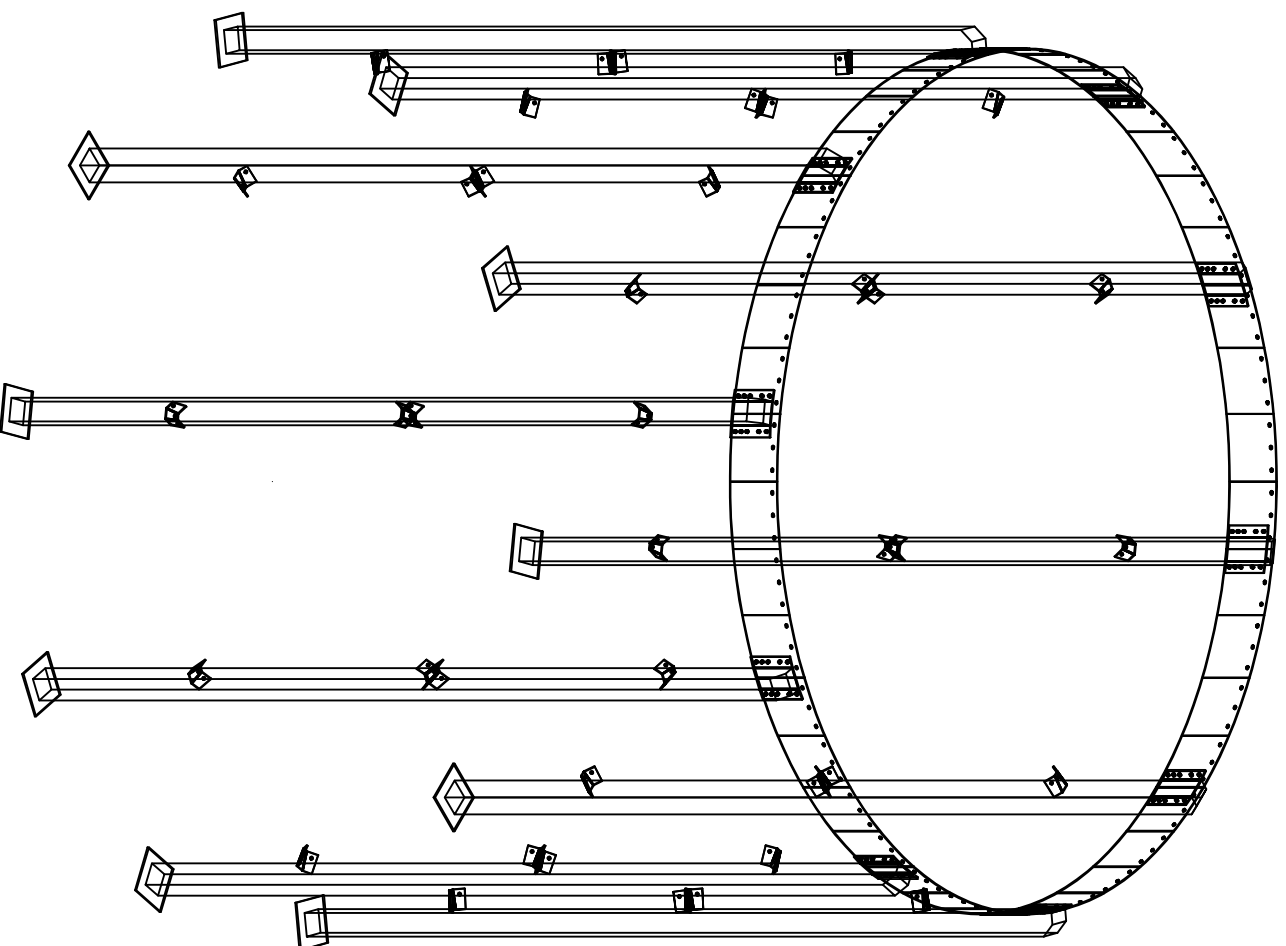


STEP 1:

- Verify that all parts are available according to the packing slip.
- If a skid is used, go to step 2. If no skid is used, go to step 3.

