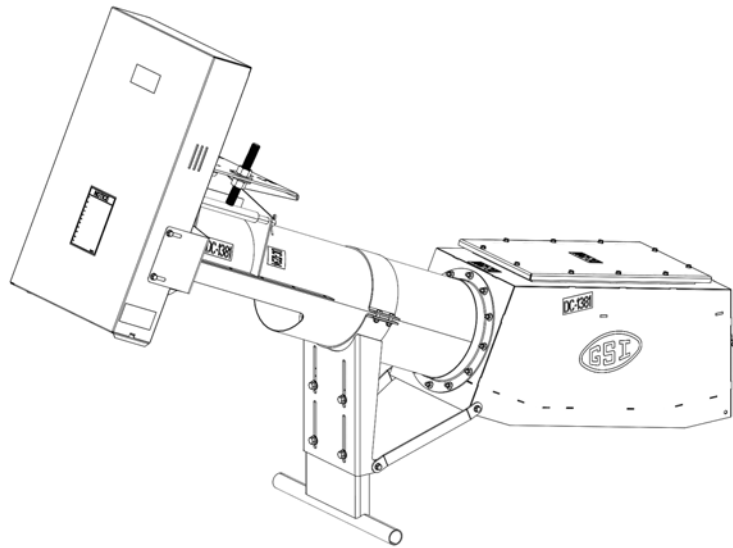




Heavy Duty Drive Unit for 25° Bin Unloader

Models:
8"-10" AND 10"-12"

Assembly and Operation Manual

PNEG-2035

Version 3.0

Date: 03-29-19



PNEG-2035

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

Contents

Chapter 1	Safety Precautions	5
	Safety Guidelines	5
	Cautionary Symbol Definitions.....	6
	Safety Cautions.....	7
	Safety Decals	10
	Safety Sign-off Sheet.....	12
Chapter 2	Assembly	13
	Assembling the Stand Weldments	14
	Attaching the Stand Weldments and the Stand Straps to the Tube	15
	Attaching the Flights	16
	Installing the Motor Mount Adjustment Rod	17
	Installing the Motor Mount Plate	18
	Installing the Belt Guard Mounting Brackets	19
	Installing the Pulley	20
	Installing the Motor (Not Provided).....	21
	Installing the Belts	21
	Installing the Belt Guard.....	22
Chapter 3	Electric Drive Motors	23
Chapter 4	Start-Up.....	25
	Perform Pre-Start Checks	25
	Start the Auger.....	26
Chapter 5	Operation	27
Chapter 6	Shut Down.....	29
	Normal Shut Down	29
	Emergency Shut Down	29
	Storage Preparation	29
Chapter 7	Maintenance.....	31
Chapter 8	Troubleshooting.....	33
Chapter 9	Parts List.....	35
	8" to 10" 25° Bin Unloader Parts	36
	10" to 12" 25° Bin Unloader Parts	38
	Limited Warranty — N.A. Grain Products	41

NOTES

1 Safety Precautions

Topics Covered in this Chapter

- Safety Guidelines
- Cautionary Symbol Definitions
- Safety Cautions
- Safety Decals
- Safety Sign-off Sheet

Safety Guidelines

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

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

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

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

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

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

ST-0001-4

Cautionary Symbol Definitions

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

Table 1-1 *Description of the different cautionary symbols*

Symbol	Description
	This symbol indicates an imminently hazardous situation which, if not avoided, will result in serious injury or death.
	This symbol indicates a potentially hazardous situation which, if not avoided, can result in serious injury or death.
	This symbol indicates a potentially hazardous situation which, if not avoided, can result in minor or moderate injury.
	This symbol is used to address practices not related to personal injury.
	This symbol indicates a general hazard.
	This symbol indicates a prohibited activity.
	This symbol indicates a mandatory action.

ST-0005-2

Safety Cautions

Use Personal Protective Equipment

- Use appropriate personal protective equipment:

Eye Protection



Respiratory Protection



Foot Protection



Hearing Protection



Head Protection



Fall Protection



Hand Protection



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

ST-0004-1

Follow Safety Instructions

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



ST-0002-1

Chapter 1: Safety Precautions

Maintain Equipment and Work Area

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



ST-0003-1

Operate Motor Properly

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



ST-0009-3

Rotating Auger Hazard

- Keep clear of rotating augers and moving parts.
- Do not remove or modify guards or covers.
- Lock-out power source before making adjustments, cleaning, or maintaining equipment.
- Failure to follow these precautions will result in serious injury or death.



ST-0037-1

Stay Clear of Hoisted Equipment

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



ST-0047-1

Stay Clear of Rotating Parts

- Do not enter the bin while the equipment is in operation.
- Entanglement in rotating augers will cause serious injury or death.
- Keep all guards and covers in place at all times.
- Lock-out power source before making adjustments, cleaning, or maintaining equipment.



ST-0008-2

Use Unload Equipment Properly

- Do not operate this equipment alone. Make sure someone nearby is aware of the proper shut down sequence in the event of an emergency.
- Do not allow any person intoxicated or under the influence of drugs to operate this equipment. All operators must be adequately rested and prepared to perform all functions of operating the equipment.
- Do not start equipment until all persons are clear of the work area and safety guards are in place.
- Do not allow anyone inside a bin, truck, or wagon which is being unloaded by an auger. Flowing grain can trap and suffocate in seconds.
- Use ample overhead lighting after sunset to light the work area.
- Always use caution to not hit the auger when positioning the load.
- Do not leave equipment operating while unattended.
- Be aware of pinch points, which can trap or catch objects and cause injury.
- Be sure all equipment is locked in position before operating.
- Always lock out all power sources to the equipment when unloading is finished.



ST-0051-1

Safety Decals

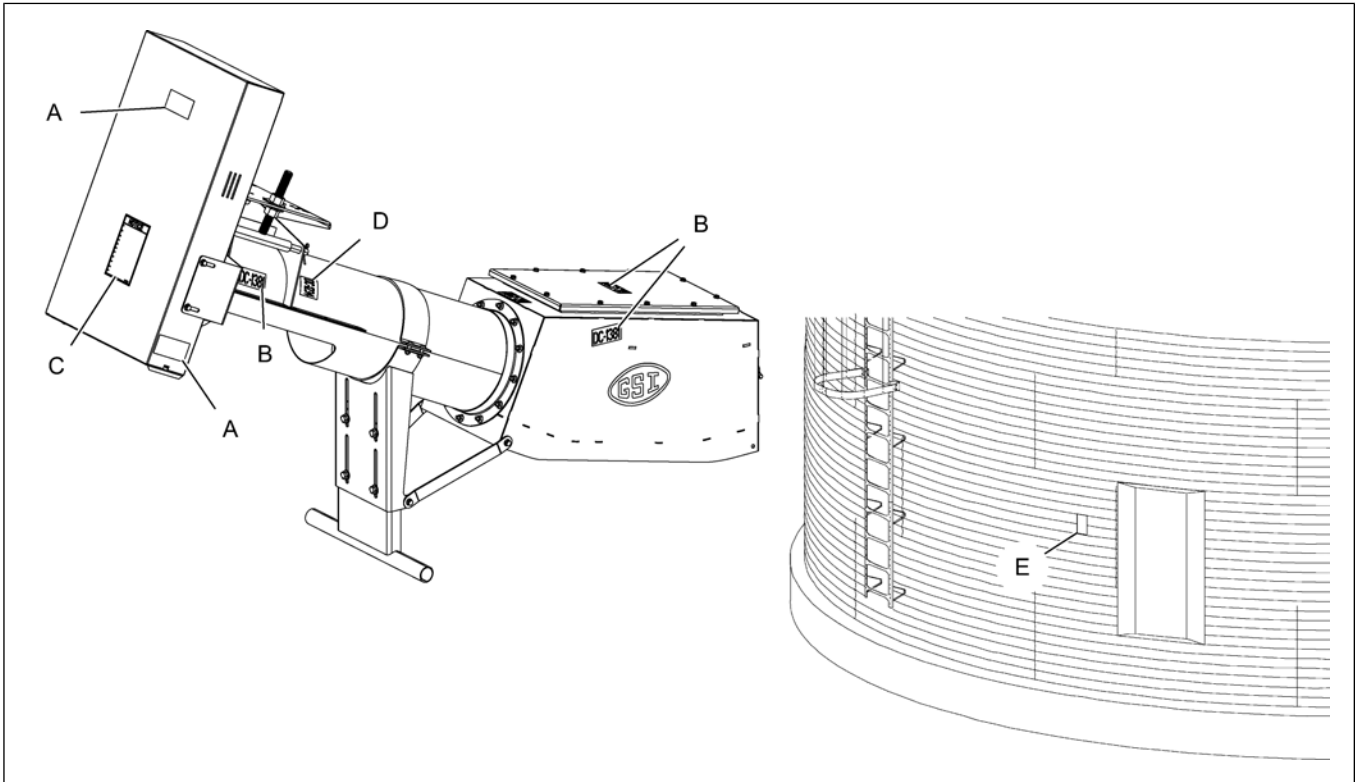
Check components shown below to ensure that the safety decals are in place and in good condition. If a decal cannot be easily read for any reason or has been painted over, replace it immediately. Contact your dealer or the manufacturer to order a replacement decal free of charge.

To replace a damaged or missing decal, contact us to receive a free replacement.

