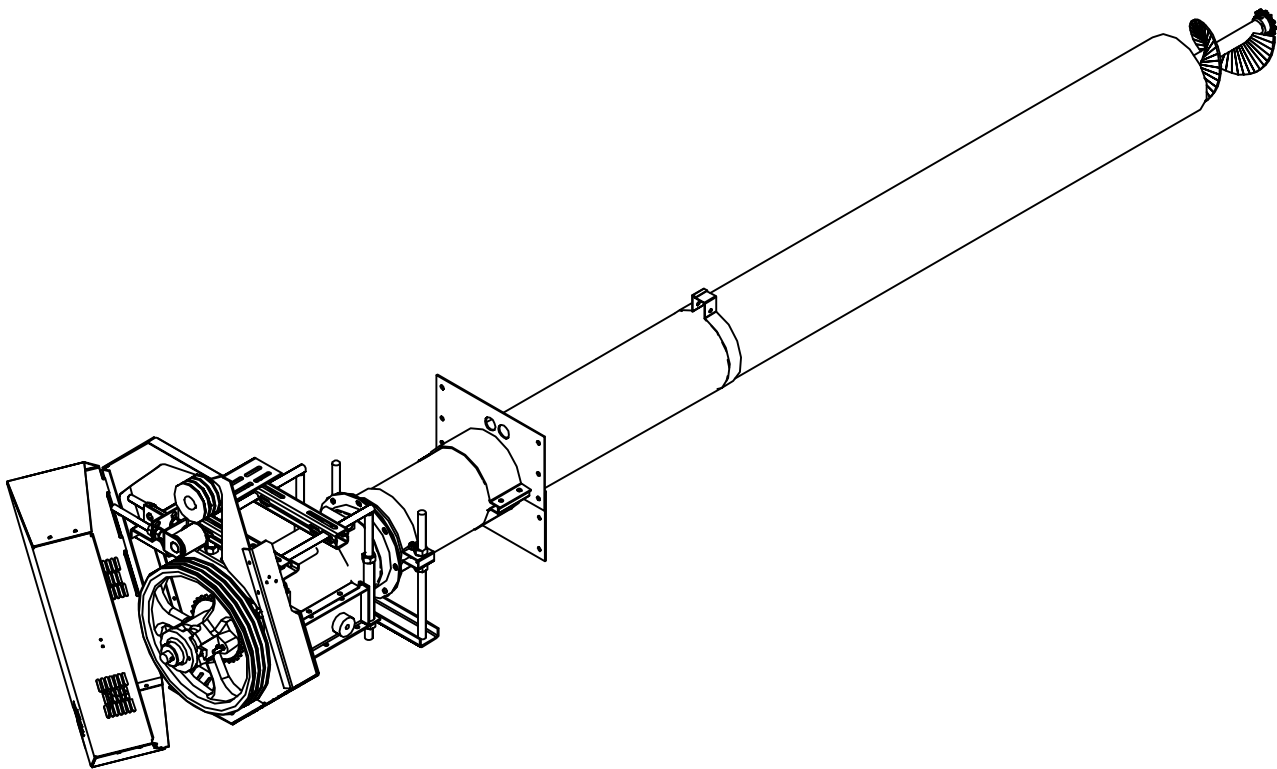




# HORIZONTAL UNLOADER PARTS MANUAL



SHIVERS MANUFACTURING, INC.  
614 W. English St.  
CORYDON, IOWA USA  
Ph.(641) 872-1005 \*\* Fax (641) 872-1593  
[www.shivers.com](http://www.shivers.com)

P-9085  
7/27/22  
REV H



# TABLE OF CONTENTS

	PAGE #
<b>6" HORIZONTAL UNLOADERS</b>	
6" HORIZONTAL UNLOADER PARTS	2-3
6" HORIZONTAL UNLOADER ACCESSORIES	4
6" TUBE WELDMENT	5
6" FLITE ASSEMBLY	6
6" FACE PLATE	7
6" CONTROL ROD GUIDE KIT	8
6" TRANSITION KIT	9
6" STAND KIT	10
6" MOTOR MOUNT KIT (STRAIGHT DOWN DISCHARGE)	11
<b>8" HORIZONTAL UNLOADERS</b>	
8" 225 SERIES HORIZONTAL UNLOADER PARTS	12-13
8" 656 SERIES HORIZ. UNLOADERS W/ HGR BRG	14-15
8" 705 HTDKSERIES HORIZ. UNLOADERS W/ HGR BRG	16-17
8" 698 DF SERIES HORIZONTAL UNLOADER	18-19
8" HORIZONTAL UNLOADER ACCESSORIES	20
8" TUBE WELDMENT	21
8" FLITE ASSEMBLY	22
8" 2 PC. FACE PLATE KIT	23
8" CONTROL ROD GUIDE KIT	24
8" TRANSITION KITS	25
8" DRI-FLO TRANSITION ASSEMBLY	26
8" STAND KIT	27
8" DRI-FLO BRACE ASSEMBLY	28
8" MOTOR MOUNT KIT (STRAIGHT DOWN DISCHARGE)	29
DRI-FLO MOTOR MOUNT ASSEMBLY	30
<b>ACCESSORIES</b>	
6" & 8" MOTOR MOUNT KIT (SIDE DISCHARGE)	31
CIRC-HU BELT SHIELD KIT	32
DRI-FLO BELT SHEILD KIT	33
15" 3 GROOVE PULLEY KIT	34
DRIVE SHAFT	35
BELT IDLER KIT	36
DRI-FLO IDLER ASSEMBLY	37
6" & 8" HORIZONTAL GRAIN OUTLET	38
3 GROOVE MOTOR PULLEYS	39
FLOOR DOOR KIT	40
6" SLIDE GATE OPENER	41
8" SLIDE GATE OPENER	41
6" & 8" SLIDE GATE OPENER, WINCH STYLE	42-43
6" INTERMEDIATE WELL	44
8" INTERMEDIATE WELL	45

# 6" HORIZONTAL UNLOADER

## (220D-001A - 220N-001A)

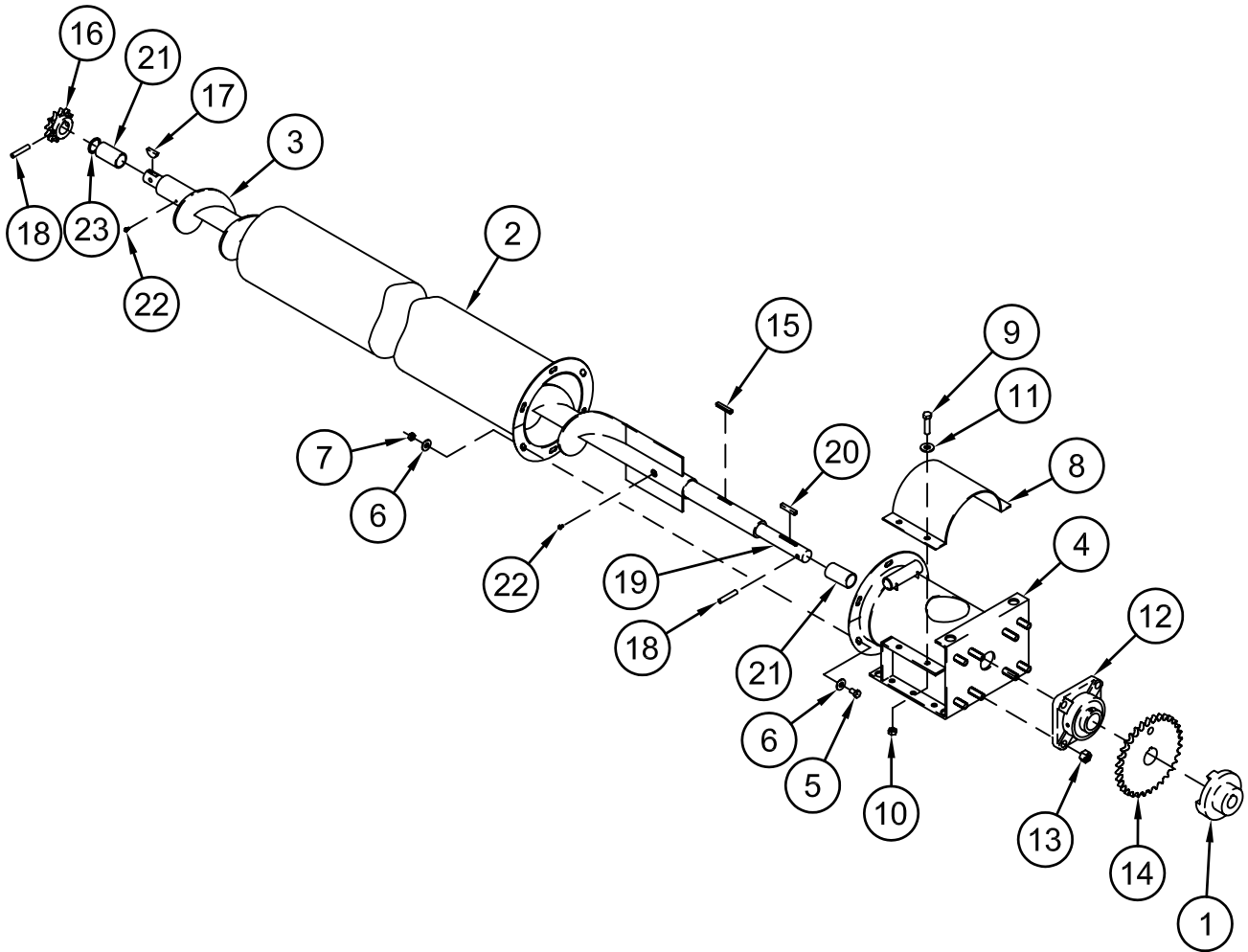
ITEM	DESCRIPTION	QTY	PART NO.	BREAK DOWN PAGE #
1	Jaw Clutch	1	220-057P	-
2	Tube Weldment	1	See Break-Down	5
3	Flite Weldment	1	See Break-Down	6
4	Transition Kit	1	See Break-Down	9
5	Capscrew, Hx, 5/16-18 X 1", Gr. 5	6	F-1015-15	-
6	Washer, Flat, Std, Steel 5/16"	12	F-1009-02	-
7	Nut, Hx, Znc Plated, 5/16-18 Nyloc	6	F-1005-02	-
8	Half Band Cover	1	220-047P	-
9	Capscrew, Hx, 3/8-16 X 1", Gr. 5	4	F-1394	-
10	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239	-
11	Washer, Flat, Std, Steel 3/8"	4	F-1009-03	-
12	Bearing, 4 Hole Flng, 1-3/8" Bore	1	D-2002-01	-
13	Nut, Hx, Znc Plated, 1/2-13 Stover	4	F-1005-05	-
14	Sprocket, 32 Tooth, 1-3/8" w/ Setscrew	1	220-007P	-
15	Key, Step	1	220-020P	-
16	Sprocket, 12 Tooth, Universal	1	D-3212	-
17	Key, Wdrf., USAS 808 1/4 X 1", #15	1	D-1004-01	-
18	Roll Pin, Double, HD, 5/16 X 1-3/4"	2	F-1036-37	-
19	Drive Shaft, 1"	1	See Break-Down	43
20	Key, 1/4" Sq. X 1-1/2"	1	435-025P	-
21	Bronze Bushing	2	220-005P	-
22	Grease Fitting	2	H-1010-01	-
23	O-Ring, 1" ID X 1.25D X 1.25	1	D-3639	-

	ASSEMBLY NUMBER	BIN DIAMETER	TUBE WLDT. NUMBER	AUGER ASSY. NUMBER	DRIVE SHAFT NUMBER
<b>CIRCULATOR</b>	220D-001A	15'11-18'7	220D-042W	220D-059A	220D-058P
	220E-001A	18'8-22'0	220E-042W	220E-059A	220E-058P
	220F-001A	22'1-24'9	220F-042W	220F-059A	220F-058P
	220G-001A	24'10-27-10'	220G-042W	220G-059A	220G-058P
	220H-001A	27'11-31'0	220H-042W	220H-059A	220H-058P
	220I-001A	31'1-34'0	220I-042W	220I-059A	220I-058P
	220J-001A	34'1-38'0	220J-042W	220J-059A	220J-058P
<b>DRI-FLO</b>	220E-001A	15'11-18'7	220E-042W	220E-059A	220E-058P
	220F-001A	18'8-22'0	220F-042W	220F-059A	220F-058P
	220G-001A	22'1-24'9	220G-042W	220G-059A	220G-058P
	220H-001A	24'10-27-10'	220H-042W	220H-059A	220H-058P
	220I-001A	27'11-31'0	220I-042W	220I-059A	220I-058P
	220J-001A	31'1-34'0	220J-042W	220J-059A	220J-058P
	220L-001A	34'1-38'0	220L-042W	220L-059A	220L-058P
	220M-001A	38'1-42'0	220M-042W	220M-059A	220M-068W
	220N-001A	46'1-50'0	220N-042W	220N-059A	220N-068W



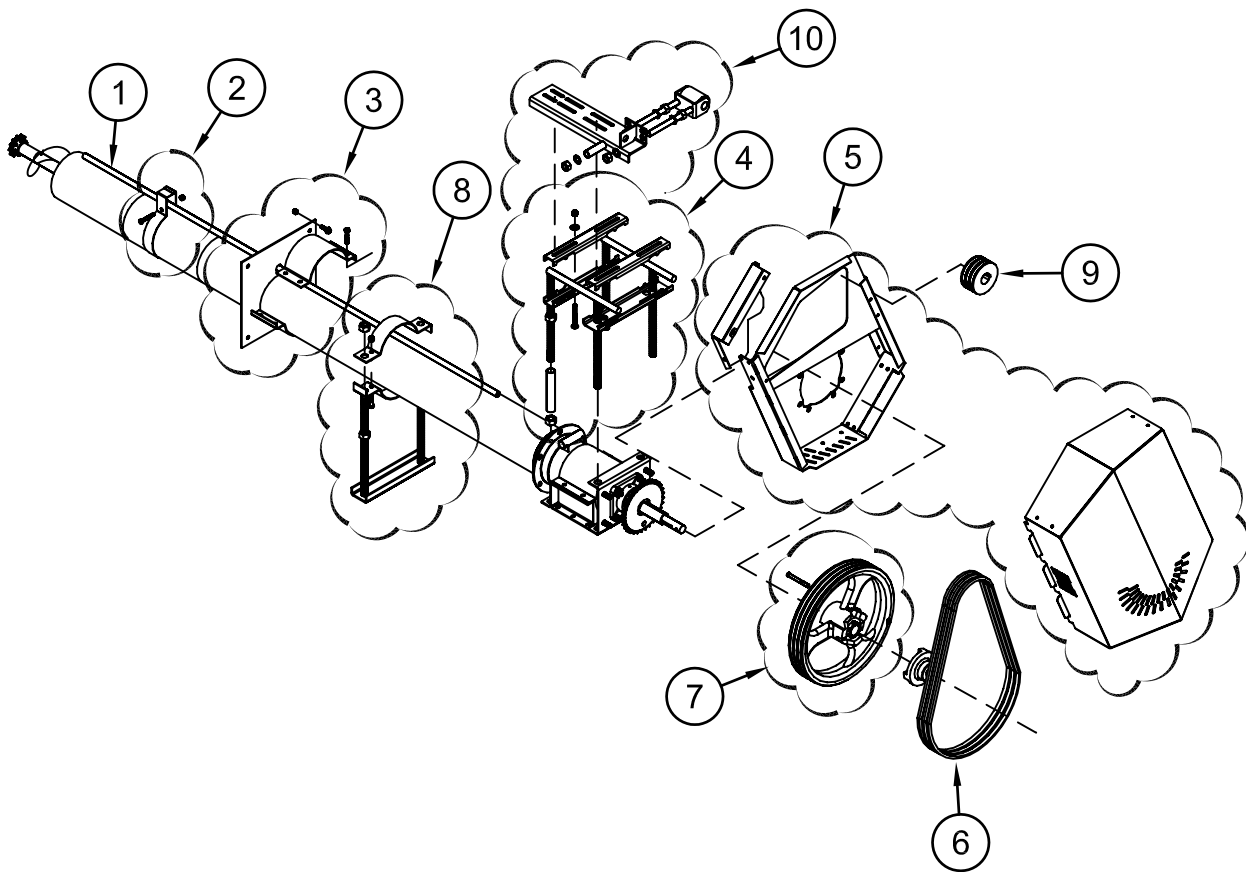
# 6" HORIZONTAL UNLOADER

(220D-001A - 220N-001A)



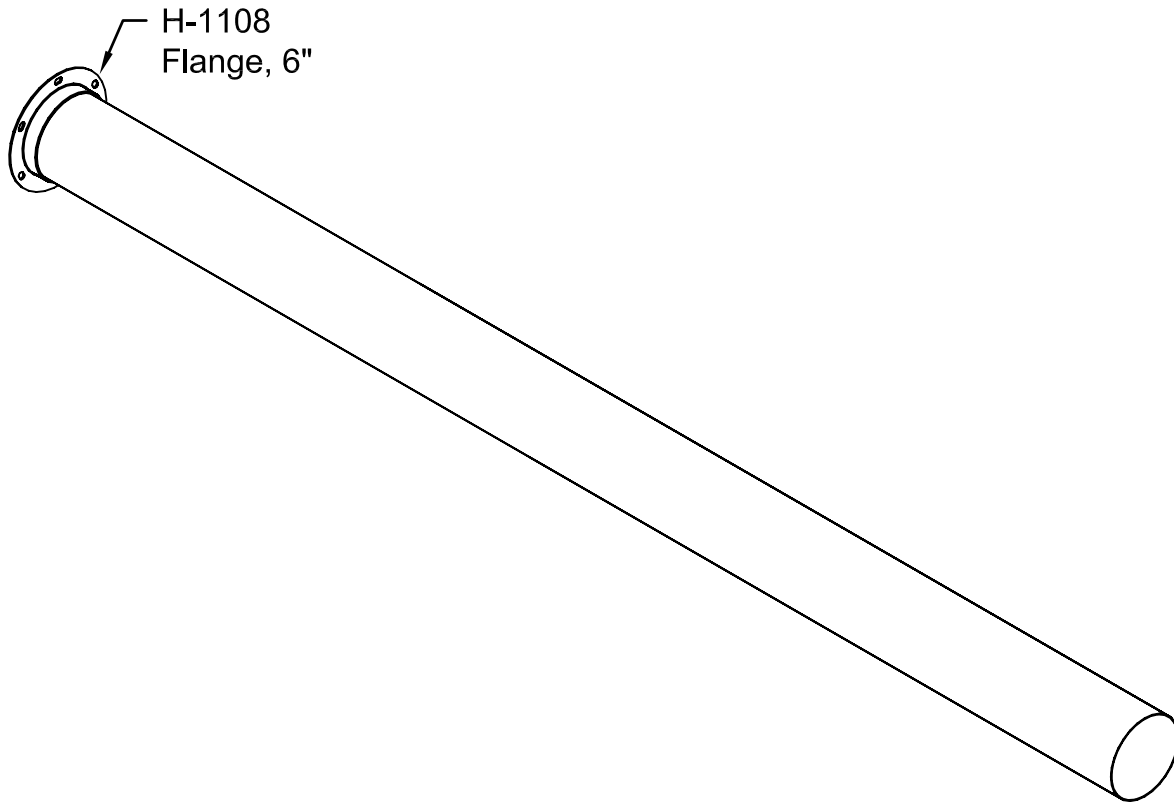
# 6" HORIZONTAL UNLOADER ACCESSORIES

ITEM	DESCRIPTION	QTY	PART NO.	BREAK DOWN PAGE #
1	Control Rod	1	See Break-Down	8
2	Control Rod Guide Kit	1	423-004-001A	8
3	Face Plate Weldment	1	See Break-Down	7
4	Motor Mount Kit	1	423-001-001A	11
5	Circ HU Belt Shield Kit	1	423-348-001A	40
-	Belt Shield Kit (DISCONTINUED)	-	423-003-001A	39
6	V-Belt, P-Cord AX60	3	D-3003-12	-
7	15" 3 Groove Pulley	1	423-067-001A	42
8	Stand Kit	1	423-002-001A	10
9	Motor Pulley	1	See Break-Down	47
10	Belt Idler Kit	1	97D-001A	44