STEP 2:

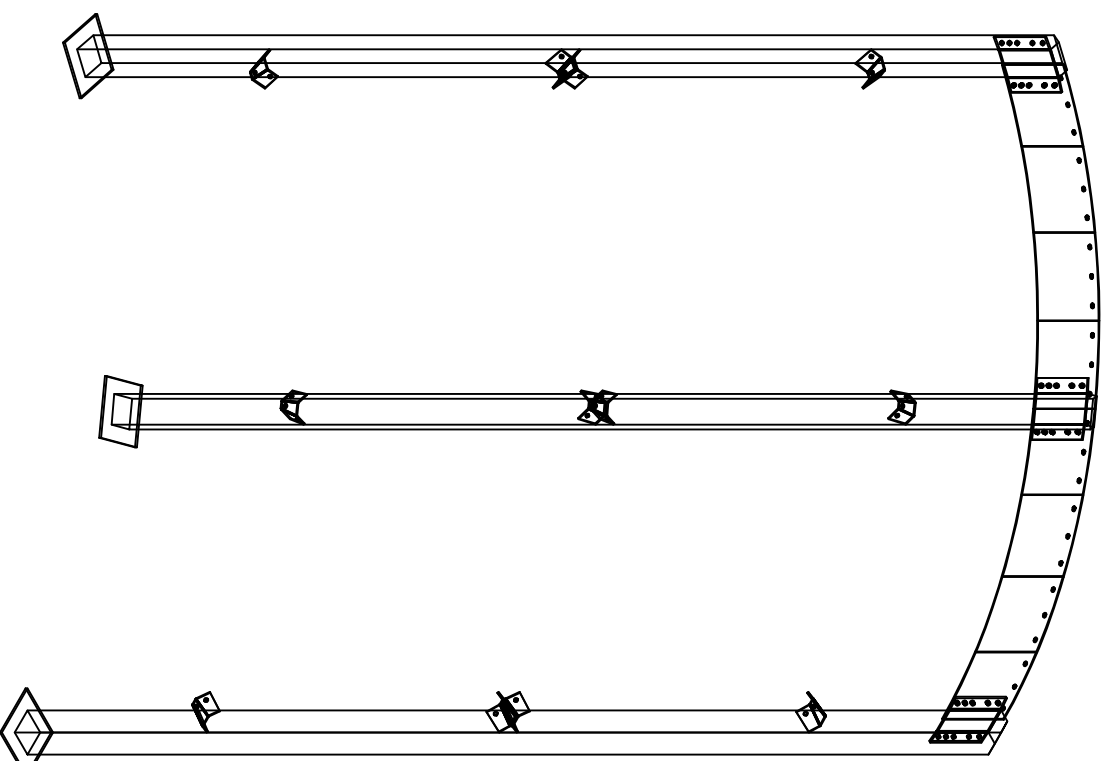
- If a skid foundation is used, set up the skid with the 5/8" hardware provided.
 - Level the skid and tighten the skid bolts. Support the skid on 4" x 4" blocks (Not supplied) to allow for easy access to the bolts attaching the legs to the skid.
 - Stand the legs up and loosely attach to the skid using the 3/4" bolts.
- (Brace clips facing the inside of the cone)
- When all the legs are installed, connect the web pieces to the legs to form the ring. Use 5/8" hardware.
- Note: bolts must be installed from the outside. (Nuts will be towards the inside of the bin)



STEP 3:

- If no skid is used, assemble 3 legs to 2 pieces of band using 5/8" hardware. Note: Bolts must be installed form the outside. (the nuts will be towards the inside of the bin)
- Stand this section up and support
- Continue adding legs and band pieces until the full circle is complete. (DO NOT TIGHTEN BOLTS UNTIL FULL CIRCLE IS COMPLETE)
- Level all of the legs.

