

# Hutchinson/Mayrath

## INSTALLATION INSTRUCTIONS



This safety symbol is used throughout these instructions to alert you to information about unsafe actions or situations, and may be followed by the word **DANGER**, **WARNING**, or **CAUTION**. **Be Alert! Your safety and the safety of others is involved.**

**DANGER** - Indicates immediate hazards that may result in severe injury or death. **WARNING** - Indicates unsafe actions or situations that may cause severe injury, death and/or major equipment or property damage. **CAUTION** - Indicates unsafe actions or situations that may cause injury, and/or minor equipment or property damage.

Please remember that safety is the number one priority. Use caution during all phases of the assembly process. Wear proper PPE (personal protective equipment) and follow the safety recommendations included in the manual provided with your equipment.

### SWIVEL ARC KIT, PART NO. P3076A8

for

### 80' & 90' PORTABLE M85 MASS-TER MOVERS

### with 8-BOLT HUB MOUNTING

Before beginning assembly it is suggested to read through these instructions and lay out all items from the kit to ensure all parts are accounted for. This not only helps you become familiar with the parts and assembly procedures, but also makes you aware of what tools, equipment or materials you may need to complete the installation process.



**CAUTION!** When raising the conveyor axle, *Do Not* rely solely on hydraulic jacks, mechanical jacks or overhead hoist's for support. Use appropriate jack stands or equivalent for supporting the unit.

**Note:** Whenever reference is made to the left, right, front or rear of the conveyor, it is always determined by standing at the hitch end looking towards the discharge spout.

#### Assembly Procedures

1. With the conveyor in its lowered position, raise one side of the conveyor axle just high enough to allow the wheel and tire to be removed (retain the lug nuts). Use jack stands or equivalent to support the axle.
2. Mount the swivel axle weldment onto the existing hub of the conveyor axle as shown in Fig. 1. Secure the axle weldment to the conveyor hub using the lug nuts retained earlier.
3. Locate the two right-hand and the two left-hand swivel spindle weldments and the spindles from the kit. Apply a light coat of anti-seize compound to the end of the spindles and install a spindle into each of the swivel weldments. Secure using 1/2" x 3 1/4" bolts and nylon locknuts (See Fig. 1).
4. The bottom of each axle weldment has a mounting plate (one to the inside, one to the outside). The swivel weldment will be fastened to these mount plates.

5. Secure each swivel weldment to the mounting plate using one 1/2" x 1 1/2" bolt, flat washer, lock washer and non-lock nut (the round hole is used for transport, the slotted hole is used for swinging the conveyor in an arc).

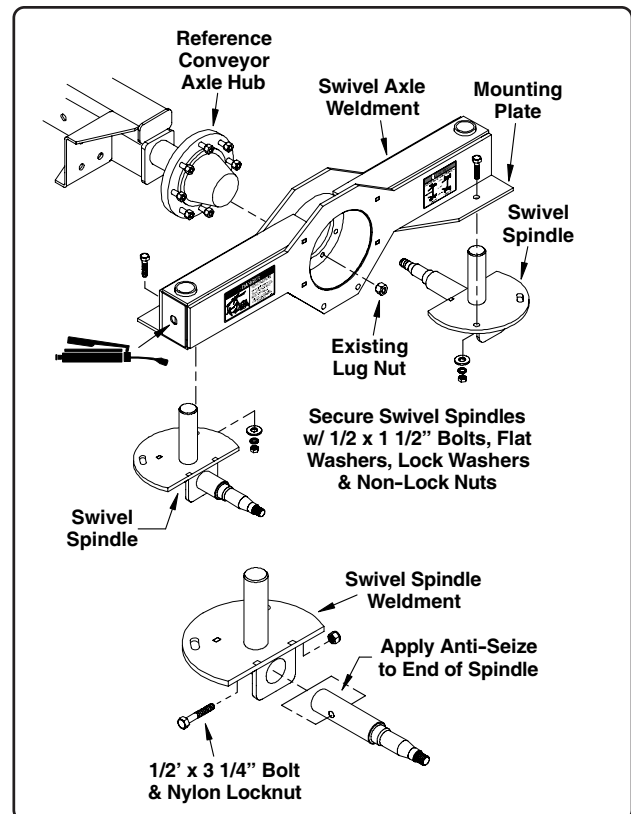


Fig. 1

**Assembly Procedures (con't.)**

6. Note the small opening on each end of the axle weldment. These allow access to lubrication fittings for the shaft on the swivel weldment. Apply one to two pumps of a good quality lithium based grease and rotate the swivel weldment back and forth a few times to help disperse the grease.

