



WALKING LEG BIN FILL SYSTEM

Operators Manual



Document: TD-09-06-1016

Revision: A



INTRODUCTION

Thank you for choosing USC, LLC for your equipment needs. We appreciate your business and will work diligently to ensure that you are satisfied with your choice.

OVERVIEW

The purpose of this manual is to provide you with the basic information needed to operate and maintain the Walking Leg . It does not hold USC, LLC liable for any accidents or injuries that may occur.

OPERATOR RESPONSIBILITIES

As the purchaser/owner/operator of this equipment and control system, you have an obligation to install, operate, and maintain the equipment in a manner that minimizes the exposure of people in your care to any potential hazards inherent in using this equipment. It is critical that the owner of this equipment:

- Has a clear and documented understanding of the process this machine is being used in and of any resulting hazards or special requirements arising from this specific application.
- Allow only properly trained and instructed personnel to install, operate or service this equipment.
- Maintain a comprehensive safety program involving all who work with this machine and other associated process equipment.
- Establish clear areas of staff responsibility (e.g. operation, setup, sanitation, maintenance, and repairs).
- Provide all personnel with necessary safety equipment.
- Periodically inspect the equipment to insure that the doors, covers, guards, and safety devices are in place and functioning, that all safety instructions and warning labels are intact and legible, and that the equipment is in good working order.
- In addition to the operating instructions, observe and enforce the applicable legal and other binding regulations, national and local codes.

As the person with the most to gain or lose from working safely, it is important that you work responsibly and stay alert. By following a few simple rules, you can prevent an accident that could injure or kill you or a co-worker.

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- Do not operate, clean, or service this equipment until you have read and understood the contents of this manual. If you do not understand the information in this manual, bring it to the attention of your supervisor, or call USC at (785) 431-7900 for assistance.
- Any operator who is known or suspected to be under the influence of alcohol or drugs should not be allowed to operate the equipment.
- Understand and follow the safety practices required by your employer and this manual.
- **PAY ATTENTION** to what you and other personnel are doing and how these activities may affect your safety.
- **Failure to follow these instructions may result in serious personal injury or death.**

RECEIVING YOUR EQUIPMENT

As soon as the equipment is received, it should be carefully inspected to make certain that it has sustained no damage during shipment and that all items listed on the packing list are accounted for. If there is any damage or shortages, the purchaser must immediately notify USC, LLC. Ownership passes to purchaser when the unit leaves the USC, LLC. premises. The purchaser is responsible for unloading and mounting all components of the equipment.

Document the serial number of the machine for future reference. The serialization label is located on the back of the control panel mounting assembly.



*Serial
Number*

SERIAL NUMBER: _____

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SAFETY INSTRUCTIONS

SECTION A

Every year accidents in the work place maim, kill and injure people. Although it may be impossible to prevent all accidents, with the right combination of training, operating practices, safety devices, and operator vigilance, the number of accidents can be significantly reduced. The purpose of this section is to educate equipment users about hazards, unsafe practices, and recommended hazard avoidance techniques.

SAFETY WORDS AND SYMBOLS

It is very important that operators and maintenance personnel understand the words and symbols that are used to communicate safety information. Safety words, their meaning and format, have been standardized for U.S. manufacturers and published by the American National Standards Institute (ANSI). The European Community (E.C.) has adopted a different format based on the International Standards Organization (I.S.O.) and applicable machinery directives. Both formats are presented below. Graphic symbols are not standardized, but most manufacturers will use some variation of the ones seen in this manual.



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



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



Indicates a potentially hazardous situation which, if not avoided, **may** result in minor or moderate injury and/or property damage.



Provides additional information that the operator needs to be aware of to avoid a potentially hazardous situation.



Mandatory Lockout Power Symbol. Disconnect, lockout and tagout electrical and other energy sources before inspecting, cleaning or performing maintenance on this panel.



International Safety Alert Symbol. The exclamation point (!) surrounded by a yellow triangle indicates that an injury hazard exists. However, it does not indicate the seriousness of potential injury. The exclamation point (!) is also used with the DANGER, WARNING and CAUTION symbols so the potential injury is indicated.



Electrocution Hazard Symbol. This symbol indicates that an electrocution hazard exists. Serious injury or death could result from contacting high voltage.



International Electrocution Hazard. This symbol indicates that an electrocution hazard exists. Serious injury or death could result from contacting high voltage.



Mandatory Read Manual Action Symbol. (I.S.O. format) This symbol instructs personnel to read the Operators Manual before servicing or operating the equipment.



Mandatory Read Manual Action Symbol. This symbol instructs personnel to read the Operators Manual before servicing or operating the equipment.

NOTICE

Notice is used to notify people of important installation, operation or maintenance information which is not hazard related.

LOCKOUT / TAGOUT PROCEDURES

Lockout/Tagout is the placement of a lock/tag on an energy isolating device in accordance with an established procedure. When taking equipment out of service to perform maintenance or repair work, always follow the lockout/tagout procedures as outlined in ANSI Z344.1 and/or OSHA Standard 1910.147. This standard “requires employers to establish a program and utilize procedures for affixing appropriate lockout devices or tagout devices to energy isolating devices and to otherwise disable machines or equipment to prevent unexpected energizing, start-up, or release of stored energy in order to prevent injury to employees.”

EMERGENCY STOP



There is an Emergency Stop push button on the Walking Leg Main Control Panel. Actuators of emergency stop shall be colored RED. The background immediately around the device actuator shall be colored YELLOW. The actuator pushbutton operated device shall be of the palm or mushroom head type.

HAZARD REVIEW

Electrocution Hazard



Electrocution accidents are most likely to occur during maintenance of the electrical system or when working on or near exposed high voltage wiring. This hazard does not exist when the electrical power has been disconnected, properly locked, and tagged out.

Automatic Start Hazard



This equipment may be controlled by an automated system and may start without warning. Failure to properly disconnect, lockout, and tagout all energy sources of remotely controlled equipment creates a very hazardous situation and could cause injury or even death. PLEASE STAY CLEAR AND BE ALERT.

WALKING LEG BIN FILL SYSTEM

YOU are responsible for the **SAFE** operation and maintenance of your USC, LLC equipment . **YOU** must ensure that you and anyone else who is going to operate, maintain or work around the equipment be familiar with the operating and maintenance procedures and related **SAFETY** information contained in this manual. This manual will take you step-by-step through your working day and alert you to good safety practices that should be adhered to while operating the equipment

Remember, **YOU** are the key to safety. Good safety practices not only protect you, but also the people around you. Make these practices a working part of your safety program. Be certain that **EVERYONE** operating this equipment is familiar with the recommended operating and maintenance procedures and follows all the safety precautions. Most accidents can be prevented. Do not risk injury or death by ignoring good safety practices.

- Equipment owners must give operating instructions to operators or employees before allowing them to operate the machine, and at least annually thereafter per OSHA (Occupational Safety and Health Administration) regulation 1928.57.
- The most important safety device on this equipment is a **SAFE** operator. It is the operator's responsibility to read and understand **ALL** Safety and Operating instructions in the manual and to follow them. All accidents can be avoided.
- A person who has not read and understood all operating and safety instructions is not qualified to operate the machine. An untrained operator exposes himself and bystanders to possible serious injury or death.
- Do not modify the equipment in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the equipment.
- Think SAFETY! Work SAFELY!

GENERAL SAFETY

1. Read and understand the operator's manual and all safety labels before operating, maintaining, adjusting or unplugging the equipment .
2. Only trained persons shall operate the equipment . An untrained operator is not qualified to operate the machine.
3. Have a first-aid kit available for use should the need arise, and know how to use it.



WALKING LEG BIN FILL SYSTEM

4. Provide a fire extinguisher for use in case of an accident. Store in a highly visible place.
5. Do not allow children, spectators or bystanders within hazard area of machine.
6. Wear appropriate protective gear. This includes but is not limited to:
 - A hard hat
 - Protective shoes with slip resistant soles
 - Protective goggles
 - Heavy gloves
 - Hearing protection
 - Respirator or filter mask
7. Place all controls in neutral or off, stop motor, and wait for all moving parts to stop. Then disable power source before servicing, adjusting, repairing, or unplugging.
8. Review safety related items annually with all personnel who will be operating or maintaining the equipment.



OPERATING SAFETY:

1. Read and understand the operator's manual and all safety labels before using.
2. Disconnect and disable electrical supply completely and wait for all moving parts to stop before servicing, adjusting, repairing or unplugging.
3. Clear the area of bystanders, especially children, before starting.
4. Be familiar with the machine hazard area. If anyone enters hazard area, shut down machine immediately. Clear the area before restarting.
5. Keep hands, feet, hair and clothing away from all moving and/or rotating parts.
6. Stay away from overhead obstructions and power lines during operation and transporting. Electrocutation can occur without direct contact.
7. Do not operate machine when any guards are removed.
8. Inspect welds and repair if needed.

WALKING LEG BIN FILL SYSTEM

PLACEMENT SAFETY

1. Move only with the appropriate equipment
2. Stay away from overhead power lines when moving equipment. Electrocutation can occur without direct contact.
3. Be familiar with machine hazard area. If anyone enters hazard areas, shut down machine immediately. Clear the area before restarting.
4. Operate the equipment on level ground free of debris. Anchor the equipment to prevent tipping or upending.



Before placement of the equipment, be sure that ground is reasonably level. The equipment may topple or work improperly if the ground is too uneven, damaging the equipment and/or causing personal injury.

MAINTENANCE SAFETY

1. Review the operator's manual and all safety items before working with, maintaining or operating the equipment.
2. Place all controls in neutral or off, stop motors, disable power source, and wait for all moving parts to stop before servicing, adjusting, repairing or unplugging.
3. Follow good shop practices:
Keep service area clean and dry.
Be sure electrical outlets and tools are properly grounded.
Use adequate light for the job at hand.
4. Keep hands, feet, hair and clothing away from all moving and/or rotating parts.
5. Clear the area of bystanders, especially children, when carrying out any maintenance and repairs or making any adjustments.
6. Before resuming work, install and secure all guards when maintenance work is completed.
7. Keep safety labels clean. Replace any sign that is damaged or not clearly visible.



SAFETY LABELS

1. Keep safety labels clean and legible at all times.
2. Replace safety labels that are missing or have become illegible.
3. Replaced parts that displayed a safety sign should also display the current sign.
4. Replacement safety labels are available. Contact USC at (785) 431-7900 .

How to Install Safety Labels:

- Be sure that the installation area is clean and dry.
- Be sure temperature is above 50°F (10°C).
- Decide on the exact position before you remove the backing paper.
- Remove the smallest portion of the split backing paper.
- Align the sign over the specified area and carefully press the small portion with the exposed sticky backing in place.
- Slowly peel back the remaining paper and carefully smooth the remaining portion of the sign in place.
- Small air pockets can be pierced with a pin and smoothed out using the piece of sign backing paper.



Located on the USC equipment you will find safety labels. Always be sure to read and follow all directions on the labels.



Guards provided with USC equipment are to remain in place during operation.

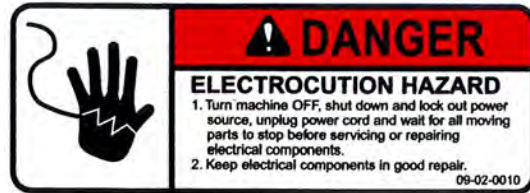
WALKING LEG BIN FILL SYSTEM

Think **SAFETY!** Work **SAFELY!**

REMEMBER—If Safety Labels have been damaged, removed, become illegible, or parts replaced without safety labels, new labels must be applied. New safety labels are available from USC at (785) 431-7900.



Part # 09-02-0003



Part # 09-02-0010



Part # 09-02-0001



Part # 09-02-0002

WALKING LEG BIN FILL SYSTEM



Part # 09-02-0007



Part # 09-02-0006



Part # 09-02-0011



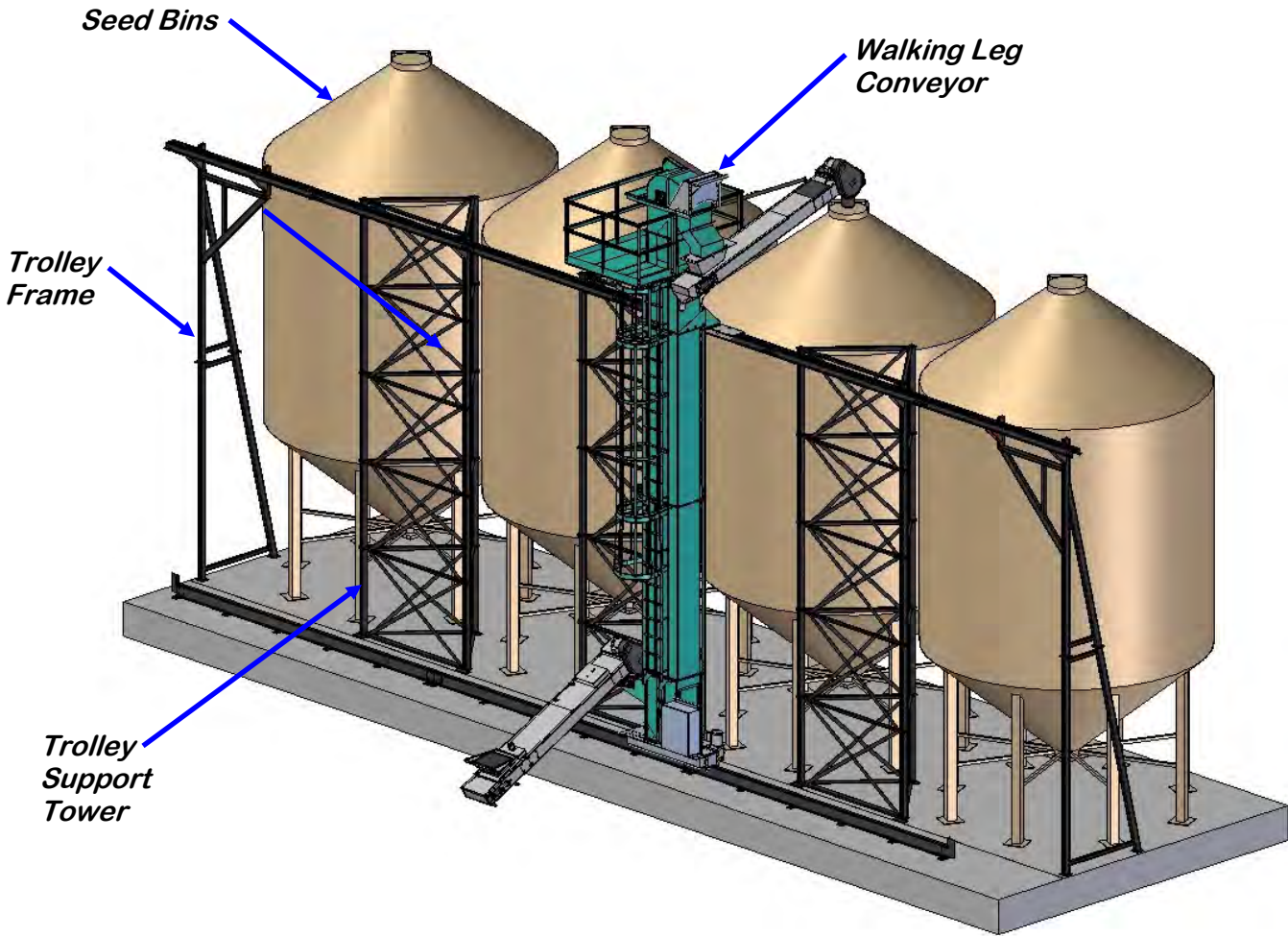
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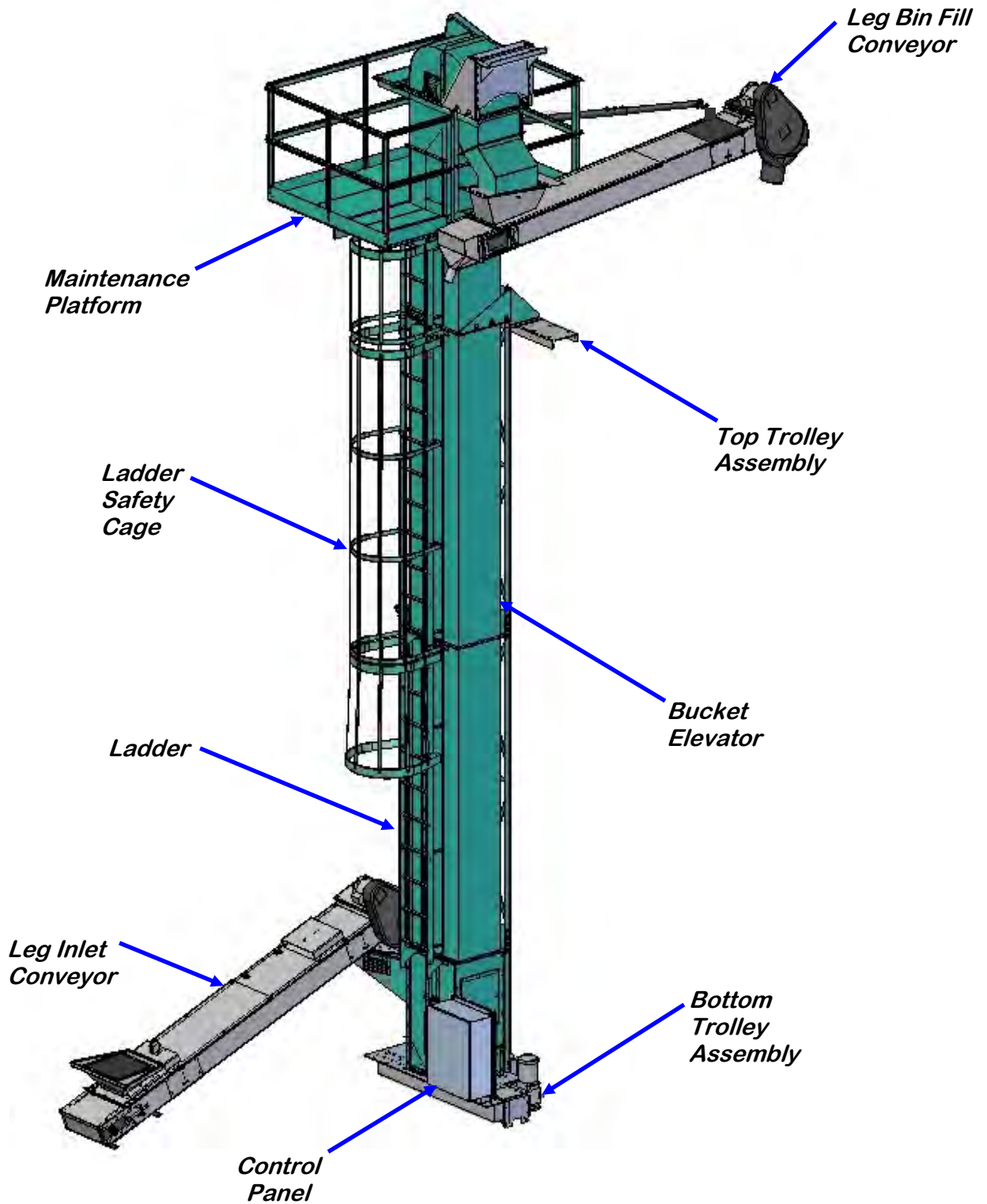
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SECTION B **MECHANICAL OPERATION**

WALKING LEG BIN SITE OVERVIEW



WALKING LEG CONVEYOR OVERVIEW



LEG FEED CONVEYOR

The leg feed conveyor is a pivoting conveyor that is connected to the leg and is used to transport seed from the truck unload conveyor to the leg. This conveyor's intake hopper will sit directly under the discharge portion of the truck unload conveyor and the leg feed conveyor will discharge directly into the leg. The height of the intake end of the leg feed conveyor can be adjusted by using the electric winch that is connected to the conveyor assembly.

