

6", 8" and 10" Variable Angle Auger Connector

Assembly and Installation Manual

PNEG-1060

Date: **12-21-20**

GSI GROUP



PNEG-1060

Part #	Tube Assembly		Flight Assembly	
	Intake Size	Discharge Size	Intake Shaft	Discharge Shaft
GK2250	6"	6"	13/16" Round	13/16" Round
GK2270	6"	6"	1" Square	1" Round
GK22501	6"	6"	1" Round	1" Round
GK2260	6"	8"	13/16" Round	1-1/4" Round
GK2271	6"	8"	1" Square	1-1/4" Round
GK22601	6"	8"	1" Round	1-1/4" Round
GK2257	8"	8"	1-1/4" Round	1-1/4" Round
GK2268	8"	10"	1-1/4" Round	1-1/2" Round
GK2262	10"	10"	1-1/2" Round	1-1/2" Round
GK2272	10"	10"	1-1/4" Square	1-1/2" Round
GK6003	10"	10"	1" Square	1-1/2" Round

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

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General Information

1. GSI reserves the right to improve its product whenever possible and practical to do so. We reserve the right to change, improve, and modify products at any time without obligation to make changes, improvements, and modifications on equipment sold previously.
2. Receiving merchandise and filing claims
 - a. When receiving merchandise, check both the quantity of parts and their descriptions against the packing list enclosed within each package. All claims for freight damage or shortage must be made by the consignee within ten (10) days from the date of the occurrence of freight damage. The consignee should accept the shipment after noting the damage or loss on the Bill of Lading (BOL).
3. The variable angle auger connectors have been designed and manufactured to provide years of dependable service. The care and maintenance of this machine will affect the service and satisfaction obtained. Observing the instructions and suggestions in this manual contributes to the satisfactory service provided by this equipment. If additional information or assistance should be required, please contact the factory or your local dealer.

Capacity

1. The capacities may vary greatly under different conditions. The following factors play a role in the performance of the auger:
 - Speed
 - Angle of operation
 - Moisture content*
 - Amounts of foreign matter
 - Different materials
 - Methods of feeding

* For example, a twenty-five percent (25%) moisture could cut capacity by as much as forty percent (40%) under some conditions.

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



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



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



CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.



NOTE indicates information about the equipment that you should pay special attention.

2. Safety

General Safety Guidelines

- A. **DO NOT** make any alterations to the equipment. Any alteration may produce a very dangerous situation that could result in **SERIOUS INJURY** or even **DEATH**.
- B. This equipment shall be installed in accordance with any regulations or installation codes that are required by law. Authorities having jurisdiction should be consulted before installations are made.
- C. Untrained operators subject themselves and others to **SERIOUS INJURY** or **DEATH**. **NEVER** allow untrained personnel to operate this equipment.
- D. Keep children and other unqualified personnel out of the working area at **ALL** times.
- E. **NEVER** start equipment until **ALL** persons are clear of the work area.
- F. Be sure **ALL** operators are adequately rested and prepared to perform **ALL** functions of operating the equipment.
- G. **DO NOT** wear loose fitting clothing when working around augers. Keep hair, loose clothing, and shoestrings away from rotating and moving parts.
- H. **NEVER** allow any person intoxicated or under the influence of alcohol or drugs to operate the equipment.
- I. **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.
- J. Make sure someone is nearby who is aware of the proper shut down sequence in the event of an accident or emergency.
- K. **NEVER** work alone.
- L. **ALWAYS** think before acting. **DO NOT** act impulsively around the equipment.
- M. Make sure **ALL** equipment is locked in position before operating.
- N. **ALWAYS** keep hands and feet away from the auger intake and other moving parts.
- O. **NEVER** attempt to assist machinery operation or to remove trash from equipment while in operation.
- P. **NEVER** drive, stand, or walk under the equipment.
- Q. Use caution not to hit the auger when positioning the load.
- R. Use ample overhead lighting after sunset to light the work area.
- S. **ALWAYS** lock out **ALL** power to the equipment when finished unloading.
- T. Keep area around intake free of obstacles such as electrical cords, blocks, etc. that might trip workers.

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.

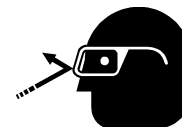
Wear gloves to protect your hands from sharp edges on plastic or steel parts.

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.

Eye Protection



Gloves



Steel Toe Boots



Respirator



Hard Hat



Emergency Shut Down Sequence

A. In an emergency, shut down the power source.

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.

A. Components of this equipment have sharp edges which can scrape and/or cut an operator.

B. A moving auger can sever an operator's limbs or even kill him/her.

Shields and Guards

A. **ALWAYS** keep **ALL** shields and guards in place during operation.

GSI will replace decals free of charge.

Operator Qualifications

A. The User/Operator must be competent and experienced to operate auger equipment. Anyone who works with or around augers must have good common sense in order to be qualified. These persons must also know and meet all other qualifications, such as:

- i. Any person who has not read and/or does not understand all operation and safety procedures is not qualified to operate any auger systems.
- ii. Certain regulations apply to personnel operating power machinery. Personnel under the age of 18 years may not operate power machinery, including augers. It is your responsibility, as owner and/or supervisor, to know what these regulations are in your area or situation.
- iii. Unqualified or incompetent persons are to remain out of the work area.
- iv. O.S.H.A. (Occupational Safety and Health Administration) regulations state: “At the time of initial assignment and at least annually thereafter, the employer shall instruct every employee in the safe operation and servicing of all equipment with which the employee is, or will be involved”. (Federal Occupational Safety and Health Standards for Agriculture. Sub Part D, Section 19287.57 (a) (6)).

B. As a requirement of O.S.H.A., it is necessary for the employer to train the employee in the safe operating and safety procedures for this auger. The sign-off sheet is for your convenience and personal record keeping. All unqualified persons should always stay out of work area. It is strongly recommended that another qualified person who knows the shut down procedure is in the area in the event of an emergency.

