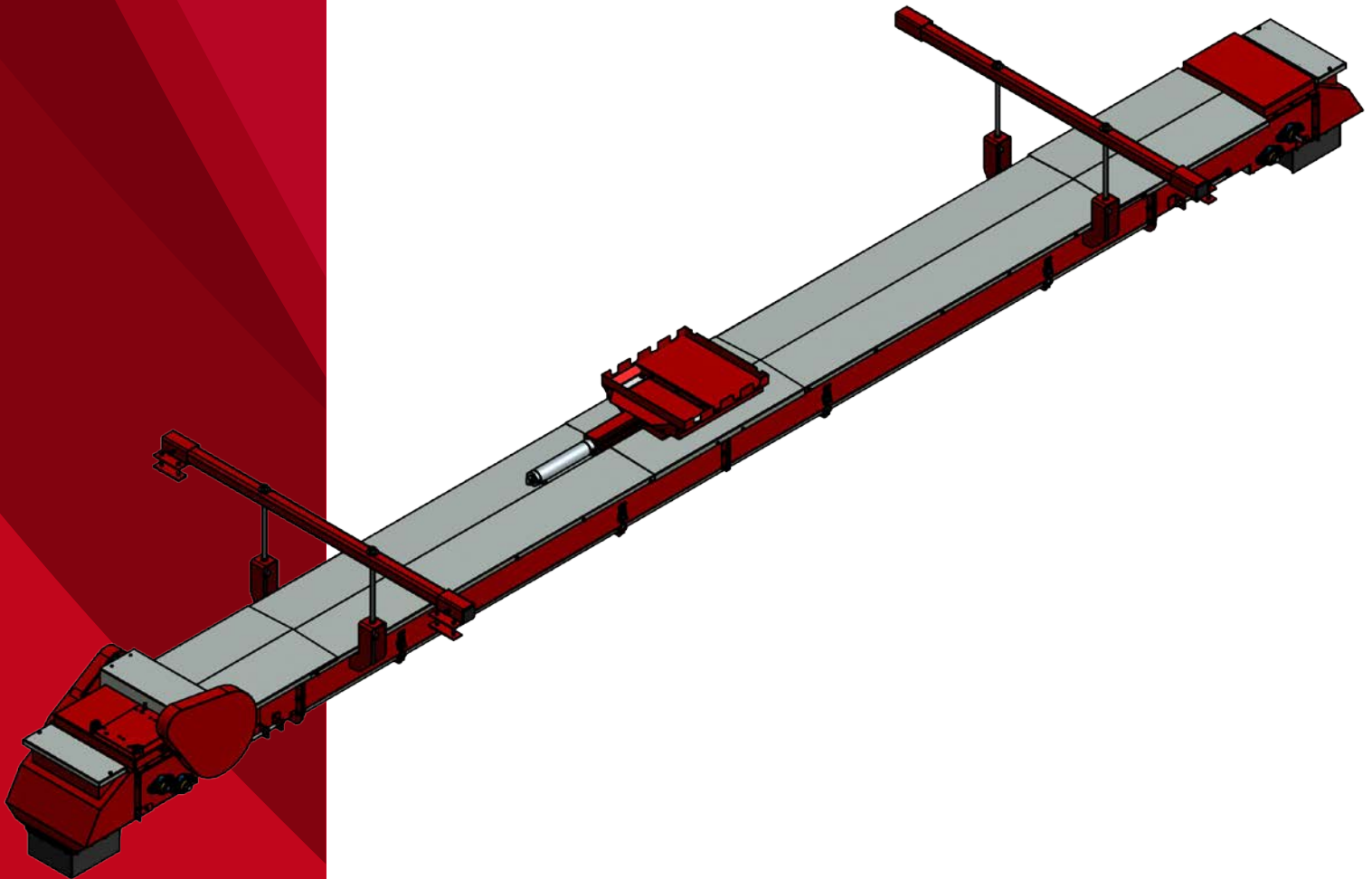


MERIDIAN

OPERATOR'S MANUAL



UNDERBIN CONVEYORS

CONGRATULATIONS

Congratulations on your choice of a Meridian Conveyor. This conveyor has been designed and manufactured to meet the exacting standards for such equipment in the agricultural industry and will keep your seed delivery system at optimum efficiency.

Safe, efficient, and trouble-free operation of your conveyor requires that you and anyone else who will be operating or maintaining the conveyor, read and understand the Safety, Operation, Maintenance, and Troubleshooting information contained within this manual.

This manual covers the operating procedures and maintenance of the conveyor designed by Meridian Manufacturing, Inc. Use the Table of Contents as a guide to locate required information.

INTENDED USE

The Underbin Conveyor is designed to move grain from single or multiple seed bins to either end of the structure. This seed can then be conveyed by another conveyor inside a building or into the mobile seed container. This system is intended for seed only and is not intended to convey any other product, such as fertilizer.

OWNER/OPERATOR

It is the responsibility of the owner or operator to read this manual and to train all other operators before they start working with the conveyor. Follow all safety instructions exactly. Safety is everyone's business. By following recommended procedures, a safe working environment is provided for the operator, bystanders, and the area around the work site. Untrained operators are not qualified and must not operate the conveyor.

In addition to the design and configuration of the conveyor, hazard control and accident prevention are dependent upon the awareness, concern, prudence, and proper training of personnel involved in the operation, transport, maintenance, and storage of the conveyor. It is the responsibility of the owner or operator to read this manual and to train all operators before they start working with the conveyors. Follow all safety instructions as provided in this manual.

Keep this manual accessible for easy reference. Call your Meridian Manufacturing, Inc. dealer if you need assistance, information, or additional copies of the manuals.

The information, specifications, and illustrations in this manual are those in effect at the time of printing. We reserve the right to change specifications or design at any time without notice.

OWNERSHIP CHANGES

If any of the equipment associated with this conveyor changes ownership, then the new owner(s) must be given all applicable documentation associated with all the components/equipment of the site. The new owners need to notify the individual manufactures of the ownership changes so that updates to product or documentation can be forwarded to the new owner(s). This should be done even if the conveyor is out of warranty because many manufacturers supply update notifications as long as they have valid ownership information.

END OF LIFE DISPOSAL

The Meridian conveyors are designed for the specific purpose of conveying grain. When this conveyor is no longer capable of doing its designed purpose, it should be dismantled and scrapped. Do not use any materials or components from this conveyor for any other purpose.

WARNING

DO NOT use this conveyor, or one of its components, for anything other than the manufacture's original intended use. Not only will the warranty be voided, but the component can fail in the unintended application, creating a hazard to the conveyor and the personnel using the conveyor.

CALIFORNIA CODES

If this conveyor is assembled in the state of California, there are some specific codes and warnings that need to be noted. Contact the State of California to determine which codes and warnings apply to the components of the conveyor.

REPORTING HAZARD

If any of the equipment associated with this conveyor appears to pose a hazard, then it is the duty of the individual to report it immediately. If the hazard is the conveyor, then the manufacturer and site manager must be notified. If the hazard is a process, then the site manager must be notified. Unreported hazards can lead to serious injury or death to personnel.

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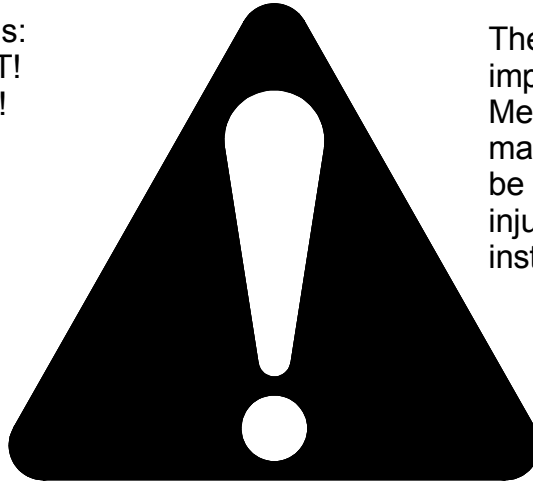
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SAFETY SYMBOLS

This Safety Alert Symbol means:
ATTENTION! BECOME ALERT!
YOUR SAFETY IS INVOLVED!



The Safety Alert Symbol identifies important safety messages on the Meridian Equipment and in the manual. When you see this symbol, be alert to the possibility of personal injury or death. Follow the instructions in the safety message.

Why is SAFETY important to you?

3 Big Reasons:

Accidents Disable and Kill
Accidents Cost
Accidents Can Be Avoided

SIGNAL WORDS:

Note the use of the signal words **DANGER**, **WARNING** and **CAUTION** with the safety messages. The appropriate signal word for each message has been selected using the following guidelines.

DANGER:

Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury. This signal word is to be limited to the most extreme situations typically for machine components which, for functional purposes, cannot be guarded.

WARNING:

Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.

CAUTION:

Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

If you have any questions not answered in the manual, require additional copies of the manual, or the manual is damaged, please contact your dealer or Meridian Manufacturing Inc.
PO Box 1996 2800 Pasqua Street North, Regina SK, S4P 3E1
1-800-667-5904 (T) 1-306-545-4216 (F) www.meridianmfg.com

SAFETY & GENERAL SAFETY

SAFETY

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

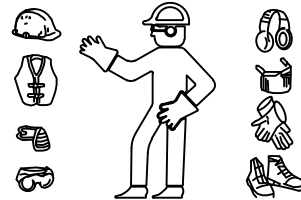
Remember, **YOU** are the key to safety. Good safety practices not only protect you but also the people around you. Make these practices a working part of your safety program. Be certain that **EVERYONE** operating this conveyor is familiar with the recommended operating and maintenance procedures and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

- Conveyor owners must give operating instructions to operators and employees before allowing them to operate the conveyor, and then annually thereafter per OSHA (Occupational Safety and Health Administration) regulation 1928.57.
- The most important safety feature on this conveyor is a **SAFE** operator. It is the operator's responsibility to read and follow **ALL** Safety and Operating instructions in the manual. Most accidents can be avoided.
- A person who has not read and understood all operating and safety instructions is not qualified to operate the conveyor. An untrained operator exposes himself and bystanders to possible serious injury or death. Always be and stay alert to any possible unsafe operating or maintenance procedures or conditions.
- Do not modify the conveyor in any way. Unauthorized modification may impair the function and/or safety of the components and systems and could affect the life of the equipment, possibly invalidating the warranty coverage.
- Improper operation, lubrication, maintenance or repair of this conveyor can be dangerous and could result in injury or death.
- Think SAFETY! Work SAFELY!

GENERAL SAFETY

1. Read and understand the operator's Manual for all safety signs before operating or maintaining the conveyor.
2. Have a first aid kit available for use should the need arise and know how to use it.
3. Have a fire extinguisher available for use should the need arise and know how to use it.
4. Do not stand or jump over conveyor.
5. When working around or operating this conveyor, wear appropriate personal protective equipment. This list includes but is not limited to:

- A Hard hat
- Protective shoes with slip resistant soles
- Protective goggles, glasses or face shield
- Heavy gloves
- Protective clothing
- Respirator



6. Do not allow long hair, loose fitting clothing or jewelry around the conveyor as it can be caught in moving parts.
7. Install and secure all guards before starting the conveyor.
8. Establish a Lock-out/Tag-out policy for the work site. Be sure all personnel are trained in and follow all procedures. Lock-out/Tag-out all power sources before working around the conveyor.
9. Clear the work area of people, especially small children, before starting.
10. Review safety related items annually with all personnel who will be operating, using or maintaining the Conveyor.

EQUIPMENT SAFETY GUIDELINES

1. Safety of the operator and bystanders is one of the main concerns in designing and developing a conveyor system. However, every year many accidents occur which could have been avoided by a few seconds of thought and a more careful approach to handling equipment. You, the operator, can avoid many accidents by observing the following precautions in this section. To avoid personal injury or death, study the following precautions and insist those working with you, or for you, follow them.
2. In order to provide a better view, certain photographs or illustrations in this manual may show an assembly with a safety shield removed. However, the conveyor should never be operated in this condition. Keep all shields in place. If shield removal becomes necessary for repairs, replace the shield prior to use.
3. Never use alcoholic beverages or sedative drugs while operating this conveyor. Consult your doctor about operating this conveyor while taking prescription medications.
4. Under no circumstances should young children be allowed to operate this conveyor. Do not allow persons to operate or maintain this conveyor until they have read this manual and have developed a thorough understanding of the safety precautions and how the conveyor works. Review the safety instructions with all users annually.
5. This conveyor is dangerous to children and persons unfamiliar with its operation. The operator should be a responsible, properly trained and physically able person familiar with farm machinery and trained in this conveyor's operation. If the elderly are assisting with farm work, their physical limitations need to be recognized and accommodated.
6. Never exceed the limits of the conveyor. If its ability to do a job, or to do so safely, is in question - DO NOT TRY IT.
7. Do not modify the conveyor in any way. Unauthorized modifications can result in serious injury or death and may impair the function and life of the conveyor.
8. In addition to the design and configuration of this conveyor, including Safety Signs and Safety Equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel involved in the operation and maintenance of the conveyor system. Also refer to Safety messages and operation instructions in manuals for auxiliary equipment. Make sure all Safety Signs are affixed to the auxiliary equipment.

SAFETY TRAINING

1. Safety is a primary concern in the design and manufacture of our conveyors. Unfortunately, our efforts to provide a safe conveyor can be cancelled out by a single careless act of an operator or bystander.
2. The best safety feature is an informed, careful operator. It is the operator's responsibility to read and comply with ALL Safety and Operating instructions in the manual. Accidents can be avoided.
3. Working with an unfamiliar conveyor system can lead to injuries. Read this manual, as well as the manual for any auxiliary equipment, before assembling or operating to acquaint yourself with the equipment. If this conveyor is used by any person other than yourself, it is your responsibility to make certain that the operator reads and understands the operator's manuals and is instructed in safe and proper use.
4. Know your controls and how to immediately stop the conveyor belt and any other auxiliary equipment in an emergency. Read this manual and the one provided with all auxiliary equipment.
5. Train all new personnel and review instructions frequently with employees. Be certain only a properly trained and physically able person will operate the conveyor. A person who has not read and understood all operating and safety instructions is not qualified to operate the conveyor. An untrained operator exposes himself and bystanders to possible serious injury or death.

SAFETY SIGNS

SAFETY SIGNS LOCATION

The types of safety signs and locations on the conveyor are shown in the following pages. Good SAFETY AWARENESS requires that you familiarize yourself with the various safety signs, the type of warning and the area, or a particular function related to that area.

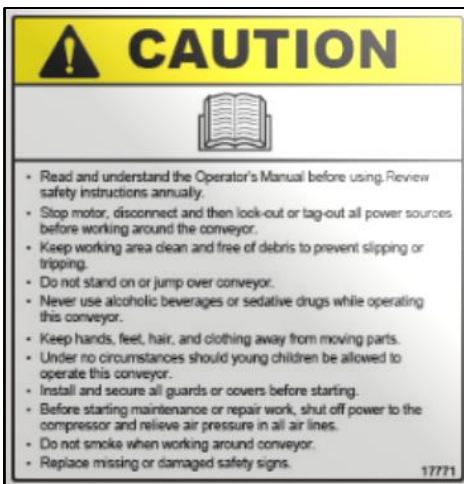
1. If safety signs have been damaged, removed, become illegible, or parts replaced without signs, new signs must be applied.
2. Replacement parts that display a safety sign should also display the current sign.
3. Replacement safety signs (labels) are available from your authorized Dealer Parts Department or the factory at no cost.

HOW TO INSTALL SAFETY SIGNS

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

DECAL LOCATIONS

1. CAUTION - Read and Understand (#17771)



2. WARNING - Missing Shield Hazard (#19937)

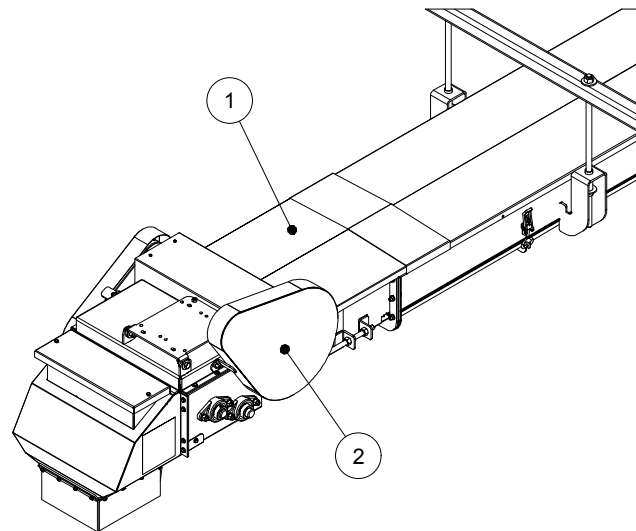


FIGURE 1

3. DANGER - Entanglement Hazard (#18435)
(Located under drive belt pulley guard)

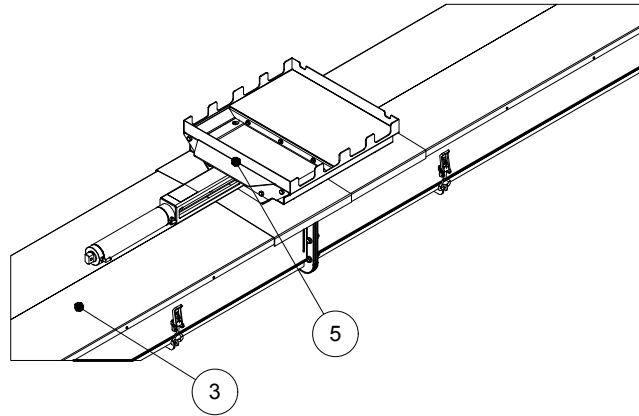


FIGURE 2

4. WARNING - Entanglement Hazard (#17770)

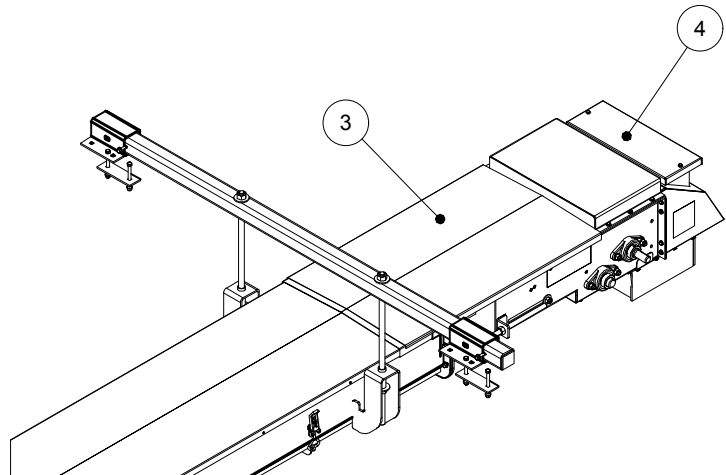
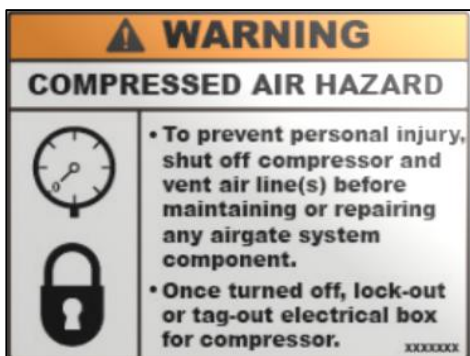


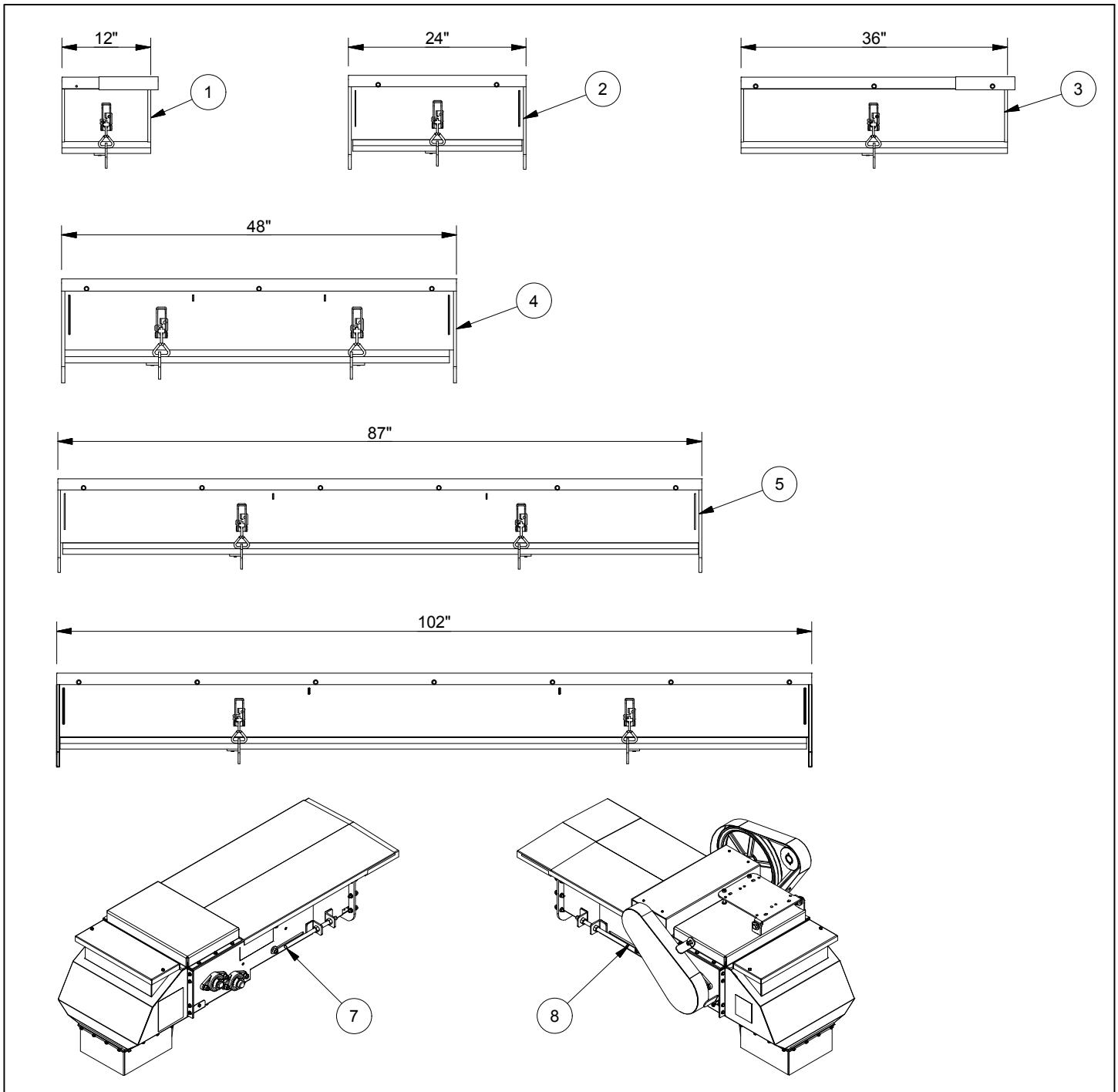
FIGURE 3

5. WARNING - Compressed Air Hazard (#17772)



SPECIFICATIONS

CONVEYOR SECTIONS SPECIFICATIONS



Item	Width	Length	Weight
1	46 cm (18")	30 cm (12")	16 kg (35 lbs)
2	46 cm (18")	61 cm (24")	27 kg (59 lbs)
3	46 cm (18")	91 cm (36")	40 kg (87 lbs)
4	46 cm (18")	122 cm (48")	52 kg (115 lbs)
5	46 cm (18")	221 cm (87")	91 kg (200 lbs)
6	46 cm (18")	259 cm (102")	104 kg (230 lbs)
7	46 cm (18")	129 to 147 cm (51 to 58")	98 kg (215 lbs)
8	46 cm (18")	129 to 147 cm (51 to 58")	135 kg (298 lbs)*

*Weight does not include the motor.

