

CONVEYOR ASSEMBLY MANUAL



AGRI STAINLESS INC.

WARNING !!!

Use all necessary safety precautions for assembly, installation and operation of this product. Be sure to stay clear of all moving parts. All safety warnings of original conveyor apply as well. **DO NOT USE AIR OR ELECTRIC IMPACTS. APPLY ANTI SEIZE TO FASTENERS. READ ALL INSTRUCTIONS PRIOR TO INSTALLING THIS PRODUCT.**

IMPORTANT !!!

Take careful consideration of all adjustments when assembling new stainless conveyors. If not set correctly, the belt can be seriously damaged in a very short amount of time. When starting to run belt, watch belt for tracking immediately.

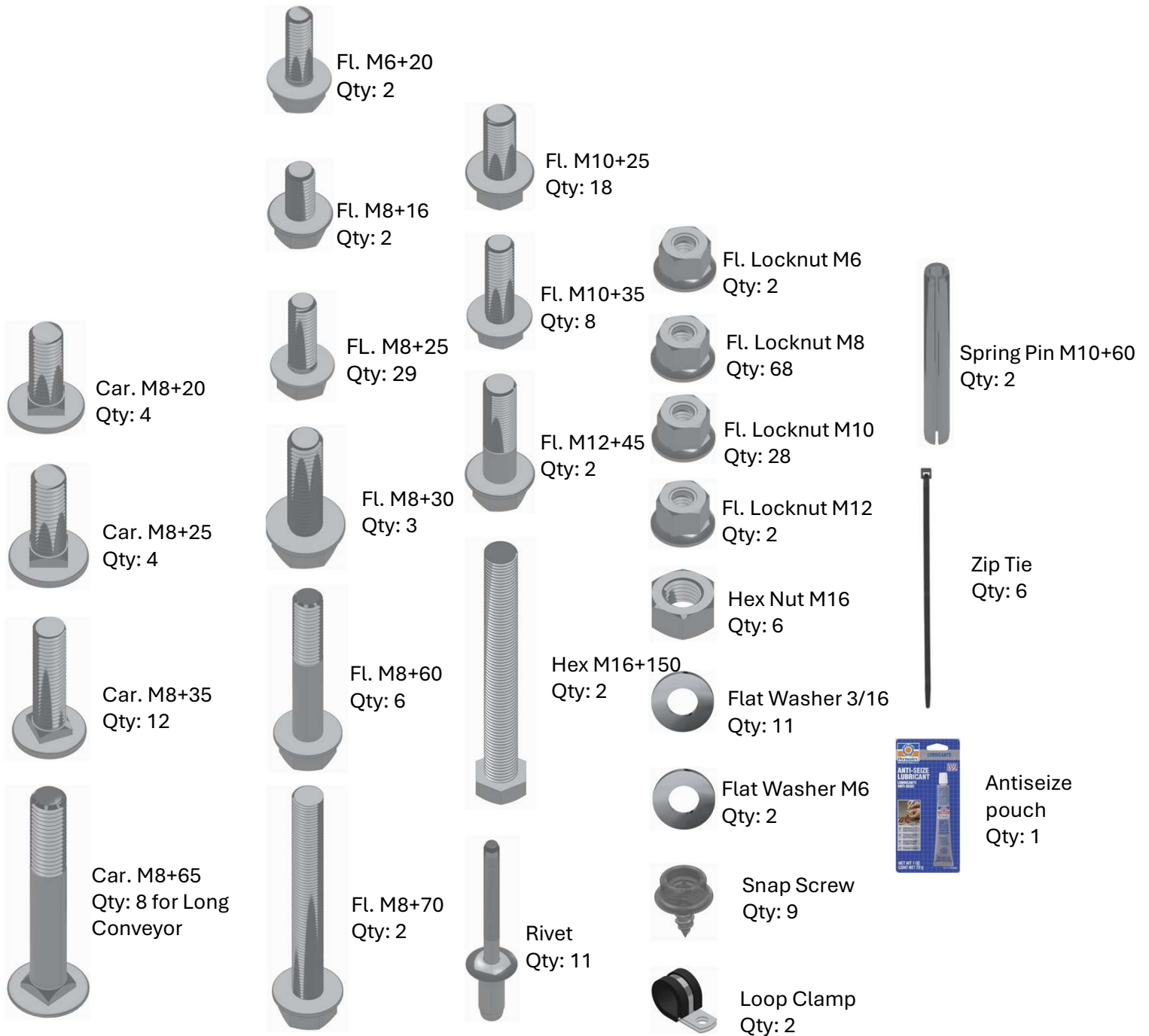
ASSEMBLY !!!

Take note of how your existing John Deere conveyor was assembled, as well as bolt sizes used in all different locations.

TORQUE VALUES FOR STAINLESS STEEL HARDWARE

- M6 → 10 NM (7 ft lbs)
- M8 → 25 NM (18 ft lbs)
- M10 → 50 NM (36 ft lbs)
- M12 → 88 NM (64 ft lbs)
- Use the above torque values as a guideline.
- **NOTE: PLEASE APPLY ANTISEIZE ON ALL STAINLESS STEEL THREADED SURFACES OTHERWISE THREAD DAMAGE WILL OCCUR.**

CONVEYOR HARDWARE KIT COMPONENTS



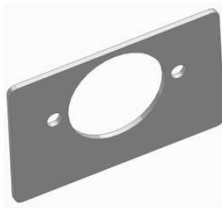
Included and Optional Conveyor parts



Scraper Bracket
Qty: 1



Scraper
Qty: 1



Spacer Motor
Qty: 1



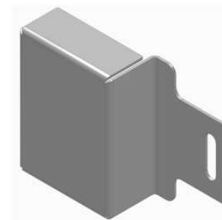
Tension Plate Motor
Qty: 1



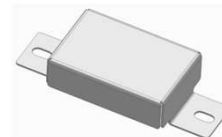
Tension Plate
Qty: 1



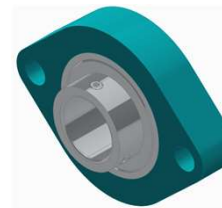
Cover
Qty: 1



Bearing Cover
Qty: 2



Bearing Cover
Qty: 1



Bearing Assembly
Qty: 4

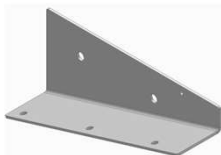


Plate Hopper
Qty: 1

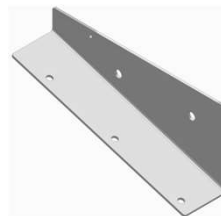


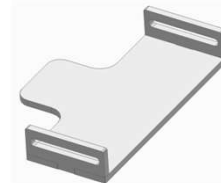
Plate Hopper
Qty: 1



Handle Lock
Qty: 1



Mounting Bracket
Qty: 1



Saddle
bracket
Qty: 1



Light Bracket
Qty: 1



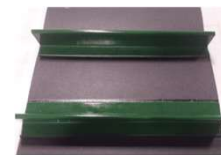
Plate Clamp
Qty: 6 for Long Conveyor
Qty: 5 For Short Conveyor



