

INSTALLATION INSTRUCTIONS



The Safety Symbol shown is used throughout these instructions to alert you to information about unsafe actions or situations and will be followed by the word **DANGER**, **WARNING** or **CAUTION**. **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.

SWIVEL ARC KIT, PART NO. P3074A FOR 72' & 82' 10" PORTABLE GRAIN PUMPS®

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 the 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 mechanical jacks, hydraulic jacks or overhead hoist's for support. Use appropriate jack stands or equivalent for supporting the unit.

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. Use jack stands or equivalent to support the axle.

2. Locate the existing reflectors that are attached to the left and right sides of the conveyors' undercarriage. Remove the reflectors and retain the hardware.

The kit contains a reflector location bracket, attach these brackets to the same location from which the reflectors were removed. Secure each bracket using two (2) 5/16" x 1" bolts and nylon locknuts.

Attach the reflectors to the brackets using the hardware previously removed.

3. Mount the swivel axle weldments onto the existing hubs on each end of the conveyor axle as shown in Fig. 1. Secure each axle weldment to the conveyor hub using six (6) 1/2" x 1" lug bolts.

4. Locate the two right and the two left hand wheel pivot axles from the kit (See Fig. 1). Insert the right hand pivot axles into the sleeves located on each end of the right side swivel axle, insert the left hand pivot axles into the sleeves on the left side swivel axle.

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

The bottom of each axle weldment has a mounting tab (one to the inside and one to the outside). Secure the pivot axles to the mounting tab 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).

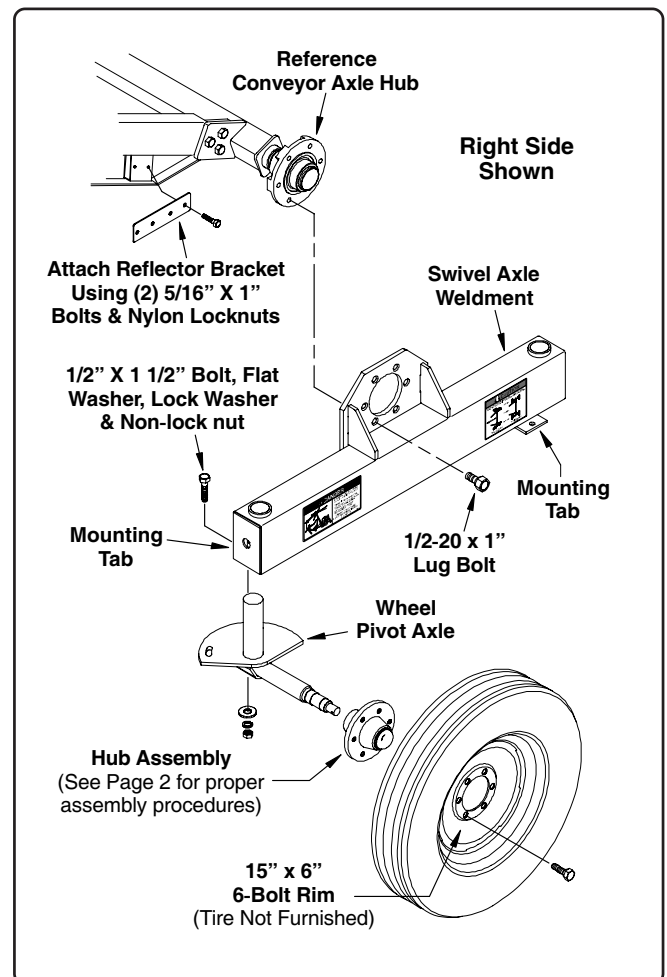


Fig. 1

Hub Assembly

Use the illustration on Page 3 for reference during assembly.

Note: The tires are not furnished with the kit. You can obtain them locally, order them through your dealer, or purchase them directly from the factory. Inflate tires to the manufacturer's recommendation listed on the tire.