<i>Date</i>	<i>Employee Name</i>	<i>Supervisor Name</i>

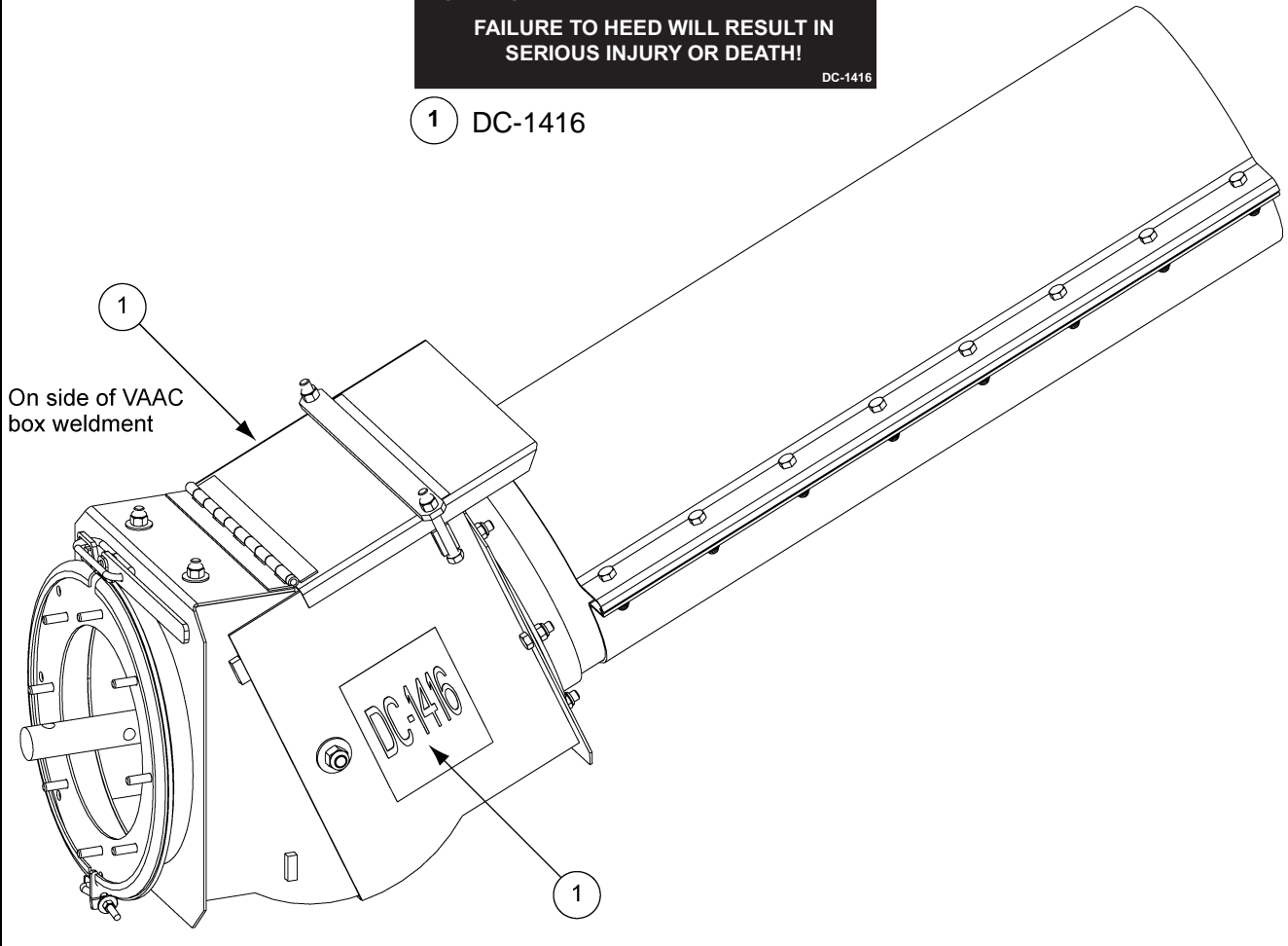
The illustration shows what the decals look like and where they should be located on the equipment. Inspect all decals and replace any that are illegible, worn, or missing. Contact your local dealer or the manufacturer to order replacement decals free of charge.

VAAC Decal List

Ref #	Part #	Description	Size
1	DC-1416	Danger - Rotating Auger	4" x 5-1/4"



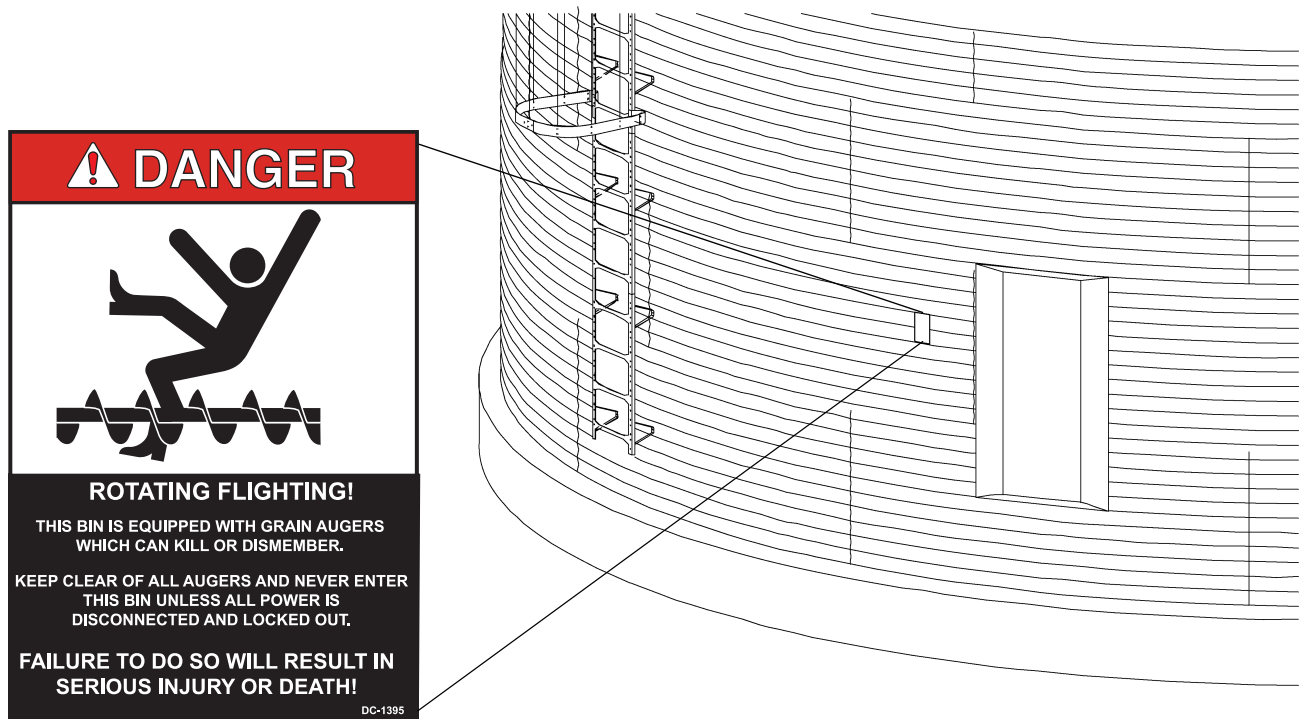
① DC-1416



3. Safety Decals

- A. DANGER Sign No. DC-1395 was supplied with your bin unloading equipment. This safety sign should be applied to the side of the bin near the bin opening, so it will be viewed by people entering into the bin storage building. Do not cover any safety signs or any other signs that are already there.
- B. If the safety sign location suggested is not in full view because of equipment modifications, other equipment in the area or any other reason, then locate the safety sign in a more suitable location.
- C. Be certain the surface is clean, dry and free of dirt and oil. Peel paper backing from decals and stick into place. The adhesive backing will bond on contact.

NOTE: Remember, safety signs provide important safety information for people working near bin unloading equipment that is in operation.



NOTE: If the safety sign cannot be easily read for any reason or has been painted over, replace it immediately. Additional safety signs may be obtained free of charge from your dealer, distributor or ordered from the factory.

Order SAFETY SIGN NO. DC-1395.

With an operating range of 0° to 25°, the variable angle auger connector can be used for a variety of applications. The intake end should attach to standard flange rings for standard bin unloading flight and tubes. The discharge side of the connector box can bolt to standard flange rings, or it can make a smooth tube type connection using the short flanged tube with connecting band. The smooth tube connection allows standard utility augers to be attached to the connector box.

The [Figure 4A](#) below shows the intake side with a VAAC connector box attached to an unloading tube and flight. The discharge side of the VAAC connector box is attached to a standard utility auger.