ELECTRICAL SPECIFICATIONS

There are different voltage and phase options available for the transport conveyors. The table below lists these various options and the corresponding part numbers. These components must be purchased separately.

Electrical Motor Options and Specifications	
Conveyor Length	Motor Size
12.2 M (40') – 2 Bins	5 hp
22 M (72') – 4 Bins	7.5 hp
27.4 M (90') – 5 Bins	10 hp
Over 27.4 M (90') – 5 Bins	15 hp

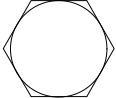


Electrical Motor Options and Part Numbers	
Motor Size	Motor Part Number
3hp/220V/1ph	17848
3hp/220V or 460V/3ph	17849
3hp/600V/3ph	17850
5hp/220V/1ph	27362
5hp/220V or 460V/3ph	18369
5hp/600V/3ph	18370
7.5hp/220V/1ph	18371
7.5hp/220V or 460V/3ph	18372
7.5hp/600V/3ph	18373
10hp/220V/1ph	18374
10hp/220V or 460V/3ph	18375
10hp/600V/3ph	18376
15hp/220V or 460V/3ph	18377
15hp/600V/3ph	18378

BOLT TORQUE VALUES

Torque figures indicated above are valid for nongreased or non-oiled threads and heads unless otherwise specified. Therefore, do not grease or oil bolts or capscrews unless otherwise instructed in this manual. When using locking elements, increase torque values by 5%.

Bolt Diameter A	SAE Grade 2 N.m (ft-lbs)		SAE Grade 5 N.m (ft-lbs)		SAE Grade 8 N.m (ft-lbs)	
	N.m	(ft-lbs)	N.m	(ft-lbs)	N.m	(ft-lbs)
1/4	8	(6)	12	(9)	17	(12)
5/16	13	(10)	25	(19)	36	(27)
3/8	27	(20)	45	(33)	63	(45)
7/16	41	(30)	72	(53)	100	(75)
1/2	61	(45)	110	(80)	155	(115)
9/16	95	(70)	155	(115)	220	(165)
5/8	128	(95)	215	(160)	305	(220)
3/4	225	(165)	390	(290)	540	(400)
7/8	230	(170)	570	(420)	880	(650)
1	345	(225)	850	(630)	1320	(970)

GRADE MARKINGS CHART

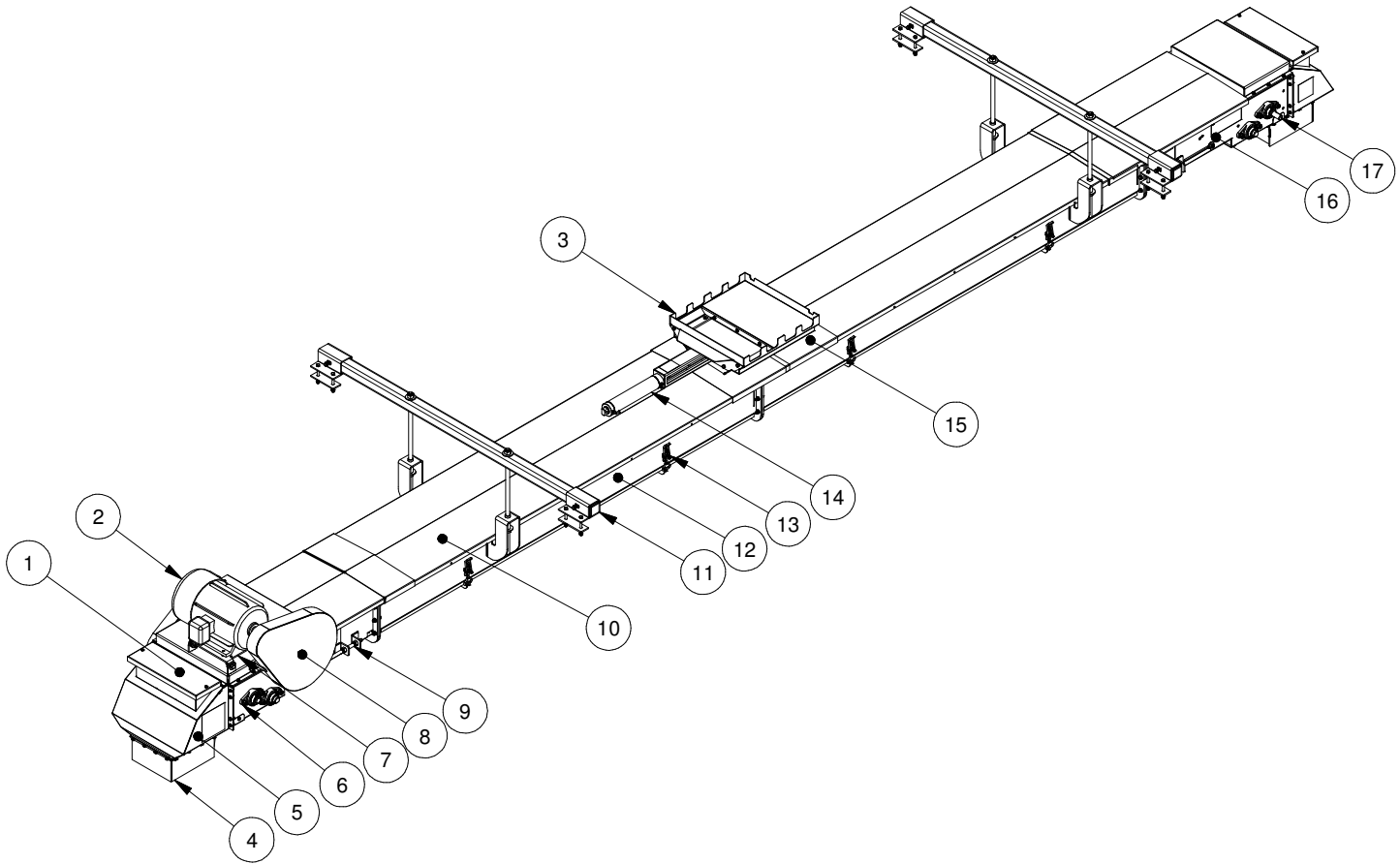
 No Marking	Grade 2 Low or Medium Carbon Steel
 3 Radial Lines	Grade 5 Medium Carbon Steel Quenched and Tempered
 6 Radial Lines	Grade 8 Medium Carbon Alloy Steel, Quenched and Tempered



WARNING

The torque value for bolts and capscrews are identified by their head markings. Replacing higher Grade bolts (Grade 8) with lower Grade bolts (Grade 5) will lead to conveyor failure and can result in injury or death. Always use replacement bolts with the same Grade markings as the removed bolt.

CONVEYOR SYSTEM NOMENCLATURE



ITEM	DESCRIPTION
1	Clean Out Cover and Hopper Attachment Point
2	Electric Motor
3	Airgate Assembly
4	Discharge Chute
5	Motor End of Conveyor
6	Drive Roller (inside housing)
7	Electric Motor Belt Tensioning Plate
8	Drive Pulleys and Belts
9	Belt Tension and Alignment Rods
10	Conveyor Top Cover
11	Conveyor Hanger
12	Conveyor Section
13	Quick Release Latch (to remove bottom cover)
14	Airgate Cylinder and Slide Gate
15	Airgate Section Top Cover
16	Non-Motor End of Conveyor
17	Conveyor Idler Roller

ASSEMBLY INSTRUCTIONS

INITIAL CONVEYOR ASSEMBLY

The Meridian Underbin Conveyor System is modular and requires assembly and attachment to the seed bin based on the needs of the seed site. A minimum number of tools are required to install the components. Be sure to check the conveyor before using the first time.

Complete the Final Check and Testing in this section to ensure all fasteners are tight and the conveyor is ready to use.

UNLOADING INSTRUCTIONS

The conveyor sections are shipped fully assembled. Make sure the lifting equipment will safely lift and hold the weight of the conveyor sections.

! WARNING

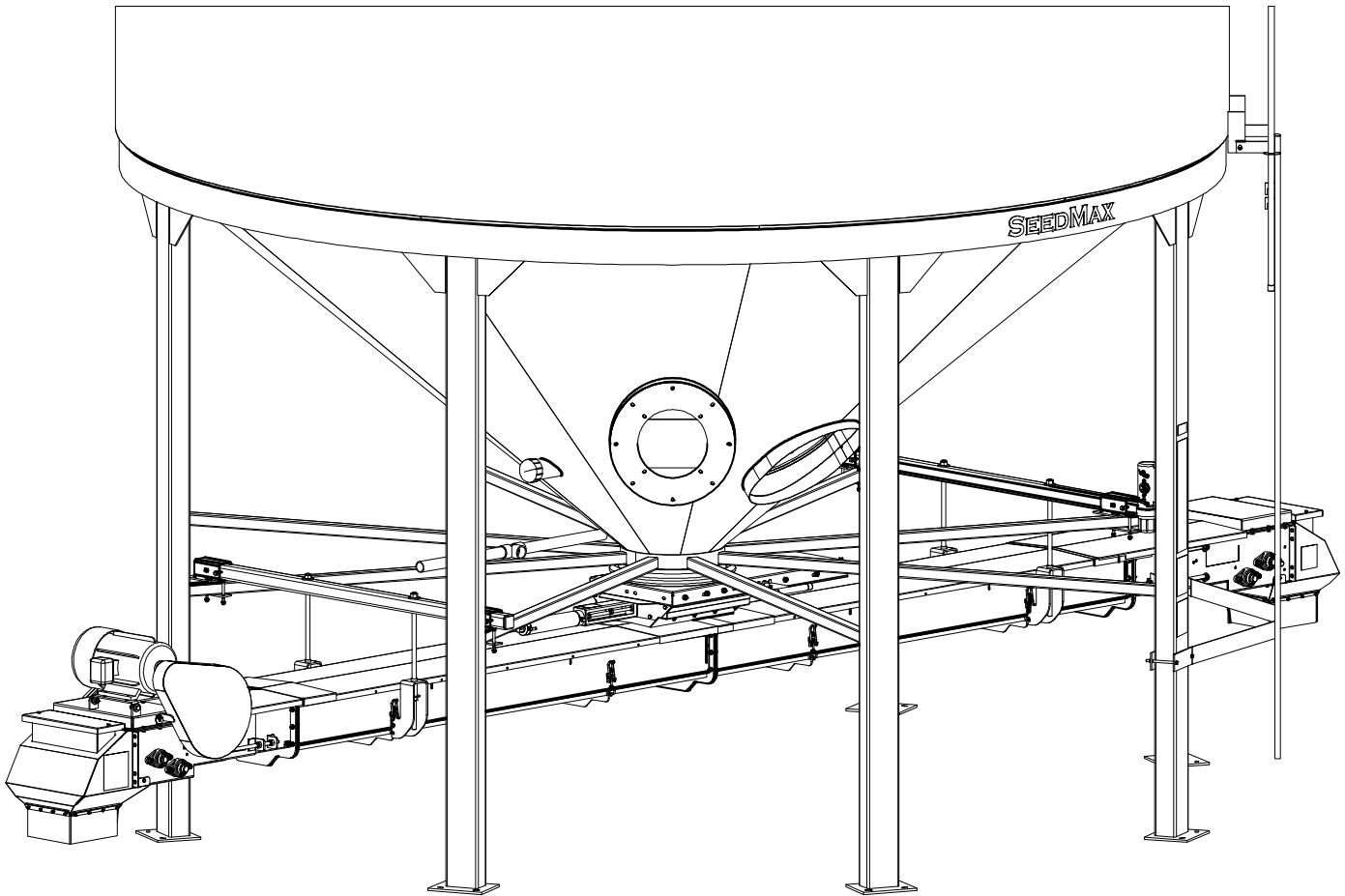


LIFTING HAZARD

Review the following chart to determine the weight of the load before making the lifts in the next procedures. Failure to have a properly rated lifting device can cause the load to fall, resulting in property and/or person injury, even death.

Conveyor System Component Weights	
Item	Weight
Conveyor Section, 30 cm (12")	16 kg (35 lbs)
Conveyor Section, 61 cm (24")	27 kg (59 lbs)
Conveyor Section, 91 cm (36") 40 kg (87 lbs)	40 kg (87 lbs)
Conveyor Section, 122 cm (48") 52 kg (115 lbs)	52 kg (115 lbs)
Conveyor Section, 221 cm (87") 91 kg (200 lbs)	91 kg (200 lbs)
Conveyor Section, 259 cm (102 ") 104 kg (230 lbs)	104 kg (230 lbs)
Motor End	135 kg (298 lbs)*
Non-Motor End	98 kg (215 lbs)
Airgate	98 kg (215 lbs)

ASSEMBLY INSTRUCTIONS



 **CAUTION**



LIFTING HAZARD

The conveyor sections typically weigh more than 50 lbs (23 kg) each. To prevent injury, use two people or a lifting device whenever moving these parts.

ASSEMBLY

1. Install the airgate assembly onto the bottom of the seed bin using four 3/8" self drilling, self tapping screws, as shown.

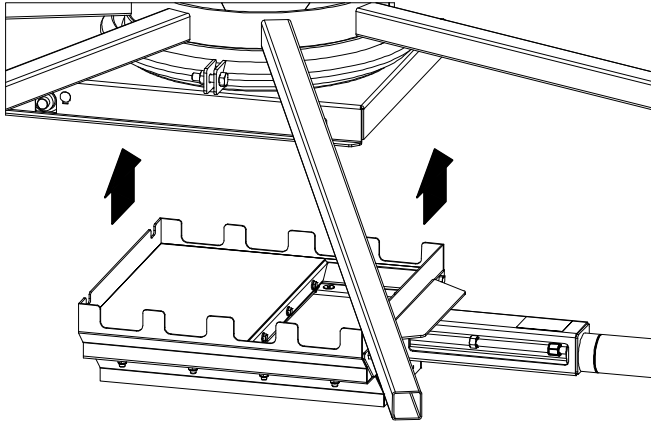


FIGURE 1

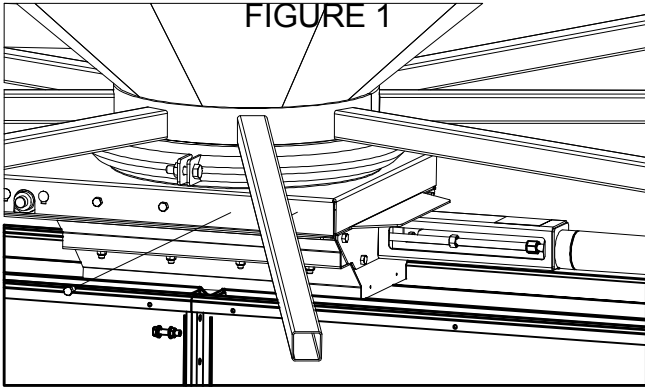


FIGURE 2

2. Connect the two sections of the pan assembly using the supplied hardware. Tighten the bolts to standard torque.

LIFTING HAZARD



The two combined conveyor sections weigh more than 400 lbs (180 kg). Use a lifting device whenever you are installing these parts.

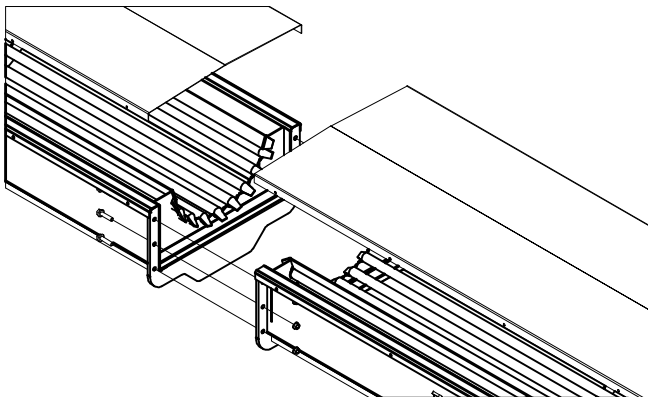


FIGURE 3

3. Set the two top covers onto the conveyor sections. Center the two top covers from the airgate assembly (part with rectangular hole) onto the conveyor sections, as shown.

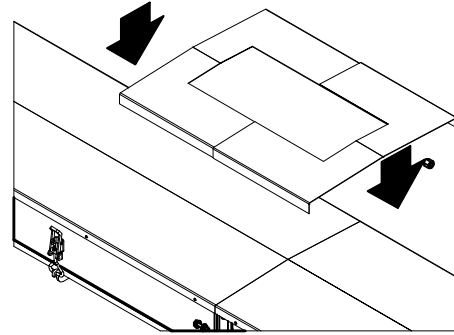


FIGURE 4

4. Using the airgate cover, trace the opening onto the two sections of the conveyor cover. Remove the airgate cover and cut out a slightly oversized opening in the conveyor covers.

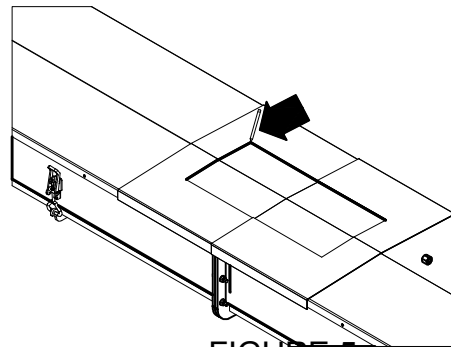


FIGURE 5

Note: The cut out in the conveyor covers can be 1 to 2 inches (25 to 50 mm) longer than the traced opening to accommodate aligning the sections with the airgate during final installation.

5. Install the top covers onto the conveyor sections using the supplied hardware. Then, install the airgate cover onto the conveyor sections, but do not bolt the cover in place at this time.

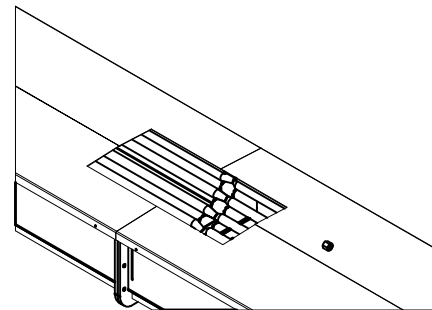


FIGURE 6

6. Loosely install the hanger bracket assemblies onto the spoked tubing of the seed bin. The cross brace should be located 12" (30 cm) from the vertical posts for a single seed bin or 16" (40 cm) for multiple seed bins, as shown.