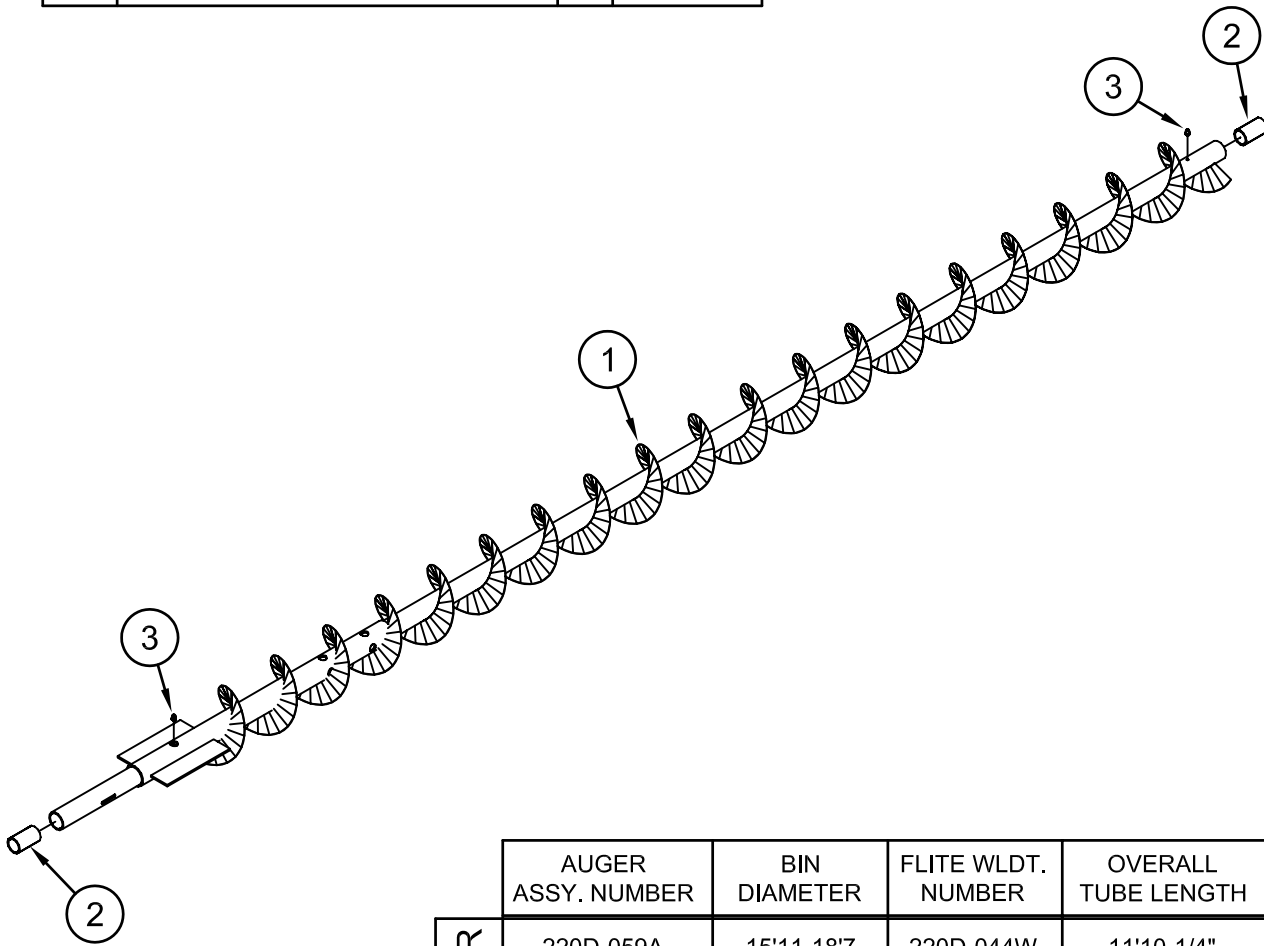
## 6" TUBE WELDMENT (220D-042W - 220N-042W)

	DESCRIPTION	FLITE WLDT. NUMBER	BIN DIAMETER
<b>CIRCULATOR</b>	Tube Weldment, 6" OD, 9'6" Long	220D-042W	15'11-18'7
	Tube Weldment, 6" OD, 11'1" Long	220E-042W	18'8-22'0
	Tube Weldment, 6" OD, 12'5-1/2" Long	220F-042W	22'1-24'9
	Tube Weldment, 6" OD, 14'0" Long	220G-042W	24'10-27-10'
	Tube Weldment, 6" OD, 15'7" Long	220H-042W	27'11-31'0
	Tube Weldment, 6" OD, 17'1" Long	220I-042W	31'1-34'0
	Tube Weldment, 6" OD, 19'1-1/2" Long	220J-042W	34'1-38'0
<b>DRI-FLO</b>	Tube Weldment, 6" OD, 11'1" Long	220E-042W	15'11-18'7
	Tube Weldment, 6" OD, 12'5-1/2" Long	220F-042W	18'8-22'0
	Tube Weldment, 6" OD, 14'0" Long	220G-042W	22'1-24'9
	Tube Weldment, 6" OD, 15'7" Long	220H-042W	24'10-27-10'
	Tube Weldment, 6" OD, 17'1" Long	220I-042W	27'11-31'0
	Tube Weldment, 6" OD, 19'1-1/2" Long	220J-042W	31'1-34'0
	Tube Weldment, 6" OD, 21'1" Long	220L-042W	34'1-38'0
	Tube Weldment, 6" OD, 25'0" Long	220M-042W	38'1-42'0
	Tube Weldment, 6" OD, 27'0" Long	220N-042W	46'1-50'0



# 6" FLITE ASSEMBLY (220D-059A - 220N-059A)

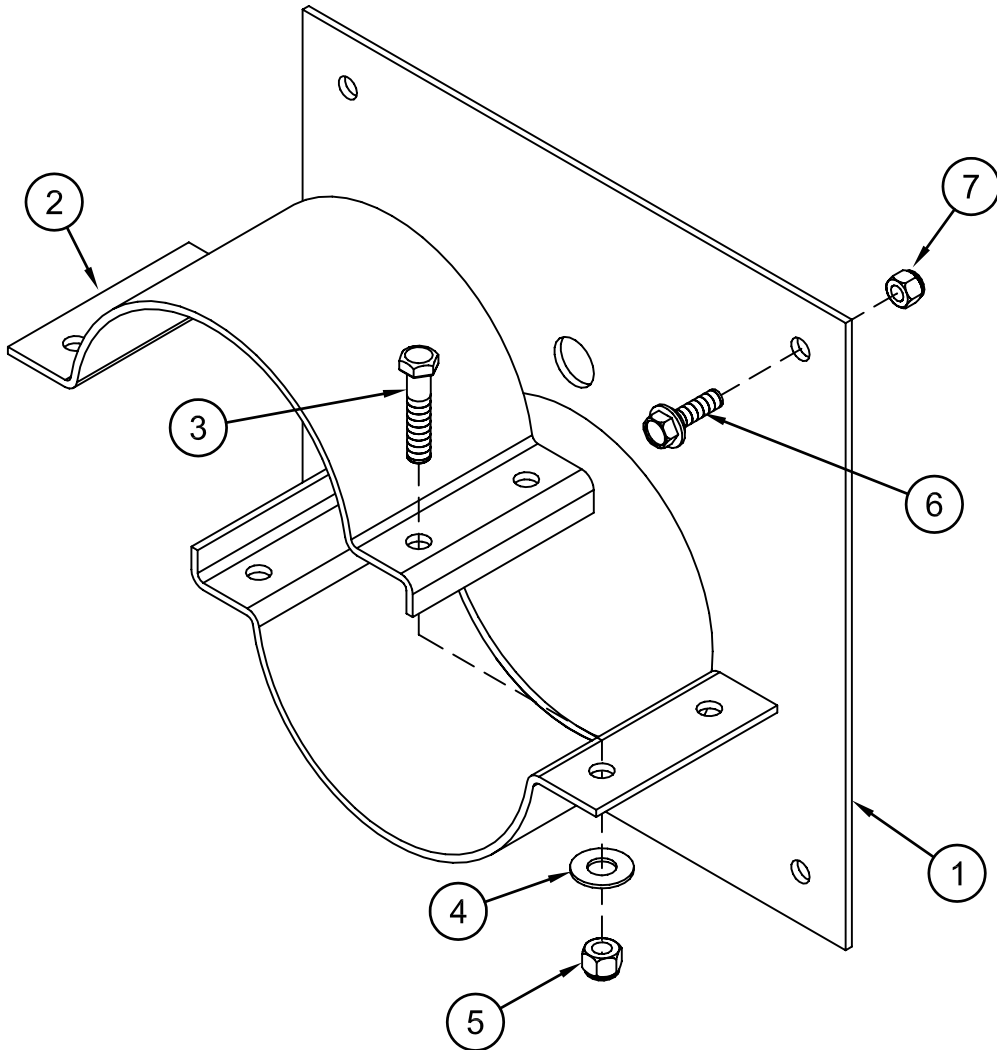
ITEM	DESCRIPTION	QTY	PART NO.
1	Flite Weldment, 6" Horizontal Circulator	1	See Chart
2	Bronze Bushing	2	220-005P
3	Fitting Grease, 1/8" Drive-in	1	H-1010-01



	AUGER ASSY. NUMBER	BIN DIAMETER	FLITE WLDT. NUMBER	OVERALL TUBE LENGTH
<b>CIRCULATOR</b>	220D-059A	15'11-18'7"	220D-044W	11'10-1/4"
	220E-059A	18'8-22'0"	220E-044W	13'5-1/4"
	220F-059A	22'1-24'9"	220F-044W	14'9-3/4"
	220G-059A	24'10-27-10"	220G-044W	16'4-1/4"
	220H-059A	27'11-31'0"	220H-044W	17'11-1/4"
	220I-059A	31'1-34'0"	220I-044W	19'5-1/4"
	220J-059A	34'1-38'0"	220J-044W	21'5-3/4"
<b>DRI-FLO</b>	220E-059A	15'11-18'7"	220E-044W	13'5-1/4"
	220F-059A	18'8-22'0"	220F-044W	14'9-3/4"
	220G-059A	22'1-24'9"	220G-044W	16'4-1/4"
	220H-059A	24'10-27-10"	220H-044W	17'11-1/4"
	220I-059A	27'11-31'0"	220I-044W	19'5-1/4"
	220J-059A	31'1-34'0"	220J-044W	21'5-3/4"
	220L-059A	34'1-38'0"	220L-044W	23'5-3/4"
	220M-059A	38'1-42'0"	220M-044W	27'4-1/2"
	220N-059A	46'1-50'0"	220N-044W	29'4-1/2"

# 6" FACE PLATE

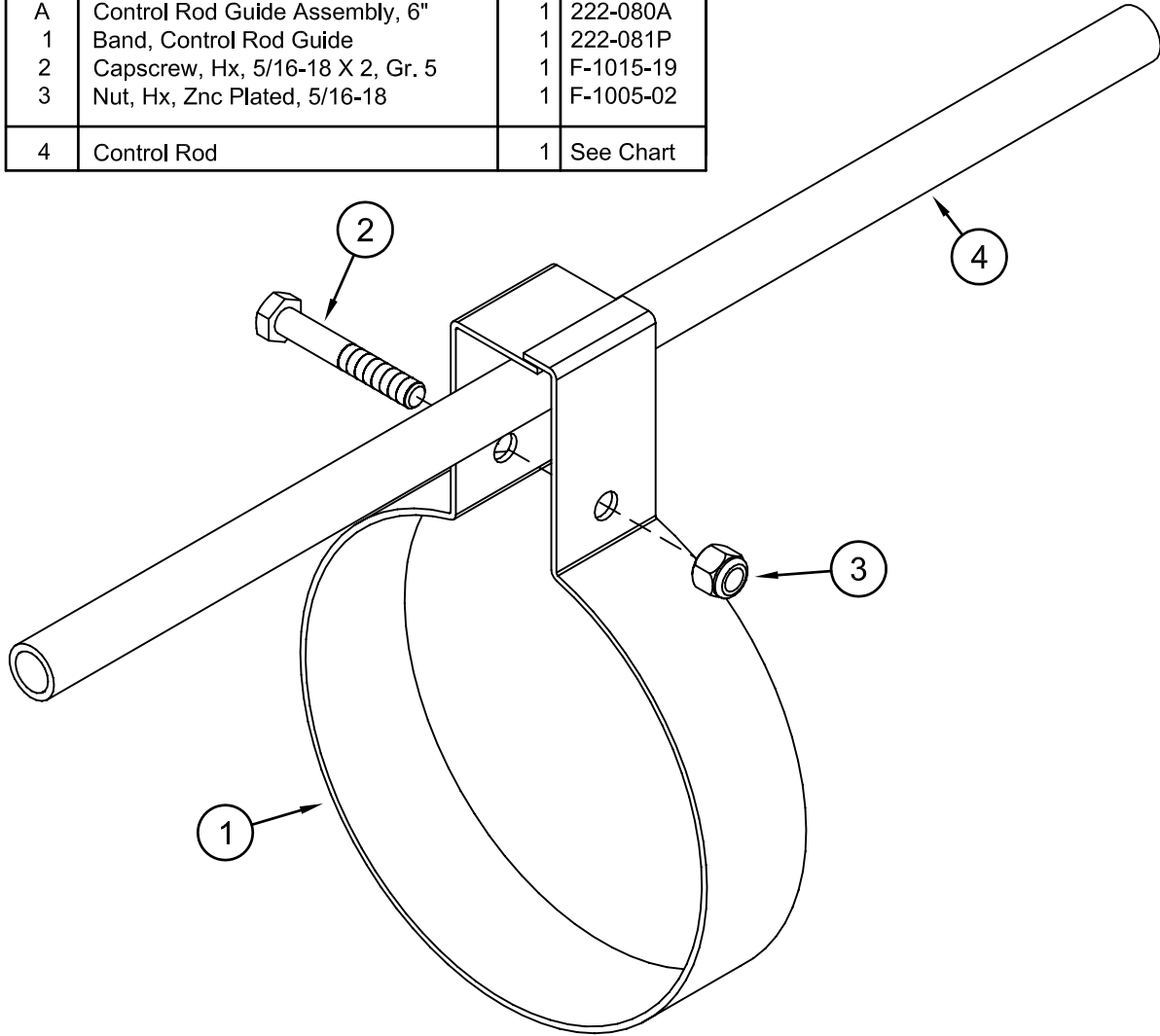
ITEM	DESCRIPTION	QTY	PART NO.
1	6" Face Plate Weldment	1	222-055W
2	6" Half Band	1	201Z-023P
A	Face Plate Sack	1	222-063A
3	Capscrew, Hx, 3/8-16 X 1-3/4", Gr. 5	4	F-1015-28
4	Washer, Flat, Std, Steel, 3/8"	4	F-1009-03
5	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
6	Bolt, Bin w/ Washer, 5/16-18 X 1, Gr. 5	4	F-1027-02
7	Nut, Hx, Znc Plated, 5/16-18 Nyloc	4	F-1005-02



# 6" CONTROL ROD GUIDE KIT

## (423-004-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Control Rod Guide Assembly, 6"	1	222-080A
1	Band, Control Rod Guide	1	222-081P
2	Capscrew, Hx, 5/16-18 X 2, Gr. 5	1	F-1015-19
3	Nut, Hx, Znc Plated, 5/16-18	1	F-1005-02
4	Control Rod	1	See Chart



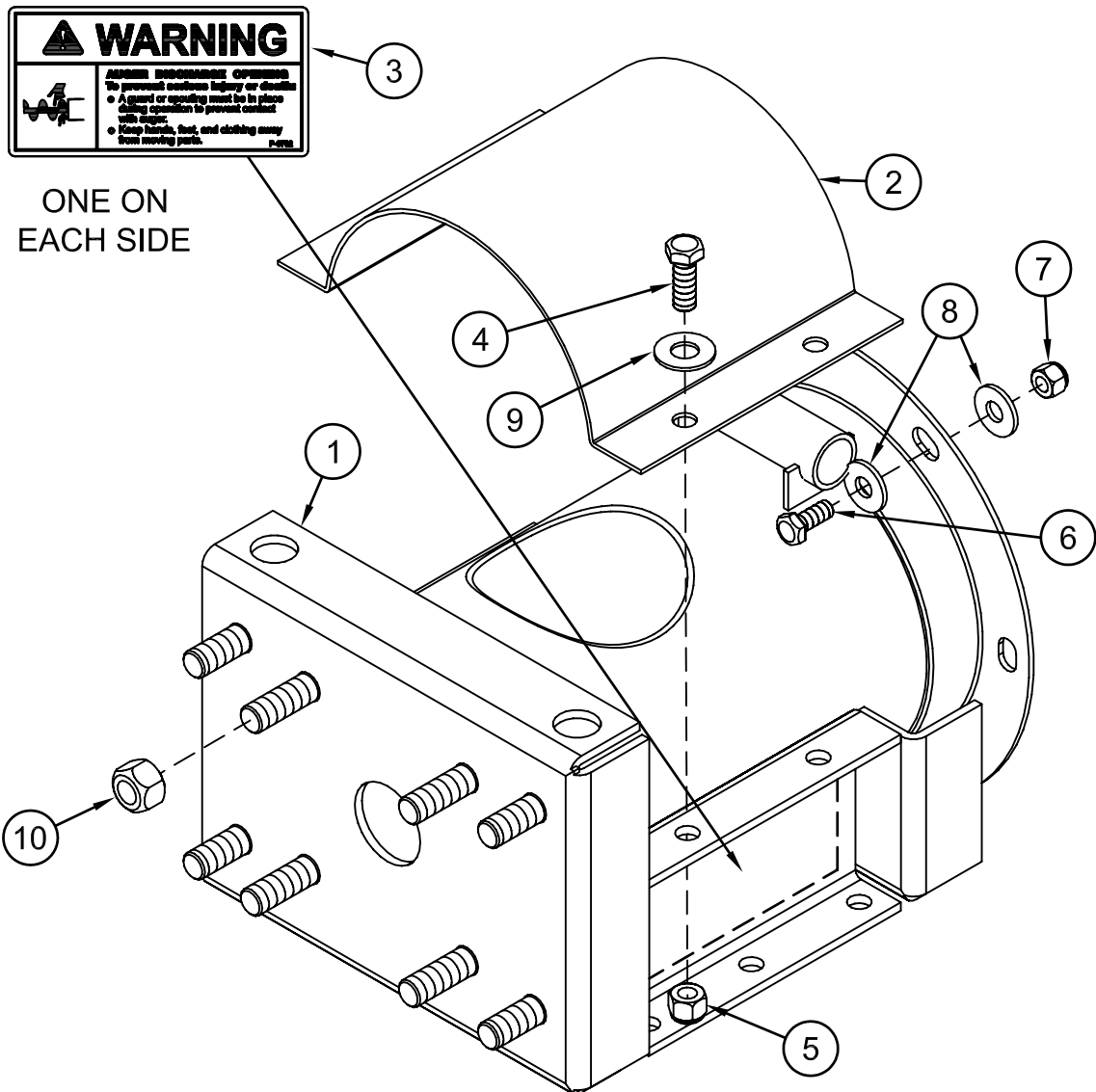
### CONTROL ROD CHART

DESCRIPTION	BIN DIAMETER	QTY	PART # ( $\frac{3}{8}$ )	PART # ( $\frac{1}{2}$ )	OVERALL LENGTH
Control Rod, Yellow	15'11-18'7"	1	221F-001A	221FF-001A	8'-1.75"
Control Rod, Black	18'8-22'0"	1	221G-001A	221GG-001A	9'-8.75"
Control Rod, Blue	22'1-24'9"	1	221H-001A	221HH-001A	11'-1.25"
Control Rod, Green	24'10-27'-10"	1	221I-001A	221II-001A	12'-7.75"
Control Rod, Red	27'11-31'0"	1	221J-001A	221JJ-001A	14'-2.75"
Control Rod, Brown	31'1-34'0"	1	221K-001A	221KK-001A	15'-8.75"
Control Rod, White	34'1-38'0"	1	221L-001A	221LL-001A	17'-9.25"
Control Rod, Orange	38'1-42'0"	1	221N-001A	221NN-001A	19'-8.75"
Control Rod	42'1-46'0"	1	221O-001A	221OO-001A	22'-2.75"
Control Rod	46'1-50'0"	1	221P-001A	221PP-001A	23'-10.75"

