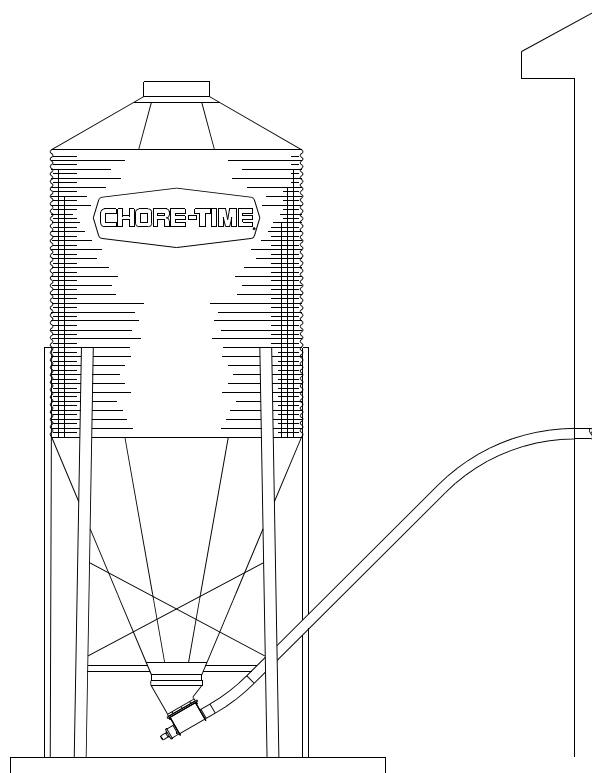


Model 55,75,75 Plus,90, & HMC FLEX-AUGER



For additional parts and information, contact your nearest Chore-Time distributor or representative.
Find your nearest distributor at: www.choretime.com/contacts

CTB, Inc.
PO Box 2000
Milford, Indiana 46542-2000 USA
Phone (574) 658-4101 Fax (877) 730-8825
Email: choretime@choretime.com
Internet: www.choretime.com

Installation and Operators Manual

Installation and Operators Manual

Limited Warranty

LIMITED WARRANTY

Chore-Time Group, a division of CTB, Inc. ("Chore-Time") warrants the new CHORE-TIME FLEX-AUGER Model 55,75 75 Plus,90, & HMC equipment manufactured by Chore-Time to be free from defects in material or workmanship under normal usage and conditions, for One (1) year from the date of installation by the original purchaser ("Warranty"). Chore-Time provides for an extension of the aforementioned Warranty period ("Extended Warranty Period") with respect to certain Product parts. If such a defect is determined by Chore-Time to exist within the applicable period, Chore-Time will, at its option, (a) repair the Product or Component Part free of charge, F.O.B. the factory of manufacture or (b) replace the Product or Component Part free of charge, F.O.B. the factory of manufacture. This Warranty is not transferable, and applies only to the original purchaser of the Product.

CONDITIONS AND LIMITATIONS

THIS WARRANTY CONSTITUTES CHORE-TIME'S ENTIRE AND SOLE WARRANTY AND CHORE-TIME EXPRESSLY DISCLAIMS ANY AND ALL OTHER WARRANTIES, INCLUDING, BUT NOT LIMITED TO, EXPRESS AND IMPLIED WARRANTIES, INCLUDING, WITHOUT LIMITATION, WARRANTIES AS TO MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSES. CHORE-TIME shall not be liable for any direct, indirect, incidental, consequential or special damages which any purchaser may suffer or claim to suffer as a result of any defect in the Product. Consequential or Special Damages as used herein include, but are not limited to, lost or damaged products or goods, costs of transportation, lost sales, lost orders, lost income, increased overhead, labor and incidental costs, and operational inefficiencies. *Some jurisdictions prohibit limitations on implied warranties and/or the exclusion or limitation of such damages, so these limitations and exclusions may not apply to you. This warranty gives the original purchaser specific legal rights. You may also have other rights based upon your specific jurisdiction.*

Compliance with federal, state and local rules which apply to the location, installation and use of the Product are the responsibility of the original purchaser, and CHORE-TIME shall not be liable for any damages which may result from non-compliance with such rules.

The following circumstances shall render this Warranty void:

- Modifications made to the Product not specifically delineated in the Product manual.
- Product not installed and/or operated in accordance with the instructions published by the CHORE-TIME.
- All components of the Product are not original equipment supplied by CHORE-TIME.
- Product was not purchased from and/or installed by a CHORE-TIME authorized distributor or certified representative.
- Product experienced malfunction or failure resulting from misuse, abuse, mismanagement, negligence, alteration, accident, or lack of proper maintenance, or from lightning strikes, electrical power surges or interruption of electricity.
- Product experienced corrosion, material deterioration and/or equipment malfunction caused by or consistent with the application of chemicals, minerals, sediments or other foreign elements.
- Product was used for any purpose other than for the care of poultry and livestock.
-

The Warranty and Extended Warranty may only be modified in writing by an officer of CHORE-TIME. CHORE-TIME shall have no obligation or responsibility for any representations or warranties made by or on behalf of any distributor, dealer, agent or certified representative.

Effective: April 2014

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Safety and General Information

Caution, Warning and Danger Decals have been placed on the equipment to warn of potentially dangerous situations. Care should be taken to keep this information intact and easy to read at all times. Replace missing or damaged safety decals immediately.

Safety–Alert Symbol



This is a safety–alert symbol. When you see this symbol on your equipment, be alert to the potential for personal injury. This equipment is designed to be installed and operated as safely as possible...however, hazards do exist.

Understanding Signal Words

Signal words are used in conjunction with the safety–alert symbol to identify the severity of the warning.



DANGER indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



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



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

Follow Safety Instructions

Carefully read all safety messages in this manual and on your equipment safety signs. Follow recommended precautions and safe operating practices.

Keep safety signs in good condition. Replace missing or damaged safety signs.

Decal Descriptions

DANGER: Moving Auger

This decal is placed on the End Cap Weldment and Clean-out cover. Severe personal injury will result, if the electrical power is not disconnected, prior to servicing the equipment.



DANGER: Electrical Hazard

Disconnect electrical power before inspecting or servicing equipment unless maintenance instructions specifically state otherwise.

Ground all electrical equipment for safety.

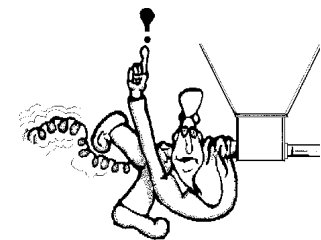
All electrical wiring must be done by a qualified electrician in accordance with local and national electric codes.

Ground all non-current carrying metal parts to guard against electrical shock.

Electrical disconnects and over current protection are not supplied with the equipment.

DANGER: Springing Auger

Use caution when working with Auger. Springing Auger may cause personal injury.



Attention: Read the Manual

See the manual for detailed installation instructions.



General Information

The CHORE-TIME FLEX-AUGER® Feed delivery system is designed to deliver poultry and livestock feed types. Using this equipment for any other purpose or in a way not within the operating recommendations specified in this manual will void the warranty and may cause personal injury and/or death.

This manual is designed to provide comprehensive planning, installation, wiring, and parts listing information. The Table of Contents provides a convenient overview of the information in this manual. The Table of Contents also specifies which pages contain information for the sales personal, installer, and consumer (end user).

IMPORTANT: CE stands for certified Europe. It is a standard which equipment must meet or exceed in order to be sold in Europe. CE provides a benchmark for safety and manufacturing issues. CE is required only on equipment sold in Europe.

CHORE-TIME Equipment recognizes CE Mark and pursues compliance in all applicable products. Any alterations to the products will violate the CE compliance, will void the warranty, and may cause personal injury and/or death.

Please include the names and address of your CHORE-TIME Distributor.



Please fill in the following information about your Chore-Time FLEX-AUGER® System. Keep this manual in a clean, dry place for future reference.

Distributor's Name _____

Distributor's Address _____

Distributor's Phone _____ **Date of Purchase** _____

Installer's Name _____

Installer's Address _____

Installer's Phone _____ **Date of Installation** _____

System Specifications _____

Feed Delivery System Supplying

Selecting the System

CHORE-TIME Feed Delivery systems are designed to handle most common livestock and poultry feeds. We can not guarantee satisfactory operation with all formulations. We suggest that you contact our Technical Service Department concerning the use of new or unusual formulations.

FLEX-AUGER Feed Delivery Systems are the most versatile feed conveying systems available. Their ease of installation, reliability, low maintenance, and adaptability for many different applications, make them an indispensable part of any livestock feeding system.

The FLEX-AUGER Feed Delivery System you choose should be based on the following;

1. Particle Size - Feed particles that are too large for the system will cause damage to the particles, excessive power requirements, and plugging of the system.
2. Moisture Content (18% maximum) - The moisture content of the feed, among other factors, determines the amount of buildup that will occur on the auger and auger tubes when conveying feed. Feeds with high moisture content (above 18%) will freeze if exposed to freezing temperatures. This type of feed tends to flow less-easily causing higher power requirements. Feeds in High Moisture Corn applications should not exceed 27% moisture content.
3. Feed capacities - Each size of FLEX-AUGER delivers feed at a different rate. These rates should be matched to your feed requirements. An application that requires a large volume of feed to be moved should use a larger (i.e. Model 90 or HMC) auger system or possibly two smaller auger (i.e. Model 55 or 75) systems. See below for System Comparison information.
4. Running Time - Size the system so that the maximum operating time is four hours per day (24 hours). If necessary, refer to **"Livestock and Poultry Feed Consumption" on page 55**. If your system operating times exceed four hours per day, contact your distributor or Chore-Time's Technical Service Department.

NOTE: The maximum allowable liquid molasses content for all FLEX-AUGER Feed Delivery Systems is 2%. At higher liquid molasses content or at moisture levels above the recommended limits, the auger tubes can become coated. This reduces the carrying capacity of the feed delivery system, causing eventual plugging of the system.

Commercial layer applications require the use of all steel FLEX-AUGER Feed Delivery Systems. Hardened steel elbows are required for these applications. This is due to the abrasive feed particles in commercial layer feed rations. Do not mix steel and PVC components within a system.

System Comparison Chart

System	Tube Dia.	Delivery Rate*	Feed Types	Max. Partical Size
Model 55	2-1/4" (55 mm)	15 lb/min. (7 kg/min.)	mash, crumbles 18% moist. content	1/8" x 1/2" (3 mm x 13 mm)
Model 75	3" (75 mm)	50 lb/min. (22 kg/min.)	mash, crumbles 18% moist. content	1/8" x 1/2" (3 mm x 13 mm)
Model 75 Plus	3" (75 mm)	50 lb/min. (22 kg/min.)	mash, crumbles, pellets 18% moist. content	1/4" x 5/8" (8 mm x 13 mm)
Model 90	3-1/2" (90 mm)	100 lb/min. (45 kg/min.)	mash, pellets, shelled corn 18% moist content	3/16" x 1/2" (5 mm x 13mm)
Model HMC	3-1/2" (90 mm)	50 lb/min. (22 kg/min.)	high-moisture corn, larger pellets, crumbles, mash 27% moist. content	3/8" x 3/4" (10 mm x 20 mm)

*Conveying capacity is based on feed with 40 pounds per cubic foot (640 kg. per cubic meter) density.

Conveying capacities for all the FLEX-AUGER Systems are determined using 348 RPM Power Units; Except Model 75 Plus which runs at 425 RPM.

System Weight & Length Specifications

Adequate support must be provided to prevent the tubes from sagging and support the weight of the Control Unit. The auger, tubes, and feed weigh approximately 6 lbs/ft. (9 kg/m). The Control Unit weighs approximately 80 lbs. (36 kg).

Line lengths specified allow for two 45 degree elbows in the elevation. Reduce line length by 30' (9 m) for each additional horizontal 90 degree elbow.

For Tandem Systems, raise the horsepower one size over recommendations in the table below or reduce line length by 50' (15.4 m).

Note: If voltage supplied is 208V, reduce the line lengths by 20%.

Horsepower requirements are based on length of the FLEX-AUGER System and type of system installed--number of turns, tandem systems, etc. The charts included show maximum line lengths for FLEX-AUGER Systems plus maximum lengths for systems using Extension Hoppers.

Model 55

Motor H.P.	Maximum Line Length	Maximum Extension
1/3	150' (46 M)	185' (56 M)
1/2	250' (76 M)	285' (72 M)

Model 90

Motor H.P.	Maximum Line Length	Maximum Extension
1/2	30' (9 M)	65' (20 M)
3/4	90' (27 M)	125' (38 M)
1	150' (46 M)	185' (56 M)

Model 75

Motor H.P.	Maximum Line Length	Maximum Extension
1/2	80' (24 M)	125' (38 M)
3/4	150' (46 M)	185' (56 M)
1	200' (61 M)	245' (75 M)

Model HMC

Motor H.P.	Maximum Line Length	Maximum Extension
1/2	30' (9 M)	55' (17 M)
3/4	90' (27 M)	105' (32 M)
1	150' (46 M)	185' (56 M)

***Model 75 Plus**

Motor H.P.	Maximum Line Length	Maximum Extension
3/4	75' (23 M)	105' (55 M)
1	150' (46 M)	180' (55 M)
1-1/2	300' (91 M)	330' (101 M)

All Systems, except Model 75 Plus are based on 348 RPM Power Units.

*Model 75 Plus System is based on a standard 425 RPM Power Units.

Planning

Planning the System

See **Figure 1. on page 10** for recommended, and **Figure 2. on page 10** for non-recommended FLEX-AUGER installations. When laying out the FLEX-AUGER Feed Delivery System, plan the system so that the auger tubes do not interfere with doors, windows, or other equipment.

See **“Bin to Building Placement Chart” on page 11** for different elevations and boots.

1. For the easiest installation and most trouble-free operation, locate the feed bin in a direct line with the FLEX-AUGER Feed Delivery System. The **“Bin to Building Placement Chart” on page 11** also provides some points of reference for bin placement according to the height at which the FLEX-AUGER tube enters the building. Remember, these are only examples. The layouts can be modified by changing the elbows, the tube sections, and/or the distance from the bin to the building.
Locate the bin so that the FLEX-AUGER Feed Delivery System does not have to convey feed at an angle of more than 60 degrees from the horizontal to enter the building at the desired height. Chore-Time considers a 45 degree elevation to be standard--the lower the angle, the more reliable the system.
2. Lay out the system as straight as possible. Avoid extra elbows and curves by locating the feed bin in line with the feeders. One horizontal 90 degree right hand turn is permissible inside the building. 180 degree turns are not recommended under any conditions.
If additional turns or elbows are required, use extension hoppers. Remember: one 90 degree elbow requires the same power as 30' (9.1 m) of straight line.
3. Plan the system so that the auger tubes are directly over the feeders or hoppers to be filled as possible. The drop tubes may be angled up to a maximum of 45 degrees from the vertical if necessary. At angles greater than 45 degrees, bridging in the drop tubes may occur.
4. The control unit must be located over a feeder or hopper that will require as much or more feed than any of the other feeders or hoppers. If frequent filling is desired, mount the drop tube switch or hopper level switch low so that this feeder or hopper will have a low feed level. This causes the feeder to call for feed more often, the system will restart, and the other feeders will be refilled sooner.
5. Do not locate outlet drops on or just before an elbow. Install the drop after the elbow so feed will cushion the auger through the curve. If there is some reason why the outlet drop cannot be moved, it must have some “feed bypass” to cushion the auger through the elbow.
6. Avoid horizontal left-hand turns if possible. The elbow in a left-hand turn is not cushioned by the feed and will wear faster. On systems with a 90 degree horizontal left-hand turn, reduce the stretch to reduce wear.

NOTE: A rule of thumb for left-hand turns is to reduce stretch to 1" per 50' (25 mm per 15.2 m) on initial installation; except for Model 75 Plus Systems. For Model 75 Plus Systems reduce stretch by 2.5" per 50' (63.5 mm per 15.2 m). Increase the stretch if necessary.
If an extension hopper is used:

- A. Locate the hopper so there will not be any outlet drops on the short tube or elbow leading out of the hopper.
- B. The longer portion of the system with most of the outlet drops should follow the extension hopper. For example: in a 300' (91.4 m) Model 75 System the distance from the bin to the extension hopper should be 100' (30.5 m). From the extension hopper to the control unit should be 200' (61 m) with most outlets placed on the 200' (61 m) section. Refer to **“System Weight & Length Specifications” on page 9**, for power unit requirements.

NOTE: The lower part of the extension hopper can be turned 90 degrees to the left or right in relation to the top portion of the extension hopper. This allows the extension hopper to replace a horizontal elbow where both might be located in approximately the same position in the system.

7. Remember the following when installing a Straight-Through Tandem System or Two Motor Tandem System:
 - A. The straight-through tandem bin arrangement uses one continuous auger.
 - B. The Two Motor Tandem bin arrangement uses two separate augers and power units.
 - C. Pour one level concrete pad for both bins (in either system).
 - D. Position bins so that legs will not interfere with the FLEX-AUGER System (in either system). See the Two Motor Tandem System instructions (Model 75, 90, & HMC systems only).
8. See **“System Weight & Length Specifications” on page 9** to determine maximum line lengths and power unit requirements.

Installation

Recommended Layouts

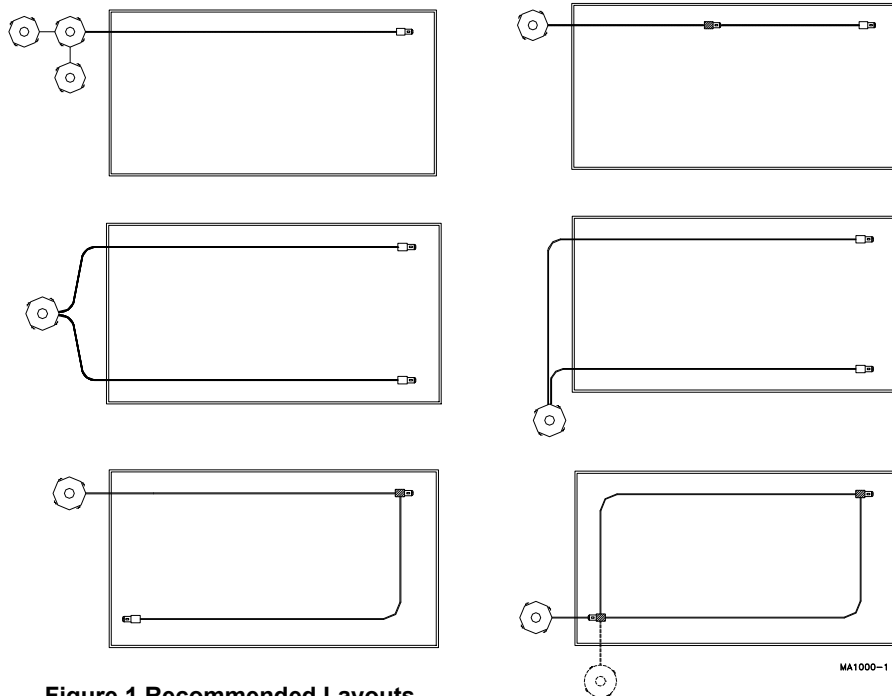


Figure 1.Recommended Layouts

Not Recommended Layouts

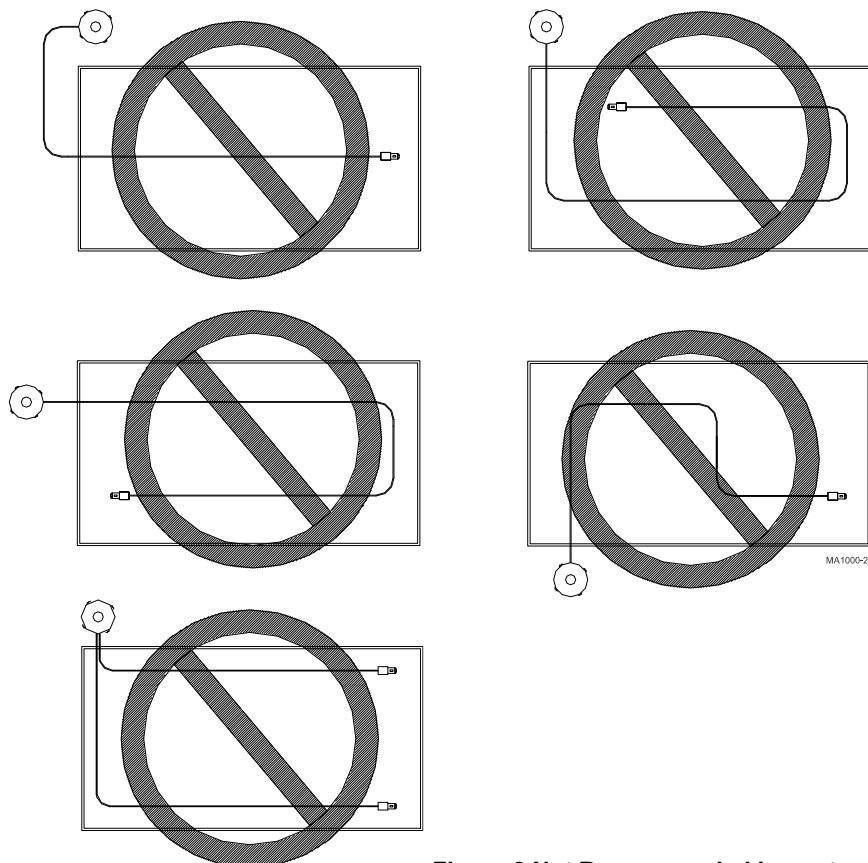


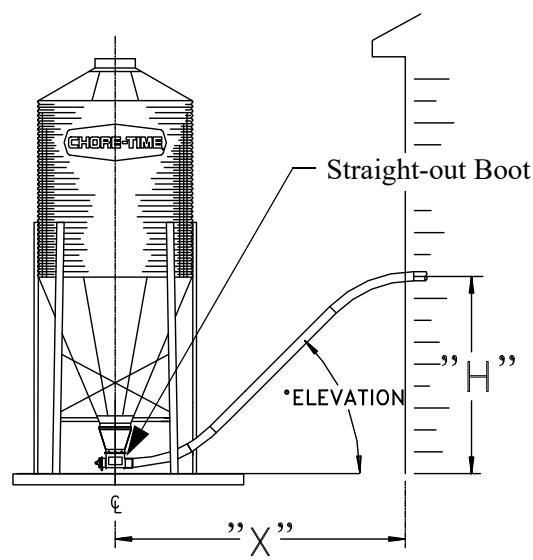
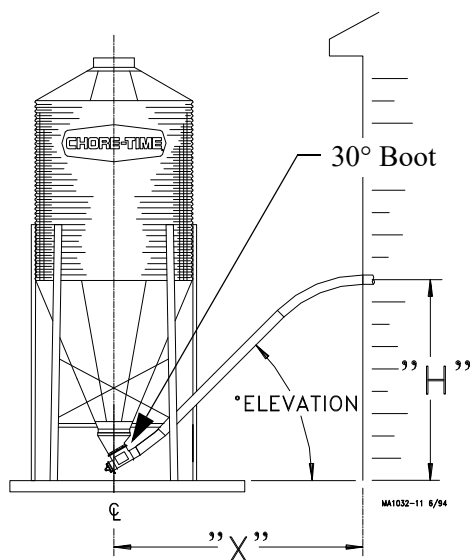
Figure 2.Not Recommended Layouts

Bin to Building Placement Chart

Use this chart to determine the distance from building to center of bin ("X") at the various entrance heights ("H") and degrees of elevations listed below.