GSI Decals

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

Figure 1-1 Decal locations



Ref #	Location	Decal No.	Decal	Description
A	Front and side of belt guard assembly	DC-994	 ⚠ DANGER SHEAR POINT Keep hands clear of moving parts. Do not operate with guard removed. Disconnect and lockout power before servicing. DC-994	Decal, Danger Shear Point
B	Discharge tube and Unloader assembly	DC-1381	 ⚠ DANGER SHEAR POINT Keep clear of rotating auger and moving parts. Do not remove or modify guards. Disconnect and lock out power before servicing. Failure to do so will result in serious INJURY or DEATH. DC-1381	Decal, Auger Danger

Ref #	Location	Decal No.	Decal	Description
C	Front of belt guard assembly	DC-1379	 NOTICE 1. Read and understand the operator's manual and all safety instructions. 2. Do not operate while under the influence of drugs or alcohol. 3. Do not operate unless all safety equipment, switches, guards, and shields are securely in place and operational. 4. Allow only trained authorized personnel in the operating area. 5. Any electrical wiring or service work must be performed by a qualified electrician. It must meet all state and local electrical codes. 6. Do not allow children in the area of operation. 7. Keep hands, feet, & clothing away from moving parts. 8. Disconnect and lockout power before making any adjustments or performing any service work. 9. Disconnect power prior to resetting any motor overload. 10. Make certain all electric motors are grounded. 11. Replace all worn or damaged labels immediately. GSI Group Inc. 217-226-4421 DC-1379	Decal, Notice
D	Discharge Tube	DC-1234	 NOTICE FAILURE TO PROPERLY SELECT, INSTALL OR MAINTAIN AN AUGER, ITS DRIVE OR OTHER COMPONENTS CAN RESULT IN DANGEROUS OPERATION. THIS EQUIPMENT IF IMPROPERLY SELECTED, INSTALLED OR MAINTAINED MAY FAIL AND COULD RESULT IN SERIOUS INJURY OR PROPERTY DAMAGE. CHECK PRODUCT LITERATURE AND EQUIPMENT MANUFACTURER'S LITERATURE OR CALL THE FACTORY FOR FURTHER INFORMATION. GSI Group 217-226-4421 DC-1234	Decal, Caution
E	Bin sidewall	DC-1395	 ! DANGER ROTATING FLIGHTING This bin is equipped with grain augers which can kill or dismember. Keep clear of all augers and never enter this bin unless all power is disconnected and locked out. FAILURE TO DO SO WILL RESULT IN SERIOUS INJURY OR DEATH. GSI Group Inc. 217-226-4421 DC-1395	Decal, Rotating Flight

Safety Sign-off Sheet

Below is a sign-off sheet that can be used to verify that all personnel have read and understood the safety instructions. This sign-off sheet is provided for your convenience and personal record keeping.

[illegible]

ST-0007

2 Assembly

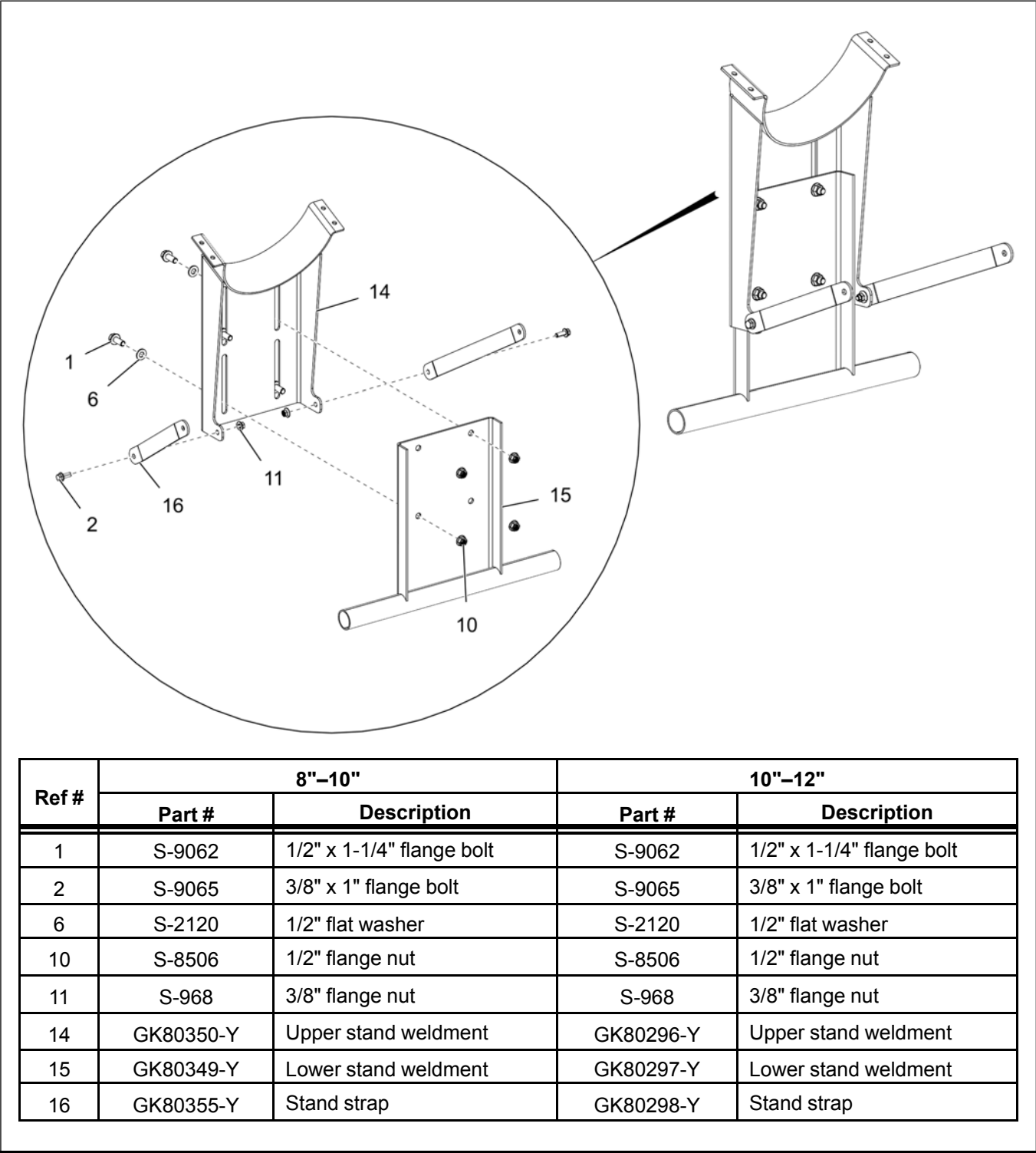
Topics Covered in this Chapter

- Assembling the Stand Weldments
- Attaching the Stand Weldments and the Stand Straps to the Tube
- Attaching the Flights
- Installing the Motor Mount Adjustment Rod
- Installing the Motor Mount Plate
- Installing the Belt Guard Mounting Brackets
- Installing the Pulley
- Installing the Motor (Not Provided)
- Installing the Belts
- Installing the Belt Guard

Assembling the Stand Weldments

- 1. Assemble the lower stand weldment (15) to the upper stand weldment (14) using 1/2" x 1-1/4" flange bolts (1), 1/2" flat washers (6) and 1/2" flange nuts (10).
- 2. Attach the stand straps (16) to the upper stand weldment (14) using 3/8" x 1" flange bolts (2) and 3/8" flange nuts (11).

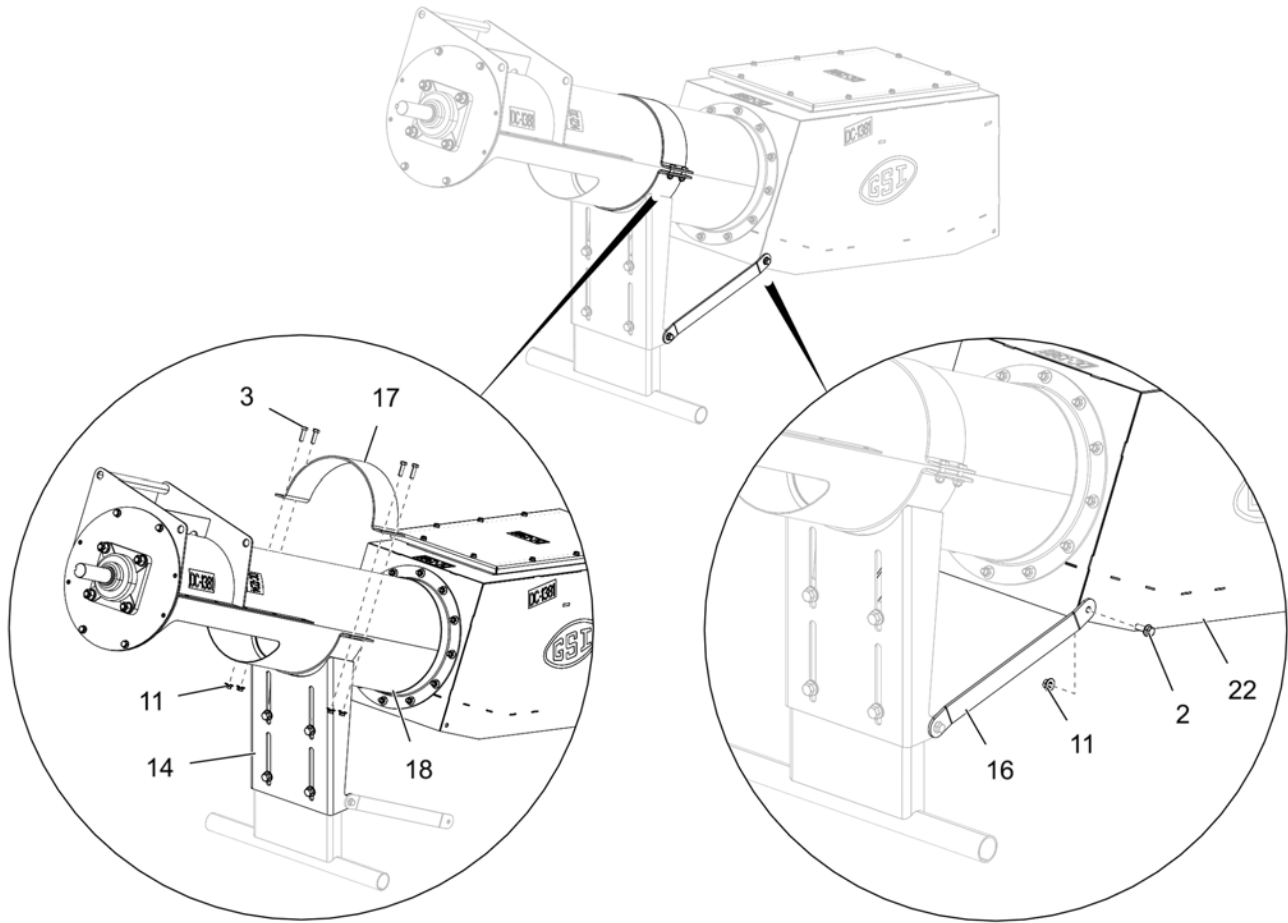
Figure 2-1 Assembling the stand weldments and stand strap



Attaching the Stand Weldments and the Stand Straps to the Tube

1. Place the upper stand weldment (14) and half band (17) around the discharge tube (18) and secure together using 3/8" flange bolts (3) and 3/8" flange nuts (11).
2. Connect the stand strap (16) installed with the upper stand weldment (14) to the unloader assembly (22) using 3/8" x 1" flange bolts (2) and 3/8" flange nuts (11).