LEG

The leg is a moveable bucket elevator that is used to transport seed from the discharge end of the leg fill conveyor to the intake of the bin fill conveyor. The leg is used as the device that moves the seed from the ground level to above the seed bins. A clean out door is located at the bottom of the leg for easy access to the buckets and quick clean out. The leg rests on an electrically controlled trolley that allows the leg to be positioned to fill the seed bins or a down spout to an alternate, empty seed bin so the customer may bring their own seed to be treated. A system of metal supports and tracks guides the leg as it travels to the back seed bin or alternate hopper down spout .

BIN FILL CONVEYOR

The bin fill conveyor is a fixed conveyor that is connected to the top of the leg and is used to transport seed from the discharge end of the leg to the top of the seed bins or a down spout to an alternate, empty seed bin so the customer may bring their own seed to be treated. This conveyor's intake hopper will sit directly under the discharge portion of the leg and the discharge end of the bin fill conveyor will be directly above the center of the seed bins or alternate discharge spout, depending upon the current position of the leg. Ensure that the lid for the seed bin or alternate down spout is open before aligning the bin fill conveyor directly over either one of these components.

ELECTRICAL OPERATION

SECTION C



HIGH VOLTAGE ~ Always disconnect the power source before working on or near the control panel or lead wires.



HIGH VOLTAGE ~ Use insulated tools when making adjustments while the controls are under power.



AUTHORIZED PERSONNEL only shall work on the control panel. Never allow anyone who has not read and familiarized themselves with the owner's manual to open or work on the control panel.

This section provides a general overview and description of the operator controls for the Walking Leg.

General Panel Descriptions

This system consists of one panel:

- The Control Panel is a 36 x 24 x 10 inch enclosure that contains all of the electrical control components. The front of the panel has a On / OFF power switch, Emergency Stop pushbutton and five additional switches to control the various components of the Walking Leg.
- The Walking Leg control package comes with a Lodar remote control system to control the trolley drive motor. This allows the operator to stand away from the control panel so they can see the top of the bins. This makes positioning the bin fill conveyor directly over the bin they wish to load seed into easier. The remote comes with a receiver (right) that may be mounted on or near the control panel and is hard wired to the panel. See page 19 for remote controller functions.



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WALKING LEG CONTROL PANEL

This following is a general overview of the control panel switches. The green switches are spring return to center and will illuminate when activated.



1. EMERGENCY STOP PUSHBUTTON: Pressing this button immediately shuts off all power to the Walking Leg control panel, stopping all of the motors simultaneously. The operator must pull the switch out to return power to the panel. Each individual motor must then be manually restarted.

2. TROLLEY DRIVE MOTOR SWITCH: When in the vertical position the motor is off. Turn to the left to put the drive motor in reverse, moving the leg to the left. Turn to the right to put the drive motor in forward, moving the leg to the right.

3. BIN FILL CONVEYOR SWITCH: Turn the switch to the left to stop the conveyor motor. Turn the switch to the right to start the conveyor motor.

4. LEG FEED CONVEYOR SWITCH: Turn the switch to the left to stop the conveyor motor. Turn the switch to the right to start the conveyor motor.

5. ON/OFF SWITCH: The horizontal position turns the power to the panel OFF as shown above. The vertical position turns the power to the panel ON.

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6. LEG MOTOR SWITCH: Turn switch to the left to stop the bucket elevator motor. Turn switch to the right to start the bucket elevator motor

7. TRUCK UNLOAD CONVEYOR SWITCH: There is a receptacle on the right side of the control panel to plug the Truck Unload conveyor into. Turn the switch to the left to stop the conveyor motor. Turn the switch to the right to start the conveyor

WALKING LEG REMOTE CONTROL

The following is a general overview of the remote sending unit, it comes with a lanyard and belt attachment.



1. OFF BUTTON: Press this button to turn OFF the remote sending unit.

2. ON / OFF STATUS INDICATOR: When the remote sending unit is OFF, the indicator will be red. When the remote sending unit is ON, the indicator will be green.

3. TROLLEY MOTOR REVERSE BUTTON: Pressing this button will put the trolley motor in reverse and the leg will move to the left.

4. ON BUTTON: Press this button to turn ON the remote sending unit.

5. TROLLEY MOTOR FORWARD BUTTON: Pressing this button will put the trolley motor in forward and the leg will move to the right.

**SECTION
D**

TROUBLESHOOTING

Below is a table describing the most frequent problems and solutions with the Walking Leg Conveyor. For further assistance, contact USC at (785) 431-7900.

Problem	Possible Cause	Solution
Conveyor will not run.	<ol style="list-style-type: none"> 1. Not turned on. 2. Conveying belt loose. 3. Drive belt loose. 	<ol style="list-style-type: none"> 1. Start power source or turn on power. 2. Tighten and align belt. 3. Tighten drive belt.
Belt edge fraying.	<ol style="list-style-type: none"> 1. Belt not aligned. 	<ol style="list-style-type: none"> 1. Align and tension belt.
Low conveying capacity.	<ol style="list-style-type: none"> 1. Angle too steep. 2. Slow operating speed. 3. Conveyor belt slipping. 4. Drive belt slipping. 	<ol style="list-style-type: none"> 1. Reposition with angle at 30°. 2. Increase operating speed. 3. Tighten belt. 4. Set drive belt tension.

Unplugging

In unusual moisture or material conditions, the machine can plug. When unplugging, follow this procedure:

1. Place all controls in neutral or off, stop motor, disable and lock out power source before unplugging.
2. Unbolt and remove the necessary conveyor covers.
3. Open the tail cover.
4. Remove plugged material.
5. Install and secure conveyor and tail covers.

For unplugging of the bucket elevator, refer to the RAPAT Corp. bucket elevator installation, maintenance and operators manual supplied with your bucket elevator. If you are unable to locate the manual, contact USC at (785) 431-7900.

MAINTENANCE

SECTION E

Proper maintenance of the Walking Leg is critical for peak performance, reliability and accuracy of this system. The following is a guideline for the type of maintenance and servicing that should be performed on this unit. Your environment and uses may require additional maintenance and service beyond this list to assure a reliable and safe unit. The operator of this unit has ultimate responsibility to identify areas of concern and rectify them before they become a hazard or safety issue. There is no substitute for a trained, alert operator.



DANGER Do not put this unit into operation with any questionably maintained parts. Poor performance or a hazard may occur.

FLUIDS AND LUBRICANTS

Grease

Use an SAE multipurpose high temperature grease with extreme pressure (EP) performance. Also acceptable is an SAE multipurpose lithium-based grease.

Storing Lubricants

Your machine can operate at top efficiency only if clean lubricants are used. Use clean containers to handle all lubricants. Store them in an area protected from dust, moisture and other contaminants.

GREASING

Use a Maintenance Checklist to keep record of all scheduled maintenance.

1. Use a hand-held grease gun for all greasing.
2. Wipe grease fitting with a clean cloth before greasing to avoid injecting dirt and grit.
3. Replace and repair broken fittings immediately.

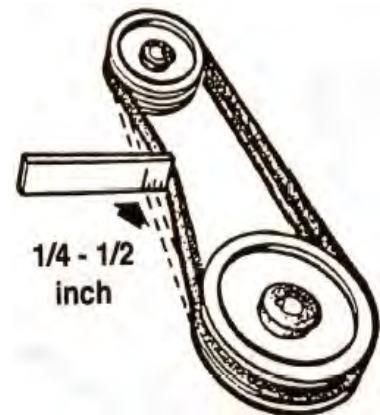
NOTICE

If fittings will not take grease, remove and clean thoroughly. Also clean lubricant passageway. Replace fitting if necessary.

SERVICING INTERVALS

Every 40 hours or Weekly

1. Check the conveyor belt tension and alignment.
2. Grease conveyor bearings.
 - Two bolt flanged bearings, tail roller bearings right and left (2 locations).
 - Two bolt flanged bearings, drive roller bearings right and left (2 locations).
 - Two bolt flanged bearings, jackshaft bearings right and left (2 locations).
3. Remove guard and check the drive belt tension and alignment. The belts will deflect approximately 1/4 to 1/2 inch when properly tensioned.
4. Check the chain tension. Adjust if required, lubricate chain and re-install guard.



Every 200 hours or Annually

1. Repack wheel bearings.
2. Wash machine.
3. Check pulley bushing for wear. To inspect pulley:
 - Lower the conveyor to its lowest position.
 - When the conveyor has reached the lowest position, it will stop on the hinge support.
 - Loosen and remove the bolt.
 - Inspect the bushing on the pulley for wear.
 - Reverse steps for re-assembly.

CONVEYING BELT TENSION AND ALIGNMENT-TAIL END

A contoured belt with molded flights is used to convey material along the frame. The tension and alignment of the belt should be checked weekly, or more often if required, to be sure that it does not slip or run to one side. A properly tensioned belt will not slip when it is operating. Operating the belt with less slippage will increase the belt life and causes less stress on bearings, pulleys and shafts.

WARNING

Although it is acceptable to align the belt from either the Head or the Tail (Intake) end. Tightening the belt may only be done from the Tail end of the conveyor

To maintain the belt, follow this procedure:

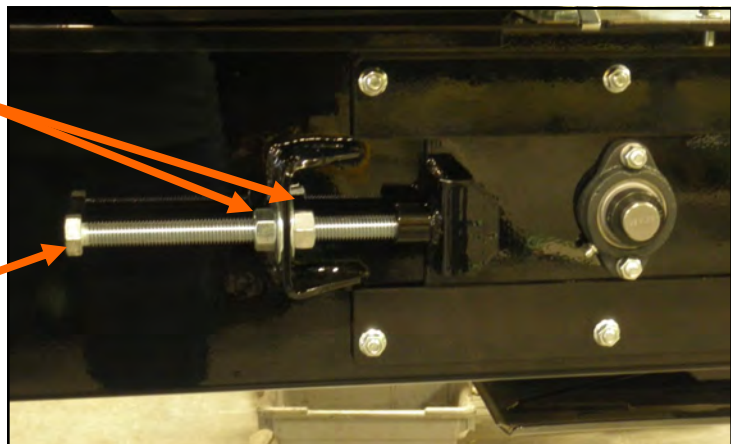
NOTICE

Place all controls in neutral or off, stop motor and disable power source before working on belt.

1. Use the take-up bolt located at the tail to set the tension of the belting.
2. If the belt needs to be tightened to prevent slippage, use the take-up adjustments on the tail end only.
3. The belt is tightened by turning both take-up adjustments an **equal** number of turns.
4. Use the drive roller to check the alignment. The belt should be centered.
5. Turn the belt 1/2 revolution when the belt is new and check the drive and tail roller. If out of alignment, the belt will move to the loose side. Loosen the jam nut and use the bearing position bolts to set the position. Tighten jam nut.
6. Run and check again. Check frequently during the first few minutes of operation and then several times during the first 10 hours. The belt normally seats itself during the first 10 hours of operation and can be checked weekly after that.
7. The belt is properly aligned when the belt runs in the center of the head and tail rollers.

Loosen this jam nuts before adjusting the bearing position bolt

Use this bolt to tighten and align the belt

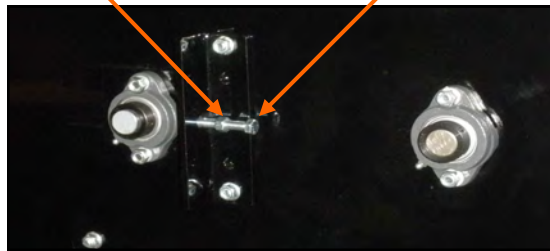


CONVEYING BELT ALIGNMENT - HEAD END

1. A misaligned belt will track toward the loose side. Set the tracking by loosening the bearing mounts on the tight side and using the bearing position bolt to move the end of the head roller toward the tail. Tighten the bearing mount when the belt is centered on the head roller.
2. Run the belt and check the tracking again. Loosen the tight side slightly again if required. Repeat the adjusting and checking procedure until the belt centers on the input end roller and remains centered when running.
3. Always repeat this aligning procedure when installing a new belt. Check frequently during the first 10 hours of operation. After 10 hours, the belt is normally seated and checking the alignment can be done less frequently.

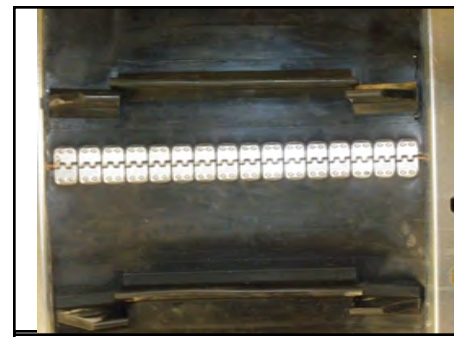
*Tighten jam nut
after adjustment*

*Use this bolt to
align the belt*



BELT REPLACEMENT

1. Rotate the belt until the seam is visible.
2. Move the tail roller to its loosest position.
3. Pull all the slack to the seam area.
4. Remove the wire connector and open the belt.
5. Attach one end of the replacement belt to the belt end being removed.
6. Pull the old belt out and the new belt will be threaded into place.
7. Disconnect the old belt.
8. Connect the ends of the new belt together and secure.
9. Set the belt tension.
10. Check and set the belt alignment



Belt Seam



Check Alignment

DRIVE BELT TENSION & ALIGNMENT

Power to the conveying belt is transmitted through a V-belt. The V-belt drive system must be maintained at the proper belt tension and pulley alignment to obtain the desired performance and life. When maintaining the belt drive system for the electric drive model, follow this procedure:

NOTICE

Turn motor off and unplug power cord or turn off power and lock out the master panel before starting maintenance on drive belt system.

Drive Belt Tension

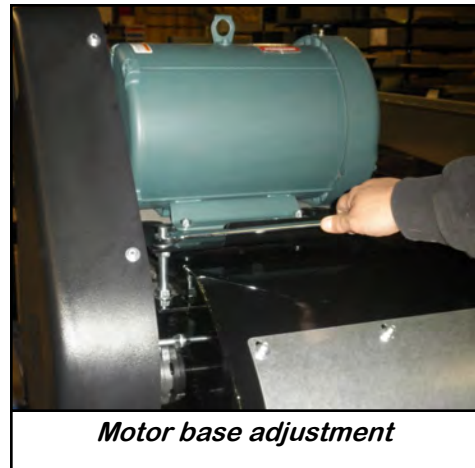
1. Push on the center of the belt span with a force of approximately 5 to 10 lbs.
2. Follow the belt tensioning specification on page 27 to determine proper belt deflection.
3. Move the motor up, using the adjustment bolts, to set drive belt tension (top, right).
4. Close and secure guards.

Drive Belt Alignment

1. Lay a straightedge across the pulley faces to check the alignment (bottom, right).
2. Use the pulley hub or the motor mounting plate slots to move the pulley to the required position for alignment.
3. Tighten hub bolts to secure pulley on shaft.
4. Check belt tension
5. Close and secure guards.

Drive Belt Replacement

1. Lower motor to its loosest position.
2. Remove old belt and replace with a new one.
3. Raise motor to set the belt tension.
4. Check pulley alignment. Adjust if required.
5. Close and secure guards.



Motor base adjustment



Lay a straightedge across

WALKING LEG BIN FILL SYSTEM

ELECTRICAL PANEL

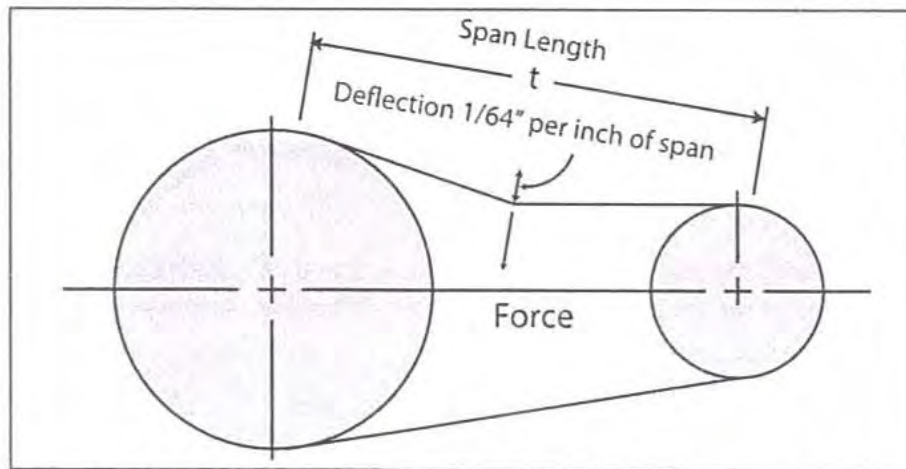
1. Check and tighten wire connections.
2. Check quick connects on bottom of control panel.
3. Check to see if starters and or overloads are tripped.
4. Check to see if relays, timers and or breakers are tripped.
5. Check quick connects on end of Auxiliary cord.
6. Check and tighten wire connections.
7. Check relay and fuse holder.

For maintenance of the bucket elevator, refer to the RAPAT Corp. bucket elevator installation, maintenance and operators manual supplied with your bucket elevator. If you are unable to locate the manual, contact USC at (785) 431-7900.

BELT TENSIONING SPECIFICATION

SECTION F

V-Belt tensioning adjustment can be made using a tension meter or other type spring scale using the following procedure. After seating the belts in the groove and adjusting center distance so as to take up the slack in the belts, further increase the tension until only a slight bow on the slack side is apparent while the drive is operating under load. Stop the drive and using the meter, measure the force necessary to depress one of the center belts 1/64 inch for every inch of belt span (see sketch below). For example, a deflection for a 50 inch belt span is 50/64 or 25/32 inch. The amount of force required to deflect the belt should compare with the deflection forces noted in the table below. Also notice for V- Belts that deflection forces vary from the initial RUN - IN values which are greater (reflecting higher run-in tensioning) to the NORMAL values for after the run-in period.



MEASURE THE SPAN LENGTH "T" AS SHOWN IN THE SKETCH ABOVE.

BELT CROSS SECTION	SMALLER PULLEY DIAMETER RANGE (inches)	DEFLECTION FORCE	
		RUN - IN (lbs)	NORMAL (lbs)
AX	3.0 - 3.6	4 - 1/8	2 - 3/4
	3.8 - 4.8	5	3 - 1/4
	5.0 - 7.0	6	4
BX	3.4 - 4.2	5 - 1/4	3 - 1/2
	4.4 - 5.2	7 - 1/8	4 - 3/4
	5.4 - 9.4	9	6

**SECTION
G****STORAGE**

When storing the Walking Leg for long periods of time, the following procedure must be followed to reduce the chance of rust, corrosion and fatigue of the conveyor. You can also use these steps when storing the machine for the winter.



A dust mask and protective rubber gloves shall be used when cleaning the machine.

1. Clear the area of bystanders, especially small children.
2. Thoroughly wash the entire machine to remove all dirt, mud, debris or residue.
3. Inspect all moving or rotating parts to see if anything has become entangled in them. Remove the entangled material.
4. Lubricate all grease fittings. Make sure that all grease cavities have been filled with grease to remove any water residue from the washing. This also protects the bearing seals.
5. Remove drive assembly covers. Clean entire area and ensure drive belt and chain are clean and free of debris. Lubricate drive chain.
6. Touch up all paint nicks and scratches to prevent rusting.
7. Cover the electric motors with a water proof tarpaulin and tie securely in place.