Support
Qty: 1



Flange Hopper
Qty: Preinstalled on Conveyor



Conveyor Belt
Long or Short
Qty: **Optional**



Roller Idler
Qty: **Optional**



Roller Drive
Qty: **Optional**



Small Latch
Qty: **Optional**



Large Latch
Qty: **Optional**



Top Handle
Qty: **Optional**



Upper Handle
Long or Short
Qty: **Optional**



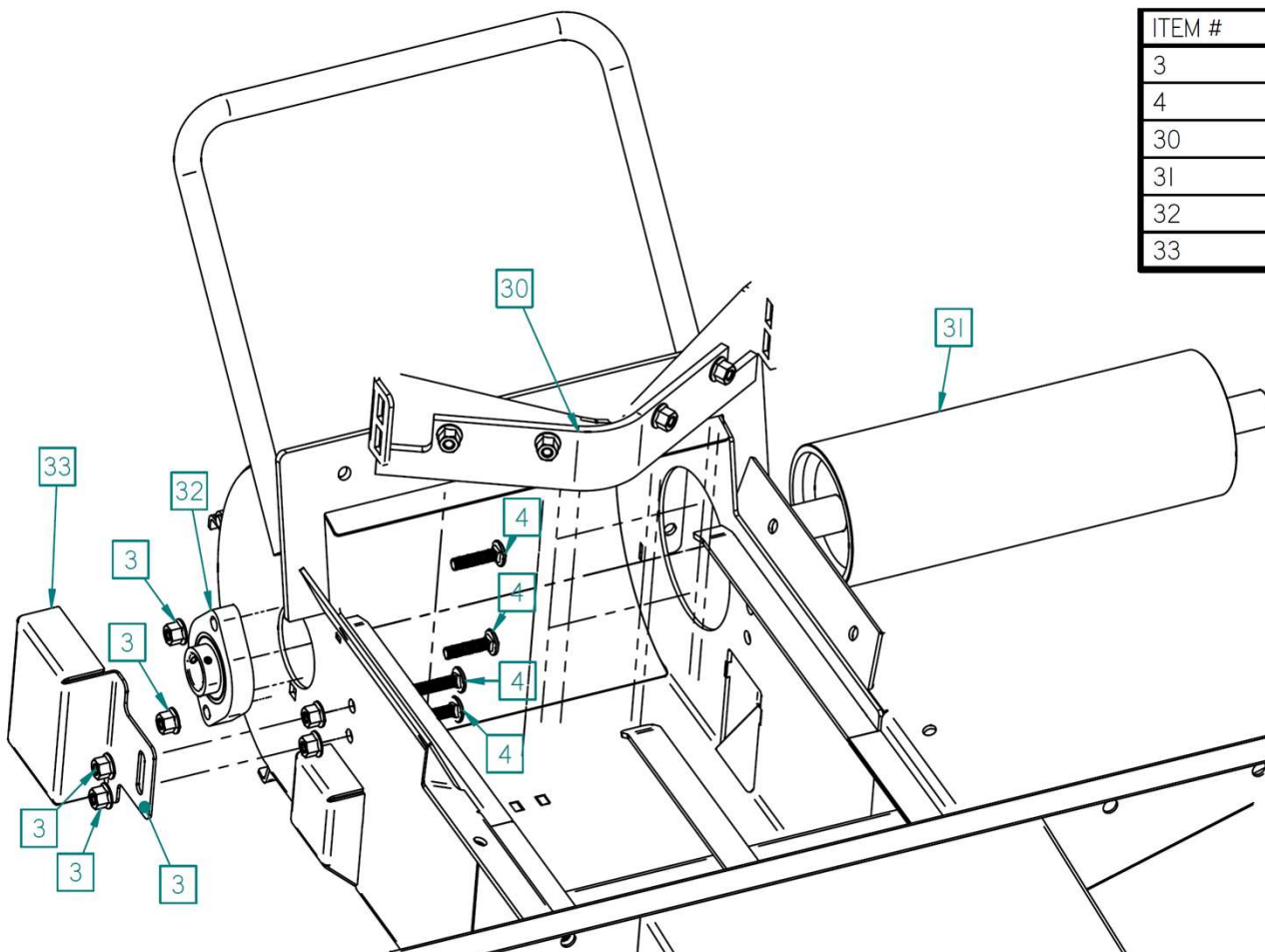
Lower Handle
Qty: **Optional**



Removable Handle
Qty: Preinstalled on Conveyor

Conveyor Installation

- Install scraper assembly using carriage bolts (#4). Height adjustment needs to be made once both rollers along with belt are installed, and belt has been tightened.
- Install bearing assembly (#32) with carriage bolts (#4) & flange locknuts (#3)
- Slide the roller in through the large opening from the right. Make sure the roller sits centered in the housing.
- Install bearing assembly (#32) on bracket (#34) and slide on roller shaft.
- To secure roller, install bearing collar and tighten in the direction of shaft rotation. Tighten bearing set screws.
- Fasten bracket (#34) using (#3 lock nut & #6 Fl. Bolt). Check belt tracking and adjust tension on #3 & #6 if tracking is off once belt has been installed.
- Install bearing cover bracket (#33) on same bolts as bracket (#34), secure with another set of flange lock nuts (#3).



ITEM #	DESCR.
3	FL. NUT LOCK M8
4	CAR. BOLT M8+35
30	SCRAPER ASSEMBLY
31	IDLER ROLLER
32	BEARING ASSEMBLY
33	COVER BEARING