**Hub Assembly**

1. Pack both bearing cones with a good quality axle grease and using the same type grease, fill the hub cavity about one-third (1/3) full.
2. Place the inner bearing into the hub. Press the grease seal into the hub and carefully install the hub onto the spindle of the swivel weldment (See Fig. 2).
3. Install the outer bearing onto the spindle and push it into the hub cavity as far as possible.
4. Slide a flat washer onto the spindle and thread on the 7/8" slotted nut.

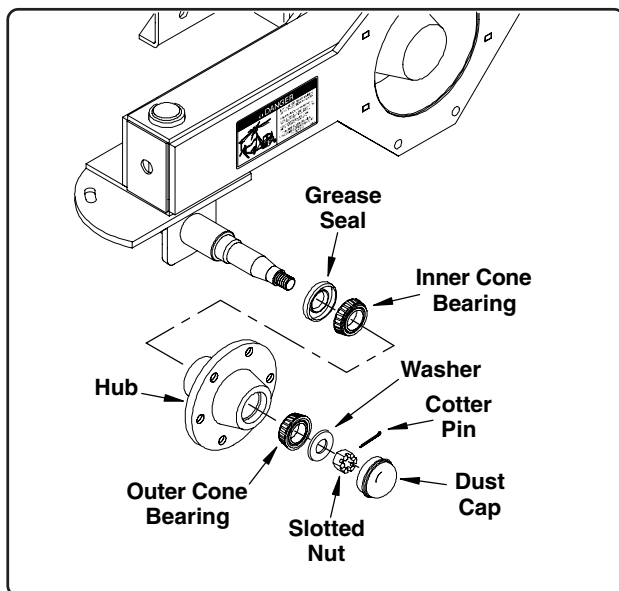


Fig. 2

5. Tighten the nut to seat the bearing. As the nut is being tightened, rotate the hub every so often until it begins to bind as it is being rotated. Back the nut off to the next slot and install a 1/8" x 1 1/2" cotter pin. Install dust cap.

6. Once the hubs have been properly installed onto the spindles of the swivel weldments, mount the tire and rims using the lug bolts furnished with the kit.

Check tires for correct pressure. Inflate to the manufacturers recommendation listed on the tires.

7. Repeat these procedures on the opposite side of the conveyor to complete installation of this kit.

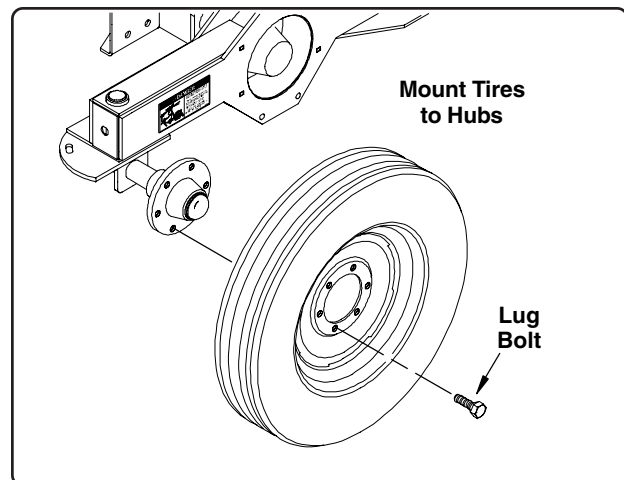


Fig. 3



**CAUTION!** When raising the conveyor axle, *Do Not* rely solely on hydraulic jacks, mechanical jacks or overhead hoist's for support. Use appropriate jack stands or equivalent for supporting the unit.

When rotating the tires to transport or swivel position, it works best to jack the end of the axle up just high enough for the tires to clear the ground. They can then be rotated easily to the desired position.

