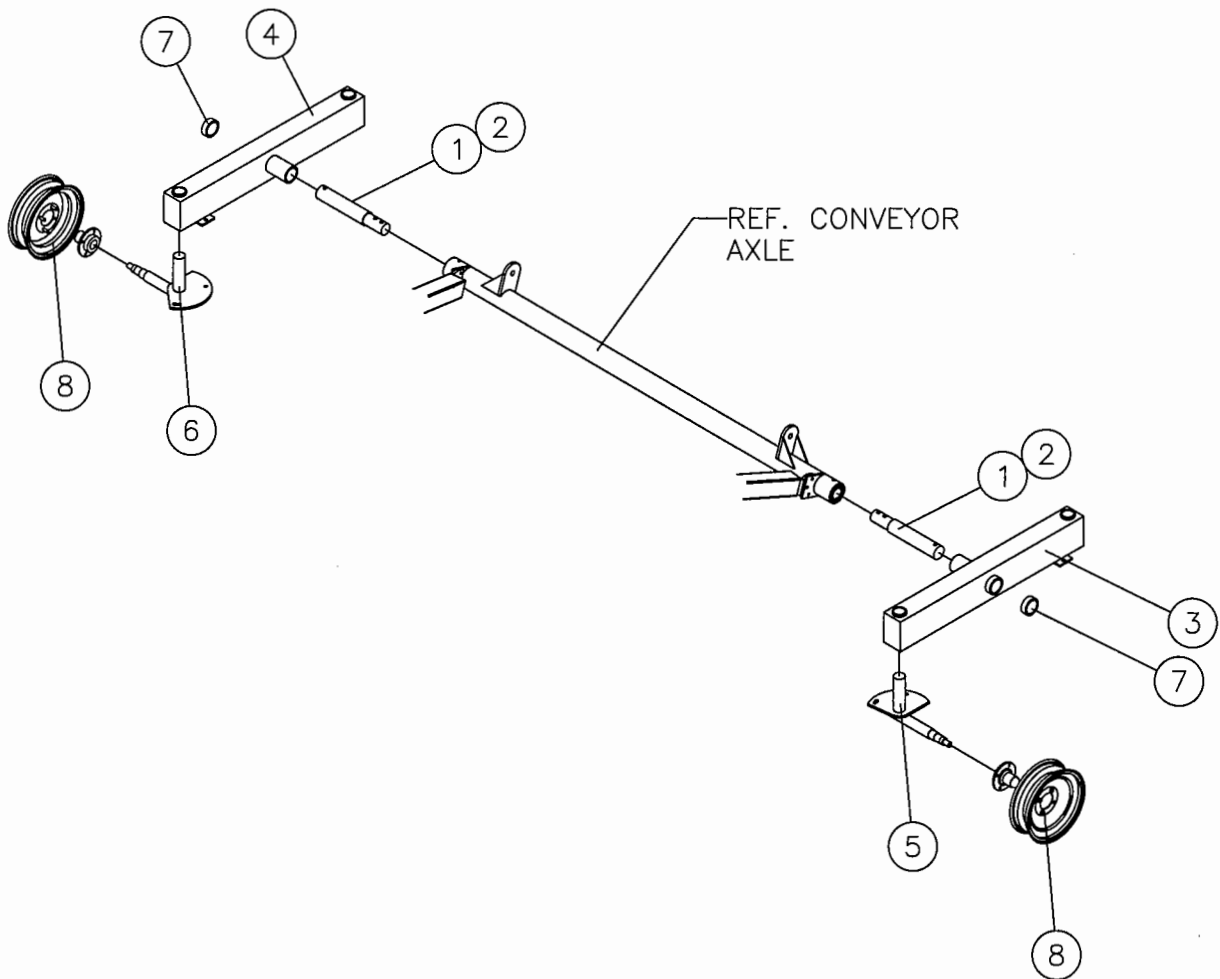


INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 90' SQUEEZE BELT® CONVEYOR