- The bin on the right is shown with a straight-out bin boot.
- The bin on the left is shown with a 30 degree bin boot.

System Model	Entrance Height "H"	30 Degree Upper Bin Boot (part no. 4347)			Straight-Out Upper Bin Boot (part no. 6093)		
		30 Degree	45 Degree	60 Degree	30 Degree	45 Degree	60 Degree
Model 55, 75, 90, or HMC with 5' radius elbows	5' (1.5 m)	9' (2.7 m)	-----	-----	11.5' (3.5 m)	10' (3 m)	-----
	6' (1.8 m)	11' (3.4 m)	8.5' (2.6 m)	8' (2.4 m)	13.5' (4.1 m)	11' (3.4 m)	10' (3 m)
	7' (2.1 m)	12.5' (3.8 m)	9.5' (2.9 m)	8.5' (2.6 m)	15' (4.6 m)	12' (3.7 m)	11' (3.4 m)
	8' (2.4 m)	14.5' (4.4 m)	10.5' (3.2 m)	9' (2.7 m)	17' (5.2 m)	13' (4 m)	11.5' (3.5 m)
	9' (2.7 m)	16' (4.9 m)	11.5' (3.5 m)	9.5' (2.9 m)	18.5' (5.6 m)	14' (4.3 m)	12' (3.7 m)
	10' (3 m)	17.5' (5.3 m)	12.5' (3.8 m)	10' (3 m)	20' (6.1 m)	15' (4.6 m)	12.5' (3.8 m)
	11' (3.3 m)	19.5' (5.9 m)	13.5' (4.1 m)	10.5' (3.2 m)	22' (6.7 m)	16' (4.9 m)	13' (4 m)
	12' (3.7 m)	21' (6.4 m)	14.5' (4.4 m)	11.5' (3.5 m)	23.5' (7.2 m)	17' (5.2 m)	13.5' (4.1 m)
	13' (4 m)	23' (7 m)	15.5' (4.7 m)	12' (3.7 m)	25.5' (7.8 m)	18' (5.5 m)	14' (4.3 m)
	14' (4.3 m)	24.5' (7.5 m)	16.5' (5 m)	12.5' (3.8 m)	27' (8.2 m)	19' (5.8 m)	15' (4.6 m)
	15' (4.6 m)	26.5' (8.1 m)	17.5' (5.3 m)	13' (4 m)	29' (8.8 m)	20' (6 m)	15.5' (4.7 m)
	16' (4.9 m)	28' (8.5 m)	18.5' (5.6 m)	13.5' (4.1 m)	30.5' (9.3 m)	21' (6.4 m)	16' (4.9 m)
	17' (5.2 m)	30' (9.1 m)	19.5' (5.9 m)	14' (4.3 m)	32.5' (9.9 m)	22' (6.7 m)	16.5' (5 m)
	18' (5.5 m)	31.5' (9.6 m)	20.5' (6.2 m)	14.5' (4.4 m)	34' (10.4 m)	23' (7 m)	17' (5.2 m)
	19' (5.8 m)	33.5' (10.2 m)	21.5' (6.5 m)	15.5' (4.7 m)	36' (11 m)	24' (7.3 m)	17.5' (5.3 m)
	20' (6.1 m)	35' (10.7 m)	22.5' (6.8 m)	16' (4.9 m)	37.5' (11.4 m)	25' (7.6 m)	18.5' (5.6 m)



Installation

Installation Notes

Install the equipment as specified in this manual. Failure to install as specified may cause damage to the equipment and/or cause personal injury or death.

Take special notice of the warnings and safety decals on the equipment and in this manual.

Always wear protective clothing and protective glasses when working with the equipment.

Discarded materials, equipment, and boxes may be recycled. Recycle according to local and national codes.

Unless otherwise specified, the Model 55, 75, 75 Plus, 90, & HMC Systems are installed similarly.

All the systems are available with straight-out or 30 degree upper boots, except the Model 55. The Model 55 requires the 30 degree upper boot (the straight-out boot is not available for the Model 55).

Bin Location and Collar Information

For easiest installation and trouble-free operation, locate the feed bin in a direct line with the FLEX-AUGER System. The layout chart provides some points of reference for bin placement according to the height at which the system enters the building.

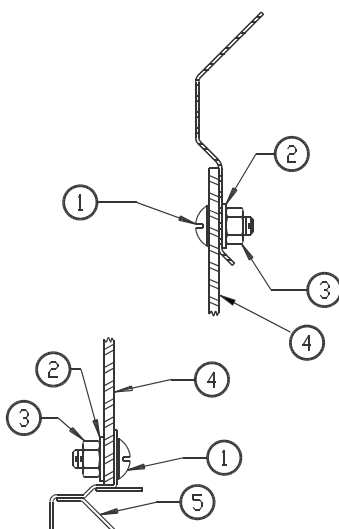
The bin collar is installed during bulk bin assembly. Chore-Time bins have a welded collar. Bin Adapter Kits are available to modify existing bins so that the welded collar can be used. In addition, most other feed bin manufacturers have a collar available to be used with Chore-Time FLEX-AUGER Feed Delivery Systems.

Boot Installation

1. Insert the upper boot into the bin collar opening and turn it to line up with the direction that the auger line will go. The boot must be as far up into the opening as it will go. Use the holes in the ring for drilling guides and drill 11/32" (8.8 mm) holes in the upper rim of the boot. Attach the boot to the Bin Collar using the hardware provided. **See Figure 3.** for correct use of hardware to attach the boot.

IMPORTANT: Failure to install the hardware as shown in Figure 3 may cause breakage of the Upper boot body.

2. Attach the transfer plate to the upper boot. Use truss head bin-seal bolts installed from the inside of the plate, with flat washers placed under the nuts.
3. Insert the slide into the transfer plate slot so that it is in its operating position before bolting the slide shield in place. Use two 5/16-18x3/4" hex head machine screws to secure the shield.
4. Bolt the lower boot to the transfer plate using four 5/16-18x3/4" hex head machine screws.



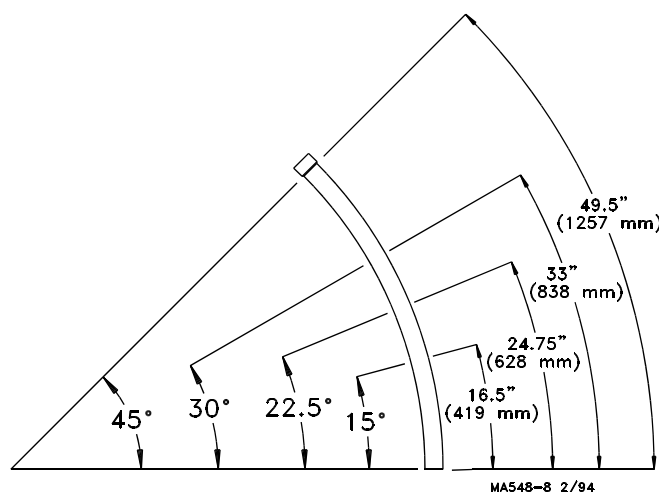
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Key	Description
1	5/16-18x3/4" Truss Head Screw
2	5/16" Nylon Washer
3	5/16-18 Nylon Hex Nut
4	Upper Boot Body
5	Transfer Plate
6	Welded Bin Collar

Figure 3.Boot Installation Diagram

Auger Tube Installation

The FLEX-AUGER Delivery System includes two 45 degree elbows as standard equipment. These elbows are used to make the sloping portion of the auger line at the feed bin, and elsewhere in the system if necessary. If additional elbows are required, they should be ordered separately. **Figure 4** shows how the elbow can be cut into shorter sections.



15 Degree Elbow	16.5" or 419 mm
22.5 Degree Elbow	24.75" or 628 mm
30 Degree Elbow	33" or 838 mm
45 Degree Elbow	49.5" or 1257 mm

These dimensions are measured along the long, outside curve of the elbow. They do not include the belled end of the elbow in the measurement.

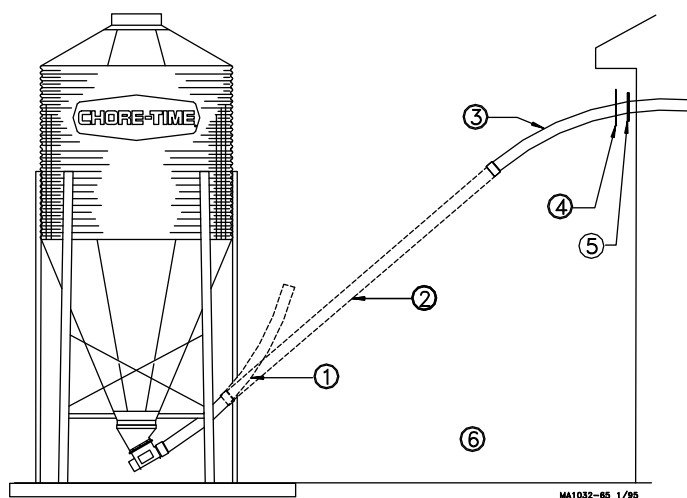
Figure 4.PVC Elbow Cutting Guidelines

1. Determine where the entrance hole for the auger tube must be located on the building and cut it.
2. Cut the elbow used where the auger enters the building (if necessary). Slide the seal ring and neoprene seal over the straight end of the elbow and place it in the hole cut in the building, with the belled end outside the building. (See **Figure 5**).
3. Model 75, 75 Plus, 90, & HMC: Slide the belled end of the elbow or auger tube over the outlet end of the boot. A clamp is provided to secure the elbow or auger tube to the boot.

Model 55: Install the Model 55 Stub Tube over the outlet end of the boot. A clamp is provided to secure the Stub Tube to the boot.

Slide the belled end of the first elbow or auger tube over the stub tube.

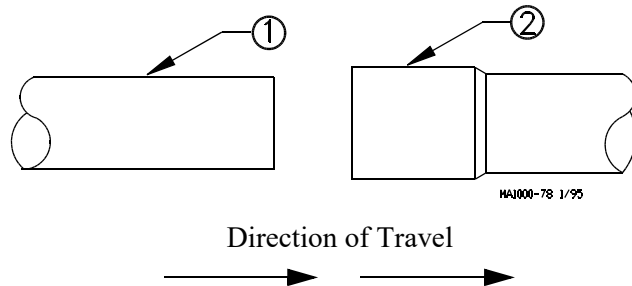
4. Place the end of a straight section of tube inside the belled end of the elbow in the building. Hold the straight section of auger tube so that it touches the elbow on the boot. Mark the spot where the tube aligns with the "boot" elbow and cut the elbow at that point.



Key	Description
1	45° Elbow
2	Auger Tube
3	45° Elbow
4	Seal Ring
5	Neoprene Seal
6	Note: Belled end of elbows and auger tubes should be towards boot.

Figure 5.Elbow Installation outside the building

5. Place the belled end of the auger tube over the end of the elbow just cut, and hold the tube against the top elbow. Mark and cut the straight auger tube so that it will fit between the two elbows. Remember to cut the auger tube long enough to fit inside the belled end of the elbow in the building. Figure 4 shows the direction the auger is to run in relation to the belled end of the tube. NOTE: In some installations it may be possible to eliminate the elbow on the boot, using only a straight auger tube and one elbow where the tube enters the building.



Key	Description
1	Straight section of Auger Tube
2	Belled end of Auger Tube

Figure 6. Proper Auger Tube Connection

6. Dry-fit all parts. When satisfied that elbows and tubes fit together smoothly, glue with PVC cement according to the following instructions.

The auger tubes and elbows for the FLEX-AUGER systems are made of specially formulated PVC tubing. Use the PVC solvent cement to make strong, reliable bonds.

FOLLOW DIRECTIONS ON THE CAN FOR SAFE HANDLING OF CEMENT.

1. Be sure tube is cut off squarely. Remove burrs from outside and inside the end of the tube.
2. Dry fit all parts. Tube should fit inside belled end of next tube to full depth without excess force.
3. Clean surfaces to be joined. SURFACES MUST BE FREE OF DIRT OR GREASE!
4. Apply a generous coat of cement to both the inside of the belled end and outside of the other tube. Be sure cement covers all of the joint area so there are no bare spots.
5. Quickly join the tubes, giving them a twisting motion to bring them into alignment as they are joined.
6. Keep pressure on the joint until the PVC cement sets up.

ALL TUBE JOINTS EXPOSED TO MOISTURE AND WEATHER MUST BE SEALED OR CAULKED TO WATERPROOF THEM IN ADDITION TO CEMENTING OR CLAMPING THE JOINT!

7. If there is more than 15 feet (4.5 meters) of auger tube between the boot and the building, provide additional support for the tubes so that the boot does not have to carry the weight of the auger. Extra support can be achieved with cables or chains fastened to the bin legs and auger tube.
8. Install the remaining tubes in the system AFTER the outlet holes have been located and cut. The auger tubes should be cemented using PVC cement supplied. NOTE: The tubes can be joined by cutting off the belled ends and fastening tubes together with tube connectors if there is some reason why permanent installation is not desired. (Tube Connectors are not standard equipment and must be ordered separately for this type of installation).

Supporting the System Inside the Building

Support the Auger Tubing with chain and "S" Hooks every 5 feet [1.5m]. Steel Tube systems require support every 10 feet [3m]. The system should be restrained from swinging by using chain and "S" hooks to brace the auger tube, every 20 feet [6m], as shown in **Figure 7**.

Horizontal elbows need to be supported in at least two places. Chain, screw hooks, and "S" hooks are supplied as a suspension kit for supporting the equipment. Keep the line as level and straight as possible.

If Drop Feeders, Extension Hoppers, Outlet Drops with long angled Drop Tubes, or other loads are imposed on the system, extra support will be required.

Power Units require extra support to resist the twisting encountered when the motor starts and stops. Use the motor mount base, all of the "ears" on the gearhead as well as the suspension point provided on the 46800 Control Unit Box to support the Power Unit.

Adequate chain and "S" hooks are provided with each system to properly support it. Other means of supporting the system are permissible as long as the system receives the correct support and the auger tube is not dented or flattened. Alternative support systems must allow for expansion and contraction of the Auger Tubes.

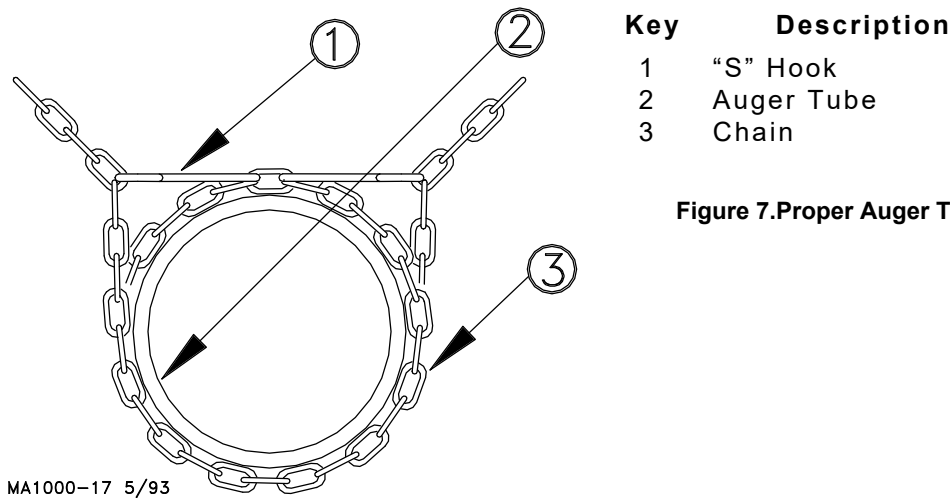


Figure 7.Proper Auger Tube Connection

When the auger tube passes through a side wall or partition, especially where it enters the building, the opening should be made large enough so the auger tube can be supported without resting on the wall. If the auger tube rests on the wall or partition, the auger tube may flatten out or become kinked--causing excessive wear. (See **Figure 8**).

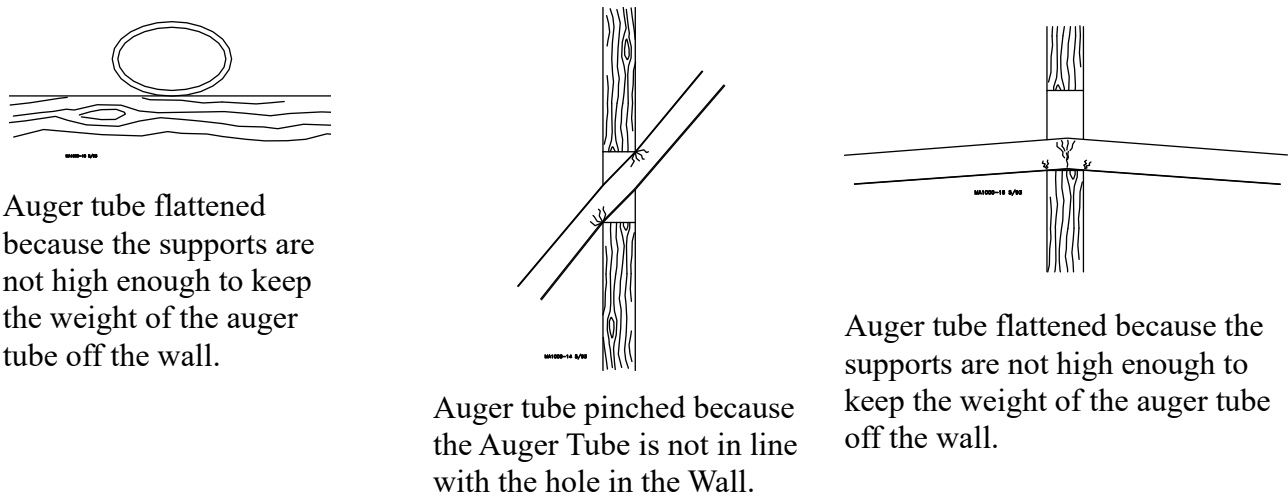


Figure 8.Faulty Tube Installations

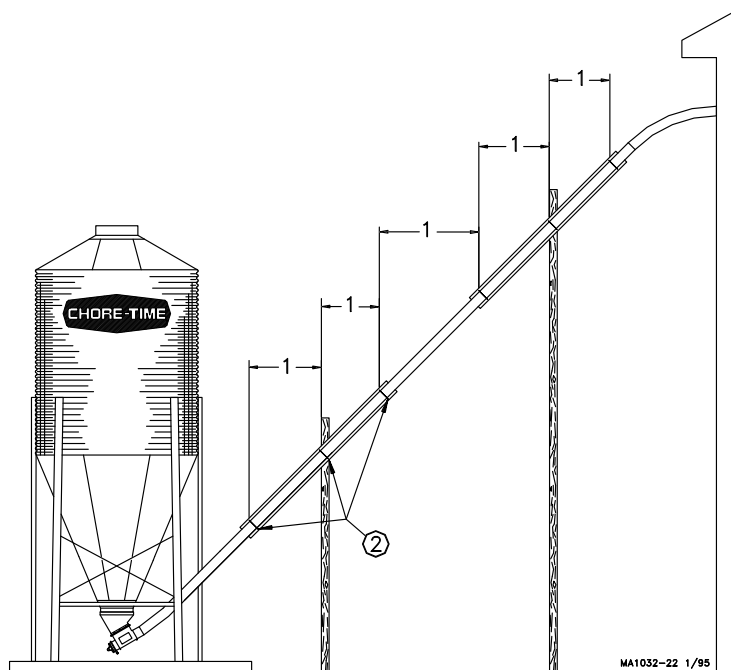
Supporting the System Outside the Building

Some systems require additional support to avoid sagging auger tubes. This support must be adequate to support the weight of the auger tubes filled with feed. Special attention should be given to avoid excessive pressure from the auger being transferred to boot. Chain or cable suspended from the bin or building will not provide adequate support for these systems.

Some common systems are shown in **Figure 9**, **Figure 10**, and **Figure 11** with the recommended supports.

Note: Supports must be designed to prevent (weight) loads from being transferred back onto the boot.

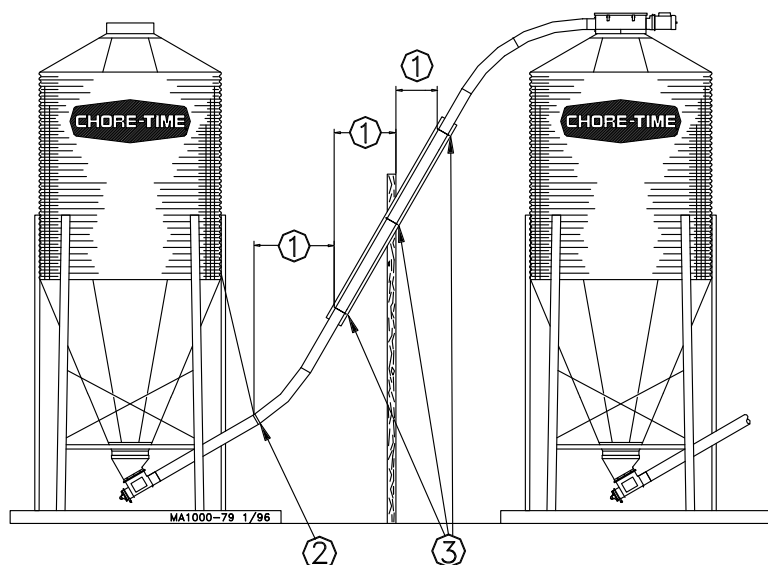
Elevated Systems



Key	Description
1	5' (1.5 m) for PVC systems 10' (3 m) for STEEL systems
2	Place clamps here.

