panel Assembly 10-40 HP 575V - 3 Phase

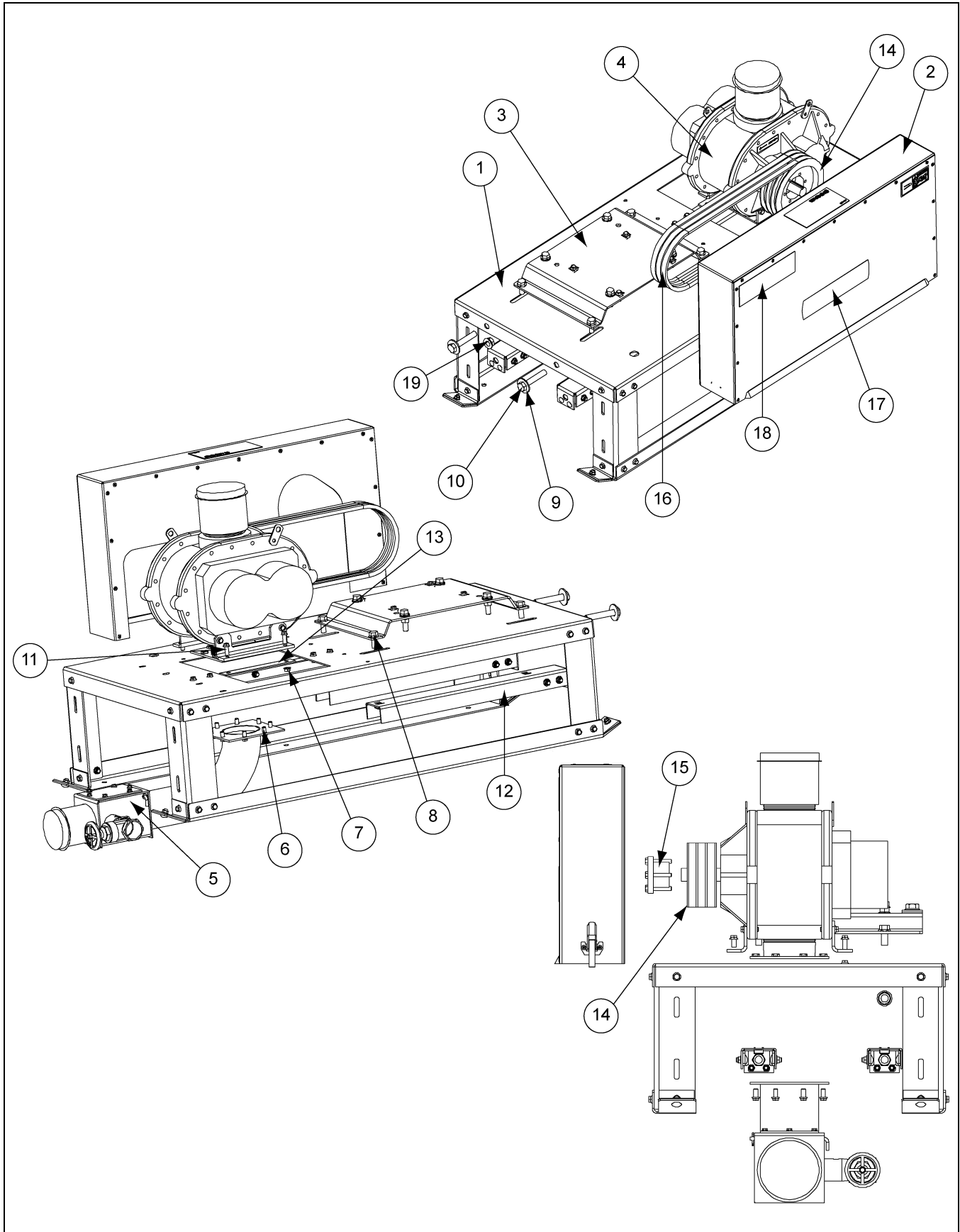
Blower Outlet Parts



## Blower Outlet Parts List

Ref #	Part #	Description	Qty		
			4"	5"	6"
1	PT1132	Gate Valve, 1-1/2" NPT	1	1	1
2	4FH0509	Pipe Nipple, 1/4" NPT x 3 Galv. SCH 40	1	1	1
3	4FH0971	Hose Barb, 1/4" x 1/4" MPT Brass	1	1	1
4	4FH0581	Pipe Tee, 1/4" FPT Galv.	1	1	1
5	PT1127	Gauge, Oil Filled 0-15 PSI	1	1	1
6	8021235	Check Valve Plate Weld - 4"	1	-	-
6	8021235	Check Valve Plate Weld - 5"	-	1	-
6	8041200	Check Valve Plate Weld - 6"	-	-	1

## 4" (700) and 5" (1200) Standard Blower Parts

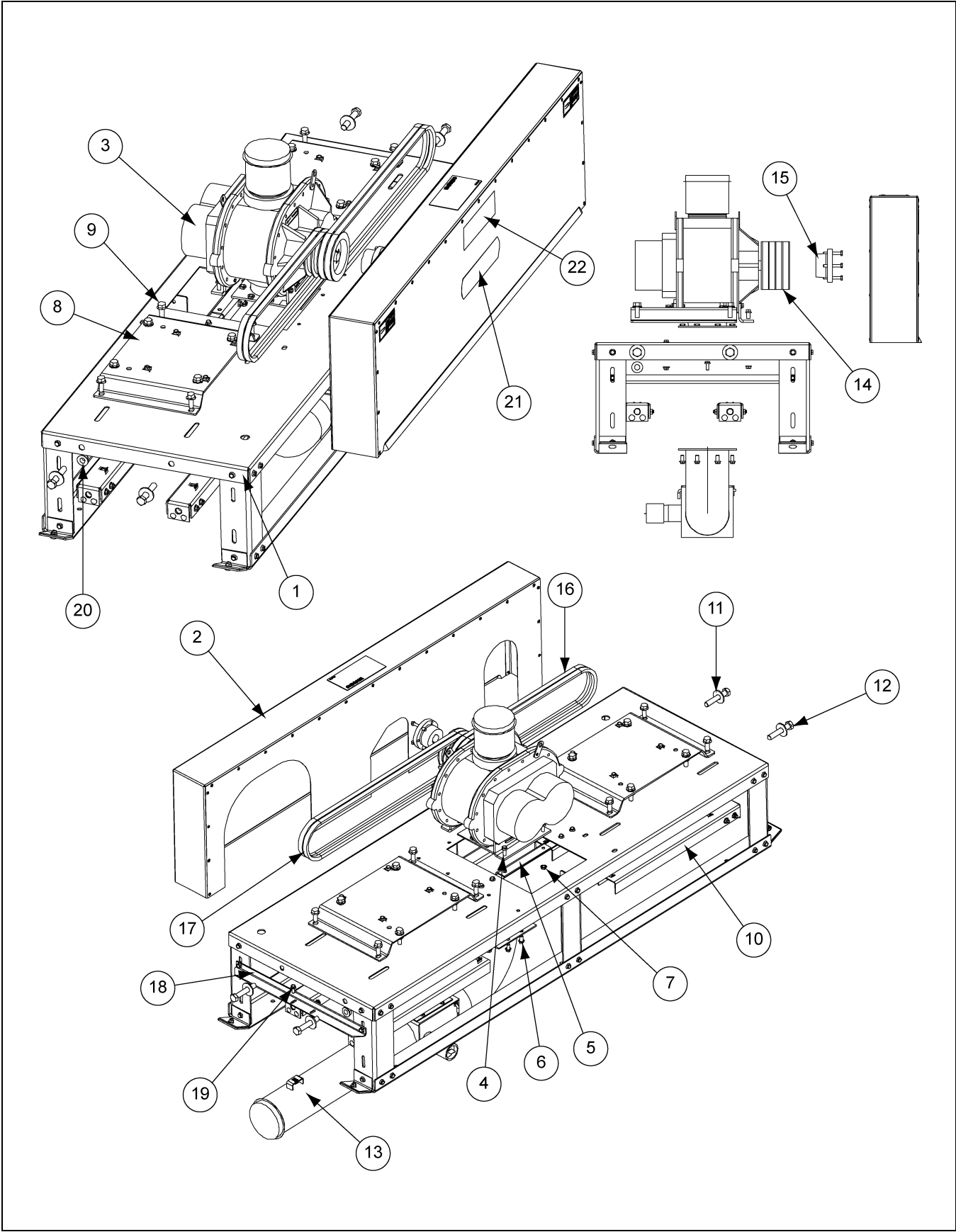


## 4" (700) and 5" (1200) Standard Blower Parts List

Ref #	Part #	Description	Qty	
			4"	5"
1	AS-0003	Blower Base Assembly - 4" and 5"	1	1
2	AS-0108	Drive Guard Assembly - 4" and 5" Standard Blower	1	1
3	AS-0047	Motor Mounting Plate Assembly - 4" Air Systems	1	-
3	AS-0058	Motor Mounting Plate Assembly - 5" Air Systems	-	1
4	8011266	Blower Sub-Assembly - 4" and 5" Standard DMC	1	1
4	8011266F	Blower Sub-Assembly - 4" and 5" Standard FFI	1	1
5	AS-0088-D	Blower Outlet Elbow Assembly - 4" DMC	1	-
5	AS-0088-F	Blower Outlet Elbow Assembly - 4" FFI	1	-
5	AS-0092-D	Blower Outlet Elbow Assembly - 5" DMC	-	1
5	AS-0092-F	Blower Outlet Elbow Assembly - 5" FFI	-	1
6	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	14	14
7	S-968	Flange Nut 3/8"-16 ZN Grade 5	8	8
8	S-9062	Flange Bolt 1/2"-13 x 1-1/4" ZN Grade 5	4	4
9	S-858	Flat Washer 5/8" USS ZN	2	2
10	2FH1043	Bolt, 5/8"-11 x 3-1/2" HHTB Grade 2 Plated	2	2
11	S-9065	Flange Bolt 3/8"-16 x 1" ZN Grade 5	2	2
12	AS-0025	Motor Adjust Rail Assembly	2	2
13	AS-0042	Blower Support/Shim Assembly - 4" and 5"	1	1
14	PT0664	Pulley QD 7-3/4" O.D. x SK Bush 3AB	1	-
14	PT0602	Pulley (Solid) 5-1/2" O.D. x SD 3AB	-	1
15	PT0772	Bushing QD Style SK, 1-1/8" Bore	1	-
15	PT0794	Bushing SD x 1-1/8" Bore	-	1
16	MHC00028	V-Belt BX60	3	-
16	PT1179	V-Belt BX58	-	3
17	801L001	Decal, Logo - DMC Transfer 700	1	-
17	8027012	Decal, Logo - DMC Transfer 1200	-	1
17	420-1443-1	Decal, Logo - FFI 14-1/2" x 12"	1	1
18	DC-1330	Decal, Logo - DMC 2-7/8" x 9"	1	1
19	S-9259	Flange Nut 5/8"-11 ZN	1	1
-	PT1132	Gate Valve, 1-1/2" NPT	1	1

Motors and Drive Parts (Not Shown)			
Part #	Description	Qty	
		4"	5"
PT0666	Pulley QD 8.95" O.D. x SK Bush 3AB	x	x
MHC60010-1	Motor 10 HP 1 PH 1800 RPM	x	x
MTR-0052	Motor 10 HP 3 PH 1800 RPM	x	x
PT0778	Bushing SK 1-3/8" Bore QD Style	x	x
CH-5753	Motor 15 HP 1 PH 1800 RPM ODP	x	x
3EL5069	Motor 15 HP 1 PH 1800 RPM TEFC	x	x
MTR-0022	Motor 15 HP 3 PH 1800 RPM	x	x
MTR-0025	Motor 20 HP 3 PH 1800 RPM	x	x
GC03810	Bushing SK 1-5/8" Bore QD Style	x	x
MTR-0056	Motor 30 HP 3 PH 1800 RPM	-	x
CE-00617	Bushing SK 1-7/8" Bore QD Style	-	x