# 6" TRANSITION KIT

## (423-025-001A)

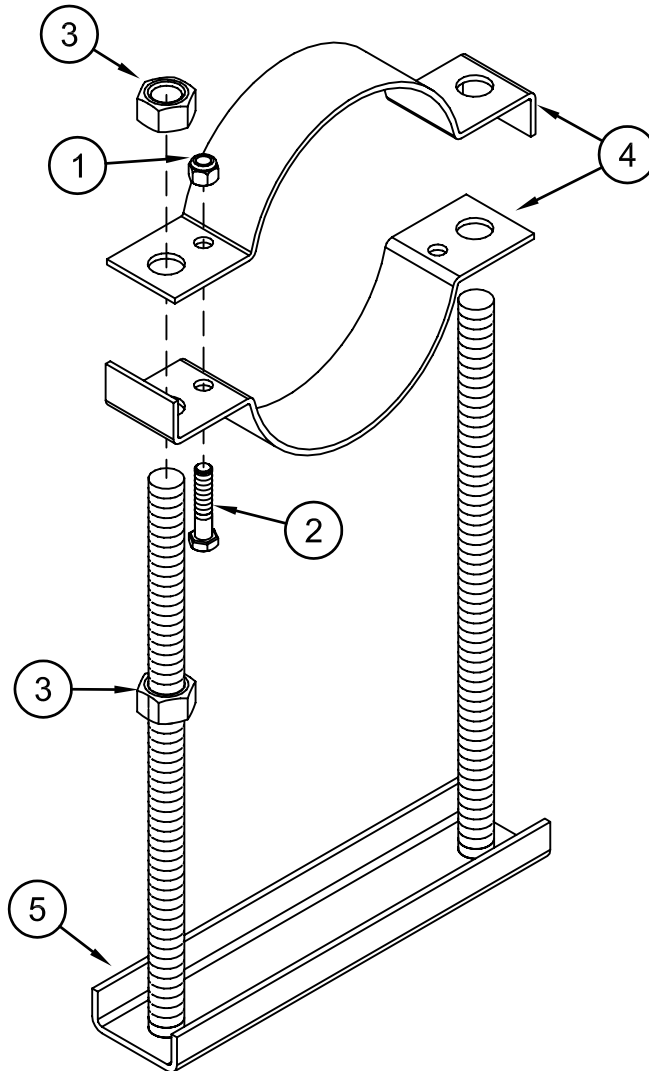
ITEM	DESCRIPTION	QTY	PART NO.
1	Transition, 6" Horizontal Weldment	1	220-064W
2	Cover, Half Band	1	220-047P
3	Decal, Warning Auger Discharge	2	P-8792
A	Transition Sack	1	547-017A
4	Capscrew, Hx, 3/8-16 X 1, Gr. 5	4	F-1394
5	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
6	Capscrew, Hx, 5/16-18 X 1", Gr. 5	7	F-1015-15
7	Nut, Hx, Znc Plated, 5/16-18 Nyloc	7	F-1005-02
8	Washer, Flat, Std, Steel, 5/16"	13	F-1009-02
9	Washer, Flat, Std, Steel, 3/8"	4	F-1009-03
10	Nut, Hx, Znc Plated, 1/2-13, Stover	4	F-1005-05



# 6" STAND KIT

## (423-002-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Horizontal Stand Sack	1	222-059A
1	Locknut, Hx, 3/8-16 w/ Nyloc	2	F-1239
2	Capscrew, Hx, 3/8-16 X 1-3/4" Gr. 5	2	F-1015-28
3	Nut, Hx, Znc Plated, 3/4-10 UNC	4	F-1011-07
4	Half Band	2	222-078P
5	Stand, Horizontal Weldment	1	222-057W



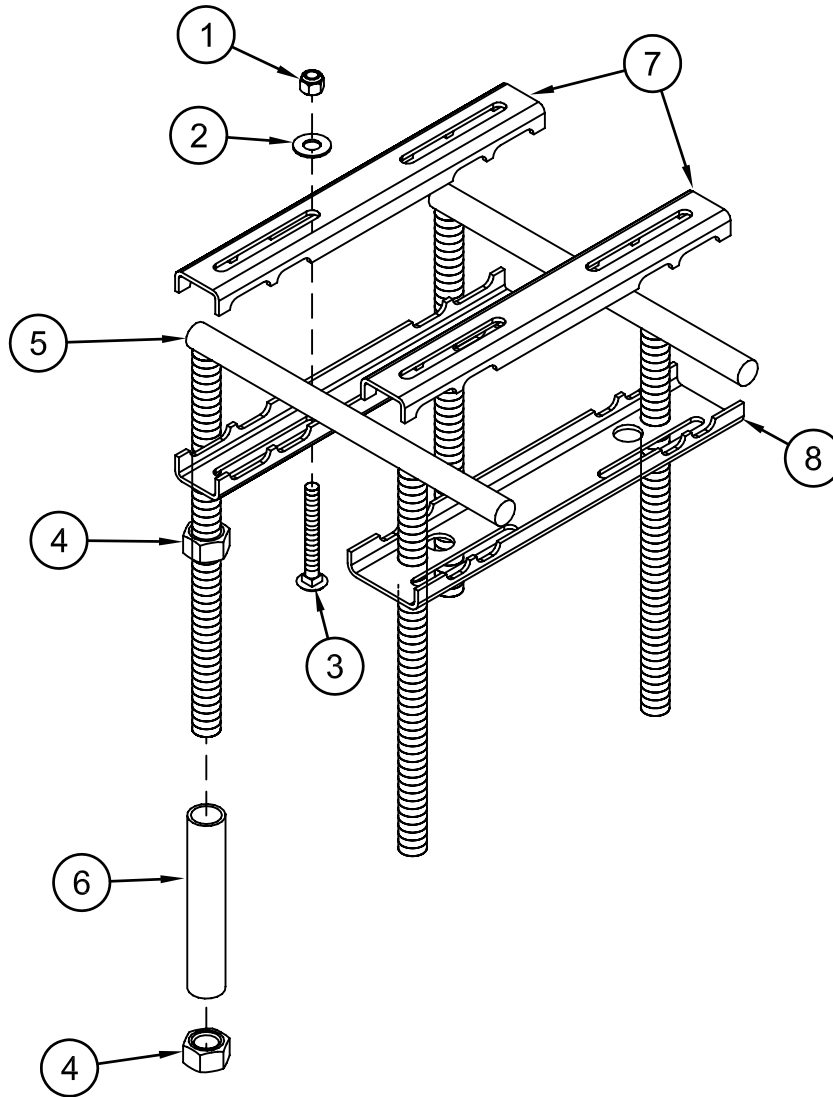


# 6" MOTOR MOUNT KIT

## STRAIGHT DOWN DISCHARGE

### (423-001-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Horizontal Motor Mount	1	222-060A
1	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
2	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
3	Bolt Carriage, 3/8-16 X 3	4	F-1024-01
4	Nut, Hx, Znc Plated, 3/4-10 UNC	8	F-1011-07
5	Motor Mount Horizontal Leg Weldment	2	222-056W
6	Pipe, Spacer, 5-1/2"	2	222-072P
7	Channel, Regular	3	530-015P
8	Channel, Notched	1	222-070P



# 8" HORIZONTAL UNLOADER

## (225A-001A - 225K-001A)

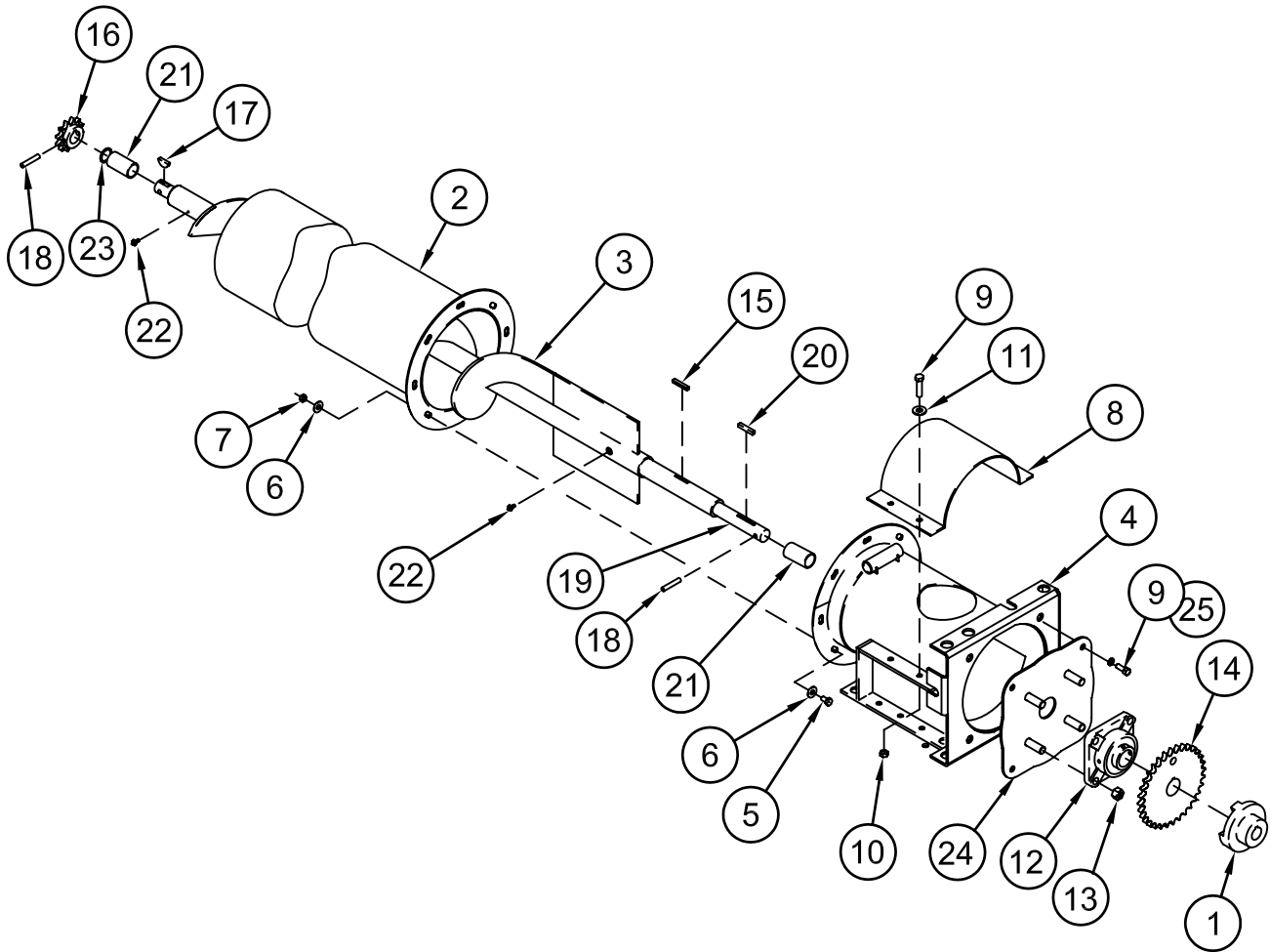
ITEM	DESCRIPTION	QTY	PART NO.	BREAK DOWN PAGE #
1	Jaw Clutch	1	220-057P	-
2	Tube Weldment	1	See Break-Down	21
3	Flite Weldment	1	See Break-Down	22
4	Transition	1	225-096W	-
5	Capscrew, Hx, 5/16-18 X 1", Gr. 5	8	F-1015-15	-
6	Washer, Flat, Std, Steel 5/16"	16	F-1009-02	-
7	Nut, Hx, Znc Plated, 5/16-18 Nyloc	8	F-1005-02	-
8	Half Band Cover	1	225-104A	-
9	Capscrew, Hx, 3/8-16 X 1", Gr. 5	4	F-1394	-
10	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239	-
11	Washer, Flat, Std, Steel 3/8"	4	F-1009-03	-
12	Bearing, 4 Hole Flng, 1-3/8" Bore	1	D-2002-01	-
13	Nut, Hx, Znc Plated, 1/2-13 Stover	4	F-1005-05	-
14	Sprocket, 32 Tooth, 1-3/8" w/ Setscrew	1	220-007P	-
15	Key, Step	1	220-020P	-
16	Sprocket, 12 Tooth, Universal	1	D-3212	-
17	Key, Wdrf., USAS 808 1/4 X 1", #15	1	D-1004-01	-
18	Roll Pin, Double, HD, 5/16 X 1-3/4"	2	F-1036-37	-
19	Drive Shaft	1	See Break-Down	35
20	Key, 1/4" Sq. X 1-1/2"	1	435-025P	-
21	Bronze Bushing	2	220-005P	-
22	Grease Fitting	2	H-1010-01	-
23	O-Ring, 1" ID X 1.25D X 1.25	1	D-3639	-
24	Bearing Plate, 3.625 Bolt Pattern		702-131W	-
25	Lockwasher, 3/8		F-1019-03	-

### STANDARD AUGERS

ASSEMBLY NUMBER	BIN DIAMETER	TUBE WLDT. NUMBER	AUGER ASSY. NUMBER	DRIVE SHAFT NUMBER
225A-001A	15'11-18'7	225A-004W	225A-017A	220D-058P
225B-001A	18'8-22'0	225B-004W	225B-017A	220E-058P
225C-001A	22'1-24'9	225C-004W	225C-017A	220F-058P
225D-001A	24'10-27-10'	225D-004W	225D-017A	220G-058P
225E-001A	27'11-31'0	225E-004W	225E-017A	220H-058P
225F-001A	31'1-34'0	225F-004W	225F-017A	220I-058P
225G-001A	34'1-38'0	225G-004W	225G-017A	220J-058P
225I-001A	38'1-42'0	225I-004W	225I-017A	220L-058P
225J-001A	42'1-46'0	225J-004W	225J-017A	220M-068W
225K-001A	46'1-50'0	225K-004W	225K-017A	220N-068W

# 8" HORIZONTAL UNLOADER

(225A-001A - 225K-001A)



# 8" HORIZONTAL UNLOADER, HTDA

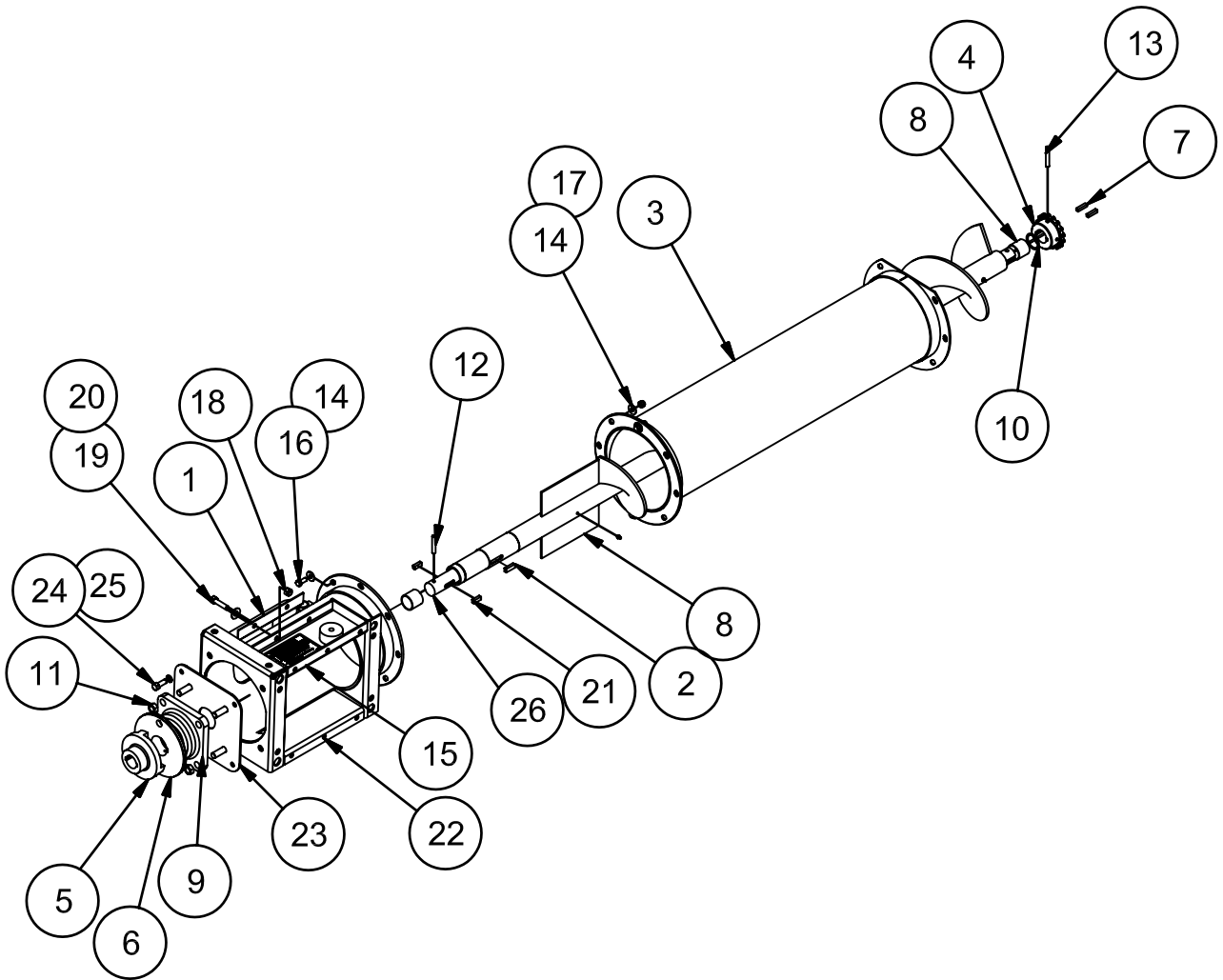
## 656A-001A - 656K-001A)