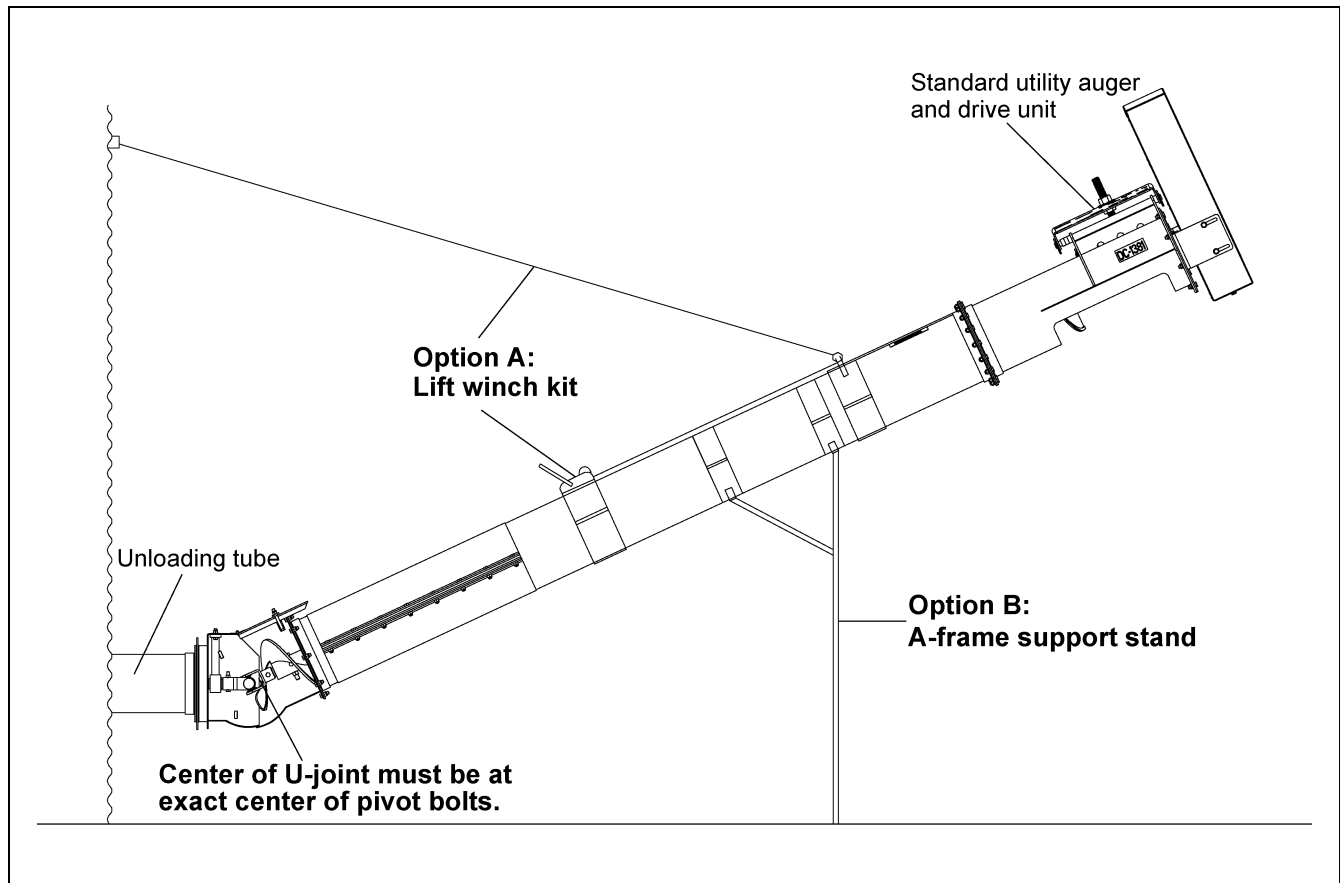


Figure 4A

Inclined Auger Support

[Figure 4A](#) shows two different methods of supporting the inclined auger.

NOTE: The connector box **CANNOT** support the weight of the auger system attached to the output side of the connector box.

CAUTION

Loosen lid strap on connector box before raising or lowering incline auger or damage may occur to equipment. The connector box will not raise higher than 25°.

- OPTION A: **WINCH KIT** - a winch kit provides an easy means to adjust the discharge height of the inclined auger. The kit includes winch, winch mount, roller assembly, roller assembly mounts, lift cable and hardware.
- OPTION B: **SUPPORT STAND** - An A-frame support stand provides a band on support for incline auger. The support stand can be attached at different locations along the auger tube to create various operating angles.

Connecting Box Angle Adjustment



DO NOT adjust the angle while the auger is in operation. Stop the machine and lock out power before cleaning, adjusting, or servicing.



DO NOT operate with cover open.

CAUTION

The inclined auger must always be supported. The connector box cannot support the weight of the auger system attached to the output side of the connector box.

1. Loosen the cover strap on the connector box before changing the angle of operation.
2. Change angle of the inclined auger, by re-supporting the inclined auger at the desired angle.
3. Check to see if the U-joint is centered with pivot bolts and make sure the input flight is not rubbing on the bearing or bearing hanger on the inside of the connector box.
4. Close cover and secure the cover strap.

Horsepower for an Auger System with an Inclined Discharge

To determine the horsepower required for the auger system, follow the [Steps 1-3](#) and use the [Chart Below](#).

1. Determine the overall length of auger system (horizontal plus inclined unit).
2. Multiply the total auger system length by the horsepower per foot from the [Chart Below](#).
3. Round horsepower up to the next common size motor.

Horsepower Chart	
Auger Diameter	Per Foot Horsepower Multiplier
6"	0.1
8"	0.15
10"	0.23

These horsepower recommendations are for augering reasonably dry grain at varying angles. High moisture grain (above 15%) will require greater power and maximum possible capacity will be less with high moisture grain than with dry grain.

Example for 10" unit:

1. 16' Horizontal portion and 11' inclined portion = 27' total length of auger system.
2. $27 \times .23 = 6.21$ HP.
3. Round up to 7 HP motor.



Refer to the installation manual received with the unloading equipment for information on safety and operating procedures. This should include start-up, shut down, lock out, break-in, full load operation, power source and troubleshooting.

1. Connect the inlet stub to the bin unloading flight.
2. Connect the box weldment inlet flange to the unloading tube flange using the quick clamp or by directly bolting them together. **(NOTE: If you have a 6" to 8" or 8" to 10" VAAC, bolt the adapter plate to the box weldment inlet flange before attaching to the bin unloading tube flange.)**
3. Remove cover strap.
4. Attach the incline auger flight to the discharge connecting stub.
5. Fasten the outlet tube to the inclined auger tube using the connecting band.
6. Once the angle of the auger is adjusted, support auger with one of the options shown [on Page 11](#).
7. Replace cover strap over the lid and tighten.