2



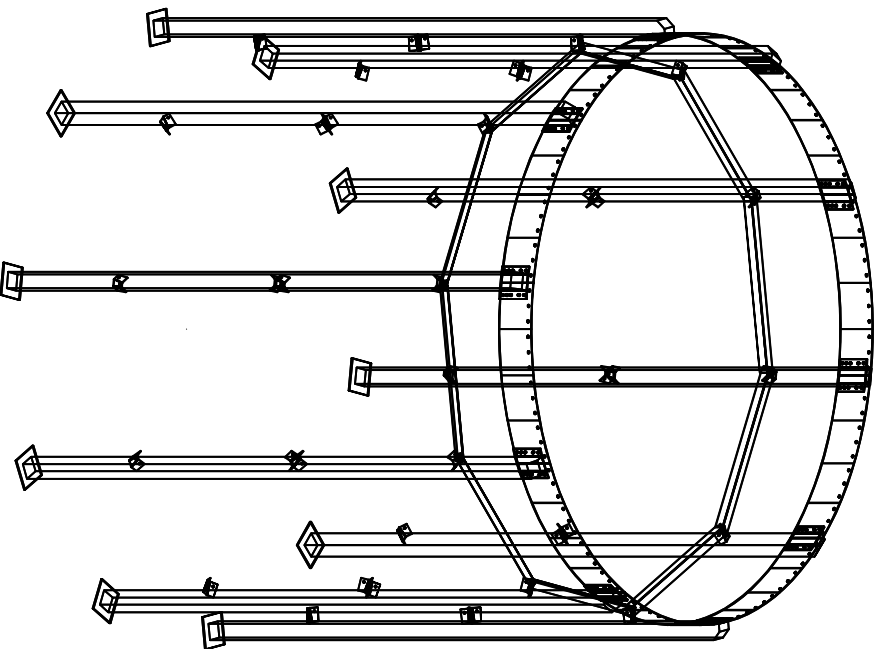
STEP 4:

- Install the upper lateral braces (galvanized angle irons). The 5/8" hardware should be left loose. The lateral braces are installed with the vertical portion facing downward to prevent holding water. 12ft cones do not have lateral braces.

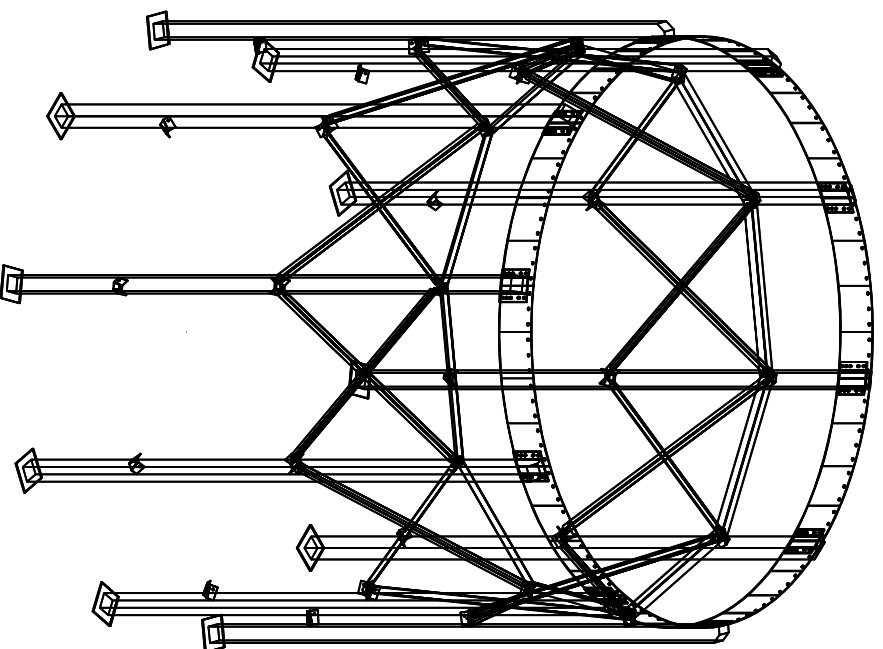
STEP 5:

- Install the channel shaped X braces in an X pattern using the 5/8" hardware. X braces are installed with the open portion of the channel downward to prevent holding water. Do not tighten the hardware.