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	225-104A	Half Band, Cover
2	1	655-017P	Key, Rect .375X.25X1.125
3	1	See Breakdown	Tube Weldment PG 21
4	1	656-009P	Coupler 1.25ID X 1.25L
5	1	656-010P	3-Jaw clutch
6	1	656-016P	Horz Unld Drive Plate
7	2	656-027P	Chain Coupler Key
8	1	See Breakdown	Flite Wldt, 36' W/1.25 DRV PG 22
9	1	D-3715	1-7/8 Flange Bearing
10	1	D-3718	O-Ring 1.234ID X .139W
11	4	F-1005-05	1/2-13 Stover Nut
12	1	F-1036-37	5/16 X 1.75" Roll Pin
13	1	F-1036-39	Roll Pin 5/16 X 2
14	16	F-1009-02	5/16" Flat Washer
15	2	P-8792	Decal, Warning Auger Discharge
16	8	F-1015-15	5/16-18 x 1" Capscrew
17	8	F-1005-02	5/16-18 Nyloc Nut
18	4	F-1239	3/8 Locknut
19	4	F-1015-27	3/8-16 x 1-1/2" Capscrew
20	4	F-1009-03	3/8" Flat Washer
21	2	656-051P	Key, 1/4 x 5/16 x 15/16L
22	1	225-096W	8" Transition Weldment
23	1	702-133W	Bearing Plate, 2" ID X 4.375 BP
24	4	F-1394	3/8-16 x 1" Capscrew
25	4	F-1019-03	3/8" Lockwasher
26	1	SEE CHART	DRIVE SHAFT

### STANDARD AUGERS

ASSEMBLY NUMBER	BIN DIAMETER	TUBE WLDT. NUMBER	FLITE WLDT. NUMBER	DRIVE SHAFT NUMBER
656A-001A	15'11-18'7	655A-003W	656A-002W	656A-007P
656B-001A	18'8-22'0	655B-003W	656B-002W	656B-007P
656C-001A	22'1-24'9	655C-003W	656C-002W	656C-007P
656D-001A	24'10-27-10'	655D-003W	656D-002W	656D-007P
656E-001A	27'11-31'0	655E-003W	656E-002W	656E-007P
656F-001A	31'1-34'0	655F-003W	656F-002W	656F-007P
656G-001A	34'1-38'0	655G-003W	656G-002W	656G-014A
656H-001A	38'1-42'0	655H-003W	656H-002W	656H-014A
656I-001A	42'1-46'0	655I-003W	656I-002W	656I-014A
656J-001A	46'1-50'0	655J-003W	656J-002W	656J-014A
656K-001A	50'1"-52.0'	655K-003W	656K-002W	656K-014A

# 8" HORIZONTAL UNLOADER, HTDA (656A-001A - 656K-001A)



# 8" HORIZ. UNL., HTDF w/HANGER BEARINGS

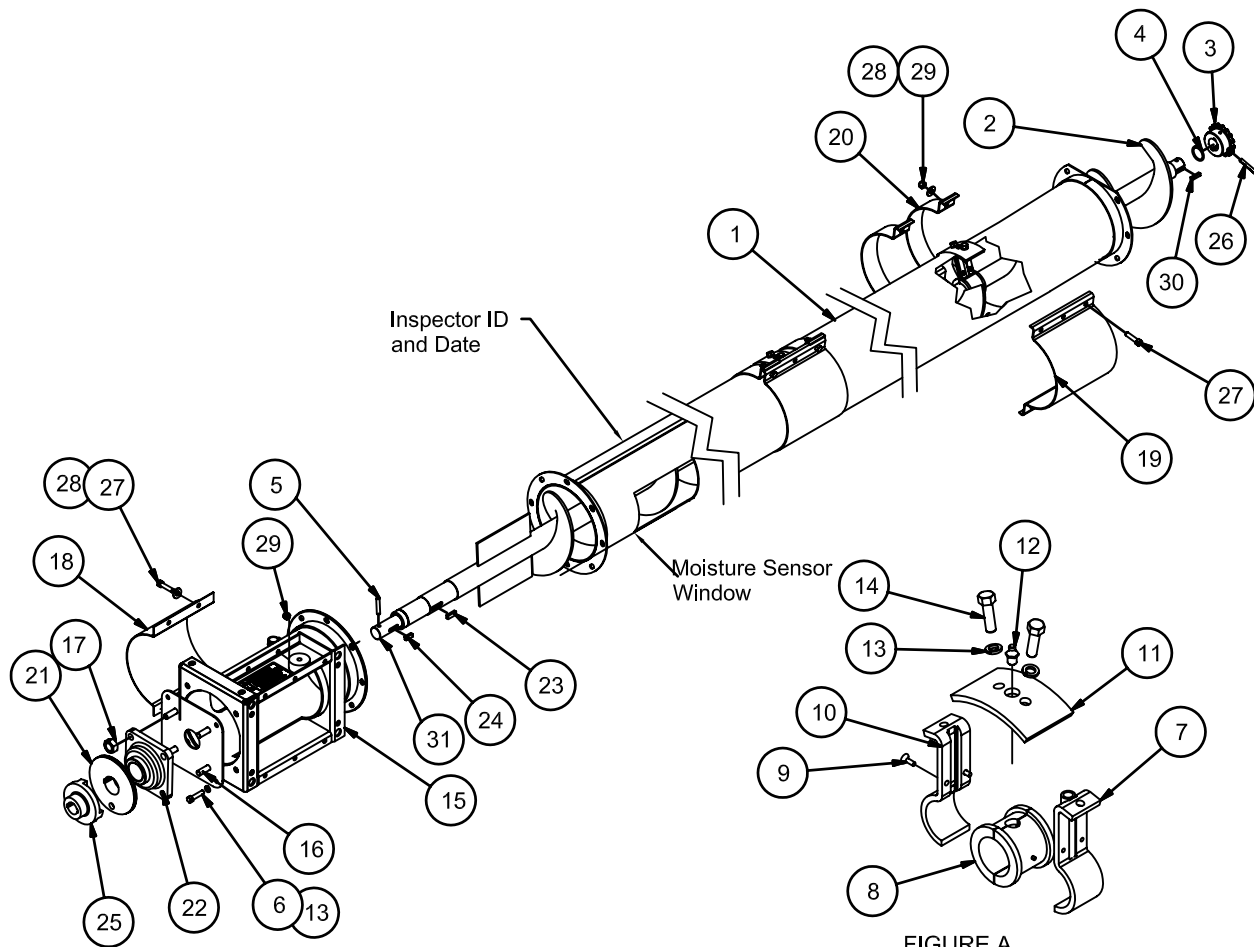
## (705D-001A - 705K-001A)

Parts List		
ITEM	PART NUMBER	DESCRIPTION
1	See Breakdown	8" Tube Wldt, High Torque HU PG 21
2	See Breakdown	8" Horizontal Unload Flite, High Torque PG 22
3	656-009P	Coupler, Chain 16T X 1.25ID X 1.25L
4	D-3718	O-Ring 1.234ID X .139W
5	F-1036-37	5/16 x 1.75" Roll Pin
6	F-1394	HHCS, 3/816 x 1"L
7	698-004P	HU Hanger Bracket, Front
8	698-008P	Hu Bearing, 1.640 ID x 2.500 OD
9	F-2074	10-32 x 1/2" Flat Head Screw
10	698-007W	HU Hanger Bracket Weldment
11	698-009P	Top Plate HU Hanger Bearing
12	H-1010-07	Grease Fitting, 1/8 NPT
13	F-1019-03	3/8" Lockwasher
14	F-1307	3/8-16 x 1-1/4" Capscrew
15	225-096W	Transition Wldt., 8"
16	702-133W	Bearing Plate, 4.375 Bolt Pattern
17	F-1005-05	1/2-13 Stover Nut
18	225-104A	Half Band, Cover
19	688-013P	Half Band, 8 in X 8"L
20	688-012P	Half Band, 8 in X 2"
21	656-016P	HTDA: Horz Unld Drive Plate
22	D-3715	1-7/8 Flange Bearing
23	655-017P	Key, Rect; .375X.25X1.125
24	656-051P	Key, Zinc Plated Steel, 1/4 x 5/16 x .938
25	656-010P	3-Jaw Clutch, HTDA; 1.25"ID
26	F1036-39	5/16 x 1.75" Roll Pin
27	F-1015-27	3/8-16 x 1-1/2" Capscrew
28	F-1009-03	3/8" Flat Washer
29	F-1239	3/8 Locknut
30	656-027P	Key, 1/4 x 1/4 x 1.125"L
31	SEE CHART	DRIVE SHAFT

Assembly	Flite Wldt.	Tube Wldt.	Drive Shaft	I.D. Color	Hngr. Brg.
705D-001A	705D-002W	705D-003W	705D-007P	Green	1
705E-001A	705E-002W	705E-003W	705E-007P	Red	2
705F-001A	705F-002W	705F-003W	705F-007P	Brown	2
705G-001A	705G-002W	705G-003W	705G-007P	White	2
705I-001A	705I-002W	705I-003W	705I-007P	Orange	2
705J-001A	705J-002W	705J-003W	705J-007P	Gray	2
705K-001A	705K-002W	705K-003W	705K-007P	Purple	3

# 8" HORIZ. UNL., HTDF w/HANGER BEARINGS

(705D-001A - 705K-001A)



**FIGURE A**  
 Fasten to flite in the spaces as shown, with the screws in bracket 698-007W to the back.

# 8" DF HORIZ. UNL. HANGER BEARING

## ASSEMBLY

(698D-001A - 698K-001A)

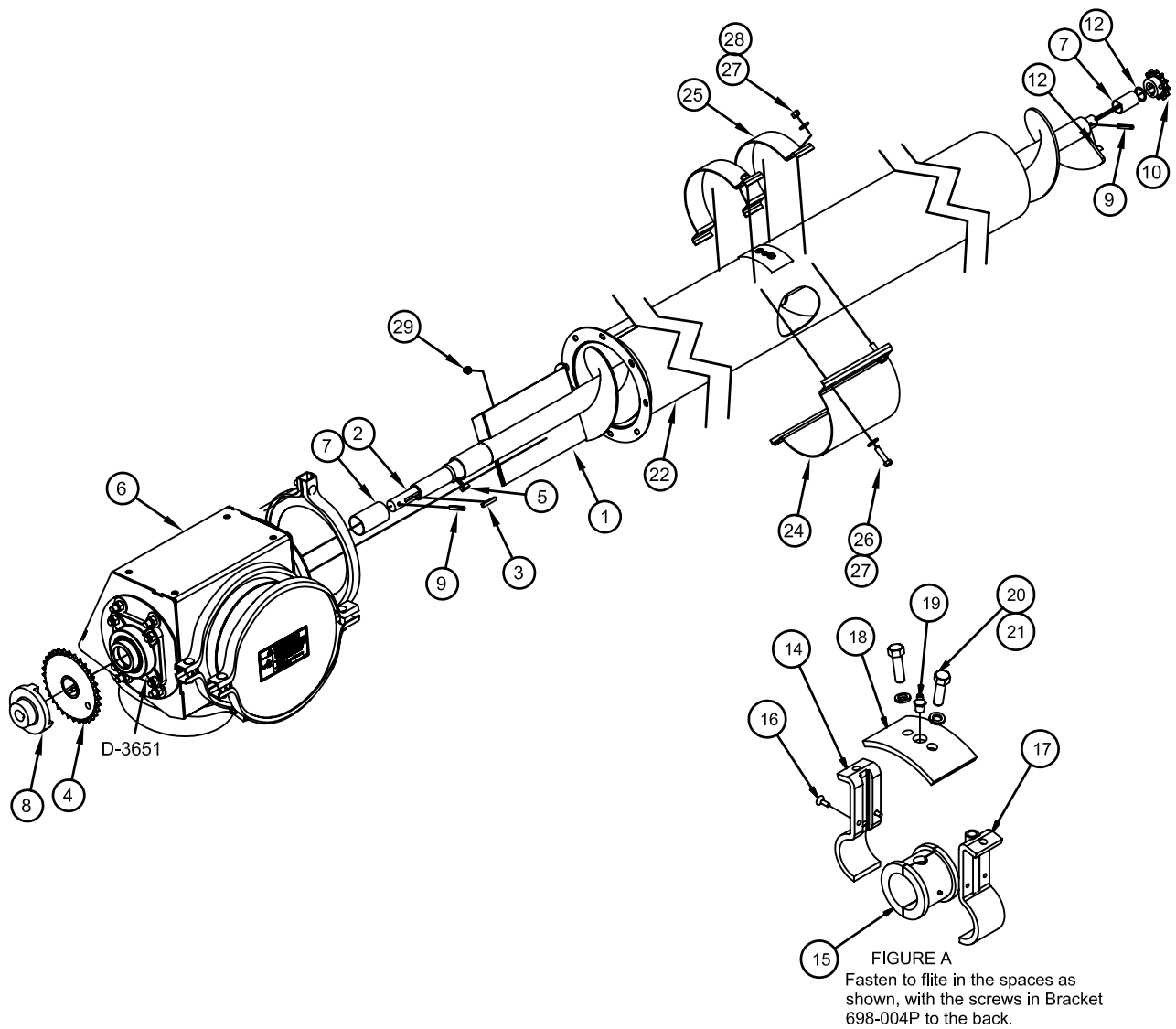
Parts List		
ITEM	PART NUMBER	DESCRIPTION
1	See Chart PG 22	8" Horizontal Unload Flite Wldt,
2	See Chart	Drive Shaft PG 35
3	435-025P	1/4" Square Key X 1 1/2" Long
4	665-026P	32T Sprocket
5	665-027P	5/16" Square Key
6	672-051A	Dri-Flo Trans Assembly
7	220-005P	Bronze Bushing
8	220-057P	Jaw Clutch
9	F-1036-37	5/16 x 1.75" Roll Pin
10	D-3212	12T Horizontal Sprocket
11	D-1004-01	Key, Woodruff 1/4X1
12	D-3639	1" O-Ring Seal
14	698-004P	HU Hanger Bracket, Front
15	698-008P	Hu Bearing, 1.625 ID x 2.250
16	F-2074	10-32 x 1/2" Flat Head Screw
17	698-007W	HU Hanger Bracket Weldment
18	698-009P	Top Plate HU Hanger Bearing
19	H-1010-07	Grease Fitting, 1/8 NPT
20	F-1019-03	3/8" Lockwasher
21	F-1394	3/8-16 x 1" Capscrew
22	See Chart	8" H/U Tube Wldt. PG 21
24	688-013P	Half Band, 8 in X 8"L
25	688-012P	Half Band, 8 in X 2"
26	F-1015-27	3/8-16 x 1-1/2" Capscrew
27	F-1009-03	3/8" Flat Washer
28	F-1239	3/8 Locknut
29	H-1010-01	Grease Fitting, 1/8"
30	P-8792	Decal, Warning, Auger--
31	P-7080	Decal, Shivers
33	P-10223	Decal, Danger Rotating---

Assembly	Flite Wldt.	Tube Wldt.	Drv.Shaft	Hngr.Brg.	I.D.Color
698D-001A	698D-002W	698D-003W	220G-058P	1	Green
698E-001A	698E-002W	698E-003W	220H-058P	2	Red
698F-001A	698F-002W	698F-003W	220I-058P	2	Brown
698G-001A	698G-002W	698G-003W	220J-058P	2	White
698I-001A	698I-002W	698I-003W	220L-058P	2	Orange
698J-001A	698J-002W	698J-003W	220M-068W	2	Gray
698K-001A	698K-002W	698K-003W	220N-068W	3	Purple



# 8" DF HORIZ. UNL. HANGER BEARING ASSEMBLY

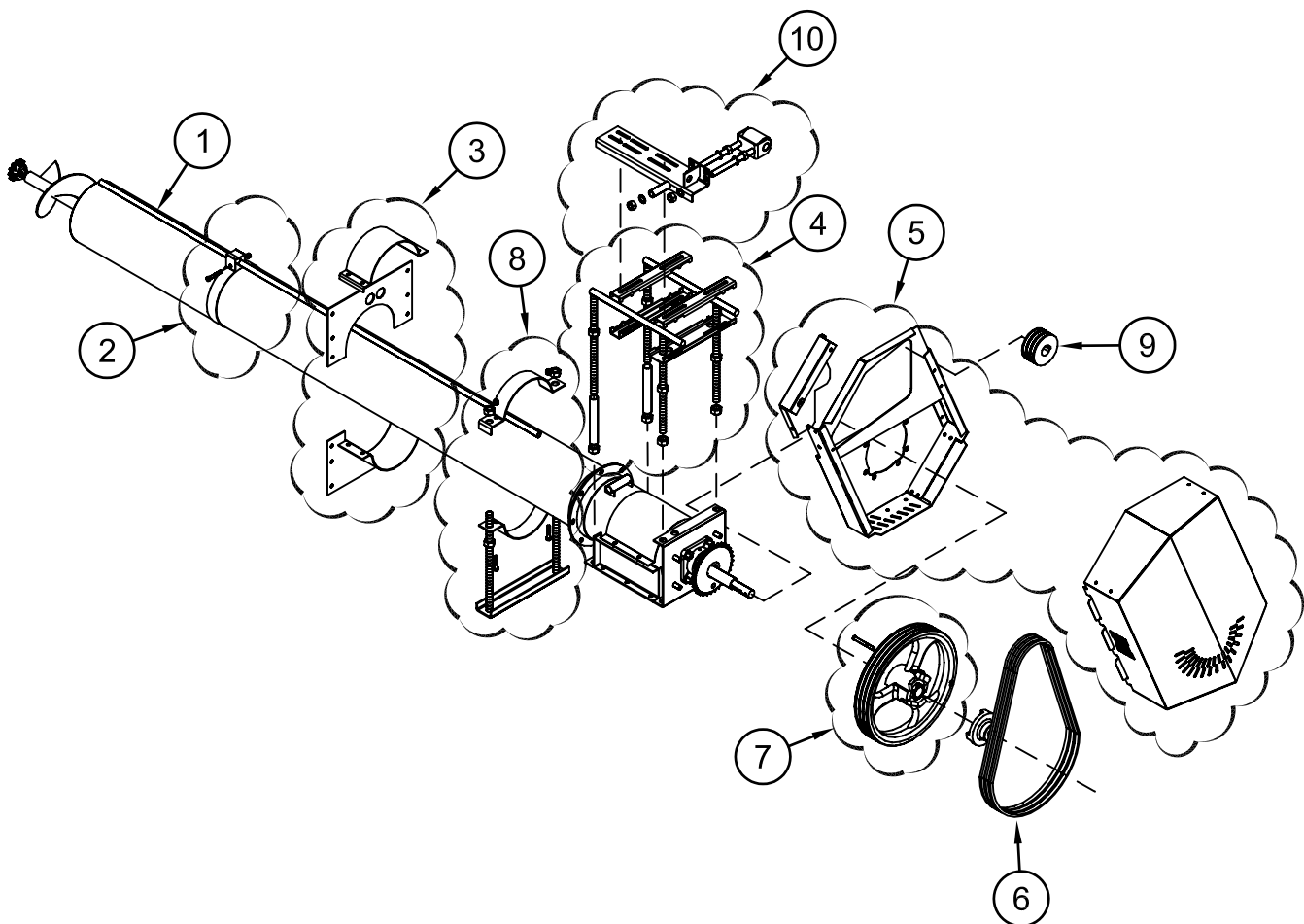
(698D-001A - 698K-001A)