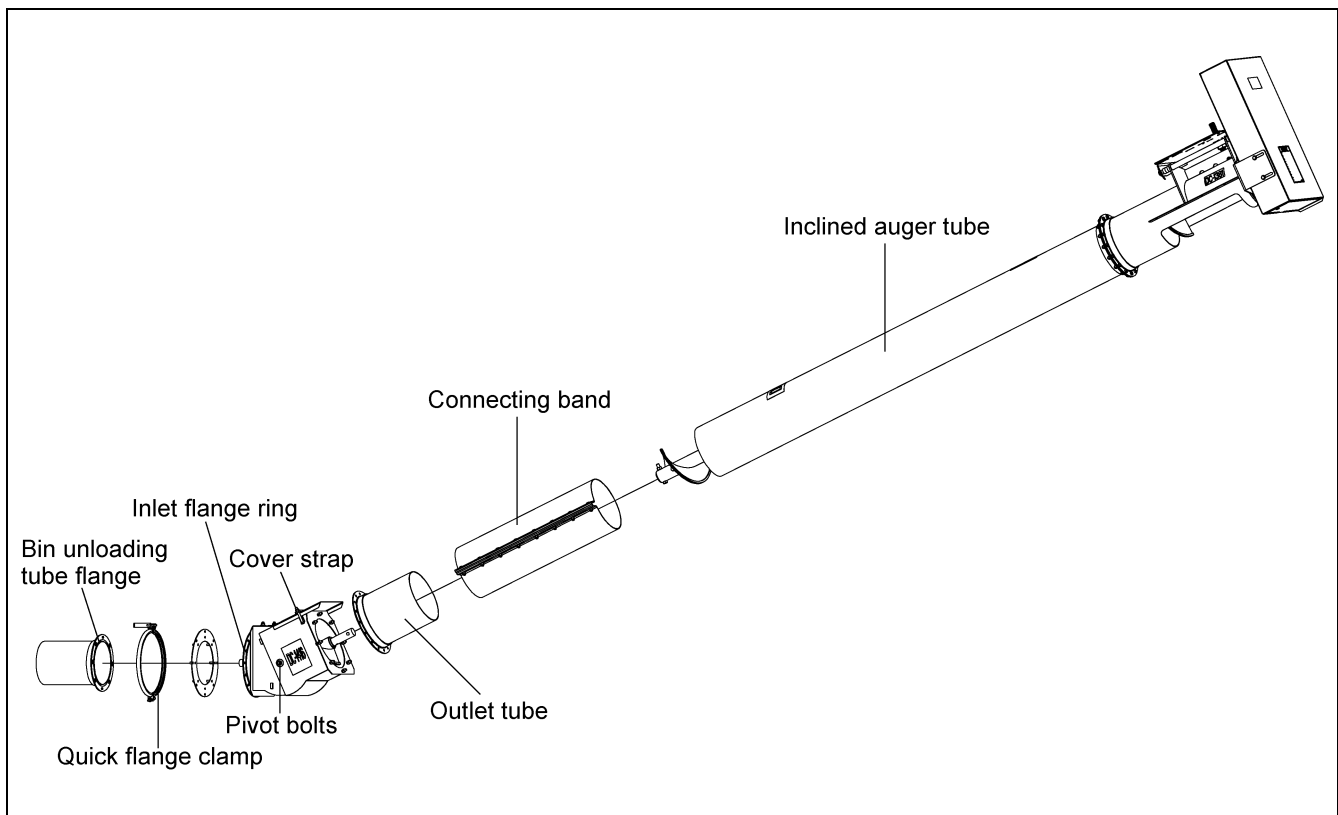
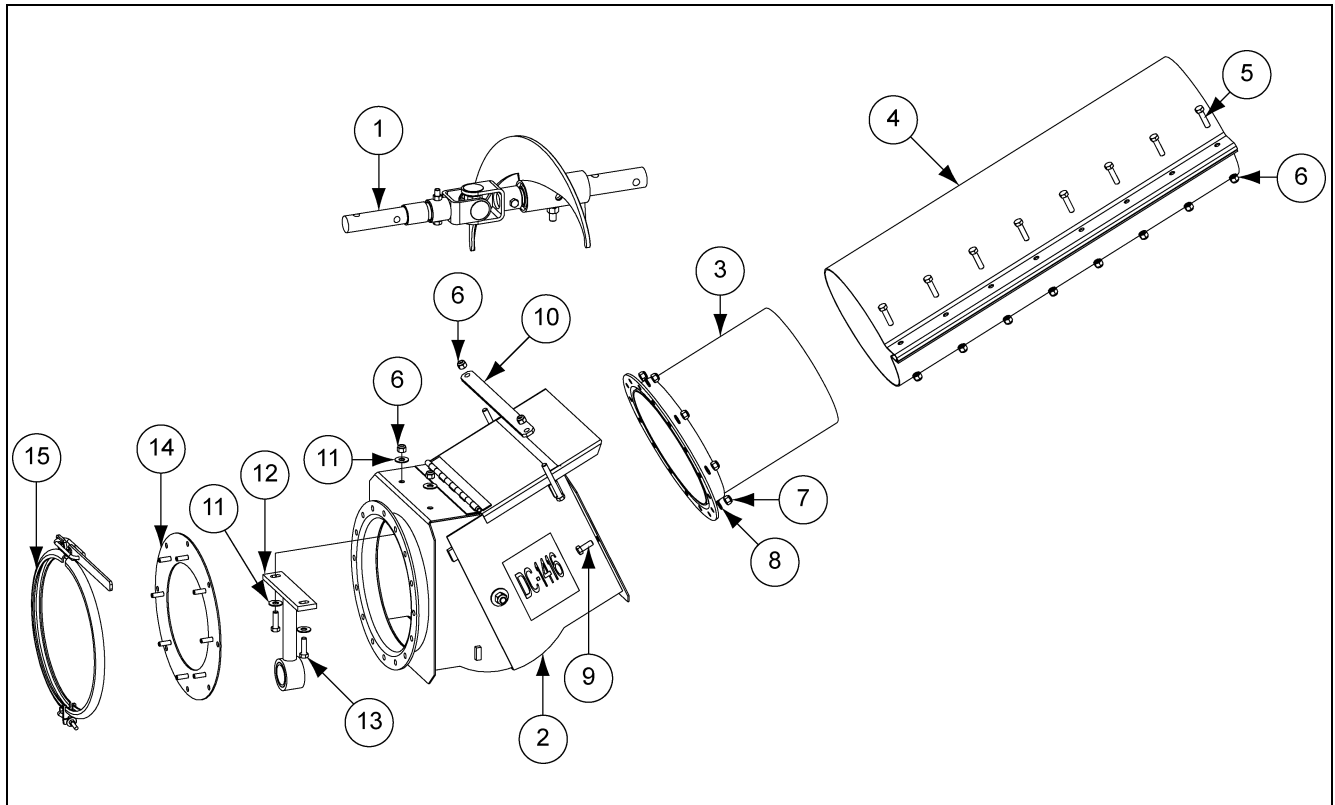