Fig.1

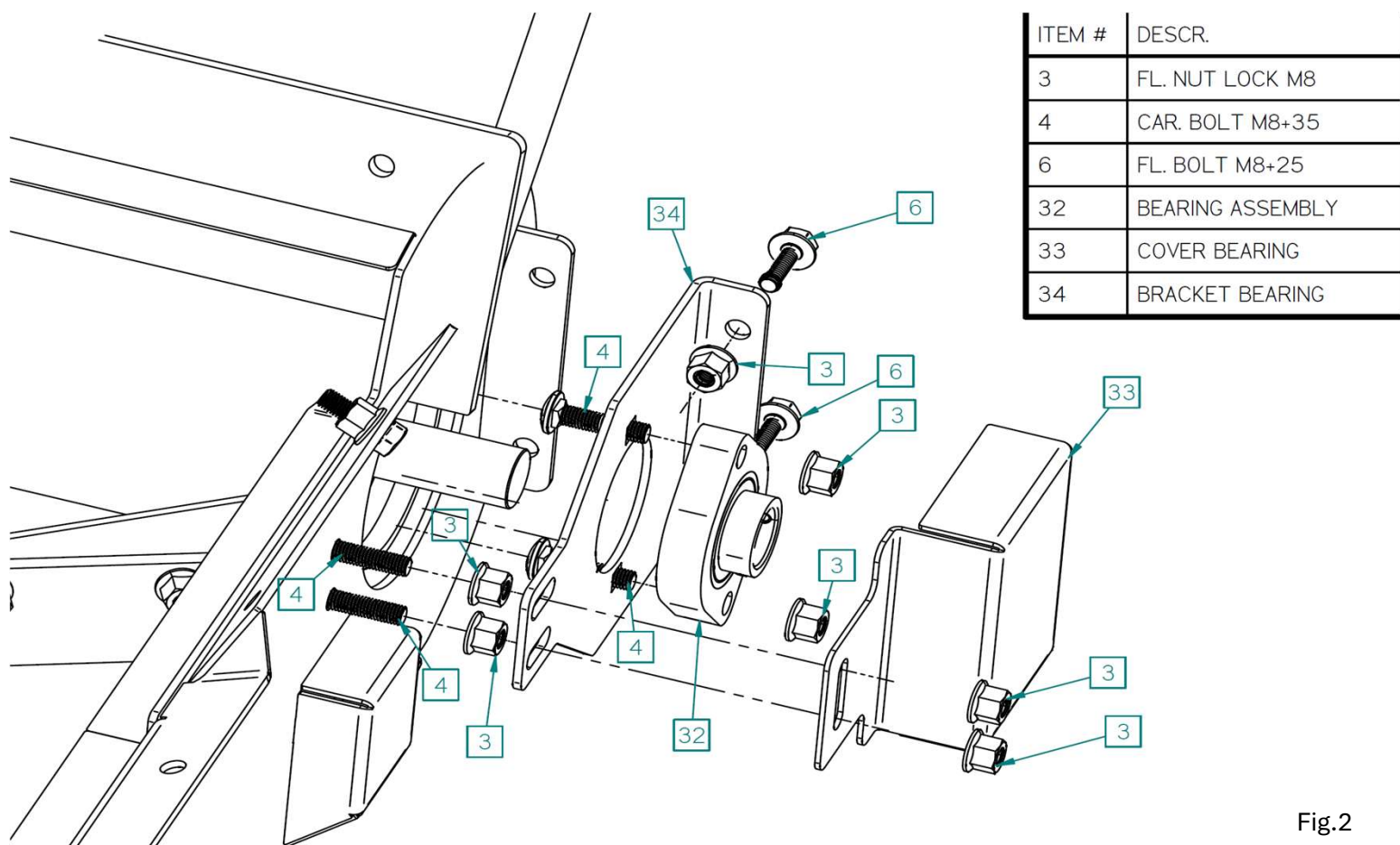
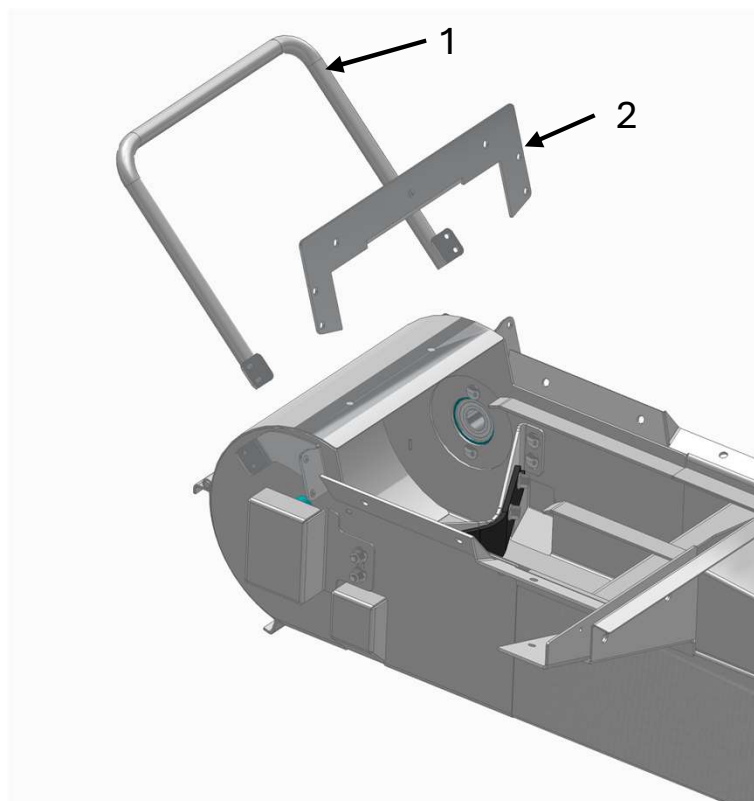
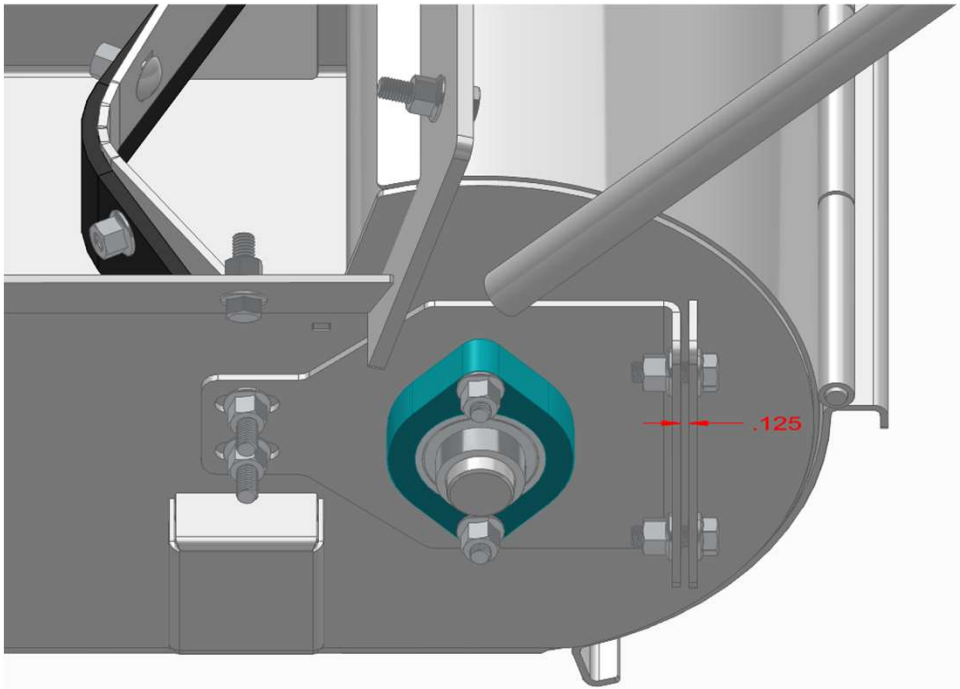


Fig.2



Please note:
If your conveyor has the flip over attachment, you must remove handle (1) and bracket (2), prior to installing the flip over on your new conveyor.



- Install tensioning bracket with a 1/8" gap to mounting flange as shown in Fig.
- Check belt tracking by rotating belt approximately 10 ft and observe tracking.
- If belt is tracking towards side of tensioning bracket, tighten lock nuts further to reduce preset gap.
- Check belt tracking again by rotating belt. If belt is still not tracking correctly, repeat the above step until corrected.

Fig.9

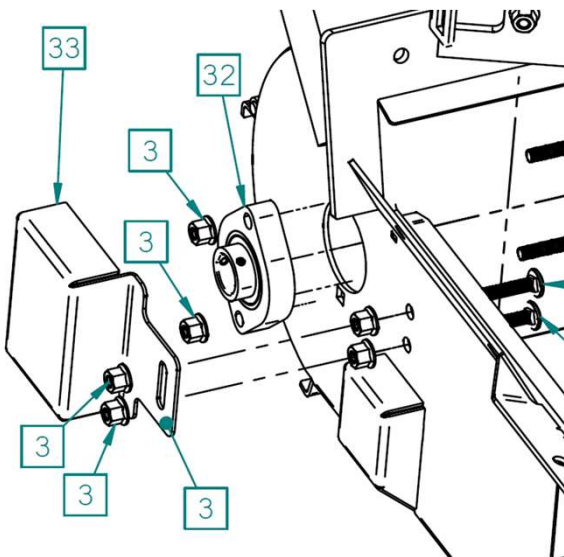


Fig.10

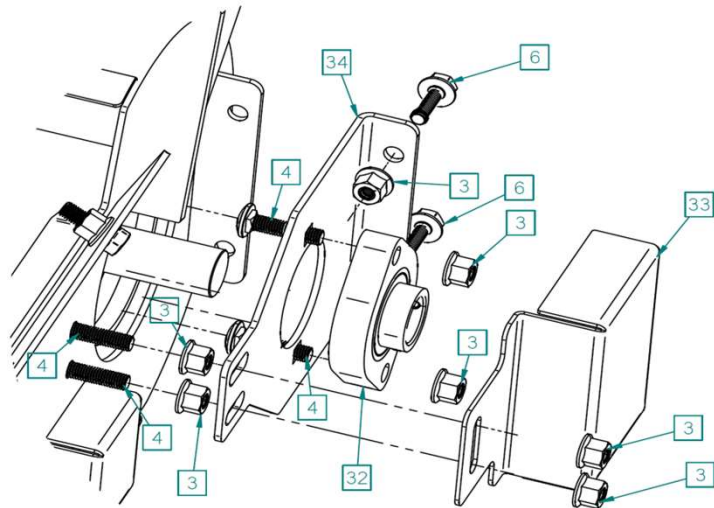


Fig.11

- When belt is properly tensioned and adjusted for proper tracking. It is critical to set scraper to correct height.
- The scraper should be in contact with the belt. If adjustment is necessary, follow the steps below.
- Remove bearing cover (#33) and loosen the 4 lock nuts that hold the scraper assembly in place. Open access door underneath conveyor and adjust scraper to proper height. Tighten the 4 lock nuts again and secure the bearing covers as done in previous steps.
- Note: If there is a gap between wear strip and belt, product will accumulate around the bottom roller resulting in damage to the belt.
- If a used belt is being reinstalled that is worn narrower than 12", it may also allow too much product to sift into the cavity by the bottom pulley.

- Before the upper and lower housing halves are bolted together, make sure you have a nice even surface to align the housings properly. Setting up on sawhorses is ideal.
It is now a good time to install the conveyor belt assembly.
Using a stiff wire, feed the wire through the housing and attach to conveyor belt.
Pull the wire and feed the belt through one half of the housing at a time.
Once it is fully through the housing, bolt the housing together making sure to not catch the belt in between the two flanges.
Now our belt can be spliced together.