# 8" HORIZONTAL UNLOADER ACCESSORIES

(225 SERIES & SERIES BEFORE 2007)

ITEM	DESCRIPTION	QTY	PART NO.	BREAK DOWN PAGE #
1	Control Rod	1	See Break-Down	30
2	Control Rod Guide Kit	1	423-006-001A	30
3	2 Pc. Face Plate Kit	1	423-357-001A	29
-	8" Face Plate Wldt' (DISCONTINUED)	-	226-003W	28
4	Motor Mount Kit	1	423-005-001A	36
5	Circ HU Belt Shield Kit	1	423-348-001A	40
-	Belt Shield Kit (DISCONTINUED)	-	423-003-001A	39
6	V-Belt, P-Cord AX60	3	D-3003-12	-
7	15" 3 Groove Pulley	1	423-067-001A	42
8	Stand Kit	1	423-007-001A	34
9	Motor Pulley	1	See Break-Down	47
10	Belt Idler Kit	1	97D-001A	44

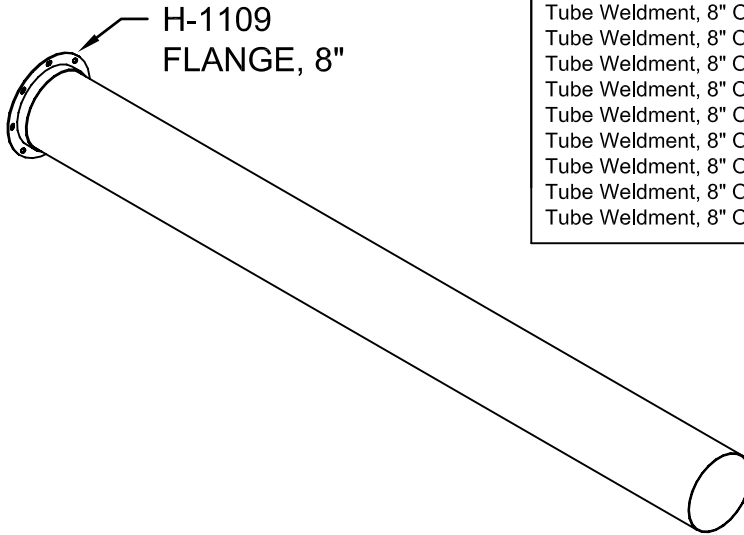


# 8" TUBE WELDMENT

225(A-K)-001A		
DESCRIPTION	PART NO.	BIN DIA.
Tube Weldment, 8" OD, 9'1" Long	225A-004W	15'11-18'7
Tube Weldment, 8" OD, 10'8" Long	225B-004W	18'8-22'0
Tube Weldment, 8" OD, 12'0-1/2" Long	225C-004W	22'1-24'9
Tube Weldment, 8" OD, 13'7" Long	225D-004W	24'10-27-10'
Tube Weldment, 8" OD, 15'2" Long	225E-004W	27'11-31'0
Tube Weldment, 8" OD, 16'8" Long	225F-004W	31'1-34'0
Tube Weldment, 8" OD, 18'8-1/2" Long	225G-004W	34'1-38'0
Tube Weldment, 8" OD, 20'8" Long	225I-004W	38'1-42'0
Tube Weldment, 8" OD, 24'7" Long	225J-004W	42'1-46'0
Tube Weldment, 8" OD, 26'7" Long	225K-004W	46'1-50'0

705(D-K)-001A		
DESCRIPTION	PART NO.	BIN DIA.
Tube Weldment, 8" OD, 13'7" Long	705D-003W	24'10-27-10'
Tube Weldment, 8" OD, 15'2" Long	705E-003W	27'11-31'0
Tube Weldment, 8" OD, 16'8" Long	705F-003W	31'1-34'0
Tube Weldment, 8" OD, 18'8-1/2" Long	705G-003W	34'1-38'0
Tube Weldment, 8" OD, 22'11" Long	705I-003W	42'1-46'0
Tube Weldment, 8" OD, 24'7" Long	705J-003W	42'1-46'0
Tube Weldment, 8" OD, 26'7" Long	705K-003W	46'1-50'0

698(C-K)-001A		
DESCRIPTION	PART NO.	BIN DIA.
Tube Weldment, 8" OD, 12'0-1/2" Long	698C-003W	22'1-24'9
Tube Weldment, 8" OD, 13'7" Long	698D-003W	24'10-27-10'
Tube Weldment, 8" OD, 15'2" Long	698E-003W	27'11-31'0
Tube Weldment, 8" OD, 16'8" Long	698F-003W	31'1-34'0
Tube Weldment, 8" OD, 18'8-1/2" Long	698G-003W	34'1-38'0
Tube Weldment, 8" OD, 20'8" Long	698H-003W	38'1-42'0
Tube Weldment, 8" OD, 22'11" Long	698I-003W	42'1-46'0
Tube Weldment, 8" OD, 24'7" Long	698J-003W	42'1-46'0
Tube Weldment, 8" OD, 26'7" Long	698K-003W	46'1-50'0

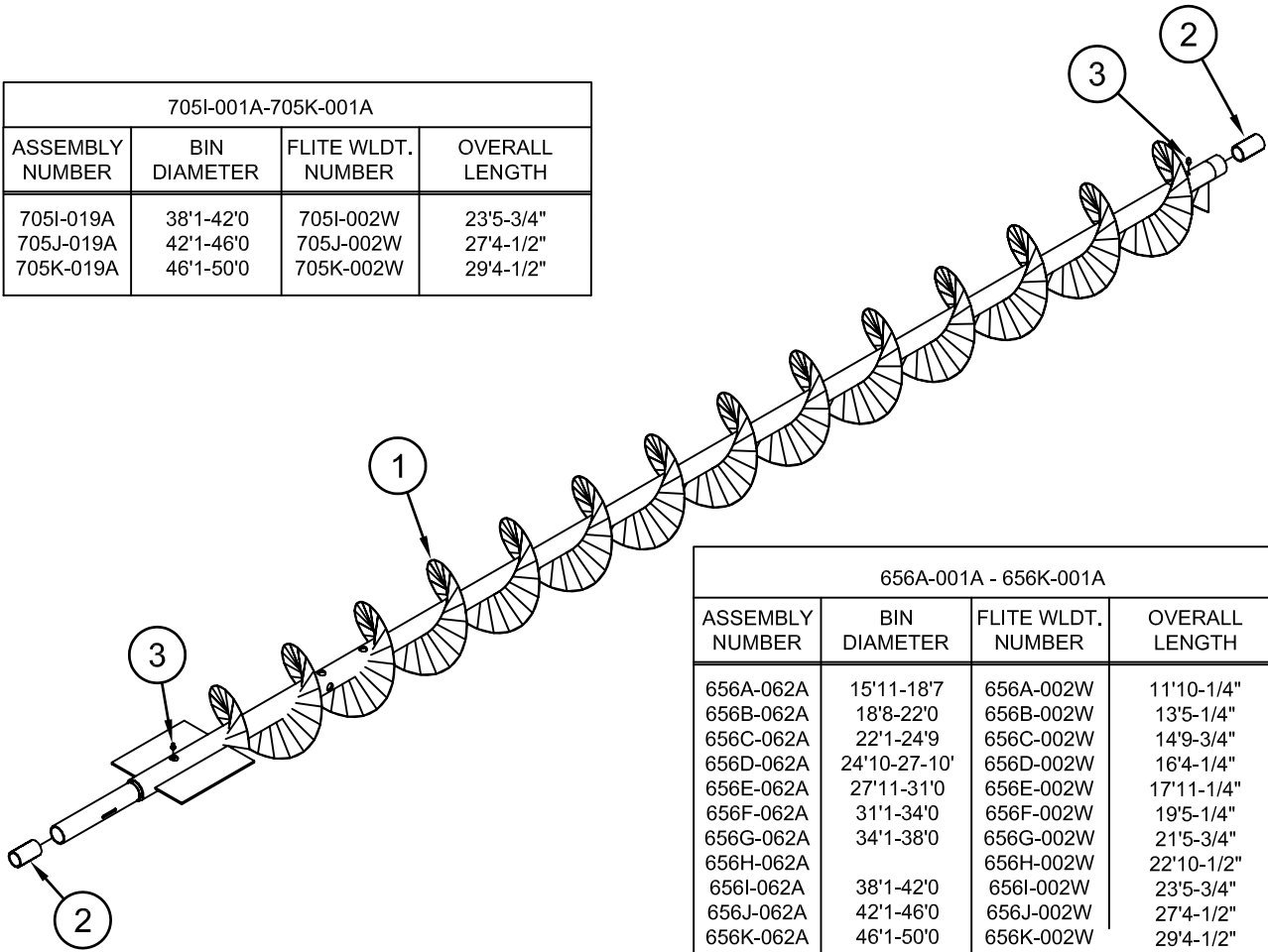


656(A-K)-001A		
DESCRIPTION	PART NO.	BIN DIA.
Tube Weldment, 8" OD, 9'1" Long	655A-003W	15'11-18'7
Tube Weldment, 8" OD, 10'8" Long	655B-003W	18'8-22'0
Tube Weldment, 8" OD, 12'0-1/2" Long	655C-003W	22'1-24'9
Tube Weldment, 8" OD, 13'7" Long	655D-003W	24'10-27-10'
Tube Weldment, 8" OD, 15'2" Long	655E-003W	27'11-31'0
Tube Weldment, 8" OD, 16'8" Long	655F-003W	31'1-34'0
Tube Weldment, 8" OD, 18'8-1/2" Long	655G-003W	34'1-38'0
Tube Weldment, 8" OD, 20'8" Long	655H-003W	38'1-42'0
Tube Weldment, 8" OD, 22'11" Long	655I-003W	42'1-46'0
Tube Weldment, 8" OD, 24'7" Long	655J-003W	42'1-46'0
Tube Weldment, 8" OD, 26'7" Long	655K-003W	46'1-50'0

# 8" FLITE ASSEMBLY

ITEM	DESCRIPTION	QTY	PART NO.
1	Flite Weldment, 8" Horizontal Circulator	1	See Chart
2	Bronze Bushing	2	220-005P
3	Fitting Grease, 1/8" Drive-in	2	H-1010-01

705I-001A-705K-001A			
ASSEMBLY NUMBER	BIN DIAMETER	FLITE WLDT. NUMBER	OVERALL LENGTH
705I-019A	38'1-42'0	705I-002W	23'5-3/4"
705J-019A	42'1-46'0	705J-002W	27'4-1/2"
705K-019A	46'1-50'0	705K-002W	29'4-1/2"



656A-001A - 656K-001A			
ASSEMBLY NUMBER	BIN DIAMETER	FLITE WLDT. NUMBER	OVERALL LENGTH
656A-062A	15'11-18'7	656A-002W	11'10-1/4"
656B-062A	18'8-22'0	656B-002W	13'5-1/4"
656C-062A	22'1-24'9	656C-002W	14'9-3/4"
656D-062A	24'10-27-10'	656D-002W	16'4-1/4"
656E-062A	27'11-31'0	656E-002W	17'11-1/4"
656F-062A	31'1-34'0	656F-002W	19'5-1/4"
656G-062A	34'1-38'0	656G-002W	21'5-3/4"
656H-062A		656H-002W	22'10-1/2"
656I-062A	38'1-42'0	656I-002W	23'5-3/4"
656J-062A	42'1-46'0	656J-002W	27'4-1/2"
656K-062A	46'1-50'0	656K-002W	29'4-1/2"

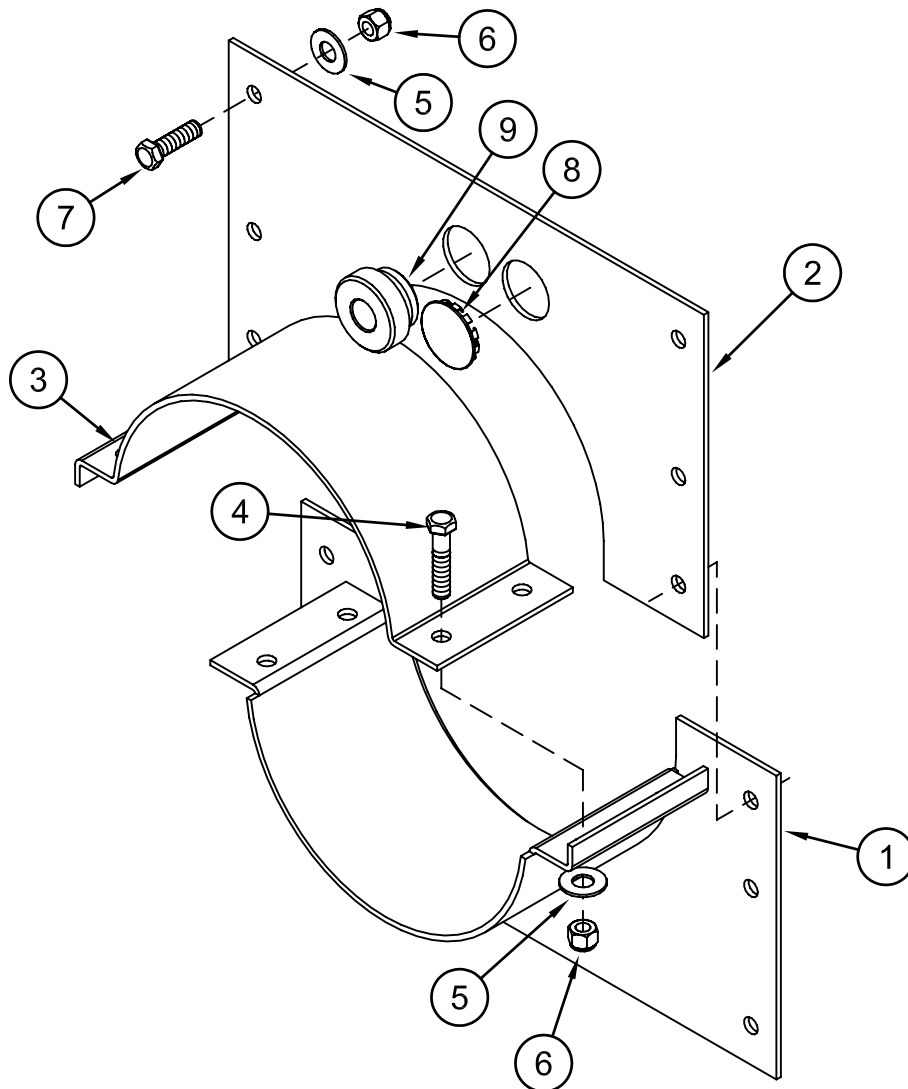
698D-001A - 698K-001A			
ASSEMBLY NUMBER	BIN DIAMETER	FLITE WLDT. NUMBER	OVERALL LENGTH
698C-002W	22'1-24'9	698C-002W	14'9-3/4"
698D-002W	24'10-27-10'	698D-002W	16'4-1/4"
698E-002W	27'11-31'0	698E-002W	17'11-1/4"
698F-002W	31'1-34'0	698F-002W	19'5-1/4"
698G-002W	34'1-38'0	698G-002W	21'5-3/4"
698I-002W	38'1-42'0	698I-002W	22'10-1/2"
698J-002W	42'1-46'0	698J-002W	23'5-3/4"
698K-002W	46'1-50'0	698K-002W	27'4-1/2"

225A-001A - 225K-001A			
ASSEMBLY NUMBER	BIN DIAMETER	FLITE WLDT. NUMBER	OVERALL TUBE LENGTH
225A-017A	15'11-18'7	225A-006W	11'10-1/4"
225B-017A	18'8-22'0	225B-006W	13'5-1/4"
225C-017A	22'1-24'9	225C-006W	14'9-3/4"
225D-017A	24'10-27-10'	225D-006W	16'4-1/4"
225E-017A	27'11-31'0	225E-006W	17'11-1/4"
225F-017A	31'1-34'0	225F-006W	19'5-1/4"
225G-017A	34'1-38'0	225G-006W	21'5-3/4"
225I-017A	38'1-42'0	225I-006W	23'5-3/4"
225J-017A	42'1-46'0	225J-006W	27'4-1/2"
225K-017A	46'1-50'0	225K-006W	29'4-1/2"

# 2 PC. FACE PLATE KIT

(423-357-001A)

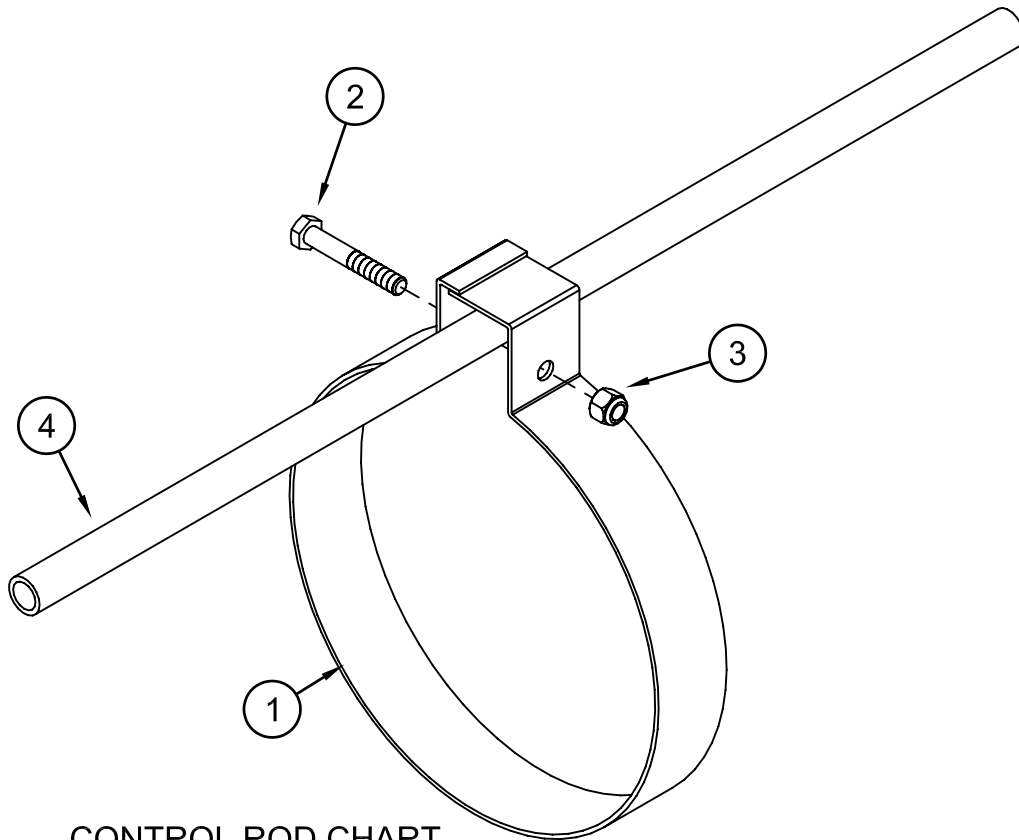
ITEM	DESCRIPTION	QTY	PART NO.
1	Bottom Weldment, 8" Face Plate	1	656-033W
2	Top, 8" Face Plate	1	656-031P
3	8" Half Band	1	201B-024P
A	Face Plate Sack	1	656-036A
4	Capscrew, Hx, 3/8-16 X 1-3/4", Gr. 5	4	F-1015-28
5	Washer, Flat, Std, Steel, 3/8"	14	F-1009-03
6	Locknut, Hx, 3/8-16 w/ Nyloc	14	F-1239
7	Capscrew, Hx, 3/8-16 X 1-1/4". Gr. 5	10	F-1307
8	Plug, Metal, 1-3/8"	1	E-6372
9	Face Plate 1/2" Control Rod Bushing	1	656-057P
-	Face Plate Assembly Instructions	1	P-11822