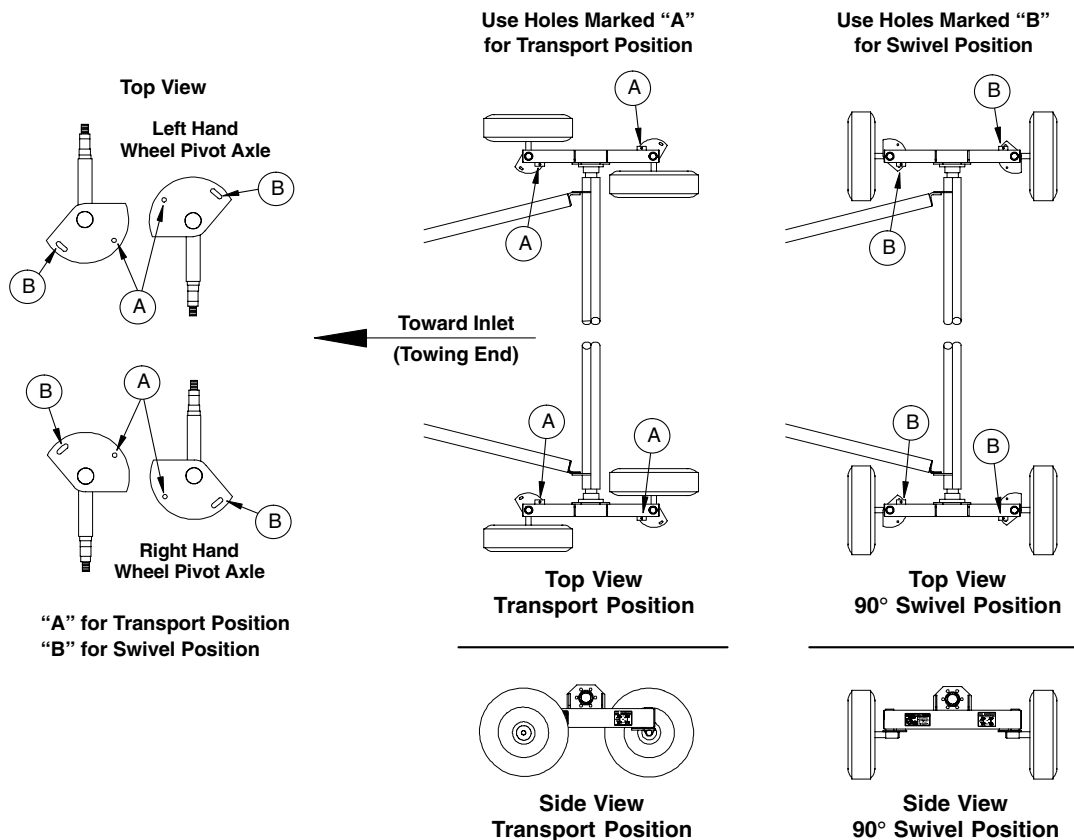
1. Pack both bearing cones with a good quality axle grease and using the same type grease, fill the hub cavity one-third full.
2. Place the inner bearing into the hub. Press the grease seal onto the hub and carefully install the hub onto the axle shaft (be careful not to damage the lip on the grease seal).
3. Install the outer bearing onto the axle shaft and push bearing into the hub cavity as far as possible. Slide a flat washer onto the shaft and secure with the 7/8" castle nut (slotted nut).
4. 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.
5. Once the hubs have been properly installed, mount the tire and rims using the lug bolts furnished with the kit.

General Information



CAUTION

- When installed, this kit will increase transport height of the conveyor. Be aware of power lines and 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.



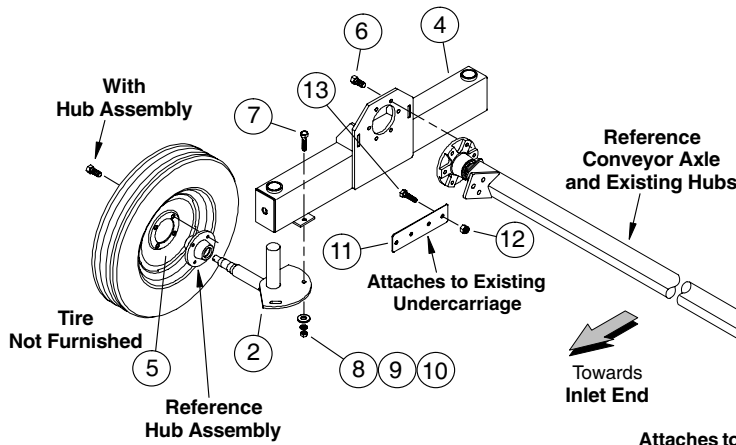
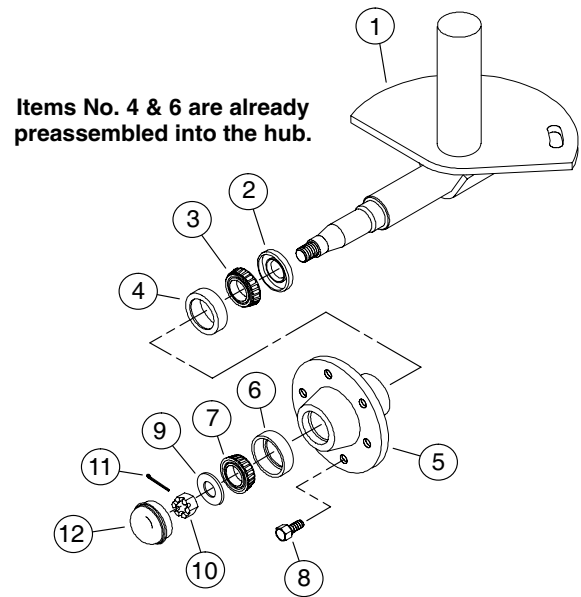
When transporting conveyor, be sure the 1/2" x 1 1/2" bolts securing the wheel pivot weldments are tight. Use holes marked "A" for transport position.