4" and 5" Twin Blower Parts



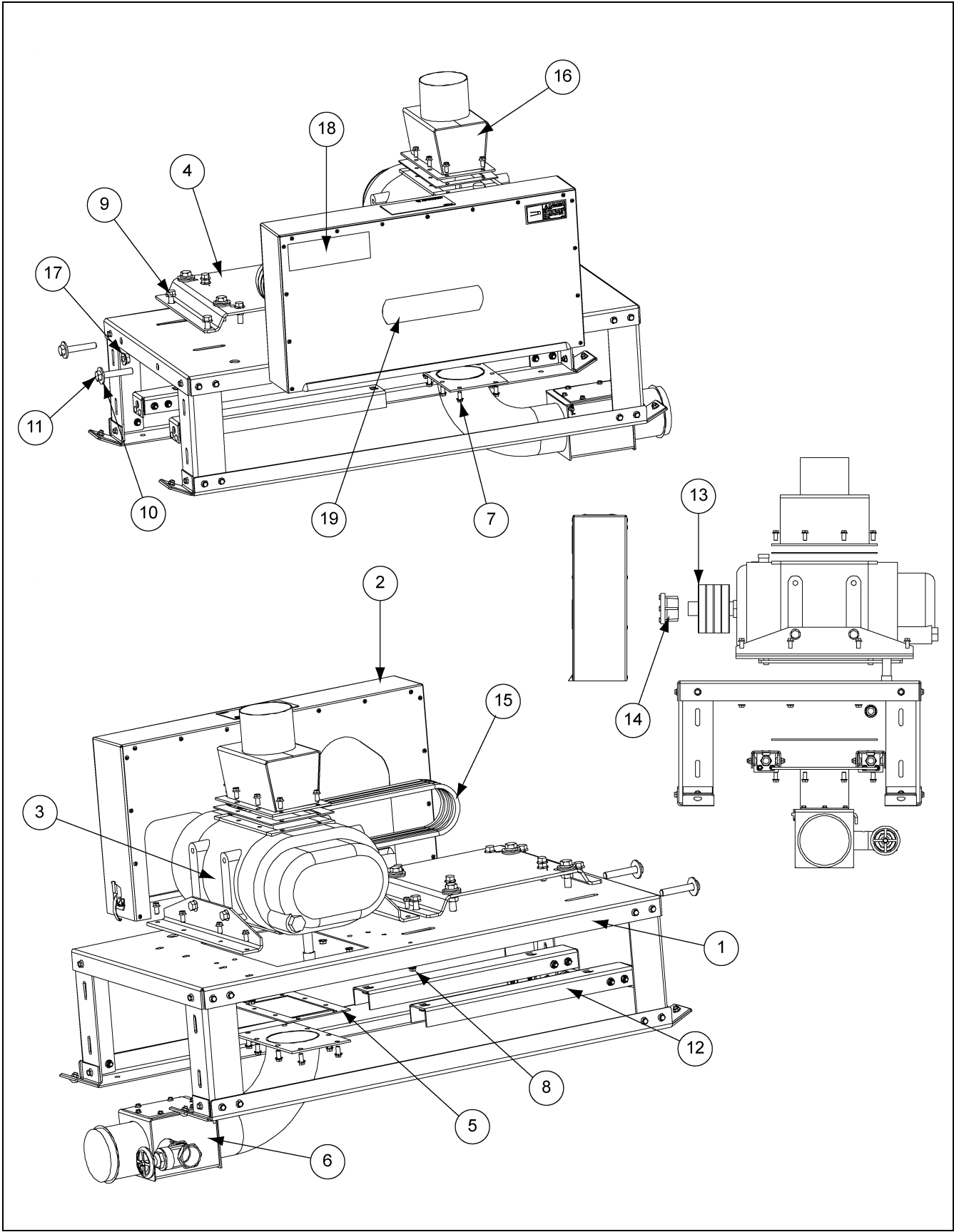


## 4" and 5" Twin Blower Parts List

Ref #	Part #	Description	Qty	
			4"	5"
1	AS-0007	Blower Base Assembly - 4" and 5" Twin	1	1
2	AS-0110	Drive Guard Assembly - 4" and 5" Twin Blower	1	1
3	8011266	Blower Sub-Assembly - 4" and 5" Standard DMC	1	1
3	8011266F	Blower Sub-Assembly - 4" and 5" Standard FFI	1	1
4	S-9065	Flange Bolt 3/8"-16 x 1" ZN Grade 5	2	2
5	AS-0042	Blower Support/Shim Assembly - 4" and 5"	1	1
6	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	16	16
7	S-968	Flange Nut 3/8"-16 ZN Grade 5	10	10
8	AS-0047	Motor Mounting Plate Assembly - 4" Air Systems	2	2
9	S-9062	Flange Bolt 1/2"-13 x 1-1/4" ZN Grade 5	8	8
10	AS-0025	Motor Adjust Rail Assembly	4	4
11	S-858	Flat Washer 5/8" USS ZN	4	4
12	2FH1043	Bolt, 5/8"-11 x 3-1/2" HHTB Grade 2 Plated	4	4
13	AS-0048-D	Elbow Assembly-Blower 4" Standard Twin DMC	1	-
13	AS-0048-F	Elbow Assembly-Blower 4" Standard Twin FFI	1	-
13	AS-0054-D	Elbow Assembly-Blower 5" Standard Twin DMC	-	1
13	AS-0054-F	Elbow Assembly-Blower 5" Standard Twin FFI	-	1
14	PT0742	Pulley QD 7-3/4" O.D. x SK Bush 4AB	1	-
14	PT0741	Pulley QD 5-1/2" O.D. x SD Bush 4AB	-	1
15	PT0772	Bushing QD Style SK, 1-1/8" Bore	1	-
15	PT0794	Bushing SD x 1-1/8" Bore	-	1
16	MHC00028	V-Belt BX60	-	2
16	MHC00743	V-Belt BX65	2	-
17	MHC00020	V-Belt BX68	2	-
17	MHC00743	V-Belt BX65	-	2
18	AS-0085	Support Angle-Blower Outlet Twin	1	1
19	S-6606	Flange Bolt 5/16"-18 x 3/4" ZN Grade 5	1	1
20	S-9259	Flange Nut 5/8"-11 ZN	2	2
21	8027012	Decal, Logo - DMC Transfer 1200	1	1
21	420-1443-1	Decal, Logo - FFI 14-1/2" x 12"	1	1
22	DC-1330	Decal, Logo - DMC 2-7/8" x 9"	1	1
-	AS-0112	Air Systems - Gate Valve Assembly - Twin	1	1

Motors and Drive Parts (Not Shown)			
Part #	Description	Qty	
		4"	5"
PT0749	Pulley QD 8.95 O.D. x SK Bush 2AB	x	x
002-1054-2	Motor 7-1/2 HP 1 PH 1800 RPM	x	-
PT0772	Bushing SK 1-1/8" Bore QD Style	x	-
MHC60010-1	Motor 10 HP 1 PH 1800 RPM	x	x
PT0778	Bushing SK 1-3/8" Bore QD Style	x	x
CH-5753	Motor 15 HP 1 PH 1800 RPM ODP	-	x
3EL5069	Motor 15 HP 1 PH 1800 RPM TEFC	-	x
GC03810	Bushing SK 1-5/8" Bore QD Style	-	x

5" (1700) High-Capacity Blower Parts

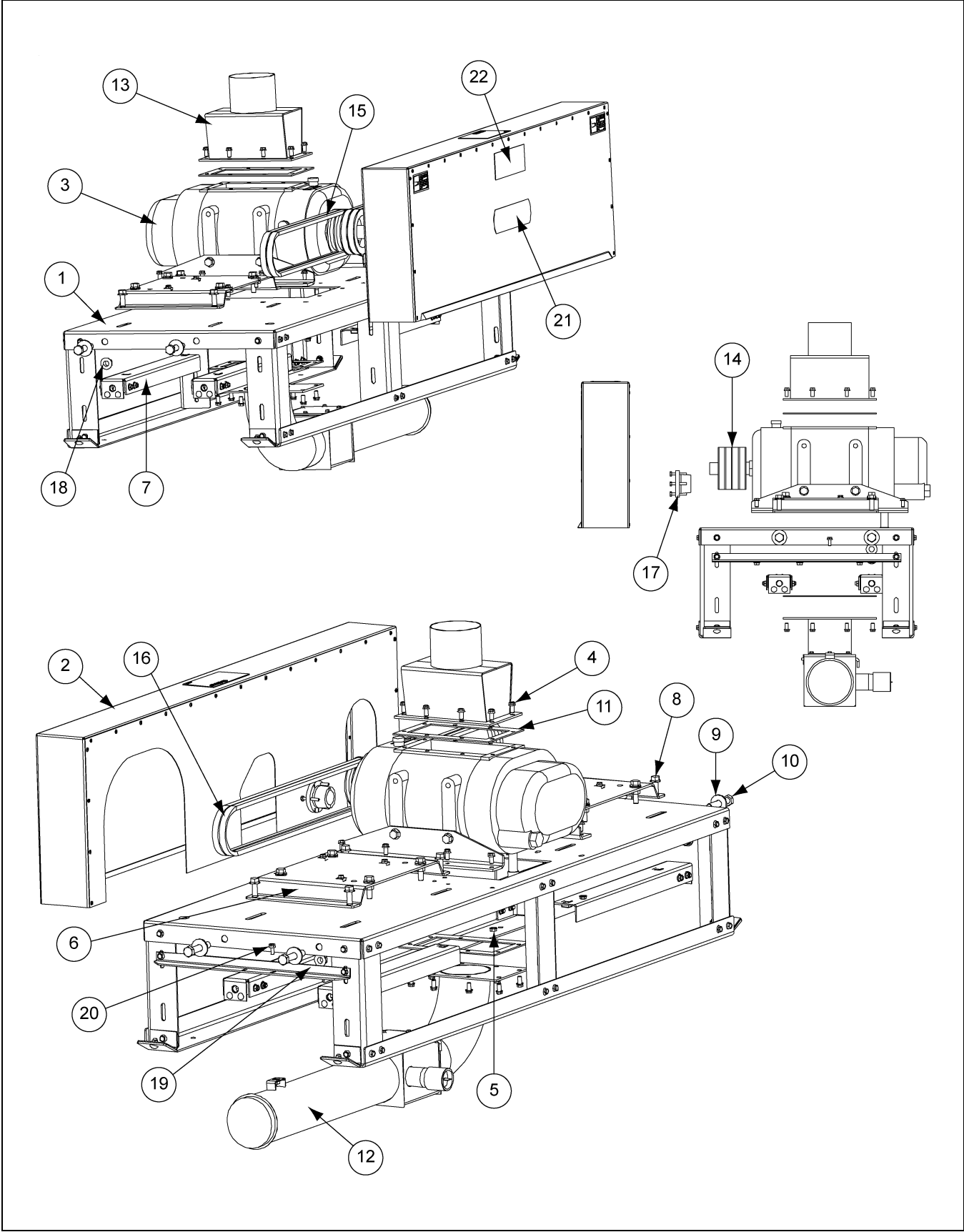


## 5" (1700) High-Capacity Blower Parts List

Ref #	Part #	Description	Qty
1	AS-0003	Blower Base Assembly - 4" and 5"	1
2	AS-0108	Dive Guard Assembly - 4" and 5" Standard Blower	1
3	CA-1059	Blower Sub-Assembly - 5" High-Capacity DMC	1
3	CA-1059F	Blower Sub-Assembly - 5" High-Capacity FFI	1
4	AS-0058	Motor Mounting Plate Assembly - 5" Air Systems	1
5	802B006	Blower Gasket - 5" High-Capacity	2
6	AS-0094-D	Blower Outlet Elbow Assembly - 5" High-Capacity DMC	1
6	AS-0094-F	Blower Outlet Elbow Assembly - 5" High-Capacity FFI	1
7	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	24
8	S-968	Flange Nut 3/8"-16 ZN Grade 5	8
9	S-9062	Flange Bolt 1/2"-13 x 1-1/4" ZN Grade 5	4
10	S-858	Flat Washer 5/8" USS ZN	2
11	2FH1043	Bolt, 5/8"-11 x 3-1/2" HHTB Grade 2 Plated	2
12	AS-0025	Motor Adjust Rail Assembly	2
13	PT0736	Sheave, 4 Grade, A 4.2-B 4.6 - SD, 4.95" O.D.	1
14	GC06682	Bushing SD x 1-7/16" Bore	1
15	MHC00028	V-Belt BX60	4
16	8021130-RD	Blower Inlet - 5" High-Capacity Red	1
16	8021130-OR	Blower Inlet - 5" High-Capacity Orange	1
17	S-9259	Flange Nut 5/8"-11 ZN	1
18	DC-1330	Decal, Logo - DMC 2-7/8" x 9"	1
19	420-1443-1	Decal, Logo - FFI 14-1/2" x 12"	1
19	8027011	Decal, Logo - DMC Transfer 1700	1
-	PT1132	Gate Valve, 1-1/2" NPT	1