Figure 5A

VAAC Parts

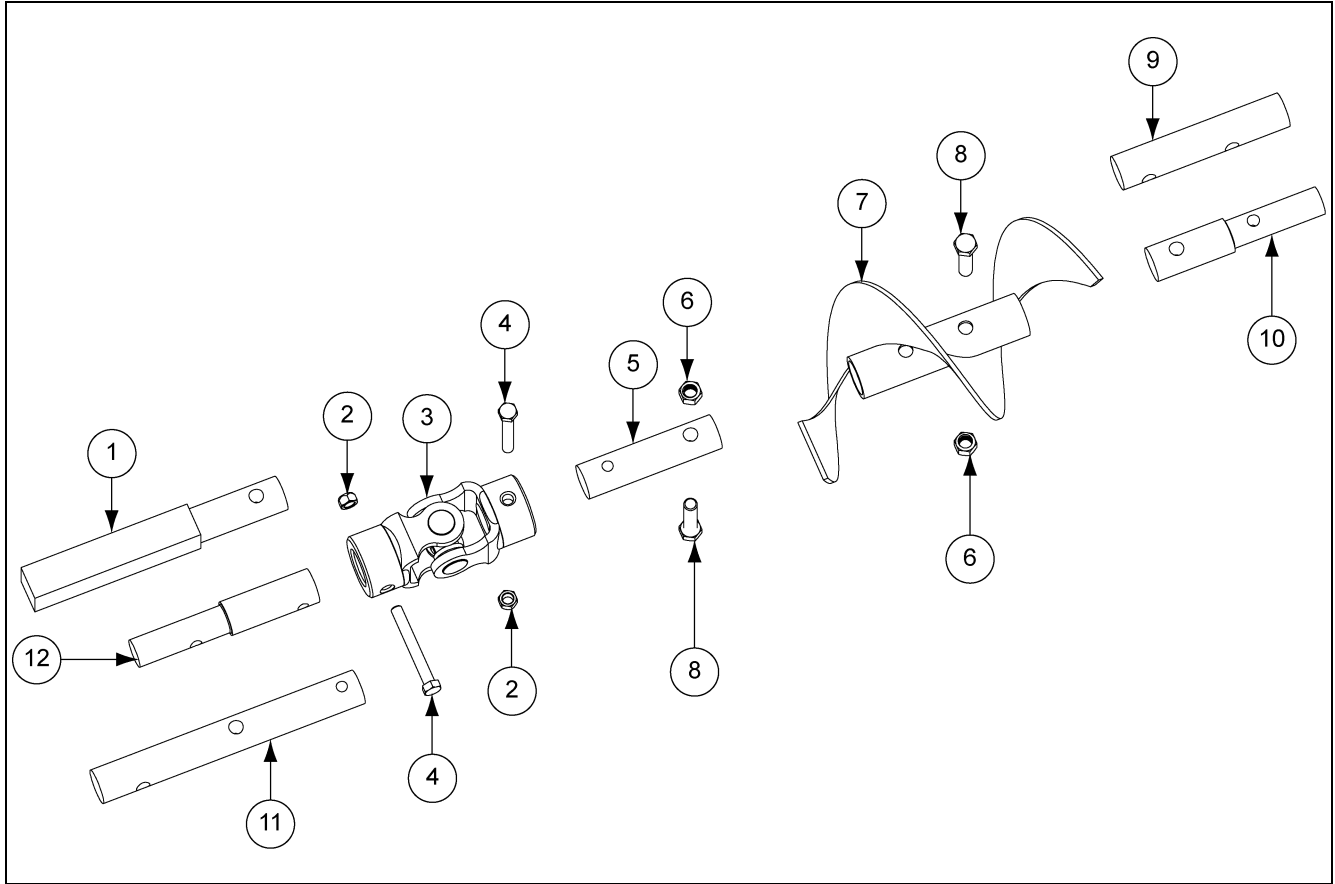


VAAC Parts

Ref #	Part #	Description	Intake Size	Discharge Size	Intake Shaft	Discharge Shaft	Page #
1	GK5187	5" VAAC Flight Assembly	6"	6"	13/16" Round	13/16" Round	See Page 16
	GK5188				1" Square	1" Round	
	GK6846				1" Round	1" Round	
	GK5190	7" VAAC Flight Assembly	6"	8"	13/16" Round	1-1/4" Round	See Page 17
	GK5191				1" Square		
	GK7256				1" Round		
	GK5189				1-1/4" Round		
	GK5193	9" VAAC Flight Assembly	8"	10"	1-1/4" Round	1-1/2" Round	See Page 19
	GK5192				1-1/2" Round		See Page 20
	GK5194				1-1/4" Square		
	GK6002				1" Square		

Ref #	Part #	Description	System
2	GK2241	VAAC Box Assembly	6"
	GK2251		8"
	GK2258		10"
3	GK2246	Outlet Tube	6"
	GK2256		8"
	GK2266		10"
4	GK1048	Connecting Band	6"
	GK1015		8"
	GK1883		10"
5	S-2086	3/8"-16 x 1-1/2" HHCS Zinc Grade 8	ALL
6	S-7383	3/8"-16 Nylock Nut Zinc Grade 5	ALL
7	S-7382	5/16"-18 Nylock Nut Zinc Grade 5	6" and 8"
	S-7383	3/8"-16 Nylock Nut Zinc Grade 5	10"
8	S-1937	5/16" Flat Washer YDP	6" and 8"
9	S-4275	5/16"-18 x 3/4" HHTB Zinc Grade 5	6" and 8"
	S-7469	3/8"-16 x 1" HHCS Zinc Grade 5	10"
10	GK2245	Cover Strap	6"
	GK2255		8"
	GK4956		10"
11	S-248	3/8" Flat Washer YDP	ALL
12	GK1357	1" Hanger Bearing	6"
	GK1359	1-1/4" Hanger Bearing	8"
	GK4253	1-1/2" Hanger Bearing	10"
13	S-2071	3/8"-16 x 1-1/4" HHCS Zinc Grade 5	ALL
14	GK1280	6"-8" Mounting Adapter Ring	6"-8"
	GK1298	8"-10" Mounting Adapter Ring	8"-10"
15	GK1013	6" Quick Clamp Band Assembly	6"
	GK1279	8" Quick Clamp Band Assembly	8"
	GK1299	10" Quick Clamp Band Assembly	10"