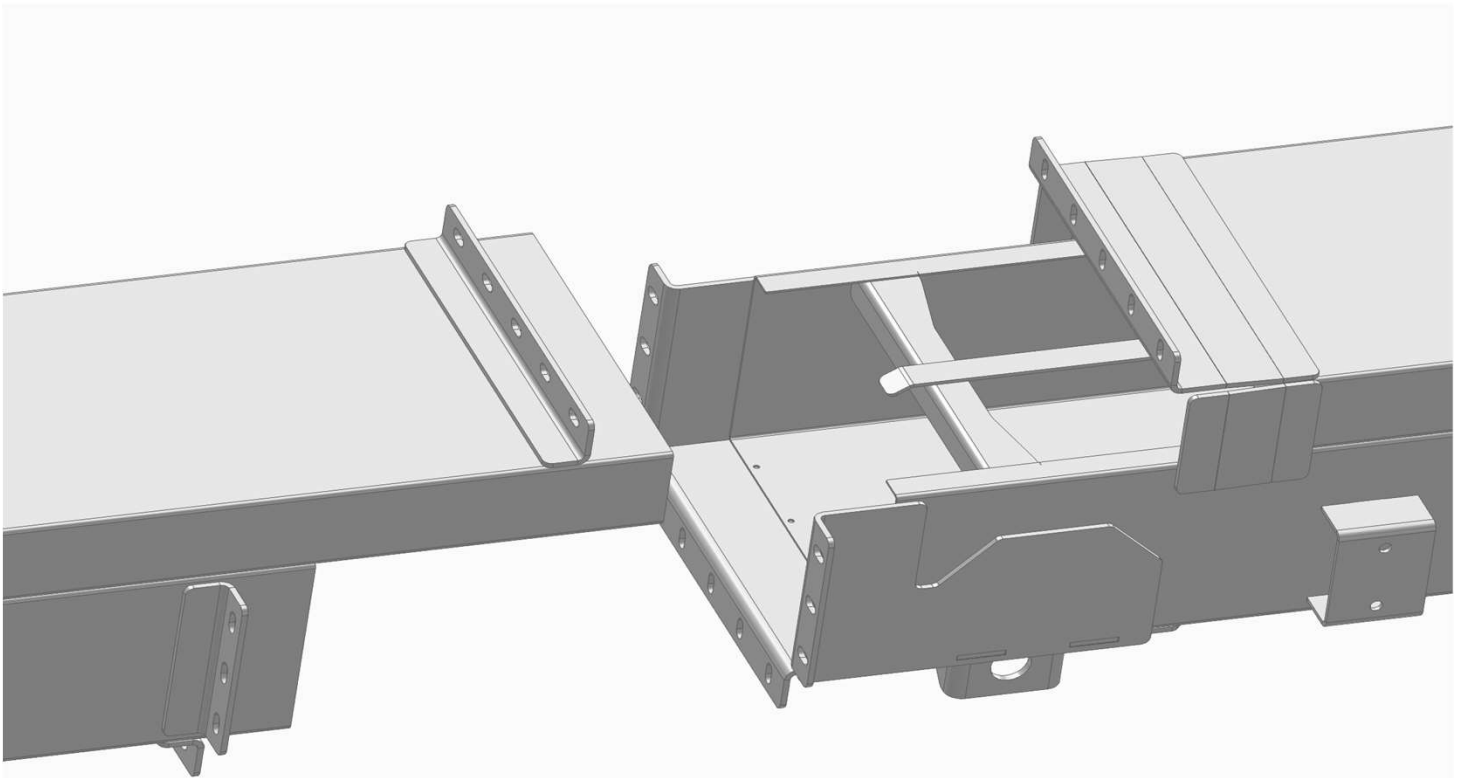


Fig.3

ITEM #	DESCR.	QTY
3	FL. NUT LOCK M8	2
9	FL. BOLT M10-25	16
10	FL. NUT LOCK M10	20
14	FL. BOLT M10-35	4
15	FL. BOLT M8-70	2