ASSEMBLY

1. Install the axle stubs (Items 1 or 2) into the end of the axle tube and secure each in place. Use a 1/2" x 5-1/2" long bolt for 60' & 70' models and use a 1/2" x 7" long bolt for 90' models. Use a lock washer and nut on each.
2. Slide the right and left hand swivel axle weldments (Items 3 and 4) over the ends of the axle stubs (Items 1 or 2).
3. Slide an axle collar (Item 7) over the end of each axle stub to secure the swivel axle weldments in place and secure with a 1/2" x 4" long bolt with locknut.
4. Slide the two right side swivel pivot weldments (Items 5) into the end sleeves of the swivel axle weldment (Item 3). Secure pivots to swivel axle weldments with 1/2" x 1-1/2" long bolts, lockwashers and nuts.



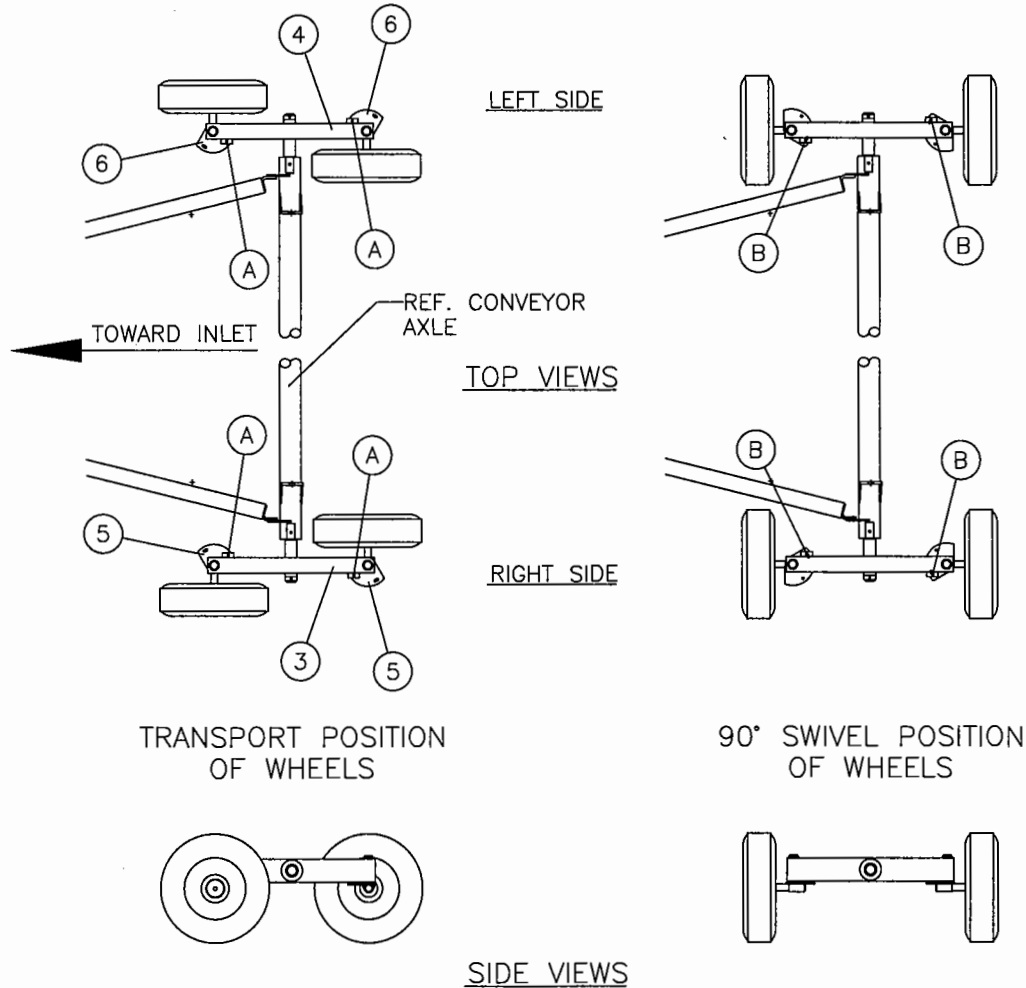
INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 90' SQUEEZE BELT® CONVEYORS

ASSEMBLY - CONT.