3



Step 4



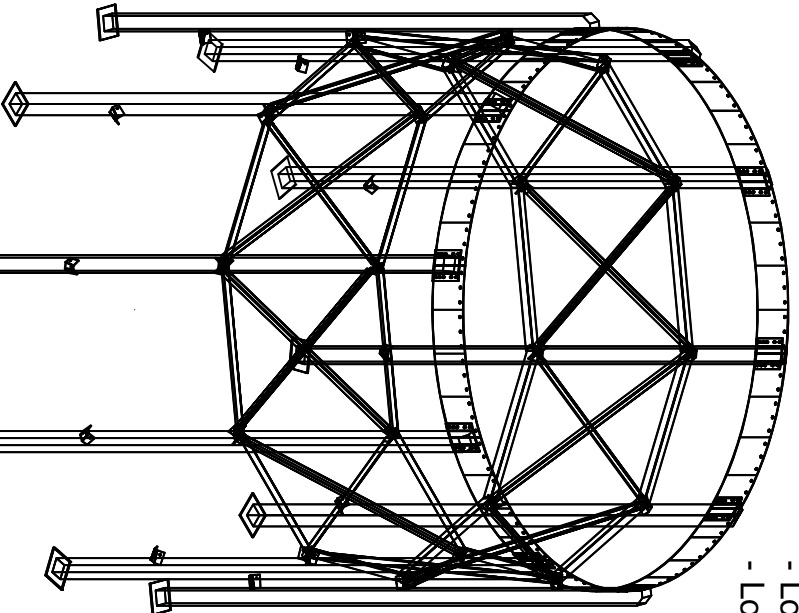
Step 5

STEP 6
- Install the second set of lateral braces between the two middle clips. Place the vertical portion of the braces downward just as with the upper lateral braces. Do not tighten the hardware

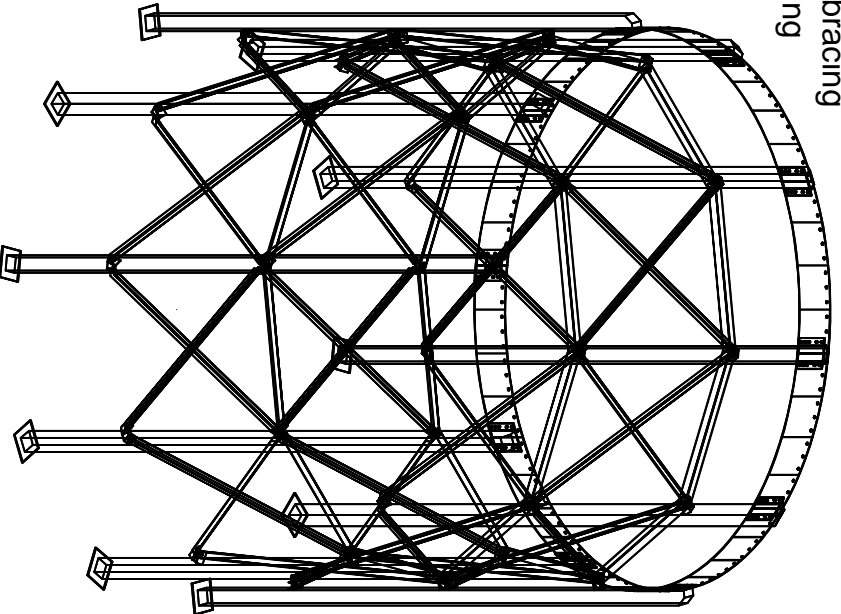
STEP 7
- Install the lower set of X braces in a X pattern with the 5/8" hardware. The open part of the channel should face downwards. Do not tighten the hardware.