Figure 9.Elevated Systems

Bin to Bin Fill Systems



Key	Description
1	5' (1.5 m) for PVC systems 10' (3 m) for STEEL systems
2	Place clamps here.

Figure 10.Bin to Bin Fill Systems

Long Elevated Systems

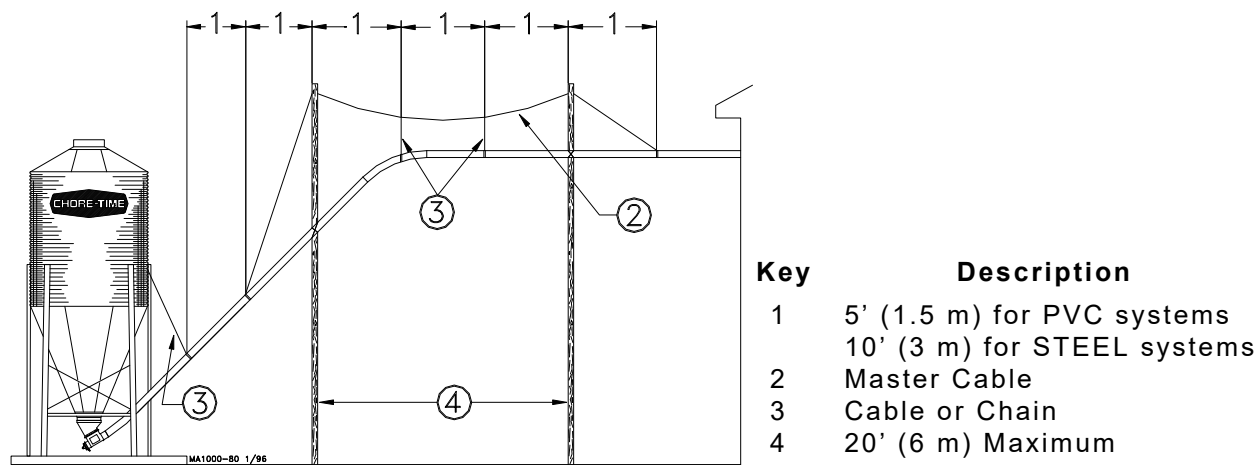


Figure 11.Long Elevated Systems

Outlet Assembly Installation

The Model 55, 75, HMC/90 Outlet Assemblies are designed to drop feed from a Feed Delivery or Feeding System into a Gravity Drop Tube. **Figure 12** shows the components that make up an outlet assembly.

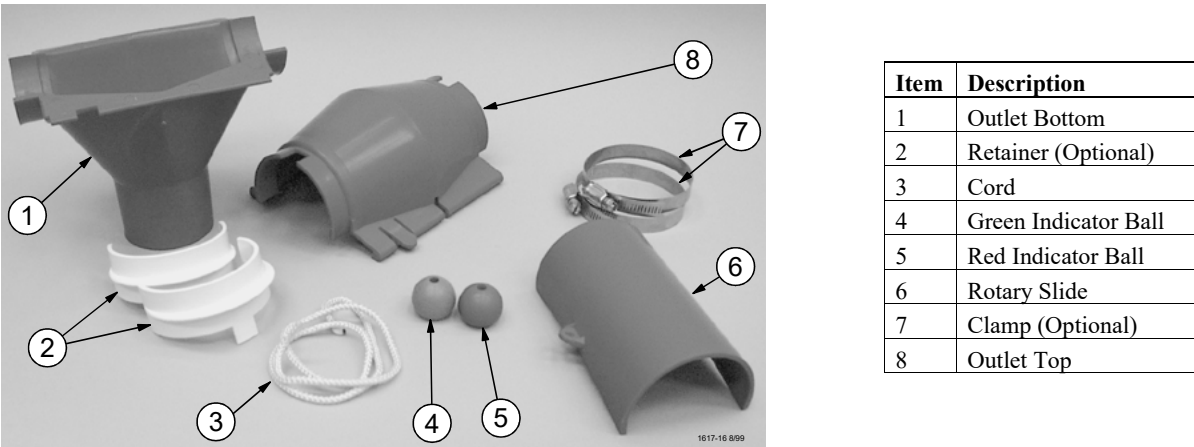


Figure 12.Outlet Assembly Components

1. Determine the location of the Outlet Assembly and drill or cut the desired outlet hole as shown in **Figure 13**.

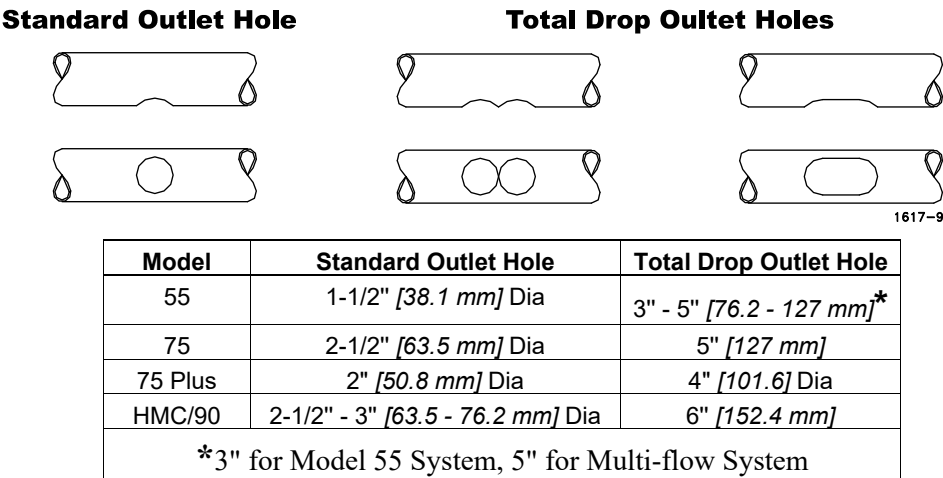
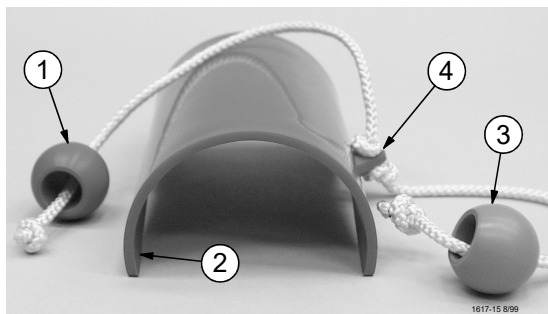


Figure 13.Cutting the Outlet Hole in the Fill System Pipe

2. Insert the Cord through the hole in the Rotary Slide tab, pull until centered, and knot it on both sides of the tab as shown in **Figure 14**. Slide the Indicator Balls on the Cord ends, as shown in **Figure 14**, and knot the Cord ends so the Indicator Balls will not fall off.



Item	Description
1	Red Indicator Ball
2	Rotary Slide

Item	Description
3	Green Indicator Ball
4	Tab on Rotary Slide

Figure 14. Assembling the Rotary Slide

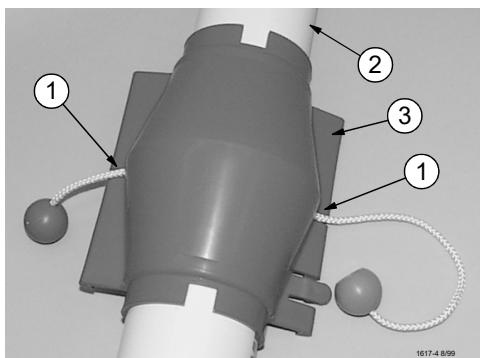
3. Snap the assembled Rotary Slide over the Fill System Pipe as shown in **Figure 15**.



Item	Description
1	Fill System Pipe
2	Rotary Slide

Figure 15. Rotary Slide Snapped onto the Fill System Pipe

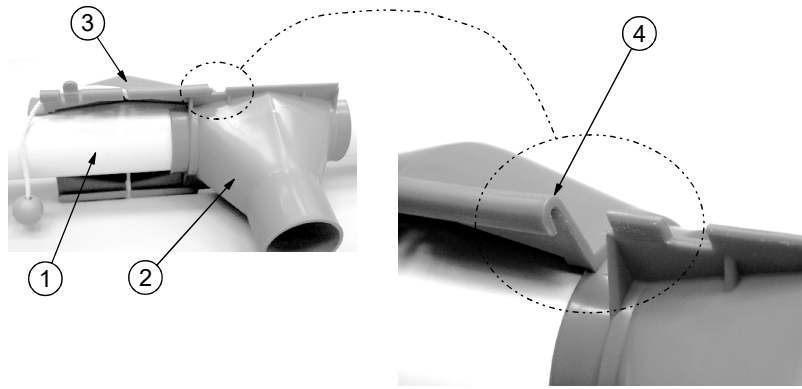
4. Snap the Outlet Top to the Fill System Pipe over the Rotary Slide as shown in **Figure 16**. Make sure the Cord comes out through the notches on each side of the Outlet Top as shown in **Figure 16**.



Item	Description
1	Notch on Top
2	Fill System Pipe
3	Outlet Top

Figure 16. Top Placed over the Rotary Slide

5. Use the Cord ends to hold the Rotary Slide in the full open position (cradled inside of the Outlet Top.) Engage the top edges of the Outlet Bottom into the open ends of the Outlet Top Tracks. Slide the parts together pressing the locking tab on the Outlet Top out of the way, allowing the Outlet Bottom to pass until completely assembled. The locking tab should then snap into place preventing the outlet assembly from sliding apart. (See **Figure 17**)



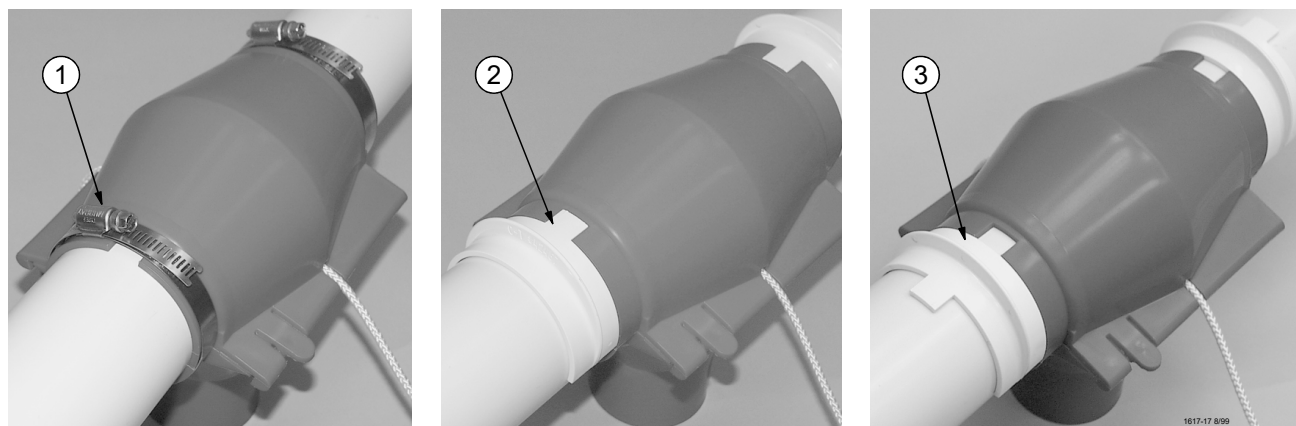
Item	Description
1	Fill System Pipe
2	Outlet Bottom
3	Outlet Top
4	Outlet Top Track

Figure 17. Assembling the Outlet Bottom to the Outlet Top

6. Now add Clamps or Retainers (as ordered) to the Outlet Assembly to prevent it from sliding and/or rotating on the pipe. Clamps will prevent the Outlet Assembly from sliding or rotating on the pipe. Retainers can be used in two different ways. Retainers may prevent the Outlet Assembly from sliding or rotating on the pipe, or prevent the Outlet Assembly from sliding on the pipe, but allow it to rotate. **Figure 18** shows the three different methods for holding the Outlet Assembly in place.

If Clamps are used, place the Clamps on the Outlet Assembly as shown and tighten.

When using the Retainers, for a completely locked Outlet Assembly, insert the tabs on the Retainers into the notches on the Outlet Top when gluing the Retainers in place with PVC Cement. With a rotating Outlet Assembly, glue the Retainers in place with the tabs pointing away from the Outlet Top.



Item	Description
1	Outlet Assembly using Clamps (non-sliding, non-rotating)
2	Outlet Assembly using Retainers (non-sliding, non-rotating)
3	Outlet Assembly using Retainers (non-sliding, rotating)

Figure 18. Installing the Retainers on the Outlet Assembly

Control Unit & Power Unit Installation

1. Attach the tube anchor to the appropriate end (determine the best side of control unit for switch placement) of the control unit body by inserting the 1/4-20x.75 carriage bolts from the inside of the control unit through the tube anchor and attach 1/4-20 flange hex nut.

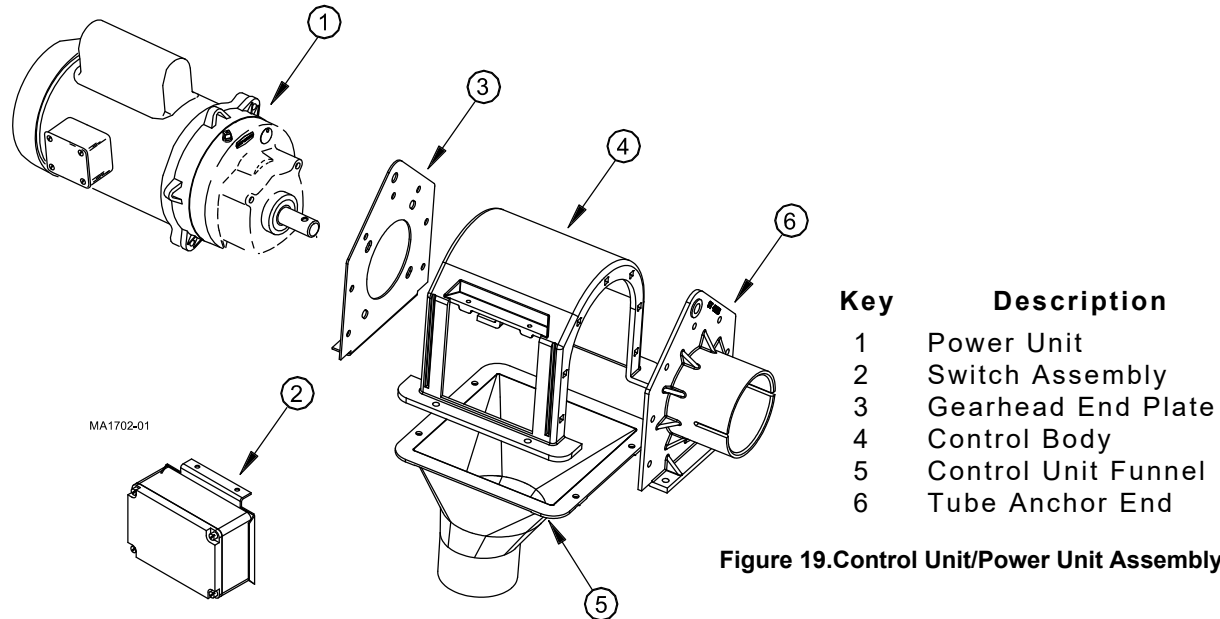


Figure 19. Control Unit/Power Unit Assembly

2. Connect the power unit to the gearhead end plate using the 5/16-18 machine screws and the flat washers packed with the control.
3. Attach the gearhead end plate to the control unit body the same as the tube anchor.
4. Insert the lower section of the switch assembly into the control unit and secure the top with the 2 #10x.5 screws provided.

For Single Phase Direct Drive Control Units

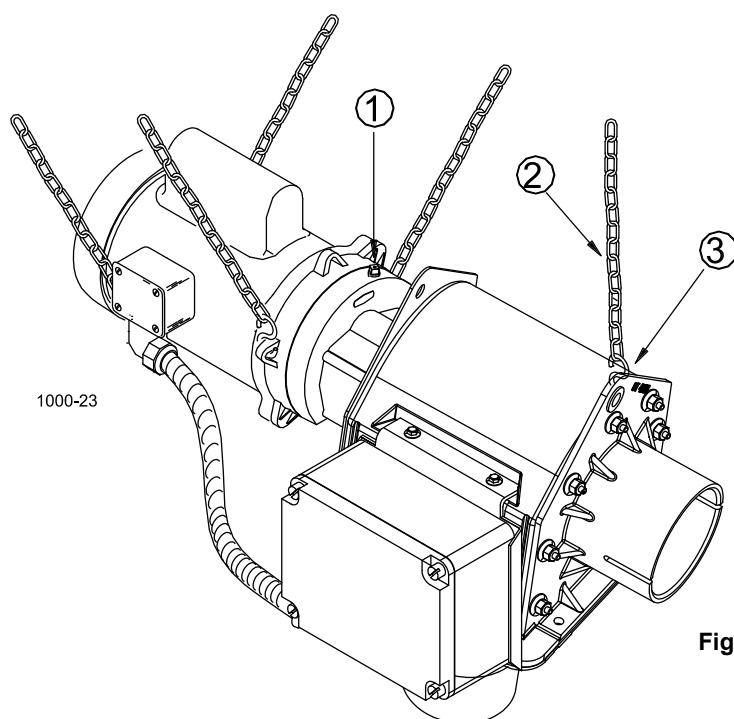
1. Connect the electrical wires on the power unit to the control unit.
2. Drill bottom of control unit switch box with 7/8" (22.2mm) hole to receive the 90o connector and motor wire. Use caution not to disturb any wires or components of the switch box ass'y when drilling holes.
3. Attach the 90 degree connector & conduit to the control unit housing.
4. Attach the insulated motor wires to the terminal block in the control housing: one wire to terminal "3" and one wire to terminal "4". Attach the bare grounding wire to one of the green colored screws provided for attaching the grounding wires.
5. Place the adjustable tube clamp on the tube anchor and connect the control unit/power unit assembly to the end of the FLEX-AUGER tube.

Note: The switch in the control unit is a safety backup switch in case the hopper level switch or drop tube switch fails to shut off the system. **DO NOT** use the safety switch to control the FLEX-AUGER System. This will cause feed to bridge in the control.

6. Support the Power Unit and Control Unit securely. Points are provided at the gear head and the tube anchor for suspending the equipment with chain and "S" hooks supplied with the delivery system (See Figure 20).
 NOTE: Other ways of supporting the delivery system can be used where it is practical, as long as the supports do not let the equipment sag or do not make flat spots in the auger tubes.

Note:The motor should be fastened to keep it from twisting. "S" hooks and chain can be attached to the motor base to prevent the motor from shifting.

7. Install the driver assembly on the power unit shaft. Start the socket head screws but leave the anchor clamp loose enough to slip in the auger.
 8. Replace the plastic shipping plug in the gear head with the vent plug provided.



Key	Description
1	Replace shipping plug with vent plug provided.
2	Chain
3	"S" Hook

Figure 20. Control Unit/Power Unit Suspension

Belt Drive Control Unit Installation

The Belt Drive Control Unit installation is much the same as the direct drive unit. Mount the Belt Drive Adapter and Motor to the control unit, then proceed with installation to the auger tube as described in this manual.

"Standard Belt Drive Control Unit Part Numbers" on page 39 can be used as an assembly guide for the Belt Drive Control Unit. **Figure 21** shows a Belt Drive Control Unit suspended.

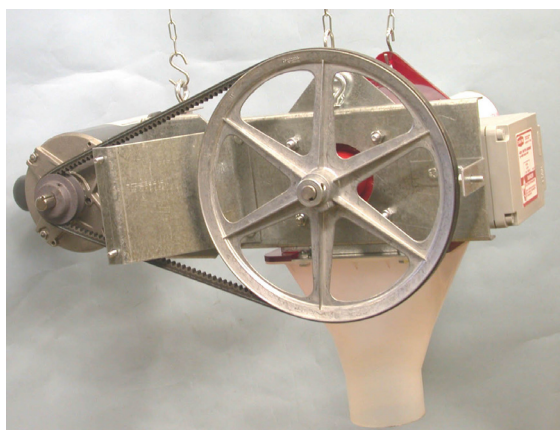


Figure 21. Belt Drive Control Unit

Auger Installation

Use extreme caution when working with the auger. The auger is under tension and may spring causing injury. Always wear protective clothing and protective glasses when working with the auger.

Use extreme caution when pushing the auger into the auger tubes. Keep your hands away from the end of the auger tube to avoid injury.

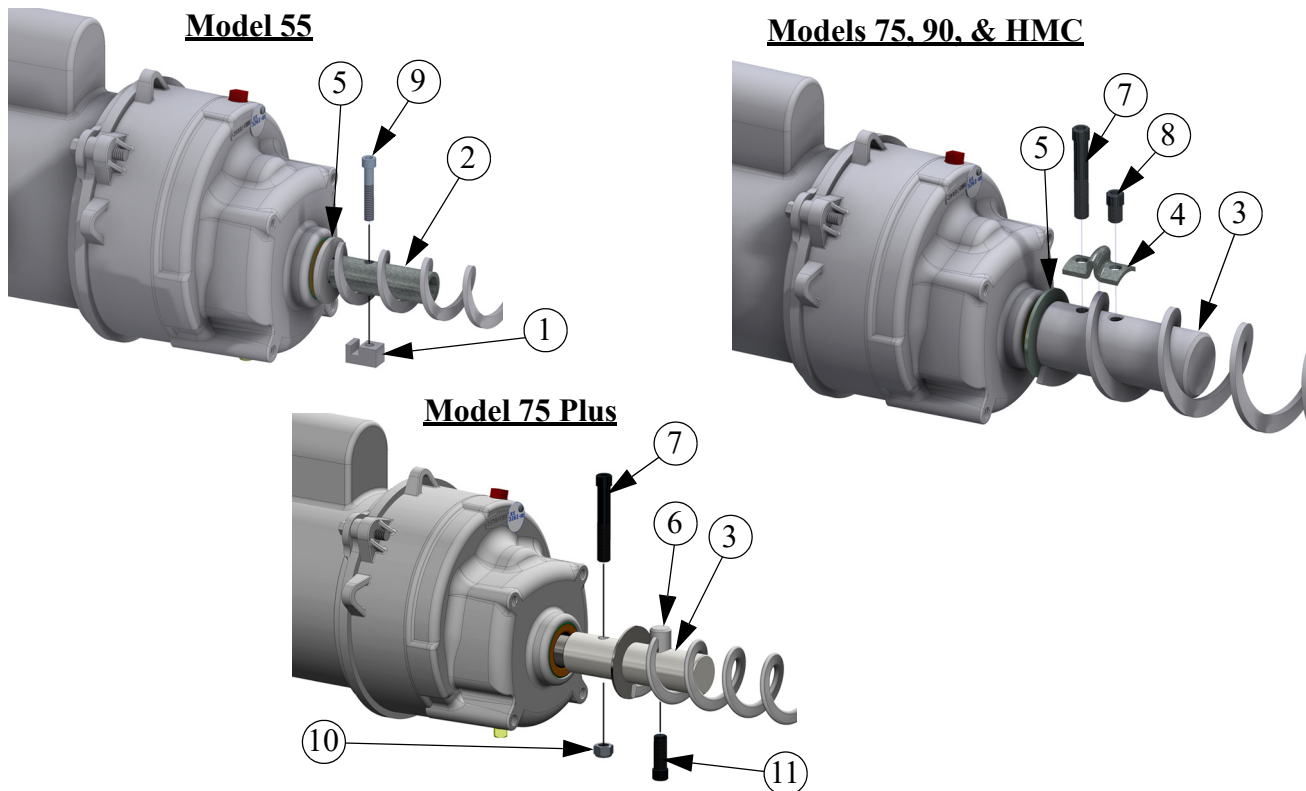
Handle the FLEX-AUGER carefully. Dropping the rolls of auger may cause the auger to kink. Do not install an auger that has a sharp kink in it. The kink will cause the auger to wear a hole in the tube at that spot. If the kink cannot be straightened with pliers, the kink must be cut out and the auger brazed back together. Refer to the "Auger Brazing" section in this manual for the correct brazing procedure.