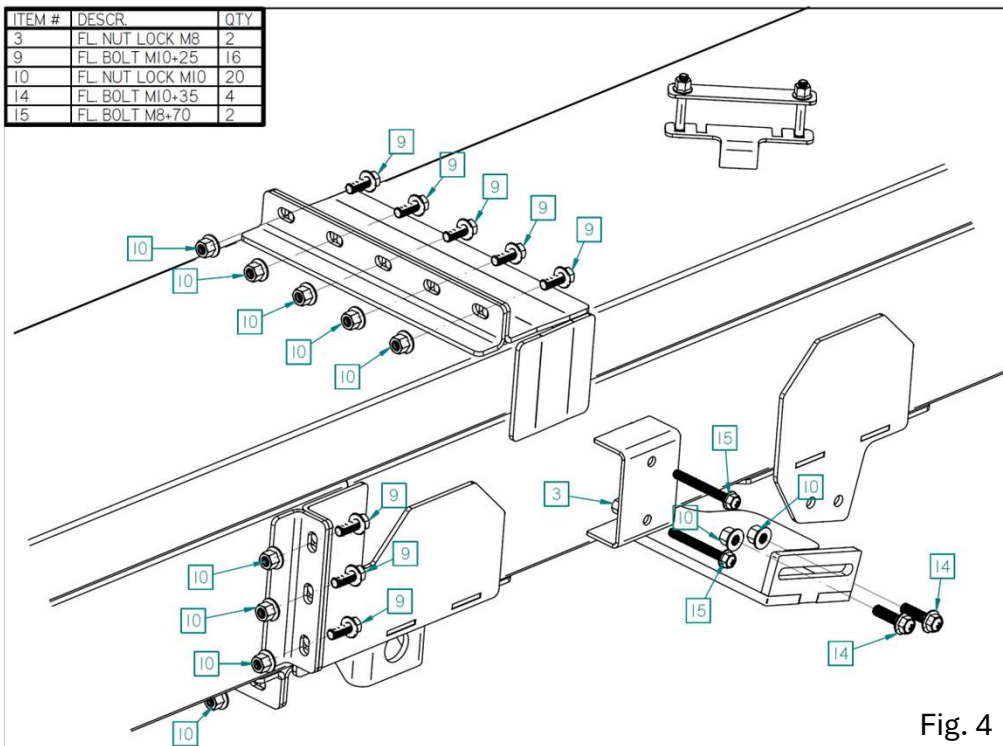


Fig. 4

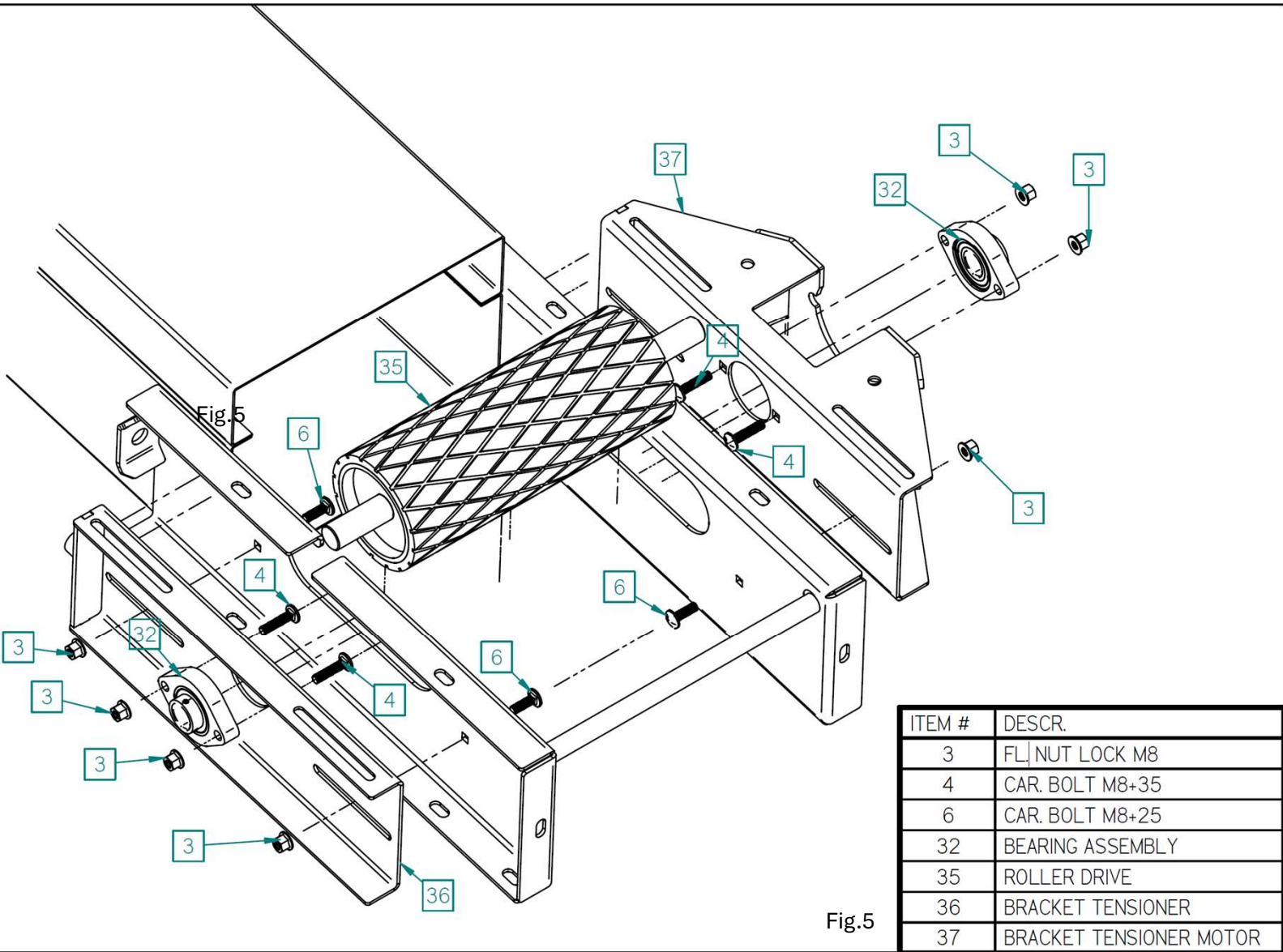
Slide the two housing halves together, use C-clamps to assist in positioning the housings to fully seated.

Use flange head bolt and flange nylon lock nut to secure the housing together (item #9 & #10) 16 pcs of each required.

Install saddle bracket (item #14 & #15).

IMPORTANT: USE ANTISEIZE ON ALL THREADED SURFACES

- Drop down drive roller into cutout at spout end of the conveyor.
- Install bearing assemblies on tensioning plate using item (#3 & 4)
- Repeat the same procedure for the motor side.
- Slide the tensioning brackets (#36 & 37) with the installed bearing housings on roller shaft and mount the brackets using item (#3 Lock nut & #6 Car. Bolt.) Do not torque yet, semi tight only to allow tension brackets to slide freely.
- Make sure the roller sits centered in the housing.
- Install locking collars and tighten in the direction of shaft rotation. Tighten set screws.
- Installation of hydraulic motor & coupler (not included) should be the same as the factory original.
- Note: Complete hydraulic kit is available by ordering part # SSK3-LONG or SSK3-SHORT.



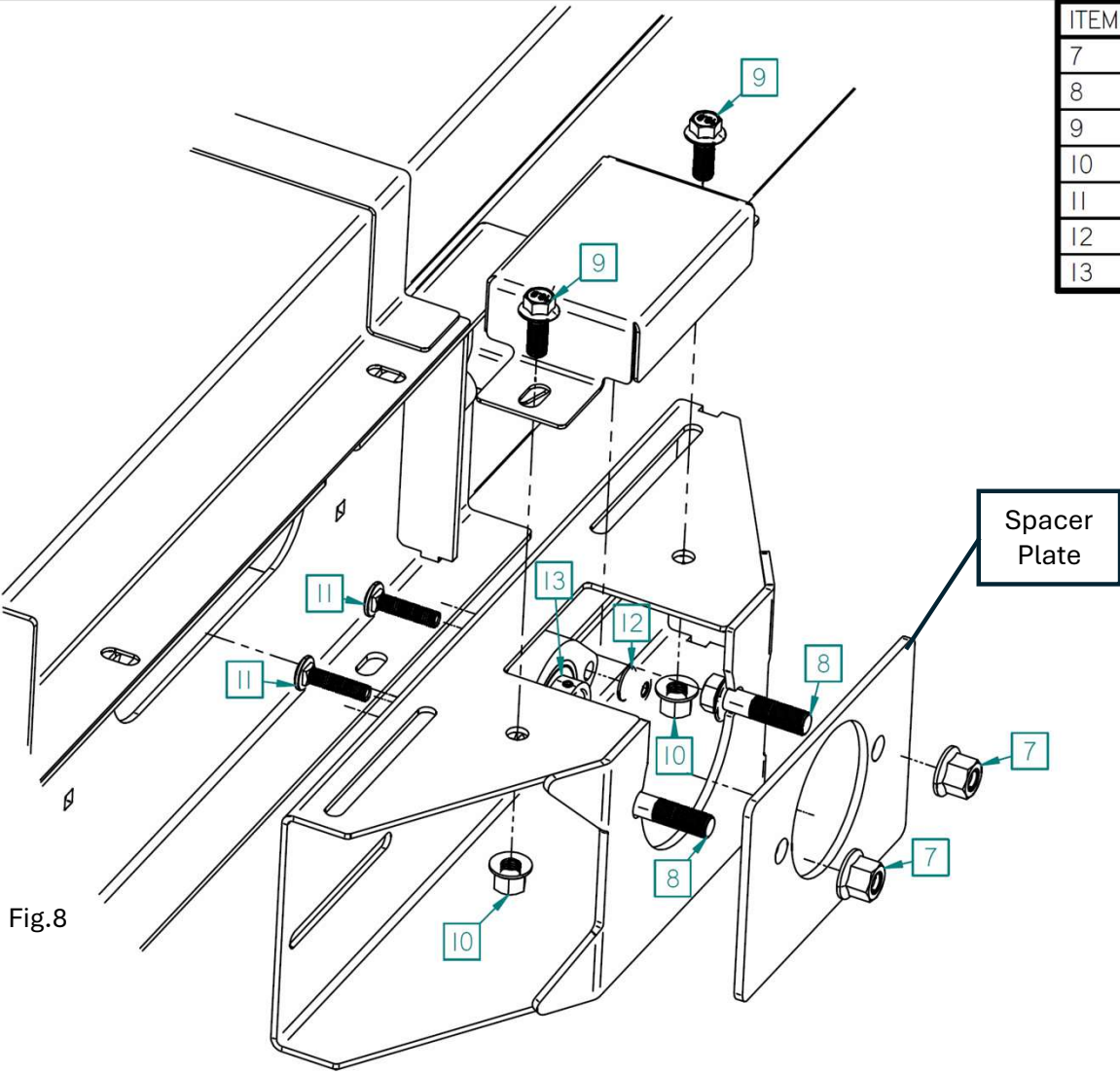


Fig.8

ITEM #	DESCR.	QTY
7	FL. NUT LOCK M12	2
8	FL. BOLT M12+45	2
9	FL. BOLT M10+25	2
10	FL. NUT LOCK M10	2
11	CAR. BOLT M8+35	2
12	FL. NUT LOCK M8	2
13	BEARING ASSEMBLY	2

Adjust Belt Tension and Tracking

- Remove slack from belt by pulling both tensioning brackets by hand.
- Tighten adjusting bolt (item #1) until they touch the brackets.
- Tension belt forward an additional 2". This will make distance as shown in Fig.7 approximately 3.25" for most belts.
- Tighten locking nut and jam nut.
- NOTE: It is normal for belt to track side to side approximately 1/16"-1/8" however belt should never be in contact with the conveyor housing.