STEP 8
- Tighten the hardware in the following order:

- Upper lateral bracing
- Upper X bracing
- Lower lateral bracing
- Lower X bracing



Step 6



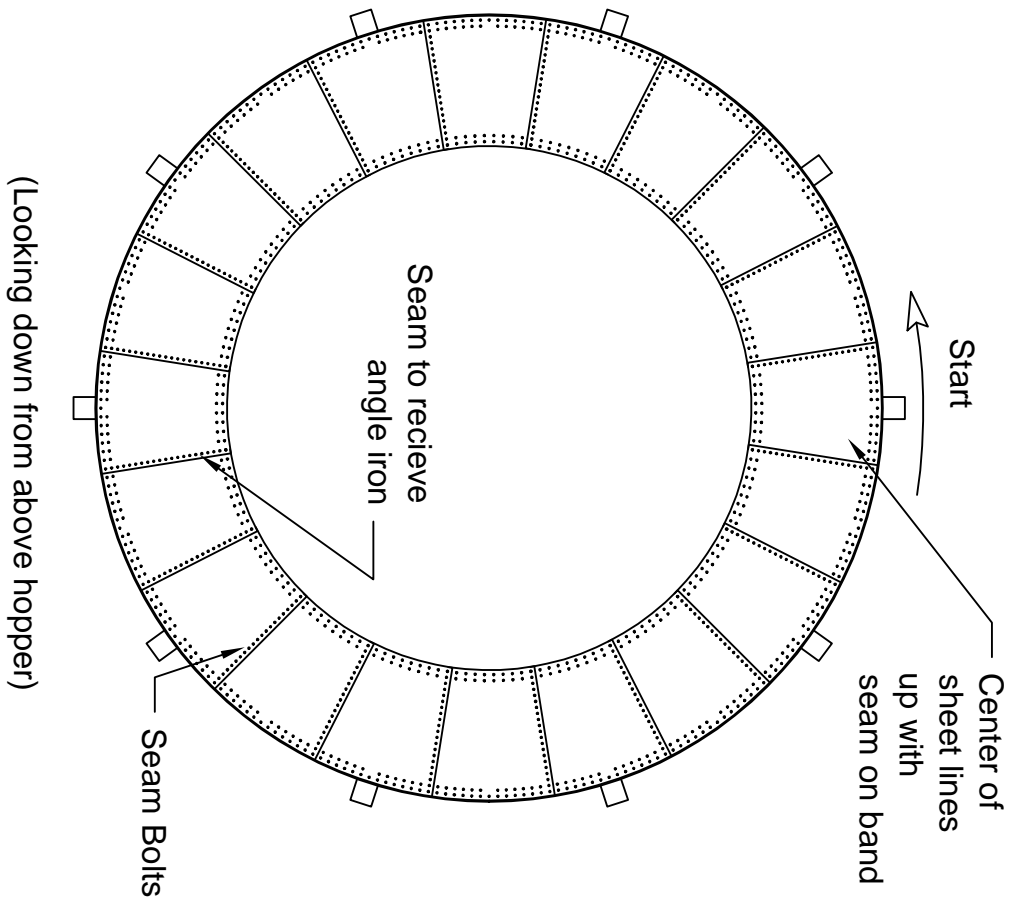
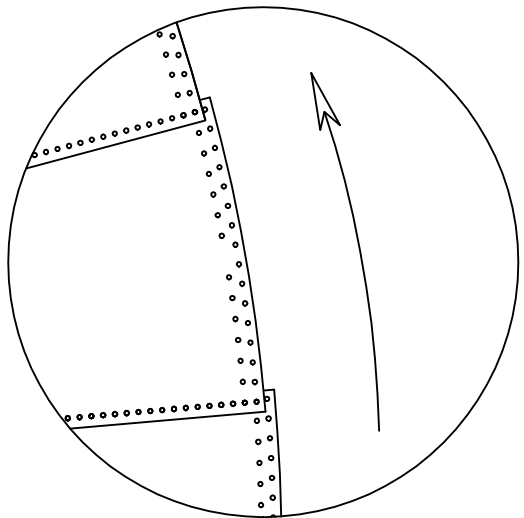
Step 7