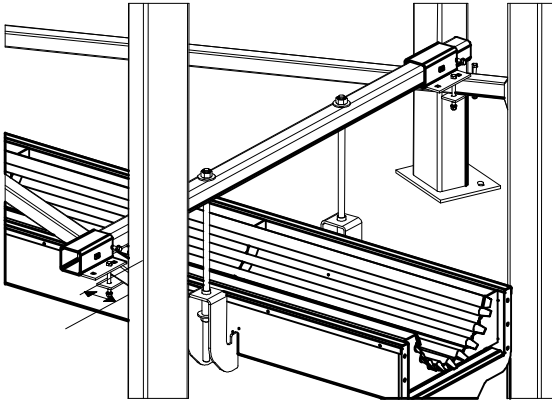


FIGURE 7

Note: As the conveyor sections are being assembled, a rope can be placed through each section in order to help install the conveyor belt once all the conveyor sections have been assembled.

7. Center the conveyor sections to align with the airgate and raise them vertically into position, hanging the assembly from the hanger brackets.

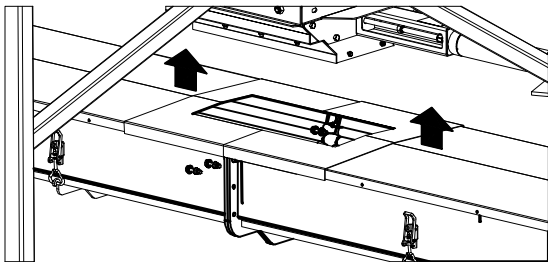


FIGURE 8

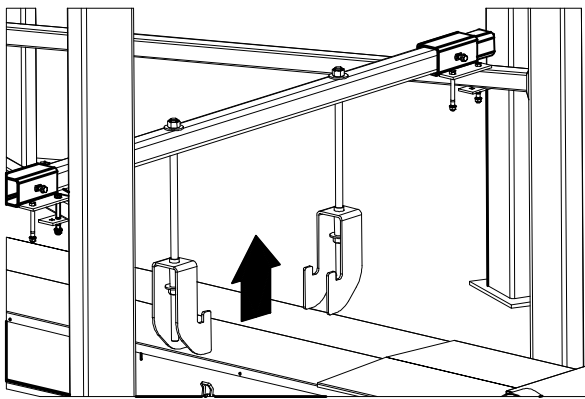


FIGURE 9

Note: When installing the conveyor system under multiple seed bins, connect and install two sections at a time, bolting the two larger sections together after they are supported from the hanger brackets.

8. Install motor end and non-motor end sections using the supplied hardware, as shown. Do not install the top covers at this time.

LIFTING HAZARD



The motor end conveyor section weighs more than 298 lbs (135 kg). The non-motor end conveyor section weighs 230 lbs (104 kg). Use a lifting device whenever installing these parts.

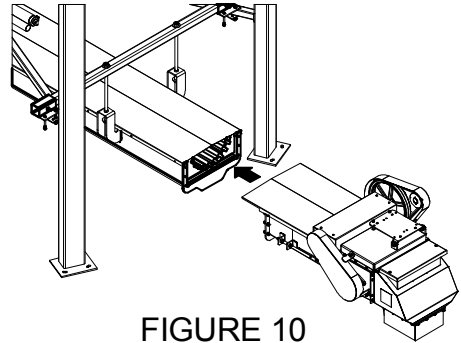


FIGURE 10

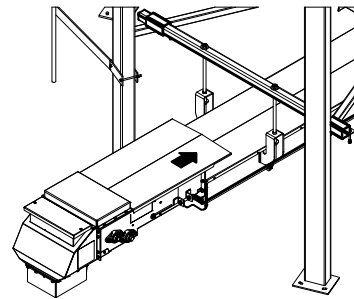


FIGURE 11

9. Install the small covers (between each section) to prevent water from entering the conveyor system.

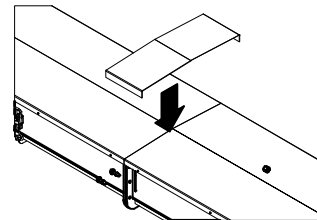


FIGURE 12

10. With the conveyor frame completely assembled and installed, install the conveyor belt.

- a. Use the rope or cable previously placed in the conveyor sections to feed the new belt into the conveyor.
- b. Align and connect the belt lace connector using the rubber coated cable. Lock the cable in place using two washers.
- c. Install the top covers on both ends.
- d. Final tensioning of the belt will be completed once the system is operational.

Note: Refer to the Conveyor Belt Replacement section in this manual for additional information.

NOTICE

The regulated air pressure for airgate cylinders should be between 90 and 110 psi (620 and 750 kPa). To prevent component damage, do not exceed the maximum recommended pressure. Use a pressure regulator, connected to the air supply, to prevent over-pressurization.

11. Install and attach air lines to the airgate cylinder(s).
The air lines for the airgate cylinder should be placed inside the metal or PVC tubing to protect them from damage.

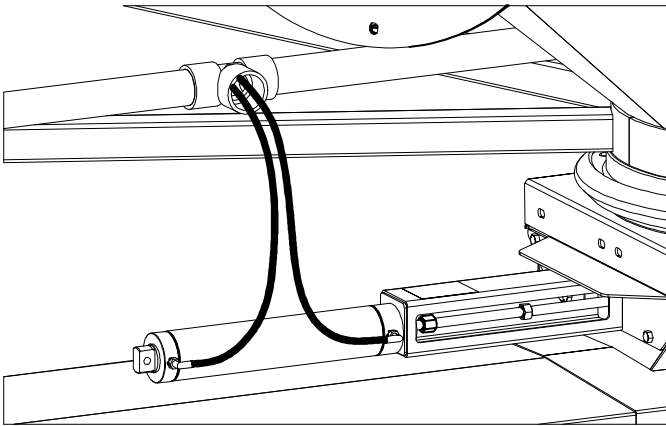


FIGURE 13

12. Install the appropriate electric motor onto the adjustable base plate.

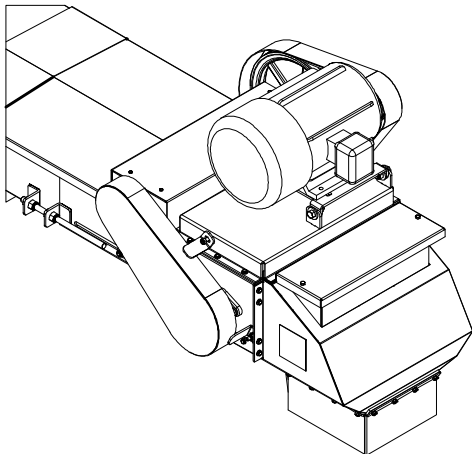


FIGURE 14

13. Install the four pulleys onto the drive shafts. Motor shaft part numbers: 27466/17840; Speed reduction shaft part numbers: 27444/27517 and 27466/27517; and, Drive roller shaft part numbers: 27425/17839. Loosely install the split bushings into the pulley and then onto the shaft.

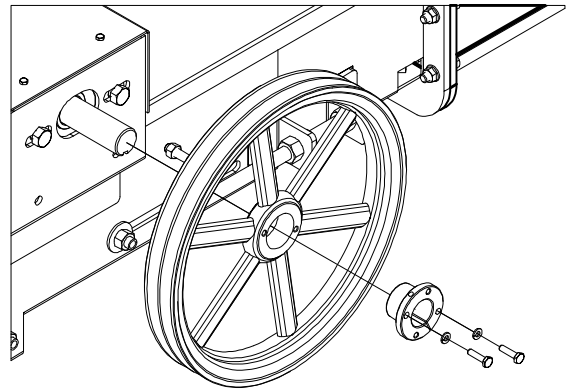


FIGURE 15

14. Align both sets of the pulleys using a straight edge. When properly aligned, a steel straight edge should contact all four points across the face of the two pulleys.

Note: Mount the pulley as close to the flange bearing as practical, but not closer than 1/8" to avoid excessive load on the bearings and shaft.

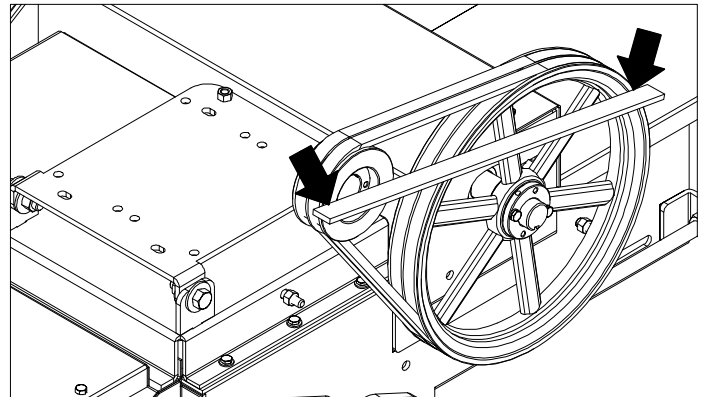


FIGURE 16

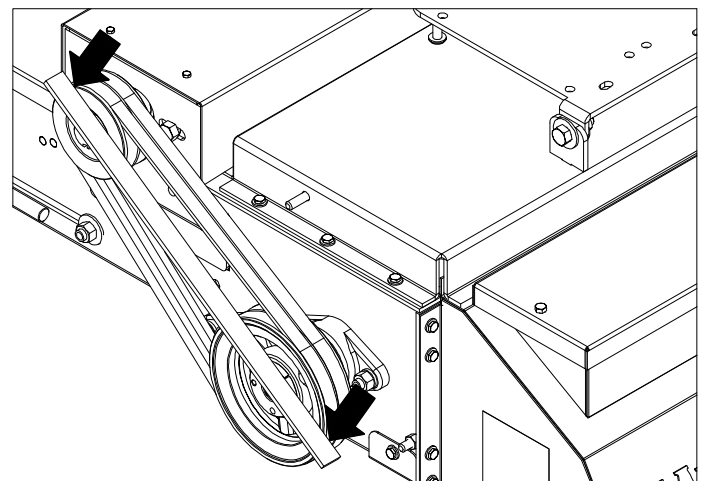


FIGURE 17

NOTICE

Misaligned pulleys will accelerate the wear of the belt sidewalls, which in turn will shorten both the belt and pulley life.

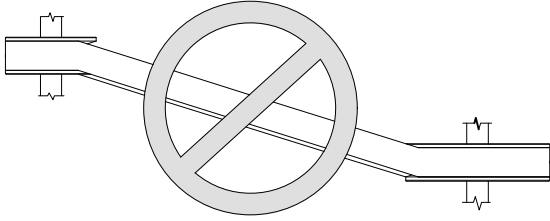


FIGURE 18

15. Install the drive motor v-belts.

NOTICE

Never pry or force a belt onto the pulley with a pry bar or by rotating the shaft as the belt is forced onto the pulley. This practice will almost certainly damage the tensile cord and although the damage may not be visible, the life of the belt will be drastically reduced.

16. Tighten the belts on the non-motor side first.

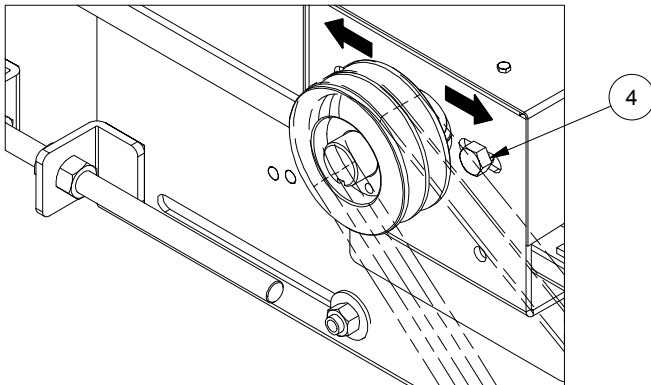


FIGURE 19

- a. Slightly loosen the two flange bearing bolts on the speed reducer shaft.
- b. Use hand pressure to push on the belts halfway between the pulleys. The amount of deflection should be approximately 1/4" (6 mm).

NOTICE

Do not overtighten the belts. Overtightening can reduce belt and bearing life.

- c. Tighten the two flange bolts.
- d. Position the flange bearing on the motor side so the shaft is parallel with the drive roller shaft. Tighten the flange bolts.

NOTICE

When adjusting belt tension, it is important that the two shafts remain parallel to each other. Abnormal wear on both the belt and pulley will occur if the alignment is not correct.

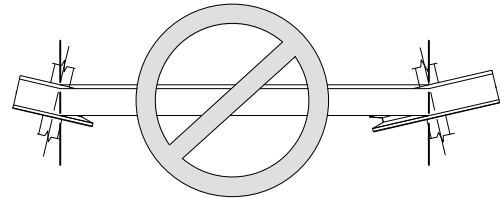


FIGURE 20

17. Adjust the belt tension on the motor side by adjusting the base plate. When properly tensioned, pushing on the belt with your finger should deflect the belt about 1/4" (6 mm).

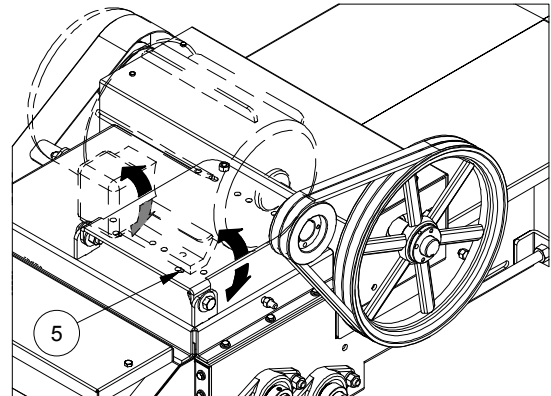


FIGURE 21

18. Recheck the alignment of the pulleys and shafts. Correct any misalignment before installing the covers.
19. Install all v-belt and shaft covers.
20. Connect power to the motor.
21. Briefly run the conveyor belt to check the tensions and the tracking of the conveyor belt.
22. Make a final inspection, making sure all hardware is properly tightened, the conveyor sections are level, and the hanger devices are properly positioned and attached to the seed bin.
23. Charge the air system and make sure all hose couplings and connections are securely tightened.

FINAL CHECK AND TESTING

All line items must be able to have the "Yes" column checked. If the line refers to an option that is not on the conveyor being tested, then "n/a" is to be placed on that line.

Item to Check	Yes	No
Top covers on all conveyor sections are in place.		
Small covers (between sections) are installed.		
Bottom covers on all conveyor sections are in place and securely latched.		
All drive motor belt covers/shields are in place.		
Conveyor belt tracks are in the center of the rollers.		
Conveyor belt tension is correct.		
Drive belt tension is correct.		
Electric drive motor functions properly.		
Conveyor belt operates in the correct direction.		
Airgate cylinders are operating properly.		
Touch up paint is applied where needed.		
Air pressure is set correctly.		
All safety signs are attached and legible.		
Apply grease to all drive motor and conveyor bearings.		

PRE-OPERATING INSTRUCTIONS

CONVEYOR BREAK-IN PERIOD

A special break-in procedure has been developed to ensure the integrity of the conveyor when first put into service. Follow the Before Starting instructions and then follow the Inspections for 1/2, 5, and 10 Hours instructions at the appropriate interval.

After completing these instructions, follow the normal service schedule in the Maintenance section.

INSPECTIONS FOR 1/2, 5, AND 10 HOURS

WARNING



Entanglement Hazard

To prevent serious injury or death, keep hands and clothing clear of moving parts.

1. Recheck the tension and alignment of the conveyor belt.
2. Recheck all fasteners. Tighten to their specified torque.
3. Recheck the tension of the drive motor belts.
4. Make sure the drive motor pulleys are still aligned.
5. Recheck all air line connections for leaks.

DAILY PRE-OPERATION CHECKLIST

Before operating the delivery system and each time thereafter, the following areas should be checked:

SAFETY INSTRUCTIONS







Make sure anyone operating the conveyor or working on or around the conveyor reads and understands all the operating, maintenance, and safety information in the operator's manual and other related OEM equipment manuals before using or towing the conveyor.

1. Start the conveyor and check the controls. Be sure they function properly.
2. Check hardware and fasteners. Tighten to their specified torque.
3. Visually inspect the conveyor belt and motor drive belts for damage. Replace if necessary.
4. Check the tension and alignment of the conveyor belt. Follow the instructions in the manual to correct the tension and/or alignment.
5. Ensure all safety guards are in place.

OPERATION

SAFETY

-  Never operate the conveyor until you have read and completely understand this manual, the engine's Operator Manual, and each of the Safety Messages found on the safety signs.
-  **PROLONGED EXPOSURE TO LOUD NOISE MAY CAUSE PERMANENT HEARING LOSS!** Motors or equipment can be noisy enough to cause permanent or partial hearing loss. We recommend that you wear hearing protection on a full-time basis if the noise in the operator's position exceeds 80 dB. NOTE: Hearing loss from loud noise (tractors, chain saws, radios, and other such sources close to the ear) is cumulative over a lifetime with uncertain natural recovery.
- Operate only in daylight or in good artificial light.
- Be sure the conveyor is properly positioned, adjusted, and in good operating condition.
-  Ensure all guards, shielding, and safety signs are properly installed and in good condition.
-  Before starting, visually inspect the conveyor for loose bolts, worn parts, cracks, leaks, or frayed belts. Make necessary repairs and always follow maintenance instructions.

OPERATION

The operation of the conveyor system is controlled by user supplied controls. Always follow the instructions provided by the installer of the controls.

SAFETY INSTRUCTIONS

Ensure all workers in the area of the conveyor have been instructed on how to stop the conveyor in case of emergency.

END-OF-SEASON STORAGE

GENERAL INFORMATION

After winter, or when the conveyor will not be used for a prolonged period of time, completely inspect all major systems of the conveyor. Replace or repair any worn or damaged components to prevent unnecessary downtime during the next use.

PLACING IN STORAGE

1. Remove all seed from the conveyor sections.
2. Thoroughly wash the conveyor to remove all dirt and debris.
3. Check the condition of the conveyor belts, drive motor belts, and delivery chutes. Replace or adjust, as required.
4. Touch up paint nicks and scratches to prevent rusting.
5. Cover openings with a waterproof tarp and tie down securely.
























REMOVING FROM STORAGE



When removing the conveyor from storage, follow this procedure:

1. Remove the tarp, if covered.
2. Review and follow the Pre-Operation Checklist.
3. Review and follow the Service Checks in the Maintenance section.





SAFETY

GENERAL SAFETY

1.  Understand the service procedure before performing the work. Good maintenance is your responsibility. Poor maintenance is an invitation for trouble.
2.  Be sure electrical outlets and tools are properly grounded.
3. Maintenance and repair work must only be carried out by authorized, qualified personnel.
4.  Always use personal protection devices, such as eye, hand, and hearing protectors, when performing any service or maintenance.
5.  Always wear protective goggles when exhausting air from the air system.
6.  Keep hands, feet, clothing, jewelry, and long hair away from any moving parts to prevent them from getting caught.
7.  Never work under the conveyor unless it is securely attached to the seed bin.
8.  Do not leave tools lying on the conveyor. Keep area clean and dry.
9.  Do not modify conveyor or safety devices. Do not weld on the conveyor. Unauthorized modifications may impair its function and safety.
-  If the conveyor has been altered in any way from the original design, the manufacturer does not accept any liability for injury or warranty.
10.  Periodically tighten all hardware to ensure the conveyor is in safe working condition.
11.  Keep all parts in good operating condition and properly installed. Fix damage immediately. Replace worn or broken parts.
12.  Where replacement parts are necessary for periodic maintenance and servicing, genuine factory replacement parts must be used to restore your conveyor to the original specifications. The manufacturer will not be responsible for injuries or damages caused by use of unapproved parts and/or accessories.
13.  Never replace hex bolts with less than Grade 5 bolts unless otherwise specified.
14.  Before servicing the conveyor or other mating components, disable the conveyor by disconnecting power at the electrical control box.
15.   Once the power is OFF, lock-out or tag-out the electrical control box to prevent unintentional starting of the conveyor.
16.  To prevent electrical shock, never touch electrical wires or components while the conveyor is operating.
17.  Never perform repair or maintenance work with the conveyor running unless expressly instructed to do so.
18.  Before servicing any component in the airgate system or disconnecting any air line, close the main valve on the compressed-air system and vent the compressed-air line(s). Shut off power to the compressor and place a lock or tag on the electrical box.
19.  Before starting maintenance or repair work, relieve air pressure in all compressed air lines.
20.  Take care to avoid damaging compressed air lines during repair or maintenance work.
21.   A fire extinguisher and first aid kit should be readily accessible while performing maintenance on this conveyor.

22.  When completing a maintenance or service function, make sure all safety shields and devices are installed before placing the conveyor in service.
23.  Replace all worn or damaged safety and instruction decals.

LOCK-OUT OR TAG-OUT SAFETY

1.   Establish a formal Lock-Out or Tag-Out program for your operation.
2.  Train all operators and service personnel before allowing them to work around the seed delivery system.
3.  Provide tags on the conveyor and a sign-up sheet to record tag-out details.

MAINTENANCE

DAILY (8 HOURS)

1. Visually check the drive motor belts and conveyor belt for wear or damage.

WEEKLY (50 HOURS)

1. Check the tracking and tension on the conveyor belt. Adjust tension as needed.
2. Check the tension on the drive motor belts. Adjust tension as needed.