1. Beginning at the boot, push the auger into the auger tube through the rear of the boot until the auger reaches the control unit end of the line.

Use extreme caution when pushing the auger into the auger tubes. Keep your hands away from the end of the auger tube to avoid injury.

2. Attach the auger to the drivers **as shown below**. Control Units not shown for Clarity.
3. Rotate the auger so that it is fully engaged on the Driver. Tighten the screws securely to clamp the auger to the control unit.



		Model 55	Model 75	Model 75 Plus	Model 90	Model HMC
Item	Description	Part No				
1	Driver Block	4642	--	--	--	--
2	Driver Tube	2920	--	--	--	--
3	Driver Weldment	--	7704	56390	7706	7704
4	Anchor Clamp	--	7703	--	7703	7703
5	Washer	1484	--	--	--	--
6	Auger Clamp	--	--	56405	--	--
7	5/16-18 x 2.25" S. Hd Cap Screw	--	6850-4	6850-4	6850-4	6850-4
8	5-16-18 x .50 SKTH Cap Screw	--	6850-3	6850-3	6850-3	6850-3
9	1/4-20 Socket Head Cap Screw	5083-8	--	--	--	--
10	5/16-18 Lock Nut	--	--	2148	--	--
11	5/16-18 x 1 SKTH Cap Screw	--	--	6850-5	--	--

Figure 22.Auger Installation

4. Assemble the control unit funnel to the tube anchor and the gearhead end plate with 4 1/4-20x.63 hex head bolts and 1/4-20 hex flange nuts. The straight side of the funnel should be position on the power unit side of the control.
5. Pull on the loose end of the auger at the boot once or twice until it begins to stretch, then release it slowly. This will bring the auger to its natural length.

Auger Stretch

On Model 55, 75, 90, & HMC Single Boot Systems: Stretch the auger 2 inches (50 mm) for every 50 feet (15.2 m) of length. Example: For a 150 ft. (45 m) system the auger should be cut 6 inches (150 mm) shorter than its natural length. Measure the amount of stretch from the rear edge of the boot and cut the auger at that point.

On Model 75 Plus single Boot System, stretch the Auger 5" (127mm) for every 50 ft. (15.2m) of length.

On Model 75, 90, & HMC Two Boot Tandem Systems, the Auger stretch must be doubled to 4" (100mm) for every 50 ft. (15.2 m) of length.

On Model 75 Plus Two Boot Tandem Systems, stretch the Auger 10" (254 mm) per 50 ft. (15.2 m).

On Model 90 Twin 3 Bin Systems, 6" (150 mm) for every 50' (15.2 m) of stretch.

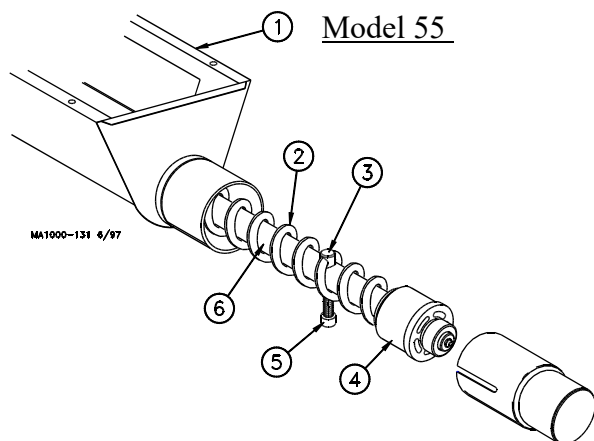
Note: For ease of cutting, measure and mark the auger at the point where it is to be cut. Then, pull the auger an additional 6-8" (150-200 mm) and use locking pliers to clamp the auger while you cut it.

6. **Figure 23** shows the proper assembly of the Model 55 boot components. Insert the Auger over the Anchor and through the Auger Clamp until Auger touches washer. Torque Set Screw into Auger Clamp 10-12 ft.-lbs. Over tightening the Set Screw may cause damage to the Auger Clamp.

Figure 23 shows the proper assembly of the Model 75, 75 Plus, 90, & HMC anchor components. Insert the anchor into the auger until the auger touches the anchor flange. The auger must be threaded onto the Boot Anchor Assembly, through the clamp pin. Use a 5/16" open-end wrench to tighten the clamp pin setscrew on the auger.

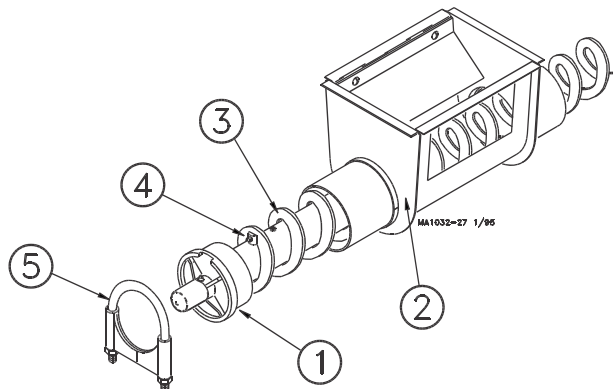
Some of the Boot Models have Anchor and Bearing Assemblies with Restrictors that may be shortened, if necessary, to increase capacity.

7. Attach the anchor assembly to the boot.
8. Place the cannonball in the boot.



Item	Description
1	Model 55 Lower Boot
2	Model 55 Auger
3	Auger Clamp
4	Anchor Bearing
5	Tighten Socket Screw to Secure to the Anchor

Model 75, 75 Plus, 90 & HMC



Item	Description
1	Anchor and Bearing Assembly
2	Lower Boot
3	Auger
4	Tighten Set Screw to Secure Auger in Clamp Pin
5	Tube Clamp

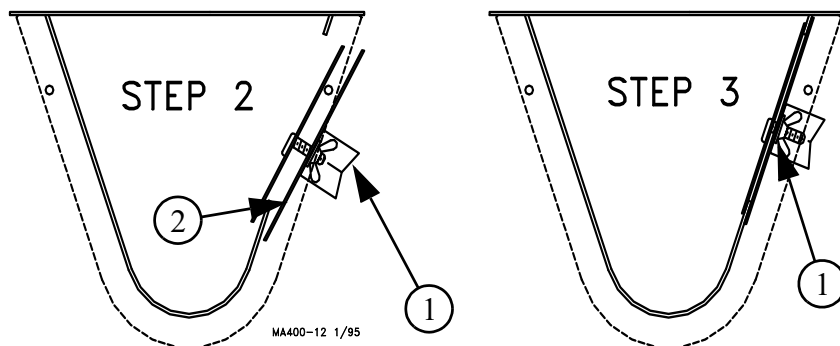
Figure 23. Anchor and Bearing Installation

Cover Plate Installation

The cover plate is installed after installation of the auger in the tube (See Figure 24).

To install the cover plate:

1. Loosen wing nuts to end of studs
2. Start lower side of cover plate in boot opening.
3. Slide the cover plate up as far as possible so that plate catches top of boot opening.
4. Hold the cover securely while tightening the wing nuts.



Item	Description
1	Lock Nut
2	Cover Plate

Figure 24. Cover Plate Installation

Auger Brazing/Filing

If the auger needs to be spliced or lengthened, locate the brazed joint closer to the power unit to minimize feed flow restriction in the line.

To align the auger for brazing, lay it in angle iron and clamp securely.

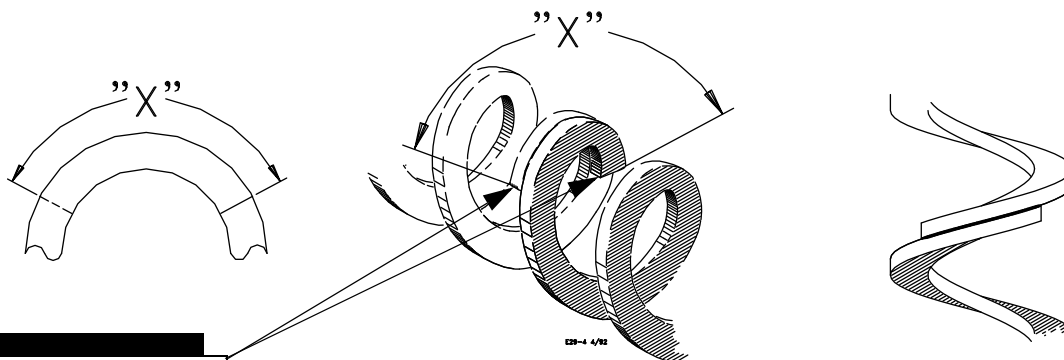
Rotate the auger to allow both the inside and outside edges of the augers to be brazed.

Butt the ends of the auger against each other. **DO NOT SCREW ONE AUGER INSIDE THE OTHER**--This restricts the feed flow.

Figure 25 and the associated chart specify how far to lap the augers.

A bronze, flux-coated rod is recommended. The joint should be well filled and smooth so that it does not wear against the tube. Allow the joint to air cool.

File the auger edges, as shown in Figure 25, to avoid damage to the auger tubes. Also, file off any brazing that extended beyond the outside radius of the auger flightings.



Note: Sharp Auger Ends at the braze(s) must be filed or ground to avoid damage to Auger Tube(s).

Figure 25. Auger Brazing/Filing

	Model 55 Auger	Model 75, & HMC Auger	Model 90 Auger	Model 75 Plus Auger
X=	1.0 to 1.13" (25 to 29 mm)	1.5 to 1.75" (38 to 45 mm)	1.5 to 1.75" (38 to 45 mm)	1.25 to 1.50" (32 to 38 mm)

Restrictor Adjustment

Some Boots have Restrictors that may be adjusted for increased delivery capacities.

DO NOT ADJUST THE RESTRICTOR UNTIL THE SYSTEM HAS BEEN IN OPERATION AND THE SYSTEM IS BROKEN IN.

THE MODEL 55 RESTRICTOR IS NOT ADJUSTABLE.

Note:Feed delivery capacities are based on 40 lbs/ ft.3 (640 kg/m3) feed density. Systems using lighter weight feeds may not be able to achieve the maximum capacities listed.

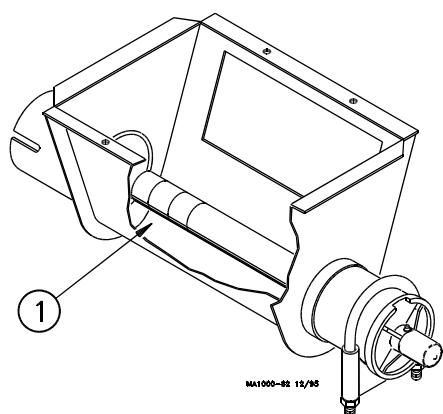
Note:Always refer to the motor amperage nameplate when increasing the feed flow capacity. Exceeding the nameplate amperage may result in nuisance motor overload tripping and/or damage to the system.

1. Loosen the tube clamp on the back of the Lower Boot to remove the Anchor and Bearing Assembly from the boot.
2. Use extreme caution when working with the auger under tension. Springing auger can cause personal injury.

Pull enough of the auger out of the auger tube to allow the Restrictor Tube to be cut.

Use locking pliers to hold the auger outside the boot.

3. Use a hacksaw to cut 1" (25 mm) at a time off the end of the Restrictor Tube to increase feed flow (See **Figure 26**).
4. CAREFULLY remove the locking pliers while holding on to the Anchor and Bearing Assembly and auger securely.
5. CAREFULLY allow auger to draw the Anchor and Bearing Assembly back into the Lower Boot. DO NOT ALLOW THE BEARING TO BE SLAMMED BACK INTO THE BOOT.



Key

1

Description

Cut off approximately 1" (25 mm) of the Restrictor Tube to increase feed flow. Repeat as required.

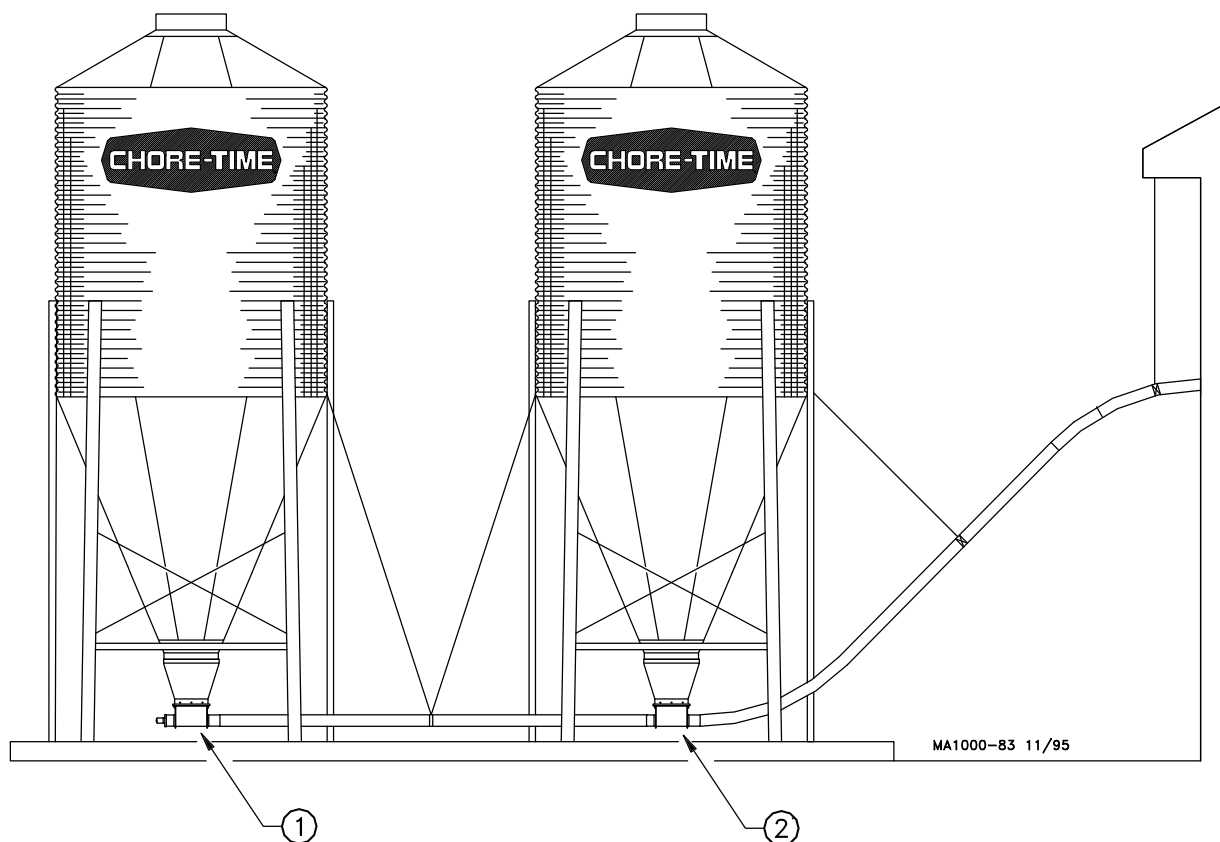
Figure 26.Restrictor Adjustment Model 90 & HMC Only

Straight-Through Tandem Boot

The Straight-Through Tandem Boots allow one or two augers to remove feed from two separate feed bins. Feed should only be drawn from one bin at a time.

Solid Cannonballs are used in conjunction with the Boot Baffles.

1. Install boots on both feed bins. Be sure the outlets and inlets on the boots are in line and arrow tape is pointed in direction of feed flow. **Figure 27** shows a typical Straight-Through Tandem System.



Key	Description
1	Straight-Out Boot on Terminal Bin (with Baffles)
2	Straight-Thru Boot on Intermediate Bin (w/Baffles)

Figure 27. Straight-Through Tandem

2. Measure and cut an auger tube(s) to connect the two boots (See **Figure 29**).

For Model 90 & HMC FLEX-AUGER systems, the belled end of the auger tube fits directly over the outlet end the Straight-Out Boot. The straight end of the Auger Tube connects to the incoming end of the Straight-Thru Boot, using a Tube Connector. (See **Figure 29**)

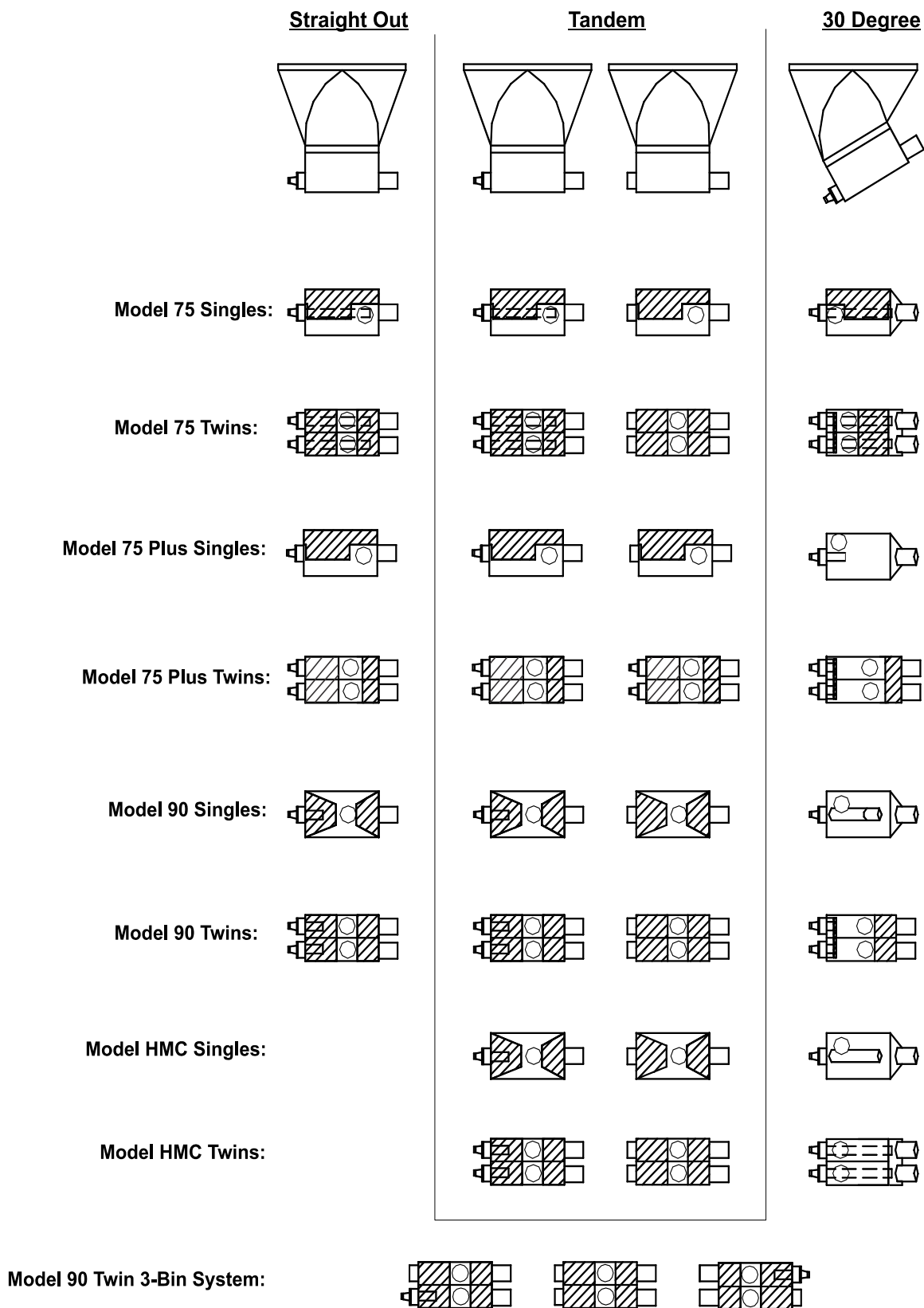
For Model 75 FLEX-AUGER (PVC) systems, slide the belled end of the Model 75 Auger Tube over the outlet of the Straight-Out Boot. The straight end of the Auger Tube connects to the incoming end of the Straight-Thru Boot, using a Tube Insert and Tube Connector.

For Model 75 FLEX-AUGER (Steel) systems, slide the straight end of the Model 75 Auger Tube into the outlet end of the Straight-Out Boot. The belled end of the Auger Tube should be slid over the inlet end of the Straight-Thru Boot. (See **Figure 29**).

Remember to caulk all tube joints exposed to weather or moisture.