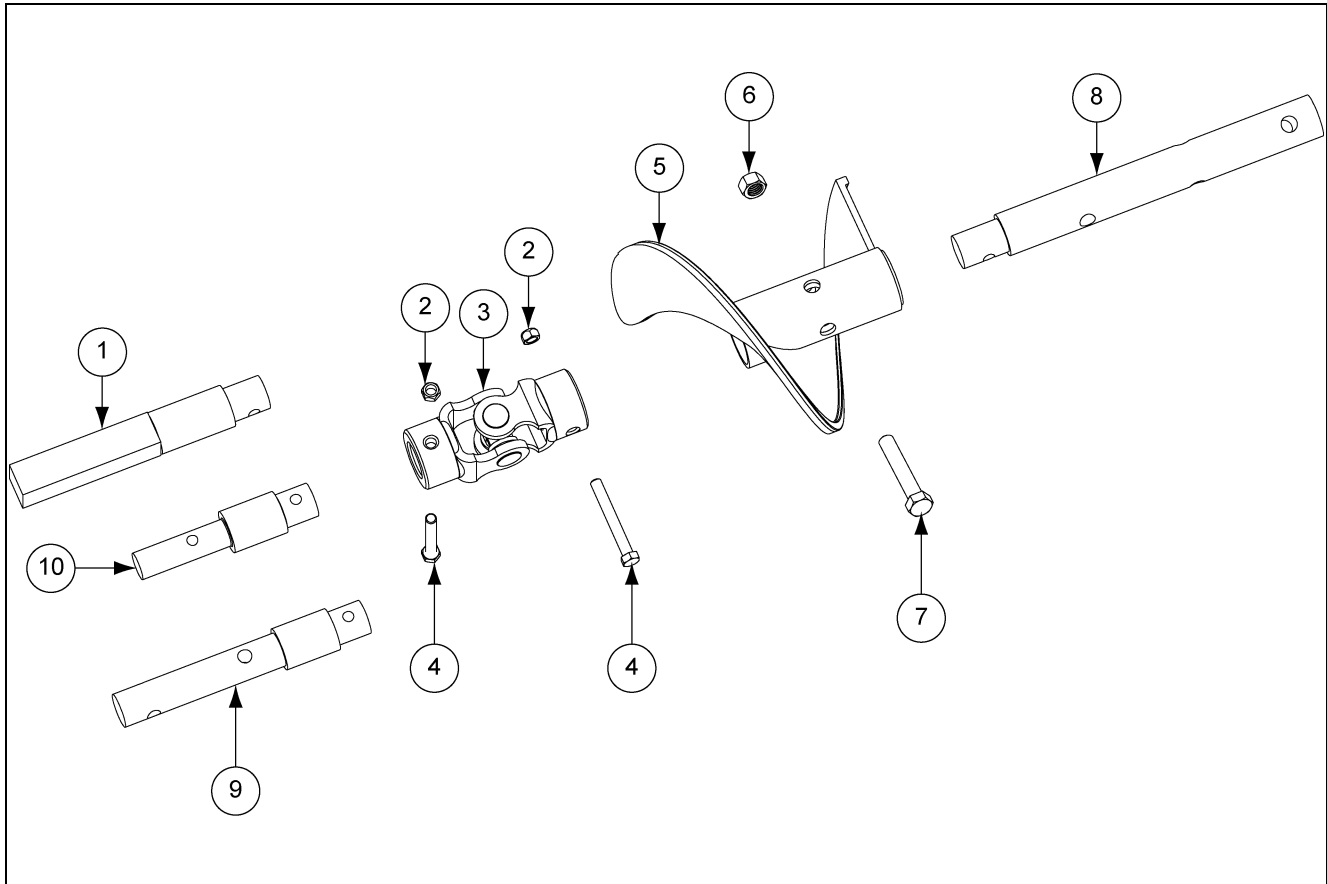
6"-6" Flight Assembly Parts



6"-6" Flight Assembly Parts

Ref #	Part #	Description
1	GK2269	Intake Shaft 1" O.D. x 1" SQ x 7-5/8" Long
2	S-8324	5/16"-18 Stover Nut Zinc Grade C
3	GK1266	U-Joint 1" Bore x 5" Long
4	S-7076	5/16"-18 x 2-1/2" HHCS Zinc Grade 5
5	GK2248	Intermediate Shaft 1" O.D. x 4" Long
6	S-8251	3/8"-16 Stover Nut Zinc Grade C
7	GK2243	VAAC 6" Flight x 9" Long
8	S-3727	3/8"-16 x 1-3/4" HHCS Zinc Grade 8
9	GK2247	Discharge Shaft 1" O.D. x 5" Long
10	GK2244	Discharge Shaft 1":13/16" O.D. x 5-1/16" Long
11	GK5706	Intake Shaft 1" O.D. x 7-7/8" Long
12	GK2249	Intake Shaft 1":13/16" O.D. x 5-3/8" Long

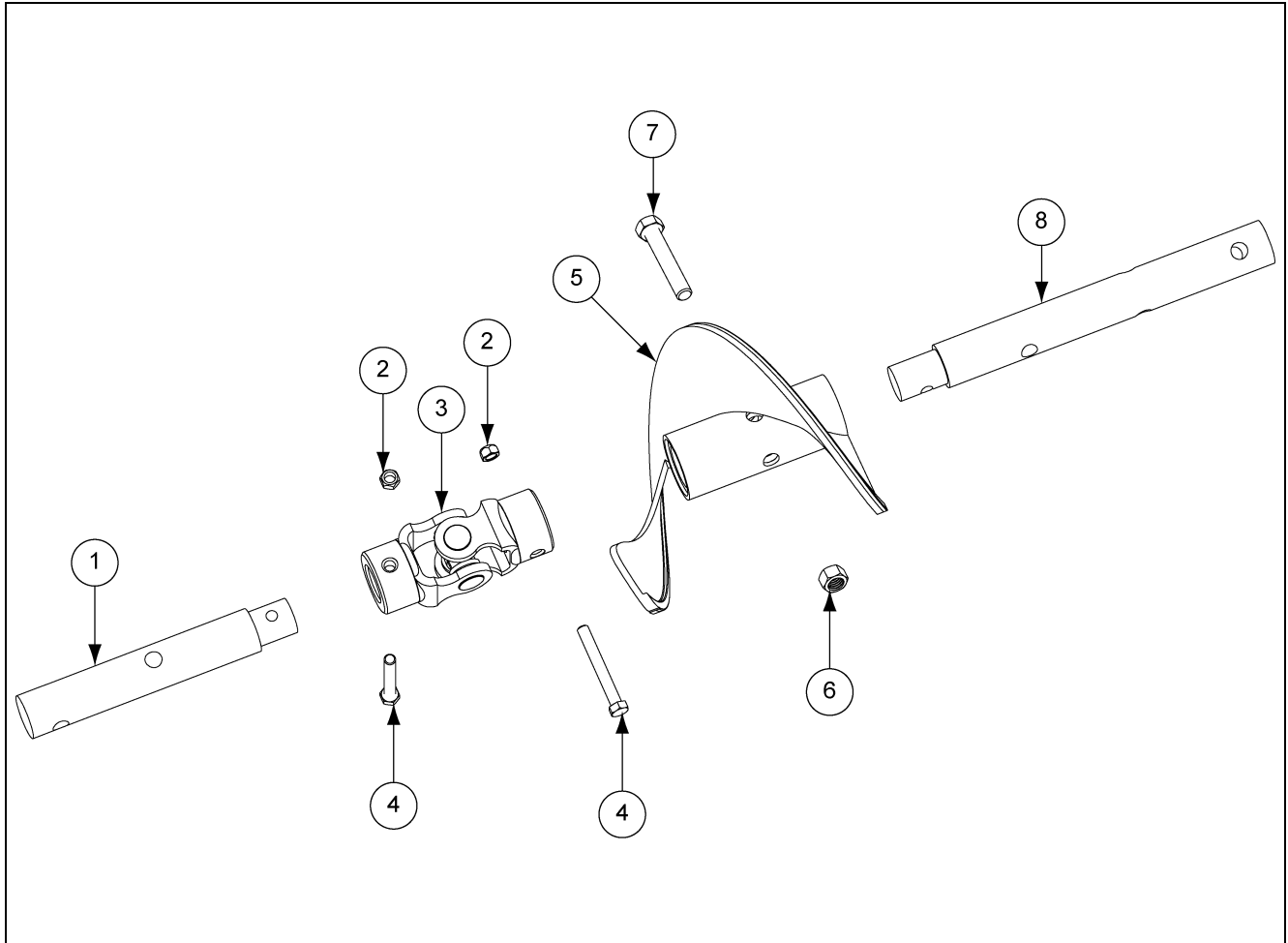
6"-8" Flight Assembly Parts



6"-8" Flight Assembly Parts

Ref #	Part #	Description
1	GK4690	Intake Shaft 1":1-1/4" O.D.:1" SQ x 7-5/8" Long
2	S-8324	5/16"-18 Stover Nut Zinc Grade C
3	GK1266	U-Joint 1" Bore x 5" Long
4	S-7076	5/16"-18 x 2-1/2" HHCS Zinc Grade 5
5	GK2253	VAAC 8" Flight x 7-1/4" Long
6	S-8317	7/16"-14 Stover Nut Zinc Grade C
7	S-7013	7/16"-14 x 2-1/2" HHCS Zinc Grade 5
8	GK2254	Discharge Shaft 1":1-1/4" O.D. x 11" Long
9	GK5704	Intake Shaft 1":1-1/4":1" O.D. x 7-9/16" Long
10	GK1264	Intake Shaft 13/16":1-1/4":13/16" O.D. x 5-3/8" Long