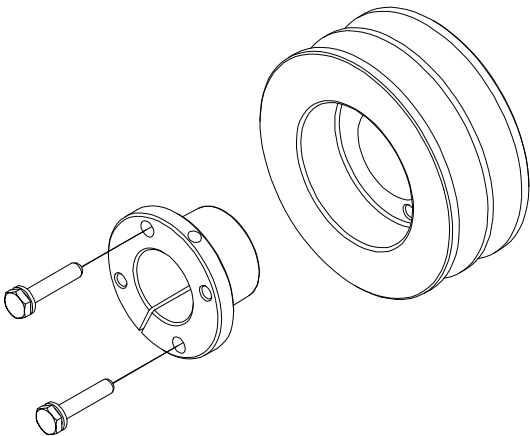
ANNUALLY (400 HOURS)

1. Check the conveyor sections and hanger tube for cracks and damage.
2. Thoroughly clean the entire conveyor.
3. Check the conveyor belt for wear or damage. Replace as needed.

KEYLESS BUSHINGS

The underbin conveyor uses keyless bushings in all drive motor pulleys. The keyless bushings use the tapered wedge principle to retain the pulley onto the shaft.

INSTALLATION AND REMOVAL TIPS



1. When a pulley fails to stay tight and true on the shaft, improper installation may be the cause. When installing a pulley, first clean oil, paint, and dirt from all tapered and mating surfaces of the pulley, bushing, and shaft.
2. Do not lubricate these components. Lubricating the mating tapered surfaces reduces friction. With lubricated surfaces and the same screw torque, the tapered surface mechanical advantage is greatly increased compared to dry surfaces. This causes excessive radial pressure, resulting in cracking of bushing or pulley hub.
3. Adhere to the manufacturer's recommended torque values for tightening installation screws. Tighten the screws in an alternating pattern, repeating the pattern several times to obtain the desired wrench torque.
4. When installing bushings avoid using a worn wrench, which can strip the screw head and cause a loose assembly. For increased gripping force, tap the face of the bushing with a drift pin or sleeve, then retighten the screws to the recommended torque setting. Do not strike the bushing directly with the hammer.
5. Excessive screw torque can damage bushings or pulleys. Also, uneven pressure on jack-apart screws may ruin the bushing, making removal difficult without damaging the pulley.

6. Pulleys mounted with tapered bushings rarely lose their tight fit, but overload or improper installation can cause them to loosen. During inspection or maintenance, check for these conditions that cause looseness:

- Cracked pulley hub.
- Other damage to pulley, shaft, bushing, or mounting screws.
- Improper mating of tapers.
- Missing keys, particularly on vertical shafts, and on horizontal shafts subject to vibration.
- Lubricant that leaks from components such as chain, gear, or grid couplings.
- Bushing bored to the wrong diameter.

PULLEY INSTALLATION AND REMOVAL

INSTALLATION

1. Make sure the pulley bore and the tapered cone surface of the bushing are clean and free from paint, dirt, and lubricants.

NOTICE

Do not use lubricants to install bushing assemblies.

2. Loosely assemble the bushing in the pulley, and insert the screws finger tight.
3. Slip the loosely assembled unit onto the shaft and position it for proper belt alignment.
4. Alternately tighten the screws to half the recommended torque value. Check the alignment of the two pulleys and correct as necessary.
5. Continue to tighten the screws alternately to the proper torque value.

Note: Allow an 1/8" to 1/4" gap between the pulley and flange bushing.

REMOVAL

1. Loosen and remove all mounting screws.
2. Insert two screws in the tapped removal holes in the pulley.
3. Begin tightening the screw opposite the bushing saw slot and alternately tighten the two screws until the bushing releases from the pulley.
4. Remove the pulley from the bushing.
5. Remove the bushing from the shaft. If the bushing is wedged onto the shaft, open the saw slot with a screwdriver or other similar prying device.

NOTICE

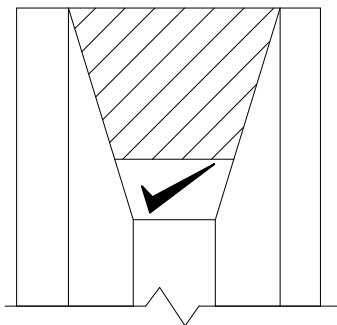
Be careful not to damage the bushing or the shaft during removal. The use of penetrating oil can also be used to free the bushing from the shaft. If penetrating oil is used, make sure the shaft is completely oil free before installing a new pulley.

REPLACEMENT BELT RECOMMENDATIONS

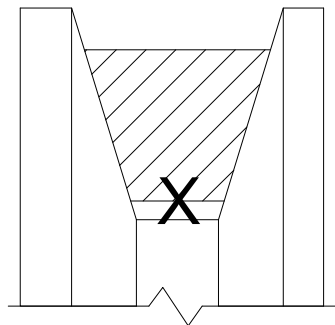
1. Do not mix used and new belts. Always replace both belts at the same time.

NOTICE

Used belts will ride lower in the pulley groove due to sidewall wear and normal belt stretch. New belts will ride higher in the pulley, travel faster, and operate at higher tension. Running used and new belts together will overload and damage the new belts.



Belt should ride at top of groove



Low riding belt indicates worn groove

2. Don't mix belts from different manufacturers. Use OEM belts only.
3. Use matched belt sets. A matched set of belts is necessary to ensure equal distribution of the load.

TENSIONING BELTS

The key to long, efficient, trouble-free belt operation is proper tension. If belts are too loose, the result is slippage, rapid belt and pulley wear, and loss of productivity. However, too much tension puts excess strain on belts, bearings, and shafts, and causes premature wear of these components.

Note: The proper tension for a V-belt is the least amount of tension at which the belt will not slip or squeal under a peak load. Never use belt dressing to stop belts from slipping. Tighten the belts and/or replace worn pulleys.

1. Tighten the belts until they are fairly taut.

Note: When installing new belts, the "initial tension" of the belts will lessen as they stretch during this run-in period.

2. Run the conveyor for about 15 minutes to seat the belts.
3. Use hand pressure to moderately push on the belts halfway between the pulleys. The amount of deflection should be approximately 1/4" (6 mm).
4. Tighten or loosen the belt as necessary.
5. Inspect the belts after 24 to 48 hours of operation.
6. Recheck the belt tension and correct as needed.

WELDING REPAIRS



Repair welding must be done with care and with procedures that may be beyond the capabilities of the ordinary welder. Before performing any type of welding repair to the conveyor, contact Meridian for approval.



WARNING



Personal Injury Hazard Repairs or modifications to the underbin conveyor components can result in serious injury or death should these repairs fail.

IMPORTANT NOTICE

Anyone performing a welding repair should be certified in accordance to the American Welding Society (AWS) standards.

CONVEYOR BELT REPLACEMENT

! WARNING



To prevent serious injury from rotating parts, shut off the power to the conveyor before removing any guards or covers. Lock-out and/or tag-out the electrical control box to prevent unintentional starting of the conveyor.

1. Turn off the power to the unit. Remove top covers (1) from both motor end and non-motor end to access the drive rollers.

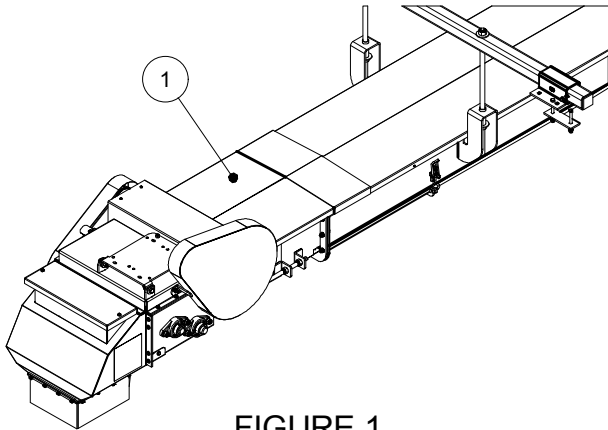


FIGURE 1

2. Loosen belt tension (2) adjusting bolts (both sides and both ends) to release tension on the belt.

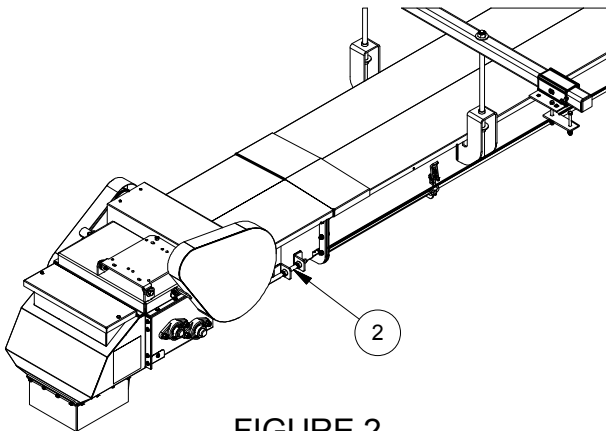


FIGURE 2

3. Install a new belt.

- a. If the belt is not broken, carefully pull (rotate) the belt until the splice connector is visible. Remove the cable splice and attach the new belt to the old one at the splice. Pull the new conveyor belt into place.

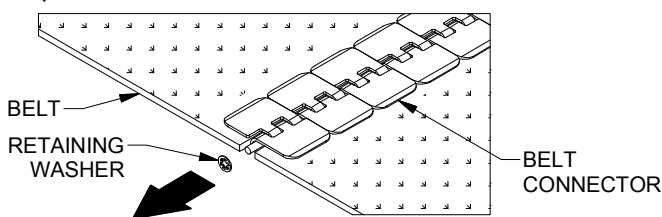


FIGURE 3

- b. If the belt is broken or missing, place a small rod through the belt connector. Attach a wire or rope to the outside of the rod ends, as shown.

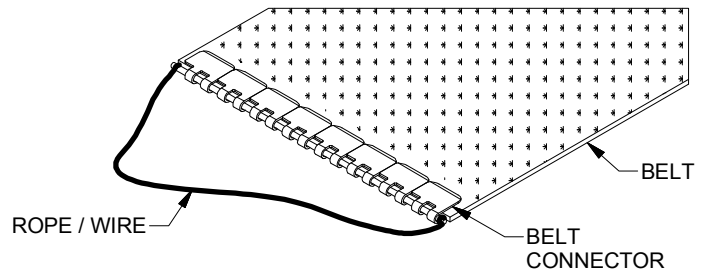


FIGURE 4

- c. Pull the new conveyor belt into place.

4. Align new belt splice and install new plastic covered splice cable and retaining washers (1).

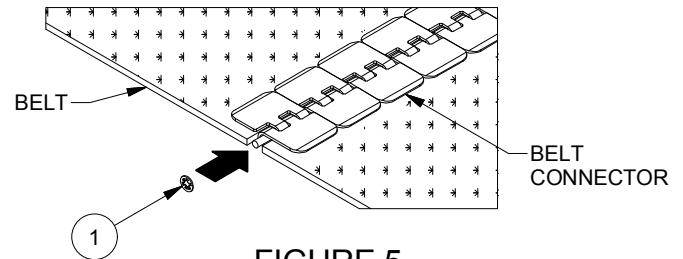


FIGURE 5

Note: A long Allen wrench or small rod can be inserted to help align the loops while pushing the cable in from the opposite side.

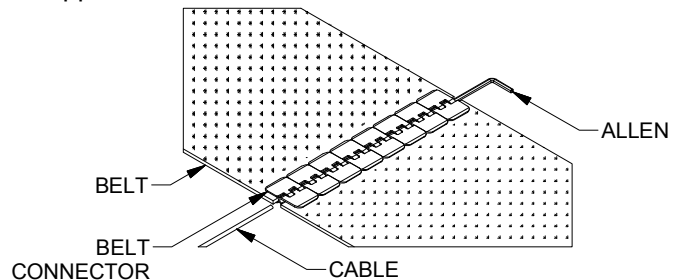


FIGURE 6

5. Initially, adjust the belt tension using adjusting bolts (2) on each end. The final tension will be set with the conveyor operating.
6. Reinstall the top covers with the appropriate removed hardware.
7. Remove the lock-out and/or tag-outs from the power supply.
8. If the old belt is broken or missing, thread a cable or rope through the system and attach it to the splice connector.

CONVEYOR BELT TENSION ADJUSTMENT

Belt tensioners are located on each side of the end section and on both end sections.

1. Loosen lock nuts (1) on each side of the belt tension mechanism.
2. Use lock nuts (2) to adjust the tension on the conveyor belt.
3. While holding adjusting bolt (3) in place, retighten both locking nuts (2).
4. Start the conveyor and make sure the belt is tracking in the center of the drive drum. If the belt is not tracking properly, use the Belt Tracking Adjustment procedure to correct the problem.
5. Increase the tension on the belt until there is no slippage.

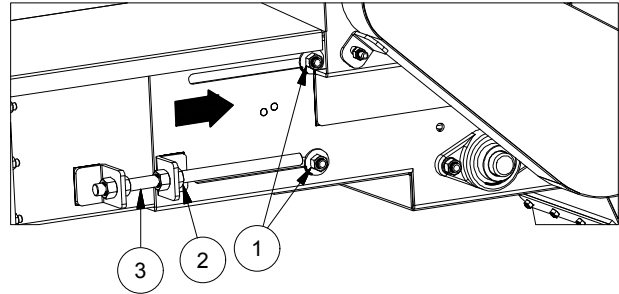


FIGURE 1

IMPORTANT

The drive drum of the motor end conveyor section must be square (drive shaft must be equal distance from end of unit) for the belt to track properly.

CONVEYOR BELT TRACKING ADJUSTMENT

WARNING



Entanglement Hazard

Checking belt tracking requires watching the belt while it's operating. Do not place your hand or arm inside the access hole for any reason. Entanglement with moving parts will result in serious injury or death.

1. Open the access cover (1) on both ends.
2. Start the conveyor belt.
3. Pushing the end of the conveyor outward will cause the belt to track to the opposite side of the tube.
4. The belt should track in the middle of the rollers. If it does not, adjust the tracking by loosening jam nuts (3).
5. Tighten or loosen lock nuts (2) to change the tracking.
6. Once the belt is tracking in the center of the rollers, tighten the jam nuts (3).
7. Recheck the belt tension.
8. Reinstall two access covers (1).
9. If removed, reinstall the discharge hood.

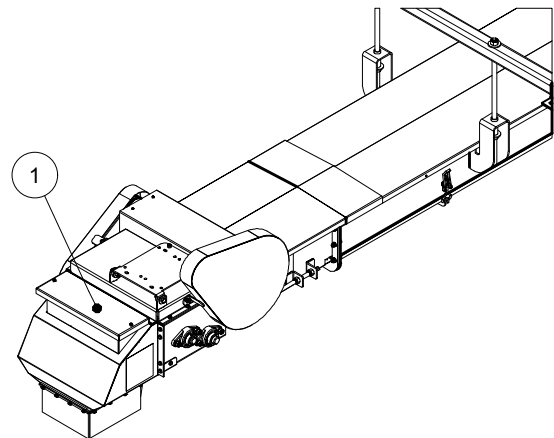


FIGURE 1

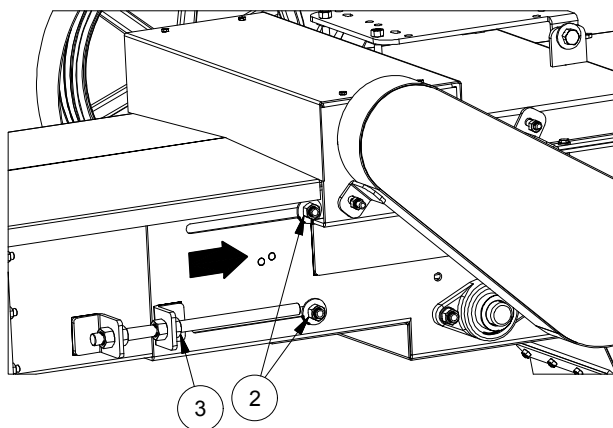


FIGURE 2

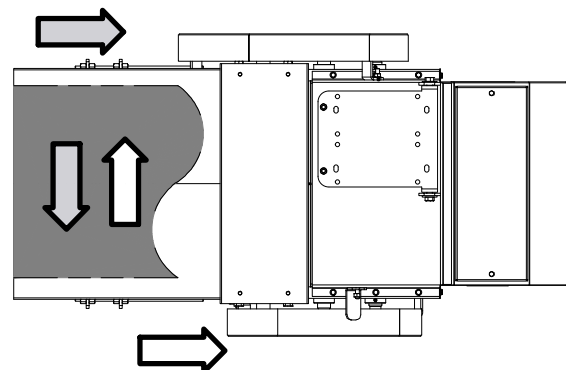


FIGURE 3

DRIVE MOTOR BELT TENSION ADJUSTMENT

1. Remove cover (3).
2. Tighten belts (2) on the non-motor side first.
3. Slightly loosen two flange bearing bolts (3) on the speed reducer shaft.
4. Place a pry bar under the speed reducer shaft and move the shaft to place tension on the drive belts.
5. Use hand pressure to push on the belts halfway between the pulleys. The amount of deflection should be approximately 1/4" (6 mm).

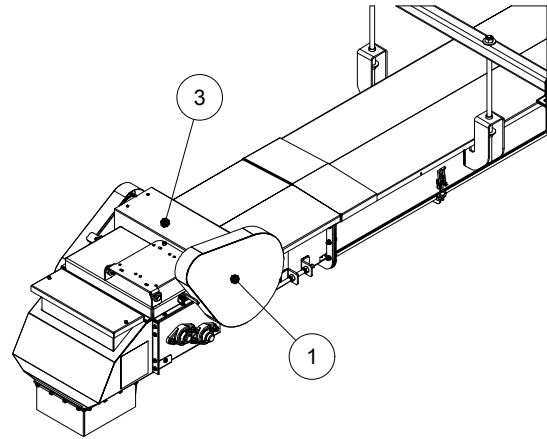


FIGURE 1

NOTICE

Do not overtighten the belts. Overtightening can reduce belt and bearing life.

6. Tighten two flange bolts (4).
7. Position the flange bearing on the motor side so the shaft is parallel with the drive roller shaft. Tighten the flange bolts.
8. Adjust the belt tension on the motor side by adjusting base plate (5). When properly tensioned, pushing on the belt with your finger should deflect the belt about 1/4" (6 mm).
9. When correctly adjusted, tighten the jam nuts.

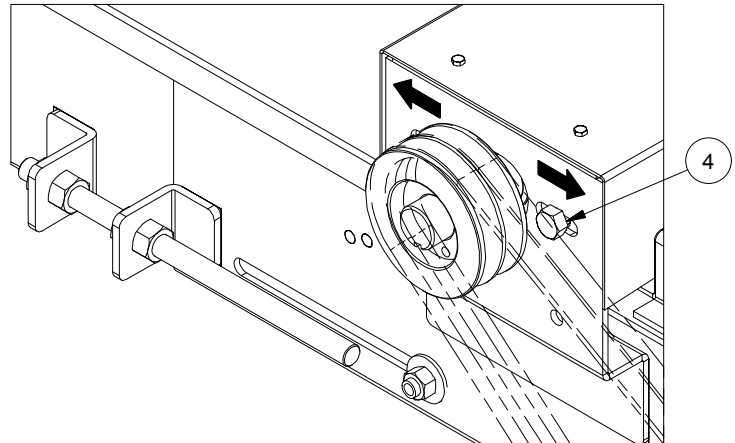


FIGURE 2

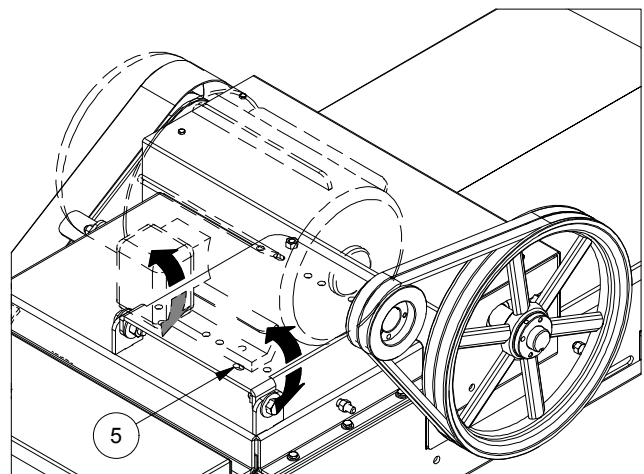


FIGURE 3

DRIVE MOTOR BELT REPLACEMENT

! WARNING



OEM Replacement Parts Only

Using parts from other manufacturers can result in failure of that part, causing equipment damage and possible serious injury or death.

There are two sets of matched V-belts used to drive the conveyor belt drive roller.

A speed reduction shaft and pulley provides the proper speed to move the seed and also provides the torque needed to drive the conveyor belt while not overloading the electric motor.

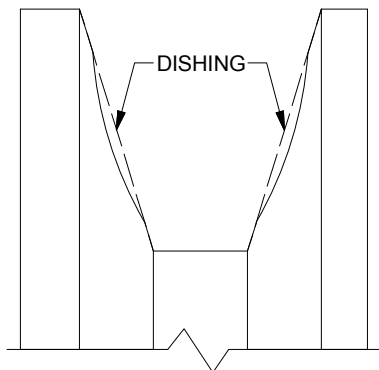
To replace the belts:

1. Remove the belt covers.
2. Loosen the belt tension by lowering the motor mounting plate and/or loosening the flange bolts on the speed reduction shaft. This way, the old belts can be removed easily and the new belts can be installed without damage.
3. Replace the belts.
4. Re-tension the belt using the Drive Motor Belt Tension Adjustment procedure.

Note: These belts must be replaced as a matched set or the service life of the belts will be dramatically reduced.