Figure 2-2 Attaching the stand weldments and the stand straps

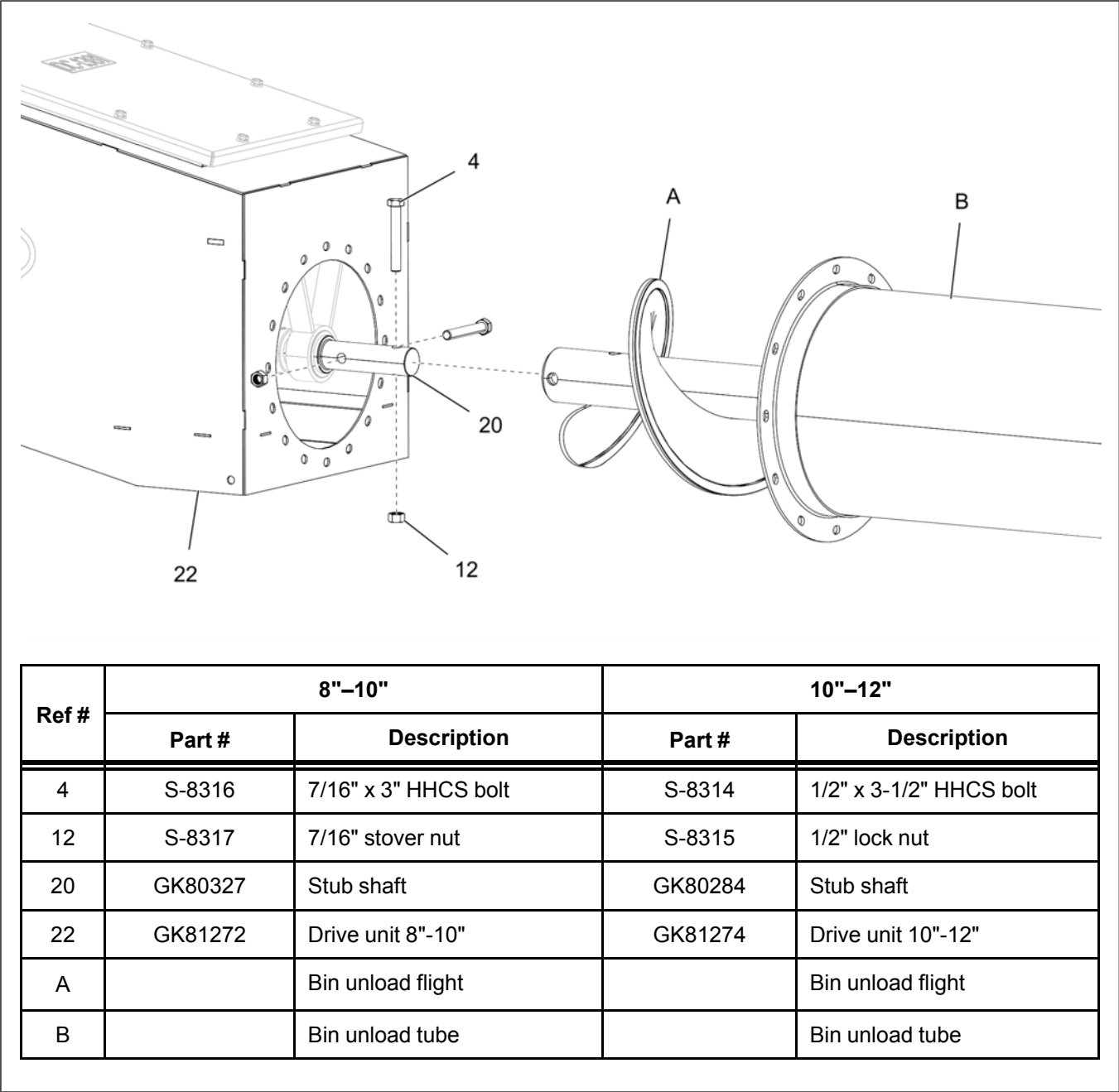


Ref #	8"-10"		10"-12"	
	Part #	Description	Part #	Description
2	S-9065	3/8" x 1" flange bolt	S-9065	3/8" x 1" flange bolt
3	S-2086	3/8" x 1-1/2" flange bolt	S-2071	3/8" x 1-1/4" flange bolt
11	S-968	3/8" flange nut	S-968	3/8" flange nut
14	GK80350-Y	Upper stand weldment	GK80296-Y	Upper stand weldment
16	GK80355-Y	Stand strap	GK80298-Y	Stand strap
17	GK5117-Y	Half Band 10" x 4"	GC08690-Y	Half band 12" x 4"
18	GK6998-18	Discharge tube 10"	GK6999-18	Discharge tube 12"
22	GK81272	Drive unit 8"-10"	GK81274	Drive unit 10"-12"

Attaching the Flights

- 1. Pull the bin unload flight (A) out of the bin unload tube (B) approximately by 1'.
- 2. Remove the bolts (4) and nuts (12) from the stub shaft (20) connected to the bearing.
- 3. Position the 25° unloader assembly (22) in-line with bin unload tube (B).
- 4. Align the holes of the bin unload flight (A) with the holes in the stub shaft (20) and slide the bin unload flight (A) onto the stub shaft (20).
- 5. With holes properly aligned, secure the bin unload flight (A) to the stub shaft (20) using bolts (4) and nuts (12) that were removed in step 2.

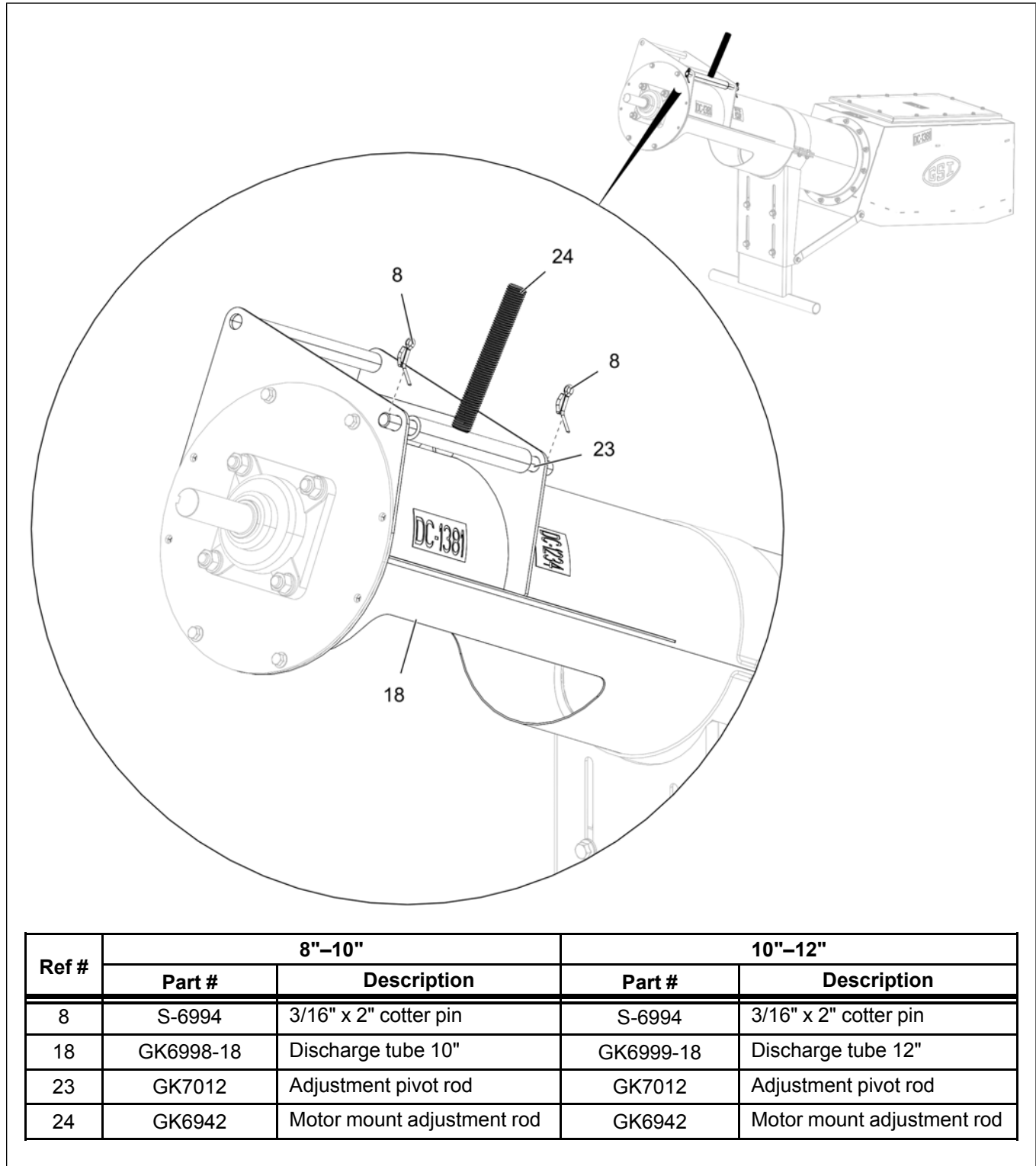
Figure 2-3 Attaching the flights



Installing the Motor Mount Adjustment Rod

1. Place the motor mount adjustment rod (24) between the welded plates of the discharge tube (18).
2. Insert the adjustment pivot rod (23) through the welded plates and motor mount adjustment rod (24). Secure the adjustment pivot rod (23) using two 3/16" x 2" cotter pins (8).