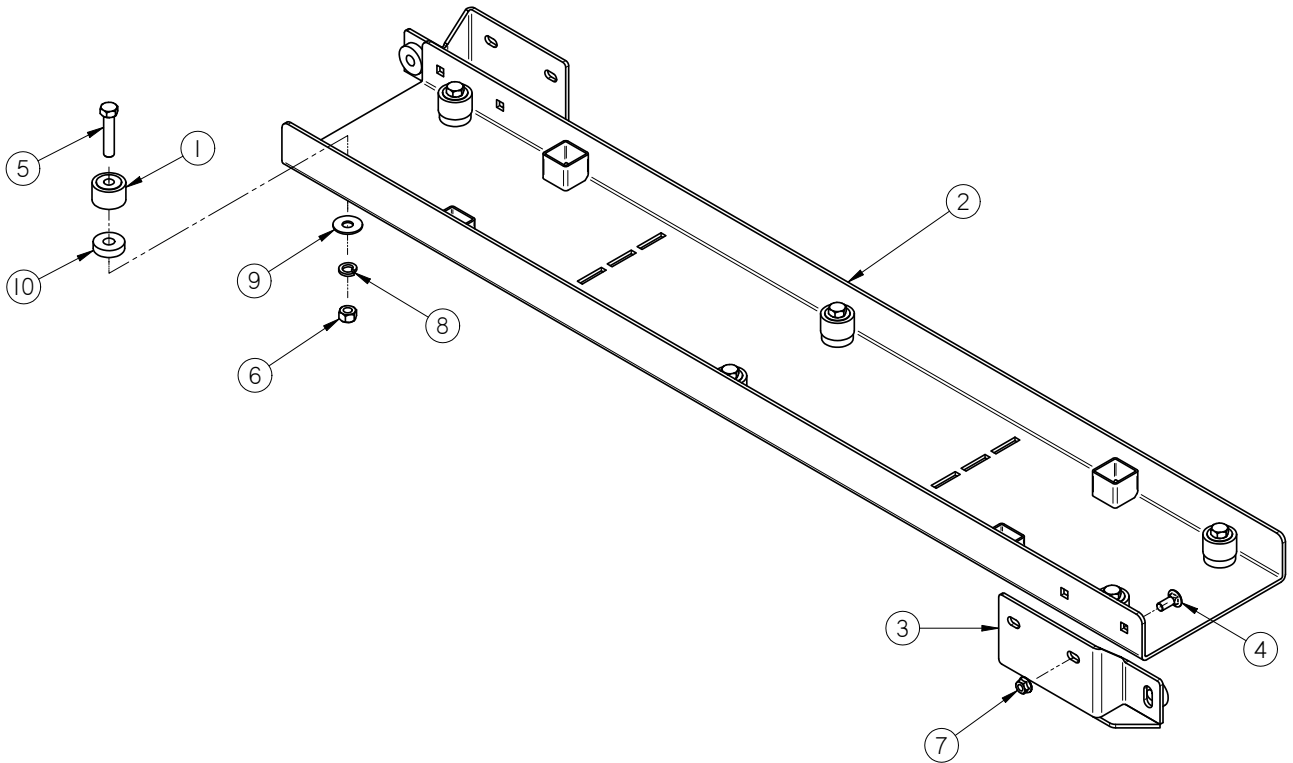
WALKING LEG BIN FILL SYSTEM

NOTES:

SECTION
H

MECHANICAL DRAWINGS

TROLLEY TOP ASSEMBLY (05-07-0226)



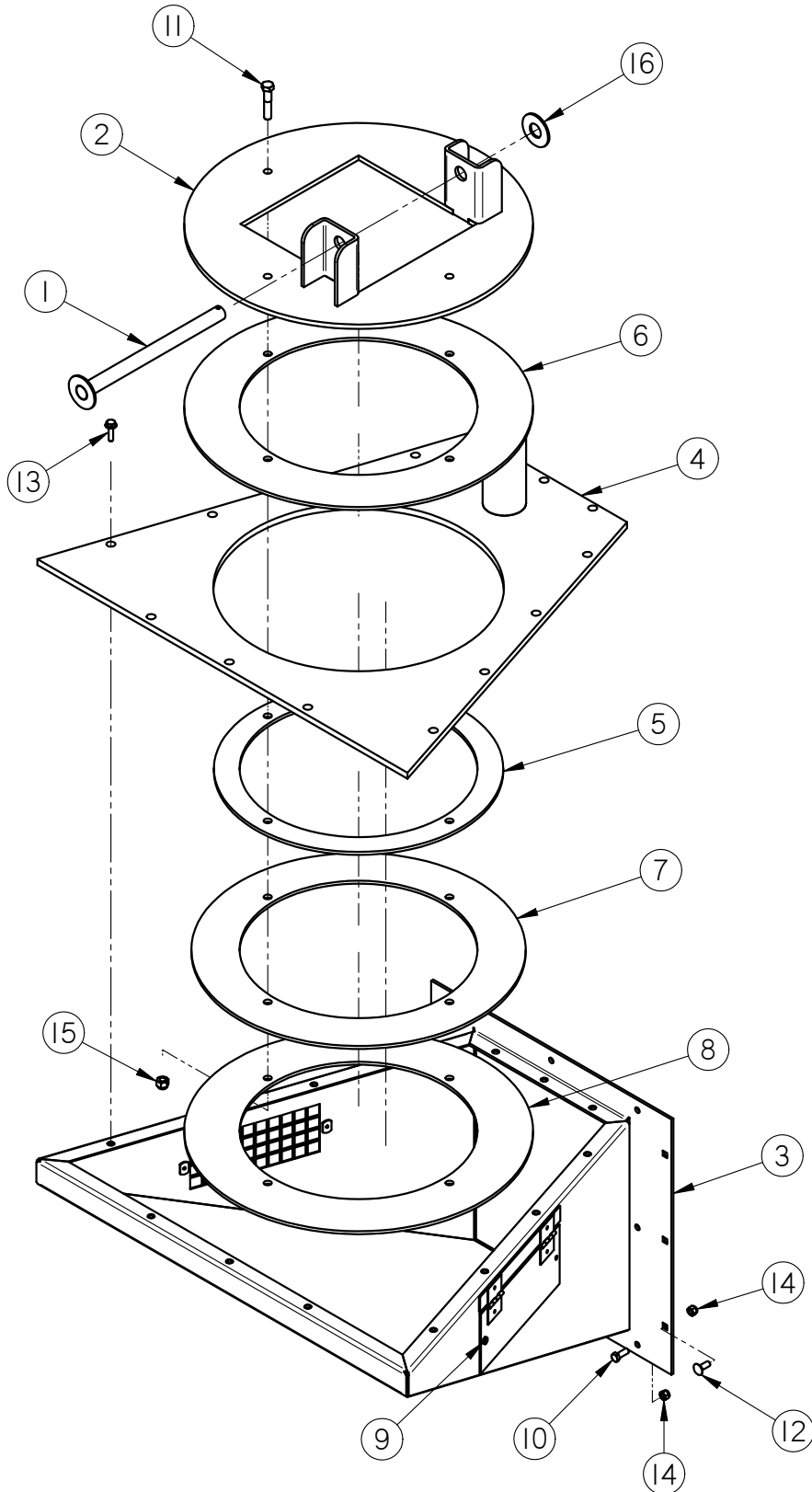
WALKING LEG BIN FILL SYSTEM

TROLLEY TOP ASSEMBLY (05-07-0226)

Item #	Part #	Description	Qty
1	01-06-0095	RLR CROWNED 2.0OD X 1.25WD .625B	6
2	05-03-0564	WDMT TRLY TOP	1
3	05-07-0287	ASSY TOP TRLY END RLR	2
4	06-01-0062	BOLT CRG .500-13 X 1.125 ZP GR5	4
5	06-01-0200	BOLT .625-11 X 3.00 ZP GR5	6
6	06-02-0005	NUT, .625-11 UNC ZP GRADE 5	6
7	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	4
8	06-04-0005	WASHER, .625 LOCK ZP	6
9	06-05-0006	WASHER, .625 FLAT ZP	6
10	100E8C	100E8C	6

WALKING LEG BIN FILL SYSTEM

INLET HOPPER PIVOT ASSEMBLY (05-07-0242)



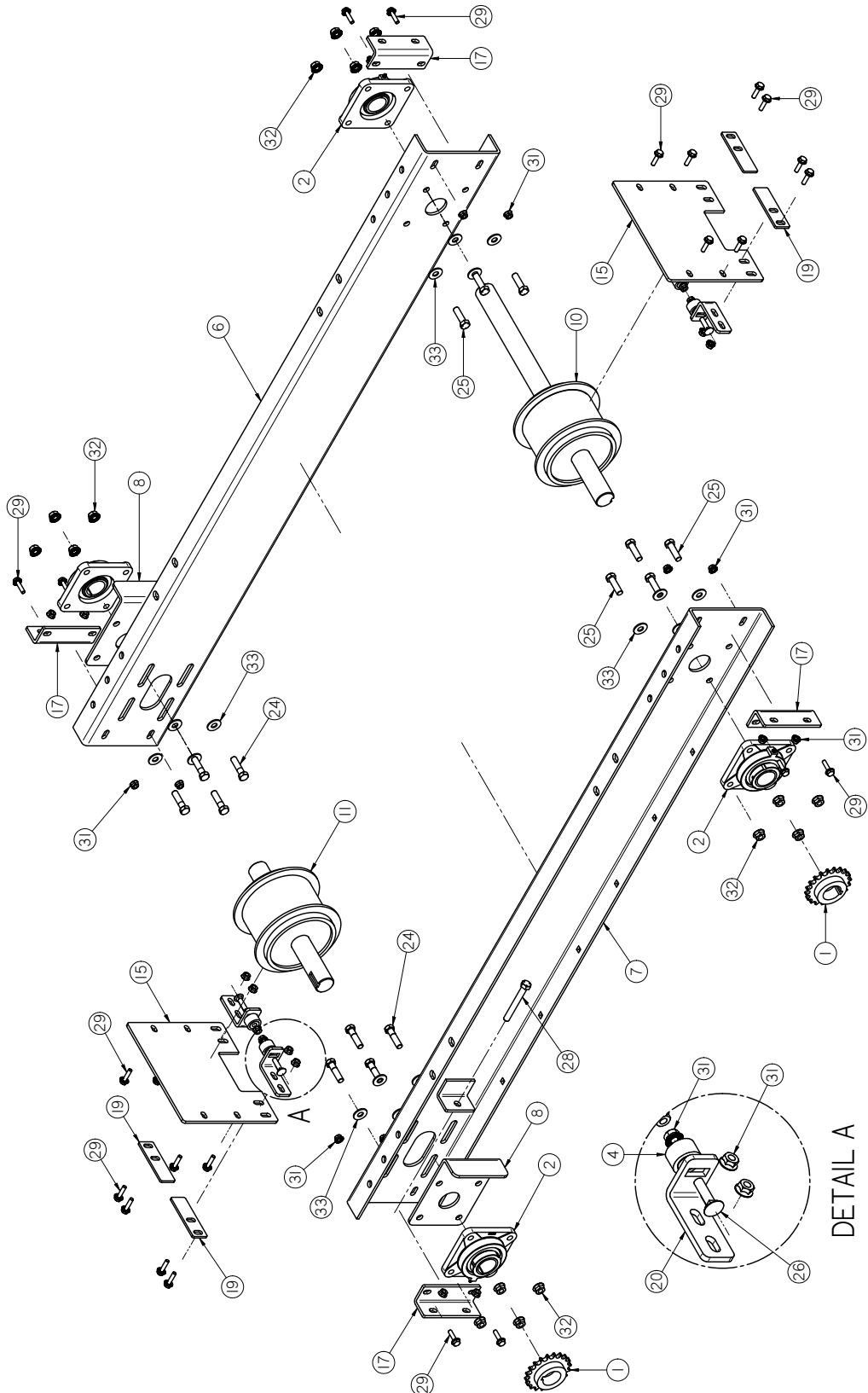
WALKING LEG BIN FILL SYSTEM

INLET HOPPER PIVOT ASSEMBLY (05-07-0242)

Item #	Part #	Description	Qty
1	05-03-0569	WDMT BOOT INLET PIVOT BAR	1
2	05-03-0591	WDMT CNVR PIVOT INLET BOOT	1
3	05-03-0622	WDMT BOOT INLET HOPPER	1
4	05-03-0665	WDMT BOOT TOP INLET HOPP	1
5	05-10-3236	RING CTR SPCR LEG INLET BOOT	1
6	05-10-3302	RING TOP LEG INLET BOOT	1
7	05-10-3303	RING SPCR INLET BOOT	1
8	05-10-3304	RING HOLDER BTTM LEG INLET BOOT	1
9	06-01-0007	BOLT, .250-20 X 1 UNC ZP GRADE 5	4
10	06-01-0016	BOLT .375-16 X 1.00 ZP GR5	8
11	06-01-0028	BOLT .500-13 X 2.50 ZP GR5	4
12	06-01-0115	BOLT CRG .375-16 X 1.00 ZP GR5	6
13	06-01-0189	BOLT, FLG .375-16 UNC ZP GRADE 5; 1-1/4" LG	14
14	06-03-0003	NUT NYL LOCK .375-16 ZP GR5	14
15	06-03-0004	NUT NYL LOCK .500-13 ZP GR5	4
16	06-05-0010	WASHER, 1.00 FLAT ZP	1
17	06-09-0023	.188 X 2.00 ZP COTTER PIN	1

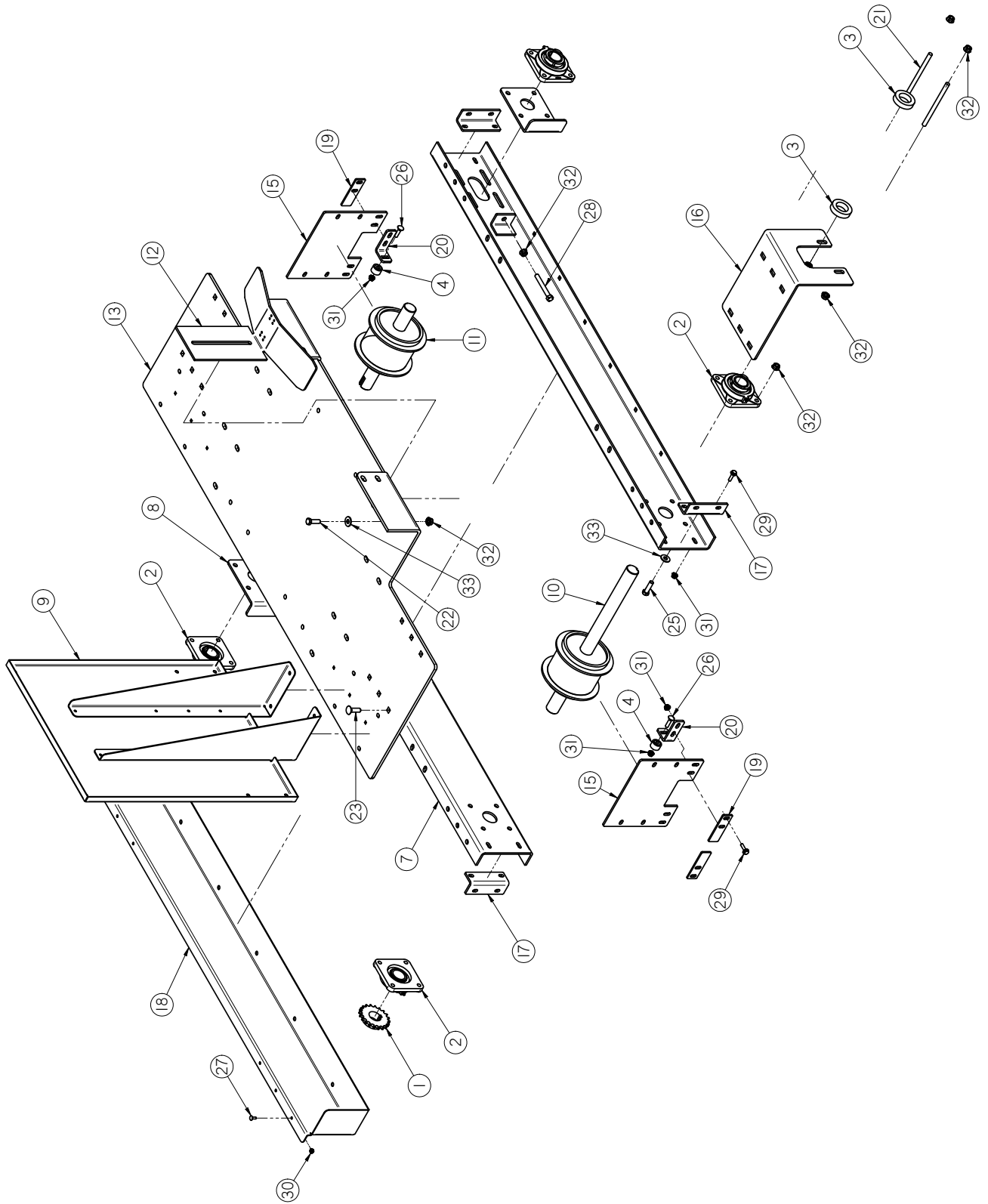
WALKING LEG BIN FILL SYSTEM

BOTTOM TROLLEY ASSEMBLY (05-07-0657)



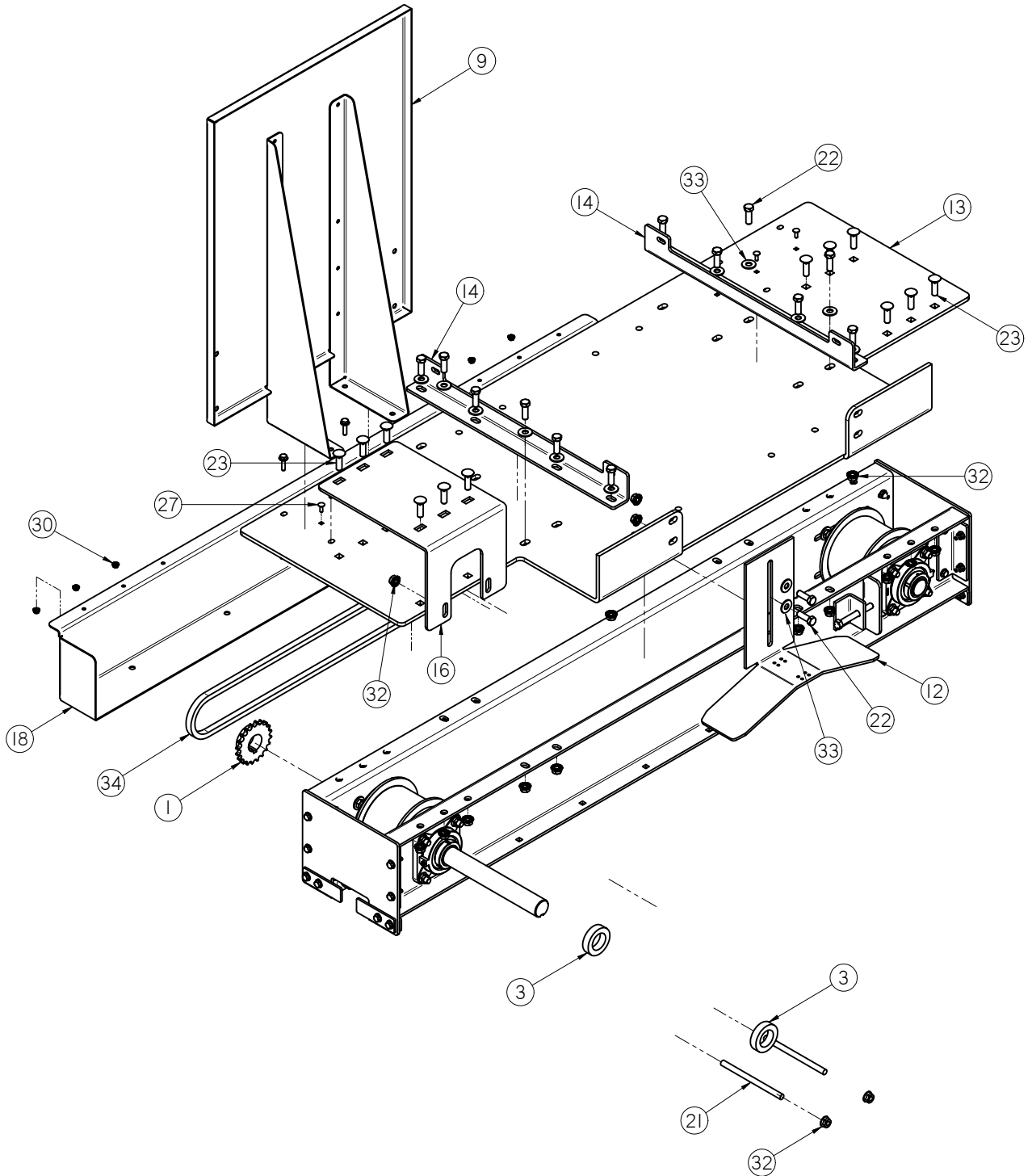
WALKING LEG BIN FILL SYSTEM

BOTTOM TROLLEY ASSEMBLY (05-07-0657)