General Information



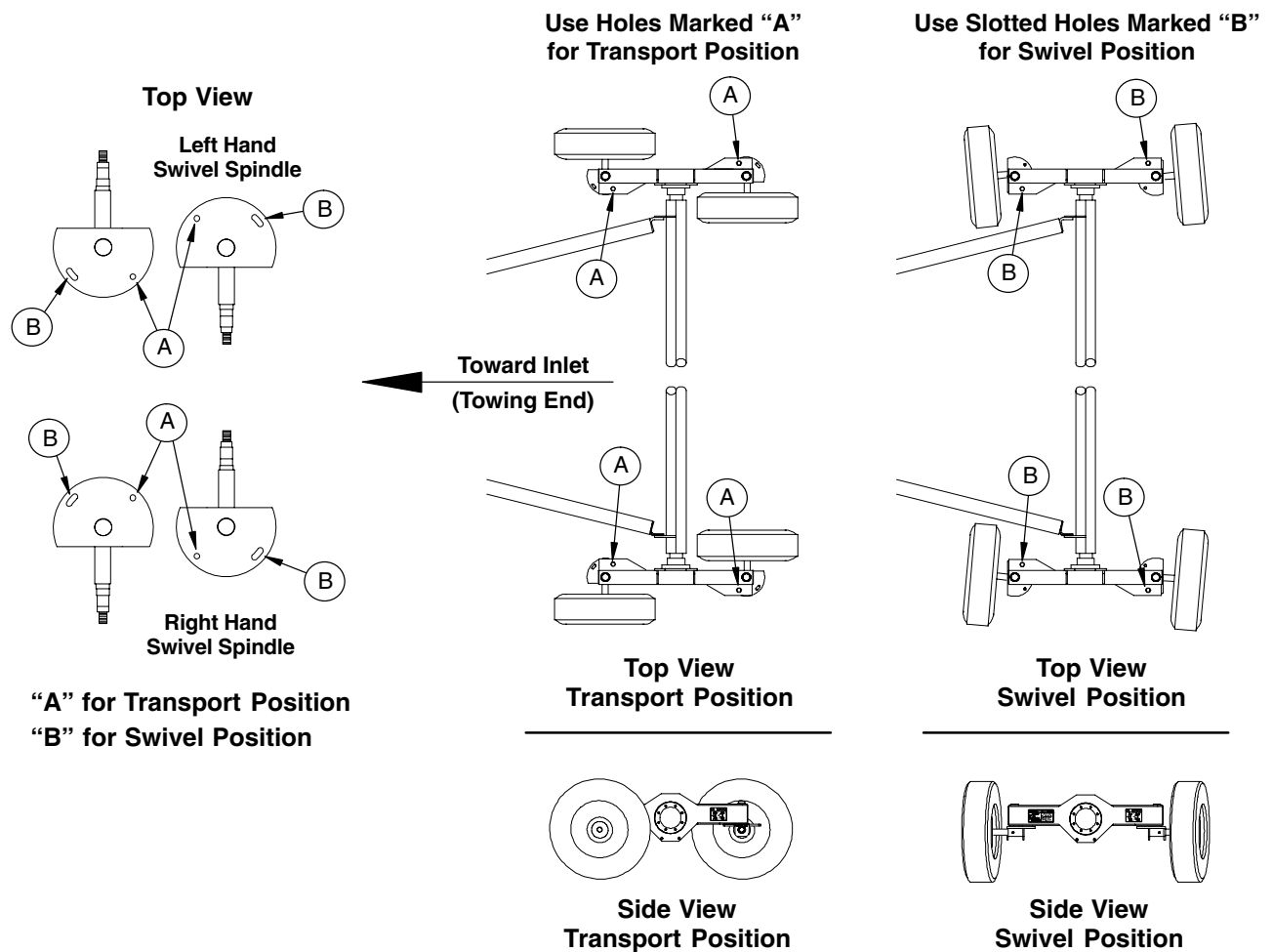
**CAUTION!** Be aware of power lines and any other obstacles that may cause hazardous conditions when transporting the conveyor.

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

When transporting conveyor, be sure the 1/2" x 1 1/2" bolts securing the swivel weldments are tight.

Use holes marked "A" for transport position. Note: The wheels must be in the transport position when raising or lowering the conveyor.