# 8" CONTROL ROD GUIDE KIT

## (423-006-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Control Rod Guide Assembly, 8"	1	226-012A
1	Band, Control Rod Guide	1	226-013P
2	Capscrew, Hx, 5/16-18 X 2, Gr. 5	1	F-1015-19
3	Nut, Hx, Znc Plated, 5/16-18	1	F-1005-02
4	Control Rod	1	See Chart



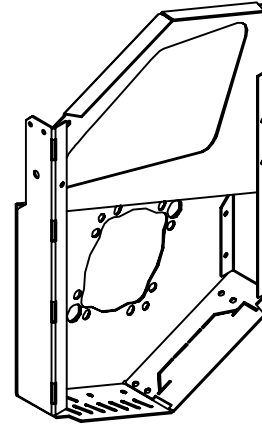
**CONTROL ROD CHART**

DESCRIPTION	BIN DIAMETER	QTY	PART # (3/8)	PART # (1/2)	OVERALL LENGTH
Control Rod, Yellow	15'11-18'7"	1	221F-001A	221FF-001A	8'-1.75"
Control Rod, Black	18'8-22'0"	1	221G-001A	221GG-001A	9'-8.75"
Control Rod, Blue	22'1-24'9"	1	221H-001A	221HH-001A	11'-1.25"
Control Rod, Green	24'10-27'-10"	1	221I-001A	221II-001A	12'-7.75"
Control Rod, Red	27'11-31'0"	1	221J-001A	221JJ-001A	14'-2.75"
Control Rod, Brown	31'1-34'0"	1	221K-001A	221KK-001A	15'-8.75"
Control Rod, White	34'1-38'0"	1	221L-001A	221LL-001A	17'-9.25"
Control Rod, Orange	38'1-42'0"	1	221N-001A	221NN-001A	19'-8.75"
Control Rod	42'1-46'0"	1	221O-001A	221OO-001A	22'-2.75"
Control Rod	46'1-50'0"	1	221P-001A	221PP-001A	23'-10.75"

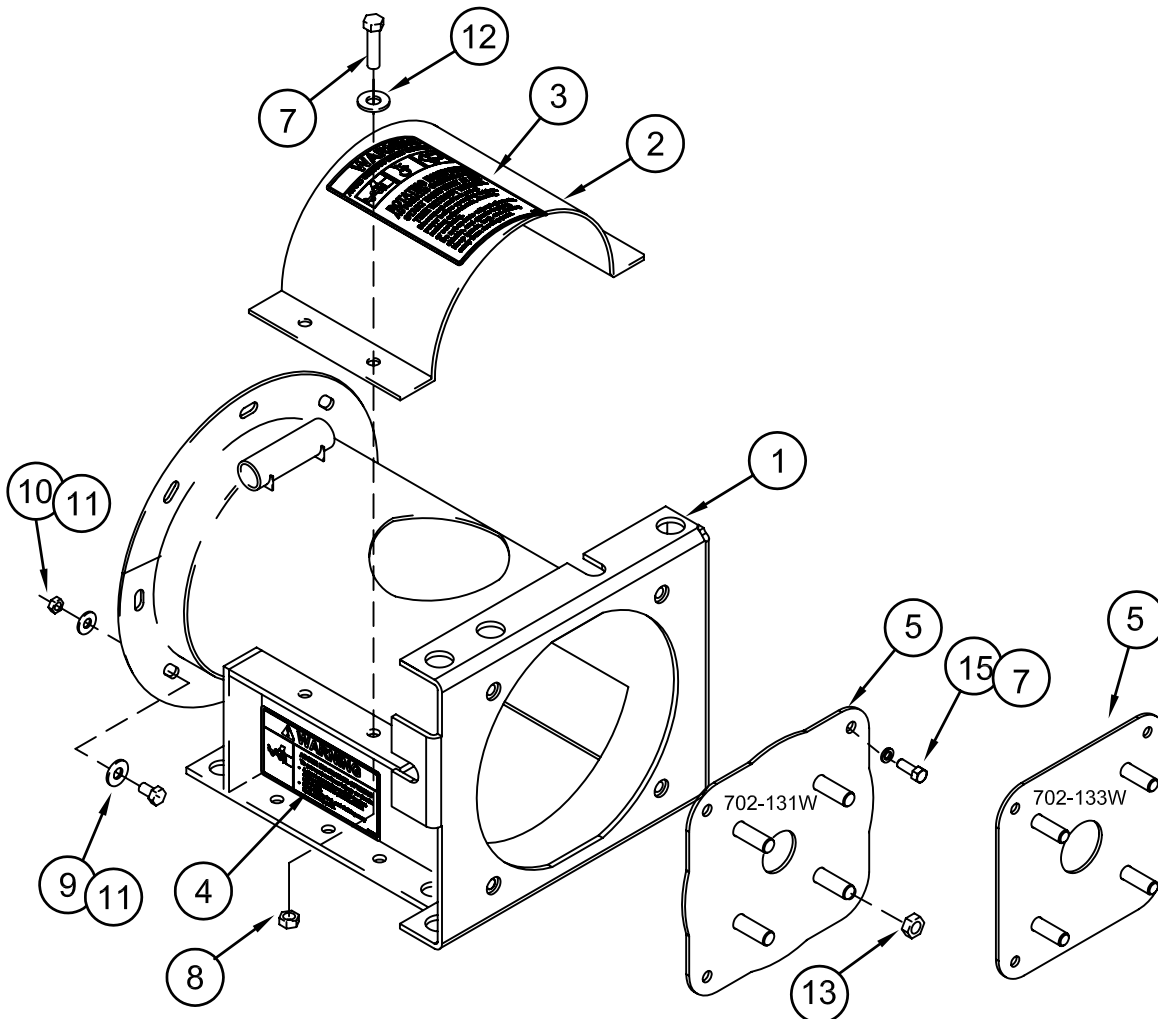
# 8" TRANSITION KIT

## (423-423-001A)

ITEM	DESCRIPTION	QTY	423-423-001A PART NO.
1	Transition, 8" Horizontal Weldment	1	225-096W
2	8" Cover, Half Band	1	225-104A
3	(Decal, Warning, Rotating Equip)	1	(P-10223)
4	Decal, Warning Auger Discharge	2	P-8792
5	Bearing Plate for Circ-2	1	702-131W
5	Bearing Plate for Circ-2	1	702-133W
A	Transition Sack	1	225-093A
7	Capscrew, Hx, 3/8-16 X 1, Gr. 5	4	F-1394
8	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
9	Capscrew, Hx, 5/16-18 X 1", Gr. 5	8	F-1015-15
10	Nut, Hx, Znc Plated, 5/16-18 Nyloc	8	F-1005-02
11	Washer, Flat, Std, Steel, 5/16"	16	F-1009-02
12	Washer, Flat, Std, Steel, 3/8"	4	F-1009-03
13	Nut, Hx, Znc Plated, 1/2-13, Stover	4	F-1005-05
14	Capscrew, Hx, 3/8-16 x 1-1/2, Gr 5	4	F-1015-27
15	Lockwasher, 3/8	4	F-1019-03
	Instructions, HTDA Guard	1	P-13191
	Instructions, C-2 to Transition	1	P-13192
	Template, Belt Shield Hole Pattern	1	P-13250
	Spacer Reinforcement	2	609-034P



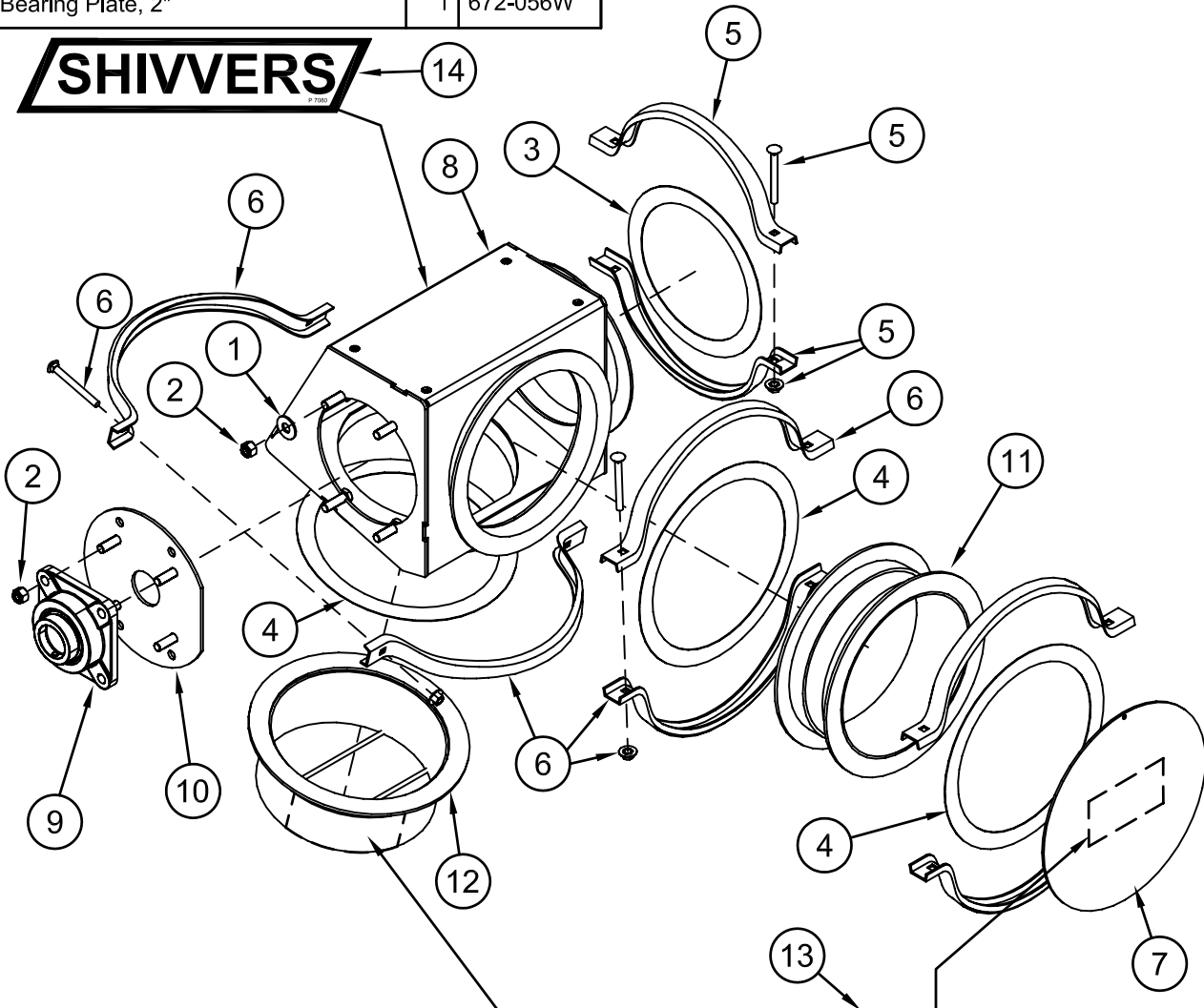
Circ-2 Belt Shield back must have holes drilled out to attach to transition bearing plate bolts. See P-13192 and P-13250 Hole Template..



# 8" DRI-FLO TRANSITION ASSEMBLY

## (672-051A)

ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
1	Washer, Flat, Std, Steel, 1/2"	4	F-1009-05	11	10" Basic Tube Offset Weldment	1	672-050W
2	1/2-13 Lock Nut w/ Nyloc	8	F-1378	12	10" Flange Safety Grill Weldment	1	672-068W
3	8" Flange Gasket	1	H-2545	13	Warning Decal, Auger Discharge	2	P-8792
4	10" Flange Gasket	3	H-2538	14	Shivvers Decal, Small	1	P-7080
5	8" Flange Clamp Assy (w/ Hardware)	1	H-2529				
6	10" Flange Clamp Assy (w/ Hardware)	3	H-2530				
7	10" Flange Door Cap	1	672-059P				
8	8" Trans Assy Weldment, Dri-Flo	1	672-058W				
9	Bearing, 4 Bolt Flange, 2" I.D.	1	D-3651				
10	Bearing Plate, 2"	1	672-056W				



**⚠ WARNING**

**AUGER DISCHARGE OPENING**  
To prevent serious injury or death:

- A guard or spouting must be in place during operation to prevent contact with auger.
- Keep hands, feet, and clothing away from moving parts.

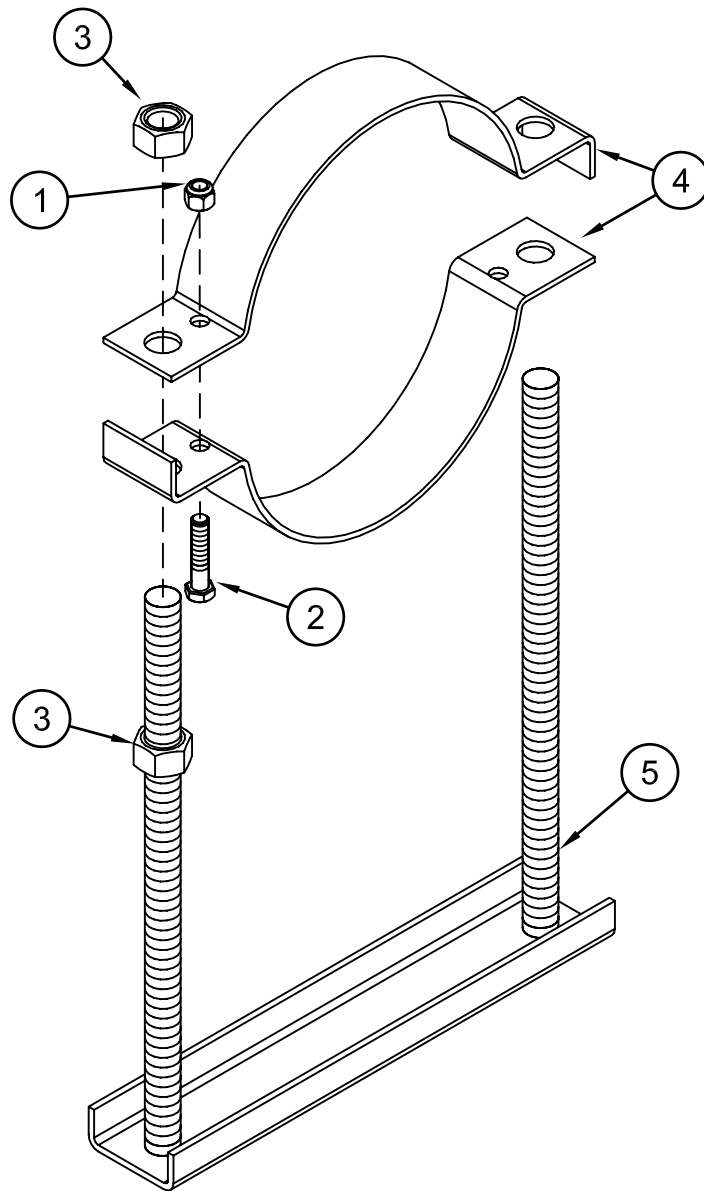
P-8792



# 8" STAND KIT

(423-007-001A)

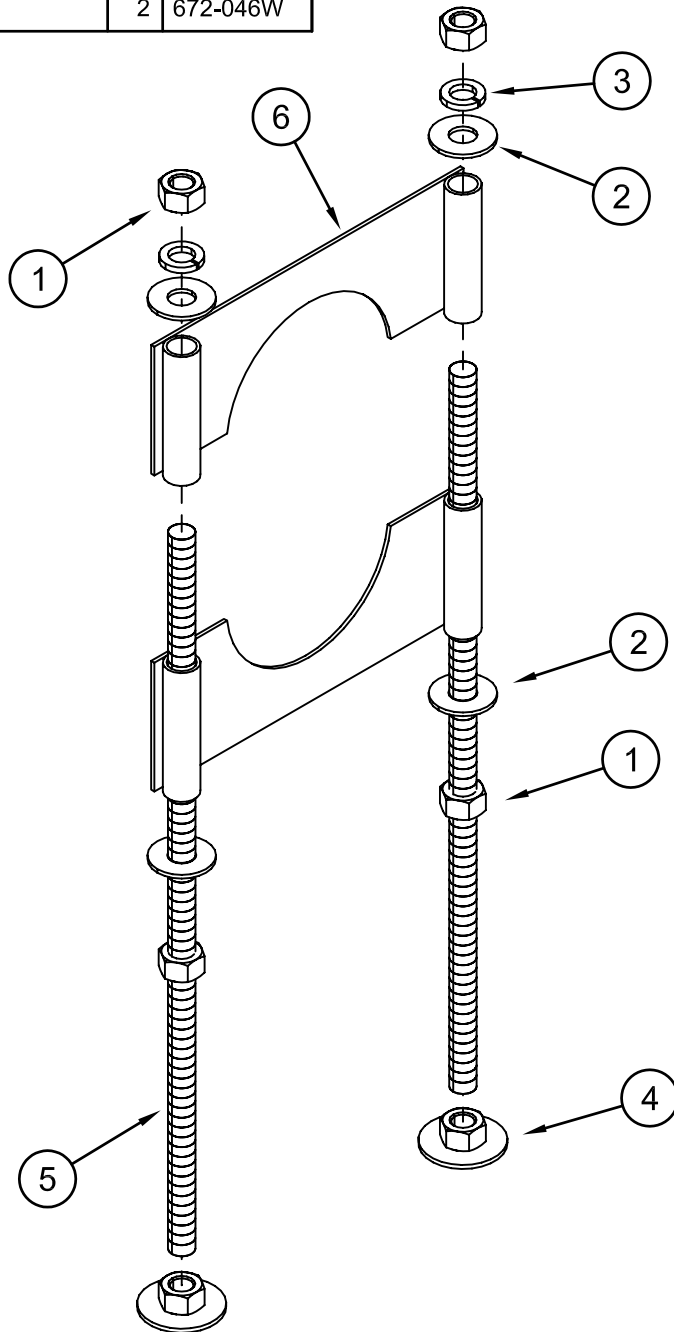
ITEM	DESCRIPTION	QTY	PART NO.
A	Horizontal Stand Sack	1	222-059A
1	Locknut, Hx, 3/8-16 w/ Nyloc	2	F-1239
2	Capscrew, Hx, 3/8-16 X 1-3/4" Gr. 5	2	F-1015-28
3	Nut, Hx, Znc Plated, 3/4-10 UNC	4	F-1011-07
4	Half Band	2	226-011P
5	Stand, Horizontal Weldment	1	226-005W