Motors and Drive Parts (Not Shown)		
Part #	Description	Qty
PT0737	Pulley QD 8.95" O.D. x SK Bush 4AB	x
MTR-0022	Motor 20 HP 3 PH 1800 RPM	x
GC03810	Bushing SK 1-5/8" Bore QD Style	x
MTR-0056	Motor 30 HP 3 PH 1800 RPM	x
CE-00617	Bushing SK 1-7/8" Bore QD Style	x
MTR-0063	Motor 40 HP 3 PH 1800 RPM	x
PT0784	Bushing SK 2-1/8" Bore QD Style	x

5" (1700) Twin High-Capacity Blower Parts

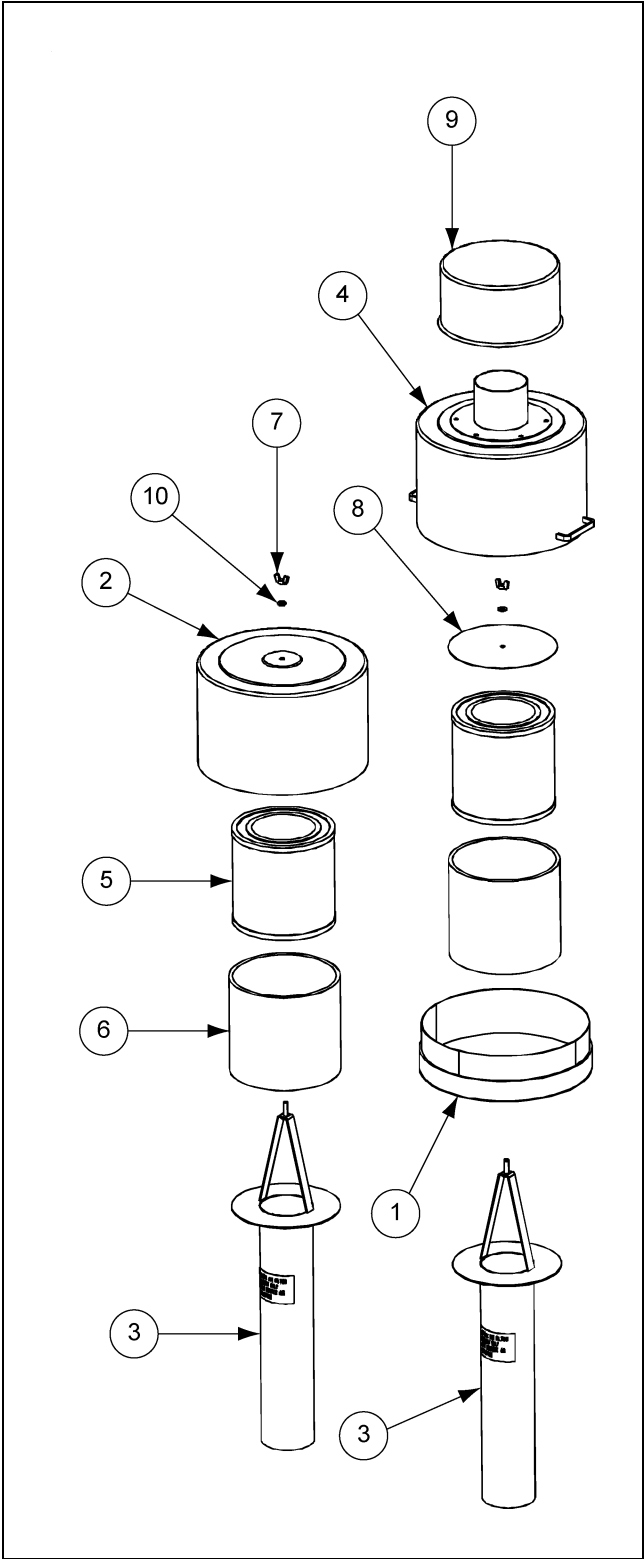


## 5" (1700) Twin High-Capacity Blower Parts List

Ref #	Part #	Description	Qty
1	AS-0007	Blower Base Assembly - 4" and 5" Twin	1
2	AS-0110	Drive Guard Assembly - 4" and 5" Twin Blower	1
3	CA-1059	Blower Sub-Assembly - 5" High-Capacity DMC	1
3	CA-1059F	Blower Sub-Assembly - 5" High-Capacity FFI	1
4	S-9067	Flange Bolt 3/8"-16 x 3/4" ZN Grade 5	26
5	S-968	Flange Nut 3/8"-16 ZN Grade 5	10
6	AS-0047	Motor Mounting Plate Assembly - 4" Air System	2
7	AS-0025	Motor Adjust Rail Assembly	4
8	S-9062	Flange Bolt 1/2"-13 x 1-1/4" ZN Grade 5	8
9	S-858	Flat Washer 5/8" USS ZN	4
10	2FH1043	Bolt, 5/8"-11 x 3-1/2" HHTB Grade 2 Plated	4
11	802B006	Blower Gasket - 5" High-Capacity	2
12	AS-0051-D	Elbow Assembly-Blower Out 5" High Twin DMC	1
12	AS-0051-F	Elbow Assembly-Blower Out 5" High Twin FFI	1
13	8021130-RD	Blower Inlet - 5" High-Capacity Red	1
13	8021130-OR	Blower Inlet - 5" High-Capacity Orange	1
14	PT0736	Sheave, 4 Grade, A 4.2-B 4.6 - SD, 4.95" O.D.	1
15	MHC00028	V-Belt BX60	2
16	MHC00743	V-Belt BX65	2
17	GC06682	Bushing SD x 1-7/16" Bore	1
18	S-9259	Flange Nut 5/8"-11 ZN	2
19	AS-0085	Support Angle - Blower Outlet Twin	1
20	S-6606	Flange Bolt 5/16"-18 x 3/4" ZN Grade 5	1
21	8027011	Decal, Logo - DMC Transfer 1700	1
21	420-1443-1	Decal, Logo - FFI 14-1/2" x 12"	1
22	DC-1330	Decal, Logo - DMC 2-7/8" x 9"	1
-	AS-0112	Air Systems - Gate Valve Assembly - Twin	1

Motors and Drive Parts (Not Shown)		
Part #	Description	Qty
PT0749	Pulley QD 8.95" O.D. x SK Bush 2AB	x
MHC60010-1	Motor 10 HP 1 PH 1800 RPM	x
PT0778	Bushing SK 1-3/8" Bore QD Style	x
CH-5753	Motor 15 HP 1 PH 1800 RPM ODP	x
3EL5069	Motor 15 HP 1 PH 1800 RPM TEFC	x
GC03810	Bushing SK 1-5/8" Bore QD Style	x

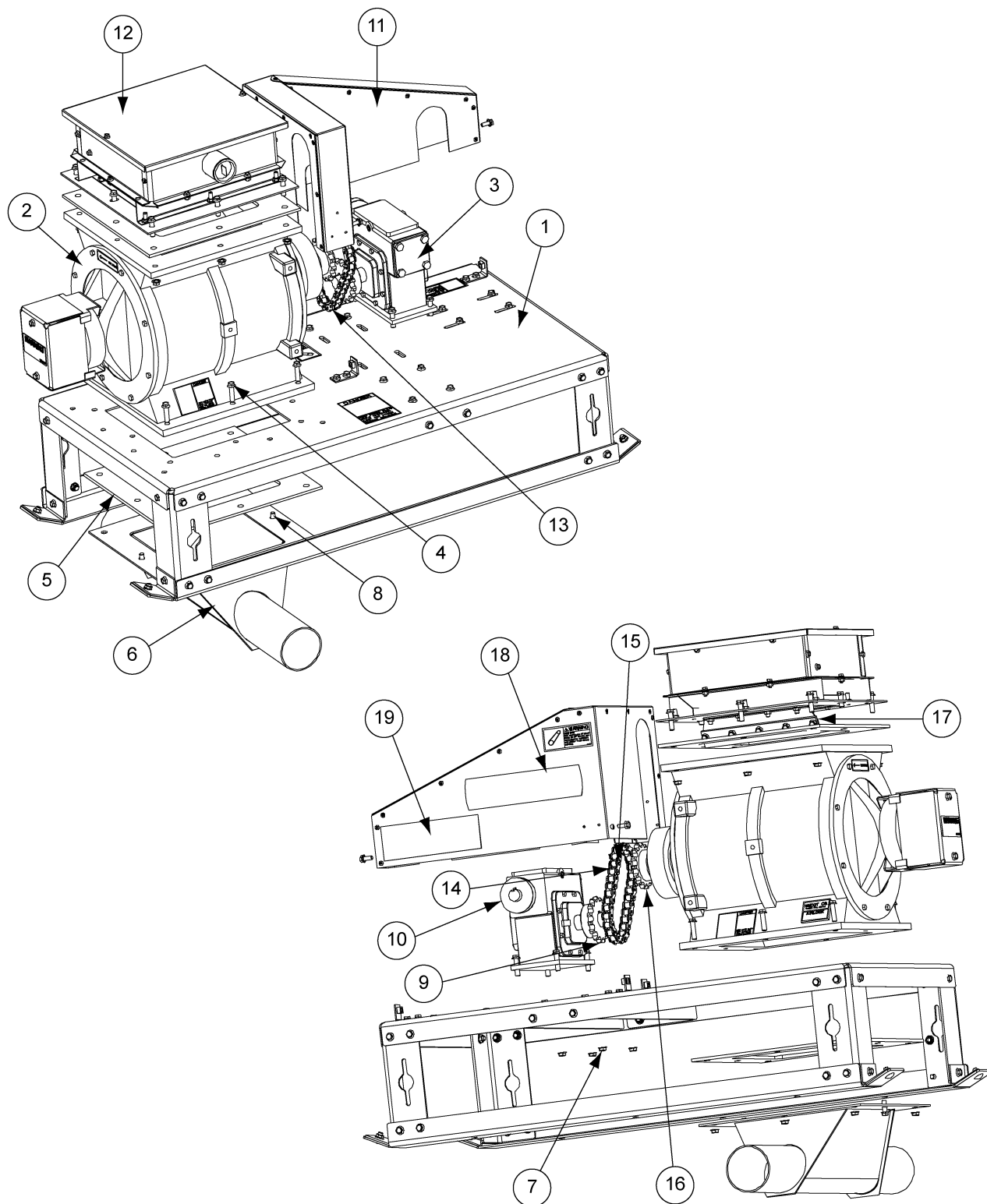
4" and 5" Blower Filters



## 4" and 5" Blower Filters Parts List

Ref #	Part #	Description	Qty
1	8021224-RD	Base, Pre-Filter, 5" Weldment - DMC	1
1	8021224-OR	Base, Pre-Filter, 5" Weldment - FFI	1
2	801A104-RD	Canister - Air Filter - 16" - Red	1
2	801A104-OR	Canister - Air Filter - 16" - Orange	1
3	802A072-D	Filter Base - 5 Assembly - DMC	1
3	802A072-F	Filter Base - 5 Assembly - FFI	1
4	8021219-D	Pre-Cleaner Canister Assembly - DMC	1
4	8021219-F	Pre-Cleaner Canister Assembly - FFI	1
5	801A154	Filter, Inner, 10 Micron	1
6	801A156	Filter, Outer, (Pre-Foam)	1
7	S-1451	Wing Nut 3/8"-16 UNC Plated	1
8	8021228	Plate-Filter Top Pre-Cleaner (4" and 5" Air Systems)	1
9	MS5466	Pre-Cleaner - 5" Inlet Centrifugal (350-700 CFM)	1
10	S-248	Flat Washer Standard 3/8", Plated	1