WALKING LEG BIN FILL SYSTEM

BOTTOM TROLLEY ASSEMBLY (05-07-0657)

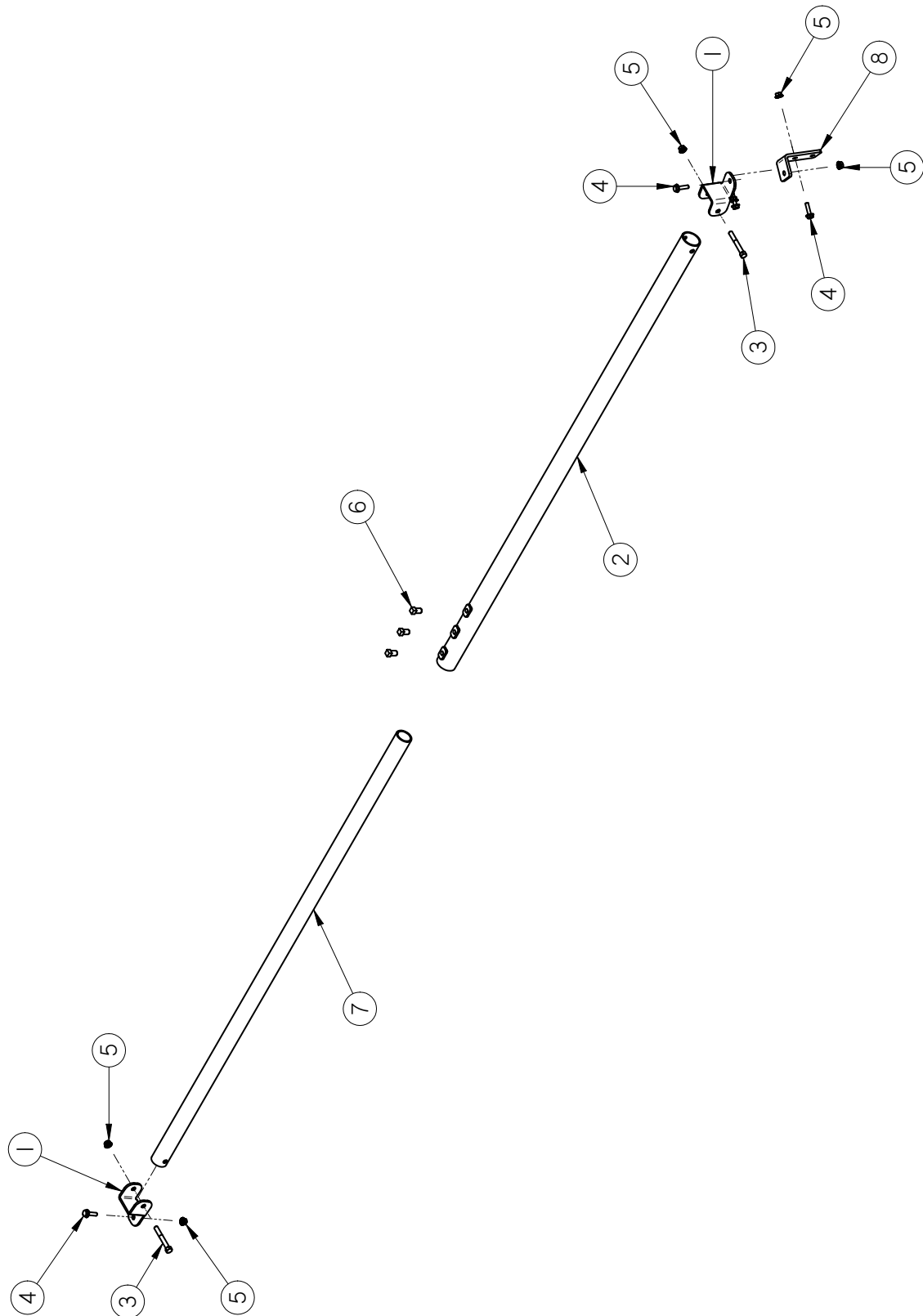


WALKING LEG BIN FILL SYSTEM

BOTTOM TROLLEY ASSEMBLY (05-07-0657)

Item #	Part #	Description	Qty
1	01-02-0104	SPKT 20T 50P 1.6875ID KWY TYPE B	2
2	01-03-0040	BRG FLG MNTG 1.6875ID 4BOLT 4IN CTR	4
3	01-05-0025	SHAFT CLR 1.6875 2PC	2
4	01-06-0025	RLR CROWNED 1.25ODX.75WD .375B	4
5	01-10-0015	3/8" KEY, CS - 1 1/2" LONG	3
6	05-03-0906	WDMT BTM TRLY SUPP CHN 1	1
7	05-03-0907	WDMT BTM TRLY SUPP CHN 2	1
8	05-03-0908	WDMT BTM TRLY CHN TNSNR BRKT	2
9	05-03-1278	WDMT BTM TRLY CTRL BOX MNT	1
10	05-08-0083	WDMT DRV WHL BTM TRLY	1
11	05-08-0084	WDMT IDLER WHL BTM TRLY	1
12	05-10-3226	BRKT CBL TRACK MNT	1
13	05-10-3764	PLT BTM TRLY LEG MNT	1
14	05-10-3765	BRKT BTM TRLY LEG SUPP	2
15	05-10-3766	PLT BTM TRLY END STOP	2
16	05-10-3767	BRKT BTM TRLY MTR MNT	1
17	05-10-3768	BRKT BTM TRLY END STOP MNT	4
18	05-10-3769	GRD BTM TRLY CHAIN	1
19	05-10-3770	BRKT BTM TRLY END CATCH	4
20	05-10-3771	BRKT BTM TRLY END RLR MNT	4
21	05-11-0298	MNT BTM TRLY GMTR FTH ROD	2
22	06-01-0025	BOLT .500-13 X 1.50 ZP GR5	22
23	06-01-0026	BOLT CRG .500-13 X 1.75 ZP GR5	12
24	06-01-0027	BOLT .500-13 X 2.00 ZP GR5	8
25	06-01-0054	BOLT .500-13 X 1.75 ZP GR5	8
26	06-01-0090	BOLT, CARRIAGE, .375-16 X 1.50 ZP G5	4
27	06-01-0122	BOLT, CARRIAGE, .250-20x.75 G5 ZP	6
28	06-01-0157	BOLT, .500-13 X 4" UNC ZP GRADE 5 fth	2
29	06-01-0189	BOLT FLG .375-16 X 1.250 ZP GR5	32
30	06-03-0013	NUT,LOCK, FLG .250-20 ZP SERRATTED	6
31	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	36
32	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	56
33	06-05-0005	WSHR FLAT .500 ZP	30
34	13-05-0198	CHAIN #50 BTM TRLY DRV	1

BIN FILL CONVEYOR BRACE ASSEMBLY (05-07-0250)



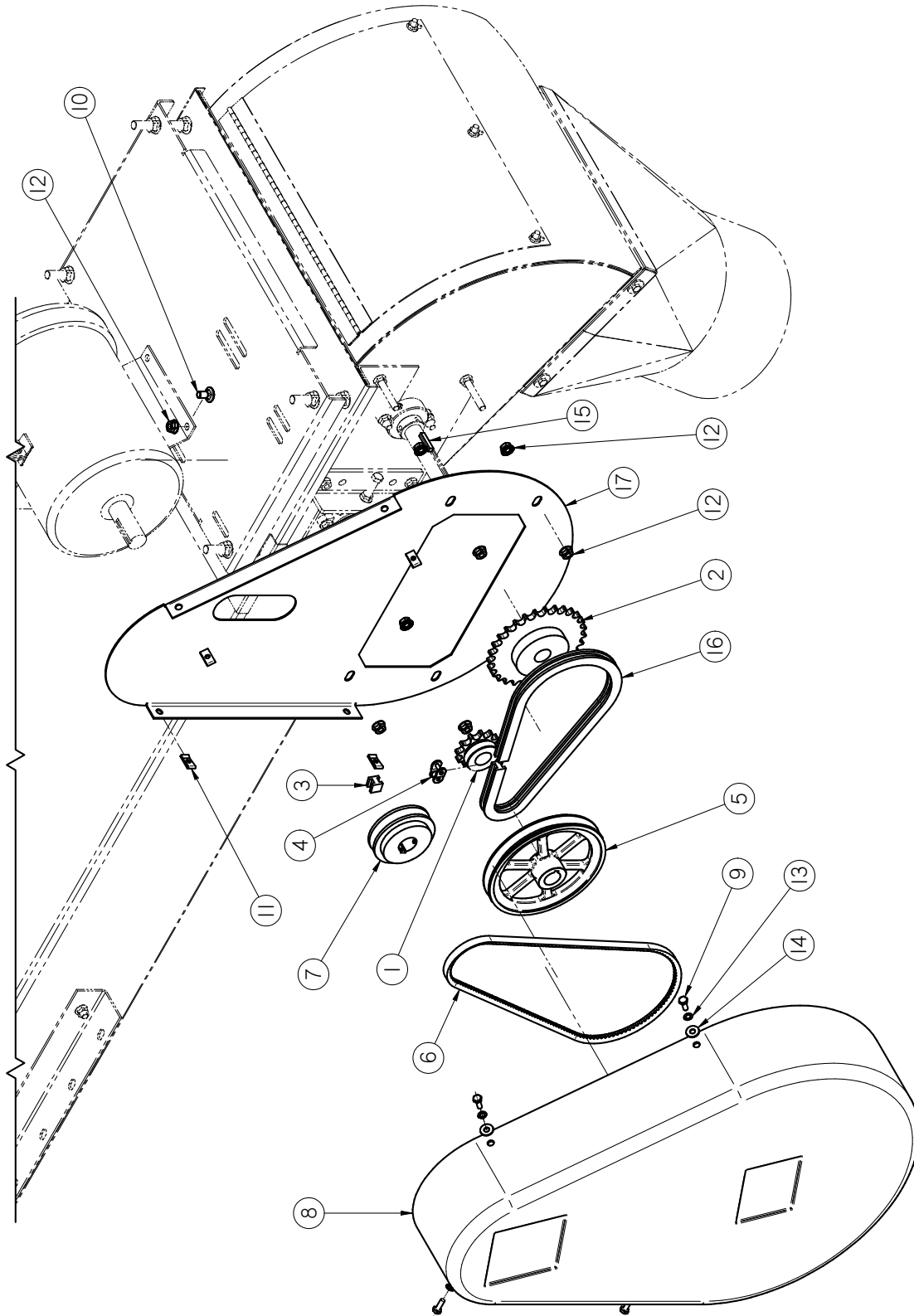
WALKING LEG BIN FILL SYSTEM

BIN FILL CONVEYOR BRACE ASSEMBLY (05-07-0250)

Item #	Part #	Description	Qty
1	05-03-1459	WDMT BRKT LEG CNVR BRACE	2
2	05-03-1460	WDMT TUBE LEG CNVR BRACE	1
3	06-01-0021	BOLT .375-16 X 3.00 ZP GR5	2
4	06-01-0189	BOLT FLG .375-16 X 1.250 ZP GR5	4
5	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	6
6	06-06-0069	SCRW SQHD .50-13 X .75 CUP PNT	3
7	10118B	TBE CNVR TOP PVT	1
8	10118D	BRACE MNT BRKT	1

WALKING LEG BIN FILL SYSTEM

5 HP MOTOR DRIVE ASSEMBLY (13-05-0210)



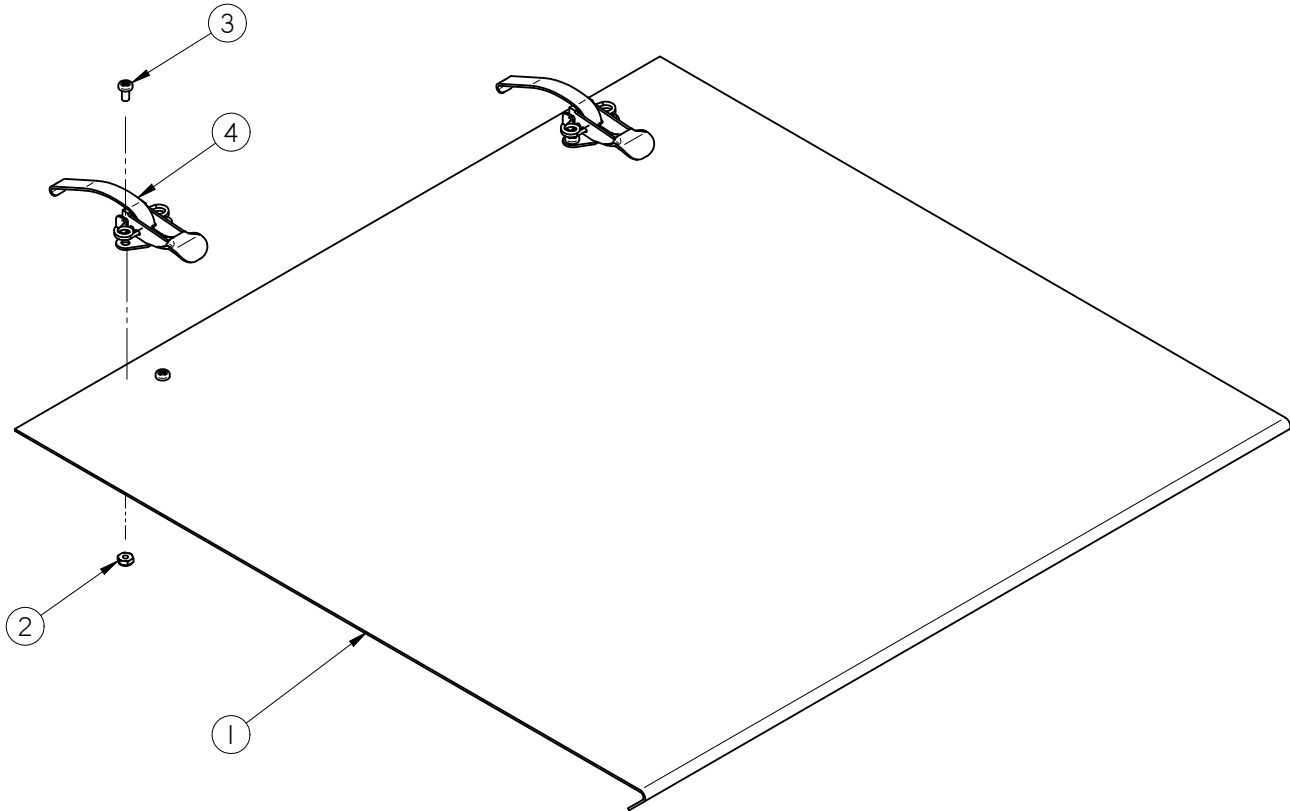
WALKING LEG BIN FILL SYSTEM

5 HP MOTOR DRIVE ASSEMBLY (13-05-0210)

Item #	Part #	Description	Qty
1	01-02-0076	Sprocket #50 12T 1.0000 in Bore Type B	1
2	01-02-0109	Sprocket #50 29T 1.00 in Bore Type B	1
3	01-04-0005	#50 CNTG LINK	1
4	01-04-0007	#50 OFFSET LINK	1
5	01-08-0058	SHEAVE BK75 1.00 BORE	1
6	01-08-0059	BELT BX38	1
7	01-08-0063	SHV BK36 1.125 FSH BORE	1
8	05-06-0035	DRIVE SHIELD MOLDED	1
9	06-01-0006	BOLT .250-20 X .750 ZP GR5	4
10	06-01-0153	BOLT CRG .375-16X.750 ZP SHORT NECK	4
11	06-02-0047	NUT .250-20 U-CLIP NUT	4
12	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	12
13	06-04-0001	WSHR LOCK SPLT .250 ZP	4
14	06-05-0001	WASHER, FLAT .250	4
15	106-3-2036	KEY .250 X 1.25 CS	3
16	13-05-0185	50 ROLLER CHAIN 28.5IN	1
17	280-3-0053	SHIELD BACKPLATE	1

WALKING LEG BIN FILL SYSTEM

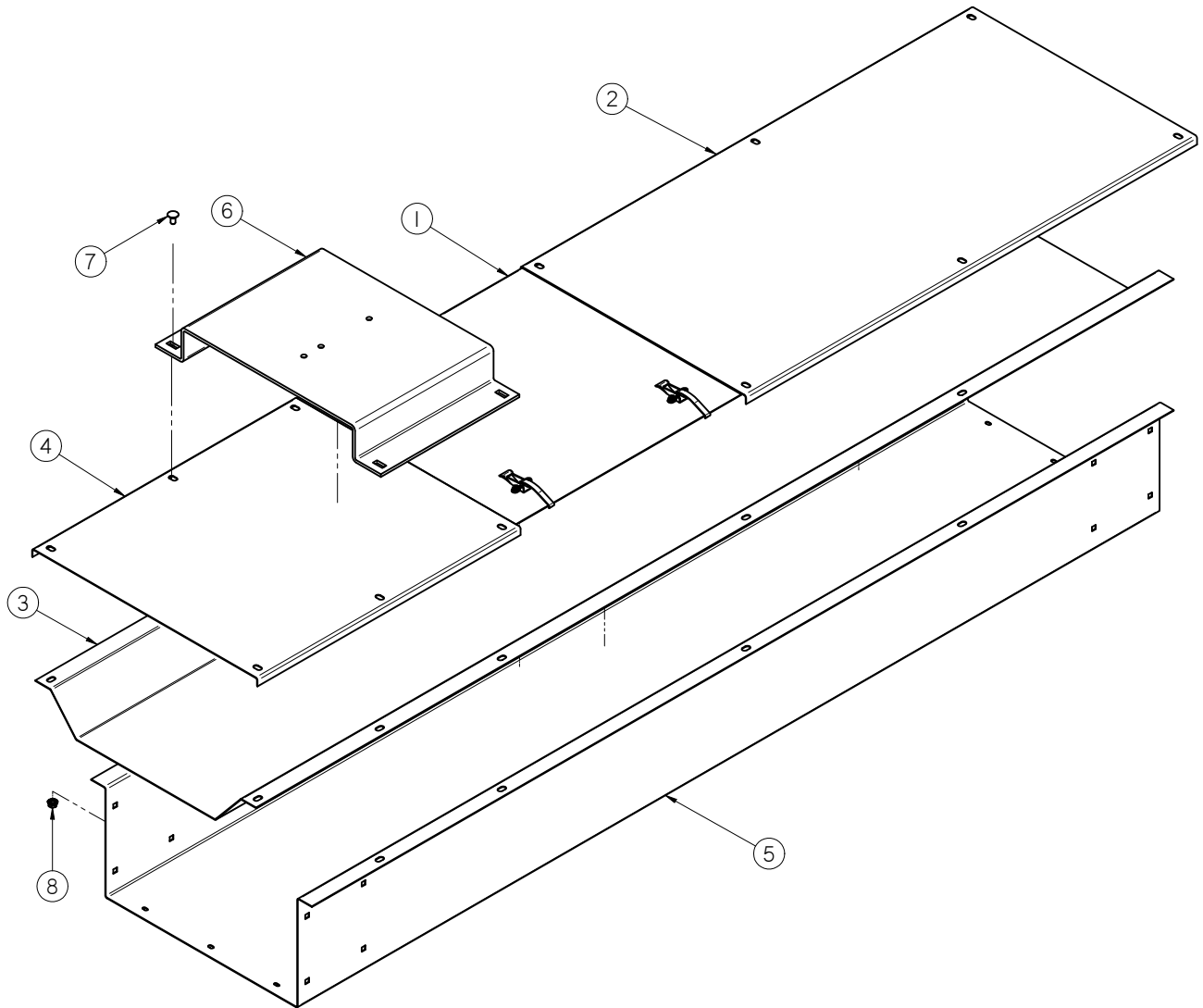
REMOVABLE CONVEYOR COVER ASSEMBLY (05-06-0082)