# 8" DRI-FLO BRACE ASSEMBLY

## (672J-001A)

ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Dri-Flo Brace Hardware	1	672-041A	5	Leg, Dri-Flo Brace	2	672-043P
1	Nut, 1-8 UNC	4	F-1011-09	6	Support Plate, Dri-Flo Brace	2	672-045W
2	Washer, 1" Wide Series	4	F-1282				
3	1" Split Lockwasher	2	F1478				
4	Foot Leg Weldment	2	672-046W				

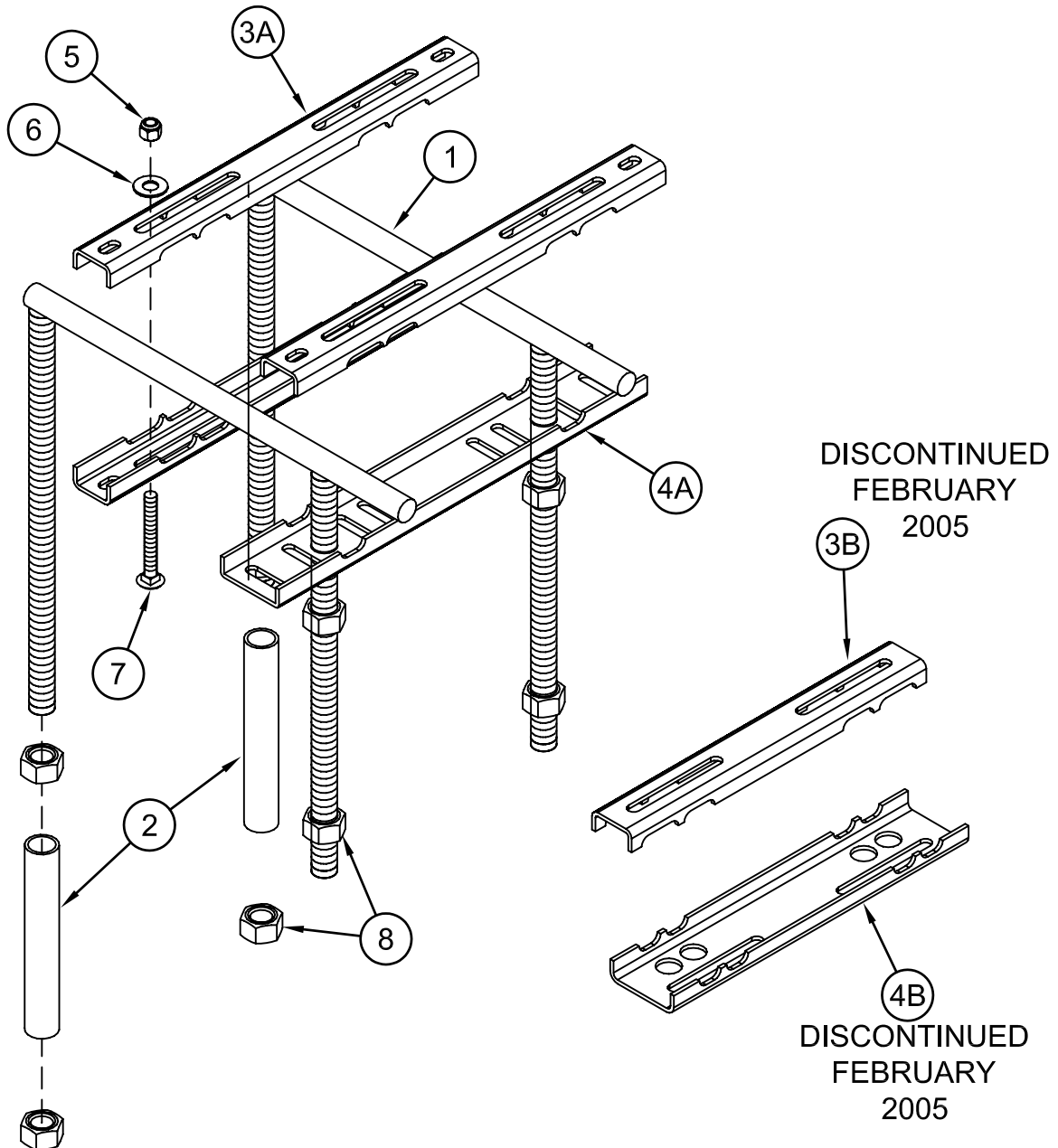


# 8" MOTOR MOUNT KIT

## STRAIGHT DOWN DISCHARGE

(423-005-001A)

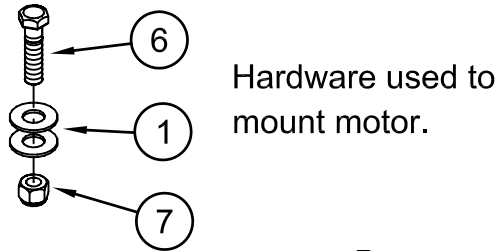
ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
1	Motor Mount Horizontal Leg Weldment	2	226-004W	A	Sack, Horizontal Motor Mount	1	222-060A
2	Pipe, Spacer, 6-1/2"	2	226-007P	5	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
3A	Channel, Regular, Long	3	222-095P	6	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
3B	Motor Mount Channel (OLD STYLE)		530-015P	7	Bolt Carriage, 3/8-16 X 3	4	F-1024-01
4A	Channel, Wide 8" Mtr Mnt 5-15 HP	1	222-096P	8	Nut, Hx, Znc Plated, 3/4-10 UNC	8	F-1011-07
4B	Channel, Notched (OLD STYLE)		222-070P				



# DRI-FLO MOTOR MOUNT ASSEMBLY

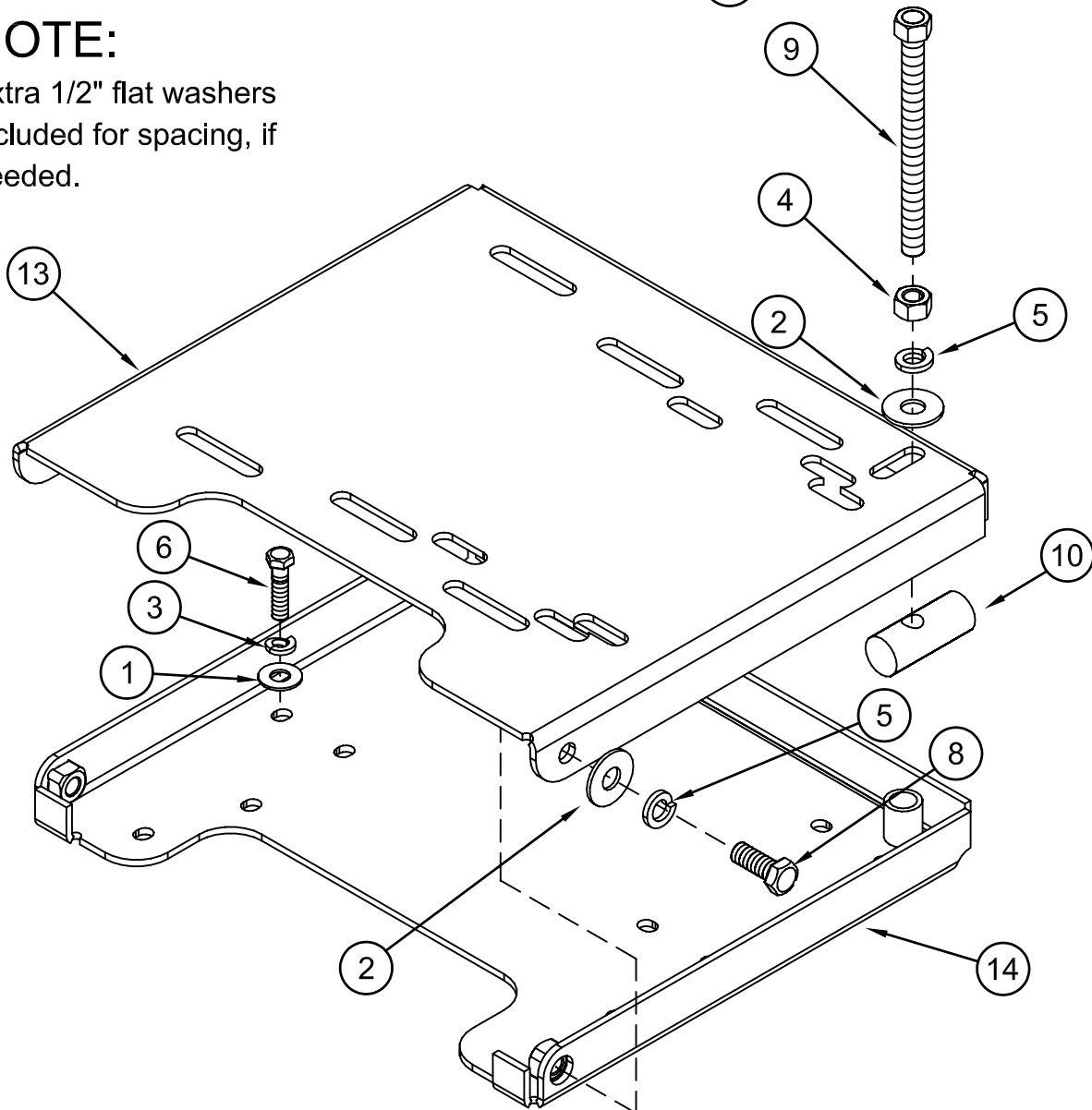
(672G-001A, STARTED 2007)

ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Motor Mount, Dri-Flo	1	672-036A	13	Top Motor Mount, Dri-Flo	1	672-027W
1	Washer, Flat, Std, Steel, 3/8"	12	F-1009-03	14	Bottom Motor Mount, Dri-Flo	1	672-026W
2	Washer, Flat, Std, Steel, 1/2"	5	F-1009-05				
3	Lockwasher, 3/8 Heavy Spring	4	F-1019-03				
4	1/2-13 Standard Nut	1	F-1011-05				
5	Lockwasher, 1/2" Split	3	F-1464				
6	Capscrew, HH 3/8-16 X 1-1/4	8	F-1307				
7	3/8-16, Lock Nut w/ Nyloc	4	F-1239				
8	Capscrew, HH 1/2-13 X 1-1/4	2	F-1386				
9	Motor Adjuster Bolt	1	F-2118				
10	Motor Adjuster Nut	1	672-029P				



## NOTE:

Extra 1/2" flat washers included for spacing, if needed.

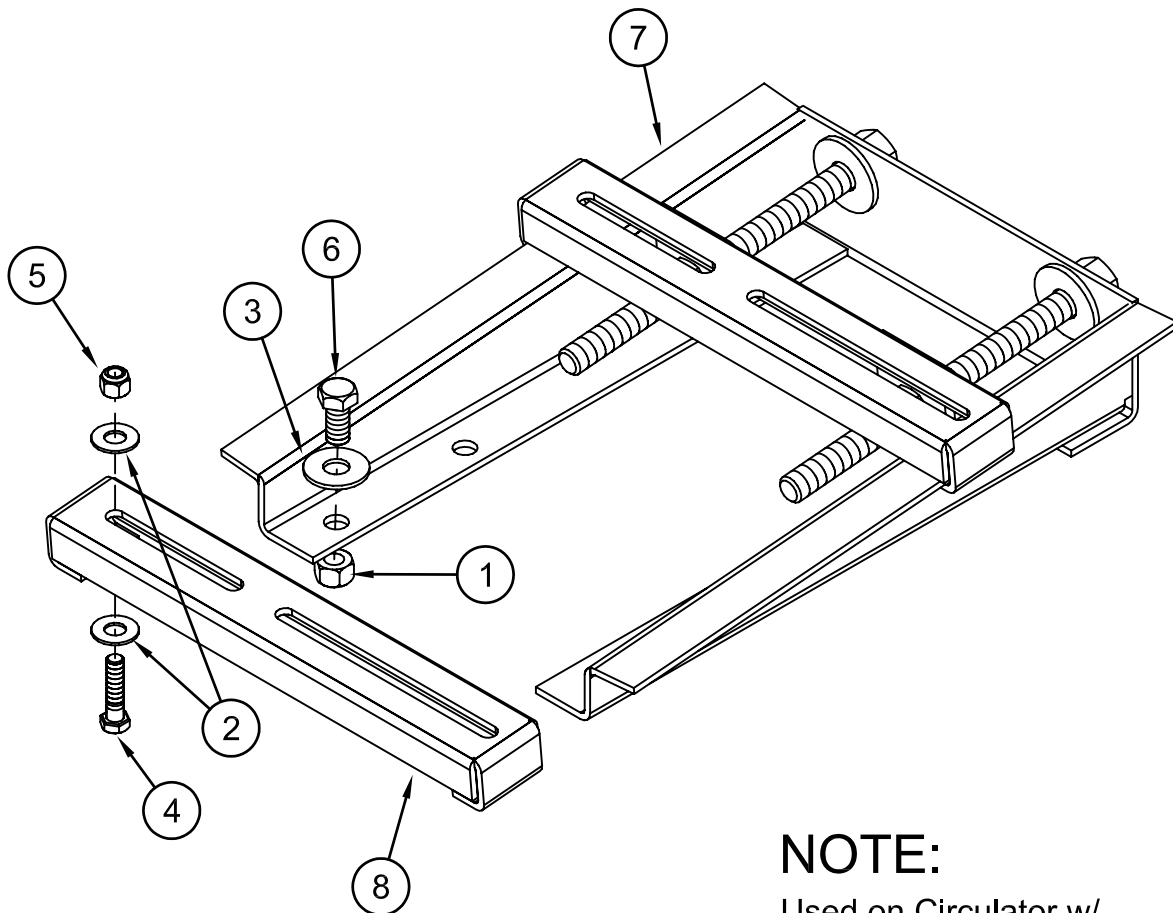


# 6" & 8" MOTOR MOUNT KIT

## SIDE DISCHARGE

### (423-008-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Vert. Motor Mount	1	237-015A
1	Nut, Hx, 1/2-13, Stover	3	F-1005-05
2	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
3	Washer, Flat, Std, 1/2"	4	F-1009-05
4	Capscrew, Hx, 3/8-16 X 1-1/2" Gr. 5	4	F-1015-27
5	Locknut, Hx, 3/8-16 w/ Nyloc	4	F-1239
6	Screw, Hxhd, 1/2-13 X 1" Gr. 5	3	F-1759
7	Motor Mount Wldt. Vert.	1	237-010W
8	Channel	1	237-032P



### NOTE:

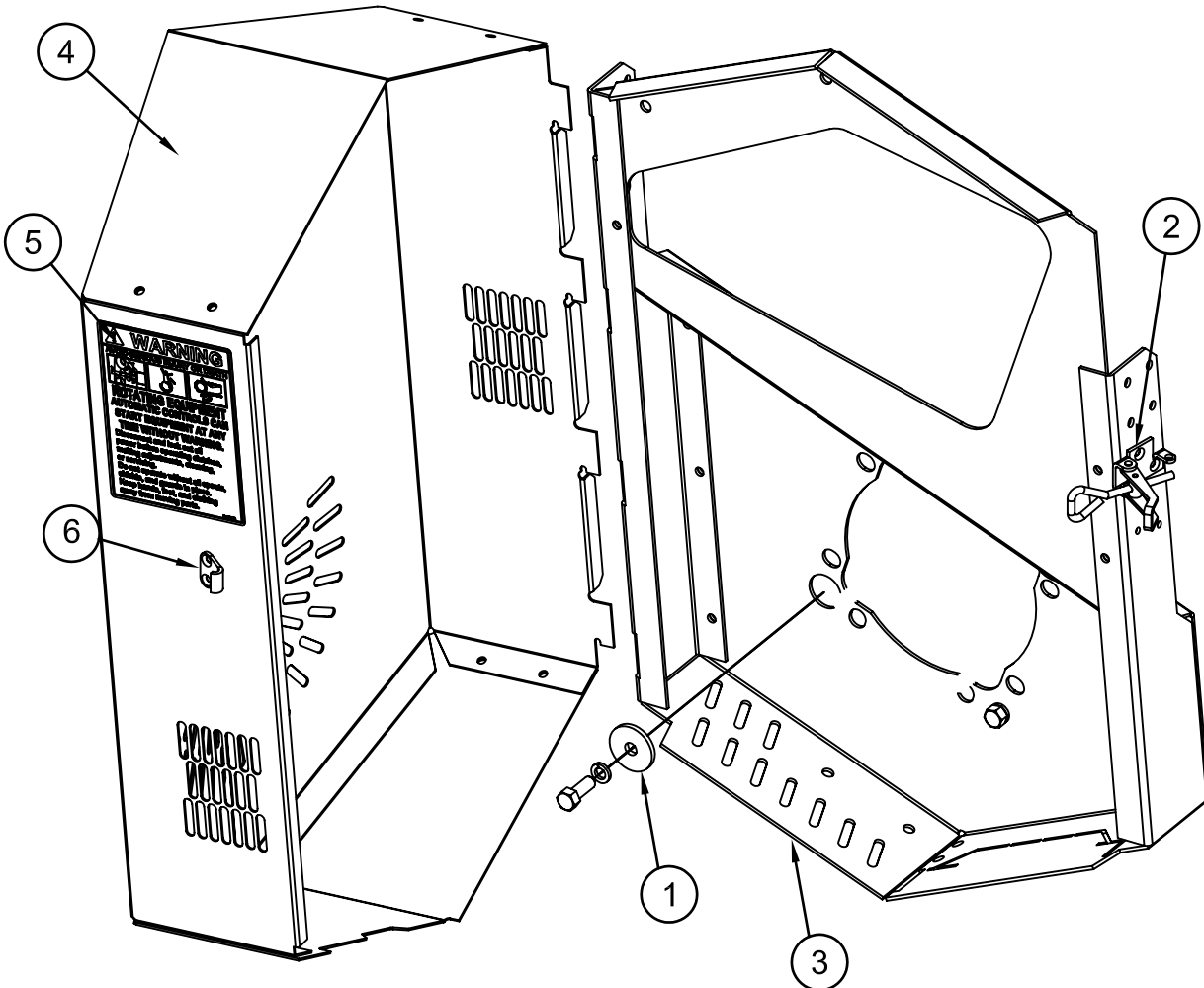
Used on Circulator w/  
Vertical Unload or Dri-Flo  
until 2007

