



**Improper installation methods of the hardware may cause permanent damage and possible breakage of the boot.**

## Boot and Transfer Plate Installation

**NOTE:** Installation of the boot is the same whether the tank has the standard collar or the Sure-Flo Feed Flow Control.

Slide the boot as far as possible into the tank collar or the Sure-Flo Feed Flow Control opening. (See Figure 1.) Align the boot with the Flex-Flo System that will be installed. Using the holes in the collars for guides, drill eight (8) 11/32" holes into the boot rim. (See Figure 2.)

Mount the boot to the collar with the hardware provided. Bolt the Transfer Plate and Unloader Braces to the boot as shown. See Figure 3 for proper usage and assembly direction of hardware for mounting the boot and the transfer plate. All connections should be tightened until they are "snug".

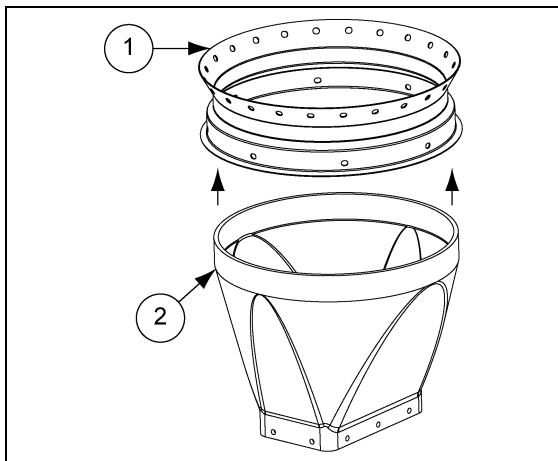


Figure 1

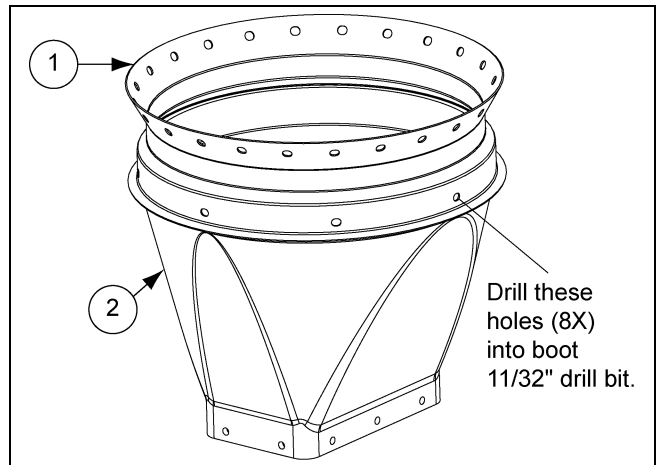


Figure 2

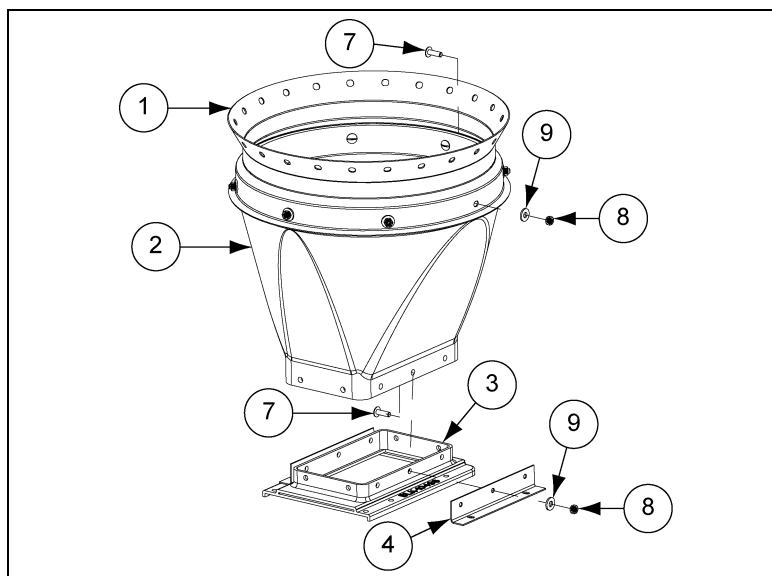


Figure 3



# HR Unloader Restrictor Adjustment

## Slide Gate Installation

Insert the slide into the transfer plate. The slide must be in its operating position prior to attaching the slide shield to the transfer plate. Use two (2) 5/16"-18 x 1" truss head tap bolts to mount the slide shield. (See Figure 4.)

