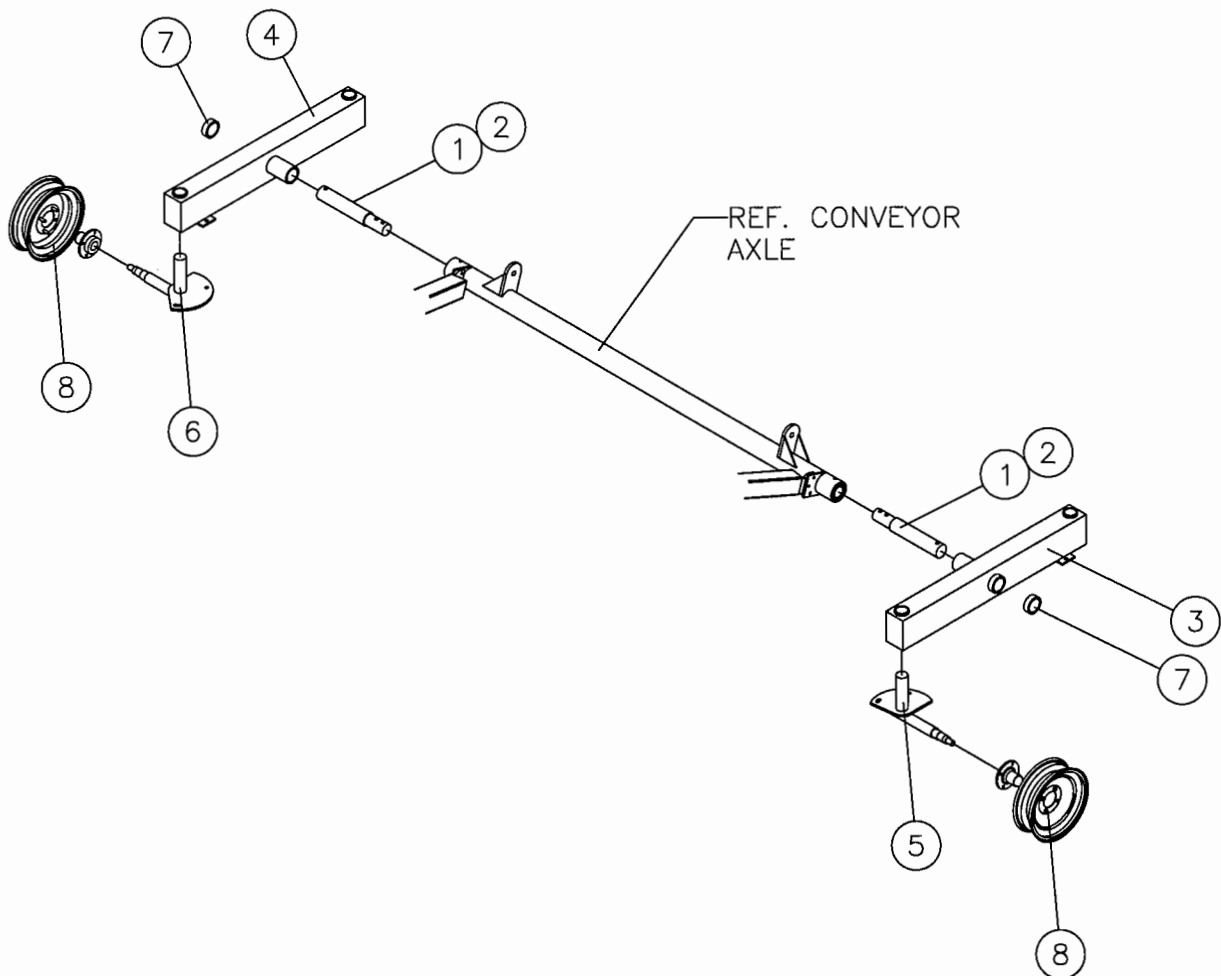


INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 85' SINGLE BELT CONVEYORS

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 $4-1/2"$ long bolt for 60' models and use a $1/2"$ x $5-1/2"$ long bolt for 70' & 85' 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 assemblies (Items 5) into the end sleeves of the swivel axle weldment (Item 3). Secure pivots to swivel axle weldment with $1/2"$ x $1-1/2"$ long bolt, lockwasher and nut.