INSPECT AND SERVICE DRIVE COMPONENTS

1. Remove rust and dirt from hinge area of motor mounting plate and lubricate as necessary.
2. Inspect and replace, as needed, damaged components such as bearings and drive shafts.
3. Inspect and clean pulleys; replace worn or damaged pulleys.
4. Check pulley grooves for nicks or burrs. Correct any damage or replace the pulley.
5. Inspect for worn pulley grooves.
 - a. Belts should ride in pulley grooves so the top of the belt is just above the highest point of the pulleys. If the grooves are worn, the belts will slip and burn.
 - b. If grooves are “dished out” 1/32” or more, replace the pulleys. If the groove walls are “dished out,” the bottom corners of the belt will quickly wear off and cause rapid failure.



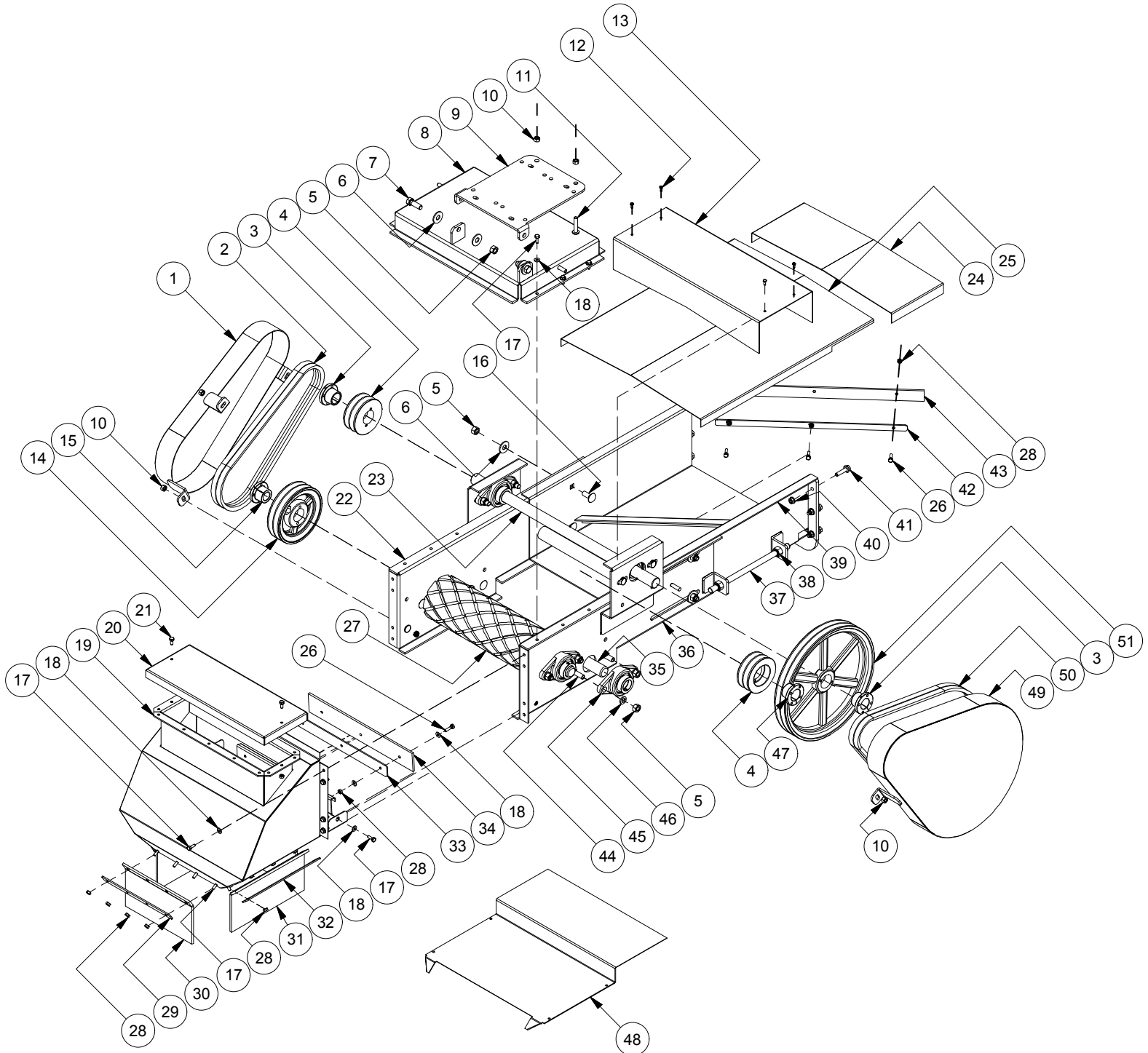
Dishing of groove sidewalls
shortens belt life

TROUBLESHOOTING

TROUBLESHOOTING CHART

PROBLEM	CAUSE	SOLUTION
Conveyor System		
Conveyor belt will not start.	No electrical power.	Connect electric motor to proper power supply.
	Drive motor belts are slipping.	Adjust drive belt tension.
	Drive motor belts are broken.	Replace belts with a matched set of belts.
	Speed reducer to drive roller belts are slipping.	Adjust belt tension.
	Speed reducer to drive roller belts are broken.	Replace belts with a matched set of belts.
	Drive roller slipping on conveyor belt.	Increase conveyor belt tension.
	Drive motor is defective.	Check electrical supply to motor. If supply is correct, then repair or replace motor.
Conveyor Belt		
Conveyor belt rubbing side of conveyor tube.	The belt is not properly aligned.	See Conveyor Belt Tracking Adjustment in this manual.
Drive Belts		
Rapid drive belt failure with no visible reason.	Worn pulley grooves (check with groove gauge).	Replace pulleys.
	Tensile cords were damaged through improper installation.	Replace all belts with a new set, properly installed.
	Wrong type or cross section belt.	Use only OEM replacement parts. Replace all belts with correct type.
Rapid sidewall damage to the drive belts.	Worn or damaged pulleys.	Replace pulleys.
Spin burns on the drive belts.	Belts may be slipping under a starting or stalling load.	Re-tension drive pulleys.
Belts stretch unequally.	Misaligned drive shafts.	Realign drive shafts.
Belt noise.	Belt is slipping.	Re-tension belts.
	Misaligned pulleys.	Realign pulleys.
	Wrong belt type.	Use only OEM replacement parts. Replace all belts with
Drive Pulleys		
Pulley fails to stay tight on shaft.	Improper installation.	Remove oil, paint, and dirt from all tapered and mating surfaces of the pulley, bushing, and shaft. Do NOT lubricate these components.
		Tighten the screws in an alternating pattern repeating several times to obtain the desired torque value.
		Avoid using worn tools, which can round bolt heads and cause a loose assembly.
	Bolts are improperly tightened.	Lightly tap the face of the bushing with a drift pin or sleeve, then retighten the bolt to the recommended torque value. Do not strike the bushing directly with a hammer.
	Bushing is improperly seated (lack of gripping force).	Make sure belts are properly tensioned.
	Overload or improper tightening.	Replace the damaged parts with OEM replacements.
Pulleys are hard to remove.	Cracked pulley hub or other damage to pulley, shaft, bushing, or mounting hardware.	Do not overtighten the bushing retaining screws.
	Excessive torque on the bolts can damage the bushings or pulley.	Tighten the screws even and progressively as the pulley is removed from the bushing.
	Uneven pressure on jack-apart screws.	

UNDERBIN MOTOR END

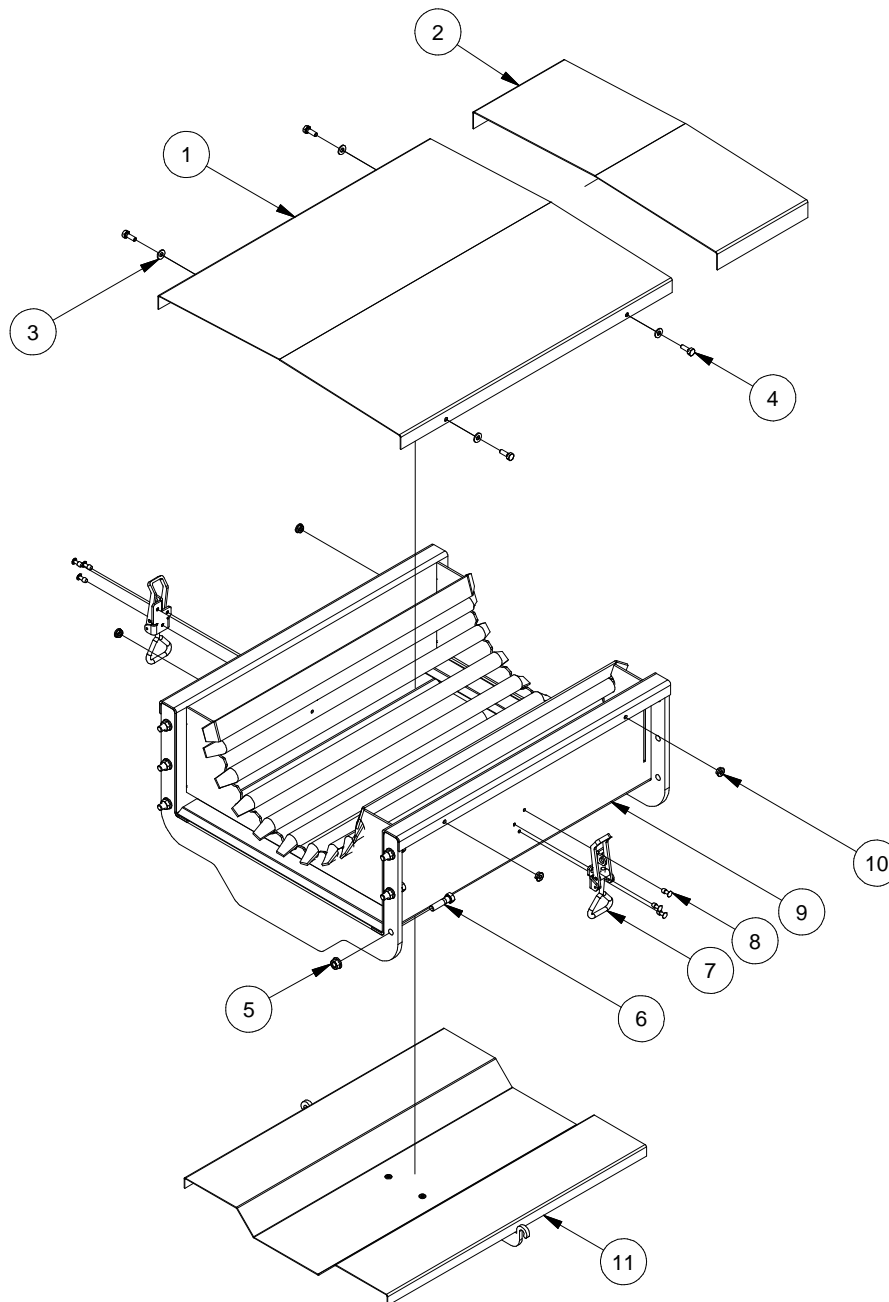


PARTS

UNDERBIN MOTOR END

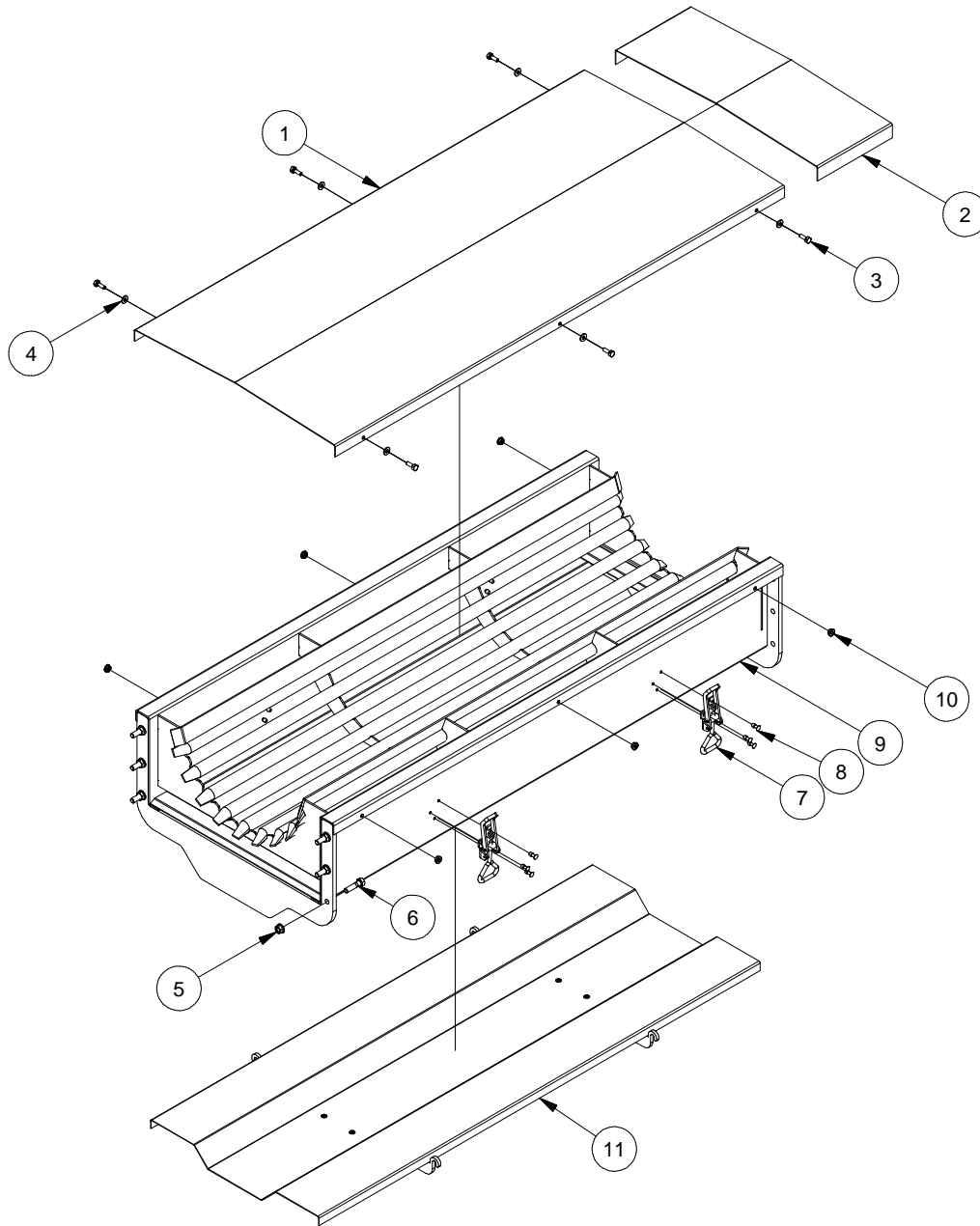
REF #	PART #	QUANTITY	DESCRIPTION
1	37538	1	Cover Small V-Belt
2	18365	2	Underbin Conveyor Belt V B42
3	27517	2	Bushing Split Taper H114
4	27466	2	Pulley 4.25 in Double
5	13-0725-00008	18	Hex Nut 1/2 PL
6	13-0736-00008	8	Washer Wide 1/2 in Type A
7	13-0702-08024	6	Hex Cap Screw 1/2-13 UNC x 1 1/2
8	37546	1	Motor Mount Weldment
9	37536	1	Mount Swivel Electric Motor
10	13-0725-00006	7	Hex Nut 3/8 PL
11	18483	2	Cross Recessed Pan Head Machine Screw 3/8-16 UNC x 2in
12	13-0707-10008	4	Screw Self Drill 10-16 UNC x 1/2
13	27422	1	Cover Galvanized Shaft Reducer
14	27425	1	Pulley 2V 7 in 2BK70H
15	17839	1	Bushing Tapered Pulley Insert
16	13-0709-08020	4	Carriage Bolt 1/2-13 UNC x 1 1/4
17	13-0702-04012	32	Hex Capscrew 1/4-20 UNC x 3/4
18	13-0736-00004	31	Washer narrow 1/4 in Type A
19	37547	1	Discharge Under Bin Red
20	27357	1	Plate Discharge Access Cover
21	13-0702-04010	2	Hex Capscrew 1/4-20 UNC x 5/8
22	37545	1	Side Plate Left Motor End
23	27844	1	Speed Reducer Shaft
24	27423	1	Cover Top Transition Galvanized
25	27421	1	Cover Top Motor End Galvanized
26	13-0702-04016	6	Hex Capscrew 1/4-20 UNC x 1
27	27361	1	Under bin drive roller
28	13-0725-00004	38	Hex Nut 1/4-20 UNC
29	27449	2	Bracket Hold Down Chute Red
30	17978	2	Rubber Flap Front Back Under Bin
31	17977	2	Rubber Flap Sides Under Bin Discharge
32	27378	2	Plate Skirt Retainer Red
33	27447	1	Bracket Hold Down Roller
34	27366	1	Scapper Brush Roller Rubber
35	27435	1	Roller Metal Under Bin
36	37544	1	Side Plate Right Motor End Red
37	27427	2	Threaded Rod Tension Belt
38	13-0725-00010	8	Hex Nut 5/8-11 UNC
39	37543	1	Frame Slider Bolt-on Discharge Red
40	13-0731-00006	6	Flanged Nut 3/8-16 UNC
41	13-0702-06024	6	Capscrew 3/8-16 UNC x 1 1/2
42	27446	1	Bracket Hold Down Scrapper
43	27365	1	Scrapper Rubber Under Bin
44	13-0709-08016	8	Carriage Bolt 1/2-13x1 Gr5
45	27441	6	Bearing Flange Two Bolt
46	13-0734-00008	8	Washer Helical Spring Lock 1/2 in
47	17843	1	Bushing 1 3/8in Tapered H-1 3/8 Pulley Insert
48	27416	1	Cover Bottom Discharge
49	37539	1	Cover Large V-Belt Red
50	18364	2	Belt V B53 Under Bin
51	27444	1	Pulley 2V 14in 2BK140H

24" CONVEYOR SECTION



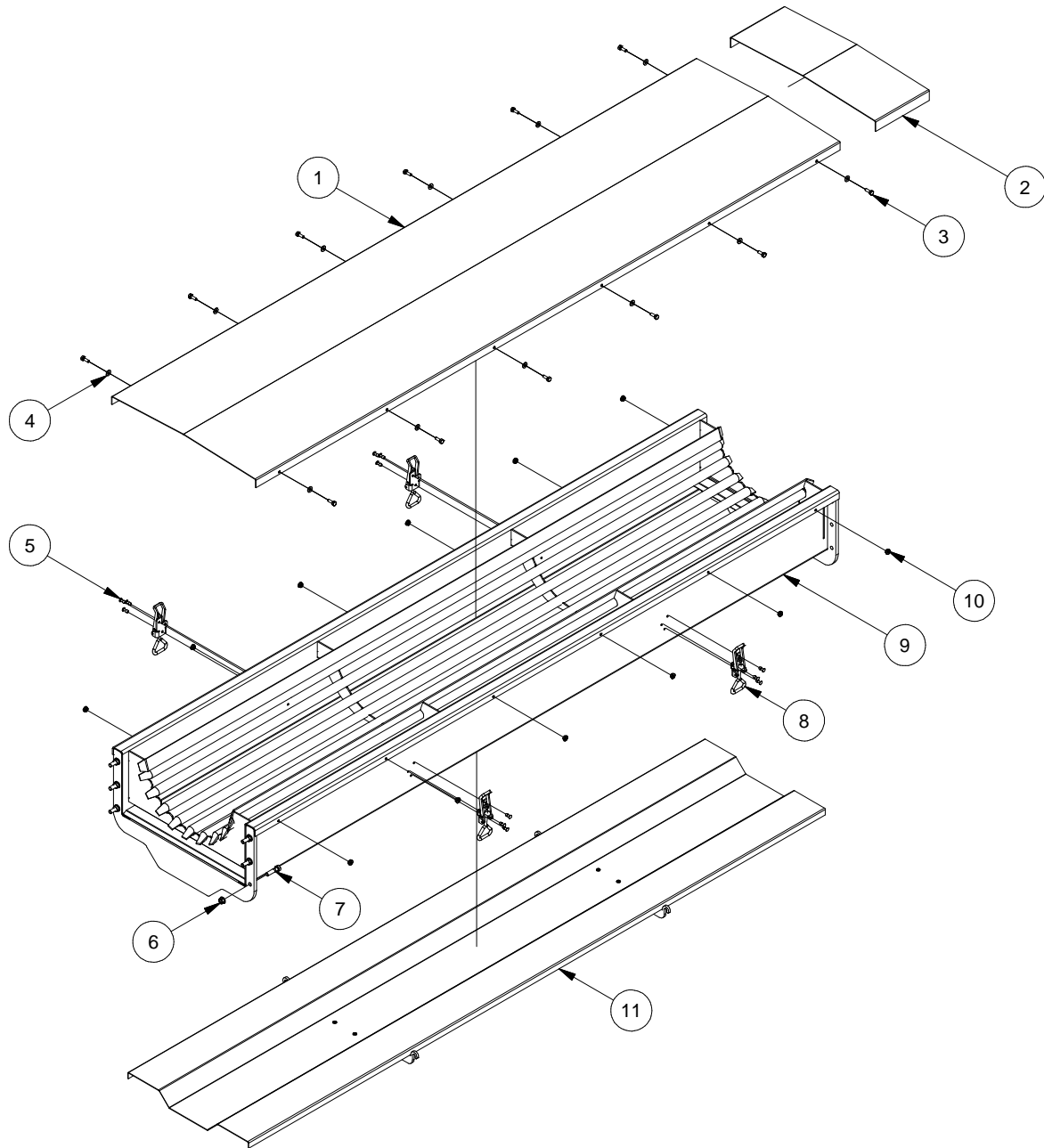
REF #	PART #	QUANTITY	DESCRIPTION
1	21384	1	Top Cover
2	27423	1	Transition Top Cover
3	13-0735-00004	4	Washer 1/4
4	13-0702-04012	4	Hex Bolt 1/4-20 UNC X 0.75
5	13-0731-00006	6	Hex Flanged Nut 3/8-16 UNC
6	13-0702-06024	6	Hex Bolt 3/8-16 UNC X 1.5
7	27934	2	Faucher 772-0128 Weldable Latch
8	19089	6	Rivet 3/16 Cosed End
9	32590	1	Conveyor Section Underbin 24in.
10	13-0731-00004	4	Hex Flanged Nut 1/4-20 UNC
11	32588	1	Bottom Cover

