

Safety Instructions for handling the auger:

- Ensure the electrical power is disconnected prior to installation or servicing to prevent personal injury
- Wear protective clothing and protective eyewear when working with auger
- Extreme caution should be exercised when working with the auger. The auger is under tension and may spring back causing severe injury. Keep your hands away from the end of the auger tube to avoid injury
- The auger must be handled with care. Dropping of the auger rolls may cause the auger to kink, causing wear in the tube.
- It is recommended that two people install the auger. One person will feed the auger into the tubing, while the other person verifies that the auger is not damaged. Ensure that no foreign objects enter the tubing.

1. Auger Installation & Tensioning Guideline:

Pre-tensioning of the auger is required in order to prevent premature wearing of the tubes or damage to the fill system.

The following steps provide a guideline for tensioning the auger during installation:

- 1.1 Pull the auger out of the tube until stretching begins and then release the auger to its relaxed position. Mark the auger where it exits the tube as shown below (see point 1- Figure 1).



Figure 1

- Stretch the auger 5cm (2 inches) for every 15m (49ft) of auger length and make a second mark (see point 2).
- Pull the auger out a further 20cm (8 inches) and using locking pliers, grip the auger.
- Allow the auger to pull back until the locking pliers press against the pipe, as shown in Figure 2.

For Tandem feeding Systems:

- Follow the same procedure as mentioned in 2.1, but stretch the auger 10cm (4 inches) for every 15m (49ft) of auger length and make a second mark (see point 2 in Figure 2).
- Never install an elbow between two boots.
- Install the Silos at a max. distance of 3m apart.
- To minimize wear on the second boot, it is imperative that the auger enters the system at a horizontal distance of 1.5m beyond the second boot.

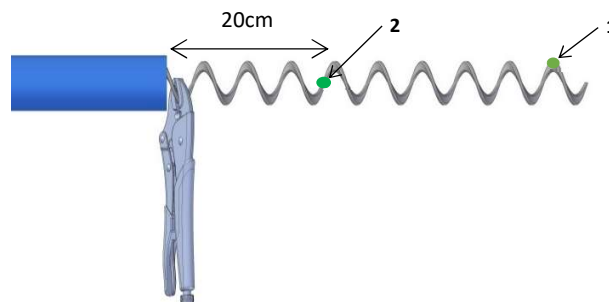


Figure 2

- 1.2 At the second mark (point 2), cut the auger using either a hacksaw or bolt cutter.

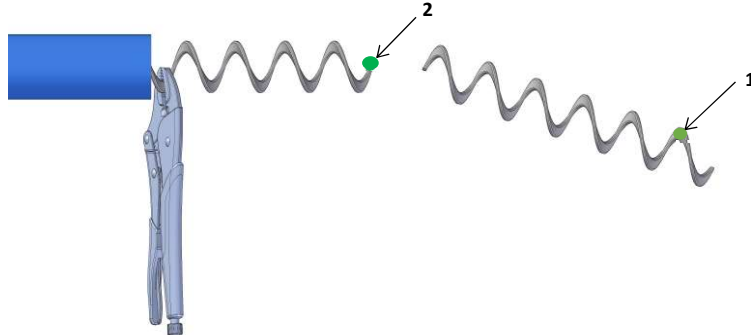


Figure 3

- 1.3 The shaft can now be installed.

NOTE: When shaft installation is complete take special care when removing locking pliers, since the auger is now under extreme stress and can cause severe injury when springing back into the tube.

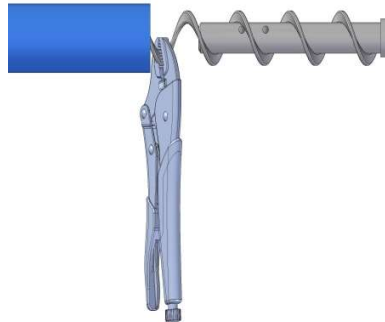


Figure 4

- 2.4. The minimum recommended radius for bends in the auger systems is 3m.

2. Auger Run-in Procedure

This process is done to remove the manufacturing grease and oil from the auger and tubes. Failure to completely remove grease and oil will result in excessive feed build up, causing the auger to plug and bind.

- 2.1 First close the slide on the feed unloader.
- 2.2 The system needs to run dry for 30 minutes. While the system is running, all drops except for the one furthest from the feed bin needs to be closed.
- 2.3 After 30 minutes, whilst leaving the system running, slowly open the unloader slide 3 - 6cm (1.2 to 2.4 inches). Allow feed to enter the system for 30 seconds, and then close the slide. The tube should now only be partially filled with feed.
- 2.4 Go to the last drop and wait for all the feed in the line to exit the system.
- 2.5 Steps 3 and 4 should be repeated at least three times until feed is clean and dry.
- 2.6 The system should now be ready for operation with the slide in its fully open position.

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