### 4" and 5" Airlock Parts



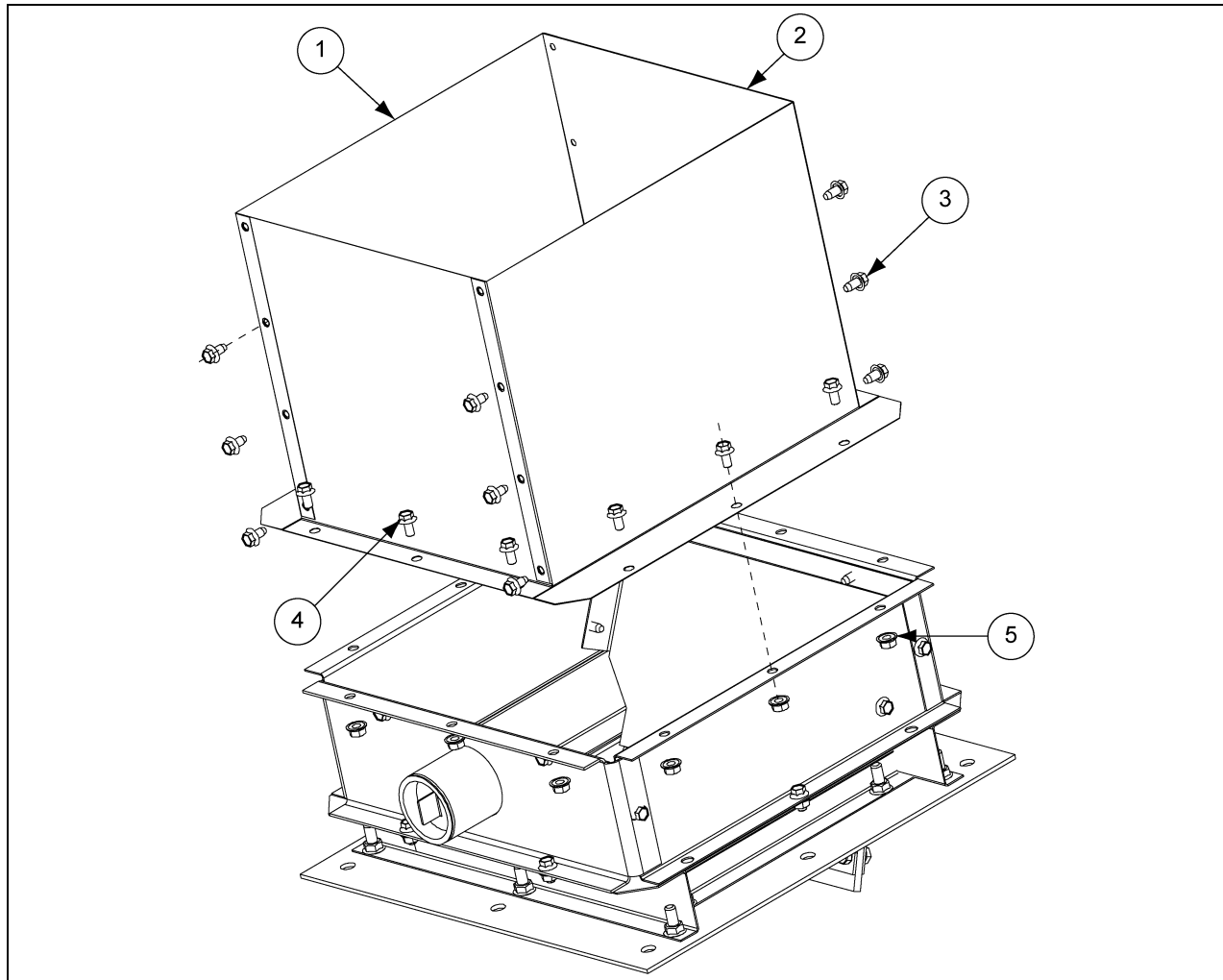


## 4" and 5" Airlock Parts List

Ref #	Part #	Description	Qty	
			4"	5"
	AS-0011	Airlock Base Assembly - 4" and 5"	1	1
1	AS-0060	Airlock Sub-Assembly - 4" System DMC	1	-
2	AS-0062	Airlock Sub-Assembly - 5" System DMC	-	1
2	AS-0060F	Airlock Sub-Assembly - 4" System FFI	1	-
2	AS-0062F	Airlock Sub-Assembly - 5" System FFI	-	1
3	AS-0114	Gearbox Assembly - DMC	1	1
3	AS-0114F	Gearbox Assembly - FFI	1	1
4	S-9064	Flange Bolt 3/8"-16 x 1-1/2" ZN Grade 5	16	20
5	801C008	Gasket - 4" Airlock	2	-
5	802C008	Gasket - 5" Airlock	-	2
6	AS-0037-RD	Airlock Hopper Weld - 4" Red	1	-
6	AS-0037-OR	Airlock Hopper Weld - 4" Orange	1	-
6	AS-0034-RD	Airlock Hopper Weld - 5" Red	-	1
6	AS-0034-OR	Airlock Hopper Weld - 5" Orange	-	1
7	S-968	Flange Nut 3/8"-16 ZN Grade 5	16	20
8	S-9065	Flange Bolt 3/8"-16 x 1" ZN Grade 5	4	8
9	PT1106	Sprocket - (Hub Type) 1-1/4" I.D.	1	1
10	PT0622	Pulley (Flat) 3" x 1" I.D. - 1A	1	1
11	AS-0124	Airlock Belt Guard Assembly - 8/05	1	1
12	AS-0070	Inlet Assembly - 4" Airlock	1	-
12	AS-0072	Inlet Assembly - 5" Airlock	-	1
13	801A205	Roller Chain (4" Airlock)	1	-
13	801A148	Roller Chain (5" Airlock)	-	1
14	KD-PRC6001	Connecting Link, #60 3/4" Pitch	1	1
15	PT1054	Link-Offset, #60 3/4" Pitch	1	1
16	PT1083	Sprocket Hub 15T 1-1/2" I.D. #60	1	-
16	PT1107	Sprocket (Hub Type) 1-3/4" I.D.	-	1
17	8011293	Airlock Wiper - Shear Protect 4"	1	-
17	8021209	Airlock Wiper - Shear Protect 5"	-	1
18	801L001	Decal, Logo - DMC Transfer 700	1	-
18	8027013	Decal, Logo - DMC 5" Transfer	-	1
18	420-1507-3	Decal, Logo - FFI Control Box Lid	1	1
19	DC-1330	Decal, Logo - DMC 2-7/8" x 9"	1	1
-	AS-0117	Air Systems - Airlock Shaft Guard Assembly	1	1

Motors and Drive Parts (Not Shown)			
Part #	Description	Qty	
		4"	5"
100-1	Motor 1 HP 1 PH 56 TEFC 5/8" Shaft	x	x
002-1087-2	Motor 1 HP 3 PH 56 TEFC 5/8" Shaft	x	x
AS-0212	V-Belt A24-8/05	x	x
PT0618	Pulley 3-1/4" O.D. x 0.62" I.D. - 1A	x	x
PT0558	Pulley 4.44" O.D. x 0.62" I.D. - 1A	-	5" (1700)

## Airlock Inlet Transition Assembly



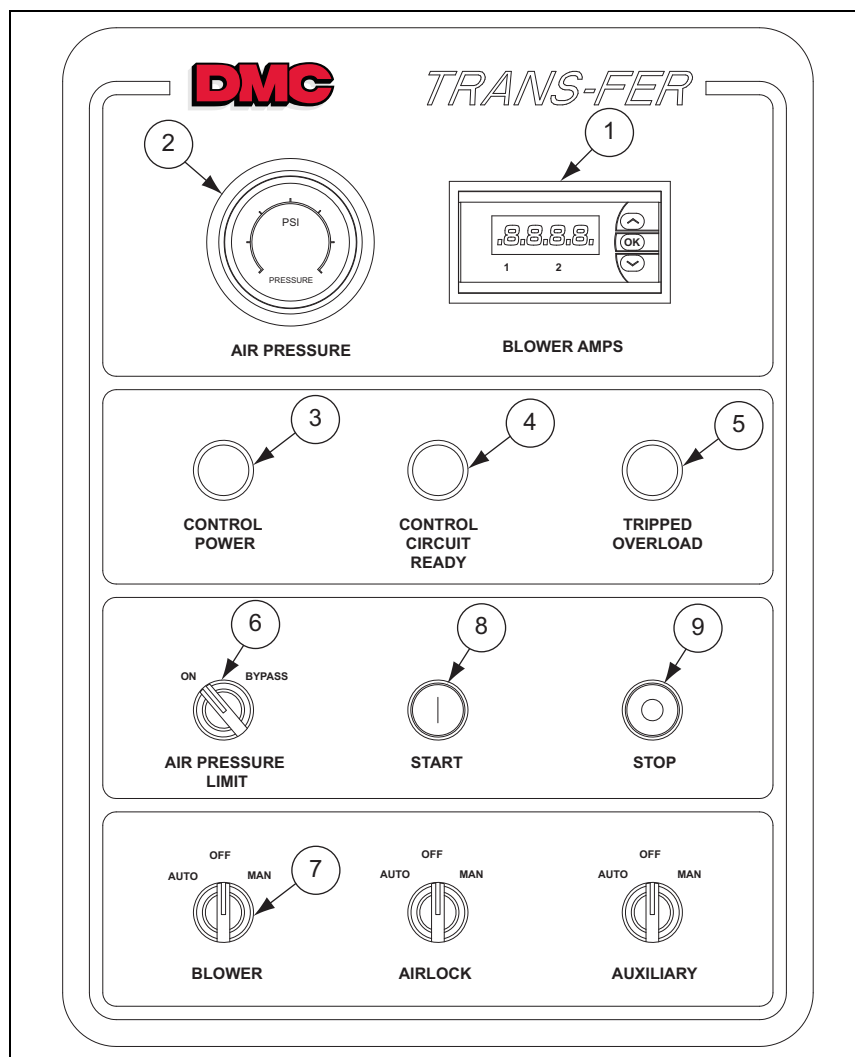
**Airlock Inlet Transition Assembly Parts List**

Ref #	Part #	Description	Qty
1	AS-0077	Airlock Inlet Transition - R.H. and L.H.	2
2	AS-0078	Airlock Transition - Front and Back	2
3	S-9028	Screw, SMSAB 1/4"-14 x 1/2" HWH ZN	12
4	S-8857	Flange Bolt 1/4"-20 x 1/2" ZN Grade 5	10
5	S-7215	Flange Nut 1/4"-20 ZN	10

### Installation of Airlock Transition to Dryer Discharge

1. Remove the weather cover from the airlock inlet assembly.
2. Assemble two (2) AS-0077 ([Ref #1](#)) and (2) AS-0078 ([Ref #2](#)) together with S-9028 ([Ref #3](#)) self-tapper screws as shown in the [above](#) diagram.
3. Determine what direction the airlock grain line is to run. Orient the transition assembly to correspond with the line direction. Attach the transition assembly to the airlock inlet using S-8857 ([Ref #4](#)) and S-7215 ([Ref #5](#)).
4. Trim the top of the transition assembly to match the height of the dryer discharge.