Bolt unloader to transfer plate/unloader brace assembly as shown in Figure 5. Note orientation of these bolts. (See Figure 5.)

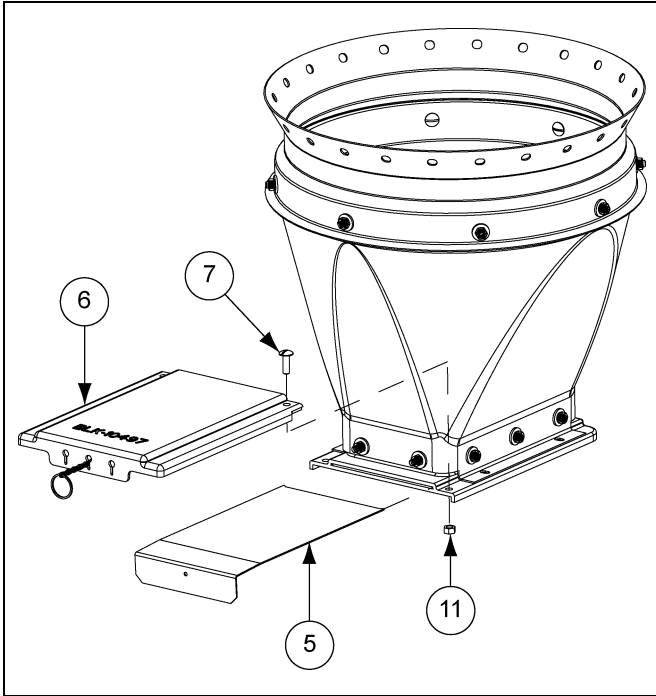


Figure 4

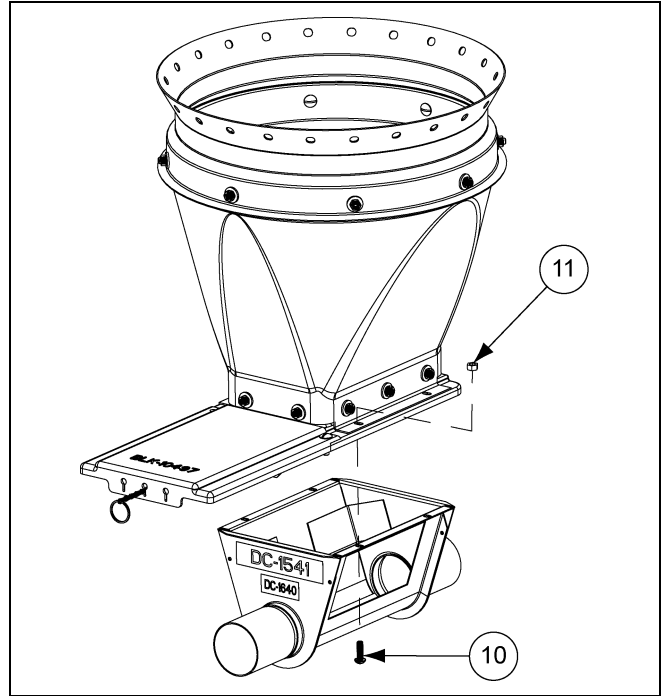


Figure 5

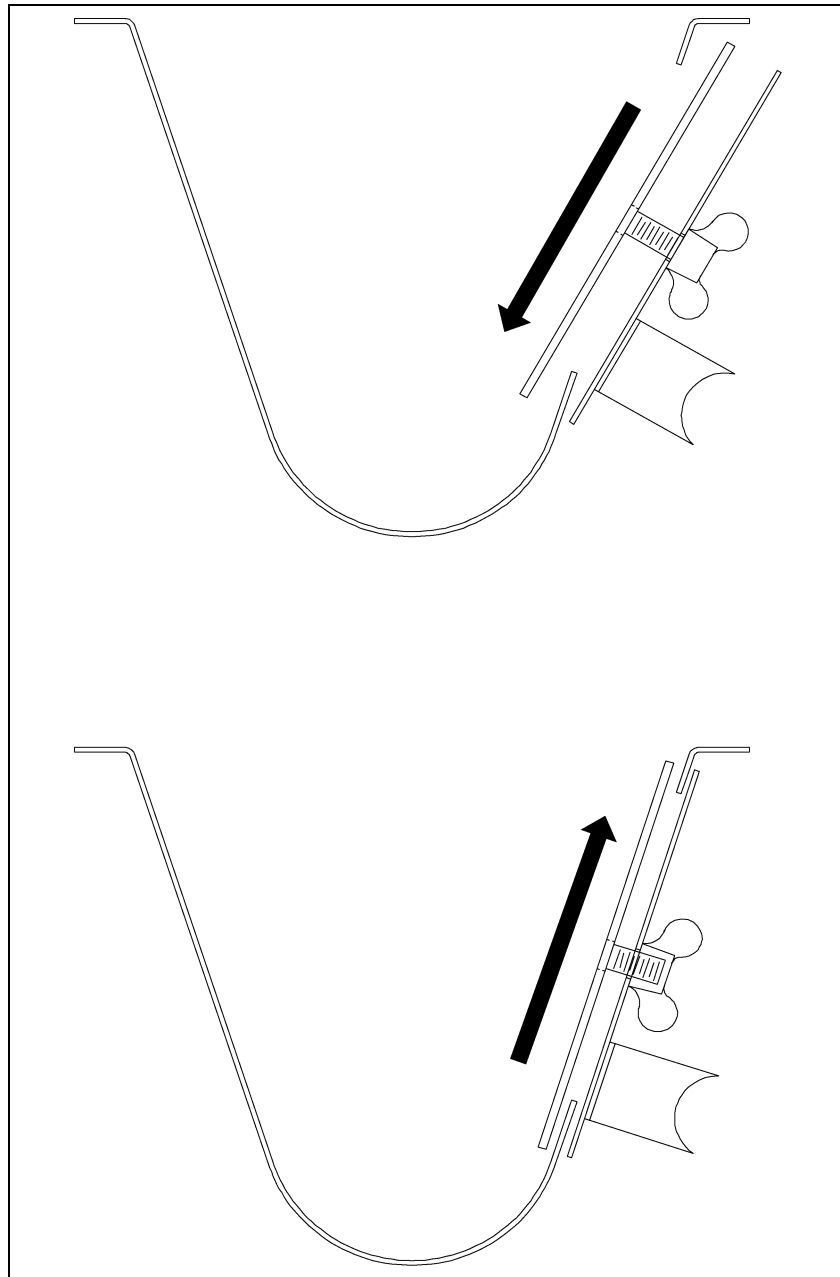
Ref #	Part #	Description
1	BLK-10488	16" 67° 16" Hopper Collar (24 Holes)
1	BLK-10489	16" 60° Hopper Collar (24 Holes)
1	BLK-11463	16" 60° Hopper Collar (27 Holes)
1	BLK-12342	16" 60° Hopper Collar (18 Holes)
2	FLX-2194	16" 30° Black Plastic Boot
2	FLX-2194C	16" 30° Clear Plastic Boot
2	FLX-2195	16" Straight Black Plastic Boot
2	FLX-2195C	16" Straight Clear Plastic Boot
2	FLX-4869	16" Double Straight Black Boot
3	BLK-10496	Transfer Plate
4	FLX-4819	Unloader Brace
5	FLX-4782	Slide Gate
6	BLK-10497	Slide Gate Shield
7	S-4336	5/16" x 1" Truss Head Machine Screw
8	S-4337	5/16"-18 Nylon Insert Nut
9	S-4338	5/16" Nylon Washer
10	S-8328	Screw, MS 5/16"-18 x 1" RHS ZN Grade 2
11	S-396	Hex Nut 5/16"-18 YDP Grade 2

## Inspection/Clean-Out Plate Installation

Once the installation of the auger tubes and auger is complete, insert the inspection/clean-out plate or the optional unloader switch.

The inspection/clean-out plate is to be installed per the following instructions ([See Figure 6](#)):

1. Back off both wing nuts to the stud ends.
2. Slide the plate onto the lower side of the unloader opening.
3. Move the plate first against the side of the unloader then upward toward the top of the unloader.
4. Tighten the wing nuts while holding the plate steady.