Item #	Part #	Description	Qty
1	05-10-3839	REMOVEABLE CVR 20BW	1
2	06-02-0043	NUT,LOCK, #10-24 ZP NYLON INSERT	4
3	06-06-0029	SCRW MACH 10-24 X .375 PHLP PHD ZP	4
4	06-09-0036	LATCH VERSA SOUTHCO V3-0072-07	2

WALKING LEG BIN FILL SYSTEM

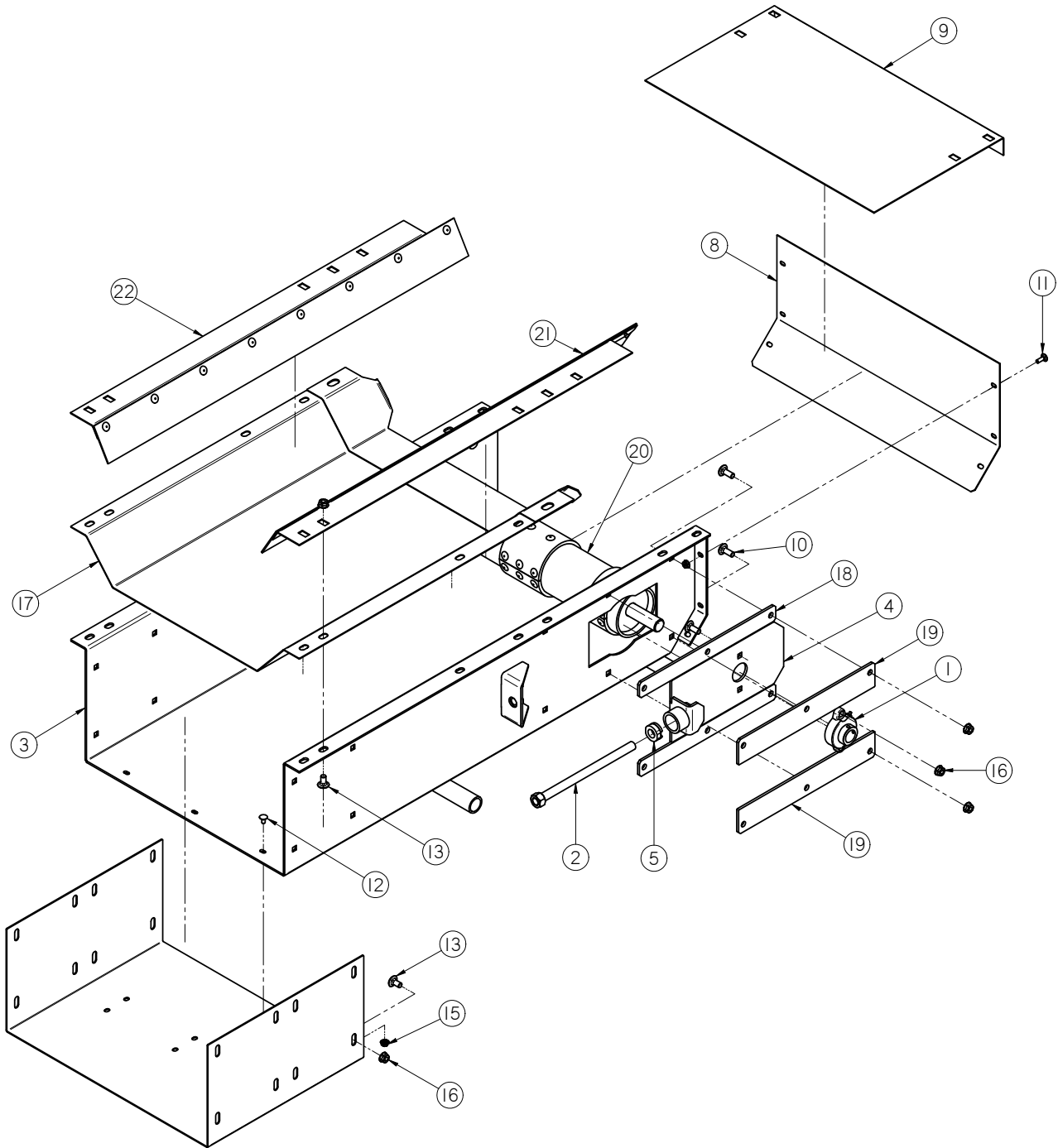
LEG FEED CONVEYOR INLET ASSEMBLY (05-07-0465)



Item #	Part #	Description	Qty
1	05-06-0082	ASSY REMOVEABLE CVR 20BW	1
2	05-10-3838	PLT TOP CVR 4FT 20BW	1
3	05-10-3961	TROUGH PAN 20BW HEAD SECT	1
4	05-10-3962	PLT TOP CVR 20BW MID SECT	1
5	05-10-3963	FR 20BW TAIL SECT	1
6	05-10-3964	BRKT WINCH MNT TRK TO LEG S4000	1
7	06-01-0153	BOLT CRG .375-16X.750 ZP SHORT NECK	10
8	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	10

WALKING LEG BIN FILL SYSTEM

LEG FEED HEAD INLET SECTION ASSEMBLY (05-07-0422)



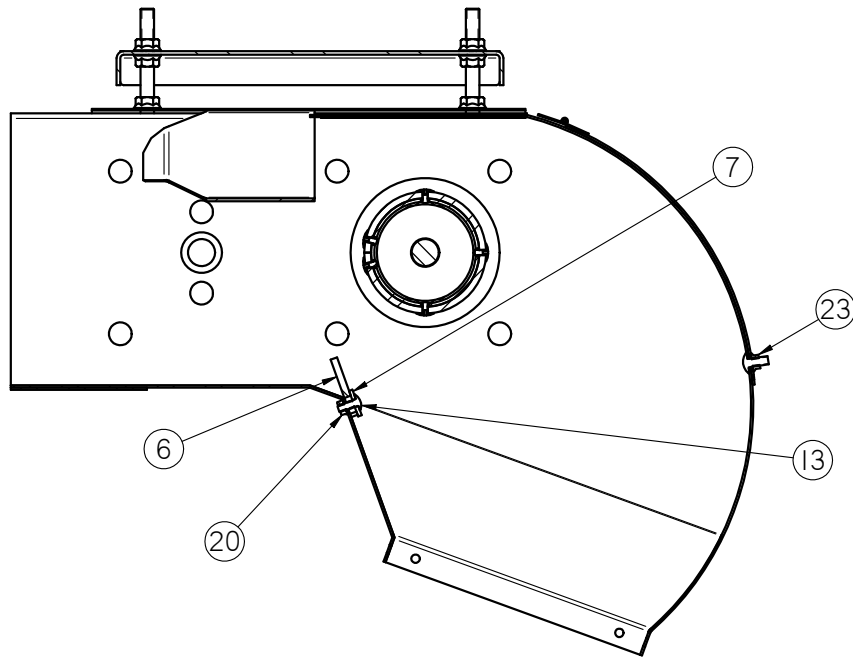
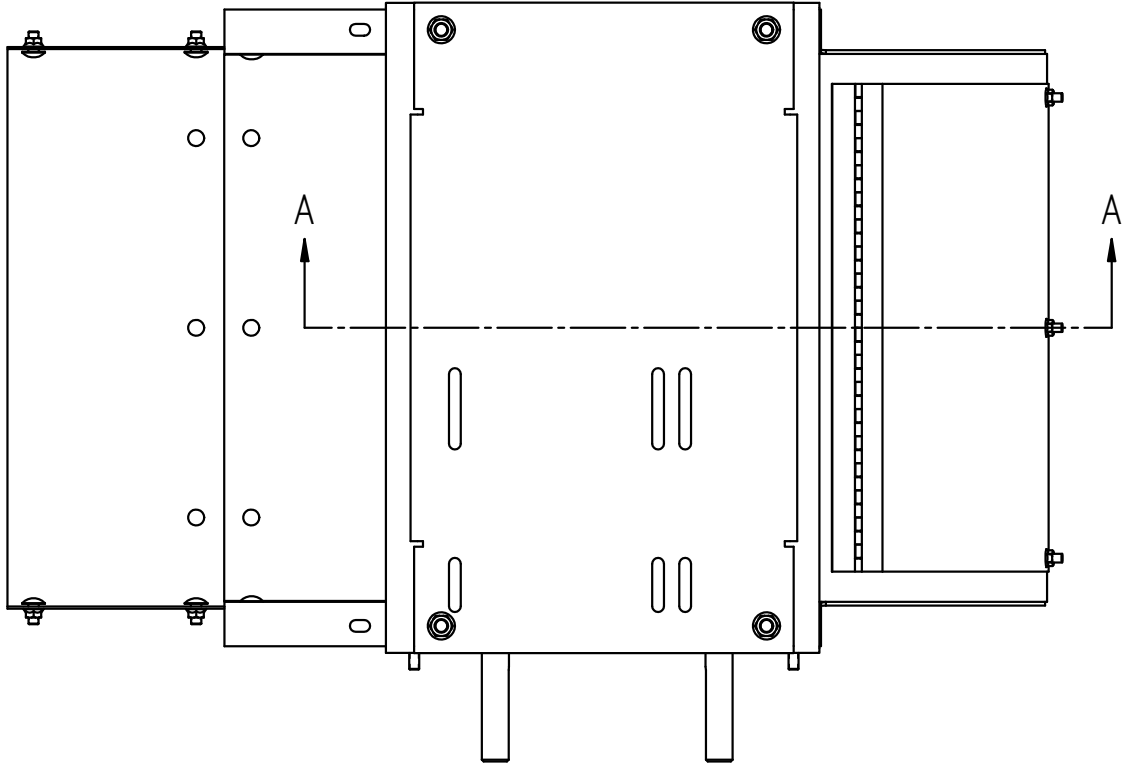
WALKING LEG BIN FILL SYSTEM

LEG FEED HEAD INLET SECTION ASSEMBLY (05-07-0422)

Item #	Part #	Description	Qty
1	01-03-0042	BRG FLG MNT 1.000ID 2BOLT ECNTRC	2
2	05-03-0493	WDMT TENSION ADJUSTER BOLT 10 IN	2
3	05-07-0424	WDMT INLET SECT HSG S3000	1
4	05-07-0425	WDMT TAKE UP BRG PLT	2
5	05-08-0290	WDMT TKUP BLT GUIDE	2
6	05-10-3828	PLT TROUGH TRANS 20BW	1
7	05-10-3829	PLT FORMED SPLICE 20BW	1
8	05-10-3902	PLT S3000 TAIL SECT CLEAN OUT DOOR	1
9	05-10-3903	PLT S3000 TAIL SECT END CVR TOP	1
10	06-01-0115	BOLT CRG .375-16 X 1.00 ZP GR5	16
11	06-01-0122	BOLT, CARRIAGE, .250-20x.75 G5 ZP	4
12	06-01-0150	BOLT, CARRIAGE, .250-20x.50 G5 ZP	6
13	06-01-0153	BOLT CRG .375-16X.750 ZP SHORT NECK	28
14	06-02-0005	NUT, .625-11 UNC ZP GRADE 5	2
15	06-03-0013	NUT,LOCK, FLG .250-20 ZP SERRATED	10
16	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	44
17	102034	TROUGH PAN 20BW TAIL SECT	1
18	10203B	SPACER	4
19	10203C	SPACER	4
20	13-05-0203	ASSY TAIL PLY S3000	1
21	280-2-0026	SKIRTING ASSY LH	1
22	280-2-0027	SKIRTING ASSY RH	1

WALKING LEG BIN FILL SYSTEM

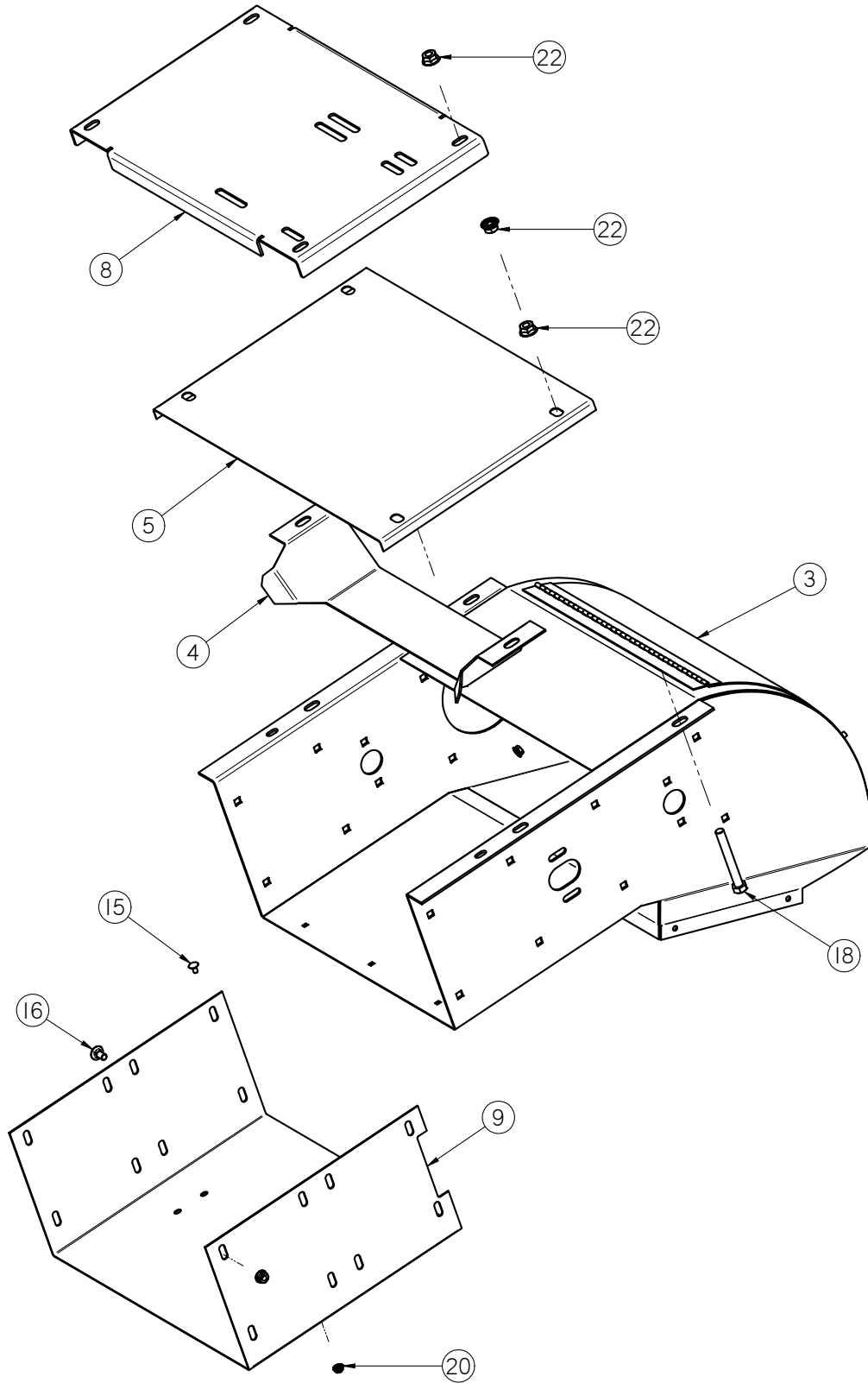
LEG FEED CONVEYOR HEAD SECTION ASSEMBLY (05-07-0463)



SECTION A-A

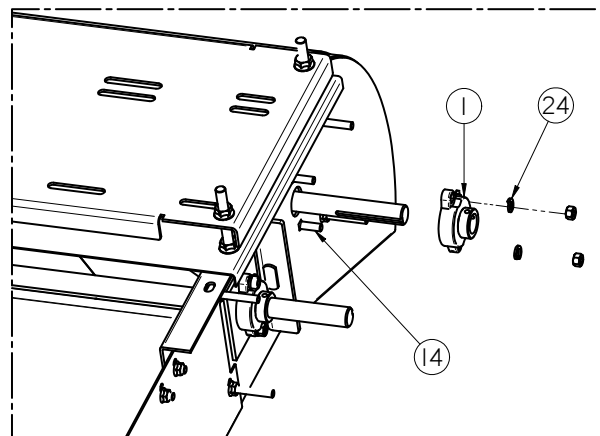
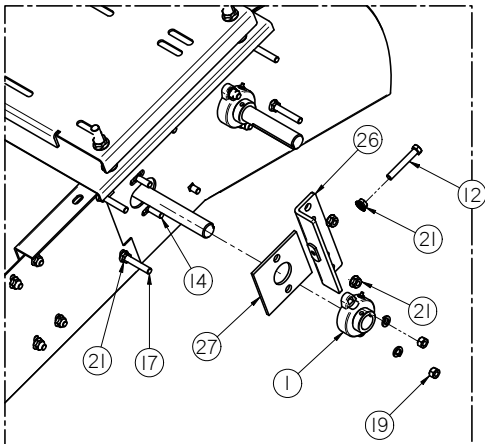
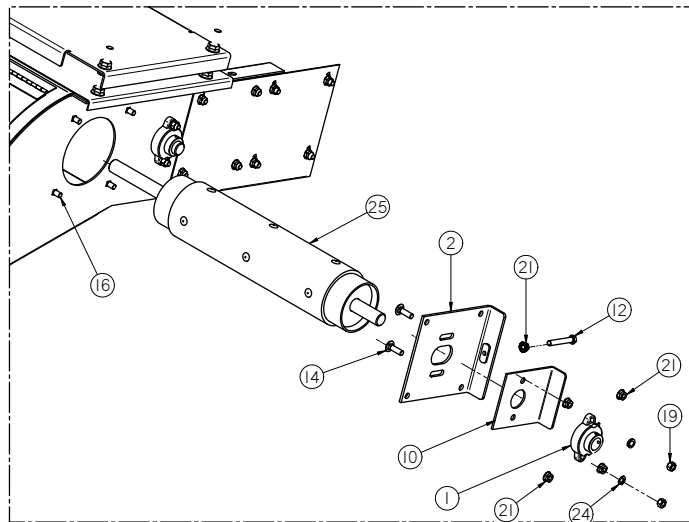
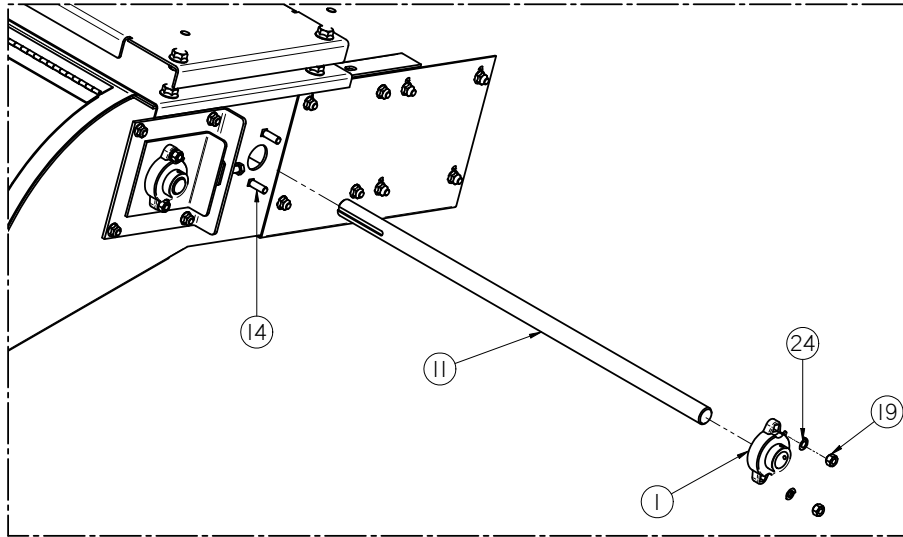
WALKING LEG BIN FILL SYSTEM