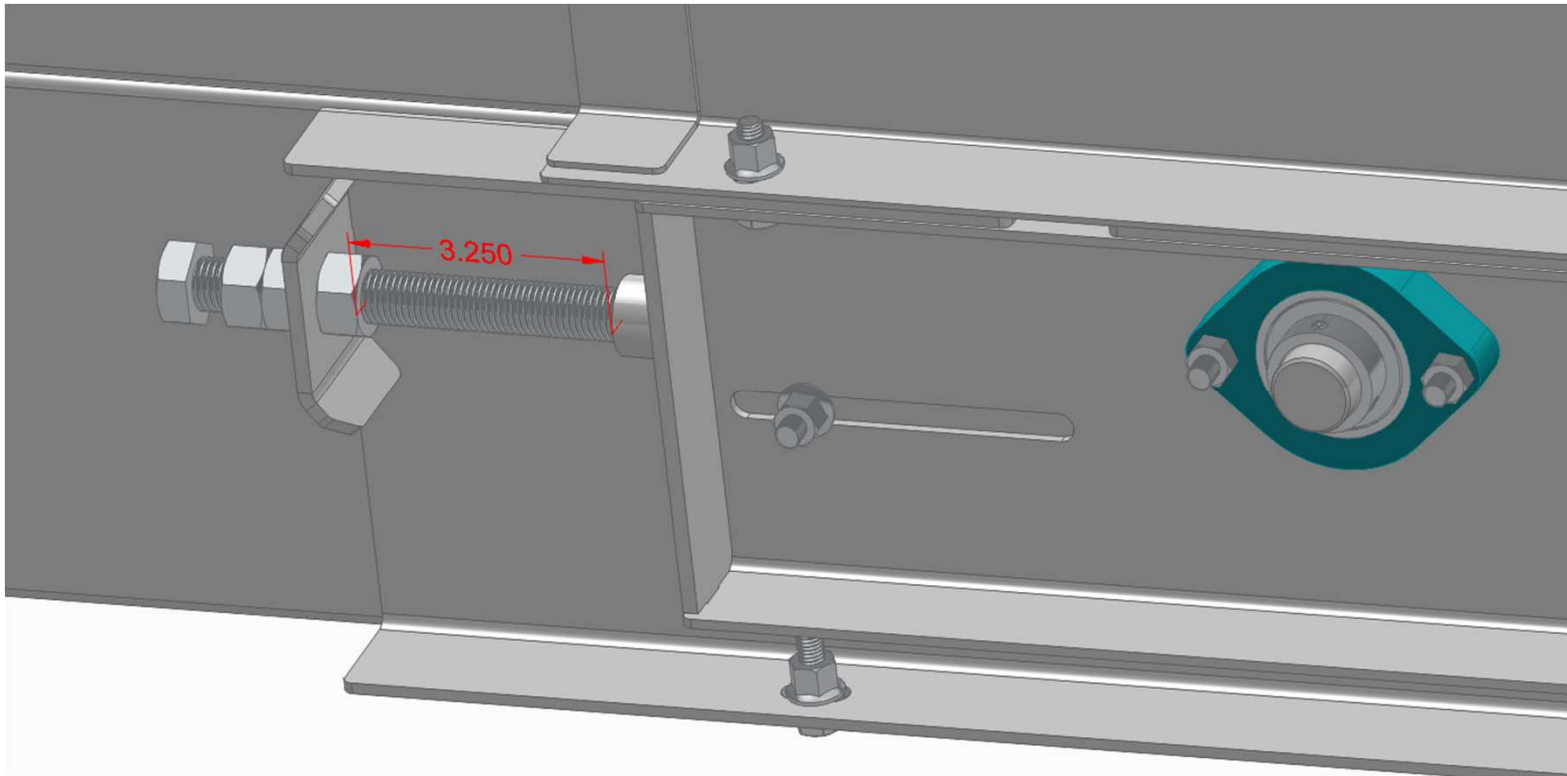


Fig.6

Adjust Belt Tension and Tracking cont.

- Check belt for proper tracking as follows:
- Rotate belt by hand approximately 10 ft. If belt tracks towards one side and will not return to center, adjustment is necessary.
- If adjustment is required, tighten adjusting bolt (item #1) one flat (1/6th turn) at a time on the side where belt is rubbing; then rotate belt by hand again to see if tracking returns to center. Repeat if necessary.
- Run conveyor at slowest speed and observe tracking. If additional adjustment is necessary, continue to tighten adjusting bolt in small increments until belt tracks side to side less than 1/8" in either direction without contact to housing.
- Tighten lock nuts on tension brackets (item # 3 & 6)

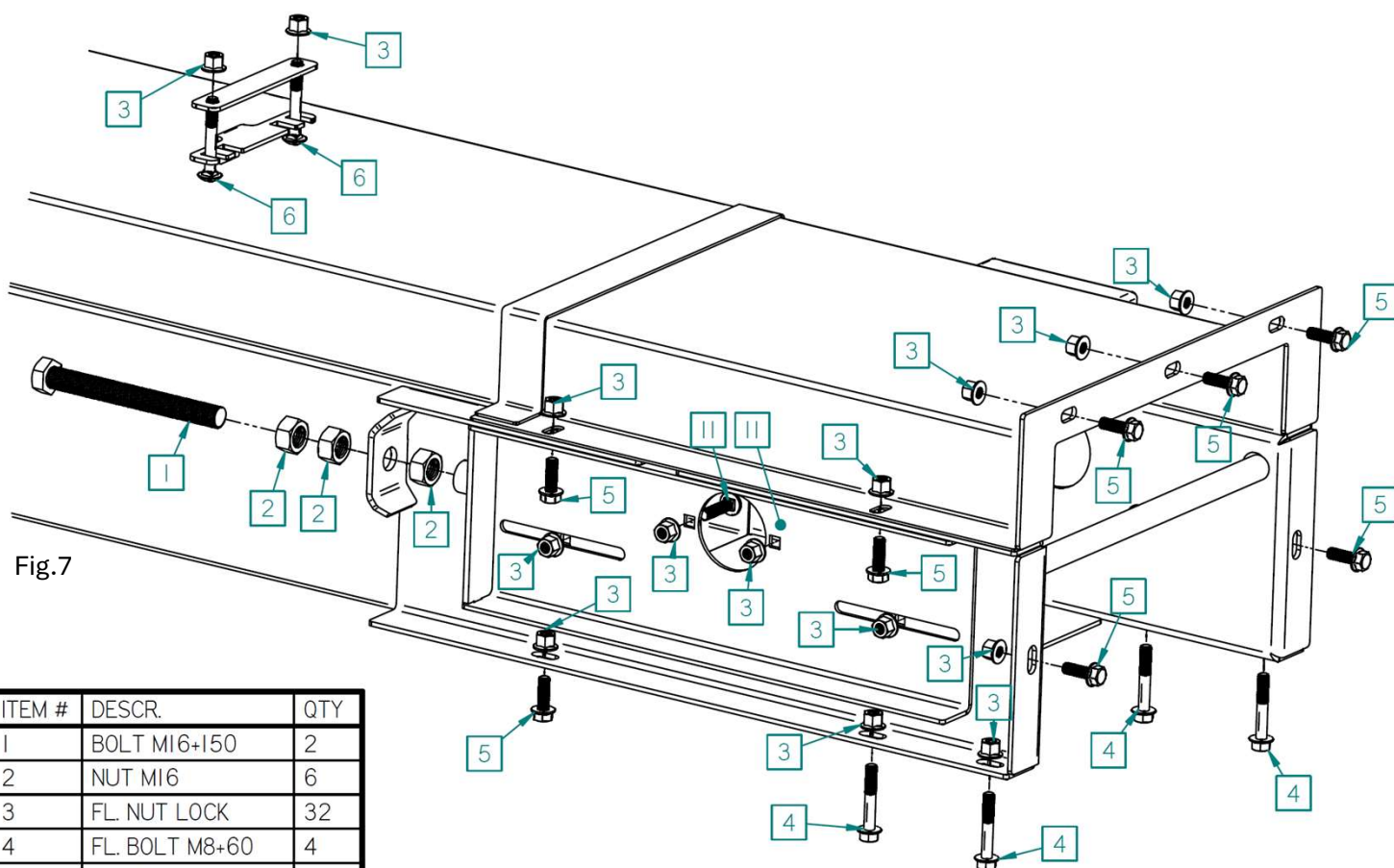


Fig.7

ITEM #	DESCR.	QTY
1	BOLT M16x150	2
2	NUT M16	6
3	FL. NUT LOCK	32
4	FL. BOLT M8x60	4
5	FL. BOLT M8x25	11
6	CAR. BOLT M8x65	8
11	CAR. BOLT M8x35	2

- Install latch as shown.
- Depending on model you will need small latch (#38) for Tow behind carts mounted in Position 1 or Large latch (#39) for Tow between carts mounted in Position 2.