For swinging 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.

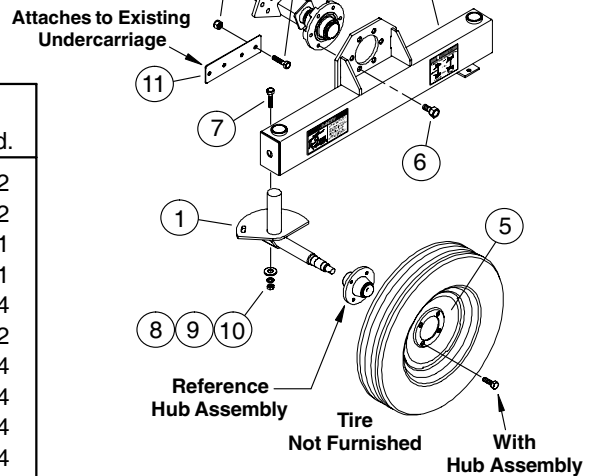
SWIVEL ARC KIT, PART NO. P3074A for 72' & 82' PORTABLE GRAIN PUMPS®

Ref No.	Part No.	Description	No. Req'd.
1	1028285	Swivel, Wheel Pivot (RH)	2
(1)	1028286	Swivel, Wheel Pivot (LH)	2
2	D1072	Grease Seal	4
3 *	3078R1	Inner Cone Bearing	4
4 *	3147R1	Inner Bearing Cup	4
5	D1251	Wheel Hub, 6 bolt 1 3/4" bore	4
6 *	3148R1	Outer Bearing Cup	4
7 *	3079R1	Outer Cone Bearing	4
8	106241	Lug Bolt, 1/2-20 x 1"	24
9	D1148	Washer, 2" O.D. x 15/16" I.D.	4
10	D1147	Nut, Castle, 7/8-14	4
11	D1146	Cotter Pin, 5/32" x 1 1/4"	4
12	40588	Dust Cover	4

* 3078R1 – Timken Part No. LM48548
 3147R1 – Timken Part No. LM48510
 3148R1 – Timken Part No. LM67010
 3079R1 – Timken Part No. LM67048



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



Ref No.	Part No.	Description	No. Req'd.
1	1028285	Swivel Wheel Pivot (RH)	2
2	1028286	Swivel Wheel Pivot (LH)	2
3	1032264	Swivel Axle Weldment (RH)	1
4	1032268	Swivel Axle Weldment (LH)	1
5	D1252	Wheel, 15" x 6" 6-bolt	4
6	106241	Lug Bolt, 1/2-20 x 1"	12
7	1002227	Bolt, 1/2-13 x 1 1/2"	4
8	33025	Washer, 1/2" flat	4
9	D1143	Washer, 1/2" lock	4
10	D1169	Nut, 1/2-13 non-lock	4
11	1032440	Bracket, reflector location	2
12	33135	Nut, 5/16-18 nylon lock	4
13	33046	Bolt, 5/16-18 x 1"	4



Hutchinson/Mayrath

A Division of GLOBAL Industries, Inc.

Hutchinson/Mayrath • P.O. Box 629 • Clay Center, KS. 67432
Ph. 785-632-2161 • Fx. 785-632-5964 • Toll Free 800-523-6993