48" CONVEYOR SECTION



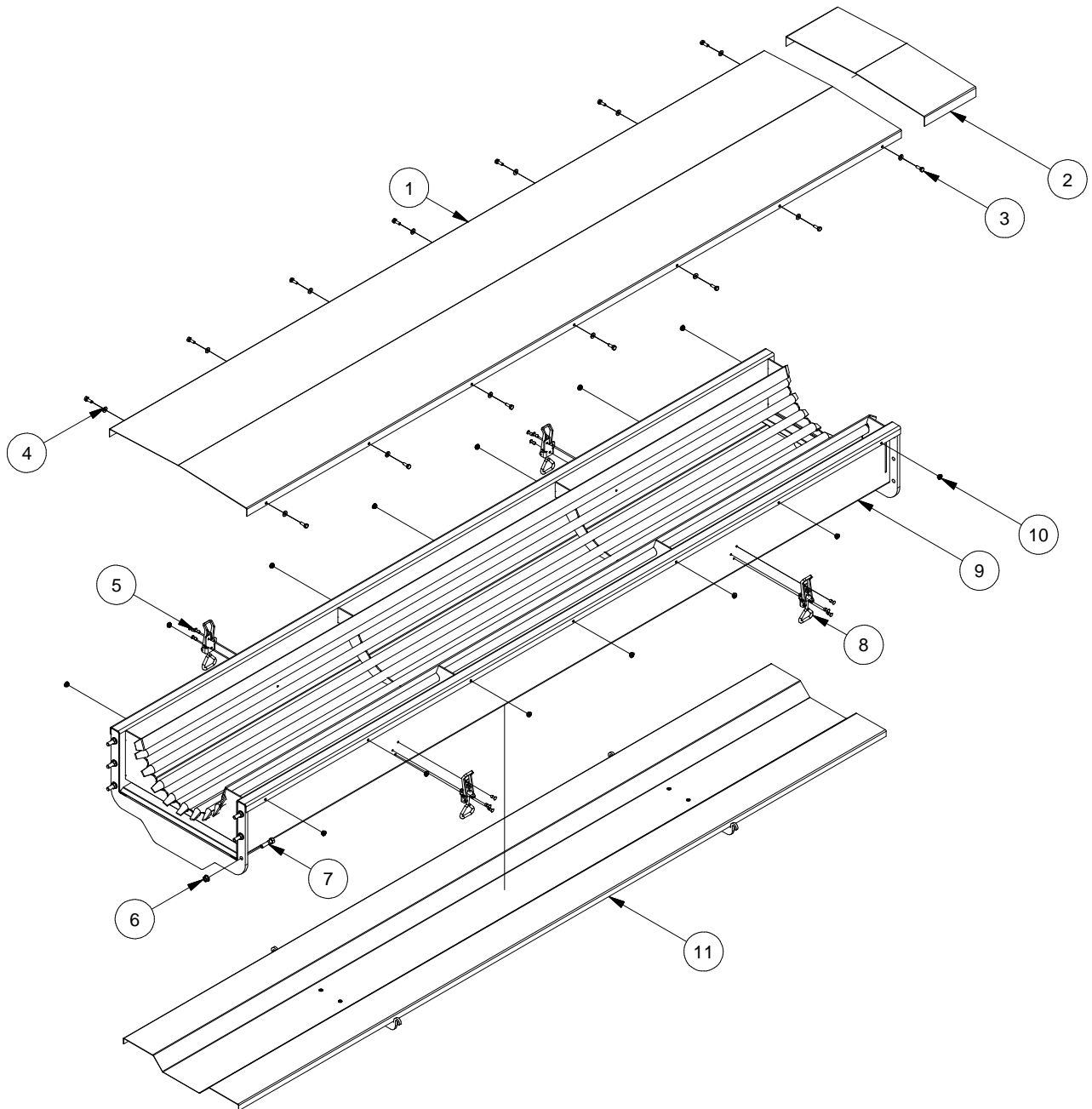
REF #	PART #	QUANTITY	DESCRIPTION
1	26439	1	Top Cover
2	27423	1	Transition Top Cover
3	13-0702-04012	6	Hex Bolt 1/4-20 UNC X 0.75
4	13-0735-00004	6	Washer 1/4
5	13-0731-00006	6	Hex Flanged Nut 3/8-16 UNC
6	13-0702-06024	6	Hex Bolt 3/8-16 UNC X 1.5
7	27934	4	Faucher 772-0128 Weldable Latch
8	19089	12	Rivet 3/16 Cosed End
9	32584	1	Conveyor Section Underbin 48in.
10	13-0731-00004	6	Hex Flanged Nut 1/4-20 UNC
11	34619	1	Bottom Cover

87" CONVEYOR SECTION



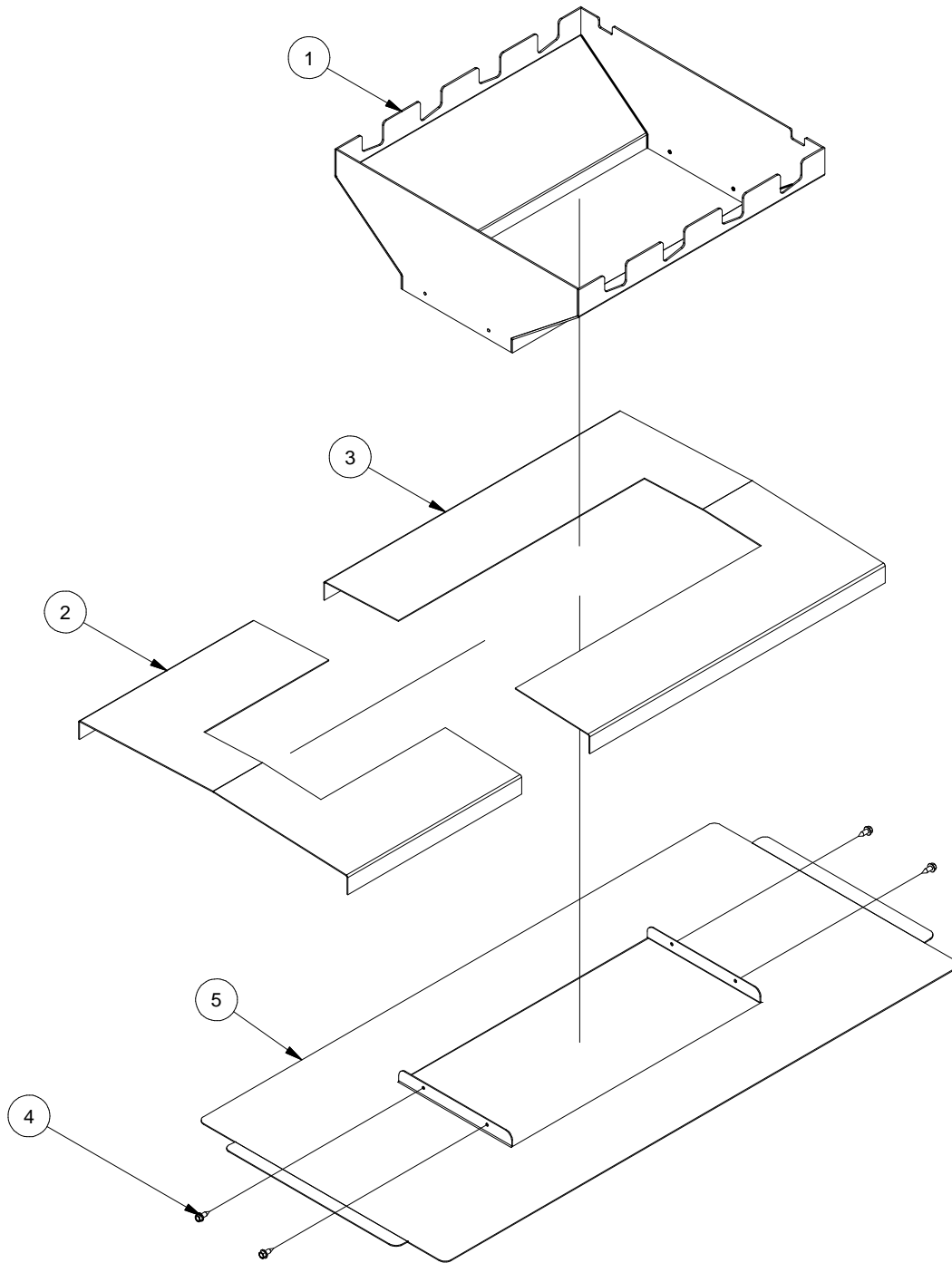
REF #	PART #	QUANTITY	DESCRIPTION
1	21383	1	Top Cover
2	27423	1	Transition Top Cover
3	13-0702-04012	12	Hex Bolt 1/4-20 UNC X 0.75
4	13-0735-00004	12	Washer 1/4
5	19089	12	Rivet 3/16 Cosed End
6	13-0731-00006	6	Hex Flanged Nut 3/8-16 UNC
7	13-0702-06024	6	Hex Bolt 3/8-16 UNC X 1.5
8	27934	4	Faucher 772-0128 Weldable Latch
9	32591	1	Conveyor Section Underbin 87in.
10	13-0731-00004	12	Hex Flanged Nut 1/4-20 UNC
11	32589	1	Bottom Cover

102" CONVEYOR SECTION



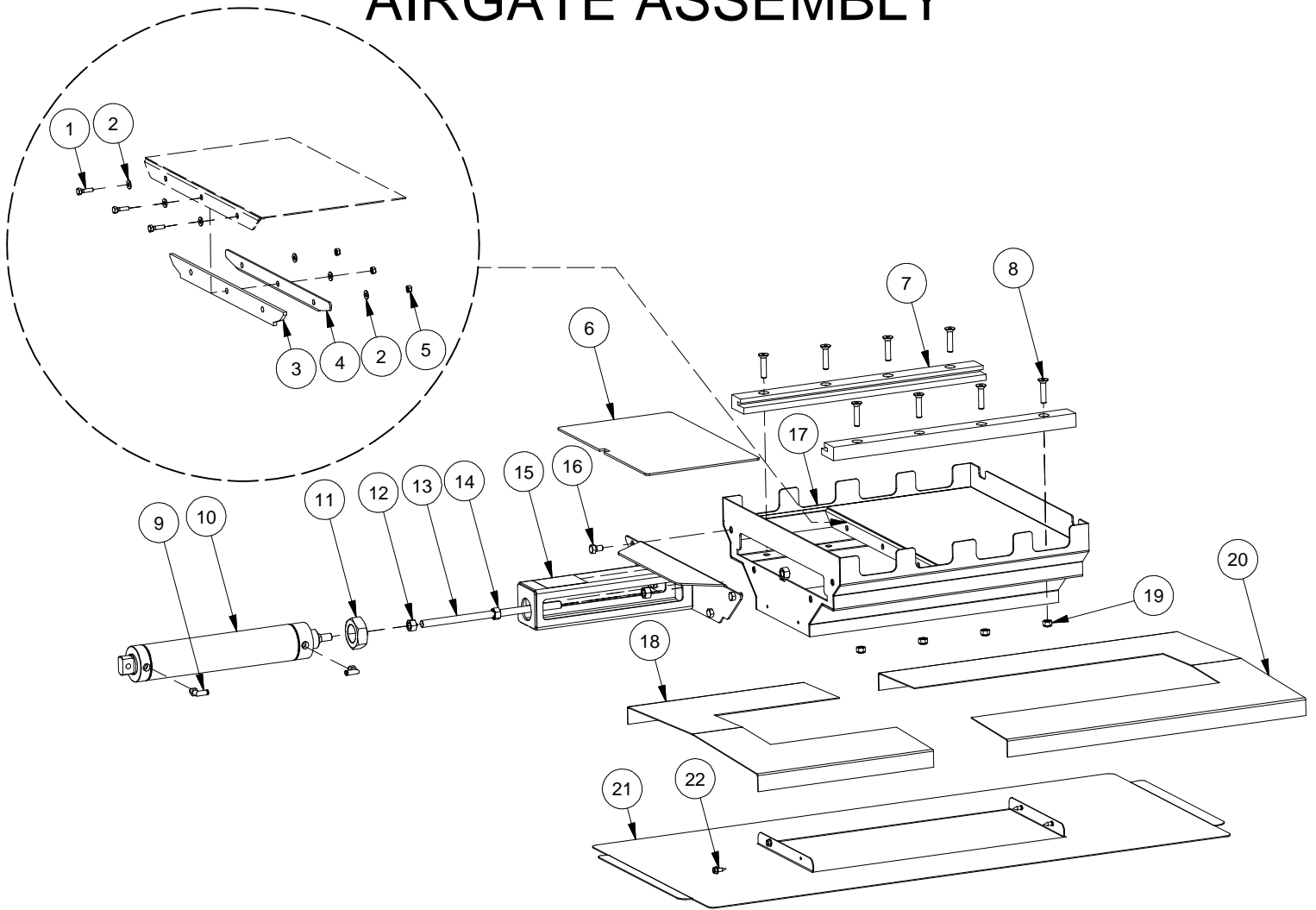
REF #	PART #	QUANTITY	DESCRIPTION
1	27407	1	Top Cover
2	27423	1	Transition Top Cover
3	13-0702-04012	14	Hex Bolt 1/4-20 UNC X 0.75
4	13-0735-00004	14	Washer 1/4
5	19089	12	Rivet 3/16 Cosed End
6	13-0731-00006	6	Hex Flanged Nut 3/8-16 UNC
7	13-0702-06024	6	Hex Bolt 3/8-16 UNC X 1.5
8	27934	4	Faucher 772-0128 Weldable Latch
9	32585	1	Conveyor Section Underbin 102in.
10	13-0731-00004	14	Hex Flanged Nut 1/4-20 UNC
11	37516	1	Bottom Cover

TRANSITION NON-AIR ASSEMBLY



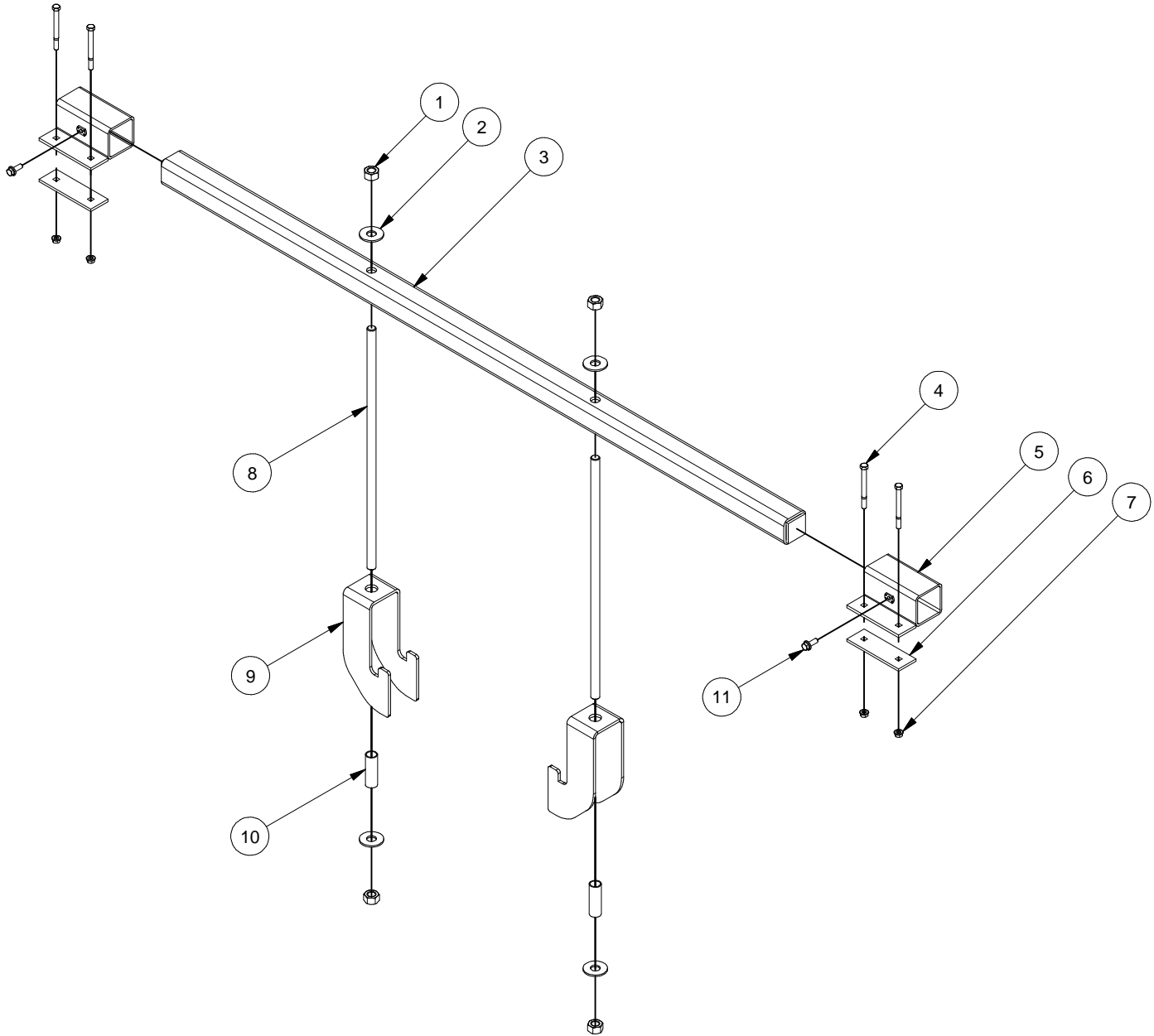
REF #	PART #	QUANTITY	DESCRIPTION
1	32025	1	Transition Non-Air
2	24394	1	Transition Cover Short
3	24393	1	Transition Cover Long
4	13-0707-04012	4	Screw Self Drill 1/4 - 14 x 3/4
5	50063	1	Transition Seal