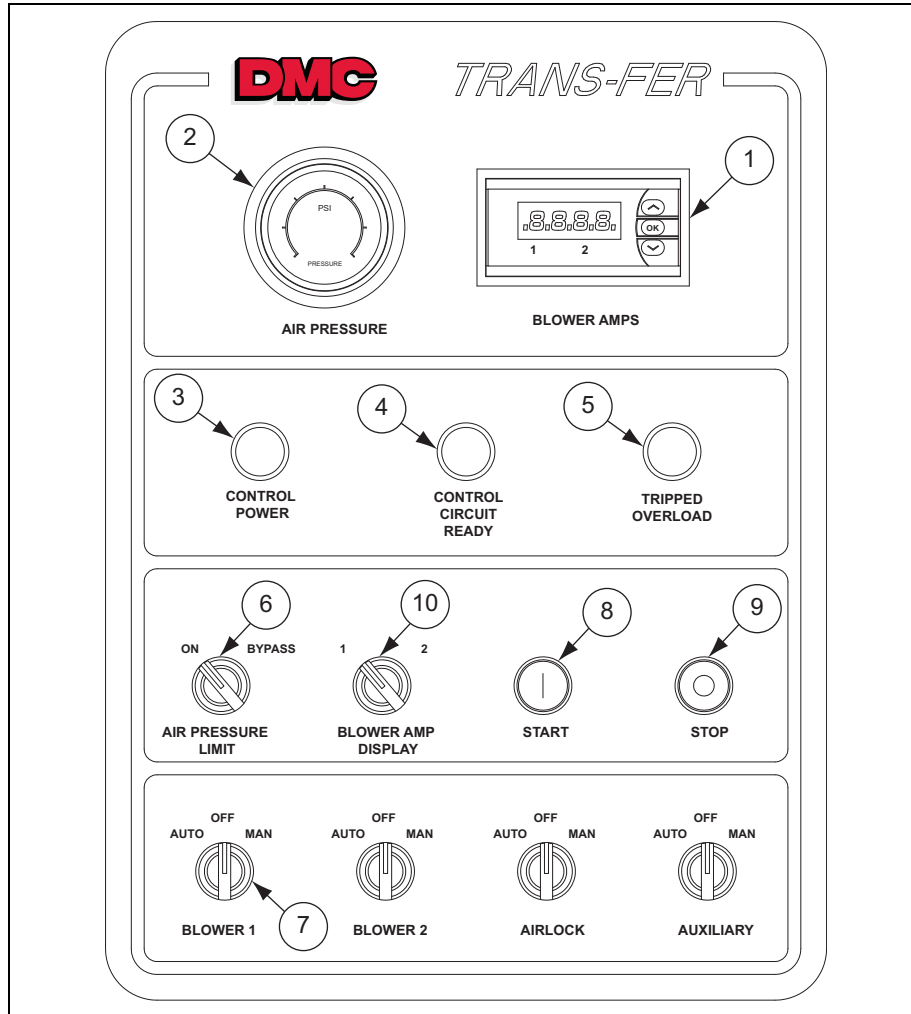
## Inner Door Assembly - Standard



**Inner Door Assembly - Standard Parts List**

Ref #	Part #	Description	Qty
1	AS-0715	LED Display	1
2	AS-0720	Air Pressure Gauge	1
3	AS-0727	Yellow Pilot Light (Control Power)	1
4	AS-0725	Green Pilot Light (Control Circuit Ready)	1
5	AS-0726	Red Pilot Light (Tripped Overload)	1
6	AS-0719	2 Position Selector Switch (Air Pressure Override)	1
7	AS-0724	3 Position Selector Switch (Motor Selector Switch)	3
8	AS-0717	22 mm Push Button Operator - Green (Start)	1
9	AS-0718	22 mm Push Button Operator - Red (Stop)	1
N/S	AS-0721	40 mm Enable/Disable Stop	1
N/S	4FH1122	Hose Barb - 1/4" Hose	1
N/S	4FH0452	Street Elbow	1
N/S	AS-0763	Hose, 1/4" I.D. x 4' Long	1

## Inner Door Assembly - Twin



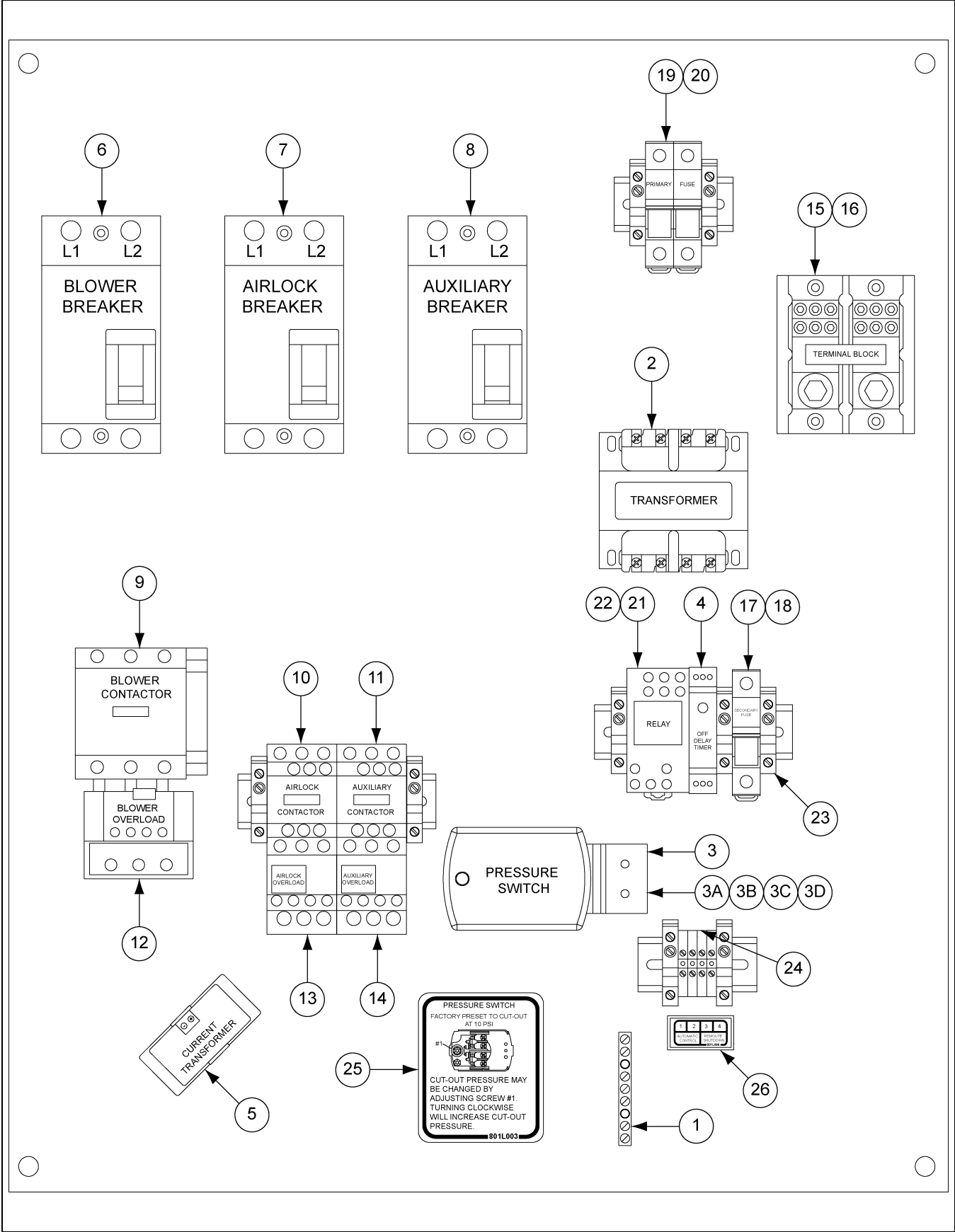
### Inner Door Assembly - Twin Parts List

Ref #	Part #	Description	Qty
1	AS-0715	LED Display	1
2	AS-0720	Air Pressure Gauge	1
3	AS-0727	Yellow Pilot Light (Control Power)	1
4	AS-0725	Green Pilot Light (Control Circuit Ready)	1
5	AS-0726	Red Pilot Light (Tripped Overload)	1
6	AS-0719	2 Position Selector Switch (Air Pressure Override)	1
7	AS-0724	3 Position Selector Switch (Motor Selector Switch)	4
8	AS-0717	22 mm Push Button Operator - Green (Start)	1
9	AS-0718	22 mm Push Button Operator - Red (Stop)	1
10	AS-0734	2 Position Maintained Selector Switch	1
N/S	AS-0721	40 mm Enable/Disable Stop	1
N/S	4FH1122	Hose Barb - 1/4" Hose	1
N/S	4FH0452	Street Elbow	1
N/S	AS-0763	Hose - 1/4" I.D. x 4' Long	1

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# NOTES

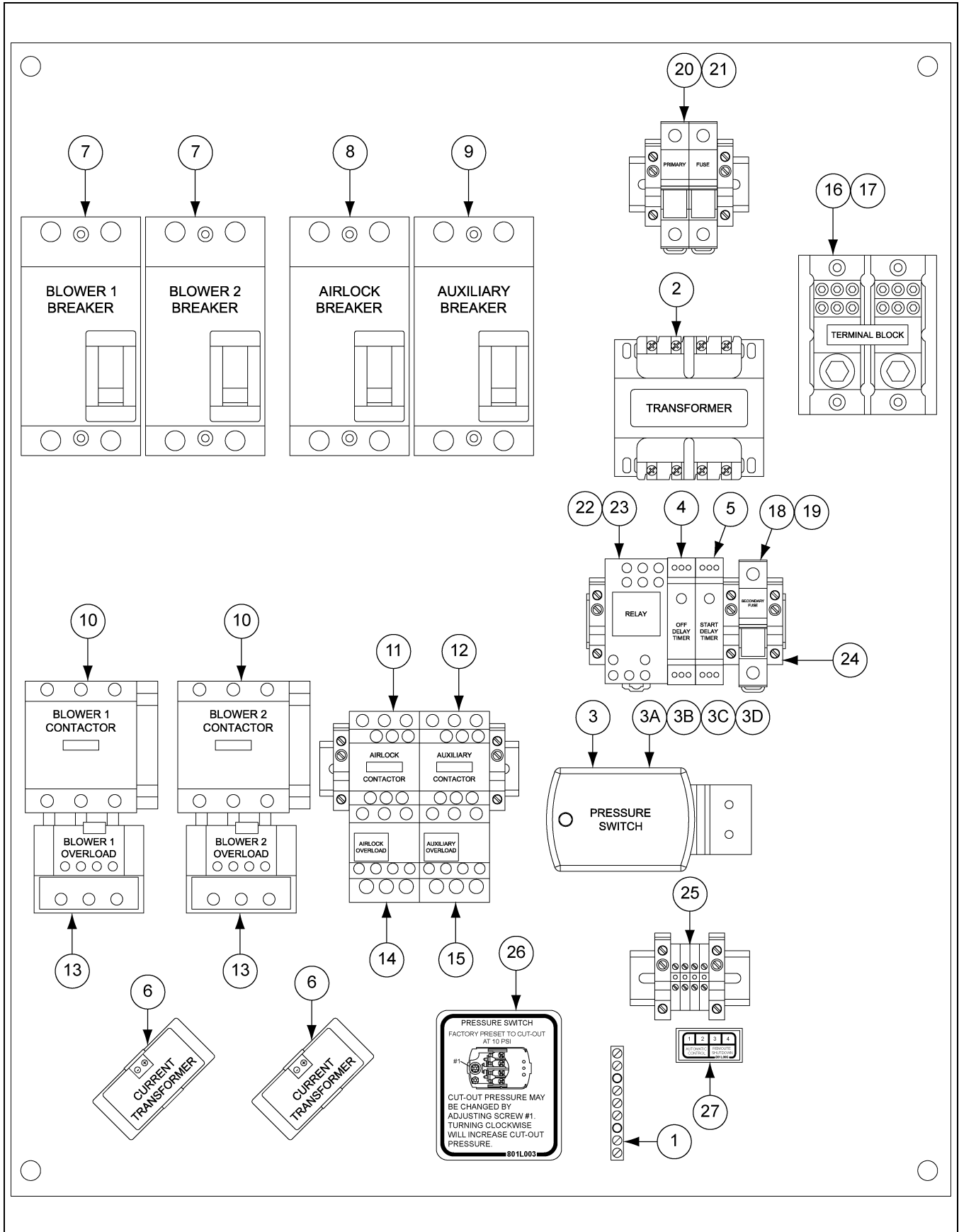
Standard Control Panel Assembly 230V - 1 Phase