STEP 9

- Install upper galvanized sheets on the top web starting with the center of the sheet lining up with the seam on the band. Use the 3/8" hardware. Install all band bolts and then add the next sheet in a counterclockwise direction. (Formed edge will be on outside). Install the bolts from the inside out. (the nuts will be on the outside of the cone. This ensures better clean out inside the bin). Always install the band bolts before doing the seams. Seam Angle irons must be installed on every second seam starting on the one shown.

5

Detail showing proper sheet overlap.



(Looking down from above hopper)

STEP 10:

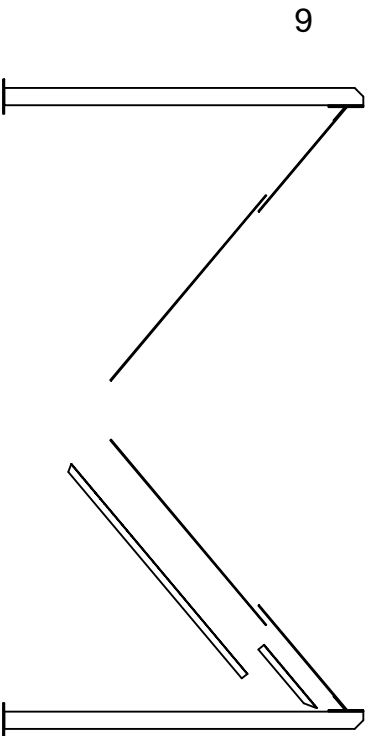
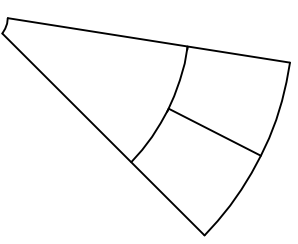
Install the lower galvanized sheets