AIRGATE ASSEMBLY



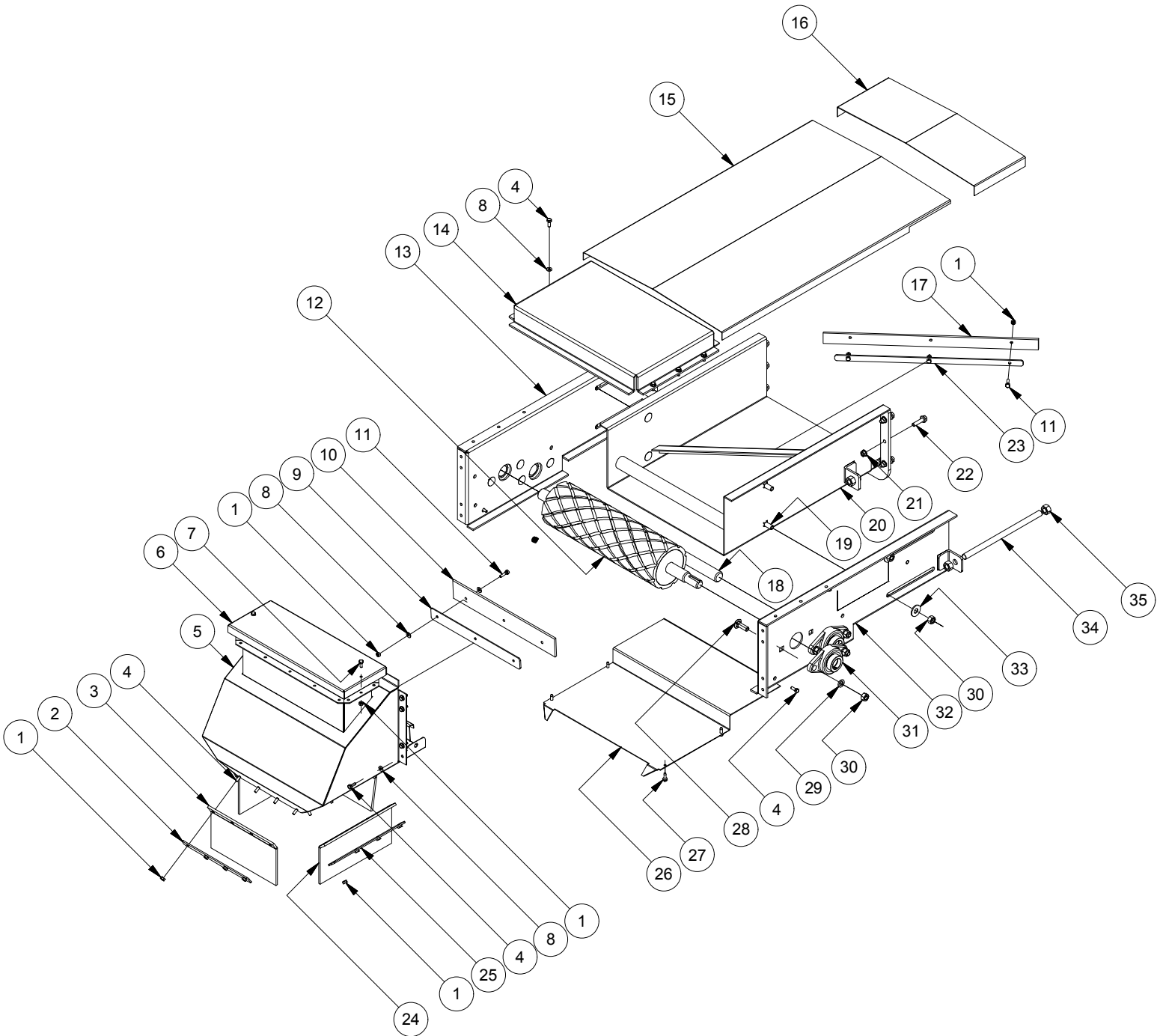
REF #	PART #	QUANTITY	DESCRIPTION
1	13-0702-04016	6	Hex Cap Screw 1/4-20 UNC x 1
2	13-0735-00004	12	Washer Narrow 1/4" Type A
3	27363	2	Scraper Blade Air Gate Rubber
4	27445	1	Hold Down Plate Scrapper
5	13-0725-00004	6	Hex Nut 1/4-20 UNC
6	37533	1	Blade Gate Weldment Air Gate
7	27364	2	Slider Air Gate UHMW
8	13-0702-06028	8	Hex Cap Screw 3/8-16 UNC x 1 3/4
9	18413	2	Fitting 1/4" NPT - 1/4" Air Line
10	27372	1	Pneumatic Cylinder 506-DXP
11	13-0727-00022	1	Hex Jam Nut 1-3/8 - 12
12	37525	1	Nut Assembly
13	27430	1	Threaded Rod Air Cylinder Blade Conveyors
14	13-0725-00008	1	Hex Nut 1/2 PL
15	37532	1	Mount Weldment Air Gate
16	13-0702-06010	4	Hex Cap Screw 3/8-16 UNC x 5/8
17	37537	1	Transition Air Gate
18	24394	1	Transition Cover Short
19	13-0729-00006	8	Nylon Hex Nut 3/8-16 UNC
20	24393	1	Transition Cover Long
21	50063	1	Transition Seal Rod Style
22	13-0707-04012	4	Screw Self Drill 1/4-14 x 3/4

CONVEYOR HANGER ASSEMBLY



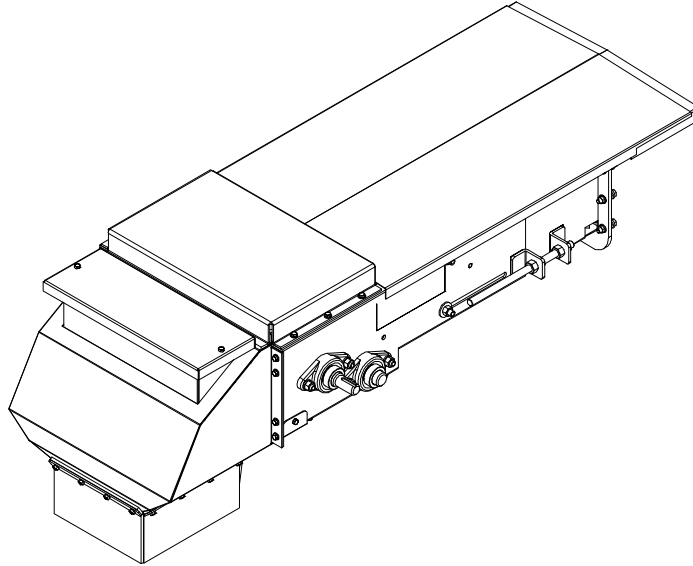
REF #	PART #	QUANTITY	DESCRIPTION
1	13-0725-00012	4	Hex Nut 3/4 PL
2	13-0735-00012	4	Washer Flat 3/4 STD F/W ZC
3	38803	1	Tube Support Under Bin Mount
4	13-0702-06064	4	Hex Cap Screw 3/8-16 UNC x 4
5	38799	2	Slider Under Bin Mount Red
6	26224	2	Plate - Anchor
7	13-0731-00006	4	Hex Flanged Nut 3/8-16 UNC
8	27951	2	Hanger Rod Under Bin Mount
9	27949	2	Hook Under Bin Mount
10	27952	2	Tube for Hanger Under Bin Mount
11	13-0712-06024	2	Hex Cap Screw 3/8-16 UNC x 1.5

UNDERBIN NON-MOTOR END



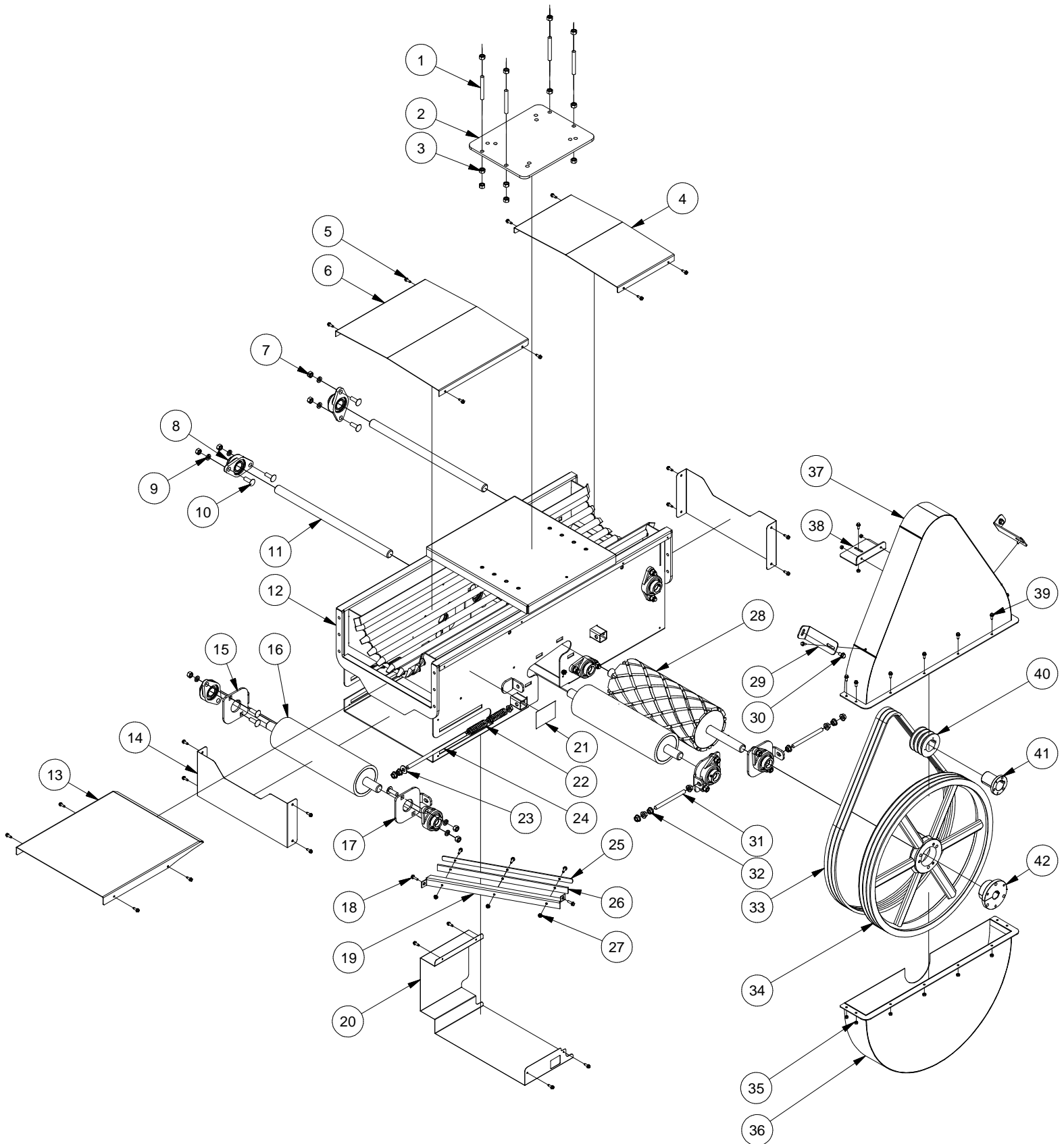
PARTS

UNDERBIN NON-MOTOR END

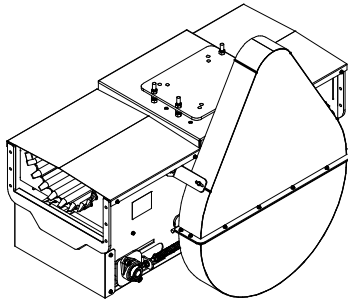


REF #	PART #	QUANTITY	DESCRIPTION
1	13-0725-00004	38	Hex Nut 1/4-20 UNC
2	27449	2	Bracket Hold Down Chute
3	17978	2	Rubber Flap Front Back Under Bin Discharge
4	13-0702-04012	32	Hex Cap Screw 1/4-20 UNC x 3/4
5	37547	1	Discharge Under Bin Red
6	27357	1	Plate Discharge Access Cover
7	13-0702-04010	2	Hex Cap Screw 1/4-20 UNC x 5/8
8	13-0735-00004	33	Washer, 1/4
9	27447	1	Bracket Hold Down Roller Scrapper
10	27366	1	Scrapper Brush Roller Rubber
11	13-0702-04016	6	Hex Cap Screw 1/4-20 UNC x 1
12	27361	1	Under Bin Drive Roller
13	37535	1	Side Plate Left Slider
14	37542	1	Cover Non-motor Red
15	27408	1	Cover Discharge Top Galvanized
16	27423	1	Cover Top Transition Galvanized
17	27365	1	Scrapper Rubber Under Bin
18	27435	1	Roller Metal Under Bin
19	13-0709-08020	4	Bolt Carriage 1/2-13 UNC x 1 1/4
20	37543	1	Frame Slider Bolt On Discharge
21	13-0731-00006	6	Flanged Nut 3/8-16 UNC
22	13-0702-06024	6	Cap Screw 3/8-16 UNC x 1 1/2 fl
23	27446	1	Bracket Hold Down Scrapper
24	17977	2	Rubber Flap Sides Under Bin Discharge
25	27378	2	Plate Skirt Retainer Red
26	27416	1	Cover Bottom Discharge
27	13-0707-04012	4	Screw Self Drill 1/4-14x3/4 HWH
28	13-0709-08016	8	Bolt Carriage 1/2-13 x 1 Gr5
29	13-0734-00008	8	Washer, Helical Spring Lock 1/2in
30	13-0725-00008	12	Hex Nut 1/2 PL
31	27441	4	Bearing Flange Two Bolt
32	37534	1	Slide Plate Right Slider Non-motor
33	13-0735-00008	4	Washer, 1/2
34	27427	2	Threaded Rod Tension Belt
35	13-0725-00010	8	Hex Nut 5/8-11 UNC

UNDERBIN S-DRIVE ASSEMBLY

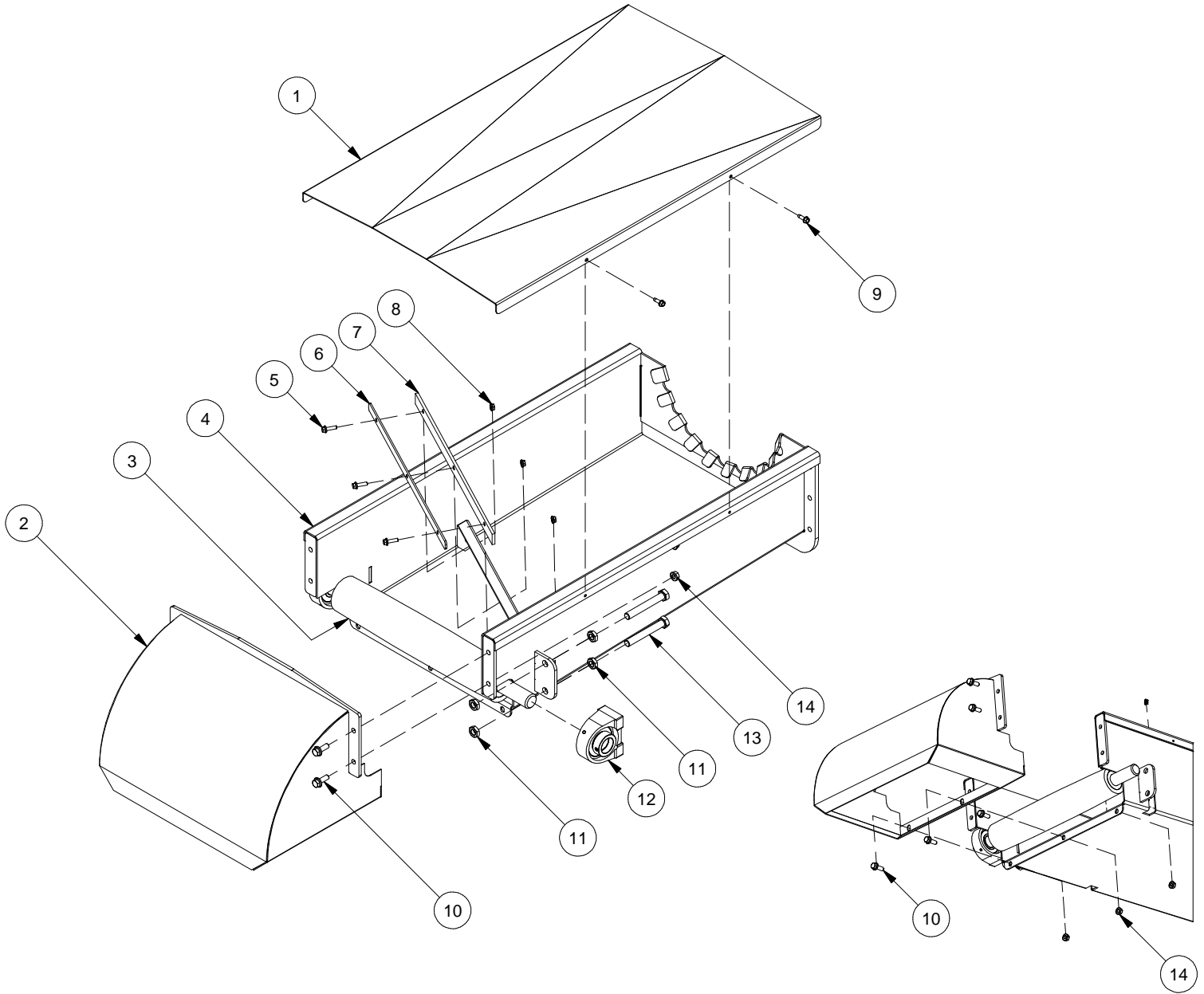


UNDERBIN S-DRIVE ASSEMBLY



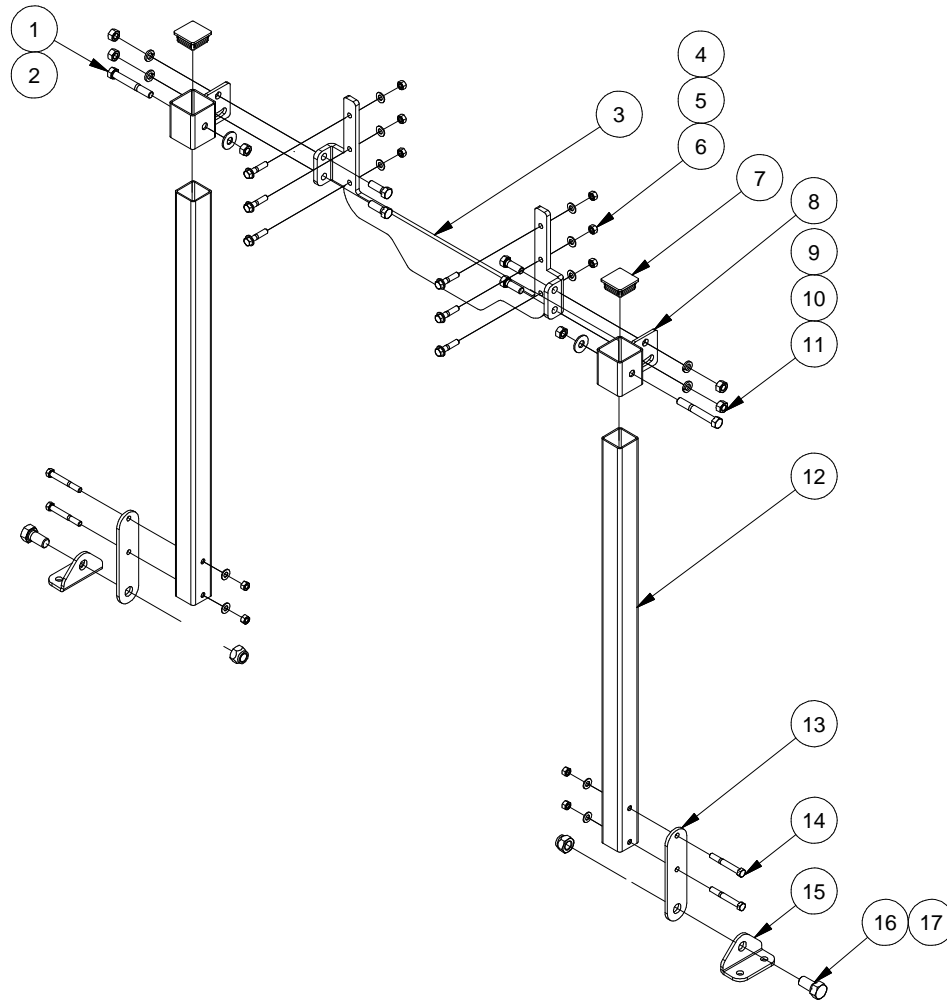
REF #	PART #	QUANTITY	DESCRIPTION
1	21756	4	Threaded Rod 1/2in. X 4in. Long
2	21737	1	Motor Mount Plate S-Drive
3	13-0723-00008	12	Hex Nut 1/2-13 UNC
4	21732	1	Cover Top Small S-Drive
5	13-0706-04010	24	Flanged Self Tapping Screw 1/4-20 UNC X 0.625
6	21731	1	Cover Top Large S-Drive
7	13-0725-00008	20	Hex Nut 1/2
8	27441	10	Bolt Flange Bearing
9	13-0734-00008	20	Lock Washers 1/2
10	13-0709-08024	20	Carriage Bolt 1/2-13 UNC X 1.5
11	27435	2	Roller Metal Under Bin
12	30649	1	S-Drive
13	21758	1	S-Drive Belt Interference Plate
14	21745	2	Plate Cover Access Port S-Drive
15	21743	3	Plate Bearing Mount Left S-Drive
16	14106	2	Pinch Roller S-Drive
17	21744	3	Plate Bearing Mount Right S-Drive
18	13-0712-04016	5	Hex Bolt Flanged 1/4-20 UNC X 0.875
19	33466	1	Scraper Bar Bolt In S-Drive
20	21736	1	Formed Cover Plate S-Drive
21	11522	1	S-Drive Belt Routing Decal
22	16128	4	Spring Compression S-Drive Tension
23	13-0736-00008	2	Washer 1/2
24	21755	2	Threaded Rod 1/2in. X 12in. Long
25	21752	1	Scraper Hold Down
26	21750	1	Scraper
27	13-0731-00004	3	Hex Nut Flanged 1/4-20 UNC
28	14109	1	Drive Roller S-Drive
29	21738	2	Mounting Tab Formed V-Belt S-Drive
30	13-0712-06012	2	Hex Bolt Flanged 3/8-16 UNC X 0.75
31	21754	4	Threaded Rod 1/2in. X 6in. Long
32	13-0731-00008	22	Hex Flange Nut 1/2
33	17664	3	V-Belt B90 S-Drive
34	17662	1	3 Groove V-belt Pulley 25" OD
35	13-0725-00004	11	Hex Nuts 1/4
36	34747	1	Bottom V-Belt Pulley Cover
37	34746	1	Top V-Belt Pulley Cover
38	21739	1	Mounting Tab V-Belt
39	13-0712-04012	11	Hex Flange Screw 1/4-20 UNC x 0.75
40	17663	1	Pulley 3V 3.75"-3TB34P Style Insert
41	14105	1	Bushing Split Taper P158
42	14104	1	Bushing Split Taper H114