## Standard Control Panel Assembly 230V - 1 Phase Parts List

Ref #	Part #	Description	Qty	
			AS-0669 10 HP	AS-0670 15 HP
1	AS-0730	Ground Bar Kit	1	1
2	2EL0308	240/480P 120/240S Control Transformer	1	1
3	AS-0760	Switch Assembly - High Pressure (Set at 10 PSI)	1	1
3A	801E019	Switch - Pressure (Preset at 10 PSI)	1	1
3B	801E050	Bracket - Pressure Switch	1	1
3C	4FH1465	Tee, Fit - Pipe (PVC) 1/4" x 1/4" x 1/4"	1	1
3D	S-1158	Screw, TCSF #8-32 x 1/2" PHP ZN	2	2
4	AS-0716	Off/Delay Timer 250V 0.7A RE11 + Options	1	1
5	AS-0736	Current Transducer	1	1
6	D03-0926	2P - 240V - 90A Circuit Breaker	1	-
6	D03-0927	2P - 240V - 100A Circuit Breaker	-	1
7	AS-0733	240V 35A Circuit Breaker	1	1
8	D03-0919	2P - 240V - 15A Circuit Breaker	1	1
9	056-1994-5A	65A 110V Contactor	1	-
9	056-2030-7	80A 110V Contactor	-	1
10	056-1949-9	18A 110V Contactor	1	1
11	056-1942-4	12A 110V Contactor	1	1
12	AS-0752	37-50A Overload	1	-
12	AS-0757	48-65A Overload	-	1
13	C-8693	5.5-8A Overload Relay	1	1
14	C-8694	7-10A Overload Relay	1	1
15	AS-0738	Power Distribution Block 175A 600V 2 Pole	1	-
15	AS-0740	Power Distribution Block 335A 600V 2 Pole	-	1
16	AS-0739	Clear Distribution Block Cover	1	1
17	AS-0728	2 Amp 600V Special Purpose Fuse	1	1
18	AS-0731	Fuse Holder 600V 30 Amp 1 Pole, CC Fuse	1	1
19	AS-0729	1 Amp 600V CC TD Fuse	2	2
20	AS-0732	Fuse Holder 600V 30 Amp 2 Pole, CC Fuse	1	1
21	AS-0722	Relay	1	1
22	AS-0723	Relay - Socket	1	1
23	AS-0758	End Clamp	11	11
24	AS-0759	Terminal Block	4	4
25	801L003	Decal - Pressure Switch	1	1
26	801L006	Decal - Terminal Strip	1	1

## Twin Control Panel Assembly 230V - 1 Phase



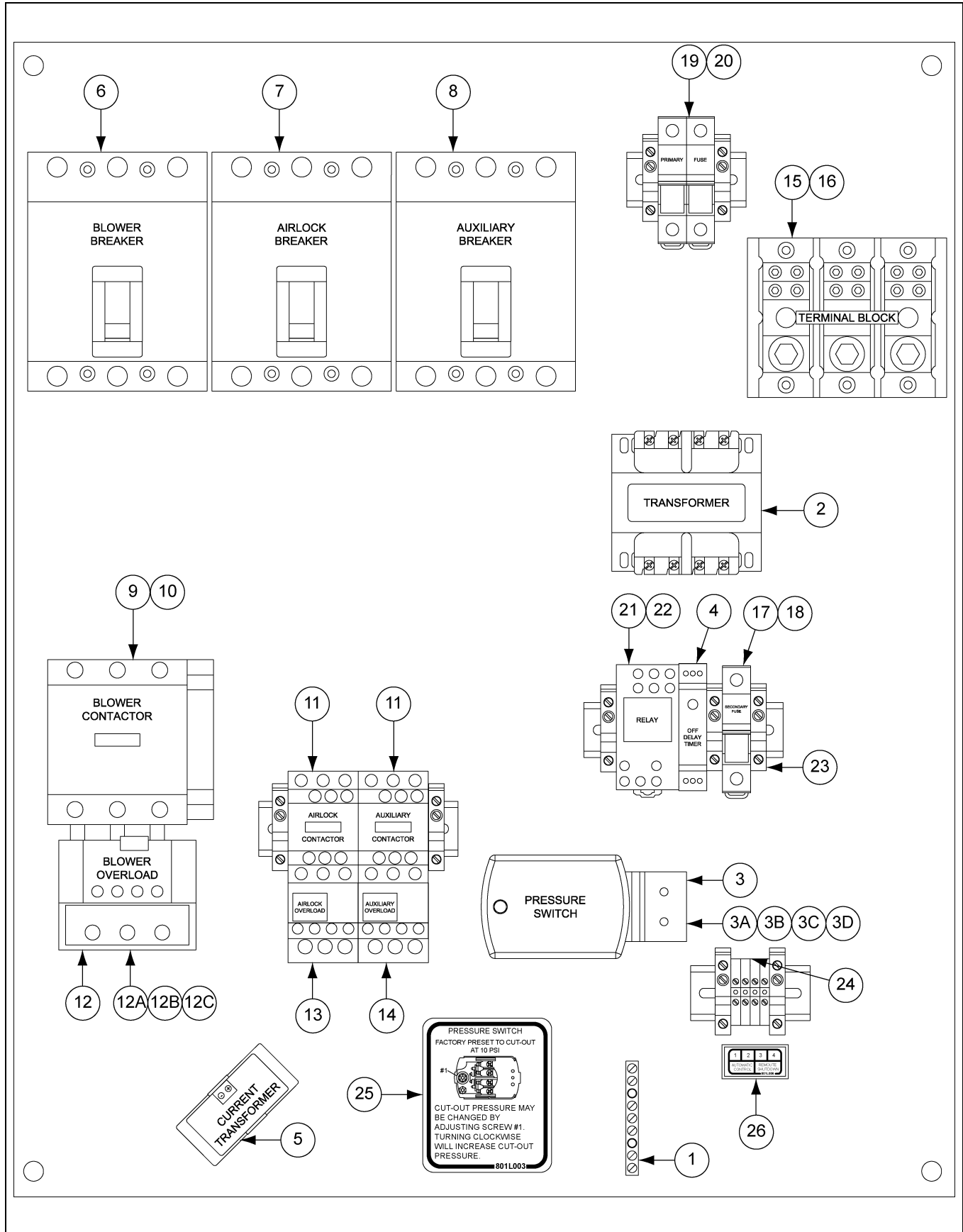


## Twin Control Panel Assembly 230V - 1 Phase Parts List

Ref #	Part #	Description	Qty	
			AS-0667 10 HP	AS-0668 15 HP
1	AS-0730	Ground Bar Kit	1	1
2	2EL0308	240/480P 120/240S Control Transformer	1	1
3	AS-0760	Switch Assembly - High Pressure (Set at 10 PSI)	1	1
3A	801E019	Switch - Pressure (Preset at 10 PSI)	1	1
3B	801E050	Bracket - Pressure Switch	1	1
3C	4FH1465	Tee, Fit - Pipe (PVC) 1/4" x 1/4" x 1/4"	1	1
3D	S-1158	Screw, TCSF #8-32 x 1/2" PHP ZN	2	2
4	AS-0716	Off/Delay Timer 250V 0.7A RE11 + Options	1	1
5	AS-0735	Start/Delay Timer 250V 0.7A	1	1
6	AS-0736	Current Transducer	2	2
7	D03-0926	2P - 240V - 90A Circuit Breaker	2	-
7	D03-0927	2P - 240V - 100A Circuit Breaker	-	2
8	AS-0733	240V 35A Circuit Breaker	1	1
9	D03-0919	2P - 240V - 15A Circuit Breaker	1	1
10	056-1994-5A	65A 110V Contactor	2	-
10	056-2030-7	80A 110V Contactor	-	2
11	056-1949-9	18A 110V Contactor	1	1
12	056-1942-4	12A 110V Contactor	1	1
13	AS-0752	37-50A Overload	2	-
13	AS-0757	48-65A Overload	-	2
14	C-8694	7-10A Overload Relay	1	1
15	C-8696	12-18A Overload Relay	1	1
16	AS-0264	Power Distribution Block 335A 600V 2 Pole	1	1
17	AS-0737	Clear Distribution Block Cover	1	1
18	AS-0728	2 Amp 600V Special Purpose Fuse	1	1
19	AS-0731	Fuse Holder 600V 30 Amp 1 Pole, CC Fuse	1	1
20	AS-0729	1 Amp 600V CC TD Fuse	2	2
21	AS-0732	Fuse Holder 600V 30 Amp 2 Pole, CC Fuse	1	1
22	AS-0722	Relay	1	1
23	AS-0723	Relay - Socket	1	1
24	AS-0758	End Clamp	11	11
25	AS-0759	Terminal Block	4	4
26	801L003	Decal - Pressure Switch	1	1
27	801L006	Decal - Terminal Strip	1	1

## 12. Parts List

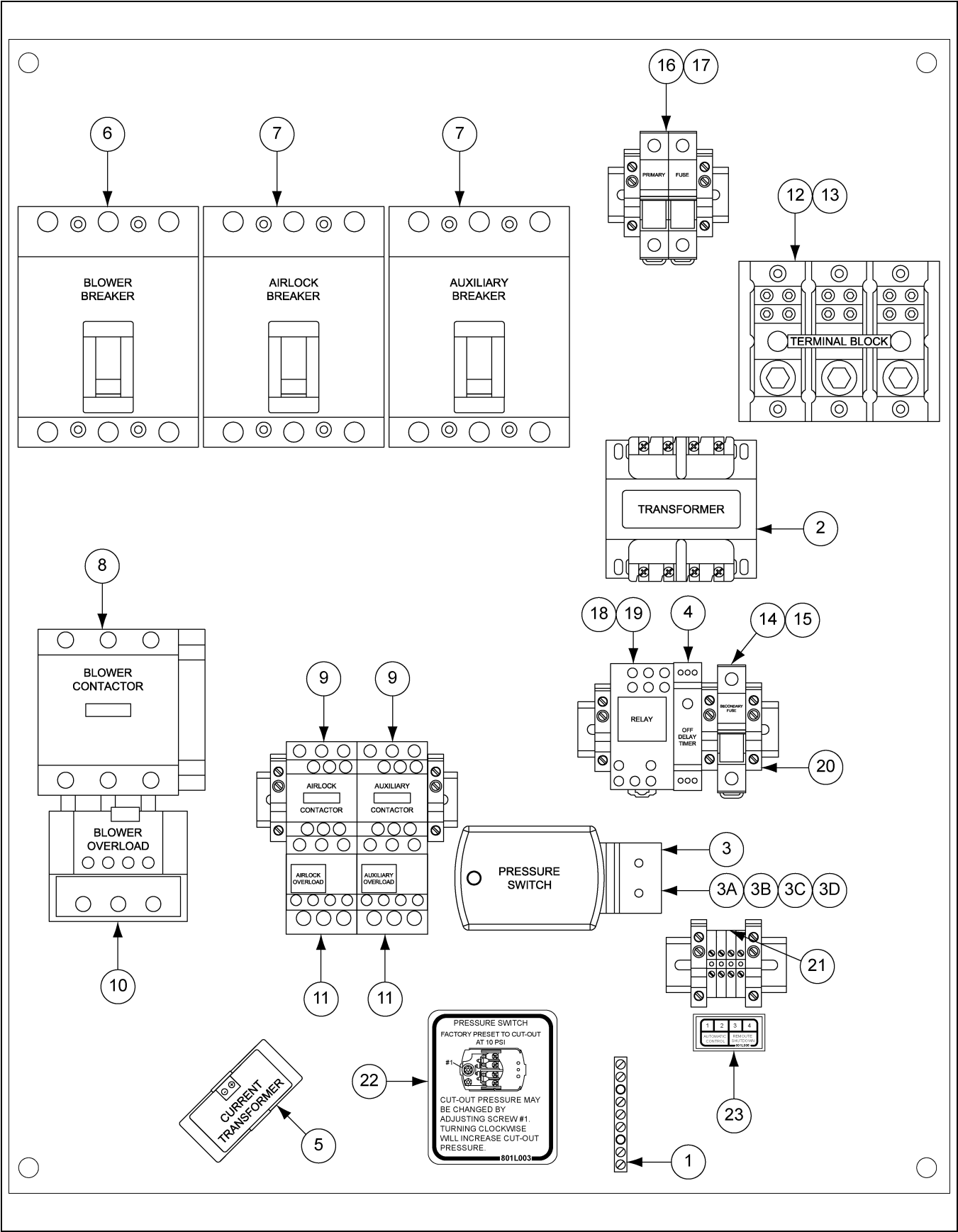
### Standard Control Panel Assembly 10-40 HP 230V - 3 Phase