Standard FLEX-AUGER Boots and Baffle Locations

(As Shipped from Factory)



1000-138 2/04

Figure 28. Standard FLEX-AUGER Boots and Baffle Locations

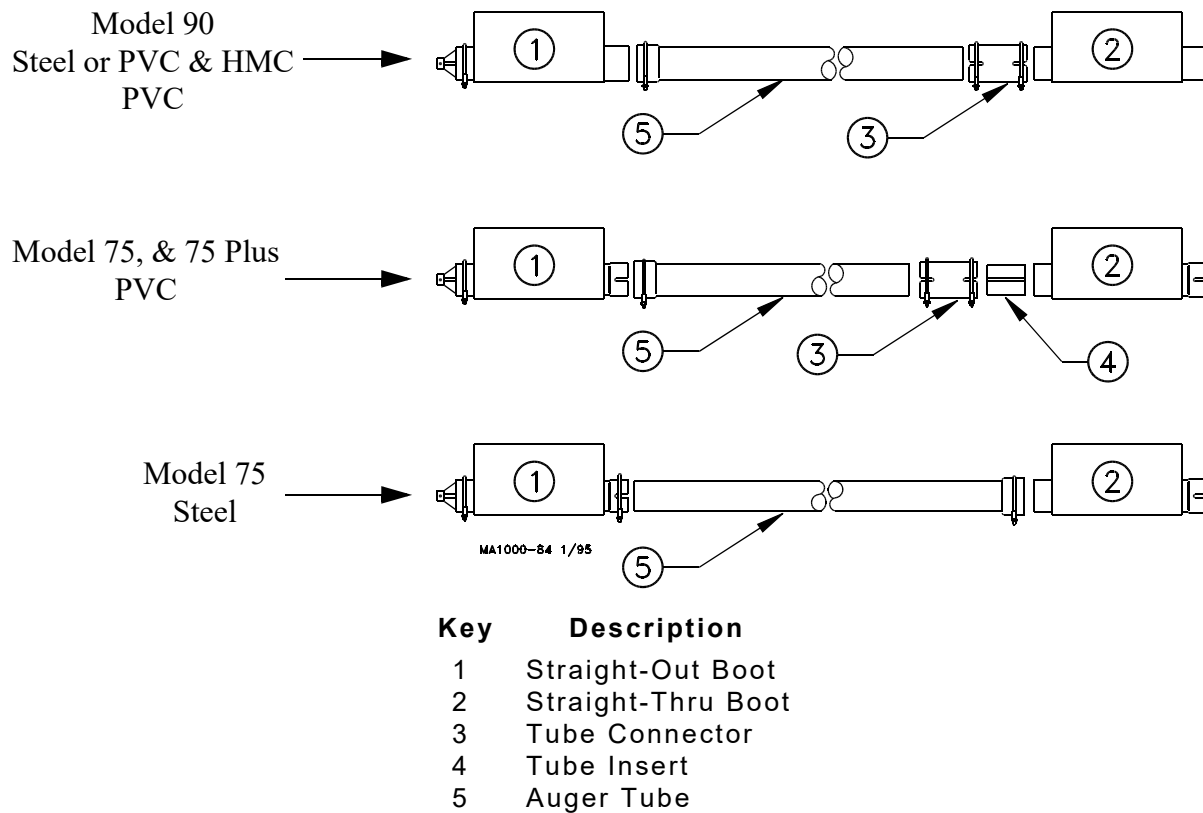


Figure 29. Model 75, 75 Plus, 90, & HMC Straight-Through Tandem Boot connections.

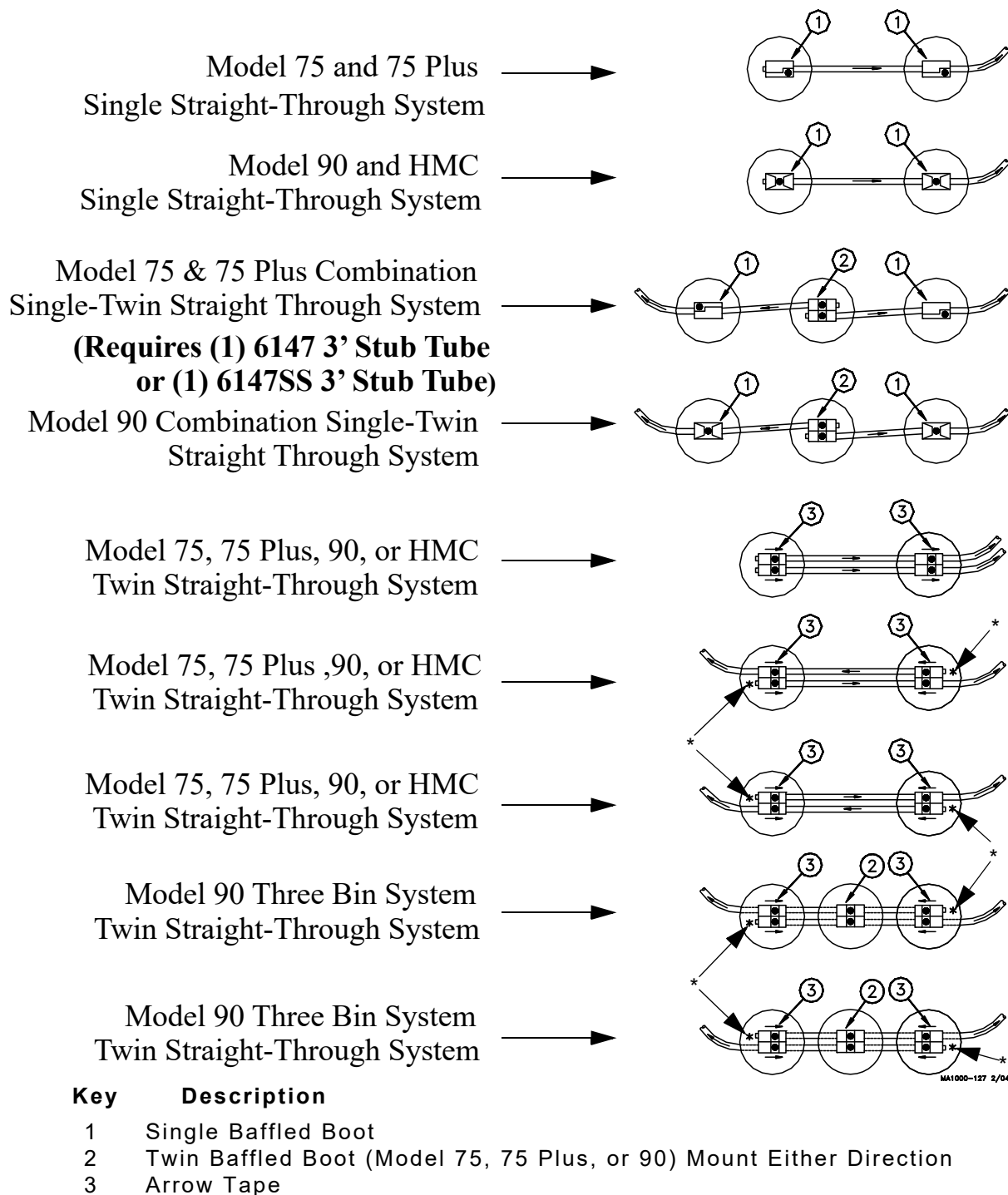
3. Push the auger into the line of tubes and anchor it at the power unit end. Stretch the auger 4 inches per 50 feet (100 mm per 15 m) and cut it even with the rear of the straight-out boot. **Notice the auger stretch is not the same as for Single Boot FLEX-AUGER Systems. Note: For Model 90 3-Bin Systems, stretch auger 6 inches per 50 feet.**
4. Use a tube clamp to secure the bearing cap to the boot.

Boot Baffles for Straight-Through Boot Systems

The Chore-Time Boot Baffles are for use with dry, coarse, mash, crumbles, or pelleted feeds to prevent boots from overcharging the system.

The Boot Baffles are intended for use in both “straight-out” & “straight-through” boots. Boot Baffles are factory installed on Straight-Through Boot Systems.

See **Figure 30** for applications and auger direction.



***Note:** On twin systems running in opposite directions, follow the tape on the bearing end of the system.

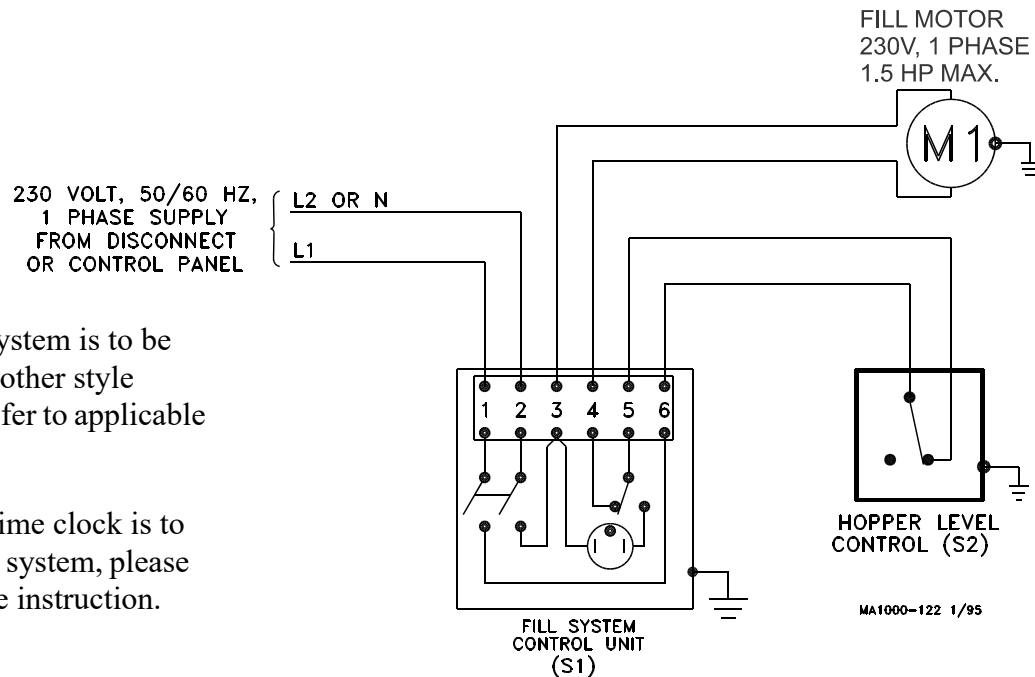
Figure 30. Optional Baffle Configurations

Feed Level Control Installation

The Hopper Level Control (or Drop Tube Switch) is installed in the feed hopper (or in the drop tube over the feeder) at the power unit end of the line. This feed flow control switch stops the FLEX-AUGER System when the last feeder is full. Install the hopper level control or drop tube switch according to instructions shipped with the unit.

The wiring diagram for each type of delivery system shows how the hopper level control (drop tube switch is the same) must be wired into the control unit.

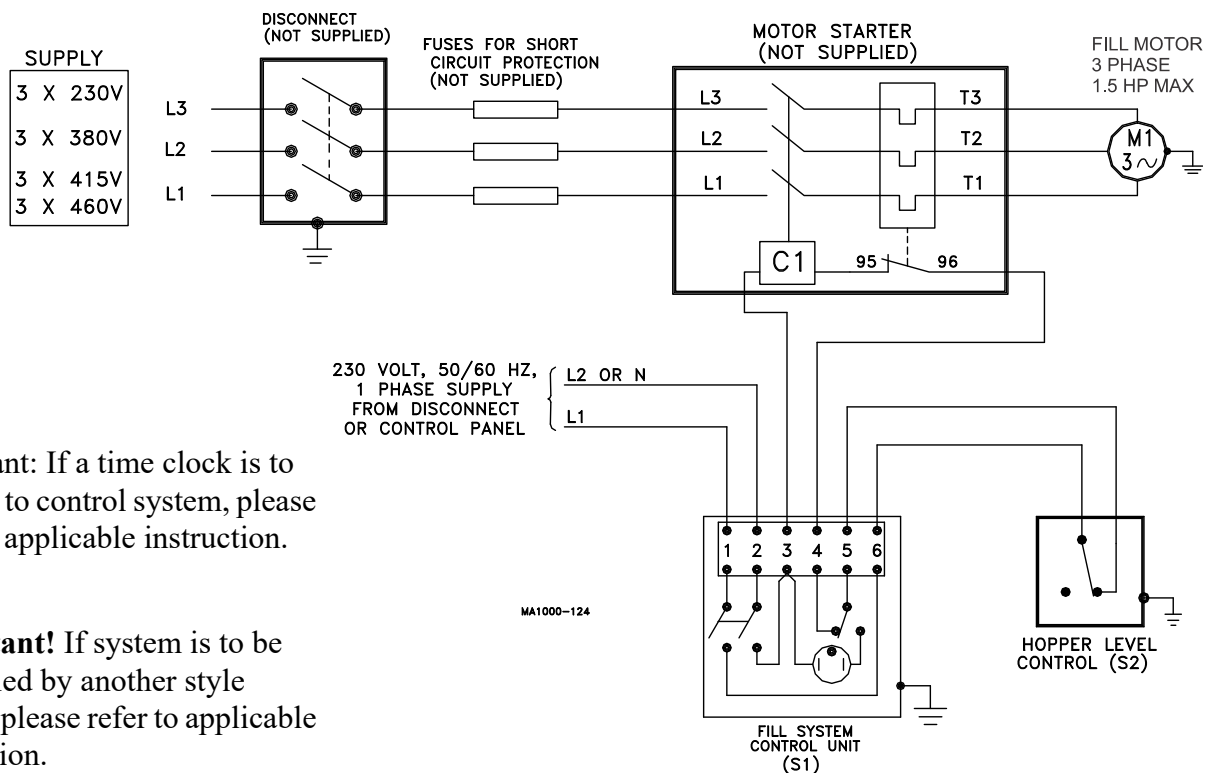
Hopper Level Control Switch (Single Phase) Wiring



Important! If system is to be controlled by another style switch, please refer to applicable instruction.

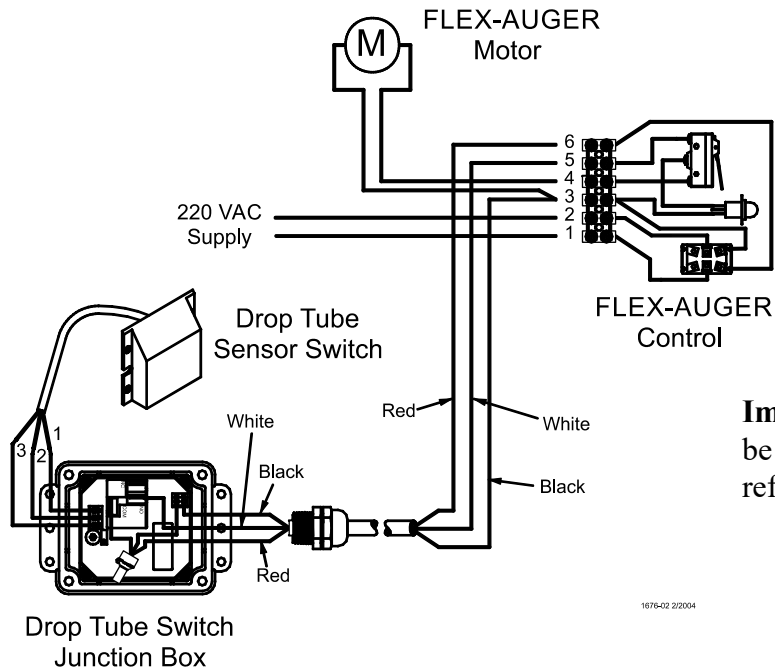
Important! If a time clock is to be used to control system, please refer to applicable instruction.

Hopper Level Control Switch (Three Phase) Wiring



Important: If a time clock is to be used to control system, please refer to applicable instruction.

Important! If system is to be controlled by another style switch, please refer to applicable instruction.

SENSOR PLUS™ Electronic Switch (Single Phase) Wiring

Operation

1. During initial start-up, the boot slide should be only partially open to prevent the auger from being fully charged. Maintain partially open Slide until feed reaches the far end Control Unit. After that, the boot slide must be fully open for proper delivery system operation.
2. Do not permit the FLEX-AUGER system to operate empty. Use a time clock or Auger Timer with the system whenever possible. This reduces short cycling by operating on a preset schedule instead of on demand. It also prevents excessive running of the system if the bin becomes empty. If the optional boot switch is used, the fill system will shut down when the bin becomes empty.
3. Program the time clock to fill feeders often so the FLEX-AUGER System does not have to run a long period of time to get feeders filled. Poultry feeders supplied by the FLEX-AUGER System should be operated by a time clock so feeders start at the same time. This gives the FLEX-AUGER System a better chance to keep up with them. Note: The hopper level control must be positioned low in the last feeder hopper.
4. The red light on the control unit will light if feed has packed inside. If this happens, remove feed from the drop tube and tap the side of the power unit to clear the safety switch. Keep the hopper level control in adjustment and positioned straight up and down so the paddle swings freely. The safety switch does not take the place of the hopper level control.
5. If the FLEX-AUGER System must be used to convey high-moisture feed, empty the auger line completely after each running to prevent the feed from setting up in the tubes.
6. On Baffled Boots, the flow rates are predetermined with factory installed Baffles. The Baffles are non-adjustable.

On Non-Baffled Boots, the restrictor on the boot anchor regulates the amount of feed flowing into the auger. Start a new system with the restrictor installed as shipped

Allow the system to polish out before adjusting the feed flow. If more feed flow is desirable, the restrictor may be shortened. Refer to "Restrictor Adjustment" on page 25.

7. When feeding with the Straight-Through Tandem System, open the slide on only one bin at a time!

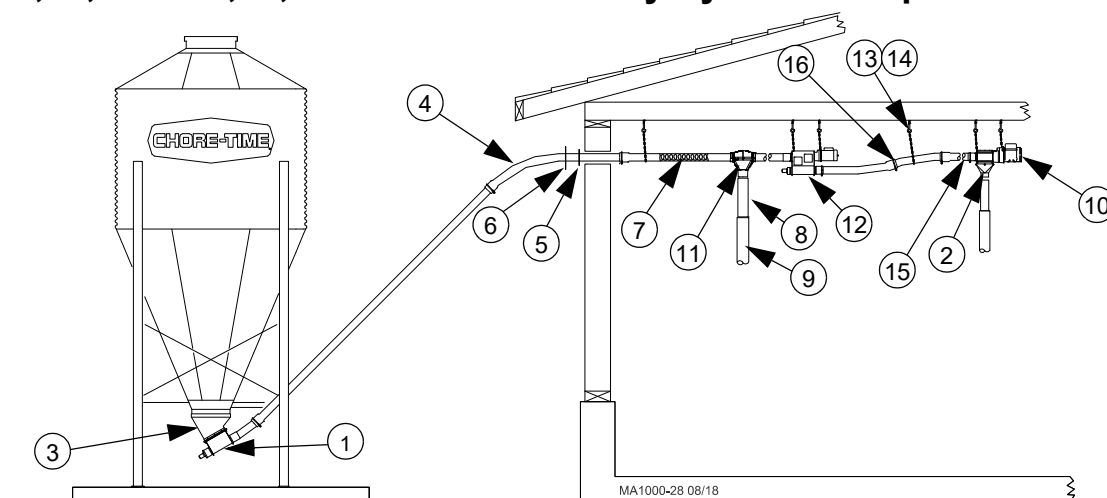
Start-Up Procedure for New Systems

Important! DO NOT RUN FEED THROUGH A NEW SYSTEM UNTIL AFTER THIS PROCEDURE HAS BEEN FOLLOWED OR THE AUGER WILL PLUG AND BIND.

1. Close the Slide on the FLEX-AUGER® Boot.
2. Operate the system empty for one minute.
3. Open the slide on the FLEX-AUGER® boot no more than 1 inch (25 mm) to allow some feed into the boot.
4. Operate the system with the slide in this position until feed has reached the Control Unit. This removes the manufacturing grease and oil from the auger and tubes. If this grease and oil is not removed, the feed may bunch up causing the auger to plug and bind.
5. Now the slide can be fully opened and the system operated normally.

Parts Listing

Model 55,75,75 Plus,90,& HMC Feed Delivery System Components



		Model 55	Model 75	Model 75 Plus	Model 90	Model HMC
Item	Description	Part No				
1	Boot Assembly	See Parts List				
2	Control Unit	See Parts List				
3	Upper Boot	See Parts List				
4	45 Degree PVC Elbow	34855	7285	7285	7357	7357
5	Neoprene Seal	6394	2613	2613	5035	5035
6	Seal Ring	2612	2612	2612	2612	2612
7**	Auger	7961-0	4744-0	56383-0	3942-0	4744-0
8	Plastic Drop Tube	1932	1932	1932	6381	6381
9	Telescoping Drop Tube	14366-1932	14366-1932	14366-1932	14366-6381	14366-6381
10	Power Unit	See Parts List				
11	Outlet Drop Kit w/Clamps	43455C	43475C	43475C	43490C	43490C
	Outlet Drop Kit w/Retainers	43455R	43475R	43475R	43490R	43490R
12	Extension Hopper	40170	7944	7944	7869	7849
13	Suspension Kit	5043	5043	5043	5043	5043
	S Hooks (Qty 25)	2805	2805	2805	2805	2805
	Screw Hooks (Qty 12)	1214	1214	1214	1214	1214
	***Chain (25') [7.62 m]	2128	2128	2128	2128	2128
14	Suspension Kit (Stainless Steel)	5043SS*	5043SS*	5043SS*	5043SS*	5043SS*
	Stainless S Hooks (Qty 25)	2805SS*	2805SS*	2805SS*	2805SS*	2805SS*
	Stainless Screw Hooks (Qty 12)	1214SS*	1214SS*	1214SS*	1214SS*	1214SS*
	***Stainless Chain (25') [7.62 m]	2128-25SS*	2128-25SS*	2128-25SS*	2128-25SS*	2128-25SS*
15	PVC Auger Tube	7955	6516	6516	6293	6293
16****	Tube Clamp Kit	29515	6515	6515	6721	6721

* SS = Stainless Steel.

**Model 55 Auger (Part No. 7961-0) may be ordered in lengths from 20 ft. to 400 ft. maximum. Example: 7961-155 would be 155' of auger.
 Model 75 Auger (Part No. 4744-0) may be ordered in lengths from 20 ft. to 300 ft. maximum. Example: 4744-155 would be 155' of auger.
 Model 75 Plus Auger (Part No. 56383-0) may be ordered in lengths from 20 ft. to 335 ft. max. Example 56383-155 would be 155' of auger.
 Model 90 Auger (Part No. 6942-0) may be ordered in lengths from 20 ft. to 250 ft. maximum. Example: 6942-155 would be 155' of auger.