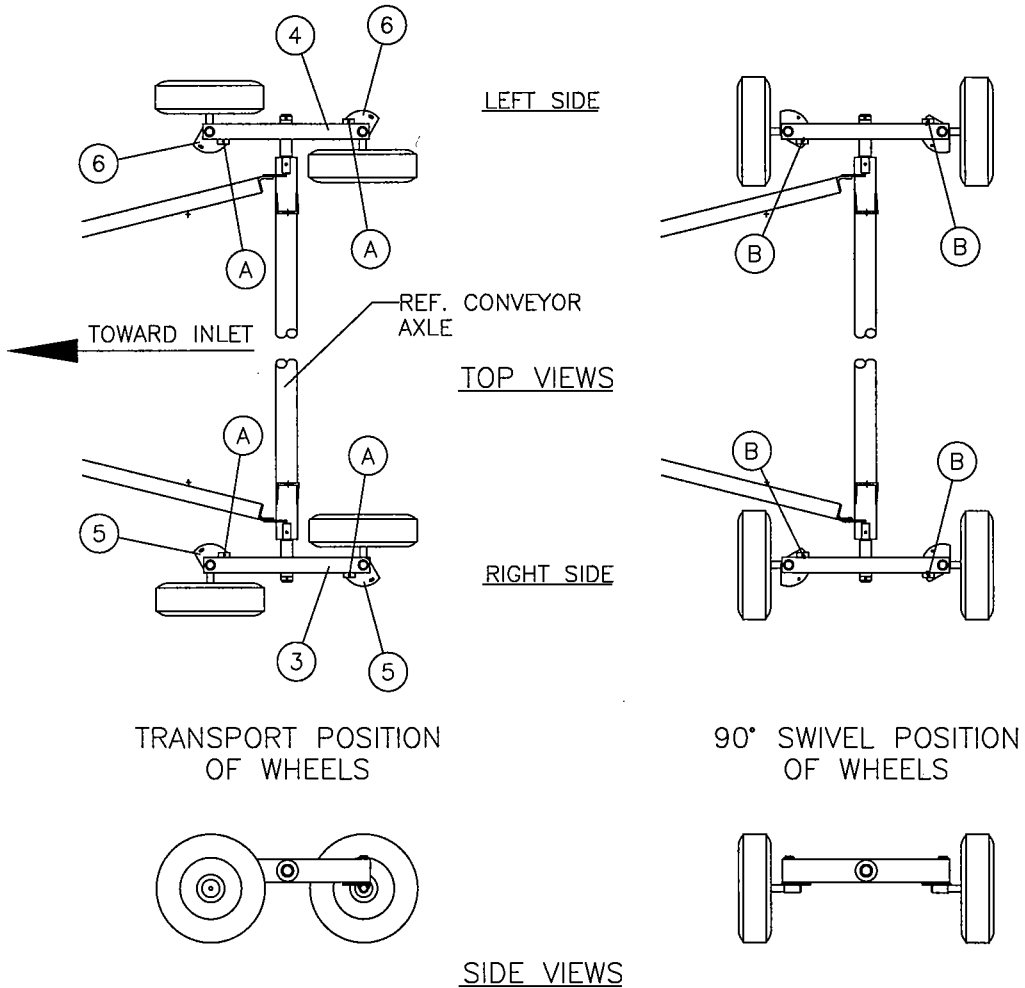
INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 85' SINGLE 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.



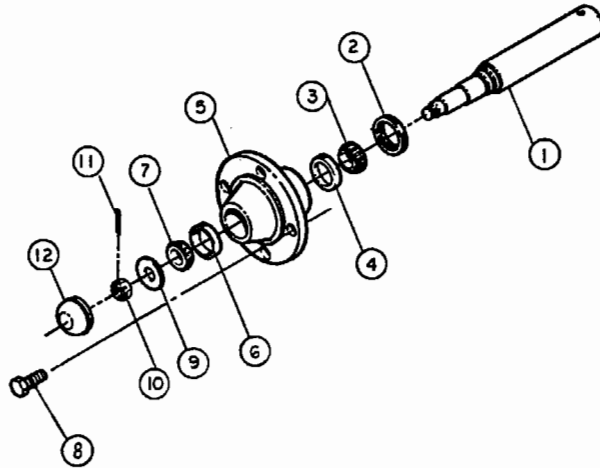
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	1028291	Axle Stub f/70' & 85' models (2.39" dia. at axle)
2	1028292	Axle Stub f/60' models (2.08" dia. at axle)
3	1028287	Swivel Axle Weldment (right hand)
4	1028288	Swivel Axle Weldment (left hand)
5	1028391	Swivel Pivot Assembly (right hand)
6	1028392	Swivel Pivot Assembly (left hand)
7	50495A1	Axle Collar
8	6393D	Wheel, 4-bolt 15"

INSTALLATION INSTRUCTIONS

SWIVEL ARC KIT - FOR 60', 70' & 85' SINGLE BELT CONVEYORS

ASSEMBLY - CONT.

5. Slide the two left side swivel pivot assemblies (Items 6) into the end sleeves of the swivel axle weldment (Item 4). Secure pivots to swivel axle weldment with 1/2" x 1-1/2" long bolt, lockwasher and nut.



<u>Ref. No.</u>	<u>Description</u>	<u>4-Bolt</u>
1	Spindle	Included w/1028391 or 1028392
2	Grease Seal	106245
3	Inner Conn (Timken No.)	3079R1 (LM67048)
4	Inner Cup	3148R1
5	Hub	90174
6	Outer Cup (Timken No.)	40552 (LM11910)
7	Outer Cone (Timken No.)	40551 (LM11949)
8	Lug Bolt	106241
9	Washer	106252
10	Slotted Hex Nut	106250
11	Cotter Pin	D1146 (5/32" x 1-1/4")
12	Hub Cap	106244

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 1-1/2" 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.