LEG FEED CONVEYOR HEAD SECTION ASSEMBLY (05-07-0463)



WALKING LEG BIN FILL SYSTEM

LEG FEED CONVEYOR HEAD SECTION ASSEMBLY (05-07-0463)



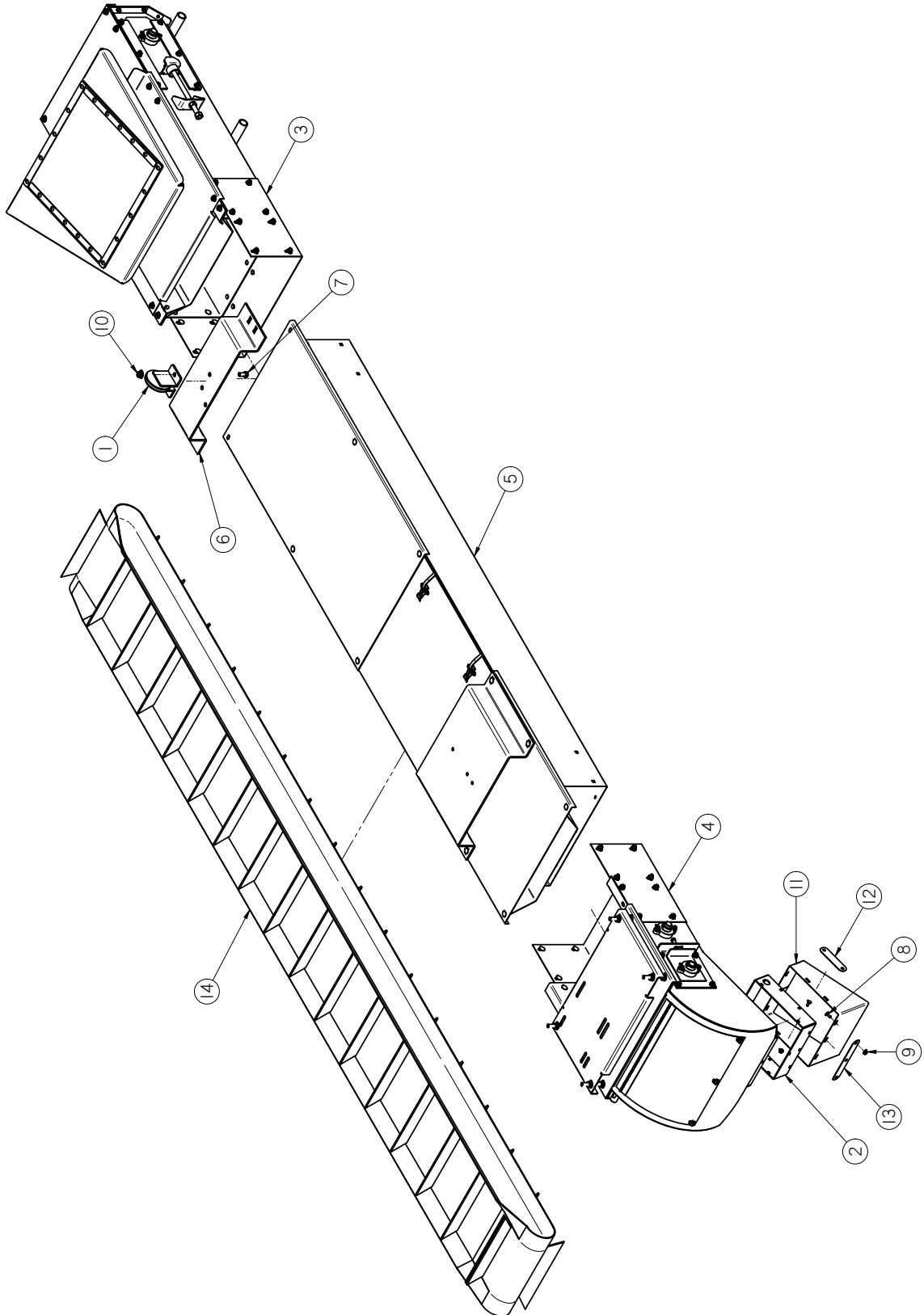
WALKING LEG BIN FILL SYSTEM

LEG FEED CONVEYOR HEAD SECTION ASSEMBLY (05-07-0463)

Item #	Part #	Description	Qty
1	01-03-0042	BRG FLG MNT 1.000ID 2BOLT ECNTRC	4
2	05-07-0445	WDMT ADJ PLT CNVR HEAD SECT	1
3	05-07-0464	WDMT S3000 DSCHG SECT	1
4	05-10-3828	PLT TROUGH TRANS 20BW	1
5	05-10-3846	PLT TOP CVR DSCHG 20BW	1
6	05-10-3851	PLT S3000 CNVR BLT SCRAPER RBRR	1
7	05-10-3852	PLT S3000 CNVR BLT SCRAPER HLDR	1
8	05-10-3854	PLT MTR MNT 20BW	1
9	05-10-3942	PLT FORMED SPLICE 20BW HEAD SECT	1
10	05-10-3947	PLT BRG ADJ STRIKE	1
11	05-11-0310	SHAFT 28 X 1IN JACK HEAD	1
12	06-01-0071	BOLT, .375-16 X 2 1/2 ZP G5 FULL THREAD	2
13	06-01-0122	BOLT, CARRIAGE, .250-20x.75 G5 ZP	3
14	06-01-0127	BOLT, CARRIAGE, .375-16 X 1 1/4 ZP G5	8
15	06-01-0150	BOLT, CARRIAGE, .250-20x.50 G5 ZP	6
16	06-01-0153	BOLT CRG .375-16X.750 ZP SHORT NECK	20
17	06-01-0154	BOLT CRG .375-16 X 2.50 FTH ZP GR5	4
18	06-01-0157	BOLT, .500-13 X 4" UNC ZP GRADE 5 fth	4
19	06-02-0003	NUT FULL .375-16 ZP GR5	8
20	06-03-0013	NUT,LOCK, FLG .250-20 ZP SERRATED	9
21	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	26
22	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	12
23	06-03-0019	NUT LOCK FLG .3125-18 ZP GR5	3
24	06-04-0003	WSHR LOCK SPLT .375 ZP	8
25	13-05-0204	ASSY HEAD PLY S3000	1
26	280-2-0016	TRACKING ANGLE WELDMENT	1
27	280-3-0112	BEARING SPACER PLATE	1

WALKING LEG BIN FILL SYSTEM

LEG FEED CONVEYOR BASE ASSEMBLY (13-08-0356)



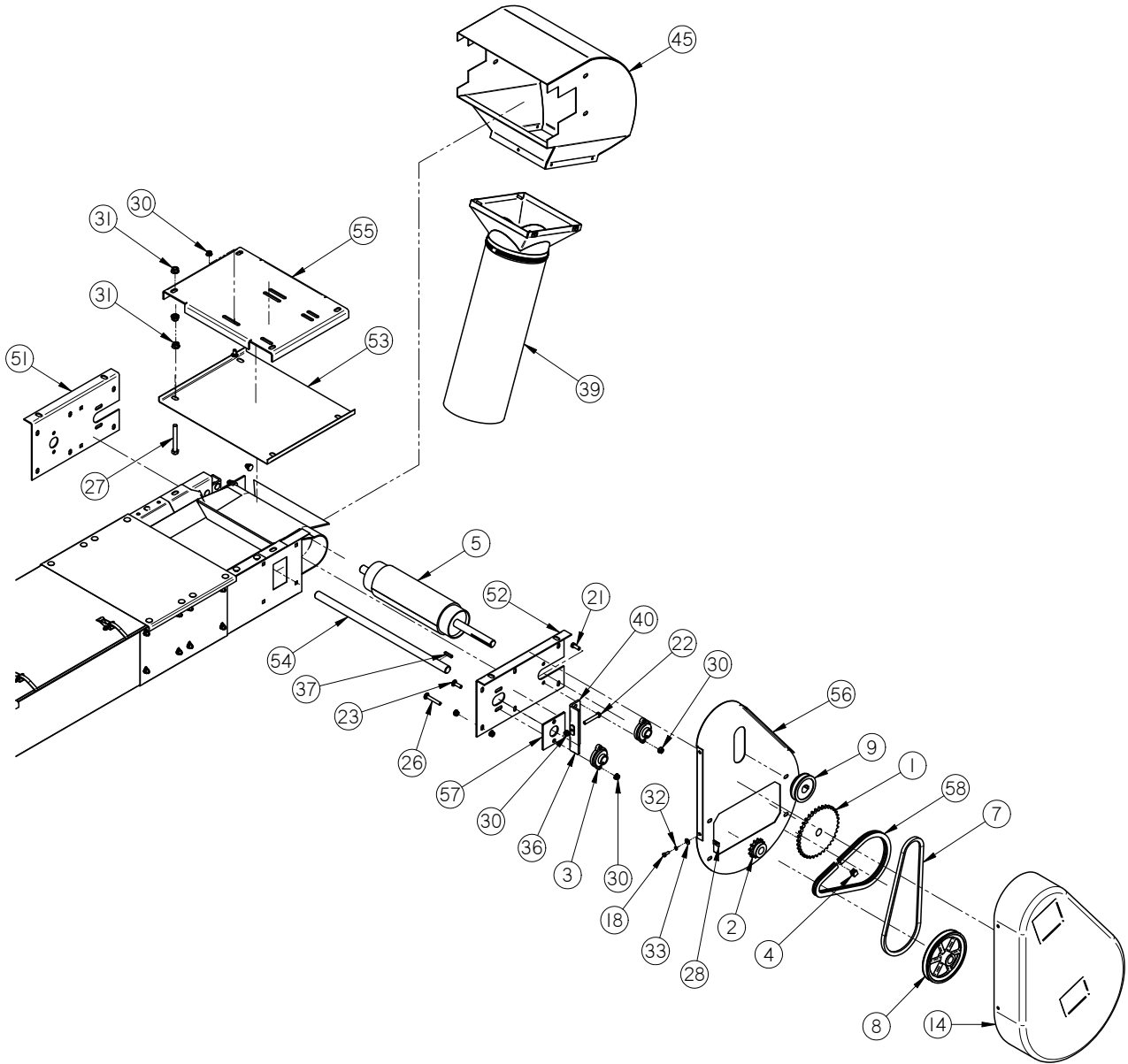
WALKING LEG BIN FILL SYSTEM

LEG FEED CONVEYOR BASE ASSEMBLY (13-08-0356)

Item #	Part #	Description	Qty
1	01-08-0073	PULLEY FLAT MOUNT BLOCK 4 IN	1
2	05-03-0566	WDMT PIVOT TRUCK TO LEG	1
3	05-07-0422	ASSY CNVR 20IN HD INLET SECT	1
4	05-07-0463	ASSY HEAD SECT 20IN LEG FILL	1
5	05-07-0465	ASSY CNVR 20IN HD INLET LEG FILL EX	1
6	05-10-3965	BRKT PLY MNT TRK TO LEG S3000	1
7	06-01-0069	BOLT .500-13 X 1.00 ZP GR5	2
8	06-01-0122	BOLT, CARRIAGE, .250-20x.75 G5 ZP	16
9	06-03-0013	NUT,LOCK, FLG .250-20 ZP SERRATED	16
10	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	2
11	100EAA	CHUTE FLEX TRUCK TO LEG	1
12	100EAB	PLT CLAMP CHUTE LONG	2
13	100EAC	PLT CLAMP CHUTE SHORT	2
14	11-02-0090	BELT CNVR CLTS 1216	1

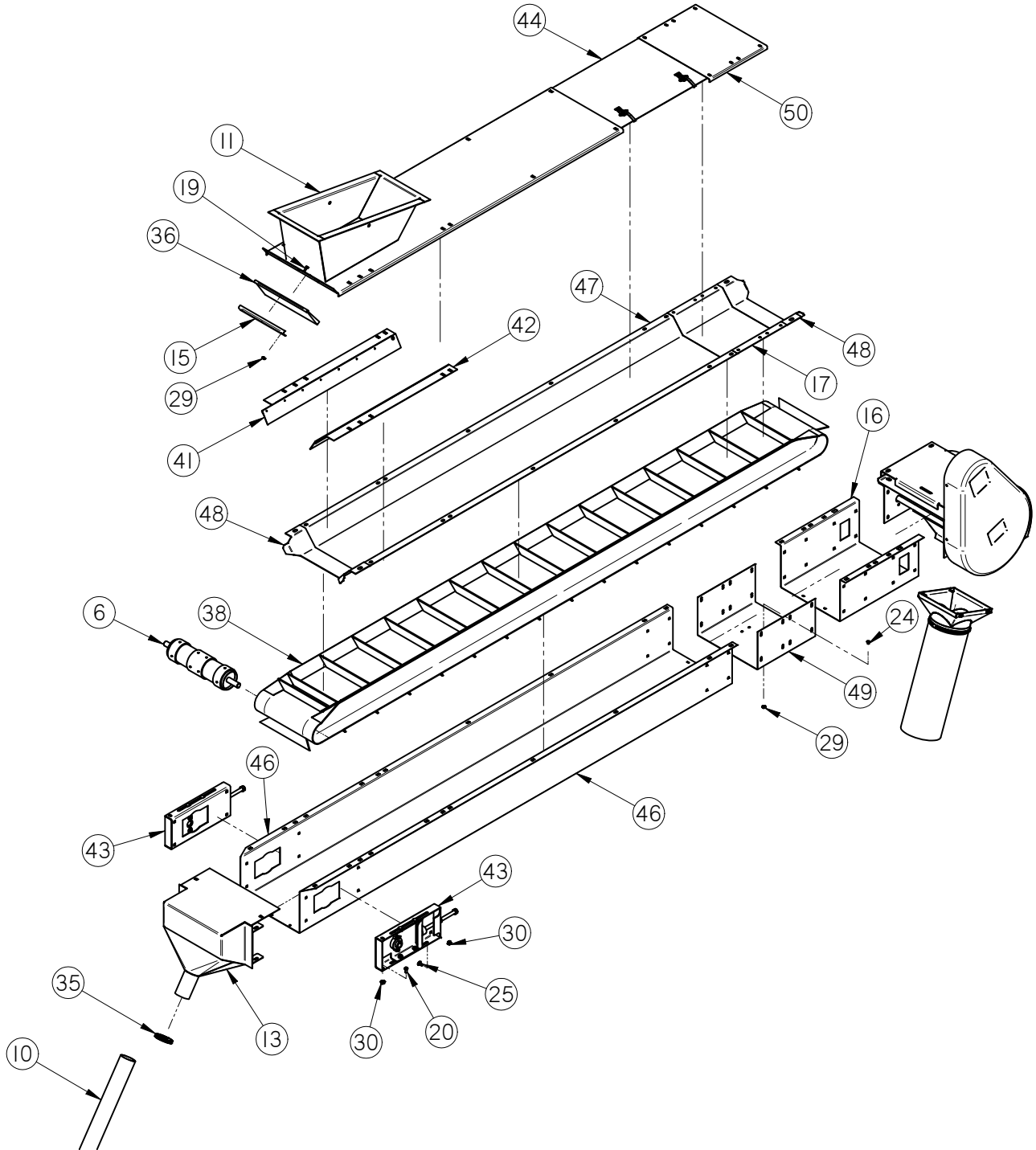
WALKING LEG BIN FILL SYSTEM

BIN FILL CONVEYOR TOP ASSEMBLY (13-08-0393)



WALKING LEG BIN FILL SYSTEM

BIN FILL CONVEYOR TOP ASSEMBLY (13-08-0393)



WALKING LEG BIN FILL SYSTEM

BIN FILL CONVEYOR TOP ASSEMBLY (13-08-0393)

Item #	Part #	Description	Qty
1	01-02-0073	Sprocket #50 36T 1.00 in Bore Type B	1
2	01-02-0076	Sprocket #50 12T 1.0000 in Bore Type B	1
3	01-03-0042	BRG FLG MNT 1.000ID 2BOLT	4
4	01-04-0005	#50 CNTG LINK	1
5	01-06-0051	WDMT 15.5 X 4 HEAD PULLEY	1
6	01-06-0052	15.5 X 4 TAIL PULLEY WELDMENT	1
7	01-08-0054	BELT B37	1
8	01-08-0058	SHEAVE BK75 1.00 BORE	1
9	01-08-0063	SHV BK36 1.125 FSH BORE	1
10	02-03-0048	HOSE RNT 3IN ID WHITE PVC VAC	1
11	05-03-0572	WDMT HPPR LEG TO BIN	1
12	05-03-0574	WDMT UPPER CNVR SUPT	1
13	05-03-0575	WDMT CNVR CATCH CONE	1
14	05-06-0035	DRIVE SHIELD MOLDED	1
15	05-10-2138	INLET BRSH HLDR S2000	1
16	05-10-3223	PAN CVR END	1
17	05-10-3224	TROUGH CNVR END	1
18	06-01-0006	BOLT .250-20 X .750 ZP GR5	4
19	06-01-0007	BOLT, .250-20 X 1 UNC ZP GRADE 5	3
20	06-01-0015	BOLT .375-16 X 0.75 ZP GR5	4
21	06-01-0016	BOLT .375-16 X 1.00 ZP GR5	4
22	06-01-0071	BOLT, .375-16 X 2 1/2 ZP G5 FULL THREAD	2
23	06-01-0127	BOLT, CARRIAGE, .375-16 X 1 1/4 ZP G5	4
24	06-01-0150	BOLT, CARRIAGE, .250-20x.50 G5 ZP	4
25	06-01-0153	BOLT CRG .375-16X.750 ZP SHORT NECK	64
26	06-01-0154	BOLT CRG .375-16 X 2.50 FTH ZP GR5	4
27	06-01-0157	BOLT, .500-13 X 4" UNC ZP GRADE 5 fth	4
28	06-02-0047	NUT .250-20 U-CLIP NUT	4
29	06-03-0013	NUT,LOCK, FLG .250-20 ZP SERRATTED	7
30	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	89
31	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	12
32	06-04-0001	WSHR LOCK SPLT .250 ZP	4
33	06-05-0001	WASHER, FLAT .250	4
34	06-05-0005	WSHR FLAT .500 ZP	4
35	06-07-0016	HOSE CLAMP, 1-15/16" to 2-1/2"	2