UNDERBIN DISCHARGE



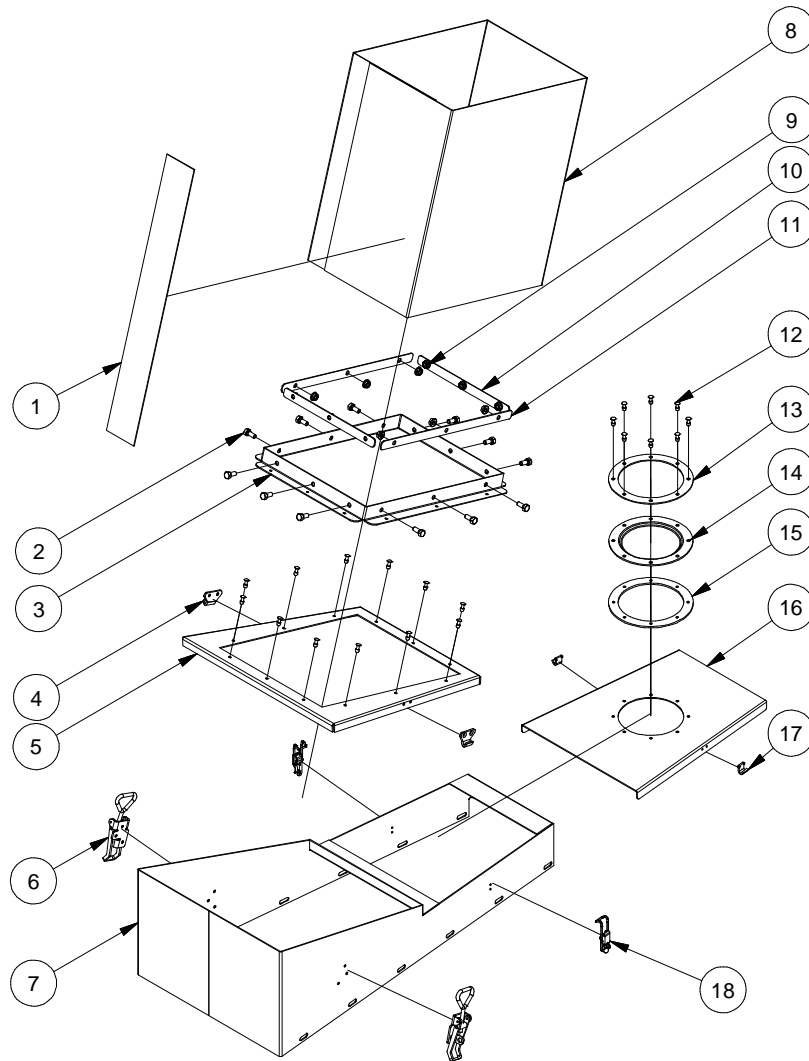
REF #	PART #	QUANTITY	DESCRIPTION
1	20832	1	Cover Galvanized UB Discharge
2	35097	1	UB Discharge Head
3	20831	1	UB Discharge Head Roller
4	35099	1	UB Discharge Body
5	13-0702-04016	3	Hex Cap Screw 1/4 x 1-20
6	21752	1	Scraper Hold Down
7	21750	1	Scraper
8	13-0731-00004	3	Flange Lock Nut 1/4-20
9	13-0707-04012	4	Screw Self Drill 1/4-14 x 3/4
10	13-0712-06016	7	Flange Lock Bolt 3/8 x 1-16
11	13-0727-10014	8	Hex Jam Nut M14 x 2
12	27467	2	Bearing Block Assembly
13	13-0701-14100	4	Hex Cap Screw M14 x 100m
14	13-0731-00006	7	Flange Lock Nut 3/8-16

UNDERBIN SUPPORT FLOOR MOUNT



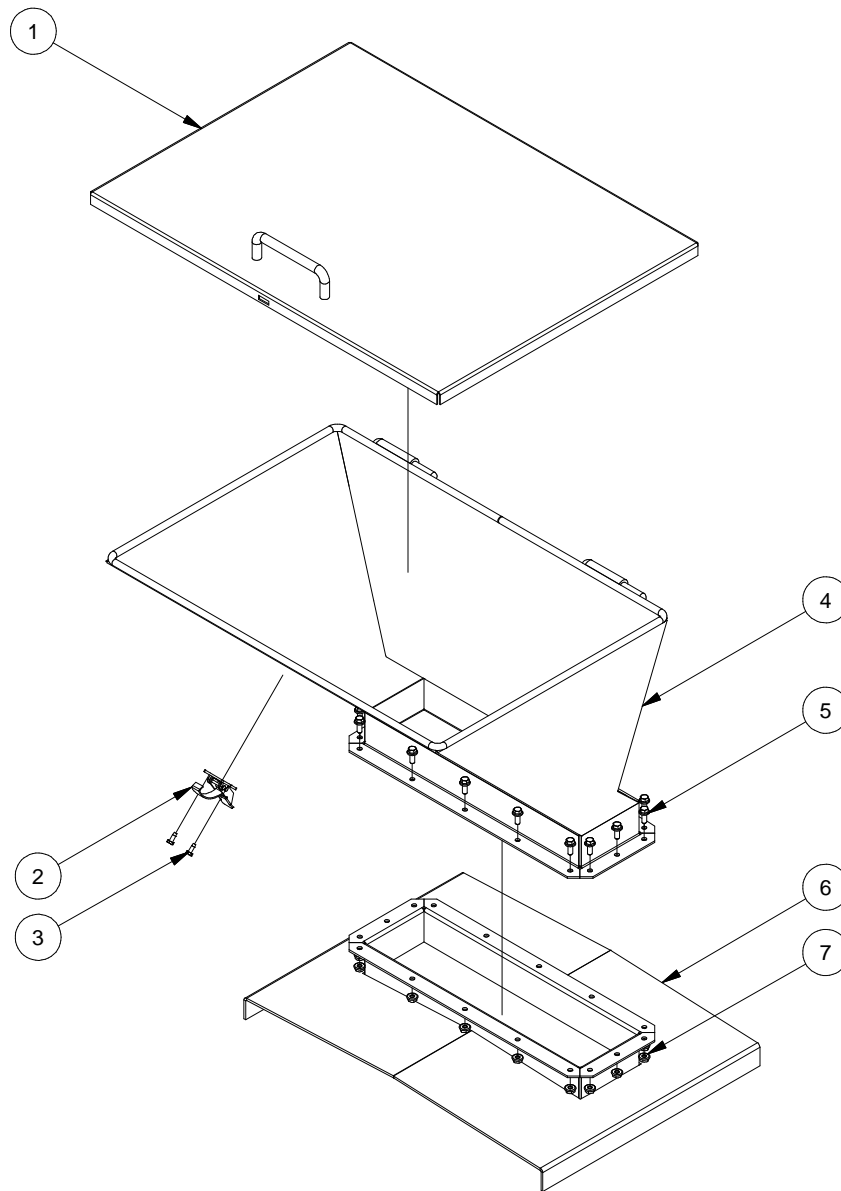
REF #	PART #	QUANTITY	DESCRIPTION
1	13-0702-08060	2	Hex Bolt 1/2-13 UNC X 3.75
2	13-0735-00008	2	Washer 1/2
3	23367	1	Flange Bolt Discharge
4	13-0702-06028	6	Hex Bolt 3/8-16 UNC X 1.75
5	13-0735-00006	16	Washer 3/8
6	13-0725-00006	10	Hex Nut 3/8-16 UNC
7	17131	2	Plastic Plug 2x2x120
8	27928	2	Underbin Support Height Adjustment
9	13-0702-08024	4	Hex Bolt 1/2-13 UNC X 1.5
10	13-0734-00008	4	Lock Washers 1/2
11	13-0725-00008	6	Hex Nut 1/2-13 UNC
12	23590	2	Underbin Conveyor Support Upright
13	27908	2	Bracket Floor Mount Tube
14	13-0702-06048	4	Hex Bolt 3/8-16 UNC X 3
15	27909	2	Bracket Floor Mount
16	13-0702-12024	2	Hex Bolt 3/4-10 UNC X 1.5
17	13-0729-00012	2	Hex Nylock 3/4-10 UNC

INCLINE TRANSITION ASSEMBLY



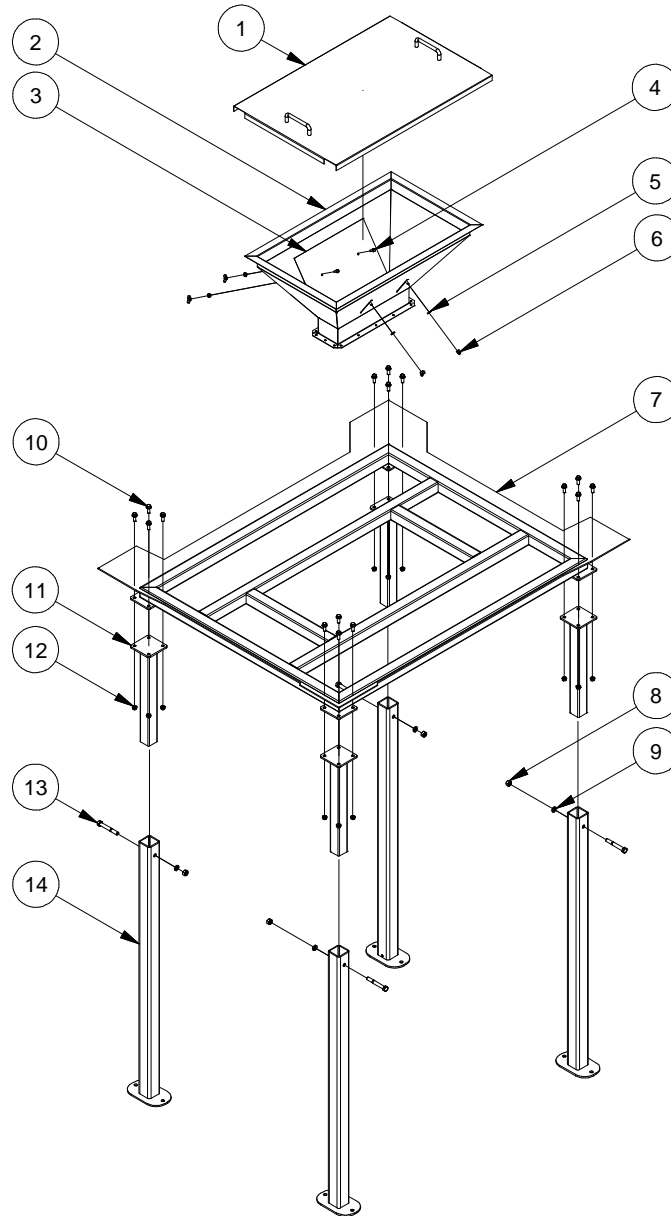
REF #	PART #	QUANTITY	DESCRIPTION
1	17830	1	Splice Tape EPDM 3in Wide
2	13-0702-05012	12	Hex Bolt 5/16-18 UNC X 0.75
3	29692	1	Transition Connection Bolt Plate
4	27935	2	Faucher 772-0142 Draw Latch
5	29691	1	Transition Connection Bottom Plate
6	27934	2	Faucher 772-0128 Weldable Latch
7	38534	1	Under Bin Transition Weldment
8	17831	1	Pond Guard EPDM 45mm
9	13-0725-00005	12	Hex Nut Flanged 5/16-18 UNC
10	29694	2	Transition Connection Spacer Short
11	29693	2	Transition Connection Spacer Long
12	19089	20	Rivet 3/16
13	19077	1	View Glass Ring
14	19285	1	View Glass
15	19055	1	View Glass Gasket
16	29695	1	Under Bin Transition Cover Plate
17	17838	2	Keeper Plate Faucher 776-2329
18	17832	2	Faucher 776-4407 Draw Latch

DUMP HOPPER ASSEMBLY



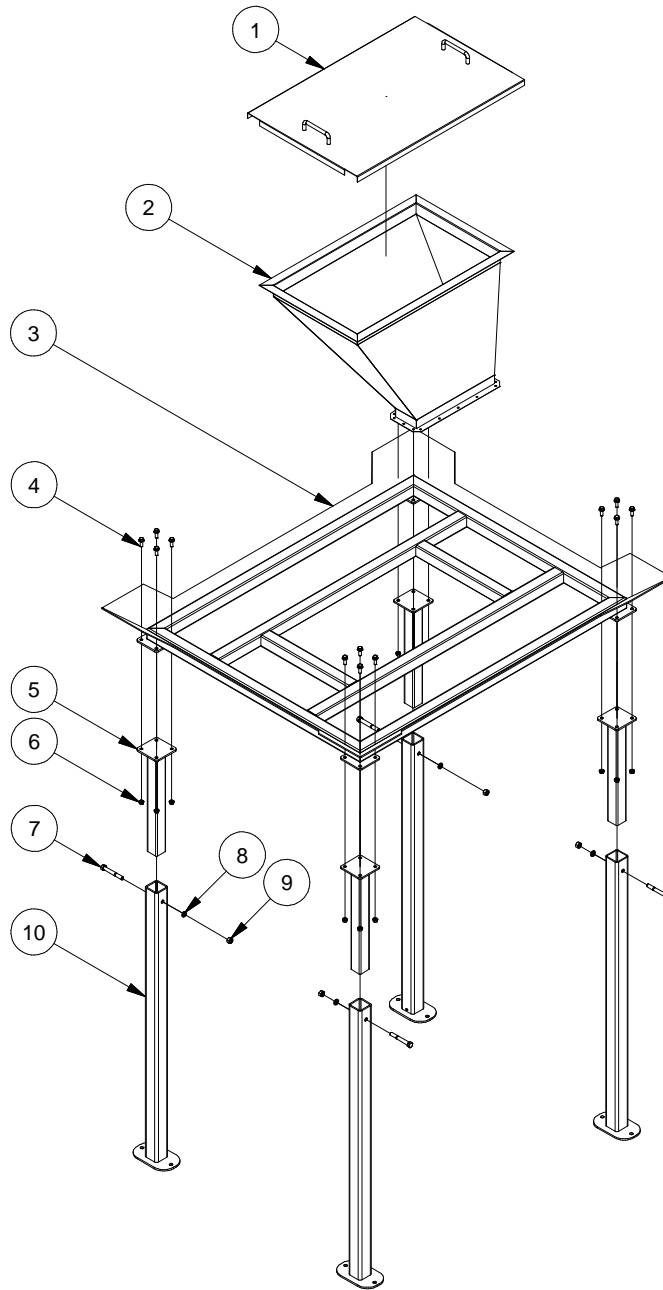
REF #	PART #	QUANTITY	DESCRIPTION
1	37503	1	Hopper Lid
2	21257	1	Over-Center Latch
3	13-0707-10008	2	Self Tapping Hex Screw 10-16 UNC X 0.5
4	37502	1	Hopper Bottom Weldment
5	13-0712-04010	16	Flanged Hex Bolt 1/4-20 UNC X 0.625
6	34620	1	Dump Hopper Mounting Plate
7	13-0731-00004	16	Flanged Hex Nut 1/4-20 UNC

SEED BOX STAND STRAIGHT DISCHARGE ASSEMBLY



REF #	PART #	QUANTITY	DESCRIPTION
1	34656	1	Seed Box Stand Lid Weldment
2	34655	1	Seed Box Stand Discharge Hopper
3	26446	2	Flow Limiting Slide Plate
4	13-0702-04012	4	Hex Bolt 1/4-20 UNC X 0.75
5	13-0735-00004	4	Washer 1/4
6	13-0732-00004	4	Wing Nut 1/4
7	34657	1	Seed Box Stand Frame
8	13-0725-00008	4	Hex Nut 1/2-13 UNC
9	13-0734-00008	4	Lock Washer 1/2
10	13-0712-06016	16	Flange Bolt 3/8-16 UNC x 1
11	50431	4	Leg - Seed Box Frame
12	13-0731-00006	16	Flange Nut 3/8-16 UNC
13	13-0702-08060	4	Hex Bolt 1/2-13 UNC X 3.75
14	34660	4	Seed Box Stand Telescope Legs

SEED BOX STAND OFFSET DISCHARGE



REF #	PART #	QUANTITY	DESCRIPTION
1	34656	1	Seed Box Stand Lid Weldment
2	37550	1	Seed Box Stand Discharge Hopper
3	34657	1	Seed Box Stand Frame
4	13-0712-06016	16	Flange Bolt 3/8-16 UNC x 1
5	50431	4	Leg - Seed Box Frame
6	13-0731-00006	16	Flange Nut 3/8-16 UNC
7	13-0702-08060	4	Hex Bolt 1/2-13 UNC X 3.75
8	13-0734-00008	4	Lock Washer 1/2
9	13-0725-00008	4	Hex Nut 1/2-13 UNC
10	34660	4	Seed Box Stand Telescope Legs

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Part #	Page	Ref #	Part #	Page	Ref #	Part #	Page	Ref #
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14105	E13	41	21752	E14	6	27441	E13	8
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19055	E16	15	27366	E11	10	27935	E16	4
19077	E16	13	27366	E2	34	27949	E9	9
19089	E16	12	27372	E8	10	27951	E9	8
19089	E3	8	27378	E11	25	27952	E9	10
19089	E4	8	27378	E2	32	29691	E16	5
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Limited Materials and Workmanship Warranty For Conveyors

Meridian Manufacturing, Inc. (hereinafter referred to as the Manufacturer) hereby warrants the Conveyor(s) sold by it to be free from any defect in material or workmanship under normal use and service for a period of one (1) year from the date of retail sale. The Manufacturer's obligation under this warranty shall be limited to the repair or replacement only, FOB the original point of shipment, of any defective parts or portions of the conveyor or accessories manufactured by Meridian. Any warranty claim must be reported to the Manufacturer within one (1) year from the date of shipment.

THIS WARRANTY IS SUBJECT TO THE FOLLOWING LIMITATIONS, PROVISIONS AND CONDITIONS:

1. This warranty does not apply:
 - a) To any product sold by the Manufacturer where it is used in areas exposed to corrosive or aggressive conditions including salt water, acids, alkaloid, ash, cement dust, animal waste or other corrosive chemicals from either inside or outside the bin.
 - b) For failures or defects arising out of damage during shipment or during storage on site.
 - c) To materials replaced or repaired under this warranty except to the extent of the remainder of the applicable warranty.
 - d) To damage resulting from misuse, negligence, accident or improper site preparation by others.
 - e) If the product has been altered or modified by others.
 - f) If in the case of coating failures the failure is the result of damage, lack of proper maintenance or failure to remove road salt or other contaminants that may have come in contact with the bin surface.
 - g) To loss of time, inconvenience, loss of material, down time or any other consequential damage.
 - h) For a function that is different than original designed intent.
2. The obligation of the Manufacturer under this warranty shall not arise unless the Manufacturer is notified and this warranty is presented together with a written statement specifying the claim or defect within thirty (30) days after the failure is first detected or made known to the owner and within one (1) year from the shipment date. The Manufacturer in its sole discretion shall determine if the claim is valid and whether correction of the defect or failure shall be made by repair or replacement of the materials.
3. The coating warranty is based on the manufacturer's performance specification for Polyester Powder finishes and does not include repair of minor blemishes or rusting that is normally part of the general maintenance of the conveyor. This warranty does not cover excessive wear on interior coatings. See attachment for full Performance Specification details on Polyester Powder Finishes.
4. The obligation of the Manufacturer hereunder extends only to the original owner and to the Meridian dealer to whom the materials may have been initially sold. This warranty shall not be subject to any assignment or transfer without the written consent of the Manufacturer.
5. The customer shall acknowledge that it has made its own independent decision to approve the use of the supplied materials and also the specific fabrication and construction procedures utilized to complete the conveyor, and has satisfied itself as to the suitability of these products for this particular application.

WARRANTY

6. The foregoing sets forth the only warranties applicable to said materials and said warranties are given expressly and in lieu of all other warranties, expressed or implied, statutory or otherwise, of merchantability or fitness for a particular purpose and all warranties which exceed or differ from said warranties herein are disclaimed by the Manufacturer.
7. The owners sole and exclusive remedy against the Manufacturer shall be limited to the applicable warranty set forth herein and the endorsements, if any, issued together with this document and no other remedy (including but not limited to the recovery of assembly or disassembly costs, shipping costs, direct, incidental, special, indirect or consequential damages for lost profits, lost sales, injury to person or property or any other loss, whether arising from breach of contract, breach of warranty, tort, including negligence, strict liability or otherwise) shall be available to the owner or Meridian Dealer or any other person or entities whether by direct action or for contribution or indemnity or otherwise.
8. The financial obligation of the Manufacturer under this warranty shall be limited to the repair or replacement of the product as originally supplied and in no event shall exceed the original cost of the product supplied.
9. The Manufacturer shall not have any obligation under any warranty herein until all accounts for materials, installation and erection of the said product thereof and for labor and other work performed by the Manufacturer or its dealers have been paid in full by the owner.

WARRANTY CLAIM PROCEDURE

1. Registering product with Meridian Manufacturing.
2. Contact the dealer unit was purchased from upon discovery of any defects.
3. A completed warranty claim form submitted by dealer to Meridian warranty representative for review and course of action.
4. Warranty repair work will only be performed by Meridian, the dealer or an approved representative. No warranty work completed prior to approval. Failure to follow procedure may affect any or all reimbursement.
5. Claims will be adjudicated at the sole discretion of the manufacturer and in accordance with the terms and conditions of the applicable limited warranty.
6. A complete list of warranty procedures can be procured from the Warranty Department or found in your owner's manual.

MERIDIAN MANUFACTURING INC.

With over 65 years of experience,
Meridian is your storage and handling expert.



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