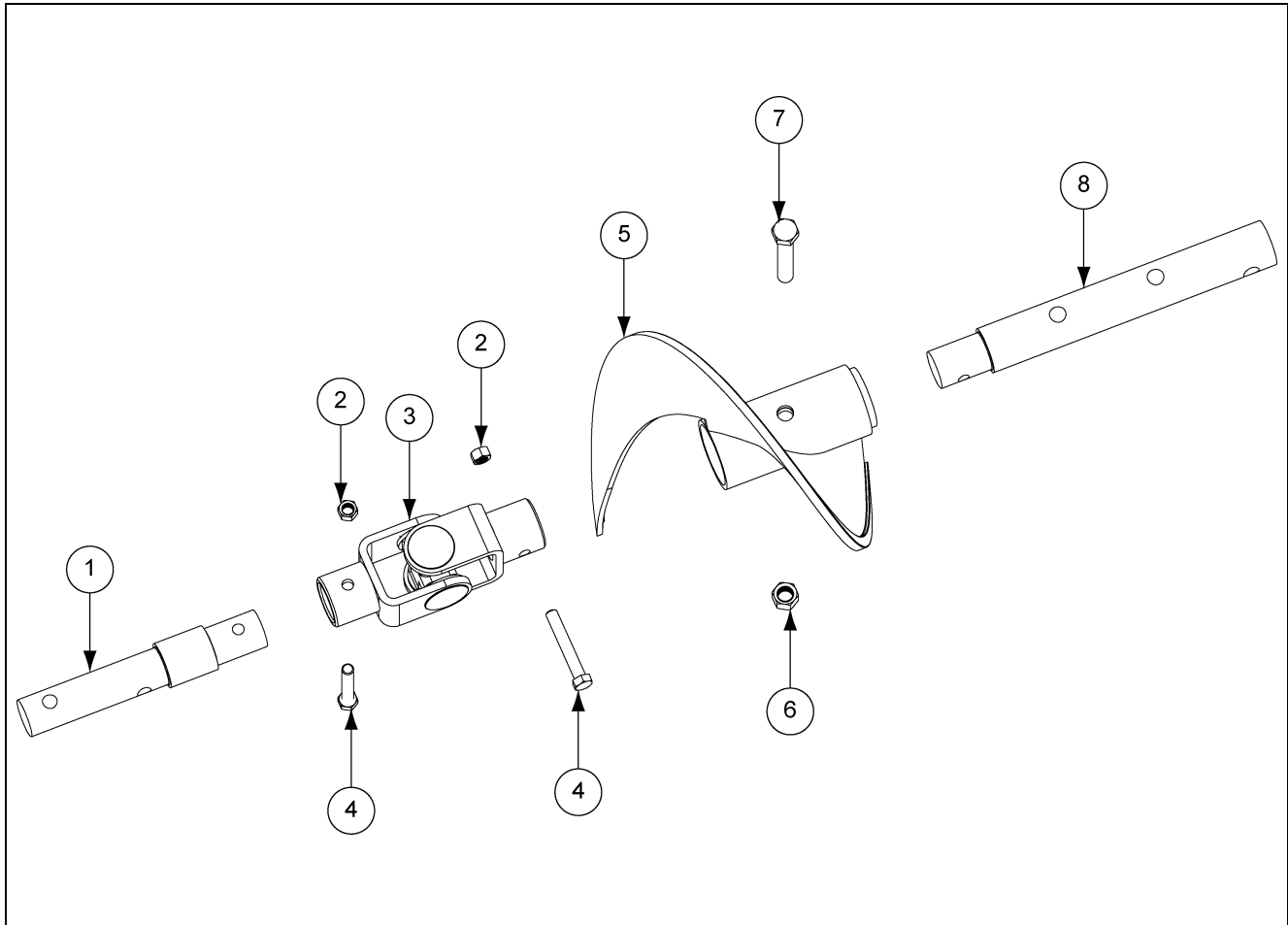
8"-8" Flight Assembly Parts



8"-8" Flight Assembly Parts

Ref #	Part #	Description
1	GK1283	Intake Shaft 1-1/4":1" O.D. x 7-7/8" Long
2	S-8324	5/16"-18 Stover Nut Zinc Grade C
3	GK1266	U-Joint 1" Bore x 5" Long
4	S-7076	5/16"-18 x 2-1/2" HHCS Zinc Grade 5
5	GK2253	VAAC 8" Flight x 7-1/4" Long
6	S-8317	7/16"-14 Stover Nut Zinc Grade C
7	S-7013	7/16"-14 x 2-1/2" HHCS Zinc Grade 5
8	GK2254	Discharge Shaft 1-1/4":1" O.D. x 11" Long