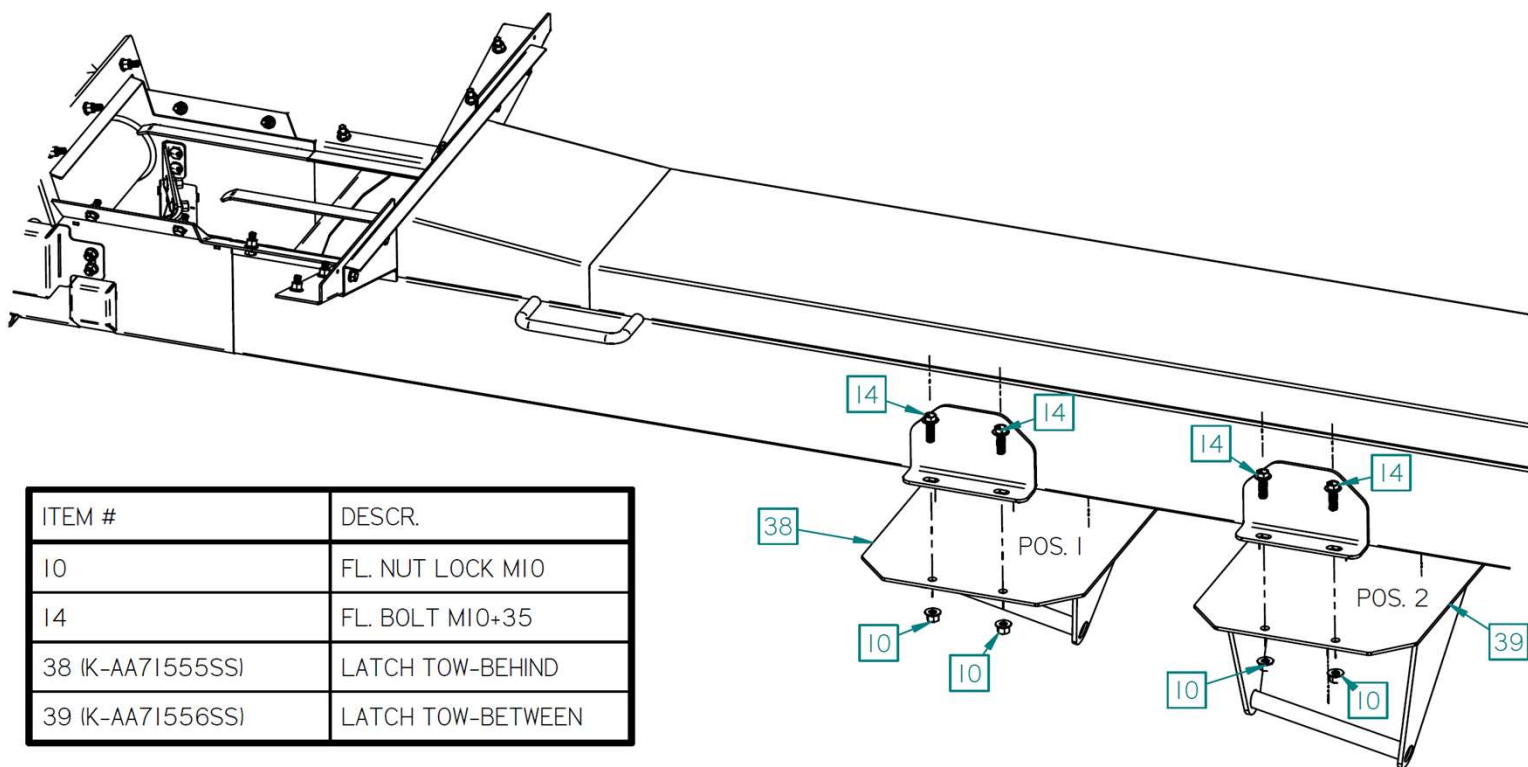


Fig.12

- Install the supplied seal tape following original conveyor example. Highlighted in red. Drilling out bolt holes will make spout and hopper installation easier.