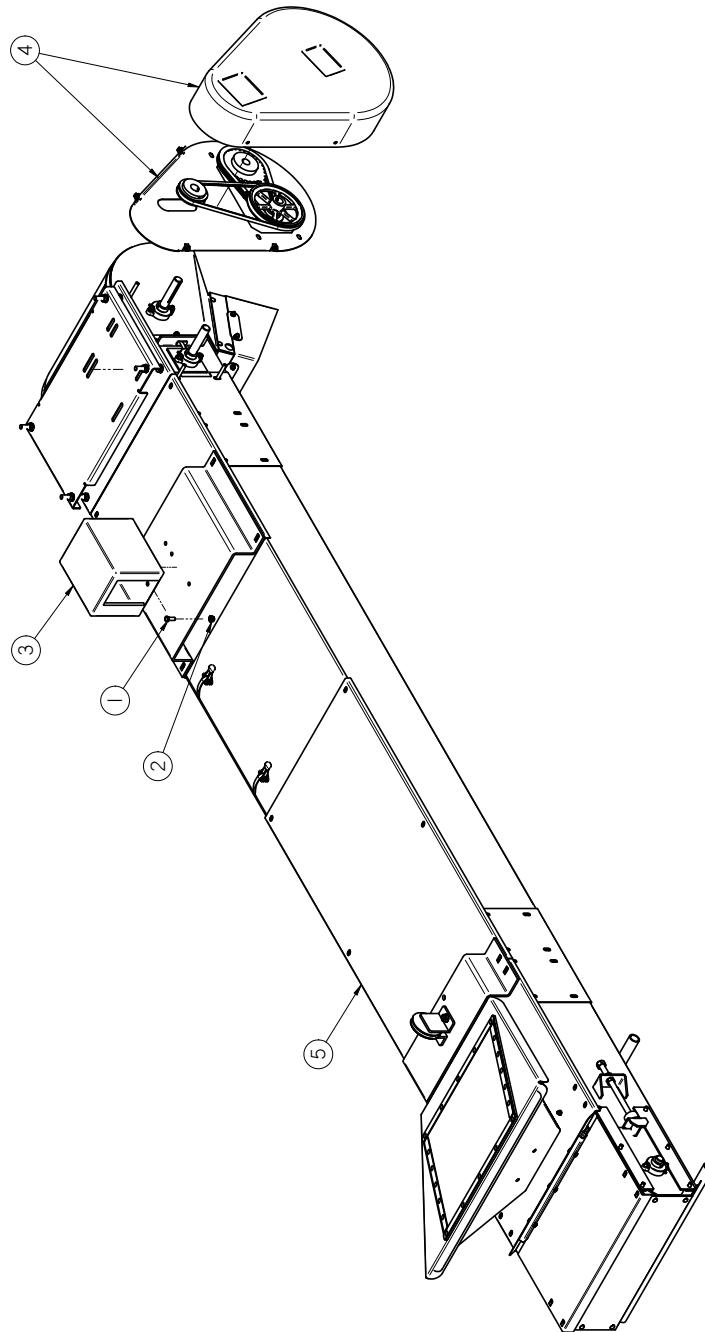
WALKING LEG BIN FILL SYSTEM

BIN FILL CONVEYOR TOP ASSEMBLY (13-08-0393)

Item #	Part #	Description	Qty
36	06-10-0028	SEAL BRSH 14.500 OAL 4.5IN EXP LG (06-10-0028)	1
37	106-3-2036	KEY .250 X 1.25 CS	4
38	11-02-0033	BELT CNVR CLTS 1216	1
39	13-05-0227	ASSY 8ID FLEX SPOUT S2000	1
40	280-2-0016	TRACKING ANGLE WELDMENT	2
41	280-2-0026	SKIRTING ASSY LH	1
42	280-2-0027	SKIRTING ASSY RH	1
43	280-2-0045	TAIL TAKE-UP ASSEMBLY	2
44	280-2-0046	REMOVABLE COVER ASSEMBLY	1
45	280-2-0047	TAPERED DISCHARGE SPOUT WELDMENT	1
46	280-3-0007	FRAME-TAIL SECTION	1
47	280-3-0008	TROUGHING PAN-TAIL SECTION	1
48	280-3-0010	TROUGH TRANSITION PLATE	2
49	280-3-0011	SPLICE PLATE-FORMED	1
50	280-3-0012	SPLICE COVER	1
51	280-3-0031	HEAD PLATE LH	1
52	280-3-0032	HEAD PLATE RH	1
53	280-3-0036	TOP COVER DISCHARGE	1
54	280-3-0048	24 X 1 INCH JACK-HEAD SHAFT	1
55	280-3-0052	MOTOR MOUNT	1
56	280-3-0053	SHIELD BACKPLATE	1
57	280-3-0112	BEARING SPACER PLATE	2
58	280-3-0119	50 ROLLER CHAIN 31IN	1

WALKING LEG BIN FILL SYSTEM

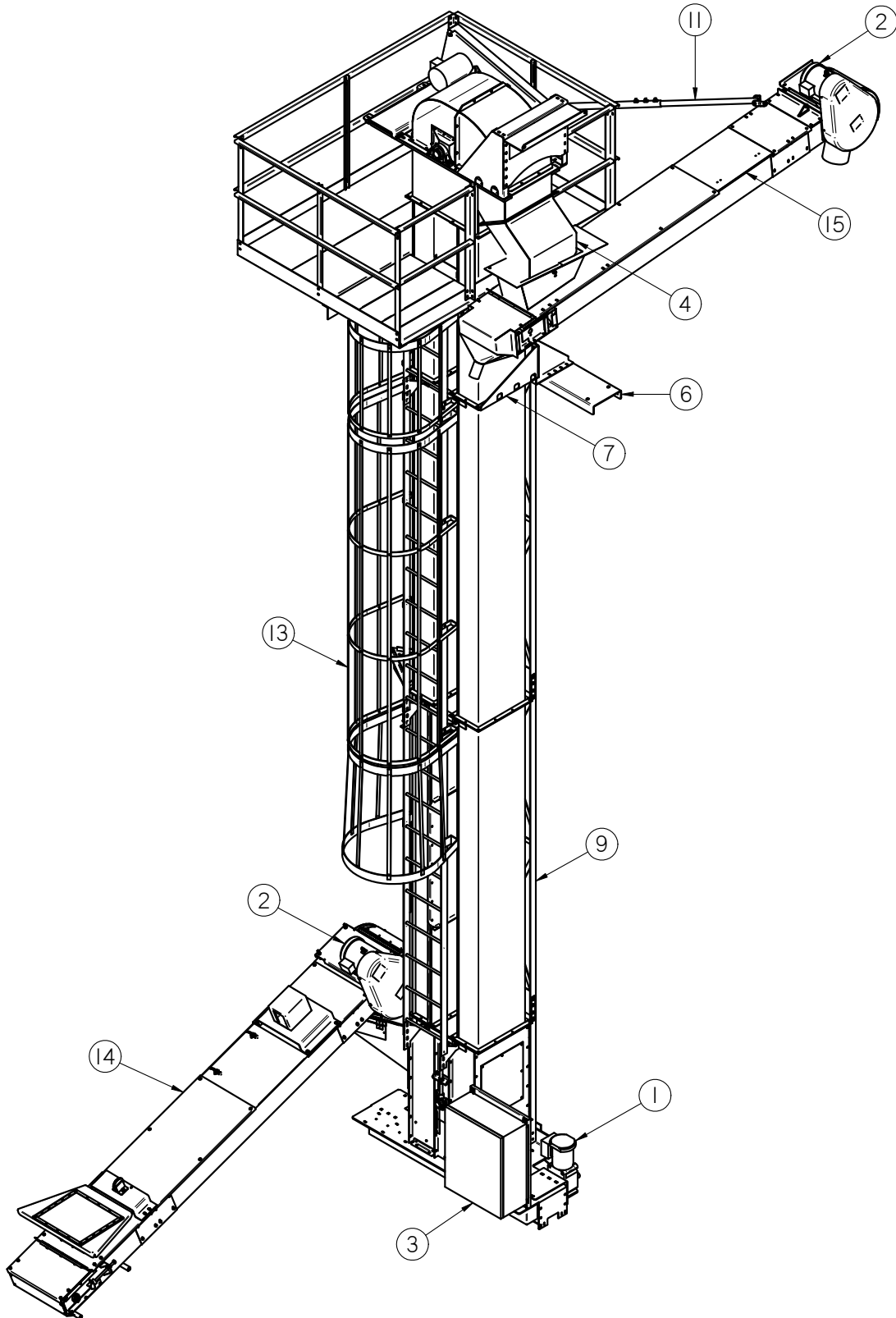
LEG FEED CONVEYOR TOP ASSEMBLY (13-08-0392)



Item #	Part #	Description	Qty
1	06-01-0016	BOLT .375-16 X 1.00 ZP GR5	3
2	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	3
3	08-08-0104	115 V WINCH ELECTRIC ENCLOSED	1
4	13-05-0210	KIT DRV 5HP CONVEYOR	1
5	13-08-0356	ASSY S3000 TRUCK TO LEG FILL BASE	1

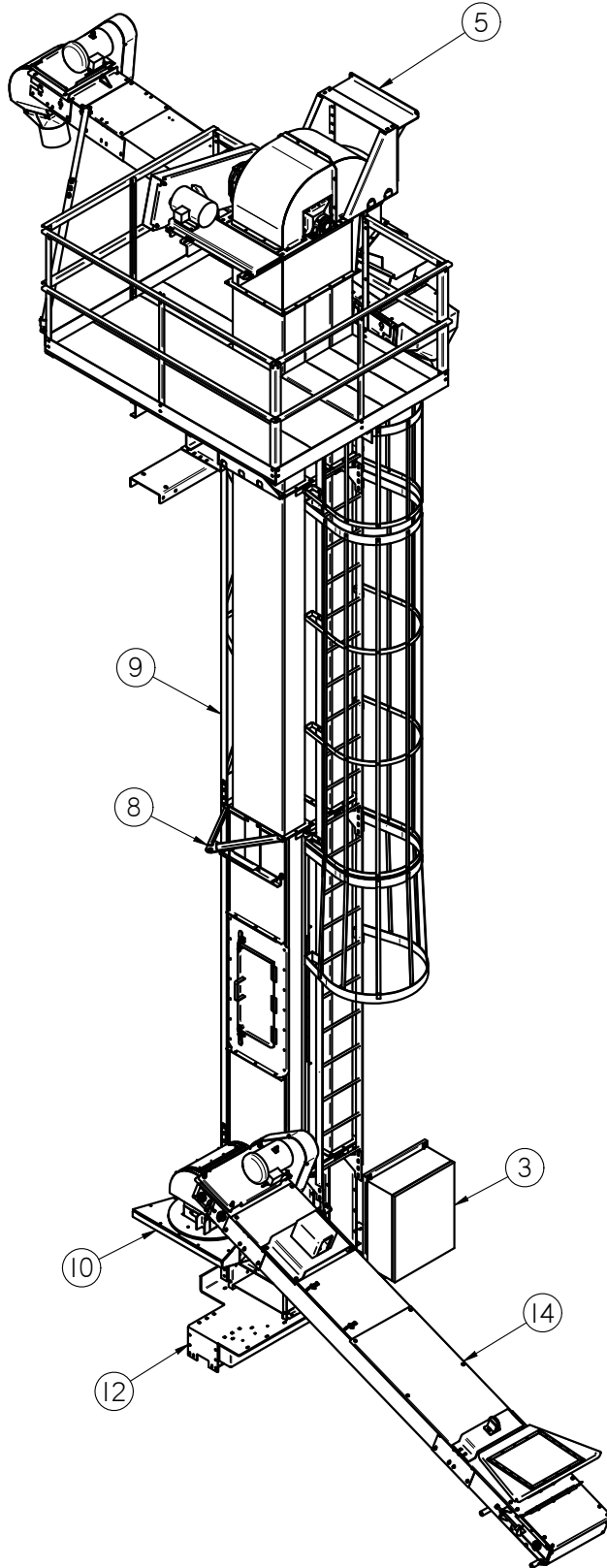
WALKING LEG BIN FILL SYSTEM

30 FOOT WALKING LEG CONVEYOR ASSEMBLY (13-08-0135)



WALKING LEG BIN FILL SYSTEM

30 FOOT WALKING LEG CONVEYOR ASSEMBLY (13-08-0135)



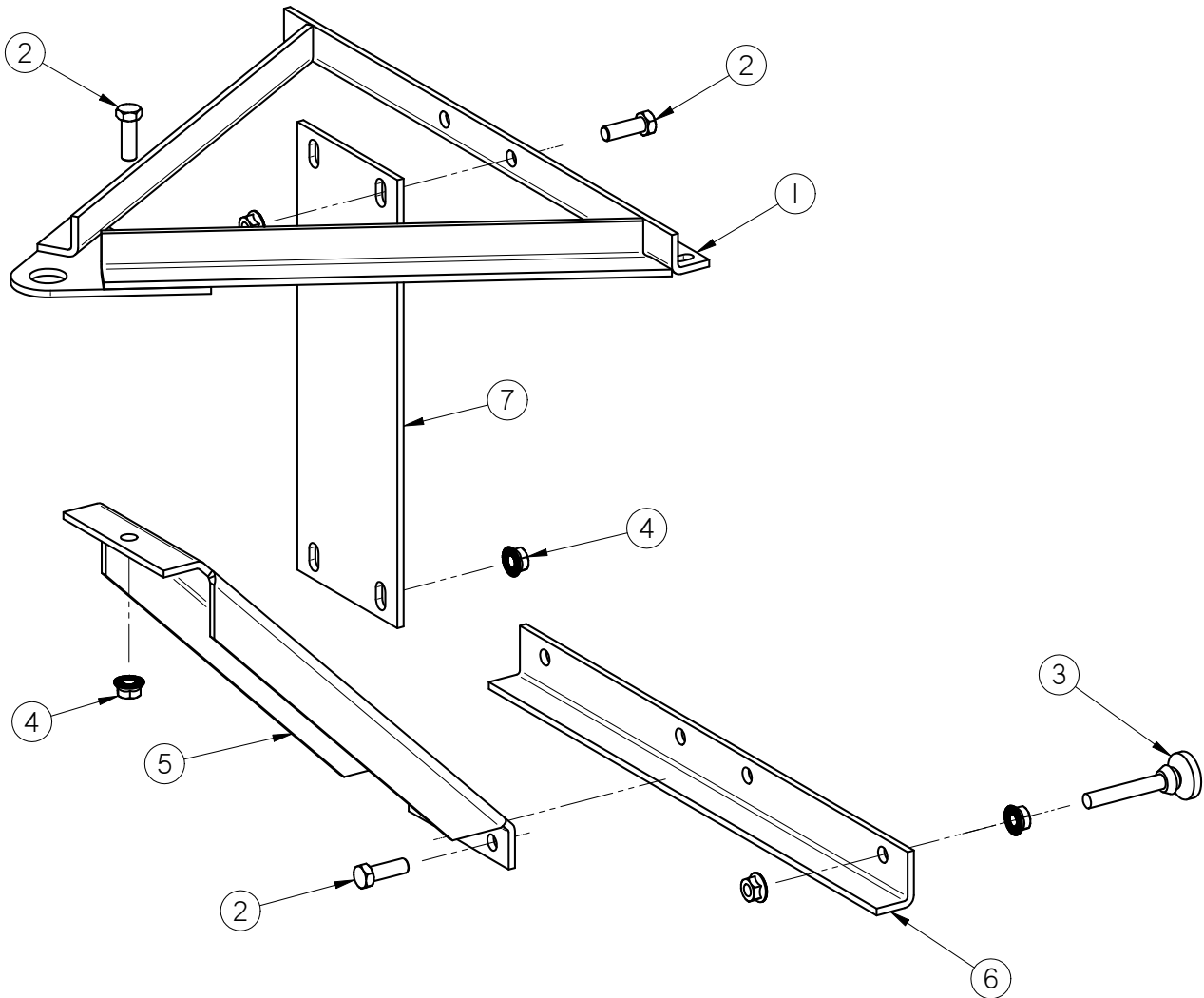
WALKING LEG BIN FILL SYSTEM

30 FOOT WALKING LEG CONVEYOR ASSEMBLY (13-08-0135)

Item #	Part #	Description	Qty
1	01-01-0123	GMTR RA 1HP 6.8RPM 3PH HLLW SHAFT	1
2	01-01-0151	MTR EE 5HP 1750RPM 184T TEFC 3PH	2
3	03-12-0274	PNL CNTL WALKING LEG 230V 3PH	1
4	05-03-0571	WDMT RAPAT LEG DISCH CHUTE	1
5	05-05-0019	BIN FILL CNVR SUPP LH	1
6	05-07-0226	ASSY TRLY TOP	1
7	05-07-0230	ASSY LEG TO TOP TRLY BRKT	1
8	05-07-0232	ASSY LEG ROT CNVR SUPPRT	1
9	05-07-0233	ASSY TRLY SUPP FR	1
10	05-07-0242	ASSY BOOT INLET HOPPER PIVOT LH	1
11	05-07-0250	ASSY BIN FILL CNVR BRACE	1
12	05-07-0657	ASSY TRLY BTM LH LEG NO MTR	1
13	12-01-0045	LEG 30 FT RAPAT L1220-85-2-30 3 PH	1
14	13-08-0392	ASSY CNVR TRUCK TO LEG NO MTR S3000	1
15	13-08-0393	ASSY CNVR LEG TO BIN NO MTR	1

WALKING LEG BIN FILL SYSTEM

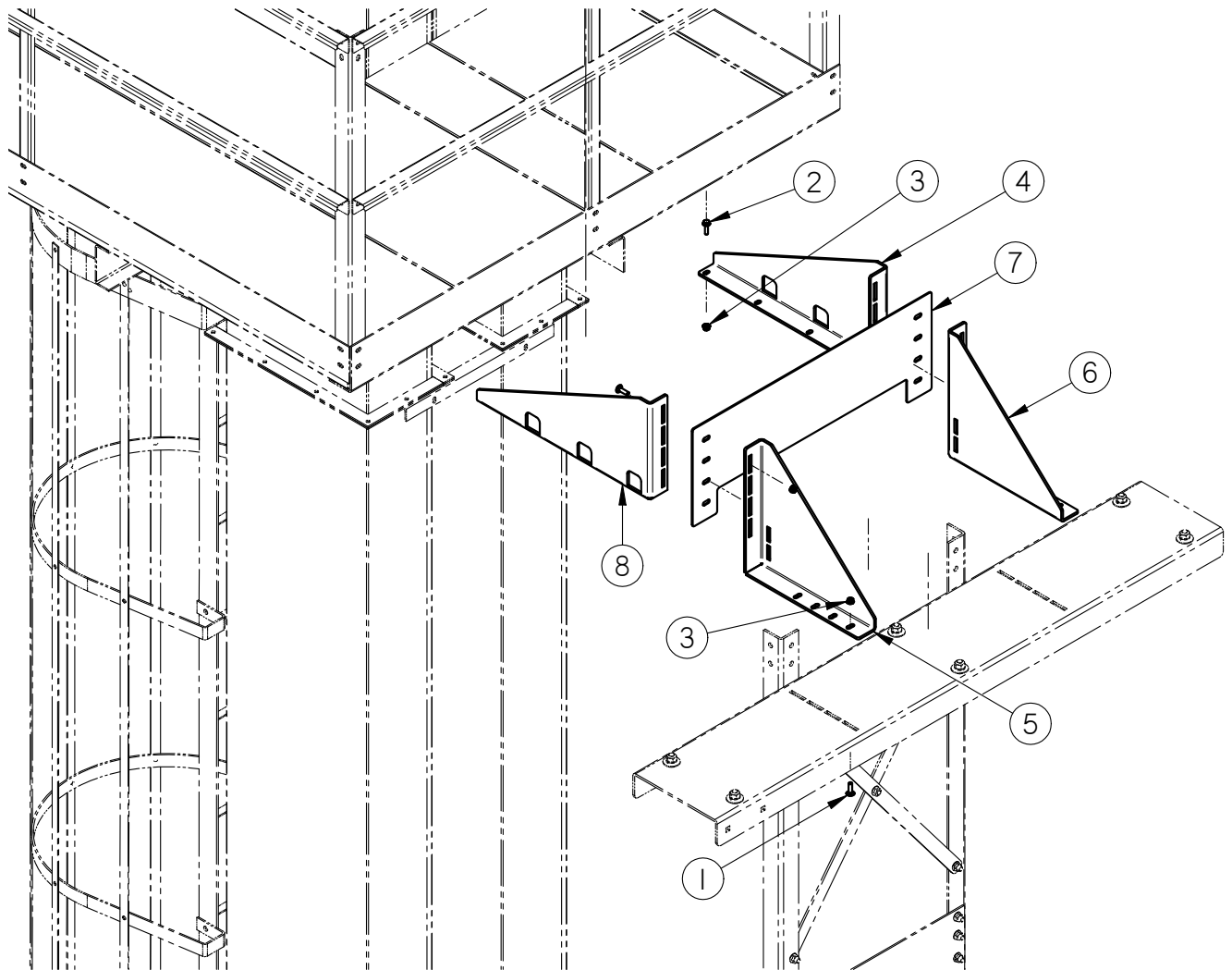
LEG FEEDCONVEYOR ROTATION SUPPORT ASSEMBLY (05-07-0232)