## Standard Control Panel Assembly 10-40 HP 230V - 3 Phase Parts List

Ref #	Part #	Description	Qty				
			AS-0674 10 HP	AS-0675 15 HP	AS-0676 20 HP	AS-0677 30 HP	AS-0671 40 HP
1	AS-0730	Ground Bar Kit	1	1	1	1	1
2	2EL0308	240/480P 120/240S Control Transformer	1	1	1	1	1
3	AS-0760	Switch Assembly - High Pressure (Set at 10 PSI)	1	1	1	1	1
3A	801E019	Switch - Pressure (Preset at 10 PSI)	1	1	1	1	1
3B	801E050	Bracket - Pressure Switch	1	1	1	1	1
3C	4FH1465	Tee, Fit - Pipe (PVC) 1/4" x 1/4" x 1/4"	1	1	1	1	1
3D	S-1158	Screw, TCSF #8-32 x 1/2" PHP ZN	2	2	2	2	2
4	AS-0716	Off/Delay Timer 250V 0.7A RE11 + Options	1	1	1	1	1
5	AS-0736	Current Transducer	1	1	1	1	1
6	D03-0941	3P 240V 60A Circuit Breaker	1	-	-	-	-
6	D03-0942	3P 240V 80A Circuit Breaker	-	1	-	-	-
6	D03-0943	3P 240V 90A Circuit Breaker	-	-	1	-	-
6	D03-0896	3P 600V 125A Circuit Breaker	-	-	-	1	-
6	D03-0897	3P 600V 150A Circuit Breaker	-	-	-	-	1
7	D03-0929	3P 240V 20A Circuit Breaker	1	1	1	1	1
8	D03-0928	3P 240V 15A Circuit Breaker	1	1	1	1	1
9	056-1941-6	32A 110V Contactor	1	-	-	-	-
9	056-2078-6A	50A 110V Contactor	-	1	-	-	-
9	056-1994-5A	65A 110V Contactor	-	-	1	-	-
9	056-2030-7	80A 110V Contactor	-	-	-	1	-
9	AS-0761	115A 600V Contactor	-	-	-	-	1
10	AS-0767	Coil 120V	-	-	-	-	-
10	AS-0768	Coil 120V	-	-	-	-	-
11	056-1942-4	12A 110V Contactor	2	2	2	2	2
12	056-2079-4	25-32A Overload	1	-	-	-	-
12	AS-0752	37-50A Overload	-	1	-	-	-
12	D03-0984	48-65A Overload	-	-	1	-	-
12	CH-1062	63-80A Overload	-	-	-	1	-
12	056-2276-6	90-150A Overload	-	-	-	-	1
12A	GT3-1064	Lug Kit	-	-	-	-	-
12B	GT3-1063	Connector Kit	-	-	-	-	-
12C	GT3-1062	Overload Mount Kit	-	-	-	-	-
13	AS-0741	2.5-4A Overload Relay	1	1	1	1	1
14	056-1968-9	4-6A Overload Relay	1	1	1	1	1
15	1EL0911	Power Distribution Block 175A 600V 3 Pole	1	1	1	-	-
15	AS-0743	Power Distribution Block 335A 600V 3 Pole	-	-	-	1	-
15	AS-0745	Power Distribution Block 350A 600V 3 Pole	-	-	-	-	1
16	AS-0742	Clear Distribution Block Cover	1	1	1	-	-
16	AS-0744	Clear Distribution Block Cover	-	-	-	1	1
17	AS-0728	2 Amp 600V Special Purpose Fuse	1	1	1	1	1
18	AS-0731	Fuse Holder 600V 30 Amp 1 Pole, CC Fuse	1	1	1	1	1
19	AS-0729	1 Amp 600V CC TD Fuse	2	2	2	2	2
20	AS-0732	Fuse Holder 600V 30 Amp 2 Pole, CC Fuse	1	1	1	1	1
21	AS-0722	Relay	1	1	1	1	1
22	AS-0723	Relay - Socket	1	1	1	1	1
23	AS-0758	End Clamp	11	11	11	11	11
24	AS-0759	Terminal Block	4	4	4	4	4
25	801L003	Decal - Pressure Switch	1	1	1	1	1
26	801L006	Decal - Terminal Strip	1	1	1	1	1

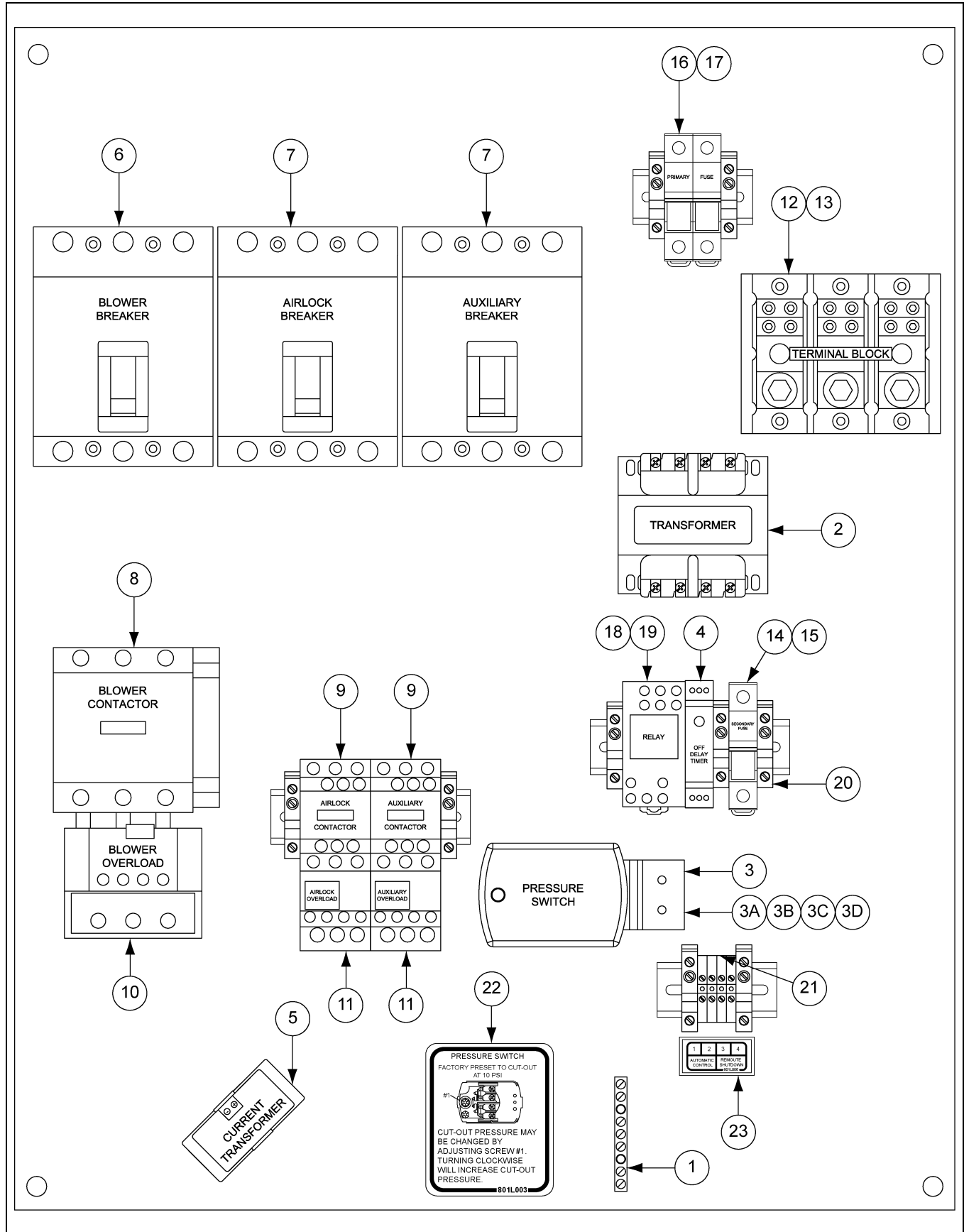
Standard Control Panel Assembly 10-40 HP 460V - 3 Phase



## Standard Control Panel Assembly 10-40 HP 460V - 3 Phase Parts List

Ref #	Part #	Description	Qty				
			AS-0678 10 HP	AS-0679 15 HP	AS-0680 20 HP	AS-0681 30 HP	AS-0682 40 HP
1	AS-0730	Ground Bar Kit	1	1	1	1	1
2	2EL0308	240/480P 120/240S Control Transformer	1	1	1	1	1
3	AS-0760	Switch Assembly - High Pressure (Set at 10 PSI)	1	1	1	1	1
3A	801E019	Switch - Pressure (Preset at 10 PSI)	1	1	1	1	1
3B	801E050	Bracket - Pressure Switch	1	1	1	1	1
3C	4FH1465	Tee, Fit - Pipe (PVC) 1/4" x 1/4" x 1/4"	1	1	1	1	1
3D	S-1158	Screw, TCSF #8-32 x 1/2" PHP ZN	2	2	2	2	2
4	AS-0716	Off/Delay Timer 250V 0.7A RE11 + Options	1	1	1	1	1
5	AS-0736	Current Transducer	1	1	1	1	1
6	AS-0769	3P 480V 25A Circuit Breaker	1	-	-	-	-
6	AS-0771	3P 480V 40A Circuit Breaker	-	1	-	-	-
6	026-1085-5	3P 480V 60A Circuit Breaker	-	-	1	-	-
6	AS-0751	3P 480V 80A Circuit Breaker	-	-	-	1	-
6	026-1040-0	3P 480V 90A Circuit Breaker	-	-	-	-	1
7	AS-0750	3P 480V 15A Circuit Breaker	2	2	2	2	2
8	056-1949-9	18A 110V Contactor	1	-	-	-	-
8	AS-0772	25A 110V Contactor	-	1	-	-	-
8	056-1941-6	32A 110V Contactor	-	-	1	-	-
8	056-2111-5A	40A 110V Contactor	-	-	-	1	-
8	056-1994-5A	65A 110V Contactor	-	-	-	-	1
9	056-1942-4	12A 110V Contactor	2	2	2	2	2
10	056-1944-0	12-18A Overload	1	-	-	-	-
10	056-1943-2	17-25A Overload	-	1	-	-	-
10	056-2079-4	25-32A Overload	-	-	1	-	-
10	AS-0752	37-50A Overload	-	-	-	1	-
10	D03-0984	48-65A Overload	-	-	-	-	1
11	056-1945-7	1.6-2.5A Overload Relay	2	2	2	2	2
12	1EL0911	Power Distribution Block 175A 600V 3 Pole	1	1	1	1	1
13	AS-0742	Clear Distribution Block Cover	1	1	1	1	1
14	AS-0728	2 Amp 600V Special Purpose Fuse	1	1	1	1	1
15	AS-0731	Fuse Holder 600V 30 Amp 1 Pole, CC Fuse	1	1	1	1	1
16	AS-0770	6/10 Amp 600V CC TD Fuse	2	2	2	2	2
17	AS-0732	Fuse Holder 600V 30 Amp 2 Pole, CC Fuse	1	1	1	1	1
18	AS-0722	Relay	1	1	1	1	1
19	AS-0723	Relay - Socket	1	1	1	1	1
20	AS-0758	End Clamp	11	11	11	11	11
21	AS-0759	Terminal Block	4	4	4	4	4
22	801L003	Decal - Pressure Switch	1	1	1	1	1
23	801L006	Decal - Terminal Strip	1	1	1	1	1