1: align the seams on the first top and bottom sheet

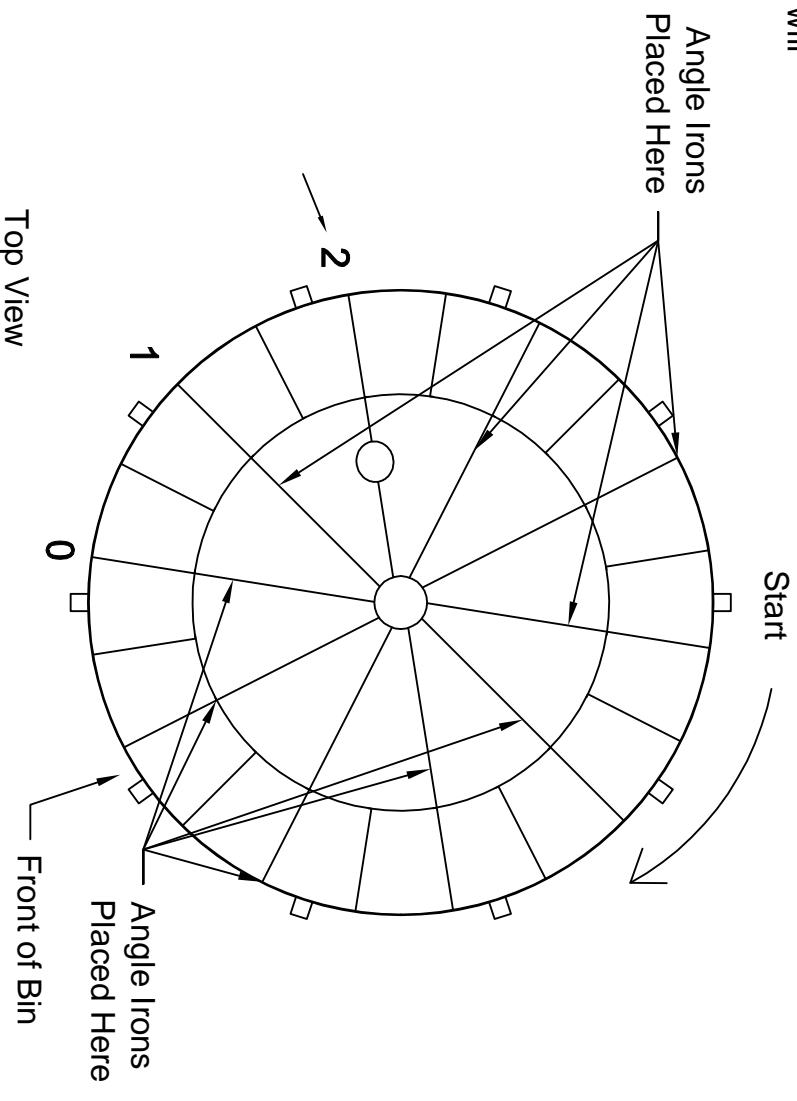
2: Bottom sheet laps over the upper sheet to the outside.

3: Proceed in **CLOCKWISE** direction Formed edge will be on outside.

1: Line up seams.



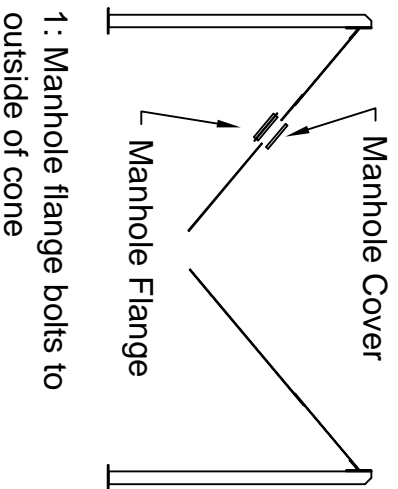
2: Bottom sheet laps over upper sheet to the outside Long angle Iron overlaps the top, shorter one by two holes. hole spacing changes from 1 3/4" at the top of the bin to 2" part way down the hopper.



3: Formed edge on outside (Looking down on hopper from above)
Note: Manhole location relative to bin front is shown above (if equipped). Seam angle irons are to be installed on every full seam.

Step 11: (if manhole equipped only)

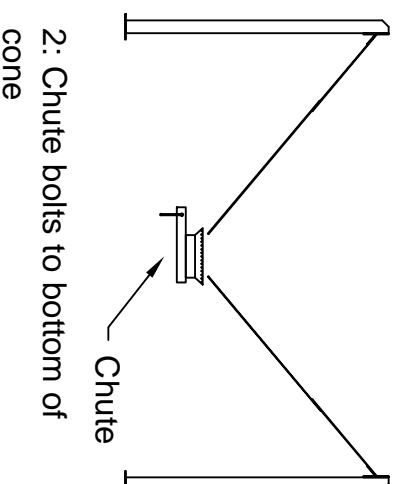
Manhole cover should be placed inside bin and manhole flange installed from outside of bin as shown below in 1.



1: Manhole flange bolts to outside of cone

Step 12:

Install Chute. Chute bolts to outside of the cone as shown in 2. The rotation of the chute relative to the front of the bin is shown in 3.



2: Chute bolts to bottom of cone

3: Chute should be installed as shown at right.