CAUTION: The wheels must be in the transport position when raising or lowering the conveyor if the inlet is held in position. Damage to the conveyor housing will occur if the wheels are in the swiveled position.



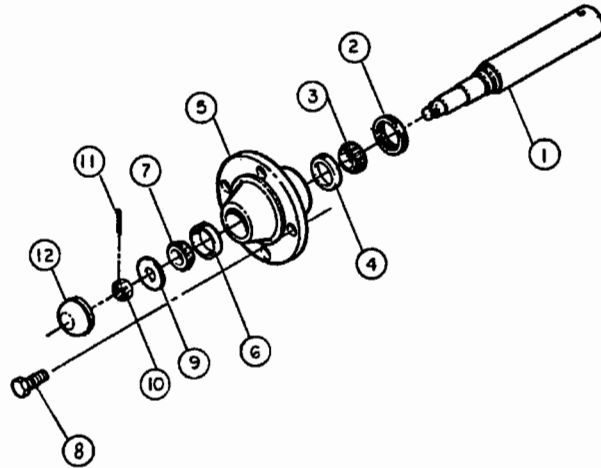
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	1028291	Axle Stub f/60' models (2.39" dia. at axle)
2	1028292	Axle Stub f/70' & 90' models (2.08" dia. at axle)
3	1028287	Swivel Axle Weldment (right hand)
4	1028288	Swivel Axle Weldment (left hand)
5	1028285	Swivel Pivot Weldment (right hand)
6	1028286	Swivel Pivot Weldment (left hand)
7	50495A1	Axle Collar
8	D1252	Wheel, 6-bolt 15" x 6"

INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 90' SQUEEZE BELT® CONVEYORS

ASSEMBLY - CONT.

5. When assembling the hub, pack both bearing cones with grease and fill the hub cavity one-third full. Place inner bearing assemblies into the hub, and then press grease seal into hub and carefully install the hub on the spindle. When placing hub on spindle, be careful not to damage the lip on the grease seal. Install outer bearing assembly into the hub. Then slide flat washer on and install slotted nut. Then tighten the slotted nut to seat the bearings until the hub binds as you rotate hub. Back off the slotted nut to the next slot and place a new cotter pin in. Use a 1/8" cotter pin 1-1/2" long. Place dust cap.



<u>Ref. No.</u>	<u>Description</u>	<u>6-Bolt</u>
1	Spindle	Included w/1028285 or 1028286
2	Grease Seal	D1072
3	Inner Conn (Timken No.)	3078R1 (LM48548)
4	Inner Cup (Timken No.)	3147R1 (LM48510)
5	Hub	D1252
6	Outer Cup (Timken No.)	3148R1 (LM67010)
7	Outer Cone (Timken No.)	3079R1 (LM67048)
8	Lug Bolt	106241
9	Washer	D1148
10	Slotted Hex Nut	D1147
11	Cotter Pin	D1146 (5/32" x 1-1/4")
12	Hub Cap	40588

6. Mount tires on wheels and inflate to recommended pressure shown on tire. Bolt the wheels to the hubs, and tighten wheel bolts evenly to assure proper alignment of wheels.

IMPORTANT NOTE:

- A. When transporting conveyor, be sure that the 1/2" x 1-1/4" bolts holding the swivel pivots are tight. Use holes marked A in Fig. on page 2 for transport position.
- B. For swinging conveyor in an arc, use bolts in slots marked B. Use adjustment in slots (marked B) to align wheels to prevent skidding when moving auger in an arc.