***Chain can be purchased in a 25' [7.62 m] bag (2128-25 or 2128-25SS*), a box of 100' [30.48 m] (2128-100 or 2128-100SS*) or a 250' [76.2 m] reel (2128-250 or 2128-250SS*).

****These Tube Clamp Assemblies are in quantities of 10.

Steel Components

		Model 55	Model 75	Model 90	Model HMC
Item	Description	Part No			
1	10' [3 m] Steel Tube	----	2088	5091	----
2	45 Degree Hardened Steel Elbow	----	14324	6472	----
3	Tube Connector Kit	----	2103	6595	----

Power Unit Assembly Part Numbers

<u>Part Number</u>	<u>HP</u>	<u>RPM</u>	<u>Phase</u>	<u>Hz</u>	<u>Voltage</u>	<u>Usages</u>
3259-49	1.0 HP	348 RPM	Single	60 Hz	230	Model 75, 90, & HMC
3259-50	1/2 HP	216 RPM	Single	60 Hz	230	Model 75/90 Two Motor Tandem
3259-51	1/2 HP	348 RPM	Single	60 Hz	230	Model 75, 90, & HMC
3259-52	3/4 HP	348 RPM	Single	60 Hz	230	Model 75, 90, & HMC
3259-67	1/2 HP	129 RPM	Single	60 Hz	230	Model 75, & HMC
3259-77	1/2 HP	425 RPM	Single	60 Hz	230	Model 90
3259-78	3/4 HP	425 RPM	Single	60 Hz	230	Model 75, 75 Plus, 90
3259-79	1.0 HP	425 RPM	Single	60 Hz	230	Model 75, 75 Plus, 90
3259-80	1.5 HP	425 RPM	Single	60 Hz	230	Model 75, 75 Plus, 90
3259-89	1.0 HP	348 RPM	Single	50 Hz	220	Model 75, 90, & HMC
3259-34	1/3 HP	348 RPM	Single	60 Hz	230	Model 55 only
3259-39	1/2 HP	348 RPM	Single	60 Hz	230	Model 55 only
3259-98	1/2 HP	348 RPM	Single	50 Hz	220	Model 55 only
3259-88	3/4 HP	348 RPM	Single	50 Hz	220	Model 75 & 90
3259-108	1.0 HP	474 RPM	Single	50 Hz	220	Model 90
3259-109	1/2 HP	180 RPM	Single	50 Hz	220	Model 75, & HMC
3259-148	1.0 HP	580 RPM	Single	50 Hz	220	Model 90
3259-136	3/4 HP	216 RPM	Single	60 Hz	230	Model 75, & HMC
3259-122	3/4 HP	584 RPM	Single	60 Hz	230	Model 90
3259-123	1.0 HP	584 RPM	Single	60 Hz	230	Model 90
3259-124	1.5 HP	584 RPM	Single	60 Hz	230	Model 90
3259-137	1.0 HP	584 RPM	Three	60 Hz	200	Model 90
3259-102	1/2 HP	180 RPM	Three	50 Hz	220/380-415	Model 75 & HMC
3259-105	1.0 HP	348 RPM	Three	50 Hz	220/380-415	Model 75 & 90
3259-117	1.0 HP	348 RPM	Three	60 Hz	208-230/460	Model 75, 90, & HMC
3259-118	1.0 HP	425 RPM	Three	60 Hz	208-230-460	Model 75,75 Plus, & 90
3259-120	3/4 HP	425 RPM	Three	60 Hz	208-230-460	Model 75, 75 Plus, & 90
3259-140	1.5 HP	425 RPM	Three	60 Hz	208-230-460	Model 75, 75 Plus, & 90
3259-119	3/4 HP	348 RPM	Three	60 Hz	208-230/460	Model 75, 90, & HMC
3259-134	1/2 HP	348 RPM	Three	60 Hz	220-240/380-400	Model 55
3259-137	1.5 HP	584 RPM	Three	60 Hz	200/380	Model 90
3259-150	1.0 HP	580 RPM	Three	50 Hz	220/380	Model 90
3259-151	1.5 HP	580 RPM	Three	50 Hz	220/380	Model 90
3259-152	1.0 HP	584 RPM	Three	60 Hz	220/380	Model 90

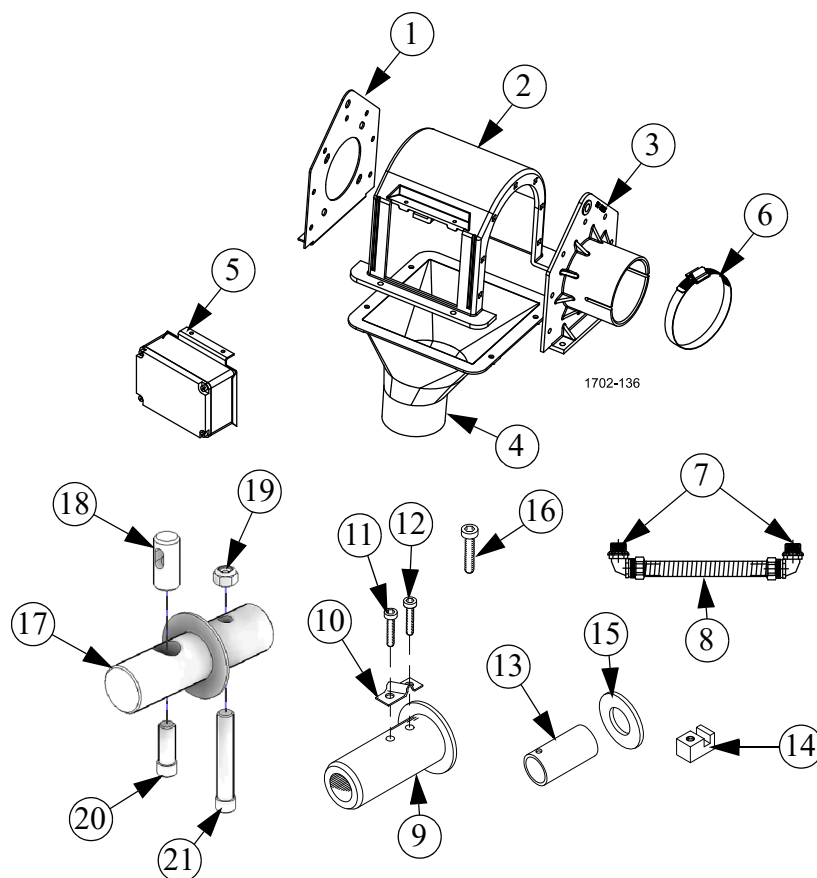
An exploded view diagram of a motor assembly. The main components are labeled with circled numbers and arrows pointing to them: 1. Motor housing, 2. Motor mounting bracket, 3. Motor mounting pin, 4. Motor mounting nut, 5. Motor mounting plate, 6. Motor mounting screw, 7. Motor mounting pin, 8. Motor mounting nut, 9. Motor mounting pin. The motor housing has a label 'MA1000-48' on its side.

[illegible]

		3259-122	3259-123	3259-124	3259-137	3259-118	3259-120
Item	Description	Part Number					
1	Motor	5051	6857	8782	28036EUR	34101	34102
4	Pipe Plug	2755	2755	2755	2755	2755	2755
5	Gearhead	3261-13	3261-13	3261-13	3261-13	3261-10	3261-10
6	Vent Plug	3523	3523	3523	3523	3523	3523
7	S Hook	2805	2805	2805	2805	2805	2805
8	Pinion Assembly	5046	6104	6104	6104	6104	5046
9	Magnetic Pipe Plug	30160	30160	30160	30160	30160	30160

MA1702G

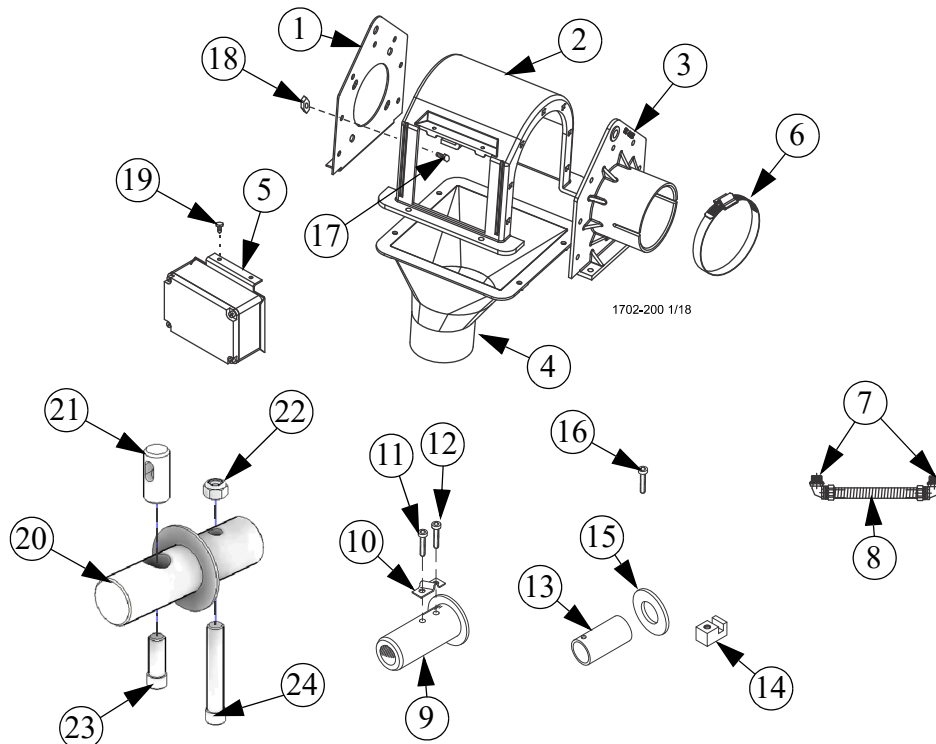
Direct Drive Control Unit (Single Phase)



KEY	DESCRIPTION	Model 55	Model 75	Model 75 Plus	Model 90	Model HMC
		46800-1 PART NO.	46800-2 PART NO.	46800-37 PART NO.	46800-4 PART NO.	46800-3 PART NO.
1	Gearhead End Plate	43596	43596	43596	43596	43596
2	Control Unit Body	43601	43601	43601	43601	43601
3	Tube Anchor Plate Weldment	45924	45925	45925	45926	45926
4	Control Unit Funnel	45943-1	45943-1	45943-1	45943-2	45943-2
5	Switch & Plate Assembly	46051	46051	46051	46051	46051
6	H.D. Adjustable Clamp	47652-1	47652-1	47652-1	47652-1	47652-1
7	Water Tight Connector	23810	23810	23810	23810	23810
8	Non-Metal Flex Conduit	26982-10	26982-10	26982-10	26982-10	26982-10
9*	Driver Weldment		7704	--	7706	7704
10*	Anchor Clamp		7703	7703	7703	7703
11*	5/16-18x1/2" Socket Hd Cap Screw		6850-3	3850-3	6850-3	6850-3
12*	5/16-18x2-1/2" Socket Hd Cap Screw		6850-4	6850-4	6850-4	6850-4
13*	Drive Tube	2920				
14*	Drive Block	4642				
15*	Flat Washer	1484				
16*	1/4-20x1-1/2" Screw	5083-8				
17	Model 75 Plus Driver Weldment	--	--	56390	--	--
18	Auger Clamp	--	--	56405	--	--
19	5/16-18 Hex Lock Nut	--	--	2148	--	--
20	5/16-18 x 1" Socket Hd Cap Screw	--	--	6850-5	--	--
21	5/16-18 x 2.25" Socket Hd Cap Screw	--	--	6850-4	--	--
--	Driver Assembly	46458	6862	56416	6861	6862

*Parts included in Driver Assembly (Part No's 46458, 6862, 5861, or 56416 respectively).

Stainless Steel Direct Drive Control Unit (Single Phase)



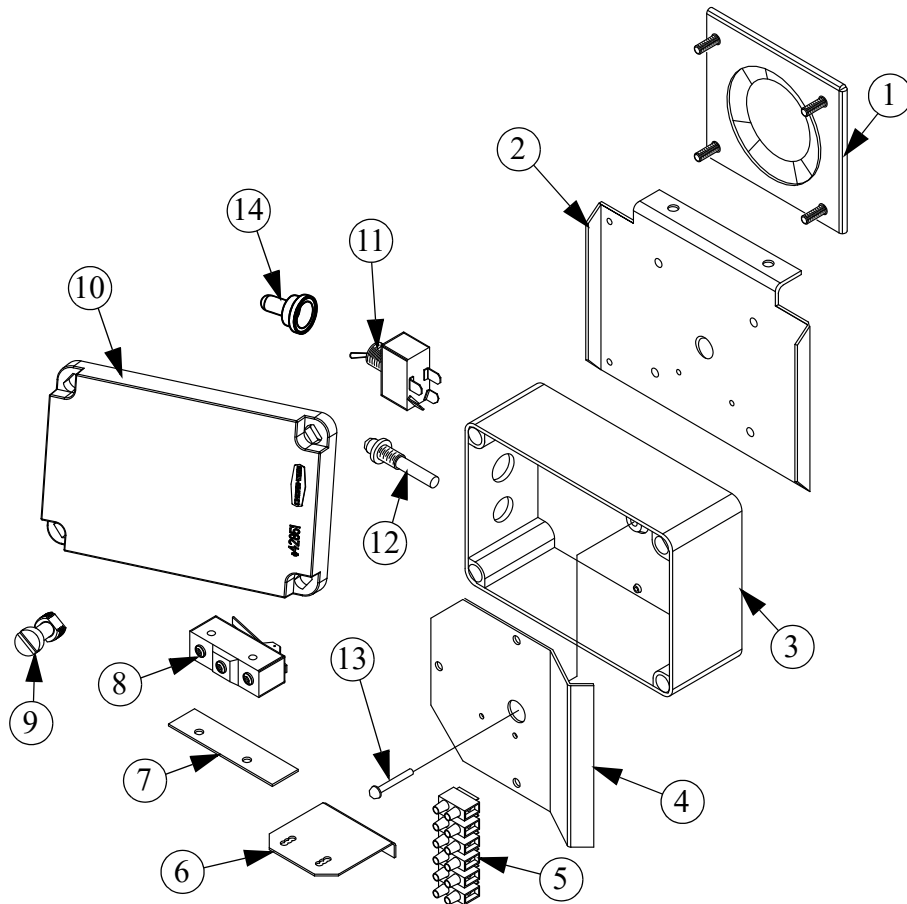
KEY	DESCRIPTION	Model 55 46800-27 PART NO.	Model 75 46800-28 PART NO.	Model 75 Plus 46800-35 PART NO.	Model 90 46800-30 PART NO.	Model HMC 46800-29 PART NO.
1	Gearhead End Plate	43596SS	43596SS	43596SS	43596SS	43596SS
2	Control Unit Body	43601	43601	43601	43601	43601
3	Tube Anchor End	45924	45925	45925	45926	45926
4	Control Unit Funnel	45943-1	45943-1	45943-2	45943-2	45943-2
5	Switch & Plate Assembly	46051SS	46051SS	46051SS	46051SS	46051SS
6	H.D. Adjustable Clamp	47652-1	47652-1	47652-1	47652-1	47652-1
7	Water Tight Connector	23810-2	23810-2	23810-2	23810-2	23810-2
8	Non-Metal Flex Conduit	26982-10	26982-10	26982-10	26982-10	26982-10
9*	Driver Weldment		7704	56390	7706	7704
10*	Anchor Clamp		7703		7703	7703
11*	5/16-18x1/2" Socket Hd Cap Screw		6850-3		6850-3	6850-3
12*	5/16-18x2-1/4" Socket Hd Cap Screw		6850-4	6850-4	6850-4	6850-4
13*	Drive Tube	2920				
14*	Drive Block	4642				
15*	Flat Washer	1484				
16*	1/4-20x1-1/2" Screw	5083-8				
--	Driver Assembly	46458	6862	6862	6861	6862
17	1/4-20 Rd. Hd. Sq Shnk. Bolt (SS)	7550-6	7550-6	7550-6	7550-6	7550-6
18	1/4-20 Hx Flg. Serr. Nut (SS)	46298	46298	46298	46298	46298
19	#10-14 Twin Helix Screw (SS)	28075SS	28075SS	28075SS	28075SS	28075SS
20	Model 75 Plus Driver Weldment	--	--	56390	--	--
21	Auger Clamp	--	--	56405	--	--
22	5/16-18 Hex Lock Nut	--	--	2148	--	--
23	5/16-18 x 1" Socket Hd Cap Screw	--	--	6850-5	--	--
24	5/16-18 x 2.25" Socket Hd Cap Screw	--	--	6850-4	--	--
--	Driver Assembly	46458	6862	56416	6861	6862

International Direct Drive Control Units (3 Phase)

Model 55	Model 75	Model 90	Model HMC
46800-31	46800-32	46800-34	46800-33

Components - Same as Standard Direct Drive Control Units except does not include the 90° connectors and the flex conduit

46051 & 46051SS Switch & Plate Assembly



Item	Description	46051 Switch & Plate Assembly	46051SS Stainless Steel Switch and Plate Assembly
		Part Number	
1	Diaphragm Assembly	46159	46159
2	Switch Cover Plate	46030	46030SS
3	4 x 6 Electrical Box	46070-1	46070-1
4	Mount Panel	46072	46072
5	Terminal Block	34925-6	34925-6
6	Switch Bracket	46093	46093
7	Switch Insulation	1907-5	1907-5
8	Micro Switch	46091	46091
9	Plastic Screw	42849	42849
10	4 x 6 Electric Box Cover	42851	42851
11	Toggle Switch	7767	7767
12	Pilot Light	46047	46047
13	3/16 x 1 Round Rivet (SS)	46906	46906
14	Toggle Switch Boot	13406	13406

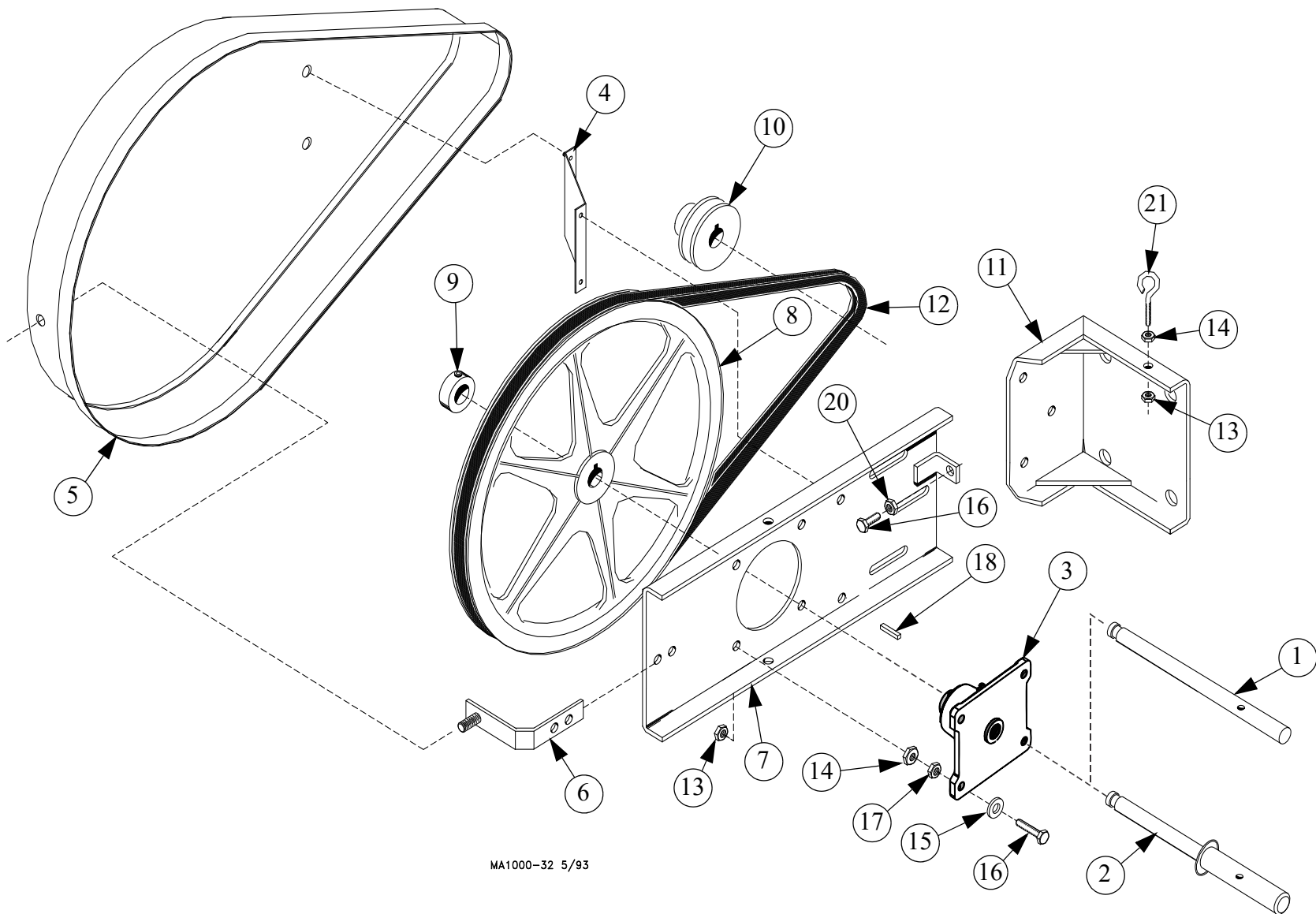
Standard Belt Drive Control Unit Part Numbers

	Model 55	Model 75	Model 90	Model HMC
	46800-11	46800-12	46800-14	46800-13
<u>DESCRIPTION</u>	<u>PART NO.</u>	<u>PART NO.</u>	<u>PART NO.</u>	<u>PART NO.</u>
Control Unit	46800-6	46800-7	46800-9	46800-8
Belt Drive Parts Package	46138-1	46138-2	46138-2	46138-2

*See separate parts list on next page for individual components.

Note: The Belt Drive Control Units include all the Direct Drive Control Unit components, plus the following components.