Item #	Part #	Description	Qty
1	05-03-1444	WDMT UPPER CBL SUPP LEG FILL CNVR	1
2	06-01-0025	BOLT .500-13 X 1.50 ZP GR5	5
3	06-01-0176	LEVELING MNT CUSHION .500-13 200LB	2
4	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	9
5	101121	101121	1
6	101122	101122	1
7	101123	101123	1

WALKING LEG BIN FILL SYSTEM

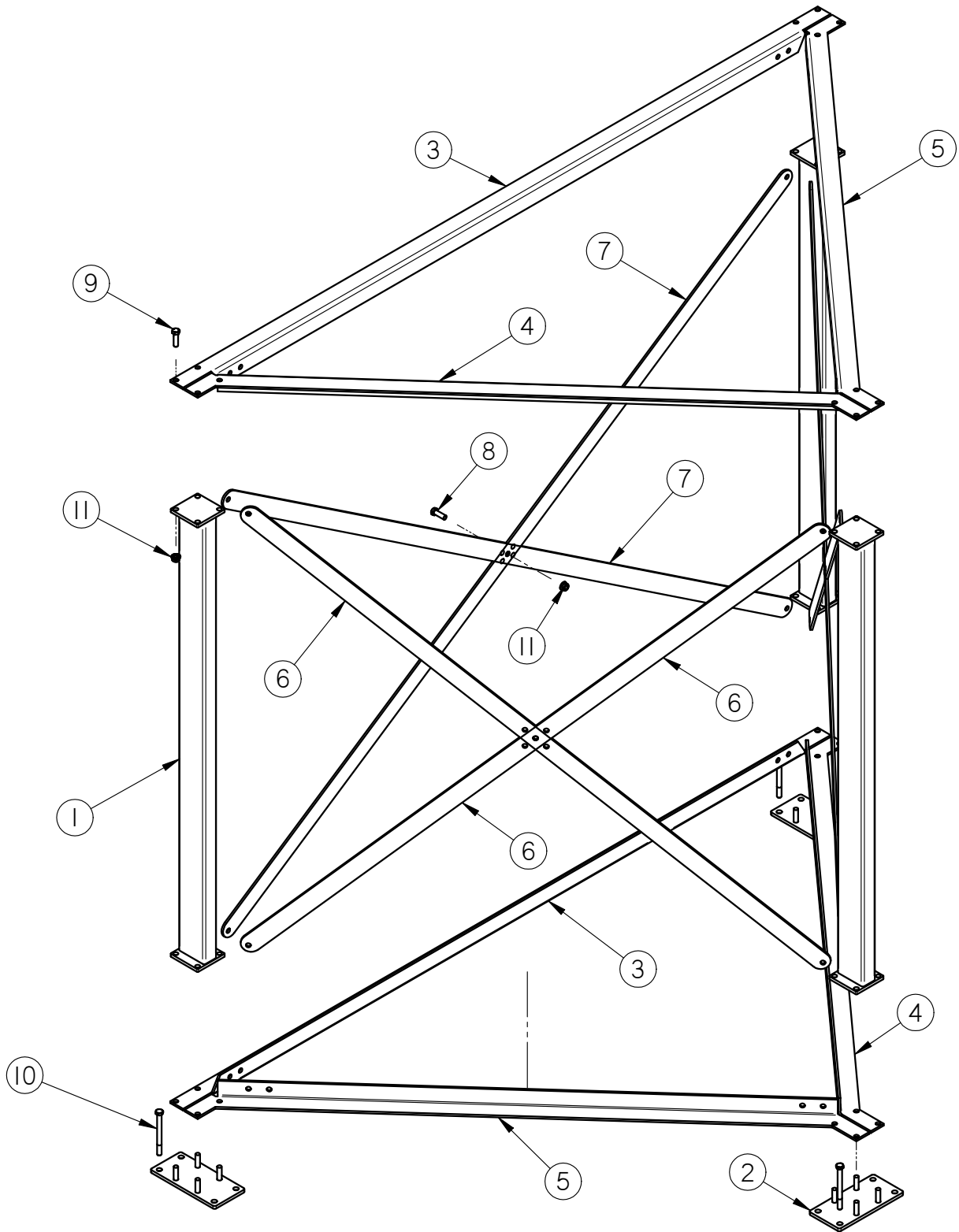
TOP TROLLEY BRACKET ASSEMBLY (05-07-0230)



Item #	Part #	Description	Qty
1	06-01-0127	BOLT, CARRIAGE, .375-16 X 1 1/4 ZP G5	16
2	06-01-0189	BOLT, FLG .375-16 UNC ZP GRADE 5; 1-1/4" LG	8
3	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	24
4	1010C3	LEG GUSSET RT	1
5	1010C4	TOP RAIL GUSSET RT	1
6	1010C5	TOP RAIL GUSSET LT	1
7	1010C6	CROSS PLT	1
8	1010C7	LEG GUSSET LT	1

WALKING LEG BIN FILL SYSTEM

TOWER SUPPORT ASSEMBLY (05-07-0223)



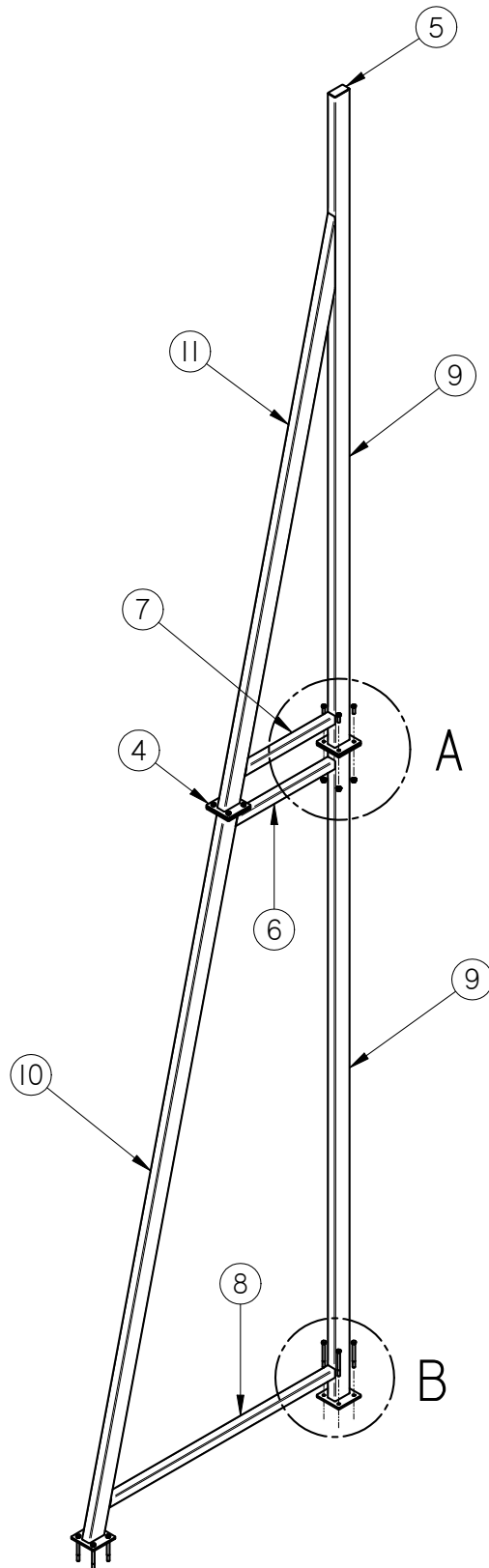
WALKING LEG BIN FILL SYSTEM

TOWER SUPPORT ASSEMBLY (05-07-0223)

Item #	Part #	Description	Qty
1	05-03-0563	WDMT SUPP TWR COLUMN	15
2	05-03-0621	WDMT MNT PLT LEG SUPP TWR	3
3	05-10-3213	FRM SIDE 1 SUPP TWR	6
4	05-10-3214	FRM SIDE 2 SUPP TWR	6
5	05-10-3215	FRM SIDE 3 SUPP TWR	6
6	05-10-3216	X-BRACE SUPP TWR SHORT	20
7	05-10-3217	X-BRACE SUPP TWR LONG	10
8	06-01-0025	BOLT .500-13 X 1.50 ZP GR5	75
9	06-01-0054	BOLT .500-13 X 1.75 ZP GR5	60
10	06-01-0179	BOLT,.500-13 CONC ANCHOR ZP 5.5 LONG	12
11	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	135

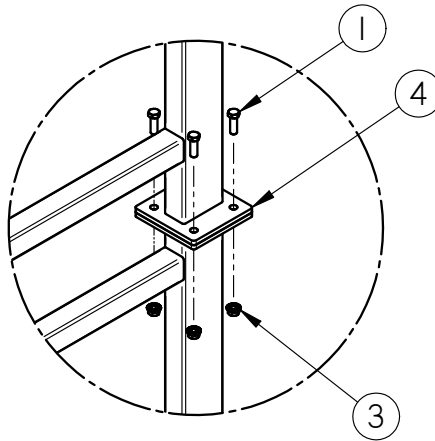
WALKING LEG BIN FILL SYSTEM

TROLLEY END SUPPORT FRAME ASSEMBLY (05-03-0561)

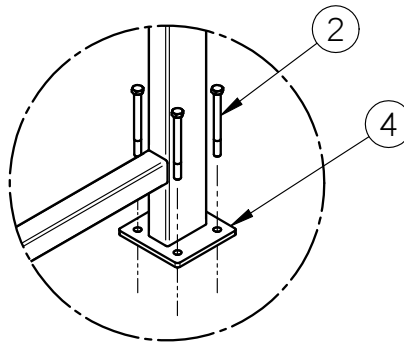


WALKING LEG BIN FILL SYSTEM

TROLLEY ENDSUPPORT FRAME ASSEMBLY (05-03-0561)



DETAIL A

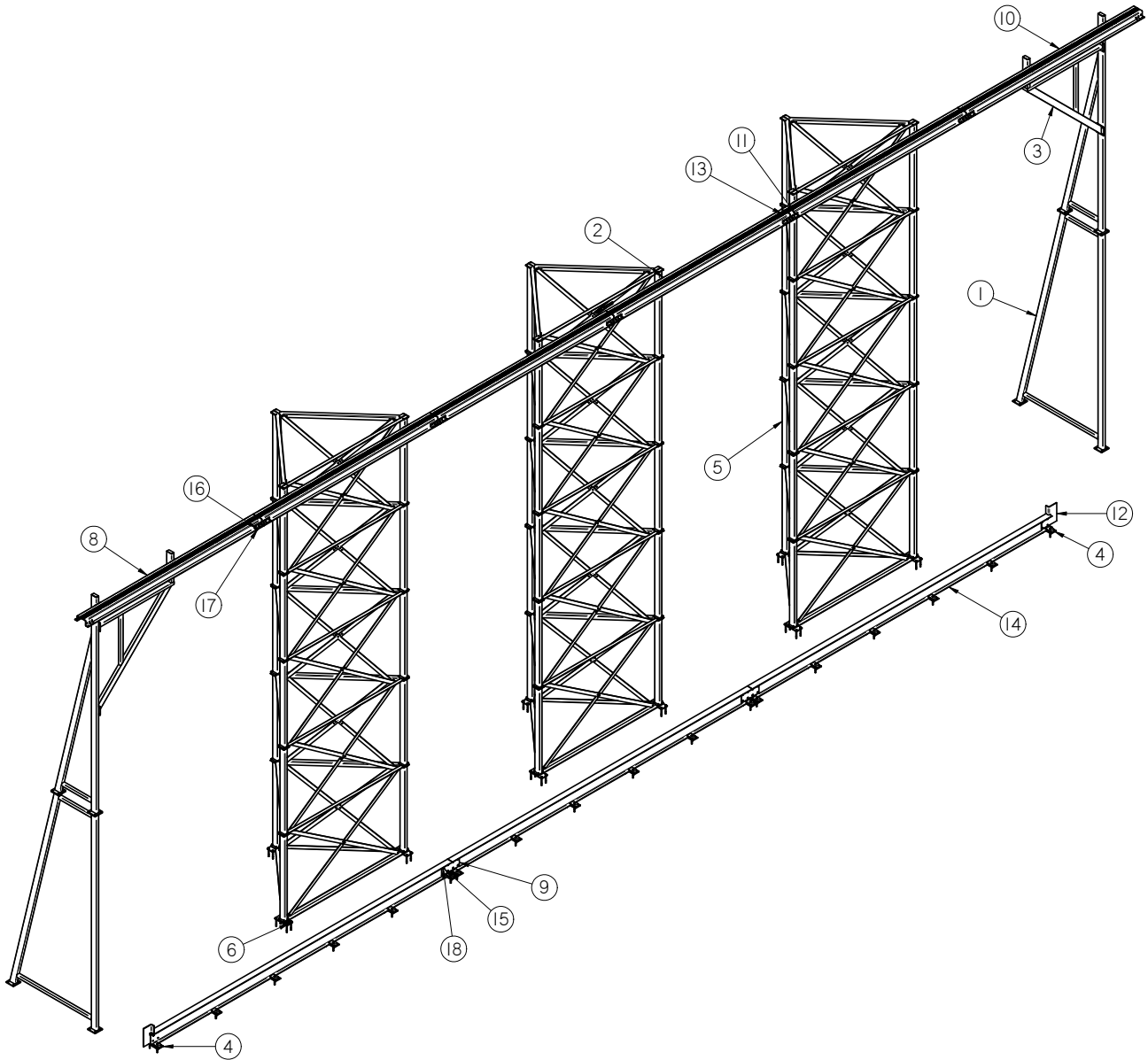


DETAIL B

Item #	Part #	Description	Qty
1	06-01-0025	BOLT,.500-13 G5 ZP 1.50.par	8
2	06-01-0179	BOLT,.500-13 CONC ANCHOR ZP 5.5 LONG.par	8
3	06-03-0015	NUT,LOCK,.500-13 ZP SERRATED -WHIZ-.par	8
4	11-03-0012	100E77.PSM	6
5	11-03-0004	100E76.PSM	1
6	11-10-0006	1010E3.par	1
7	11-10-0006	1010E5.par	1
8	11-10-0006	1010E6.par	1
9	11-10-0018	1010E0.par	2
10	11-10-0018	1010E1.par	1
11	11-10-0018	1010E4.par	1

WALKING LEG BIN FILL SYSTEM

TROLLEY TOP ASSEMBLY (13-08-0063)



WALKING LEG BIN FILL SYSTEM

TROLLEY TOP ASSEMBLY (13-08-0063)

Item #	Part #	Description	Qty
1	05-03-0561	WDMT END SUPP 25FT	2
2	05-03-0562	BRKT MNT TOP TRLLY SUPP	10
3	05-03-0567	WDMT END BRKT TOP TRLY	2
4	05-03-0624	CLMP BASE RAIL ASSY	18
5	05-07-0223	ASSY SUPP TWR 25FT	3
6	05-08-0089	SHIM KIT MOVING LEG TOWER	4
7	05-08-0090	SHIM KIT BOTTOM RAIL CLAMP	3
8	05-08-0091	SHIM KIT TOP RAIL MNT BRKTS	1
9	05-10-3218	SPLICE PLT BOTTOM TROLLEY RAIL	2
10	05-10-3220	UPPER SUPPORT RAIL 141"	6
11	05-10-3221	SPLICE TOP RAIL	10
12	05-10-3222	BRKT END STOP TRLY RAIL	2
13	05-10-3277	SPLICE TOP RAIL FLAT PLT	5
14	05-11-0219	RAIL BASE TROLLEY 20FT	3
15	06-01-0080	BOLT .500-13 X 1.25 ZP GR5	36
16	06-01-0127	BOLT CRG .375-16 X 1.25 ZP GR5	192
17	06-03-0014	NUT LOCK FLG .375-16 ZP GR5	192
18	06-03-0015	NUT LOCK FLG .500-13 ZP GR5	36

WALKING LEG BIN FILL SYSTEM

NOTES:

USC LIMITED WARRANTY

SECTION H

USC, LLC, (Manufacturer) warrants its seed treating equipment as follows:

1. **Limited Warranty:** Manufacturer warrants that the Products sold hereunder will be free from defects in material and workmanship for a period of 18 months from date of shipment. If the Products do not conform to this Limited Warranty during the warranty period, Buyer shall notify Manufacturer in writing of the claimed defects and demonstrate to Manufacturer satisfaction that said defects are covered by this Limited Warranty. If the defects are properly reported to Manufacturer within the warranty period, and the defects are of such type and nature as to be covered by this warranty, Manufacturer shall, at its expense, furnish replacement Products or, at Manufacturer's option, replacement parts for the defective products. Shipping and installation of the replacement Products or replacement parts shall be at the Buyer's expense.

2. **Other Limits:** THE FOREGOING IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. Manufacturer does not warrant against damages or defects arising from improper installation (where installation is by persons other than Manufacturer), against defects in products or components not manufactured by Manufacturer, or against damages resulting from such non-Manufacturer made products or components. Manufacturer passes on to the Buyer the warranty it received (if any) from the maker of such non-Manufacturer made products or components. This warranty also does not apply to Products upon which repairs and/or modifications have been effected or attempted by persons other than pursuant to written authorization by Manufacturer. Manufacturer does not warrant against casualties or damages resulting from misuse and/or abuse of product(s), acts of nature, effects of weather, including effects of weather due to outside storage, accidents, or damages incurred during transportation by common carrier.

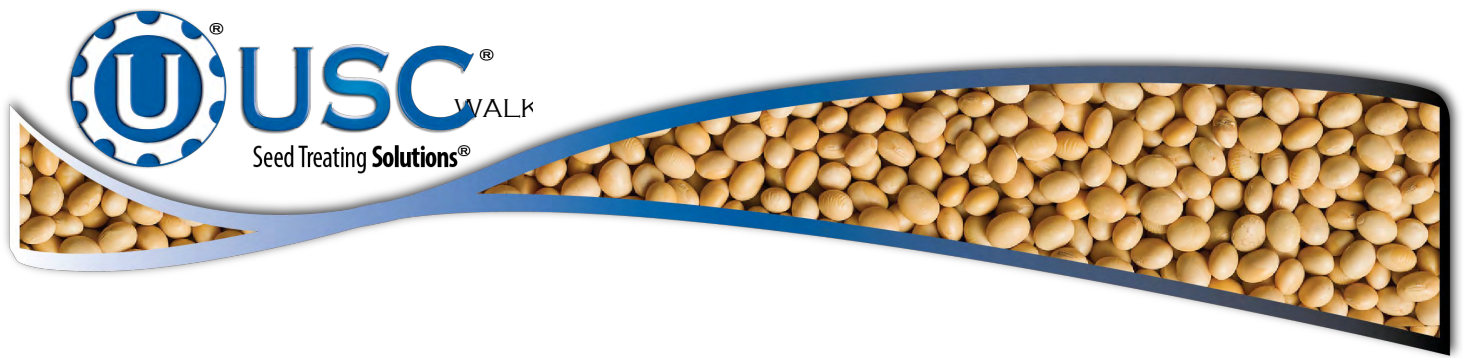
3. **Exclusive Obligation:** THIS WARRANTY IS EXCLUSIVE. The sole and exclusive obligation of Manufacturer shall be to repair or replace the defective Products in the manner and for the period provided above. Manufacturer shall not have any other obligation with respect to the Products or any part thereof, whether based on contract, tort, strict liability or otherwise. Under no circumstances, whether based on this Limited Warranty or otherwise, shall Manufacturer be liable for incidental, special, or consequential damages.

4. **Other Statements:** Manufacturer's employees or representatives' oral or other written statements do not constitute warranties, shall not be relied upon by Buyer, and are not a part of the contract for sale or this limited warranty.

5. **Return Policy:** Approval is required prior to returning goods to USC, LLC. A restocking fee will apply.

6. **Entire Obligation:** This Limited Warranty states the entire obligation of Manufacturer with respect to the Products. If any part of this Limited Warranty is determined to be void or illegal, the remainder shall remain in full force and effect.





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