## Standard Control Panel Assembly 10-40 HP 575V - 3 Phase



## Standard Control Panel Assembly 10-40 HP 575V - 3 Phase Parts List

Ref #	Part #	Description	Qty				
			AS-0704 10 HP	AS-0705 15 HP	AS-0706 20 HP	AS-0707 30 HP	AS-0708 40 HP
1	AS-0730	Ground Bar Kit	1	1	1	1	1
2	AS-0774	600V - 120/240V Control Transformer	1	1	1	1	1
3	AS-0760	Switch Assembly - High Pressure (Set at 10 PSI)	1	1	1	1	1
3A	801E019	Switch - Pressure (Preset at 10 PSI)	1	1	1	1	1
3B	801E050	Bracket - Pressure Switch	1	1	1	1	1
3C	4FH1465	Tee, Fit - Pipe (PVC) 1/4" x 1/4" x 1/4"	1	1	1	1	1
3D	S-1158	Screw, TCSF #8-32 x 1/2" PHP ZN	2	2	2	2	2
4	AS-0716	Off/Delay Timer 250V 0.7A RE11 + Options	1	1	1	1	1
5	AS-0736	Current Transducer	1	1	1	1	1
6	AS-0776	3P 600V 20A Circuit Breaker	1	-	-	-	-
6	AS-0778	3P 600V 35A Circuit Breaker	-	1	-	-	-
6	AS-0780	3P 600V 45A Circuit Breaker	-	-	1	-	-
6	AS-0782	3P 600V 60A Circuit Breaker	-	-	-	1	-
6	AS-0783	3P 600V 80A Circuit Breaker	-	-	-	-	1
7	AS-0775	3P 600V 15A Circuit Breaker	2	2	2	2	2
8	056-1942-4	12A 110V Contactor	1	-	-	-	-
8	056-1949-9	18A 110V Contactor	-	1	-	-	-
8	AS-0789	25A 110V Contactor	-	-	1	-	-
8	056-1941-6	32A 110V Contactor	-	-	-	1	-
8	AS-0784	50A 110V Contactor	-	-	-	-	1
9	056-1942-4	12A 110V Contactor	2	2	2	2	2
10	AS-0777	9-13A Overload	1	-	-	-	-
10	056-1944-0	12-18A Overload	-	1	-	-	-
10	056-1943-2	17-25A Overload	-	-	1	-	-
10	056-2079-4	25-32A Overload	-	-	-	1	-
10	AS-0752	37-50A Overload	-	-	-	-	1
11	056-1945-7	1.6-2.5A Overload Relay	2	2	2	2	2
12	1EL0911	Power Distribution Block 175A 600V 3 Pole	1	1	1	1	1
13	AS-0742	Clear Distribution Block Cover	1	1	1	1	1
14	AS-0728	2 Amp 600V Special Purpose Fuse	1	1	1	1	1
15	AS-0731	Fuse Holder 600V 30 Amp 1 Pole, CC Fuse	1	1	1	1	1
16	AS-0770	6/10 Amp 600V CC TD Fuse	2	2	2	2	2
17	AS-0732	Fuse Holder 600V 30 Amp 2 Pole, CC Fuse	1	1	1	1	1
18	AS-0722	Relay	1	1	1	1	1
19	AS-0723	Relay - Socket	1	1	1	1	1
20	AS-0758	End Clamp	11	11	11	11	11
21	AS-0759	Terminal Block	4	4	4	4	4
22	801L003	Decal - Pressure Switch	1	1	1	1	1
23	801L006	Decal - Terminal Strip	1	1	1	1	1

## 13. Troubleshooting

Problem	Solution
<b>System plugs up.</b>	<ol style="list-style-type: none"> <li>1. Check belt tension on air blower and tighten if loose.</li> <li>2. Check air filter and clean out. Locate in a place where there is less dust.</li> <li>3. Check tubing system for any obstructions.</li> <li>4. Reduce feed-in rate.</li> <li>5. Air pressure switch setting may be too low.</li> <li>6. Outlet gate valve too far open.</li> </ol>
<b>Excessive grain damage.</b>	<ol style="list-style-type: none"> <li>1. May be overfeeding airlock, causing vanes to shear off grain. Reduce feed rate.</li> <li>2. Air velocity may be excessive. Slow air blower by changing pulleys or by opening gate valve.</li> <li>3. Damage can occur if system is running at less than full capacity. Increase feed rate.</li> <li>4. Rubber hose used to change grain direction or used for extended lengths.</li> <li>5. Airlock shear protector installed wrong.</li> </ol>
<b>Airlock stops or is noisy.</b>	<ol style="list-style-type: none"> <li>1. A foreign object may have become lodged in the airlock vanes.</li> <li>2. Check belt tension.</li> <li>3. Check gearbox drive.</li> <li>4. The rotor vanes may be rubbing on the ends of the airlock. Check clearance at both ends of rotor and center in housing by loosening the set screws in the bearings on both ends of the rotor shaft and moving rotor. Tighten set screws after re-positioning.</li> <li>5. The rotor vanes may have become rusted to the airlock housing. The airlock can be broken loose by using a pipe wrench on the exposed rotor shaft.</li> </ol> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">  <p><b>The worm drive gearbox <u>cannot</u> be driven in reverse and can be damaged. Remove the airlock drive chain before attempting to turn the airlock by hand.</b></p> </div> <ol style="list-style-type: none"> <li>6. "U" cup packings on rotor too tight. (Contact factory)</li> </ol>
<b>Unit will not start, "ready light" is not ON.</b>	<ol style="list-style-type: none"> <li>1. Check AC power supply.</li> <li>2. Check control box fuses.</li> <li>3. Thermal overload tripped (overload indicator is ON).</li> <li>4. Air pressure limit switch may be misadjusted (less than 5 PSI). If pressure switch is not reset, turn pressure adjustment clockwise until switch resets.</li> <li>5. Be sure "Start" switch is pushed.</li> </ol>
<b>Unit will not start, the "ready light" is ON.</b>	<ol style="list-style-type: none"> <li>1. Blower, airlock and auxiliary switches must be in either "AUTO" or MANUAL" to operate.</li> <li>2. The automatic control not wired correctly or not working. (Requires a closed contact across TB1 and TB2 to auto start.)</li> </ol>



Problem	Solution
<b>Blower motor trips thermal overload.</b>	<ol style="list-style-type: none"><li>1. Check current draw using amp meter. The motor should not be pulling more current than the nameplate specifies. Reduce feed rate if excessive.</li><li>2. Check overload amp settings.</li><li>3. Check for loose connections and/or too small gauge wire.</li><li>4. Wrong voltage (either high or low).</li><li>5. Too much load due to obstructions, bad bearings or dry gears.</li></ol>
<b>No control voltage.</b>	<ol style="list-style-type: none"><li>1. Control fuse inside the control box is down.</li><li>2. Check main power for proper voltage.</li><li>3. Check Transformer Fuses.</li></ol>

## 14. Couplings

### How to Handle Handling Couplings

1. Couplings are shipped ready-to-install. Do not disassemble. To prevent gasket from slipping out of proper position, always grasp coupling as shown in [Figure 14A](#). This will save time by maintaining proper position of gasket and sleeve in relation to shell and flange.

### Installing Couplings

1. Confirm pipe O.D. size you intend joining. Each compression coupling has been factory inspected for proper O.D. size before shipment.
2. Be sure outside surface of pipe is dry and free of dirt, grease or external burrs. (Burrs and jagged pipe ends can cut gasket; dirt and grease can cause coupling slippage.)
3. Grasp coupling as shown in [Figure 14A](#) to keep gasket and sleeve (and gasket protector when used) in separate quadrants, as shown in [Figure 14A](#). Be sure gasket teeth mesh and do not overlap.
4. Slide coupling over one pipe past end, then butt pipe ends. (A small gap 1/16 maximum at butt joint will not reduce coupling performance.) Slide coupling back until coupling and gasket protector are centered over joint. Use care when sliding coupling into place. Avoid wrinkling of gasket or gasket protector.
5. The gasket protector provides a bleed path for static electricity.
6. Partially tighten bolts evenly as follows:
  - 1/2" Bolt size - 45 ft. lbs. torque
  - 5/8" Bolt size - 65 ft. lbs. torque
  - 3/4" Bolt size - 95 ft. lbs. torque(Where SAE grade 5 5/8" bolts are specified tighten to 95 ft. lbs. For couplings with aluminum shell and inner sleeve do not exceed 40 ft. lbs.)
7. When properly and evenly tightened to the recommended torque the coupling installation is complete. The top edges of the flanges will touch and flanges appear as a vee when viewed from the end, as shown in [Figure 14A](#). **DO NOT** attempt tightening bolts to flatten flange faces together, as this exceeds recommended limits.

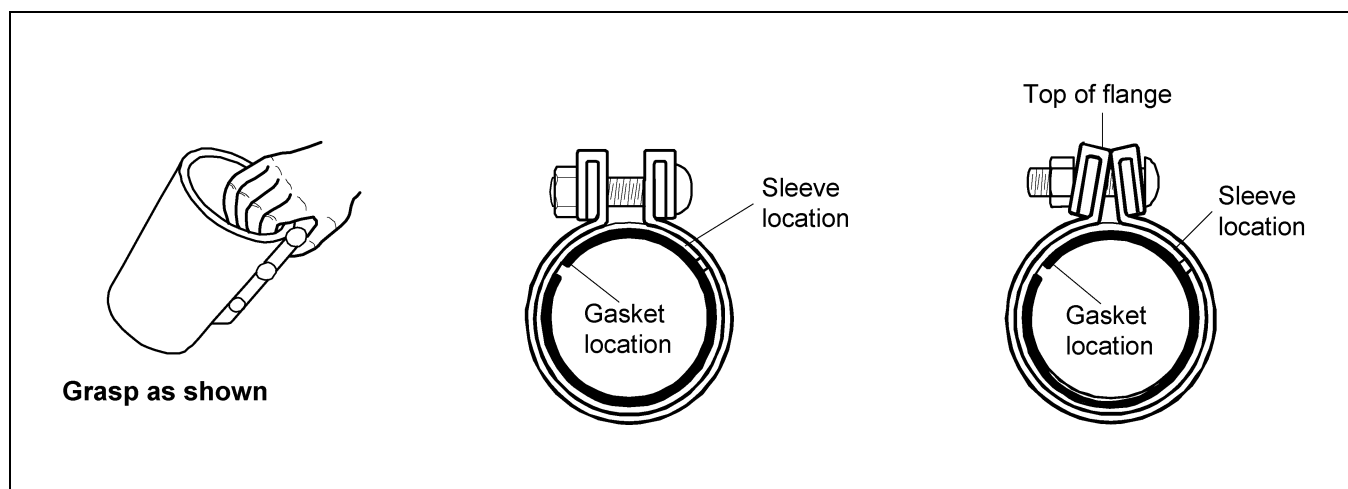


Figure 14A

## GSI Group, LLC Limited Warranty

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 after sale to the original end-user or if a foreign sale, 14 months from arrival at port of discharge, whichever is earlier. The end-user's sole remedy (and GSI's only obligation) is to repair or replace, at GSI's option and expense, products that in GSI's judgment, contain a material defect in materials or workmanship. Expenses incurred by or on behalf of the end-user without prior written authorization from the GSI Warranty Group shall be the sole responsibility of the end-user.

### Warranty Extensions:

The Limited Warranty period is extended for the following products:

	Product	Warranty Period	
<b>AP Fans and Flooring</b>	Performer Series Direct Drive Fan Motor	3 Years	* Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 25% 5 to 7 years - end-user pays 50% 7 to 10 years - end-user pays 75%
	All Fiberglass Housings	Lifetime	
	All Fiberglass Propellers	Lifetime	
<b>Cumberland Feeding/Watering Systems</b>	Feeder System Pan Assemblies	5 Years **	** Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 50%
	Feed Tubes (1-3/4" and 2.00")	10 Years *	
	Centerless Augers	10 Years *	
	Watering Nipples	10 Years *	
<b>Grain Systems</b>	Grain Bin Structural Design	5 Years	† Motors, burner components and moving parts not included. Portable dryer screens included. Tower dryer screens not included.
<b>Grain Systems Farm Fans Zimmerman</b>	Portable and Tower Dryers	2 Years	
	Portable and Tower Dryer Frames and Internal Infrastructure †	5 Years	

GSI further warrants that the portable and tower dryer frame and basket, excluding all auger and auger drive components, shall be free from defects in materials for a period of time beginning on the twelfth (12<sup>th</sup>) month from the date of purchase and continuing until the sixtieth (60<sup>th</sup>) month from the date of purchase (extended warranty period). During the extended warranty period, GSI will replace the frame or basket components that prove to be defective under normal conditions of use without charge, excluding the labor, transportation, and/or shipping costs incurred in the performance of this extended warranty.

### Conditions and Limitations:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH ABOVE. SPECIFICALLY, GSI MAKES NO FURTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) 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.

GSI shall not be liable for any direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. The sole and exclusive remedy is set forth in the Limited Warranty, which shall not exceed the amount paid for the product purchased. 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.

GSI assumes no responsibility for claims resulting from construction defects or unauthorized modifications to products which it manufactured. Modifications to products not specifically delineated in the manual accompanying the equipment at initial sale will void the Limited Warranty.

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. This Limited Warranty extends solely to products manufactured by GSI.

Prior to installation, the end-user has the responsibility to comply with federal, state and local codes which apply to the location and installation of products manufactured or sold by GSI.

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.

**For more information, contact the DMC Distribution Center closest to you.**



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