**Figure 6** *Clean-Out Plate Installation*

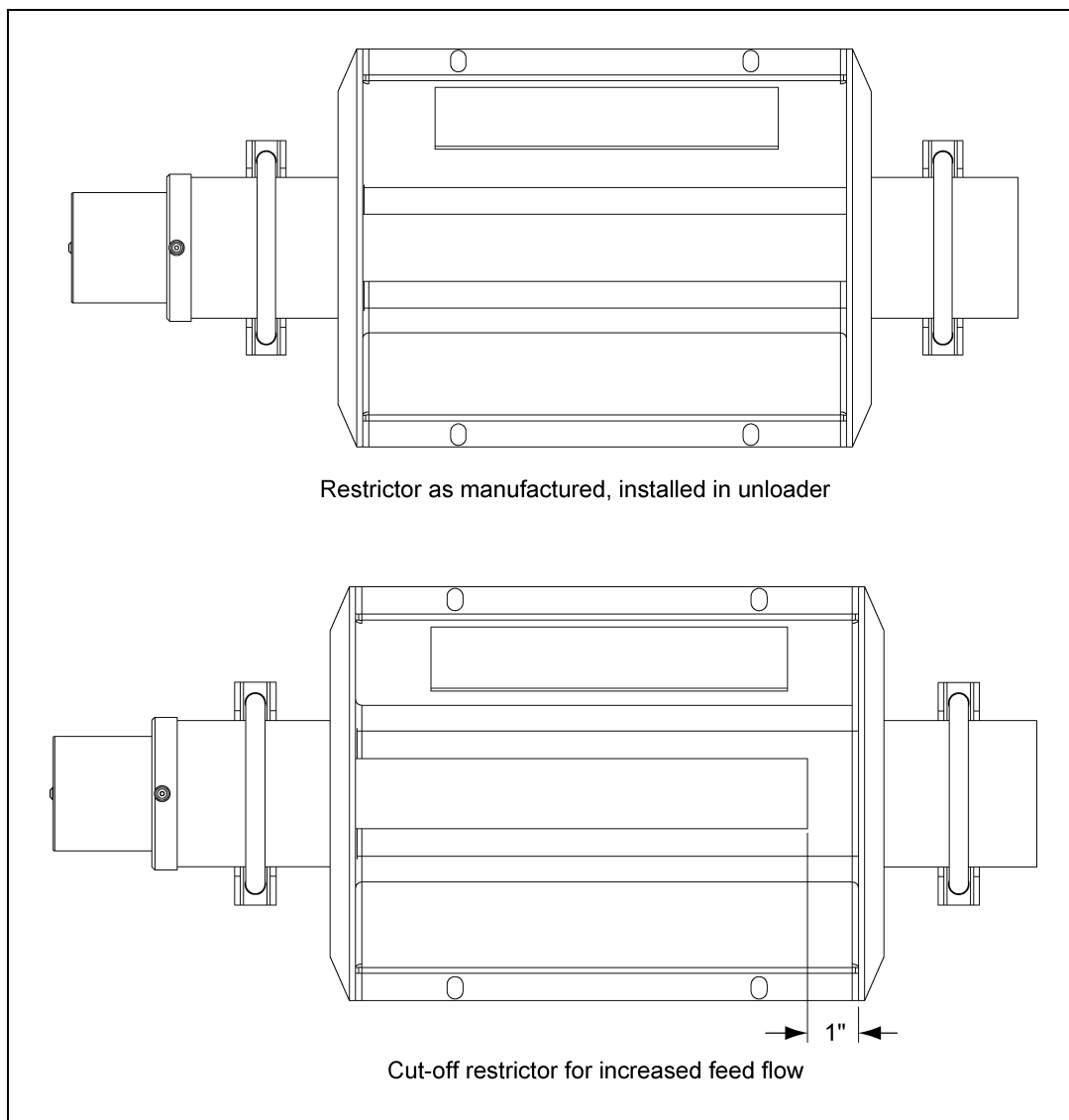
# HR Unloader Restrictor Adjustment

## Restrictor Adjustment

The restrictor may be adjusted to allow more feed flow. Do not modify the restrictor until the system is completely operational and the auger has been polished by running feed through the system.