Standard Belt Drive Control Unit Itemized Part Numbers

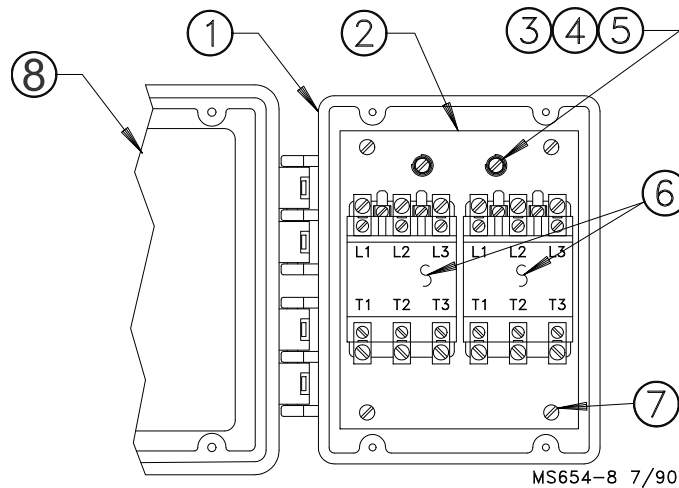


MA1000-32 5/93

Part Numbers

Item	Description	Part Number	
		Model 55	Model 75, 90, and HMC
1 ¹	Model 55 Driver Shaft	27126	--
2 ²	Model 75, 90, & HMC Driver Shaft	--	46156
3 ^{1,2}	Front Plate Bearing Holder	2096	2096
4	Belt Guard Mount	46198	46198
5	Belt Guard	46199	46199
6	Angle Guard Mount	46299	46299
7	Adjustment Bracket	46301	46301
8	11" Dia. Sheave	46190	46190
9 ^{1,2}	5/8" Set Collar	1386	1386
10	2.25" Dia. Sheave	3208	3208
11	Motor Mount Weldment	3058	3058
12	"V" Gripnotch Belt	4409	4409
13	5/16-18 Hex Locknut	2148	2148
14	5/16-18 Hex Locknut	593	593
15	5/16 Flat Washer	546	546
16	5/16-18x1-3/4" Hex Hd. M.S.	4412-4	4412-4
17	5/16-18 Hex Lock Nut	2148	2148
18 ^{1,2}	3/16" Key	2112-1	2112-1
20	5/16-18 Hex Nut	2145	2145
21	Eyebolt	1503-2	1503-2
¹ May be ordered as Bearing and Shaft Assembly (Part no. 46486)			
² May be ordered as Bearing and Shaft Assembly (Part no. 46157)			

24392-0 Contactor Box



Key	Description	Part No.
1	Box	30860-3
2	Mounting Plate Support	41436
3	#10 Ext. Lock washer	305
4	#10-32 Hex Screw	34662
5	Cup Washer	5775
6	Contactor	56577-230
7	#10-24 Pan Head Screw	46011
8	Lid	30859-2

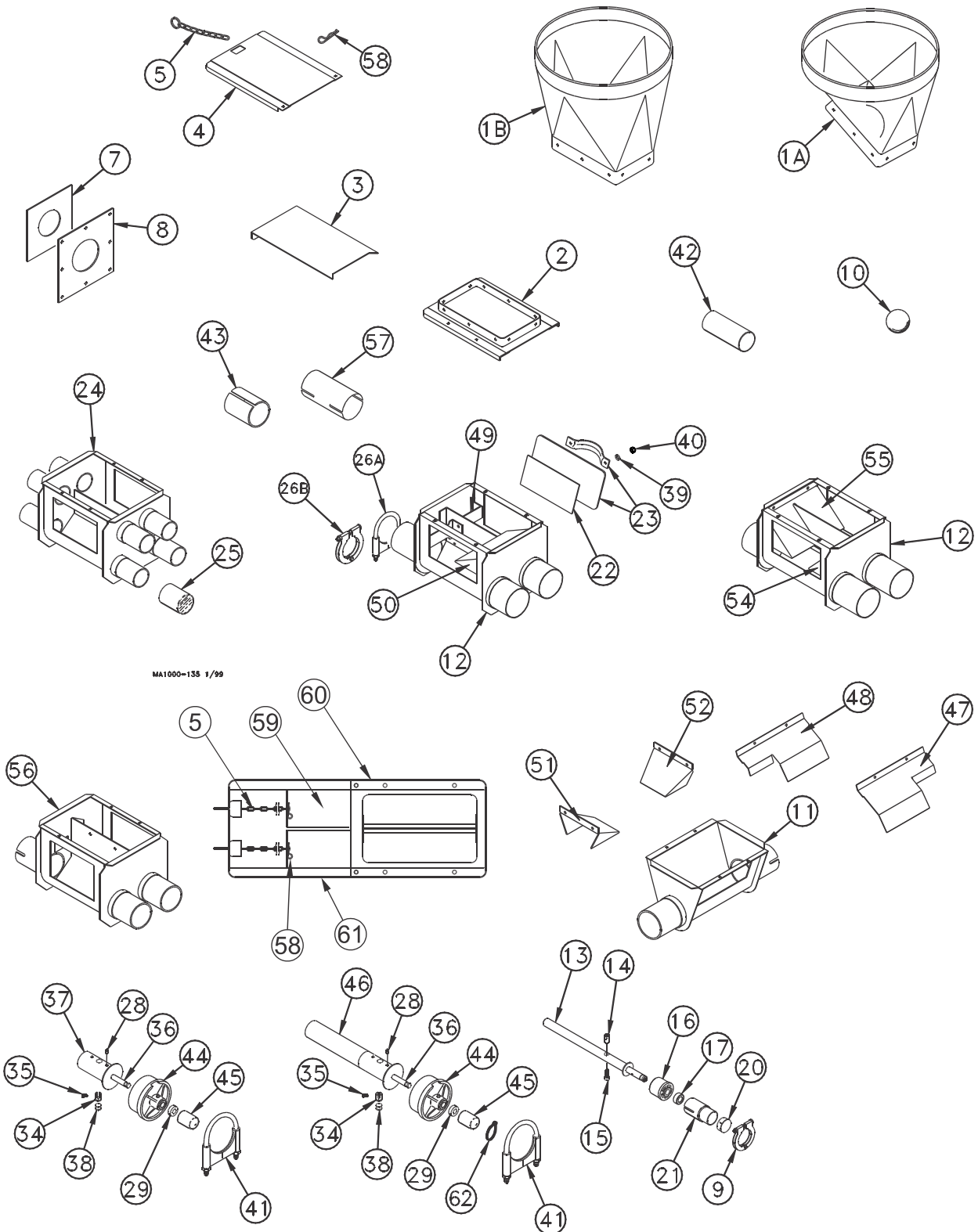
The Contactor Box containing (1) 56577-230 Contactor may be ordered under Part No. 24392-1.

The Contactor Box containing (2) 56577-230 Contactors may be ordered under Part No. 24392-2.

The Contactor Box containing (3) 56577-230 Contactors may be ordered under Part No. 24392-3.

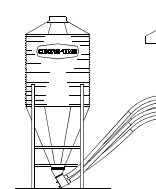
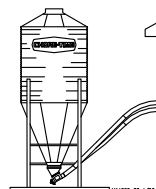
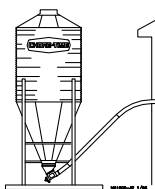
Boot Components

Note: The Parts Listings on the following pages provide the parts numbers associated with this drawing. Be sure to refer to the appropriate page for your model of FLEX-AUGER.



Model 55 Boot Components

See “Boot Components” on page 43 for Part Schematic.



Item	Description	30 Degree Single Boot	30 Degree Twin Boot	30 Degree Quad Boot
-- ⁵	Complete System	8465 ⁵ /SS	8466 ⁵ /SS	8467 ⁵ /SS
-- ²	Lower Boot Assembly	9313/SS	9314/SS	9315/SS
1A ⁶	30 Degree Upper Boot	4347R ⁶	4347R ⁶	4347R ⁶
2 ³	Transfer Plate	4359	4359	4359
3 ³	Slide	4357	4357	36091
4 ³	Slide Shield	4876	4876	4876
5 ³	Chain Assembly	27374	27374	27374
7	Neoprene Seal	6394	6394	6394
8	Seal Ring	2612	2612	2612
9	Tube Clamp	29515	29515	29515
10	Cannonball	3621	3621	3621
11	Single Boot Body	7999/SS	----	----
13 ¹	Model 55 Anchor	39410	39410	39410
14 ¹	Auger Clamp	39205	39205	39205
15 ¹	Socket Head Screw	6850-7	6850-7	6850-7
16 ¹	Anchor Bearing	39407	39407	39407
17 ¹	Set Collar	1386	1386	1386
20	Cap	29523	29523	29523
21	Stub Tube	4163	4163	4163
22 ⁴	Back Plate Weldment	6298SS	6298/SS	6298/SS
23 ⁴	Clean-Out Cover	6301SS	6301/SS	6301/SS
24	Quad Boot Weldment	----	----	7980/SS
25	Outlet Cover	----	----	8026
26B	Tube Clamp	29520	29520	29520
39 ⁴	Sealing Washer	39-20155	39-20155	39-20155
40 ⁴	5/16-18 Lock Nut	2148	2148	2148
42	5" Stub Tube	8555	8555	8555
56	Twin Boot Body Weldment	----	7998/SS	----
58 ³	Hairpin	13906	13906	13906

¹These components may be ordered as a Model 55 Anchor Bearing Assembly under Chore-Time Part No. 39405.

²Items 2 through 56 and item 58 (as listed above) make up the Lower Boot Assemblies (Single, Twin, or Quad).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS*.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS* Clean-Out Cover Ass'y.

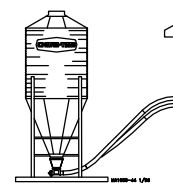
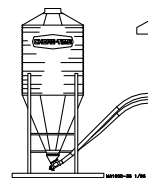
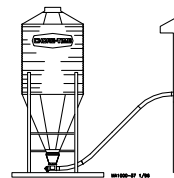
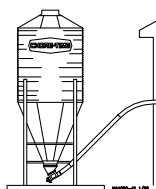
⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a “C” (i.e. Complete System # 8465C) This “C” indicates the Complete System will come with a transparent Clear upper boot.

⁶Upper boot Part No.'s will have a suffix “R” for transparent Red upper boots (i.e. 4347R) or will have a suffix “C” for transparent Clear upper boots (i.e. 4347C).

*SS = Stainless Steel

Model 75 Boot Components

See “Boot Components” on page 43 for Part Schematic.



Item	Description	30 Degree Single Boot	Straight-Out Single Boot	30 Degree Twin Boot	Straight-Out Twin Boot
-- ⁵	Complete System	6539 ⁵ or 6539SS ^{5*}	6540 ⁵ or 6540SS ^{5*}	6873 ⁵ or 6873SS ^{5*}	36801 ⁵ or 36801SS ^{5*}
-- ²	Lower Boot Assembly	36442 or 36442SS*	36589/ or 36589SS*	36389 or 36389SS*	36390 or 36390SS*
1A ⁶	30 Degree Upper Boot	4347R ⁶	----	4347R ⁶	----
1B ⁶	Straight Out Upper Boot	----	6093R ⁶	----	6093R ⁶
2 ³	Transfer Plate Weldment	4359	4359	4359	36641
3 ³	Slide	4357 or 4357SS*	4357 or 4357SS*	4357 or 4357SS*	----
4 ³	Slide Shield	4876	4876	4876	14827
5 ^{3,8}	Chain Assembly	27374	27374	27374	27374
7	Neoprene Seal	2613	2613	2613	2613
8	Seal Ring	2612	2612	2612	2612
10	Cannonball	3531	3531	3531	3531
11	Single Boot Body	36588 or 36588SS*	36588 or 36588SS*	----	----
12	Twin Boot Body	----	----	36350 or 36350SS*	36350 or 36350SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*
26A	Tube Clamp Kit	6515	6515	6515	6515
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174	1174	1174
29 ¹	5/8" Set Collar	1386	1386	1386	1386
34 ¹	Clamp Pin	4702	4702	4702	4702
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095	5095	5095
36 ¹	Anchor Shaft	43281	43281	43281	43281
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*	2148 or 8938*	2148 or 8938*
41 ¹	Tube Clamp Kit	4141	4141	4141	4141
42 ⁷	2.75 x 3.0 Tube	6147	6147	6147	6147
44	Bearing Cap	35440	35440	35440	35440
45 ¹	Safety Cap	29702	29702	29702	29702
46 ¹	Anchor Tube Weldment	6840	6840	6840	6840
47	S-O/S-T Single Baffle	----	35731 or 35731SS*	----	----
48	30° Single Baffle	35732 or 35732SS*	----	----	----
49	Cannon Ball Guard	----	----	35843 or 35843SS*	----
54	Twin End Baffle (75)	----	----	----	35845 or 35845SS*
55	Twin Outlet Baffle (75)	----	----	----	35846 or 35846SS*
58 ^{3,8}	Hairpin	13906	13906	13906	13906
59 ⁸	Slide	----	----	----	14821 or 14821SS*
60 ⁸	Transfer Plate Assembly	----	----	----	36642
61 ⁸	Slide Shield Assembly	----	----	----	14827
62	Cable Tie	56705	56705	56705	56705

¹These components may be ordered as a Model 75 Anchor Bearing Assembly under Chore-Time Part No. 37346 with Long Restrictor and Chore-Time Part No. 37347 with Short Restrictor.

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Assemblies (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS*.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS* Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 6539C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

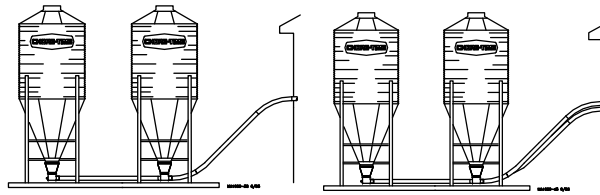
⁷Stub Tube (Item 42) For Opposing Anchor.

⁸Included in 36683 Twin Boot Slide Assembly.

*SS=Stainless Steel.

Model 75 Boot Components (continued)

See “Boot Components” on page 43 for Part Schematic.



Item	Description	Straight-Thru Single Tandem	Straight-Thru Twin Tandem
-- ⁵	Complete System	6541 ⁵ or 6541SS ^{5*}	35880 ⁵ or 35880SS ^{5*}
-- ²	Lower Boot Package	36590 or 36590SS*	36394 or 36394SS*
1A ⁶	30 Degree Upper Boot	----	----
1B ⁶	Straight Out Upper Boot	6093R ⁶	6093R ⁶
2 ³	Transfer Plate Weldment	4359	----
3 ³	Slide	4357 or 4357SS*	----
4 ³	Slide Shield	4876	----
5 ^{3,8}	Chain Assembly	27374	27374
7	Neoprene Seal	2613	2613
8	Seal Ring	2612	2612
10	Cannonball	3531	3531
11	Single Boot Body	36588 or 36558SS*	----
12	Twin Boot Body Weldment	----	36350 or 36350SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*
26A	Tube Clamp Kit	6515	6515
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174
29 ¹	5/8" Set Collar	1386	1386
34 ¹	Clamp Pin	4702	4702
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095
36 ¹	Anchor Shaft	43281	43281
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*
41	Tube Clamp Kit	4141	4141
42 ⁷	2.75 x 3.0 Tube	6147	6147
43	Insert	6524	6524
44 ¹	Bearing Cap	35440	35440
45 ¹	Safety Cap	29702	29702
46 ¹	Anchor Tube Weldment	6840	6840
47	S-O/S-T Single Baffle	35731 or 35731SS*	----
54	Twin End Baffle (75)	----	35845 or 35845SS*
55	Twin Outlet Baffle (75)	----	35846 or 35846SS*
57	Tube Connector	6512	6512
58 ^{3,8}	Hairpin	13906	13906
59 ⁸	Slide	----	14821 or 14821SS*
60 ⁸	Transfer Plate Assembly	----	36642
61 ⁸	Slide Shield Assembly	----	14827
62	Cable Tie	56705	56705

¹These components may be ordered as a Model 75 Anchor Bearing Assembly under Chore-Time Part No. 37346 with Long Restrictor and Chore-Time Part No. 37347 with Short Restrictor.

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Packages (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 6541C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

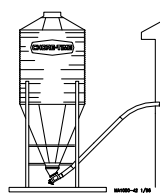
⁷Stub Tube (Item 42) For Opposing Anchor.

⁸Included in 36683 Twin Boot Slide Assembly.

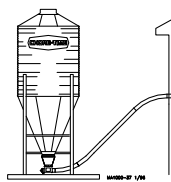
*SS=Stainless Steel.

Model 75 Plus Boot Components

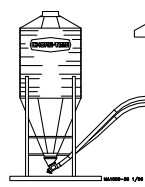
See “Boot Components” on page 43 for Part Schematic.



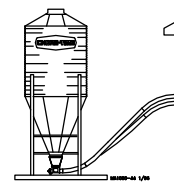
**30 Degree
Single Boot**



**Straight-Out
Single Boot**



**30 Degree
Twin Boot**



**Straight-Out
Twin Boot**

Item	Description	30 Degree Single Boot	Straight-Out Single Boot	30 Degree Twin Boot	Straight-Out Twin Boot
-- ⁵	Complete System	56422-3 ⁵ or 56422SS-3 ^{5*}	56422-2 ⁵ or 56422SS-2 ^{5*}	56424-3 ⁵ or 56424SS-3 ^{5*}	56424-2 ⁵ or 56424SS-2 ^{5*}
-- ²	Lower Boot Assembly	56386 or 56386SS*	56389/ or 56389SS*	56419 or 56419SS*	56421 or 56421SS*
1A ⁶	30 Degree Upper Boot	4347R ⁶	----	4347R ⁶	----
1B ⁶	Straight Out Upper Boot	----	6093R ⁶	----	6093R ⁶
2 ³	Transfer Plate Weldment	4359	4359	4359	36641
3 ³	Slide	4357 or 4357SS*	4357 or 4357SS*	4357 or 4357SS*	----
4 ³	Slide Shield	4876	4876	4876	14827
5 ^{3,8}	Chain Assembly	27374	27374	27374	27374
7	Neoprene Seal	2613	2613	2613	2613
8	Seal Ring	2612	2612	2612	2612
10	Cannonball	3531	3531	3531	3531
11	Single Boot Body	36588 or 36588SS*	36588 or 36588SS	----	----
12	Twin Boot Body	----	----	36350 or 36350SS*	36350 or 36350SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*
26A	Tube Clamp Kit	6515	6515	6515	6515
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174	1174	1174
29 ¹	5/8" Set Collar	1386	1386	1386	1386
34 ¹	Clamp Pin	56409	56409	56409	56409
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095	5095	5095
36 ¹	Anchor Shaft	43281	43281	43281	43281
37	Anchor Tube Weldment	56387	56387	56387	56387
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*	2148 or 8938*	2148 or 8938*
41 ¹	Tube Clamp Kit	4141	4141	4141	4141
42 ⁷	2.75 x 3.0 Tube	6147	6147	6147	6147
44	Bearing Cap	35440	35440	35440	35440
45 ¹	Safety Cap	29702	29702	29702	29702
47	S-O/S-T Single Baffle	----	56464 or 56464SS*	----	----
48	30° Single Baffle	----	----	----	----
49	Cannon Ball Guard	----	----	35843 or 35843SS*	----
54	Twin End Baffle (75)	----	----	----	35845 or 35845SS*
55	Twin Outlet Baffle (75)	----	----	----	56491 or 56491SS*
58 ^{3,8}	Hairpin	13906	13906	13906	13906
59 ⁸	Slide	----	----	----	14821 or 14821SS*
60 ⁸	Transfer Plate Assembly	----	----	----	36642
61 ⁸	Slide Shield Assembly	----	----	----	14827
62	Cable Tie	56705	56705	56705	56705

¹These components may be ordered as a Model 75 Plus Anchor Bearing Assembly under Chore-Time Part No. 56417.

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Assemblies (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS*.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS* Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 56422-3C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

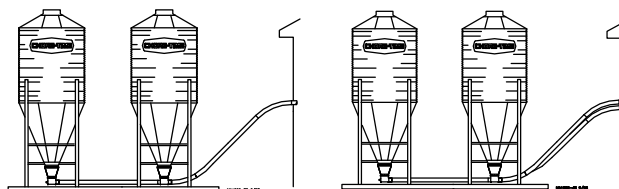
⁷Stub Tube (Item 42) For Opposing Anchor.

⁸Included in 36683 or 36683SS Twin Boot Slide Assembly.

*SS = Stainless Steel.

Model 75 Plus Boot Components (continued)

See “Boot Components” on page 43 for Part Schematic.



Item	Description	Straight-Thru Single Tandem	Straight-Thru Twin Tandem
-- ⁵	Complete System	56422-1 ⁵ or 56422SS-1 ⁵	56424-1 ⁵ or 56424SS-1 ⁵ *
-- ²	Lower Boot Package	56423 or 56423SS*	56490 or 56490SS*
1A ⁶	30 Degree Upper Boot	----	----
1B ⁶	Straight Out Upper Boot	6093R ⁶	6093R ⁶
2 ³	Transfer Plate Weldment	4359	----
3 ³	Slide	4357 or 4357SS*	----
4 ³	Slide Shield	4876	----
5 ^{3,8}	Chain Assembly	27374	27374
7	Neoprene Seal	2613	2613
8	Seal Ring	2612	2612
10	Cannonball	3531	3531
11	Single Boot Body	36588 or 36588SS*	----
12	Twin Boot Body Weldment	----	36350 or 36350SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*
26A	Tube Clamp Kit	6515	6515
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174
29 ¹	5/8" Set Collar	1386	1386
34 ¹	Clamp Pin	56409	56409
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095
36 ¹	Anchor Shaft	43281	43281
37 ¹	Anchor Tube Weldment	56387	56387
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*
41	Tube Clamp Kit	4141	4141
42 ⁷	2.75 x 3.0 Tube	6147	6147
43	Insert	6524	6524
44 ¹	Bearing Cap	35440	35440
45 ¹	Safety Cap	29702	29702
47	S-O/S-T Single Baffle	56488 or 56488SS*	----
54	Twin End Baffle (75 Plus)	----	35845 or 35845SS*
55	Twin Outlet Baffle (75 Plus)	----	56491 or 56491SS*
57	Tube Connector	6512	6512
58 ^{3,8}	Hairpin	13906	13906
59 ⁸	Slide	----	14821 or 14821SS*
60 ⁸	Transfer Plate Assembly	----	36642
61 ⁸	Slide Shield Assembly	----	14827
62	Cable Tie	56705	56705

¹These components may be ordered as a Model 75 Plus Anchor Bearing Assembly under Chore-Time Part No. 56417.

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Packages (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 56422-1C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

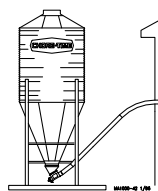
⁷Stub Tube (Item 42) For Opposing Anchor.