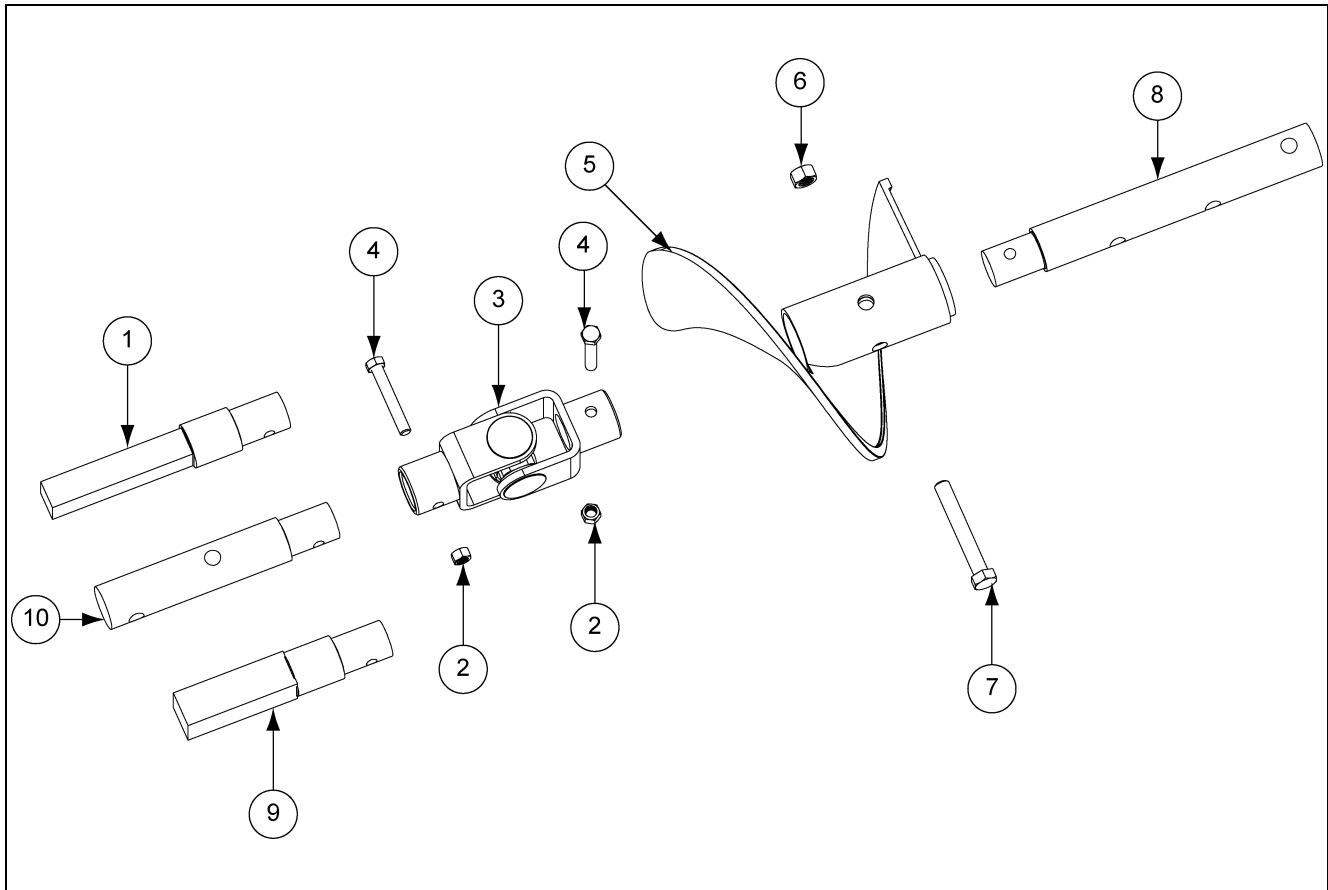
8"-10" Flight Assembly Parts



8"-10" Flight Assembly Parts

Ref #	Part #	Description
1	GK1292	Intake Shaft 1-1/4":1-1/2":1-1/4" O.D. x 8-1/8" Long
2	S-8251	3/8"-16 Stover Nut Zinc Grade C
3	GK1291	U-Joint 1-1/4" Bore x 7" Long
4	S-6762	3/8"-16 x 2-1/2" HHCS Zinc Grade 5
5	GK2261	VAAC 10" Flight x 9" Long
6	S-8315	1/2"-13 Stover Nut Zinc Grade C
7	S-8314	1/2"-13 x 3-1/2" HHCS YDP Grade 8
8	GK2264	Discharge Shaft 1-1/4":1-1/2" O.D. x 11-1/2" Long

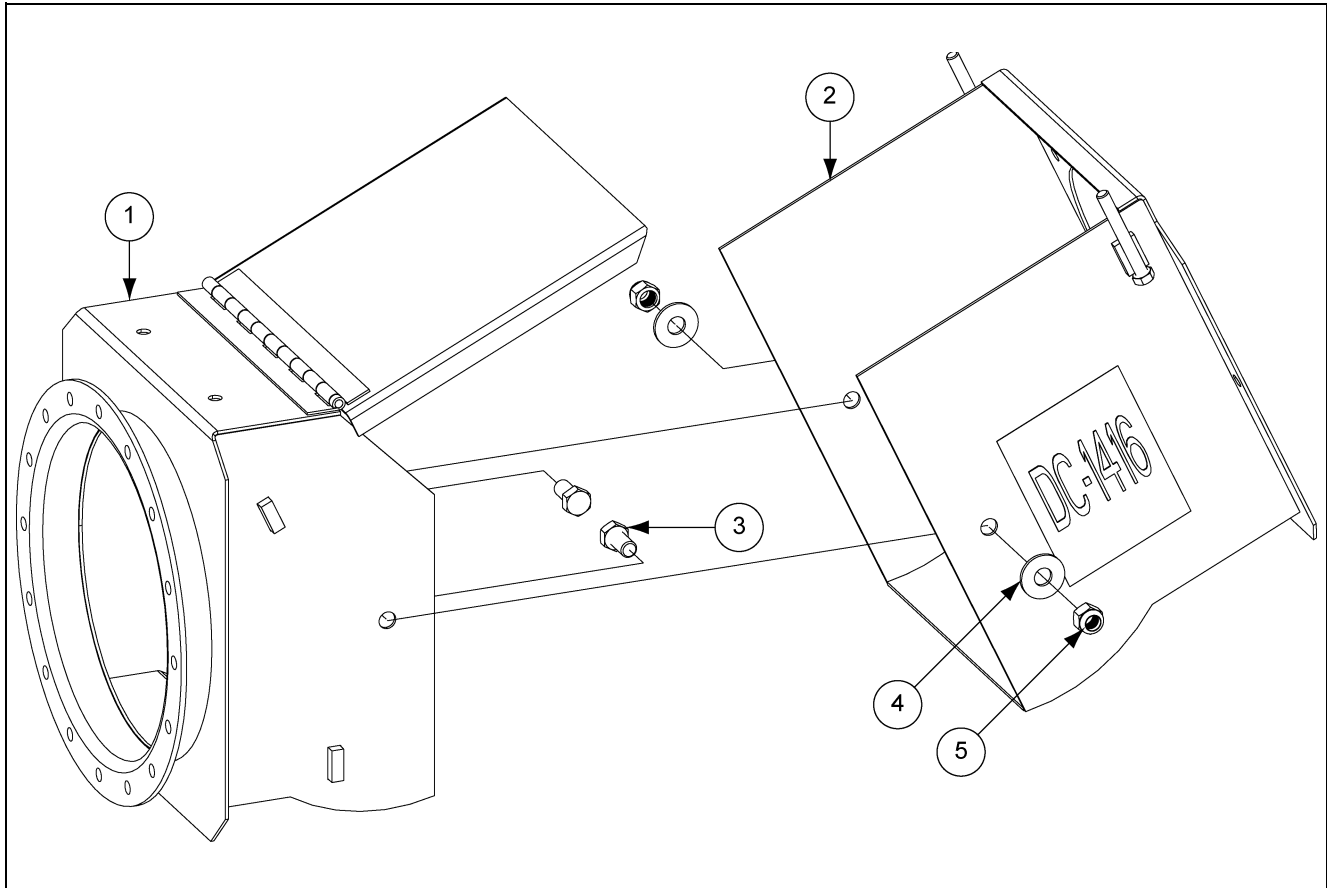
10"-10" Flight Assembly Parts



10"-10" Flight Assembly Parts

Ref #	Part #	Description
1	GK1996	Intake Shaft 1-1/4":1-1/2" O.D.:1" SQ x 8-3/8" Long
2	S-8251	3/8"-16 Stover Nut Zinc Grade C
3	GK1291	U-Joint 1-1/4" Bore x 7" Long
4	S-6762	3/8"-16 x 2-1/2" HHCS Zinc Grade 5
5	GK2261	VAAC 10" Flight x 9" Long
6	S-8315	1/2"-13 Stover Nut Zinc Grade C
7	S-8314	1/2"-13 x 3-1/2" HHCS YDP Grade 8
8	GK2264	Discharge Shaft 1-1/4":1-1/2" O.D. x 11-1/2" Long
9	GK2273	Intake Shaft 1-1/4":1-1/2" O.D.:1-1/4" SQ x 7-1/4" Long
10	GK2263	Intake Shaft 1-1/4":1-1/2" O.D. x 8-1/8"

VAAC Box Parts



VAAC Box Parts

Ref #	Part #	Description	System
1	GC05585	Intake VAAC Box Assembly	6"
	GC03725		8"
	GC05606		10"
2	GC05575	Discharge VAAC Box Assembly	6"
	GC03730		8"
	GC05600		10"
3	S-7935	1/2"-13 x 1" HHCS Zinc Grade 5	ALL
4	S-2121	1/2" Flat Washer Plated	ALL
5	S-8260	1/2"-13 Nylock Nut Zinc Grade 5	ALL

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.

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.

G S I G R O U P



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