Figure 2-4 *Installing the motor mount adjustment rod*



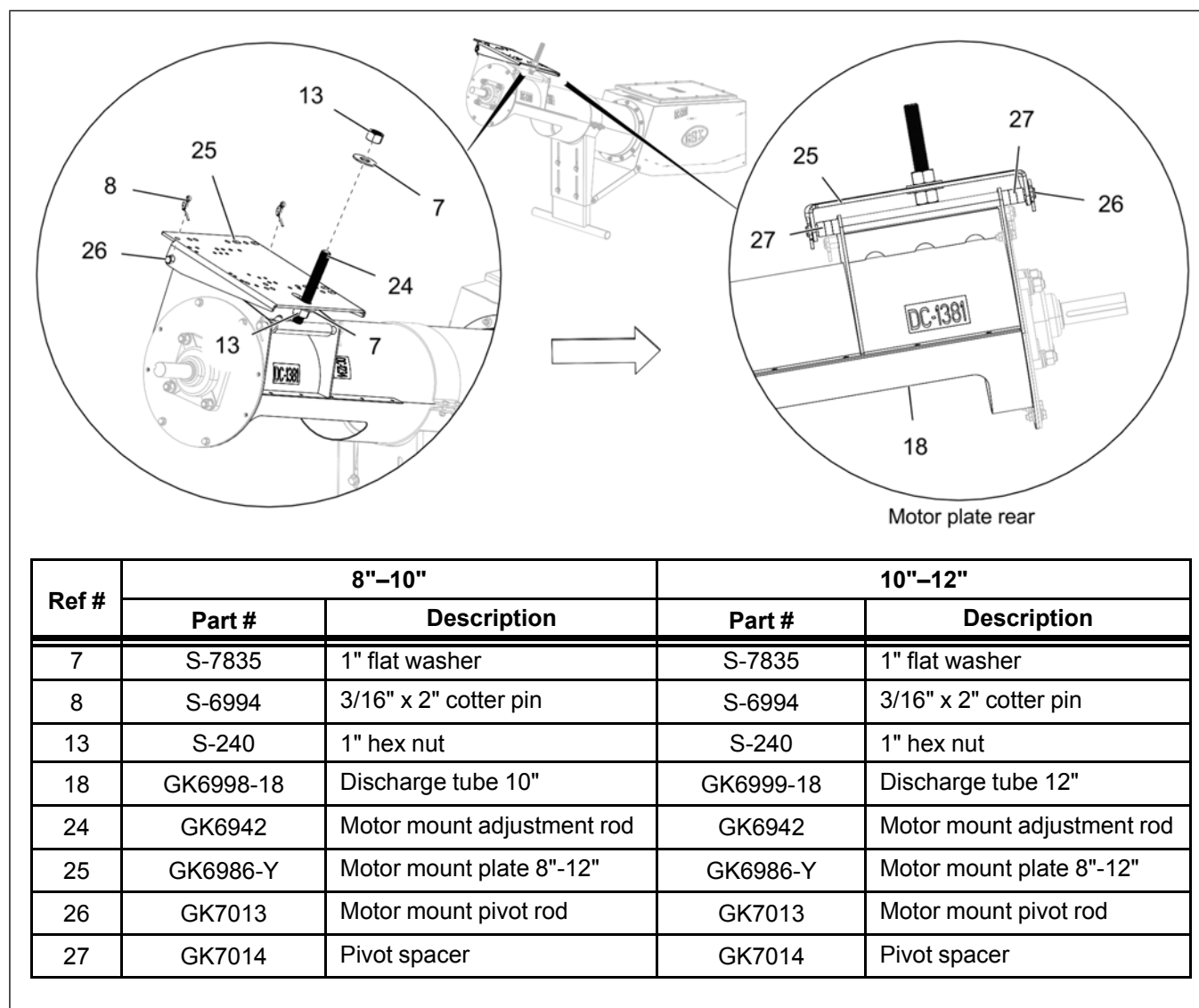
Installing the Motor Mount Plate

1. Install one 1" hex nut (13) and one 1" flat washer (7) approximately 3/4" of the way down the threaded stud of the motor mount adjustment rod (24).
2. Once the 1" hex nut (13) and 1" flat washer (7) are installed, slip the motor mount plate (25) over the motor mount adjustment rod (24) and align the pivot holes of the motor mount plate (25) with the welded pivot tube.
3. Insert the motor mount pivot rod (26) through the motor mount plate (25) and pivot tube welded with the discharge tube (18).
4. Add spacers (27) to both sides of the motor mount pivot rod (26) between the inner face of the motor mount plate (25) and welded plates of the discharge tube (18).

NOTE: The number of spacers (27) will vary depending on the size of the unloader.

5. Secure the motor mount plate (25) to the motor mount adjustment rod (24) using 1" flat washer (7) and 1" hex nut (13). Also, secure the motor mount pivot rod (26) with two 3/16" x 2" cotter pins (8).

Figure 2-5 Installing the motor mount plate

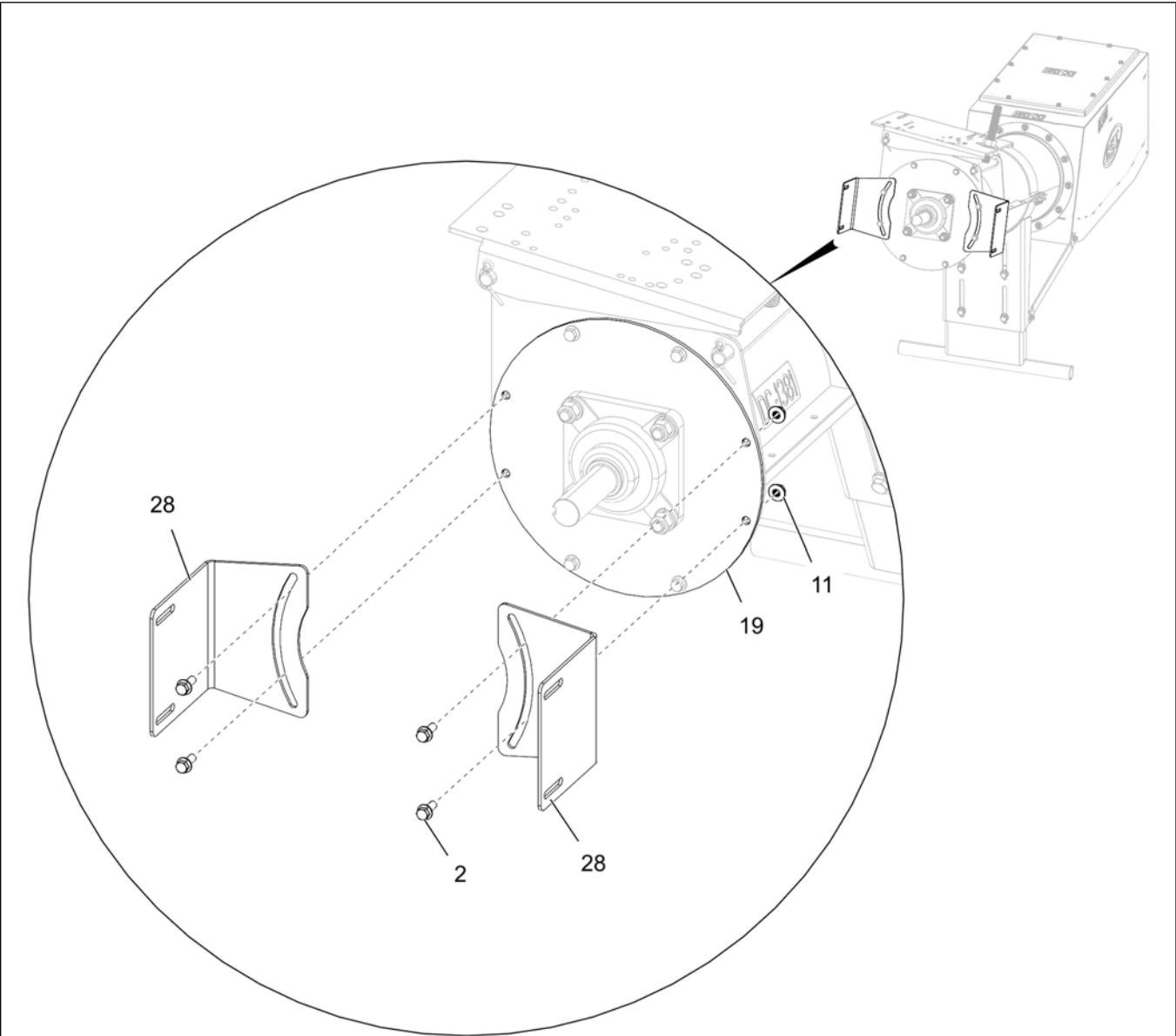


Installing the Belt Guard Mounting Brackets

Align the slots of the belt guard mounting brackets (28) with the holes in the bearing plate (19) and secure using 3/8" x 1" flange bolts (2) and 3/8" flange nuts (11).