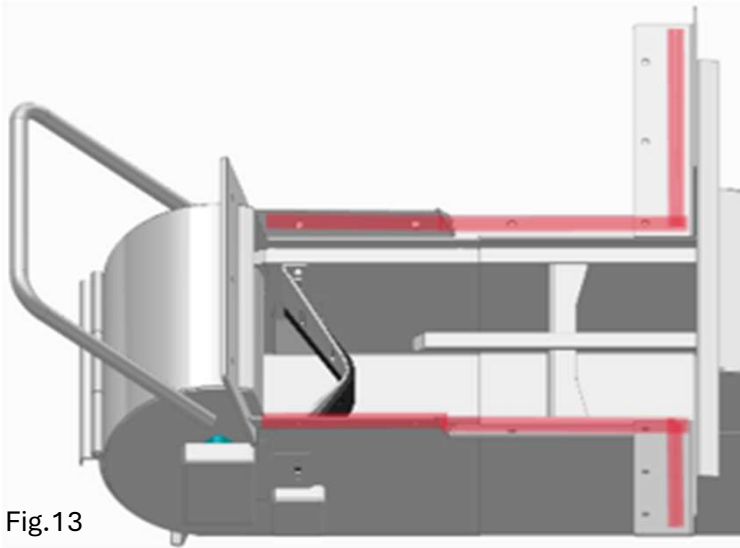


Fig.13

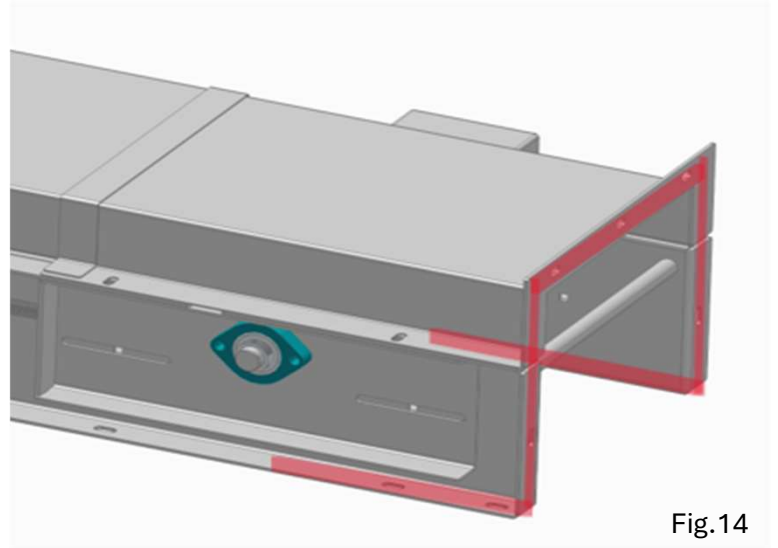


Fig.14

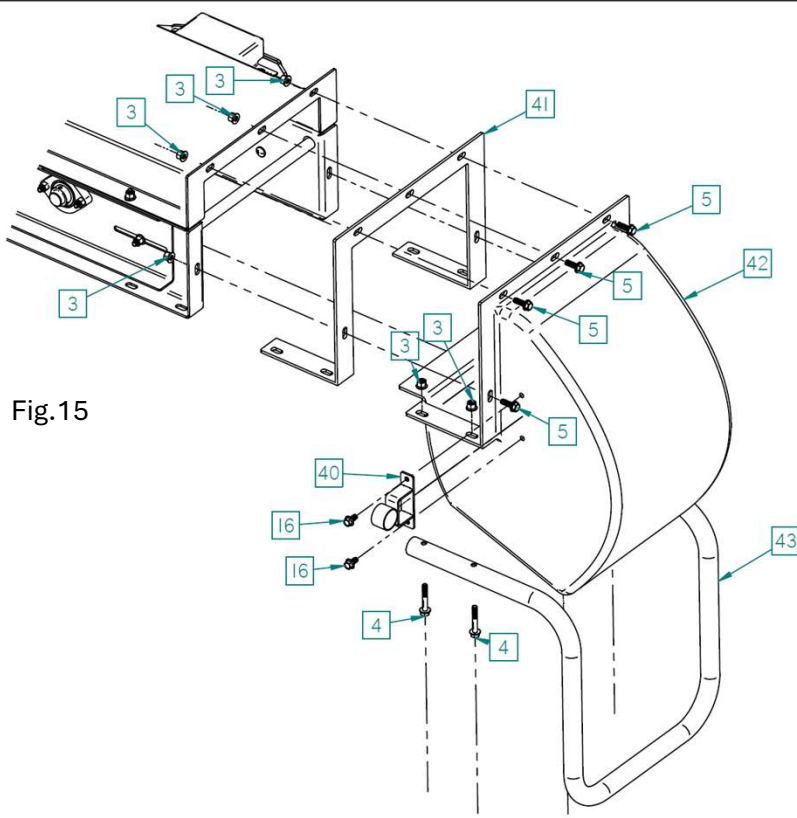


Fig.15

ITEM #	DESCR.
3	FL. NUT LOCK M8
4	FL. BOLT M8-60
5	FL. BOLT M8-25
16	FL. BOLT M8-16
40	SUPPORT HANDLE
41	SEAL TAPE
42	SPOUT
43	TOP HANDLE

Top End Installation Final Steps

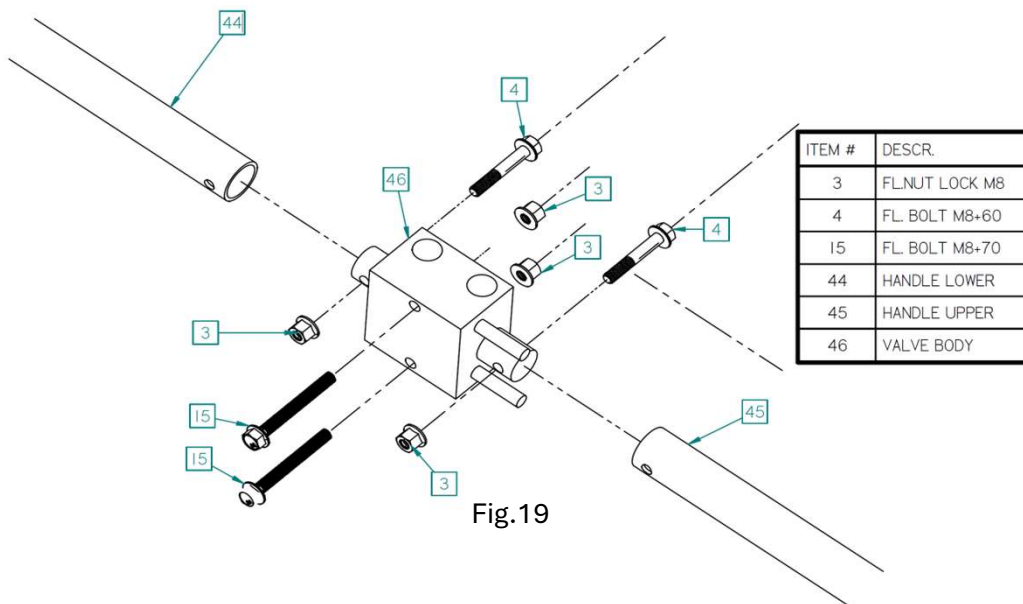
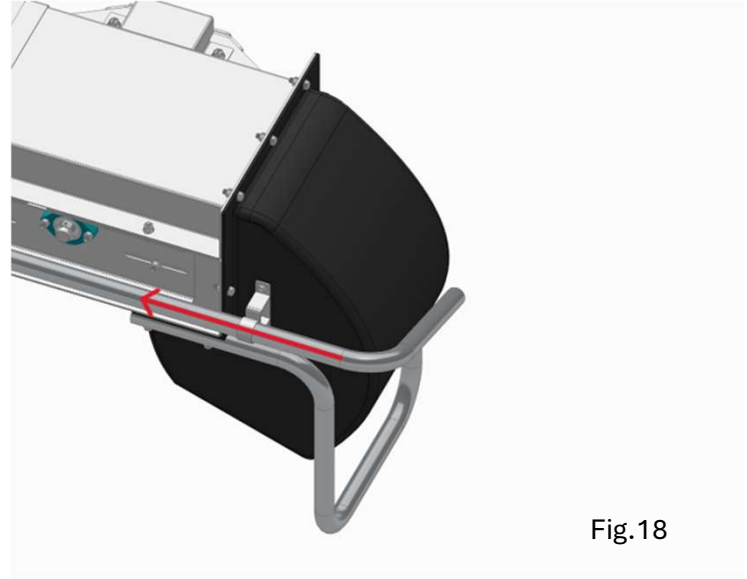
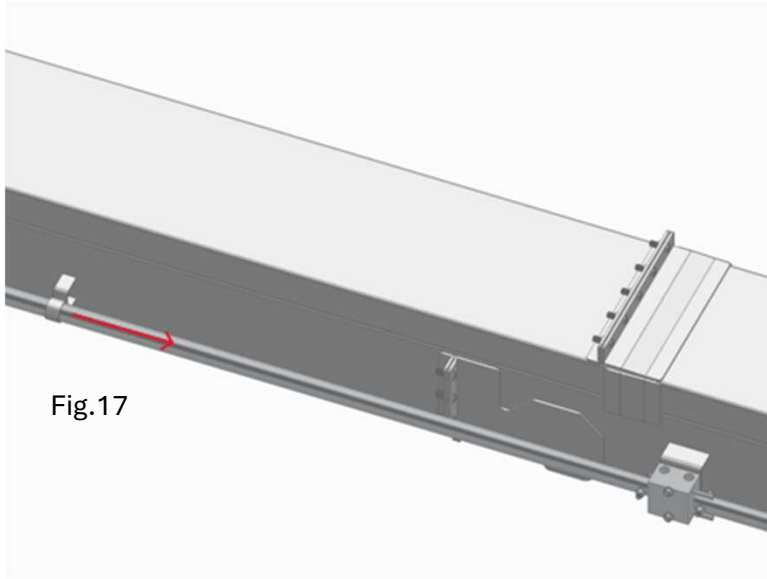
- Install seal tape (#41) as shown in Fig. 13 & 14.
- Follow with spout installation (#42) starting with top 3 bolts (#5).
- Finish with bottom 4 bolts and attach top handle (#43) at the same time using (#3&4) nut and bolt. Dependent on model
- Install support bracket (#40) on spout with (#16) bolts.
- Finish spout component installation in the same manner as original conveyor (Fig.16).



Fig.16

VALVE & HANDLE INSTALLATION

- Install valve body (#46) to conveyor using nut and bolt (#3 & #15).
- Slide in lower handle through mounted support on conveyor and attach to valve body using (#3 & #4).
- Repeat the same step for upper handle, slide it through the support bracket (#40) mounted on spout in previous step and attach to valve body using the same size of nut and bolt again.



- Before installing hopper, install sealing tape as shown in Fig.13 & 14
- Remove screen and hopper from original conveyor.
- Clean all sealing surfaces
- Install hopper and screen in same manner as original.
- Note all hardware from original conveyor and replace with same size using the provided stainless steel hardware.
- Stainless steel rivets are also supplied, use as needed to secure hopper shield to hopper if it became loose or was taken apart.
Drilling holes may be required. (#10 drill bit)
- Once conveyor has been assembled, install on air cart support rod, using a forklift or other suitable lifting device.
- Install provided spring pin to secure.