⁸Included in 36683 or 36683SS Twin Boot Slide Assembly.

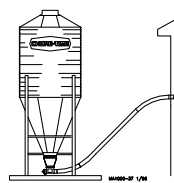
*SS=Stainless Steel.

Model 90 Boot Components

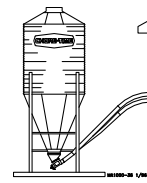
See “Boot Components” on page 43 for Part Schematic.



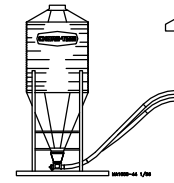
**30 Degree
Single Boot**



**Straight-Out
Single Boot**



**30 Degree
Twin Boot**



**Straight-Out
Twin Boot**

Item	Description	30 Degree Single Boot	Straight-Out Single Boot	30 Degree Twin Boot	Straight-Out Twin Boot
-- ⁵	Complete System	6161 ⁵ or 6161SS ^{5*}	6187 ⁵ or 6187SS ^{5*}	6874 ⁵ or 6874SS ^{5*}	6535 ⁵ or 6535SS ^{5*}
-- ²	Lower Boot Assembly	9301 or 9301SS*	36435 or 36435SS*	36391 or 36391SS*	36398 or 36398SS*
1A ⁶	30 Degree Upper Boot	4347R ⁶	----	4347R ⁶	----
1B ⁶	Straight Out Upper Boot	----	6093R ⁶	----	6093R ⁶
2 ³	Transfer Plate Weldment	4359	4359	4359	----
3 ³	Slide	4357 or 4357SS*	4357 or 4357SS*	4357 or 4357SS*	----
4 ³	Slide Shield	4876	4876	4876	----
5 ^{3,7}	Chain Assembly	27374	27374	27374	27374
7	Neoprene Seal	5035	5035	5035	5035
8	Seal Ring	2612	2612	2612	2612
10	Cannonball	3531	3531	3531	3531
11	Single Boot Body	28873 or 28873SS*	36433 or 36433SS*	----	----
12	Twin Boot Body	----	----	36354 or 36354SS*	36354 or 36354SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*
26A	Tube Clamp Kit	6721	6721	6721	6721
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174	1174	1174
29 ¹	5/8" Set Collar	1386	1386	1386	1386
34 ¹	Clamp Pin	4702	4702	4702	4702
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095	5095	5095
36 ¹	Anchor Shaft	43281	43281	43281	43281
37 ¹	Anchor Tube Weldment	----	26048	26048	26048
38 ¹	Clamp Spacer	5009	5009	5009	5009
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*	2148 or 8938*	2148 or 8938*
41	Tube Clamp Kit	6721	6721	6721	6721
44 ¹	Bearing Cap Assembly	34830	34830	34830	34830
45 ¹	Safety Cap	29702	29702	29702	29702
46 ¹	Anchor Tube Weldment	6833	----	----	----
49	Cannonball Guard	----	----	35843 or 35843SS*	----
50	Twin End Baffle (90)	----	----	36026 or 36026SS*	----
51	Single Inlet Baffle (90)	----	35998 or 35998SS*	----	----
52	Single Outlet Baffle (90)	----	35999 or 35999SS*	----	----
54	Twin Inlet Baffle (90)	----	----	----	36000 or 36000SS*
55	Twin Outlet Baffle (90)	----	----	----	36001 or 36001SS*
58 ^{3,7}	Hairpin	13906	13906	13906	13906
59 ⁷	Slide	----	----	----	14821 or 14821SS*
60 ⁷	Transfer Plate Assembly	----	----	----	36642
61 ⁷	Slide Shield Assembly	----	----	----	14827
62	Cable Tie	56705	56705	56705	56705

¹These components may be ordered as a Model 90 Anchor Bearing Assembly under Chore-Time Part No. 35345 with Short Restrictor (except for 30° Single Boot Systems, order Part No. 35343 with Long Restrictor).

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Assemblies (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a “C” (i.e. Complete System # 6161C) This “C” indicates the Complete System will come with a transparent Clear upper boot(s).

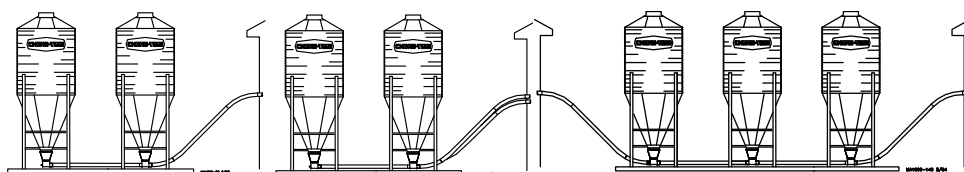
⁶Upper boot Part No.'s will have a suffix “R” for transparent Red upper boots (i.e. 4347R) or will have a suffix “C” for transparent Clear upper boots (i.e. 4347C).

⁷Included in 36683 Twin Boot Slide Assembly.

*SS=Stainless Steel.

Model 90 Boot Components (continued)

See “Boot Components” on page 43 for Part Schematic.



Item	Description	Straight-Thru Single Tandem	Straight-Thru Twin Tandem	Twin Straight-Thru Three Bin System
-- ⁵	Complete System	6281 ⁵ or 6281SS ^{5*}	6538 ⁵ or 6538SS ^{5*}	48660 ⁵
-- ²	Lower Boot Package	36434 or 36434SS*	36388 or 36388SS*	48661
1B ⁶	Straight Out Upper Boot	6093R ⁶	6093R ⁶	6093R ⁶
2 ³	Transfer Plate Weldment	4359	----	----
3 ³	Slide	4357 or 4357SS*	----	----
4 ³	Slide Shield	4876	----	----
5 ³	Chain Assembly	27374	27374	27374
7	Neoprene Seal	5035	5035	5035
8	Seal Ring	2612	2612	2612
10	Cannonball	3531	3531	3531
11	Single Boot Body	36433 or 36433SS*	----	----
12	Twin Boot Body Weldment	----	36354 or 36354SS*	36354
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*	6298
23 ⁴	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*	6301
26A	Tube Clamp Kit	6721	6721	6721
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174	1174
29 ¹	5/8" Set Collar	1386	1386	1186
34 ¹	Clamp Pin	4702	4702	4702
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095	5095
36 ¹	Anchor Shaft	43281	43281	43281
37 ¹	Anchor Tube Weldment	26048	26048	26048
38 ¹	Clamp Spacer	5009	5009	5009
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*	2148 or 8938*
41	Tube Clamp Kit	6721	6721	6721
44 ¹	Bearing Cap Assembly	34830	34830	34830
45 ¹	Safety Cap	29702	29702	29702
51	Single Inlet Baffle (90)	35998 or 35998SS*	----	----
52	Single Outlet Baffle (90)	35999 or 35999SS*	----	----
54	Twin Inlet Boot Baffle (90)	----	36000 or 36000SS*	36000
55	Twin Outlet Boot Baffle (90)	----	36001 or 36001SS*	36001
58 ³	Hairpin	13906	13906	13906
59 ⁷	Slide	----	14821 or 14821SS*	14821
60 ⁷	Transfer Plate Assembly	----	36641	36641
61 ⁷	Slide Shield Assembly	----	14827	14827
62	Cable Tie	56705	56705	56705

¹These components may be ordered as a Model 90 Anchor Bearing Assembly under Chore-Time Part No. 35345 with Short Restrictor.

²Items 2 through 55 and item 58 (as listed above) make up the Lower Boot Packages (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time Part No. 6284 or 6284SS*.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS* Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 6281C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

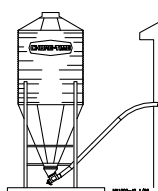
⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

⁷Included in 36683 Twin Boot Slide Assembly.

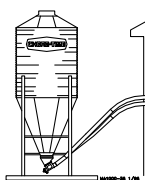
*SS=Stainless Steel.

Model HMC Boot Components

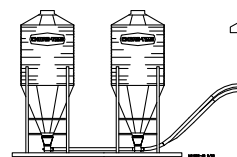
See “Boot Components” on page 43 for Part Schematic.



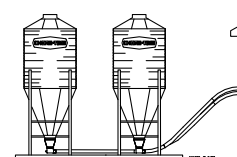
**30 Degree
Single Boot**



**30 Degree
Twin Boot**



**Single Straight-
Thru Tandem**



**Straight-Thru
Twin Tandem**

Item	Description	30 Degree Single Boot	30 Degree Twin Boot	Single Straight- Thru Tandem	Straight-Thru Twin Tandem
-- ⁵	Complete System	7921 ⁵ or 7921SS ^{5*}	7920 ⁵ or 7921SS ^{5*}	40082 ⁵ or 40082SS ^{5*}	36795 ⁵ or 36795SS ^{5*}
-- ²	Lower Boot Ass'y/Package	38507 or 38507SS*	38506 or 38506SS*	40081 or 40081SS*	36796 or 36796SS*
1A ⁶	30 Degree Upper Boot	4347R ⁶	4347R ⁶	----	----
1B ⁶	Straight-Through Upper Boot	----	----	6093R ⁶	6093R ⁶
2 ³	Transfer Plate Weldment	4359	4359	4359	----
3 ³	Slide	4357 or 4357SS*	4357 or 4357SS*	4357 or 4357SS*	----
4 ³	Slide Shield	4876	4876	4876	----
5 ^{3,7}	Chain Assembly	27374	27374	27374	27374
7	Neoprene Seal	5035	5035	5035	5035
8	Seal Ring	2612	2612	2612	2612
10	Cannonball	3531	3531	3531	3531
11	Single Boot Body	28873 or 28873SS*	----	36433 or 36433SS*	----
12 ⁴	Twin Boot Body	----	28878 or 28878SS*	----	36354 or 36354SS*
22 ⁴	Back Plate Weldment	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*	6298 or 6298SS*
23	Clean-Out Cover	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*	6301 or 6301SS*
26	Tube Clamp Kit	6721	6721	6721	6721
28 ¹	5/16-18 x 3/8" Set Screw	1174	1174	1174	1174
29 ¹	5/8" Set Collar	1386	1386	1386	1386
34 ¹	Clamp Pin	4702	4702	4702	4702
35 ¹	5/16-18 x 1/2" Set Screw	5095	5095	5095	5095
36 ¹	Anchor Shaft	43281	43281	43281	43281
37 ¹	Tube Anchor Weldment	----	----	36393	36393
39 ⁴	Sealing Washer	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*	39-20155 or 56308*
40 ⁴	5/16-18 Wing Nut	2148 or 8938*	2148 or 8938*	2148 or 8938*	2148 or 8938*
41	Tube Clamp Kit	6721	6721	6721	6721
44 ¹	Bearing Cap Assembly	34830	34830	34830	34830
45 ¹	Safety Cap	29702	29702	29702	29702
46 ¹	Anchor Tube Weldment	6840	6840	----	----
51	Single Inlet Baffle (HMC)	----	----	38638 or 38638SS*	----
52	Single Outlet Baffle (HMC)	----	----	38639 or 38639SS*	----
54	Twin Inlet Boot Baffle (HMC)	----	----	----	36797 or 36797SS*
55	Twin Outlet Boot Baffle (HMC)	----	----	----	36798 or 36798SS*
58 ^{3,7}	Hairpin	13906	13906	13906	13906
59 ⁷	Slide	----	----	----	14821 or 14821SS*
60 ⁷	Transfer Plate Assembly	----	----	----	36641
61 ⁷	Slide Shield Assembly	----	----	----	14827
62	Cable Tie	56705	56705	56705	56705

¹These components may be ordered as a Model HMC Anchor Bearing Assembly under Chore-Time Part No. 35344 with Long Restrictor (except for Tandem Systems, order Part No. 37241 with Short Restrictor).

²Items 2 through 46 and item 58 (as listed above) make up the Lower Boot Assemblies/Packages (Single or Twin).

³Items 2 through 5 and item 58 may be ordered under Chore-Time part no. 6284 or 6284SS*.

⁴Items 22, 23, 39, & 40 may be ordered under Chore-Time Part No. 6197 or 6197SS* Clean-Out Cover Ass'y.

⁵All Complete Systems will come with transparent Red upper boot(s) unless specified with a "C" (i.e. Complete System # 7921C) This "C" indicates the Complete System will come with transparent Clear upper boot(s).

⁶Upper boot Part No.'s will have a suffix "R" for transparent Red upper boots (i.e. 4347R) or will have a suffix "C" for transparent Clear upper boots (i.e. 4347C).

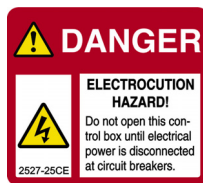
⁷Included in 36683 Twin Boot Slide Assembly.

*SS = Stainless Steel.

Troubleshooting

ALWAYS DISCONNECT POWER TO THE SYSTEM WHEN SERVICING OR MAINTAINING THE EQUIPMENT. FAILURE TO DISCONNECT POWER MAY CAUSE INJURY OR DEATH.

Maintenance and repair to the system must be performed by a qualified technician only.



Problem	Possible Cause	Corrective Action
Delivery system will not run.	No power to the system.	Check circuits, fuses, and on-off switches on the equipment.
	Bin level switch has stopped the system due to lack of feed in the boot.	Check feed supply and for possible bridging.
	Motor overloaded and stopped.	Check for foreign material in the line. Push the motor reset button.
	Safety switch actuated in the Control Unit (red pilot light will be lit).	Determine reason for feed packing in the Control Unit. Feed level switch out of adjustment?
Motor overloads after running briefly.	Motor too small.	Use recommended size motor for line length.
	Low voltage (motor runs slow and overheats).	Check line voltage at the motor; use adequate size wire in circuits.
	Foreign object in the auger (motor runs, stalls, then auger spins in reverse).	Check auger line, pull auger to remove objects.
	Motor wired in reverse (motor runs, stalls, no feed conveyed).	Disconnect power and change wire connections (direct drive power unit shaft at rear of motor turns clockwise).
	Boot Anchor tight.	Check for Anchor binding.
	Wet feed being conveyed or allowed to stand in auger tubes. Defective motor (over heats without load).	Clean auger and tubes; avoid conveying wet feed or empty line after each feeding. Replace motor.
Motor runs, but auger does not turn.	Sheared driver bolt at Control Unit.	Replace driver bolt.
	Broken power unit pinion.	Examine pinion on motor shaft; replace BOTH gear head and pinion if pinion is damaged.

Auger wears holes in tubes.	Auger kinked or poorly brazed.	See Auger Brazing section in this manual
Elbows wear out.	Auger is stretched too tight; horizontal L.H. turn; auger has been run dry.	Lengthen auger; Install an Extension Hopper; wire Boot Switch into system.
Excessive auger vibration and noise.	System has been operated too often without feed (auger has scored the auger tubes).	Wire a Boot Switch to stop the system when the feed bin is empty; replace damaged auger tubes; be sure auger has proper amount of stretch.
	Tubes inadequately supported.	Support the tubes every 5' (1.5 m) or closer.
	Horizontal L.H. turn.	No outlet drops on or just before an elbow; lengthen the auger; install an Extension Hopper ahead of elbows.
Fill system short cycles.	Control end feed level switch does not provide large enough feed differential.	Use a time clock to program operating cycles. Use Control end feed level switch w/lockout and time clock.
Extension Hopper packs full of feed.	Both switches on Extension Hopper are out of adjustment.	Adjust switches as specified in maintenance section in this manual.
Second portion of extended length system will not start.	Lower switch on Extension Hopper out of adjustment.	Adjust switch as specified in the maintenance section of this manual.
	Feed level control at end of line out of adjustment.	Examine and make necessary adjustments; see feed level switch adjustment instruction.
Second portion of extended length system short cycles.	Too much Restrictor in the Boot.	Shorten Restrictor.
	Too much feed is still dispensing from drops ahead of Extension Hopper.	Last outlet drop before Extension Hopper must have full feed drop out. NOTE: All feeders ahead of hopper must complete filling before feed reaches hopper.
	Trim Restrictor on first portion to allow more incoming feed.	

Maintenance

The FLEX-AUGER Feed Delivery System requires minimum maintenance. However, a routine periodic inspection of the equipment will prevent unnecessary problems.

Maintenance should be done by a qualified technician.

ALWAYS DISCONNECT POWER TO THE SYSTEM WHEN SERVICING OR MAINTAINING THE EQUIPMENT. FAILURE TO DISCONNECT POWER MAY CAUSE INJURY OR DEATH.

1. Periodically check and tighten the delivery system hardware.
2. Grease boot bearings on grease fittings regularly, using an automotive or industrial type grease.
3. Keep the FLEX-AUGER tubes level. Adjust if necessary. Wear increases at the points where tubes sag.
4. Replace the Plastic Shipping Plug in the power unit gear head with the Vented Plug during installation of the Power Unit.
5. Check the oil level in the gear heads at installation and every 6 months. The Pipe Plug, on the side of the gear head, indicates proper oil level. Add SAE 40W oil when necessary.

The oil in the gear heads should be replaced every 12 months with new SAE 40W oil.

- A. Remove the bottom Pipe Plug to drain the oil. Discard used oil in accordance with local and national codes.
- B. Wipe any debris off the magnet on the bottom Pipe Plug and reinstall. Remove the side Pipe Plug and (top) Vent Plug.
- C. Set the power unit in the horizontal position.
- D. 2-Stage Gear Heads (3261-5, -6, -7, -8, -10, -11, -13, -16, and -17): Add approximately 9 oz. (266 ml) of SAE 40W oil through top hole. This should be just enough oil to reach the side Pipe Plug.
- 3-Stage Gear Heads (3261-14, -15, -21, and -22): Add approximately 13.5 oz. (384 ml) of SAE 40W oil through top hole. This should be just enough oil to reach the side Pipe Plug.
- E. Install the side Pipe Plug and (top) Vent Plug.

6. Extension Hopper Switch Adjustment Procedure:
 - A. CAUTION: DISCONNECT POWER.
 - B. Make sure no feed is against the Paddle.
 - C. Turn adjusting nut clockwise until switch clicks.
 - D. Turn adjusting nut counterclockwise until switch clicks.
 - E. Turn adjusting nut counterclockwise one half turn.

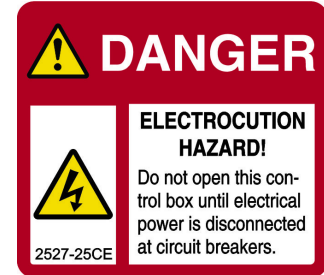
7. If the system is not to be used for an extended period of time, remove all the feed from the auger lines.

Disconnect power to the system to prevent accidentally starting the system.

8. If the system must be disassembled, extreme caution must be used to prevent injury from springing auger.
 - A. Disconnect power to the entire system.
 - B. Pull the Anchor and Bearing Assembly and approx. 18" (45 cm) of auger out of the boot.
 - C. Place a clamp or locking pliers on the auger to prevent it from springing back into the auger tubes.
 - D. Remove Anchor and Bearing Assembly.
 - E. Carefully release the clamp securing the auger.

CAUTION: Stand clear...the auger will spring back into the tubes.

- F. Remove remaining system components in the opposite order they were installed, according to this manual.



Livestock and Poultry Feed Consumption

POULTRY

Poultry applications use automatic feeding systems sized for the building density. The FLEX-AUGER® Feed Delivery System's delivery rate should be sized to match or exceed the sum of the delivery rates of the automatic feeders supplied.

CHORE-TIME Floor Feeding Systems

Delivery Rates

Model C, C2, H2, and G with 216 RPM Power Unit.....	10.8 lbs or 4.89 kg/min.*
Model C, C2, H2, and G with 348 RPM Power Unit.....	17.0 lbs or 7.71 kg/min.*
Model ATF.....	18.0 lbs or 8.16 kg/min.*
Pan Breeder Feeder System.....	35.0 lbs or 15.87 kg/min.*
ULTRAFLO Breeder Feeder (per Hopper).....	52.0 lbs or 23.58 kg/min.*
ULTRAPAN Feeding System (per Hopper).....	50.0 lbs or 22.68 kg/min.*

*Based on 40 lbs/ft³ density (64 kg/m³)

Genesis Loop (Per Inlet Boot).....	65.0 lbs or 29.48 kg/min.*
Genesis Straight-Line.....	35.0 lbs or 15.9 kg/min.*

HOGS

Live weight-lbs/Hog

Total Average Daily Feed-lbs/Head

10-25 (4.5-11.3 kg).....	1.2 (.54 kg)
25-50 (11.3-22.7 kg).....	2.5 (1.13 kg)
50-75 (22.7-34 kg).....	4.0 (1.81 kg)
75-125 (34-56.7 kg).....	5.2 (2.35 kg)
125-175 (56.7-79.4 kg).....	6.7 (3.04 kg)
175-225 (79.4-102 kg).....	7.8 (3.54 kg)
Gestating Sows.....	5 (2.26 kg)

DAIRY

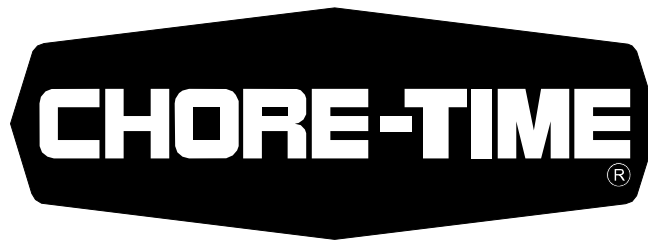
Milk/Cow/Day-lbs Average

Concentrates*/Cow/Day-lbs Average

30 (13.61 kg)	10 (4.53 kg)
50 (22.68 kg)	20 (9.07 kg)
70 (31.75 kg)	30 (13.61 kg)
80 (36.28 kg)	40 (18.14 kg)

TO DETERMINE THE RUNNING TIME PER DAY-Multiply the number of animals by the feed consumption/head figures from the charts to get Total Feed Consumption.

-Divide Total Feed Consumption by the stated delivery rate of the FLEX-AUGER® Feed Delivery System to get running time per day in minutes. Divide this by 60 to get running time per day in hours.



MADE TO WORK.

BUILT TO LAST.®

Revisions to this Manual

Page No.	Description of Change	ECO
23	Added "Model 90 Twin 3 Bin..."	35207
27	Changed Model 75 Plus Twins Pictorially	
37	45926 to 45925 for Model 75 Plus	
40	Consolidated Front Plate Bearing Parts into assembly	

**For additional parts and information, contact your nearest Chore-Time distributor or representative.
Find your nearest distributor at: www.choretime.com/contacts**

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