NOTE: Do not tighten the bolts (2). The belt guard mounting brackets (28) will need to be rotated to align the slot in the belt guard with the shafts on the motor and flight.

Figure 2-6 Installing the belt guard brackets



Ref #	8"-10"		10"-12"	
	Part #	Description	Part #	Description
2	S-9065	3/8" x 1" flange bolt	S-9065	3/8" x 1" flange bolt
11	S-968	3/8" flange nut	S-968	3/8" flange nut
19	GK7017-BS	Bearing plate 10"	GK7064-BS	Bearing plate 12"
28	GK7018	Belt guard bracket 10" x 15"	GK7065	Belt guard bracket 12" x 19"

Installing the Pulley

1. For a 10" drive unit: Slide the pulley (29) along with the key (9) onto the drive shaft (21) with the set screw holes of the pulley (29) facing away from the bearing plate.

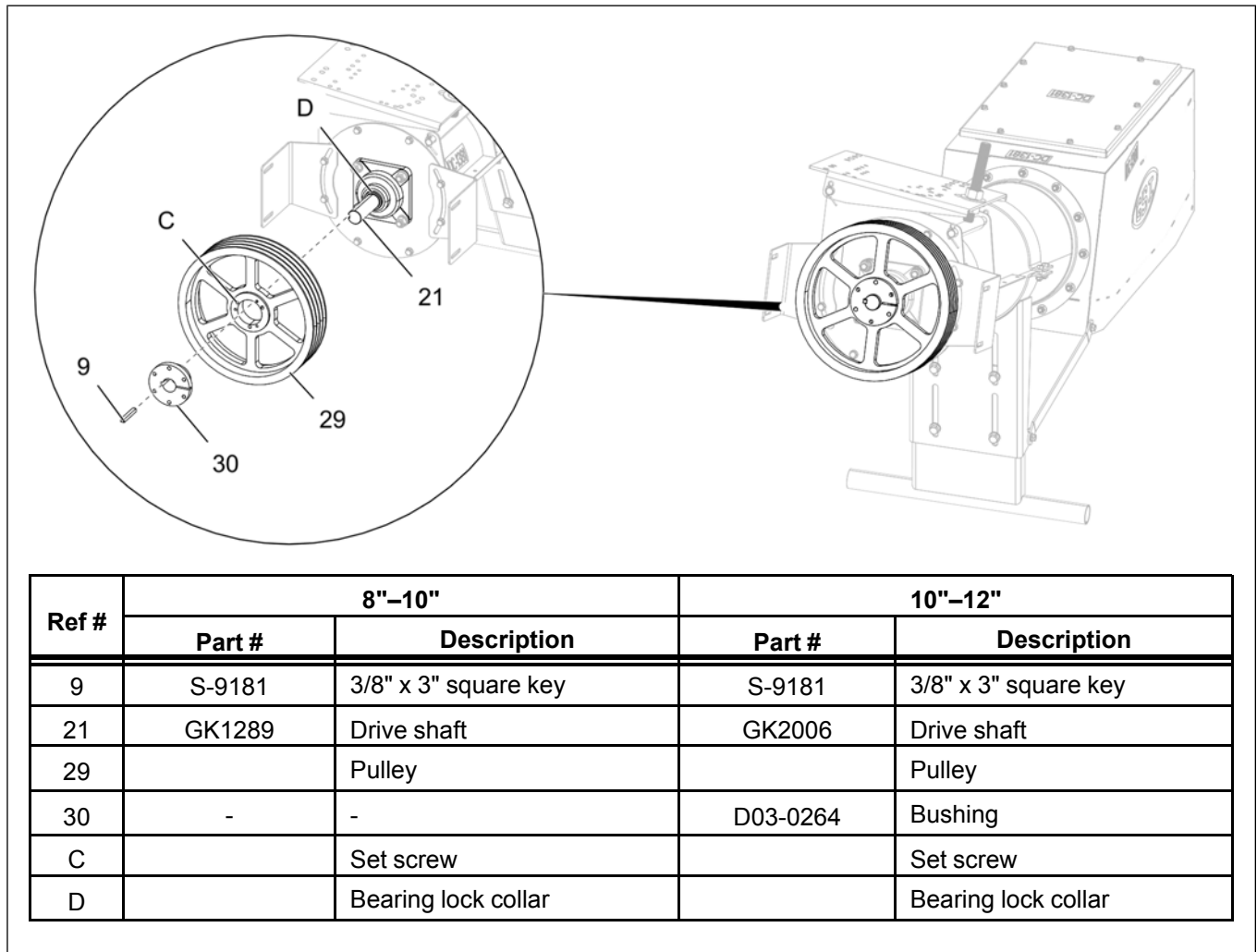
NOTE: Slide the pulley (29) as close as possible to the bearing lock collar (D), but without touching it.

2. For a 12" drive unit: Slide the pulley (29) and the bushing (30) along with the key (9) onto the drive shaft (21) with the set screw side of the pulley (29) facing away from the bearing plate.

NOTE: Slide the pulley (29) as close as possible to the bearing lock collar (D), but without touching it.

3. Secure the pulley (29) to the drive shaft (21) by tightening the set screw (C).

Figure 2-7 Installing the pulley and bushing



4. Use a punch and hammer to drive the lock collar (D) clockwise or in the same direction as the shaft rotation (clockwise rotation). Once the lock collar is set in place, tighten the set screws of the lock collar (D).

NOTE: If the lock collar (D) is not turned far enough, the set screw will not lock it into place.

Installing the Motor (Not Provided)

1. Install the motor to the motor mount plate (25) using the appropriate bolts, washers and nuts.
2. Install the motor pulley onto the motor shaft and make sure it is aligned with the flight pulley (29).

NOTE: It may be necessary to move the spacers (27) for aligning the motor pulley with the unload pulley (29).

Figure 2-8 Installing the motor

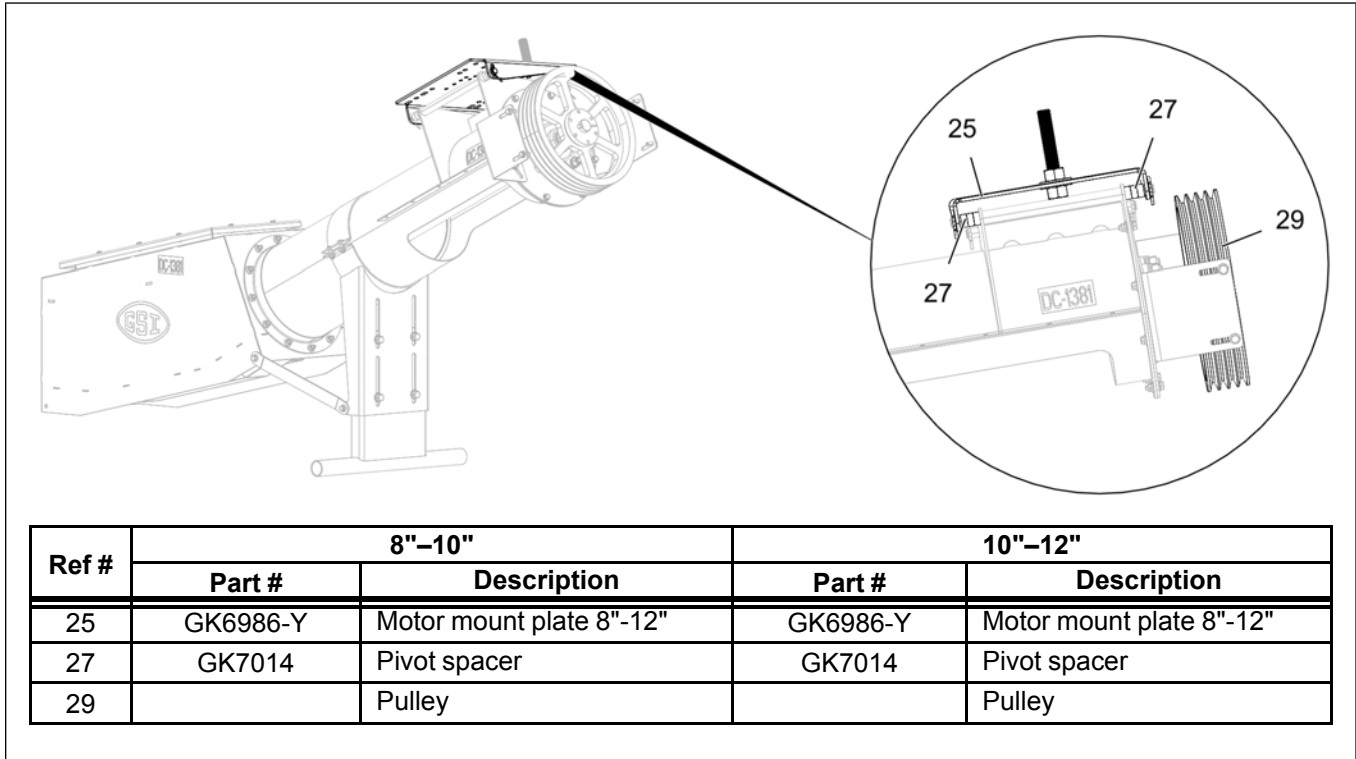


Table 2-1 Motor bolt chart

Motor Size	Hex Bolt Size	Qty
56	5/16" x 1-1/4"	4
143T		
145T		
182T	3/8" x 1-1/4"	4
184T		
213T		
215T		
254T		
256T	1/2" x 1-3/4"	4