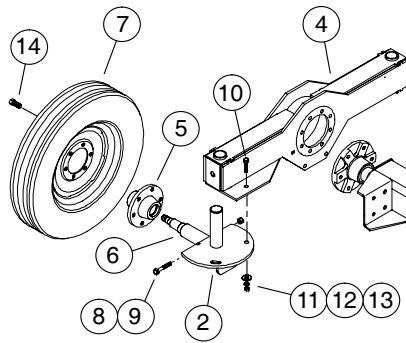
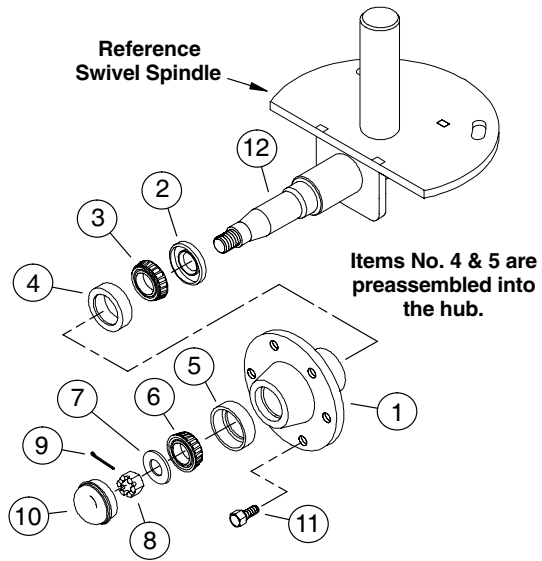
For swinging the conveyor in an arc, the slotted holes marked "B" should be used. Make sure to align the wheels properly to prevent skidding when moving the conveyor in an arc.



**PARTS LIST for  
SWIVEL ARC KIT, PART NO. P3076A8**

**Hub Assembly**

| Ref. No. | Part No. | Description                   |
|----------|----------|-------------------------------|
| 1        | 1025911  | Wheel Hub, 6-Bolt             |
| 2        | 1026088  | Grease Seal                   |
| 3        | 1026089  | Inner Cone Bearing            |
| 4        | 1026090  | Inner Bearing Cup             |
| 5        | 3148R1   | Outer Bearing Cup             |
| 6        | 3079R1   | Outer Cone Bearing            |
| 7        | D1148    | Washer, 2" O.D. x 15/16" I.D. |
| 8        | D1147    | Nut, Castle (slotted), 7/8-14 |
| 9        | 107230   | Cotter Pin, 5/32" x 1 3/4"    |
| 10       | 107234   | Dust Cap                      |
| 11       | 106241   | Lug Bolt, 1/2-20 x 1"         |
| 12       | 1039670  | Spindle                       |



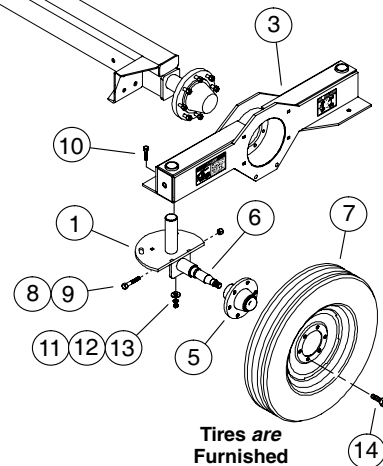
Reference  
Conveyor Axle  
and Existing Hubs

The ends of each swivel axle have openings for access to grease zerks. Grease periodically using a good quality lithium based lubricant.

Towards  
Discharge End

**Axle Weldment Components**

| Ref. No. | Part No. | Description                              |
|----------|----------|--|
| 1        | 1039662  | Swivel Weldment (RH)                     |
| 2        | 1039663  | Swivel Weldment (LH)                     |
| 3        | 1039646  | Swivel Axle Weldment (RH)                |
| 4        | 1039647  | Swivel Axle Weldment (LH)                |
| 5        | 1029511  | Wheel Hub, 6-Bolt                        |
| 6        | 1039670  | Spindle                                  |
| 7        | 1026197  | Wheel & Tire Assembly<br>16" x 6" 6-bolt |
| 8        | 1007473  | Bolt, 1/2-13 x 3 1/4"                    |
| 9        | 33138    | Nut, 1/2-13 Nylon Lock                   |
| 10       | 1002227  | Bolt, 1/2-13 x 1 1/2"                    |
| 11       | 33025    | Washer, 1/2" Flat                        |
| 12       | D1143    | Washer, 1/2" Lock                        |
| 13       | D1169    | Nut, 1/2-13 Non-Lock                     |
| 14       | 106241   | Lug Bolt 1/2-20 x 1"                     |



Tires are  
Furnished





## ***Hutchinson/Mayrath***

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