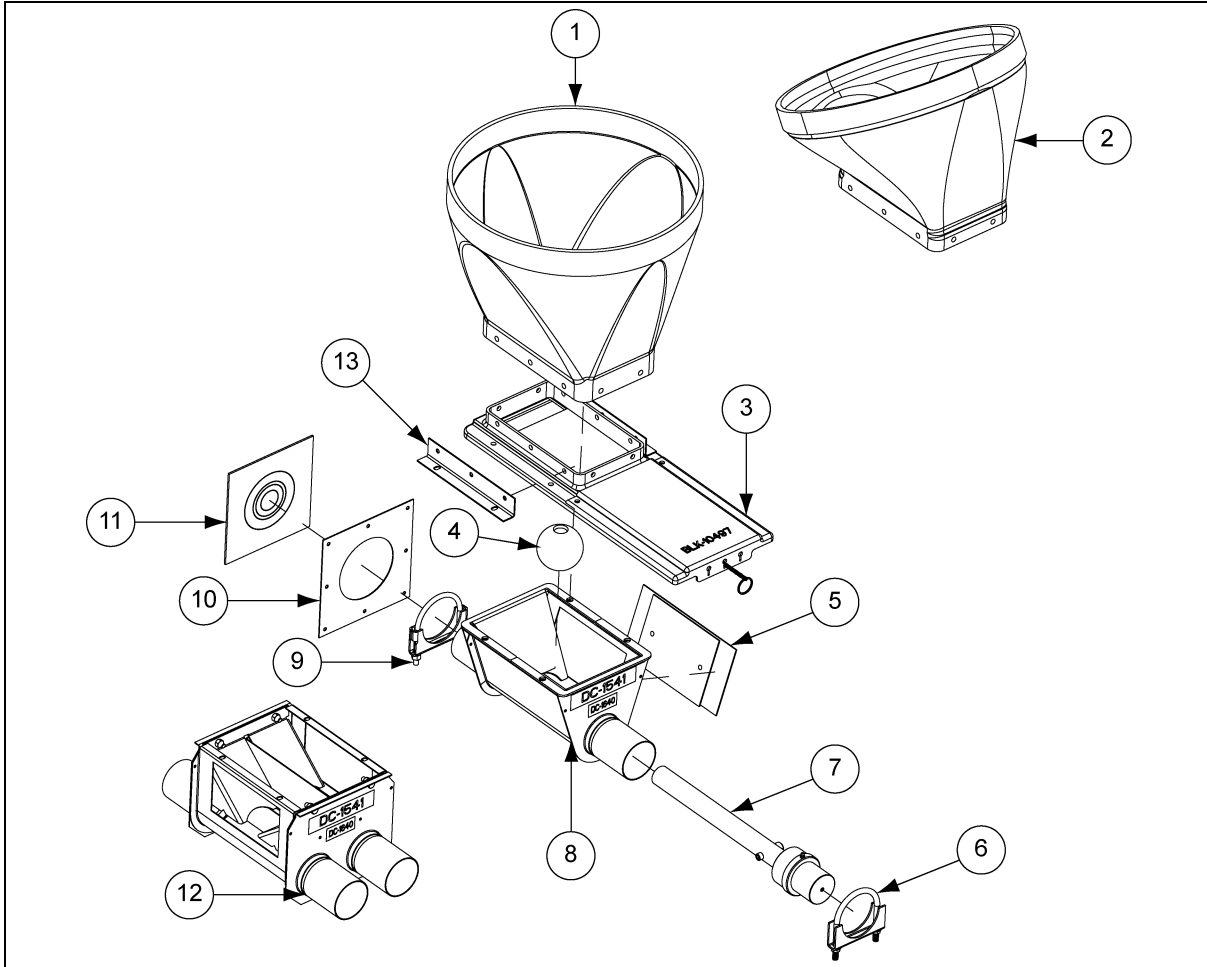
### Instructions:

1. Remove the restrictor tube from the unloader.
2. Cut 1" (2.5 cm) from the restrictor. (*See Figure 7.*)
3. Install the restrictor and the bearing assembly into the unloader.
4. Test the feed flow.
5. If the desired feed flow rate is not attained, repeat the above procedure until the desired rate is reached.



**Figure 7** Restrictor Adjustment

HR Unloader and Anchor Assembly



HR Unloader		
Ref #	Part #	Description
1	FLX-2195	16" Straight Black Plastic Boot
1	FLX-2195C	16" Straight Clear Plastic Boot
2	FLX-2194	16" 30° Black Plastic Boot
2	FLX-2194C	16" 30° Clear Plastic Boot
N/S	FLX-4869	16" Double Straight Black Boot
3	BLK-11137A	Transfer and Slide Gate Kit
4	404238	Iron Ball 3" Hollow - 1-1/2 #
5	FLX-4461	Clean-out Plate Assembly
6	S-4319	3-1/2" Tube Clamp
7	FLX-4648HR	Anchor and Bearing Assembly
8	FLX-2605	Model HR Flex-Flo Single through Unloader Body Assembly
9	S-4443	4" Tube Clamp
10	FLX-2217	Model 220, 300, 350 Flex Seal Ring
11	FLX-3422	Neoprene Seal
12	FLX-2116HR	HR Twin Unloader Body with Baffle
13	FLX-4819	Unloader Brace