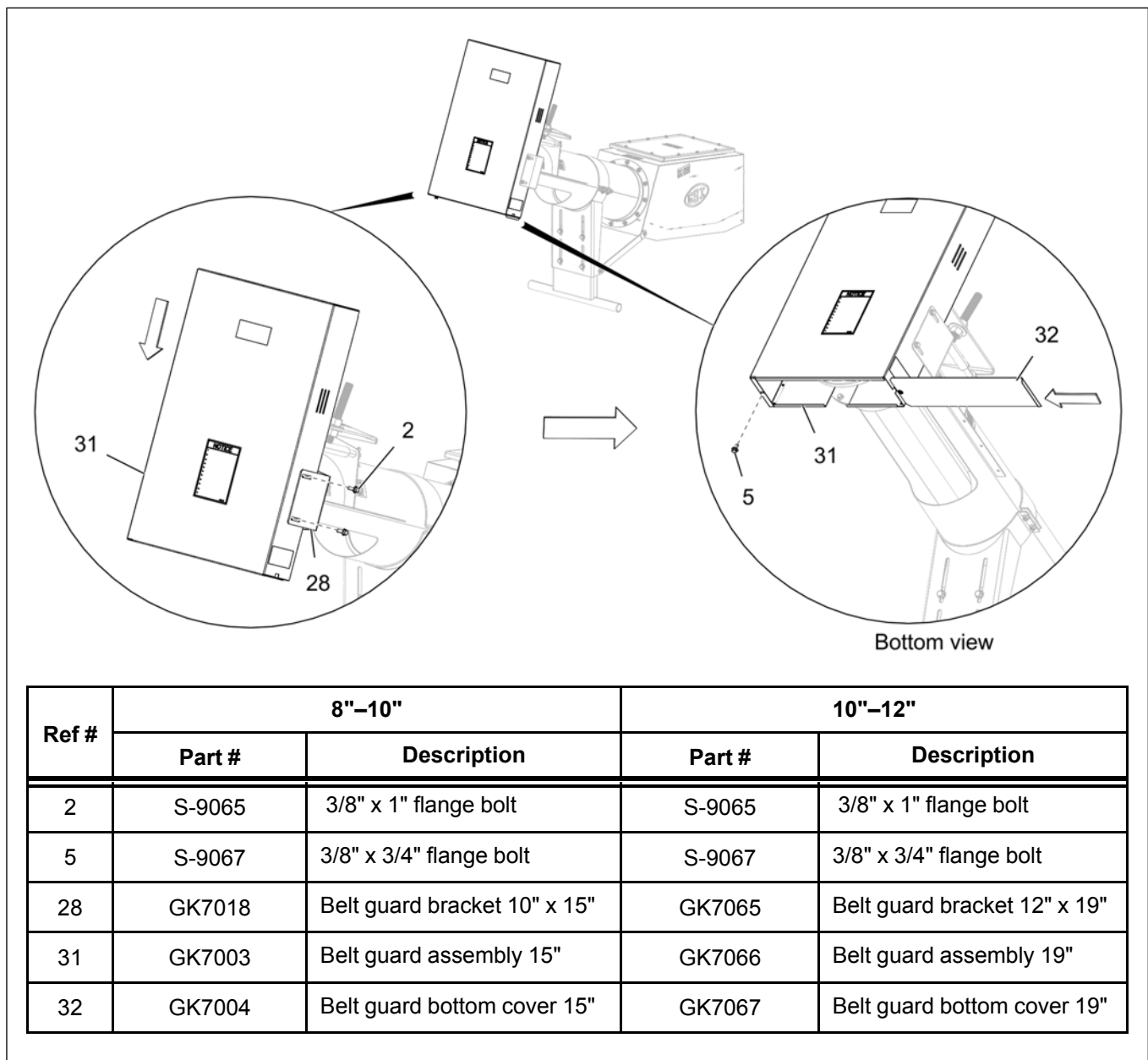
Installing the Belts

1. Place the belts on the pulleys.
2. Adjust the 1" nut (13) below the motor mount plate (25), thereby raising the motor mount plate (25) and putting tension on the belts. Refer to [Installing the Motor Mount Plate, page 18](#).
3. After achieving the desired tension, secure the motor mount plate (25) in position by tightening the 1" nut (13) on top of the motor mount plate (25).

Installing the Belt Guard

1. After the belts are properly tensioned, remove the bottom belt guard cover (32) and slip the belt guard assembly (31) down, over the motor shaft.
2. Install the belt guard assembly (31) to the belt guard mounting brackets (28) using 3/8" x 1" flange bolts (2). Do not tighten the belt guard mounting brackets (28) to the bearing plate.
3. Align the slot of the belt guard assembly (31) with the motor shaft and flight drive shaft, making sure that the belt guard assembly DOES NOT contact with either the pulleys or the shafts and tighten the belt guard mounting brackets (28) to the bearing plate.
4. Once the brackets are tightened, slide the bottom belt guard cover (32) back into the belt guard assembly (31) and install using 3/8" x 3/4" flange bolt (5).

Figure 2-9 *Installing the belt guard*



3 Electric Drive Motors



Electrical controls and wiring should be installed by a qualified electrician. The motor disconnect switches and conductor cables should comply with the National Electrical Code and any local codes which apply. Reset and motor starting stations should be located so that the operator can see that all personnel are clear of the equipment.

1. Knowing the bin size and the length of flighting to be used in the unloading tube is necessary to determine how much horsepower is required for the job.
2. Use the chart below to determine the size of motor required. Use a larger motor when encountering high moisture or when high capacity is required.

25° Horse-power	Grain Bin Diameter									
	15'	18'	21'	24'	27'	30'	33'	36'	42'	48'
8"-10"	3	3	5	5	5	7-1/2	7-1/2	7-1/2	7-1/2	7-1/2
10"-12"	-	-	-	5	5	7-1/2	7-1/2	7-1/2	10	10

NOTE: For high capacity or high moisture, use one size larger motor.

LONGER BELT NOTE: Longer belts may be required when using larger framed motors due to high capacity or high moisture applications.

3. The following horsepower recommendations are for augering relatively dry grain. Use an electric motor of the proper size that operates at 1750 RPM. Motor pulleys are not furnished with the auger.
4. A magnetic starter should be used for the operator's protection and for the protection of the motor. This helps to protect the operator against accidental re-start caused by power interruption, conductor fault, low voltage, circuit interruption or motor overload. Therefore, the motor must be restarted manually. If using a motor with built-in thermal overload protection, make sure this type of motor has a manual reset.



Disconnect and lock out power before resetting motor overloads. Make certain electric motors are grounded.

NOTES

4 Start-Up

Topics Covered in this Chapter

- Perform Pre-Start Checks
- Start the Auger

Perform Pre-Start Checks



Failure to perform any or all of these pre-start checks may cause damage to the equipment and/or cause serious injury or death to those in the work area.

Failure to perform any or all of these pre-start checks may also be a misuse of the equipment. Any misuse of the equipment may void the warranty.

1. Make sure all belts are tensioned properly.
2. Make sure all shields are in place and that the belt(s) and pulley(s) are able to move freely.
3. Inspect the drive unit for any problems or potential problems.
4. Be aware of any emergency shut down procedures. Two people must always be in a position where the operation of the equipment can be monitored.
5. Before starting the auger for the first time, make sure that all parts are assembled correctly according to the instructions in this manual.



Always keep all guards and shields in place, until all the power is disconnected and locked out.



Make certain only trained operators are in the work area before operating or moving the machine. Two people must always be in a position where the operation of the equipment can be monitored.

Start the Auger

1. Start the auger.



DO NOT start or stop the auger while it is under load. Doing so may cause the auger to jam.

2. Run the auger through a “break-in” period if it is being used for the first time or for the first time of the season.
3. Polish the flighting by running the auger at partial capacity until it is smooth, before attempting to run it at full capacity.



Failures may occur if the auger is run full before it has been “polished” during the “break-in” period.



NEVER operate the auger empty. Operating augers empty for any length of time will cause excessive wear.

NEVER operate the auger at speeds higher than recommended. Auger flight speed in excess of recommended speed causes excessive wear.



Be aware of any unusual vibration or noises during the initial start-up and “break-in” period. If anything unusual is detected, immediately shut down the auger and disconnect and lock out the power supply before servicing.

5 Operation

NOTE: *The auger capacity can fluctuate greatly under varying conditions. Moisture content, different commodities, amount of foreign matter and speeds all play a part in the performance of the auger. For example, 25% moisture may cut capacity by as much as 40% under some conditions.*

1. Make certain there are at least two people in the work area to monitor operations at all times.
2. Visually inspect the auger periodically during operation.



Be alert for any unusual vibrations, noises and the loosening of any fasteners. If anything unusual is detected, immediately shut down the auger, disconnect and lock out the power source before servicing.

3. Consideration should be given to the proper size auger for a batch drying or any intermittent type operations. When augers are stopped and re-started under full load, it may result in damage to the auger. Using a larger diameter auger and reducing its load level is generally preferable to subjecting a smaller diameter auger to big loads. If an auger is kept from absolute filling, it will make start-up easier and it will convey more efficiently.

NOTES

6 Shut Down

Topics Covered in this Chapter

- Normal Shut Down
- Emergency Shut Down
- Storage Preparation

Normal Shut Down

1. Before shutting down the unit, be sure the hoppers and augers are empty.
2. Disconnect and lock out the power source before leaving the work area.

Emergency Shut Down

1. Know how to shut down the auger in case of an emergency.
2. DO NOT re-start the auger when it is under load.
3. Close the bin well control gates.
4. Re-connect and unlock the power source.
5. Clear the auger gradually until there is no grain and there are no obstructions.



NEVER start the equipment under load. Doing so may cause damage. This type of damage is considered a misuse of the equipment. Any misuse of the equipment may void the warranty.

Storage Preparation

1. Close all wells to the discharge auger.
2. Be sure the unload tube is empty.
3. Shut down the auger.
4. Make sure all fasteners are tight.

NOTES

7 Maintenance



Always shut down and disconnect the power supply before adjusting, servicing or cleaning the equipment.

1. Use caution when repairing or replacing equipment parts.
2. Make sure all decals are legible and tightly attached to the auger. If necessary, replace them FREE OF CHARGE by contacting your dealer or the manufacturer.
3. Ensure that all electric motors, etc., are operating at the proper speed.
4. Maintain proper adjustments on the belt(s).
5. Mount controls for any electric motors at a safe distance from the machine and in a location accessible in case of an emergency.
6. Make sure all electrical wiring is not damaged and that it meets proper wiring codes.
7. Make sure all components are in good working condition before use.
8. Check the auger flighting to make sure it is in good working condition.
9. Check the internal bearing bracket, bearing and universal joint to make sure they are in good working condition.
10. Grease bearing at least two times each season.

NOTES

8 Troubleshooting

Problem	Possible Cause	Solution
Auger vibration	1. Drive belt may be overtightened, putting head stub and flight in a bind. 2. Damage can occur to the auger flighting, thus causing noise. 3. Damage usually is caused from foreign material having been run through the auger.	1. It may be necessary to remove the flighting for inspection. 2. Adjust the drive belt to the proper tension.
Low capacity	The auger may not be getting enough grain.	Check that the intake has not bridged over, restricting flow. The exposed flighting at the auger intake should be covered with grain to achieve maximum capacity.
	The auger is moving too slowly.	Check the auger speed. Speeds slower than the recommended speed will result in low capacity.
Auger plugs	The auger may be getting too much grain, causing "jamming" inside the housing.	Decrease the amount of grain the auger is gathering.
	The motor may be too small or wired improperly.	If the motor is a newer lightweight aluminum type, the next larger size should be considered.
	The grain may be wet.	If wet grain or other hard-to-move material is being augured, use a larger size motor than recommended for normal use.
	The auger may be jammed with foreign material.	Be sure there is no foreign material in the auger such as sacks, tarp corners, etc.
	The discharge end may be plugged.	Make sure the discharge end of the auger is not plugged. A plug of the discharge end will cause an auger plug.

NOTES

9 Parts List

Topics Covered in this Chapter

- 8" to 10" 25° Bin Unloader Parts
- 10" to 12" 25° Bin Unloader Parts

8" to 10" 25° Bin Unloader Parts

Figure 9-1 8" to 10" 25° bin unloader parts

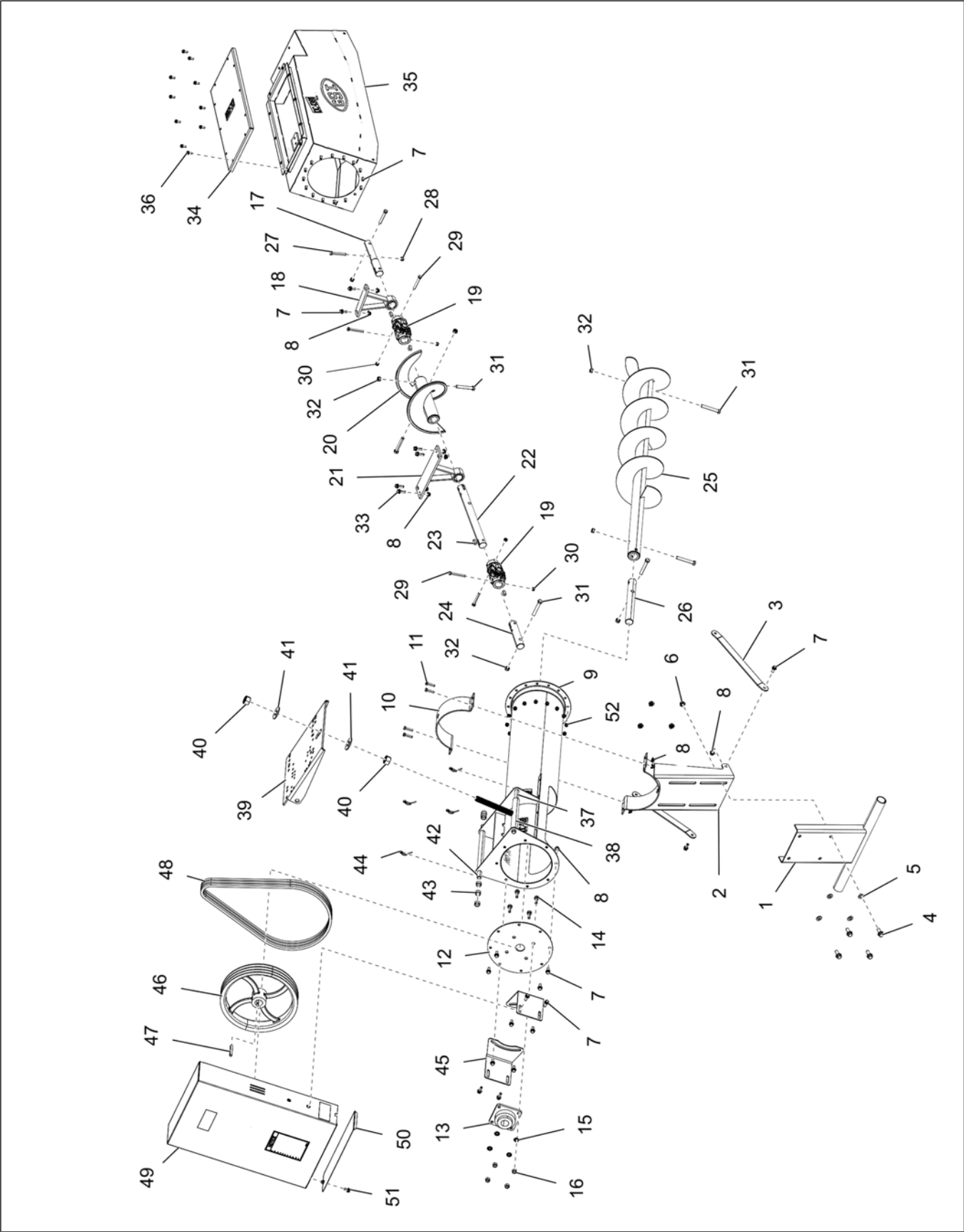


Table 9-1 8" to 10" 25° bin unloader parts list

Ref #	Part #	Description	Ref #	Part #	Description
1	GK80349-Y	Drive Unit: HD 8"-10" 25° Stand Lower Weldment	29	S-8677	Bolt, HHCS 3/8"-16 x 3" YDP Grade 8
2	GK80350-Y	Drive Unit: HD 8"-10" 25° Stand Upper Weldment	30	S-8251	Nut, Stover 3/8"-16 ZN Grade C
3	GK80355-Y	Drive Unit: Common 10"-12" 25° Stand Strap	31	S-8314	Bolt, HHCS 1/2"-13 x 3-1/2" YDP Grade 8
4	S-9062	Bolt, Flange 1/2"-13 x 1-1/4" ZN Grade 5	32	S-8315	Nut, Lock 1/2"-13 ZN Grade C Prevailing Torque
5	S-2120	Washer, Flat 1/2" SAE ZN	33	S-9066	Bolt, Flange 3/8"-16 x 1-1/4" ZN Grade 5
6	S-8506	Nut, Flange 1/2"-13 ZN	34	GK80334	Drive Unit: HD 8"-10" 25° Box Cover Assembly
7	S-9065	Bolt, Flange 3/8"-16 x 1" ZN Grade 5	35	GK81272	Drive Unit: HD 8"-10" 25° Box Assembly
8	S-968	Nut, Flange 3/8"-16 ZN Grade 5 Wide Flange	36	S-6606	Bolt, Flange 5/16"-18 x 3/4" ZN Clear Grade 5
9	GK6998-18	Tube: 10" Horizontal Assembly	37	GK7012	Motor Mount: Adjustment Pivot Rod 8"
10	GK5117-Y	Band: Half 10" x 4" 7 Gauge Ochre	38	GK6942	Motor Mount: Adjustment Rod Weldment 8"
11	S-2086	Bolt, HHCS 3/8"-16 x 1-1/2" ZN Grade 8	39	GK6986-Y	Motor Plate: 8"-12"
12	GK7017-BS	Bearing Plate: 10" Horizontal - Bin Silver	40	S-240	Nut, Hex 1"-8 ZN Grade 5
13	GK1343	Bearing, Light Duty 1.50" Bore with Locking Collar	41	S-7835	Washer, Flat 1" ID USS Washer, Low Carbon
14	S-8760	Bolt, HHTB 1/2"-13 x 1-1/2" ZN Grade 5	42	GK7013	Motor Mount: Plate Pivot Rod 8"
15	S-236	Washer, Lock Split, 1/2" Reg Zinc Plated	43	GK7014	Drive Unit: Pivot Spacer Tube
16	S-3729	Nut, Hex 1/2"-13 YDP Grade 5	44	S-6994	Pin, Cotter 3/16" x 2" ZN Grade 2
17	GK80327	Drive Unit: HD 8"-10" 25° Lower Shaft	45	GK7018	Belt Guard: 10" x 15" Mount Bracket
18	GK81187	Drive Unit: HD 8"-10" 25° Lower Bearing Hanger Assembly	46	GK1304	Sheave, 3 Groove, B Belt, 1.5" B, 15" O.D.
19	GK80285	U-Joint, 12E 1.5" Bore 5.75" Long		GK1345	Sheave, 2 Groove, B Belt, 1.5" B, 15" O.D.
20	GK80351	Drive Unit: HD 8"-10" 25° Lower Flight Weldment	47	S-9181	Key, Square 3/8" x 3"
21	GK81193	Drive Unit: HD 8"-10" 25° Bearing Hanger Assembly	48	MHC01253	Belt, V B x 62
22	GK80326	Drive Unit: HD 8"-10" 25° Lower Flight Shaft		MHC00028	Belt, V B x 60
23	GC03540	Key, 3/8" x 3/8" x 1"		GK1346	Belt, V B57
24	GK80325	Drive Unit: HD 8"-10" 25° Upper Flight Shaft	49	GK7003	Belt Guard: 15" Top Assembly
25	GK80352	Drive Unit: HD 8"-10" 25° Upper Flight Weldment	50	GK7004	Belt Guard: 15" Bottom Assembly
26	GK1289	Shaft: Drive 1.50" OD x 12.5"	51	S-9067	Bolt, Flange 3/8"-16 x 3/4" ZN Grade 5
27	S-8316	Bolt, HHCS 7/16"-14 x 3" ZN YDP Grade 8	52	S-7383	Nut, Nylock 3/8" ZN Clear Grade 5
28	S-8317	Nut, Stover 7/16"-14 ZN Grade C			

10" to 12" 25° Bin Unloader Parts

Figure 9-2 10" to 12" 25° bin unloader parts

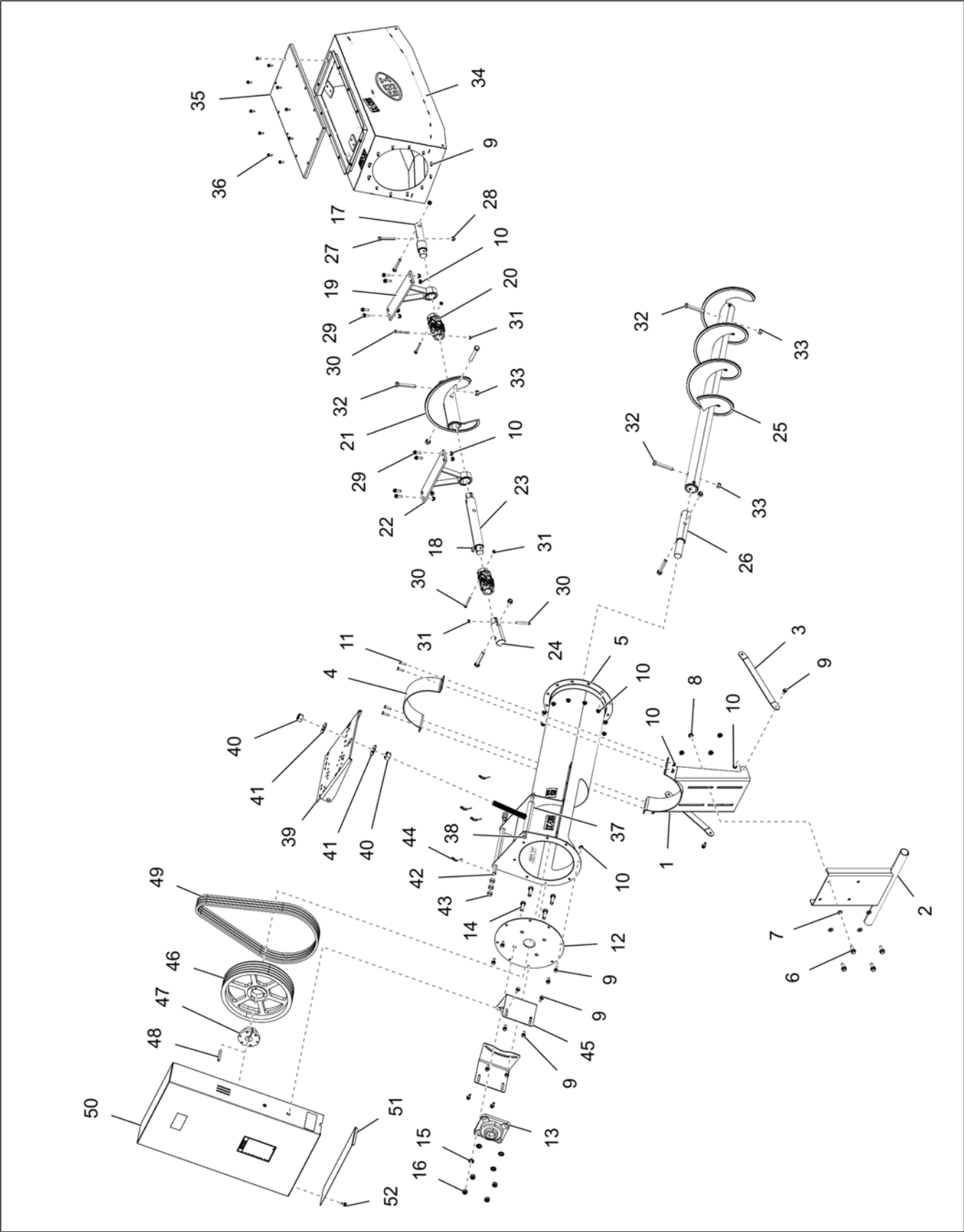


Table 9-2 10" to 12" 25° bin unloader parts list

Ref #	Part #	Description	Ref #	Part #	Description
1	GK80296-Y	Drive Unit: Common 10"-12" 25° Stand Upper Weldment	29	S-9066	Bolt, Flange 3/8"-16 x 1-1/4" ZN Grade 5
2	GK80297-Y	Drive Unit: Common 10"-12" 25° Stand Lower Weldment	30	S-8677	Bolt, HHCS 3/8"-16 x 3" YDP Grade 8
3	GK80298-Y	Drive Unit: Common 10"-12" 25° Stand Strap	31	S-8251	Nut, Stover 3/8"-16 ZN Grade C
4	GC08690-Y	Band: Half 12" x 4" 7 Gauge	32	S-7893	Bolt, HHCS 5/8"-11 x 4" YDP Grade 8
5	GK6999-18	Tube: 12" Horizontal Assembly	33	S-8606	Nut, Stover 5/8"-11 ZN Grade C
6	S-9062	Bolt, Flange 1/2"-13 x 1-1/4" ZN Grade 5	34	GK81274	Drive Unit: Common 10"-12" 25° Box Weldment
7	S-2120	Washer, Flat 1/2" SAE ZN	35	GK80308	Drive Unit: Common 10"-12" 25° Box Cover Assembly
8	S-8506	Nut, Flange 1/2"-13 ZN	36	S-6606	Bolt, Flange 5/16"-18 x 3/4" ZN Clear Grade 5
9	S-9065	Bolt, Flange 3/8"-16 x 1" ZN Grade 5	37	GK6942	Motor Mount: Adjustment Rod Weldment 8"
10	S-968	Nut, Flange 3/8"-16 ZN Grade 5 Wide Flange	38	GK7012	Motor Mount: Adjustment Pivot Rod 8"
11	S-2071	Bolt, HHCS 3/8"-16 x 1-1/4" ZN Grade 5	39	GK6986-Y	Motor Plate: 8"-12"
12	GK7064-BS	Bearing Plate: 12" Horizontal - Bin Silver	40	S-240	Nut, Hex 1"-8 ZN Grade 5
13	GK2004	Bearing, Light Duty 2.00" Bore with Locking Collar 4 Hole Flange	41	S-7835	Washer, Flat 1" ID USS Washer, Low Carbon
14	S-8399	Bolt, HHTB 5/8"-11 x 2" ZN Grade 5	42	GK7013	Motor Mount: Plate Pivot Rod 8"
15	S-3208	Washer, Lock Split 5/8" Med ZN	43	GK7014	Drive Unit: Pivot Spacer Tube
16	S-4110	Nut, Hex 5/8"-11 YDP Grade 5	44	S-6994	Pin, Cotter 3/16" x 2" ZN Grade 2
17	GK80284	Drive Unit: Common 10"-12" 25° Lower Shaft	45	GK7065	Belt Guard: 12" x 19" Mount Bracket
18	GC03540	Key, 3/8" x 3/8" x 1"	46	GK3541	Sheave, 4 Groove, A15.0-B 15.4 -SF, 15.75" O.D.
19	GK81198	Drive Unit: HD 10"-12" 25° Bearing Hanger Assembly		GK1304	Sheave, 3 Groove, B Belt, 1.5" B, 15" O.D.
20	GK80285	U-Joint, 12E 1.5" Bore 5.75" Long		GK1345	Sheave, 2 Groove, B Belt, 1.5" B, 15" O.D.
21	GK80310	Drive Unit: Common 10"-12" 25° Lower Flight Weldment	47	D03-0264	Bushing, SF 1-1/2"
22	GK81197	Drive Unit: HD 10"-12" 25° Upper Bearing Hanger Assembly	48	S-9181	Key, Square 3/8" x 3"
23	GK80279	Drive Unit: Common 10"-12" 25° Lower Flight Shaft	49	MHC00126	Belt, V B x 64
24	GK80291	Drive Unit: Common 10"-12" 25° Upper Flight Shaft		MHC01253	Belt, V B x 62
25	GK80309	Flight, 25° DU, Weldment 11" x 0.250" x 55.75"	50	GK7066	Belt Guard: 19" Top Assembly
26	GK2006	Shaft: Drive 2" OD x 12" 25°	51	GK7067	Belt Guard: 19" Bottom Assembly
27	S-8314	Bolt, HHCS 1/2"-13 x 3-1/2" YDP Grade 8	52	S-9067	Bolt, Flange 3/8"-16 x 3/4" ZN Grade 5
28	S-8315	Nut, Lock 1/2"-13 ZN Grade C Prevailing Torque			

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	5 Years
	▪ Roof, doors, platforms and walk arounds ▪ Flooring (when installed using GSI specified floor support system for that floor) ▪ Hopper tanks	
Conditioning	Dryer Structural Design – (Tower, Portable and TopDry)	5 Years
	▪ Includes (frame, portable dryer screens, ladders, access doors and platforms)	
	All other Dryer parts including:	2 Years
	▪ Electrical (controls, sensors, switches & internal wiring)	
	Bullseye Controllers	2 Years
Material Handling	Bucket Elevators Structural Design	5 Years
	Towers Structural Design	5 Years
	Catwalks Structural Design	5 Years
	Accessories (stairs, ladders and platforms) Structural Design	5 Years

Conditions and Limitations:

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

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

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

Notice Procedure:

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

Service Parts:

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

(Limited Warranty - N.A. Grain Products_ revised 19 October 2018)

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



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