# CIRC HU BELT SHIELD KIT

## (DRI-FLO BELT SHIELD 2004 TO 2007)

### (423-348-001A)

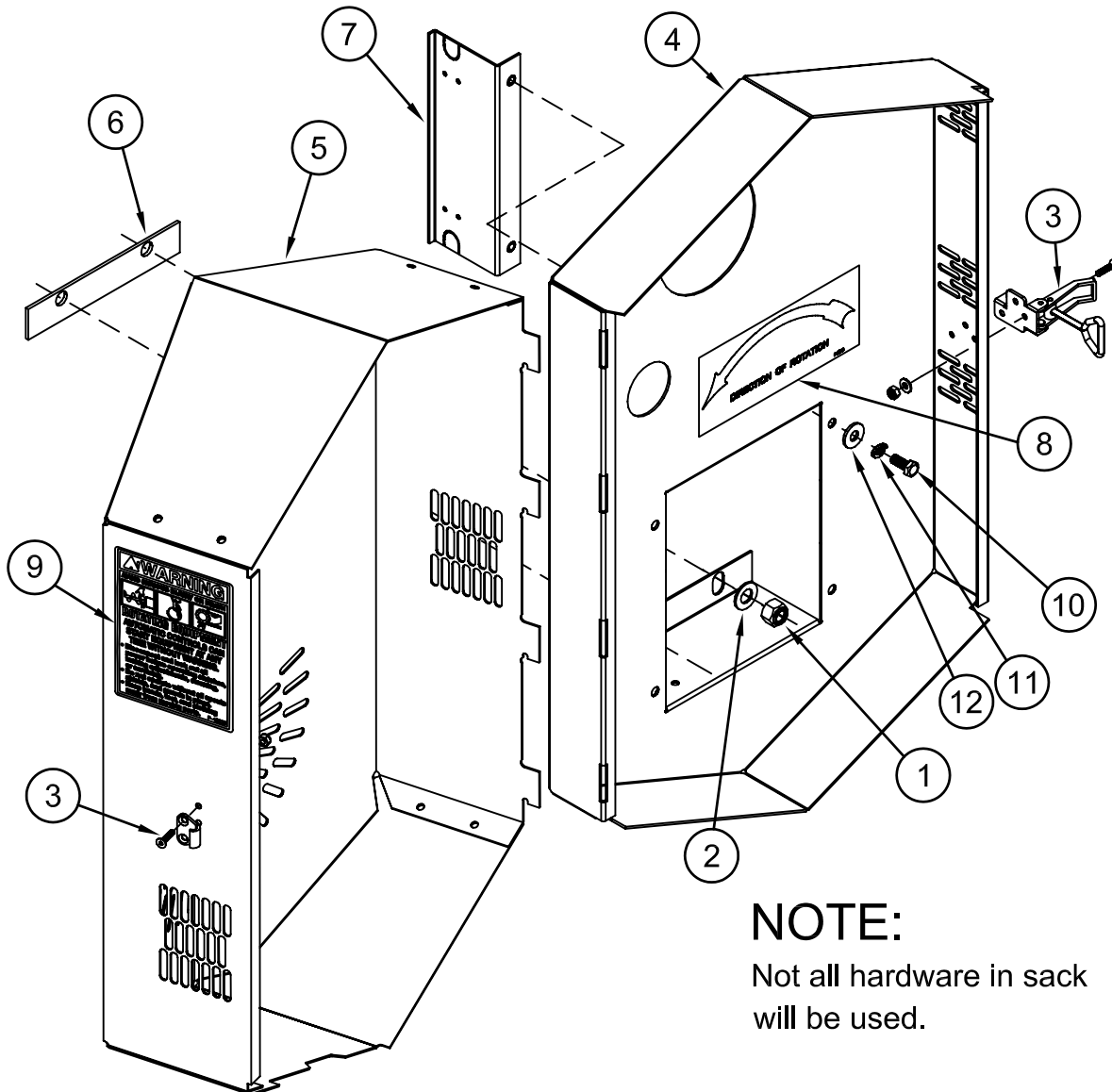
ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Belt Shield Hardware Sack, Circ	1	225-079A	B	Decal Pkg.	1	222-037A
-	Washer, Flat, Std, Steel, 5/16"	2	F-1009-02	-	Decal, Danger Suffocation	3	P-10125
-	Lockwasher, 5/16 Heavy Spring	2	F-1019-02	-	Decal, Caution Main Disconnect	1	P-10811
-	1/2-13 Locknut w/ Nylon	4	F-1378	-	Decal, Safety Danger, Rot. Equip.	3	P-11035
-	Washer, 1/2" Nom. Type B Narrow	4	F-1521	-	Decal, Warning Auger Discharge	2	P-8792
-	CapscREW, HH 5/16-18 X 3/4, Gr. 5	2	F-1546	-	Decal, Dir. of Rotation, CCW	1	P-8875
1	Spacer Washer	2	609-034P	5	Decal, Warning - Rotating Equipment	2	P-10223
2	Draw Latch w/ Hardware	1	H-2412	-	Decal, Shivvers Large (not shown)	1	P-8427
3	Belt Shield Back Weldment, Circ-HU	1	225-075W				
4	Belt Shield Door Assembly, Circ-HU	1	225-080A				
-	Belt Shield Motor Guard (Not Shown)	1	225-087P				



# DRI-FLO BELT SHIELD KIT

## (672E-001A, STARTED 2007)

ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Belt Shield Hardware Sack, Circ	1	225-079A	B	Decal Pkg.	1	222-037A
-	Washer, Flat, Std, Steel, 5/16"	2	F-1009-02		Decal, Danger Suffocation	3	P-10125
-	Lockwasher, 5/16 Heavy Spring	2	F-1019-02		Decal, Caution Main Disconnect	1	P-10811
1	1/2-13 Locknut w/ Nylon	4	F-1378		Decal, Safety Danger, Rot. Equip.	3	P-11035
2	Washer, 1/2" Nom. Type B Narrow	4	F-1521		Decal, Warning Auger Discharge	2	P-8792
-	Capscrew, HH 5/16-18 X 3/4, Gr. 5	2	F-1546	8	Decal, Dir. of Rotation, CCW	1	P-8875
3	Draw Latch w/ Hardware	1	H-2412	9	Decal, Warning - Rotating Equipment	2	P-10223
4	Belt Shield Back Weldment, Dri-Flo	1	672-040W	-	Decal, Shivvers Large (not shown)	1	P-8427
5	Belt Shield Door Assembly, Circ-HU	1	225-080A	10	Capscrew, HH 5/16-18 X 3/4, Gr. 5	4	F-1546
6	Spacer Plate	2	672-037P	11	Lockwasher, 5/16 Heavy Spring	4	F-1019-02
7	Side Shield	2	672-079P	12	Washer, Flat, Std, Steel, 5/16"	4	F-1009-02



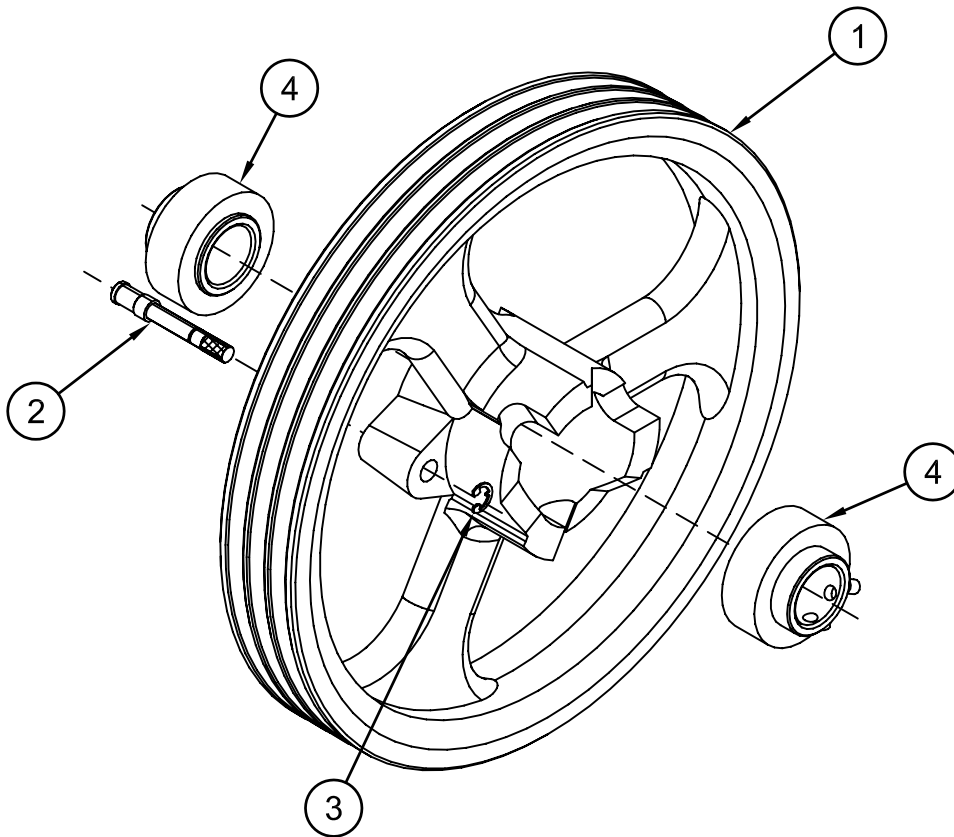
### NOTE:

Not all hardware in sack will be used.

# 15" 3 GROOVE PULLEY KIT

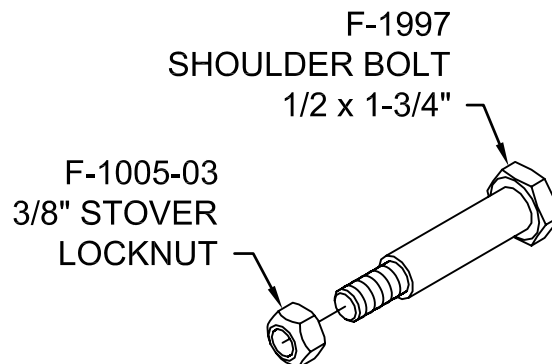
(423-067-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Pulley Assembly	1	222-058A
1	Pulley, 15" 3 Groove	1	222-076P
2	Pin Clutch 3-1/4"	1	222-075P
3	Snap Ring	1	F-1080
4	Bearing, 1-3/8" Bore	2	D-2004-01



## NOTE:

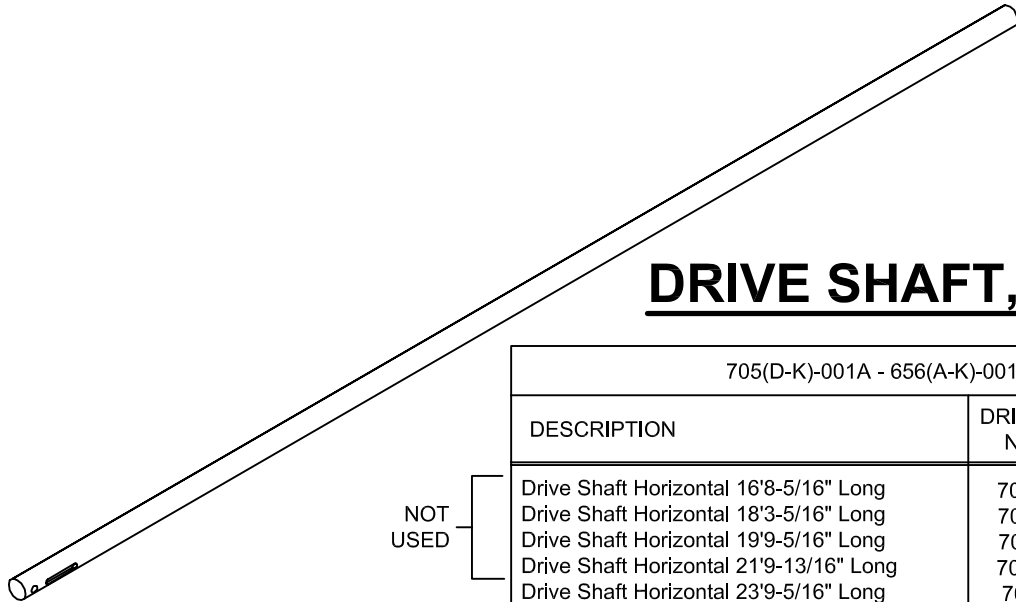
222-097A HARDWARE SACK,  
 (SHOULDER BOLT TO REPLACE  
 CLUTCH PIN) IS AVAILABLE TO  
 ORDER FOR SHIVERS DRI-FLO  
 BOTTOM UNLOADING MACHINES.  
 (P-12118 INSTALLATION  
 INSTRUCTIONS INCLUDED.)





# DRIVE SHAFT, 1"

698(D-K)-001A - 225(A-K)-001A - 220(D-N)-001A			
	DESCRIPTION	DRIVE SHAFT NUMBER	BIN DIAMETER
<b>CIRCULATOR</b>	Drive Shaft Yellow Horizontal 12'2-5/16" Long	220D-058P	15'11-18'7
	Drive Shaft Black Horizontal 13'9-5/16" Long	220E-058P	18'8-22'0
	Drive Shaft Blue Horizontal 15'1-13/16" Long	220F-058P	22'1-24'9
	Drive Shaft Green Horizontal 16'8-5/16" Long	220G-058P	24'10-27-10'
	Drive Shaft Red Horizontal 18'3-5/16" Long	220H-058P	27'11-31'0
	Drive Shaft Brown Horizontal 19'9-5/16" Long	220I-058P	31'1-34'0
	Drive Shaft White Horizontal 21'9-13/16" Long	220J-058P	34'1-38'0
	Drive Shaft Orange Horizontal 23'9-5/16" Long	220L-058P	38'1-42'0
<b>DRI-FLO</b>	Drive Shaft Black Horizontal 13'9-5/16" Long	220E-058P	15'11-18'7
	Drive Shaft Blue Horizontal 15'1-13/16" Long	220F-058P	18'8-22'0
	Drive Shaft Green Horizontal 16'8-5/16" Long	220G-058P	22'1-24'9
	Drive Shaft Red Horizontal 18'3-5/16" Long	220H-058P	24'10-27-10'
	Drive Shaft Brown Horizontal 19'9-5/16" Long	220I-058P	27'11-31'0
	Drive Shaft White Horizontal 21'9-13/16" Long	220J-058P	31'1-34'0
	Drive Shaft Orange Horizontal 23'9-5/16" Long	220L-058P	34'1-38'0
	Drive Shaft Horizontal 27'8-5/16" Long	220M-068W	38'1-42'0
	Drive Shaft Horizontal 29'8-5/16" Long	220N-068W	46'1-50'0



# DRIVE SHAFT, 1-1/4"

NOT USED

705(D-K)-001A - 656(A-K)-001A			
	DESCRIPTION	DRIVE SHAFT NUMBER	BIN DIAMETER
<b>NOT USED</b>	Drive Shaft Horizontal 16'8-5/16" Long	705D-007P	15'11-18'7
	Drive Shaft Horizontal 18'3-5/16" Long	705E-007P	18'8-22'0
	Drive Shaft Horizontal 19'9-5/16" Long	705F-007P	22'1-24'9
	Drive Shaft Horizontal 21'9-13/16" Long	705G-007P	24'10-27-10'
	Drive Shaft Horizontal 23'9-5/16" Long	705I-007P	36'0
	Drive Shaft Horizontal 27'8-5/16" Long	705J-007P	42'0
	Drive Shaft Horizontal 29'8-5/16" Long	705K-007P	48'0
	Drive Shaft Horizontal 12'2-5/16" Long	656A-007P	15'11-18'7
	Drive Shaft Horizontal 13'9-13/16" Long	656B-007P	18'8-22'0
	Drive Shaft Horizontal 15'1-5/16" Long	656C-007P	22'1-24'9
	Drive Shaft Horizontal 16'8-5/16" Long	656D-007P	24'10-27-10'
	Drive Shaft Horizontal 18'3-5/16" Long	656E-007P	27'11-31'0
	Drive Shaft Horizontal 19'9-13/16" Long	656F-007P	31'1-34'0
	Drive Shaft Horizontal 21'9-5/16" Long	656G-007P	36'0
	Drive Shaft Horizontal 25'1-5/16" Long	656I-007P	42'0
	Drive Shaft Horizontal 27'8" Long	656J-007P	48'0

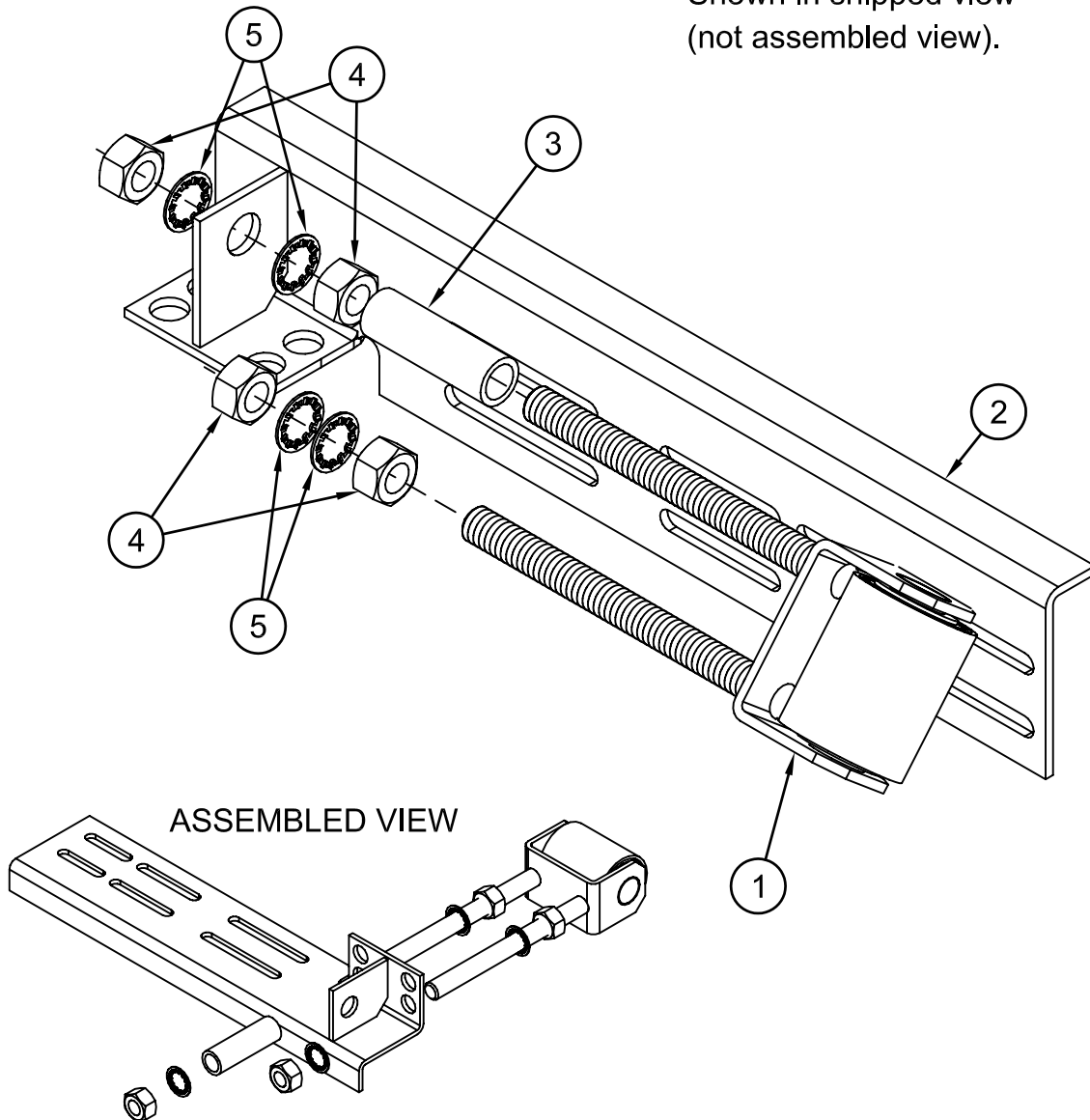
# BELT IDLER KIT

## (97D-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Belt Idler Assembly	1	97-030A
1	Idler Pulley Weldment	1	97-023W
2	Mounting Bracket Weldment	1	97-038W
3	Idler Spacer, 2-3/4"	1	97-040P
4	Nut, Hex, 5/8-11, UNC-2B	4	F-1011-06
5	Lockwasher, 5/8 Internal	4	F-1209
-	Belt Idler Instructions	1	P-8250

### NOTE:

Shown in shipped view  
(not assembled view).



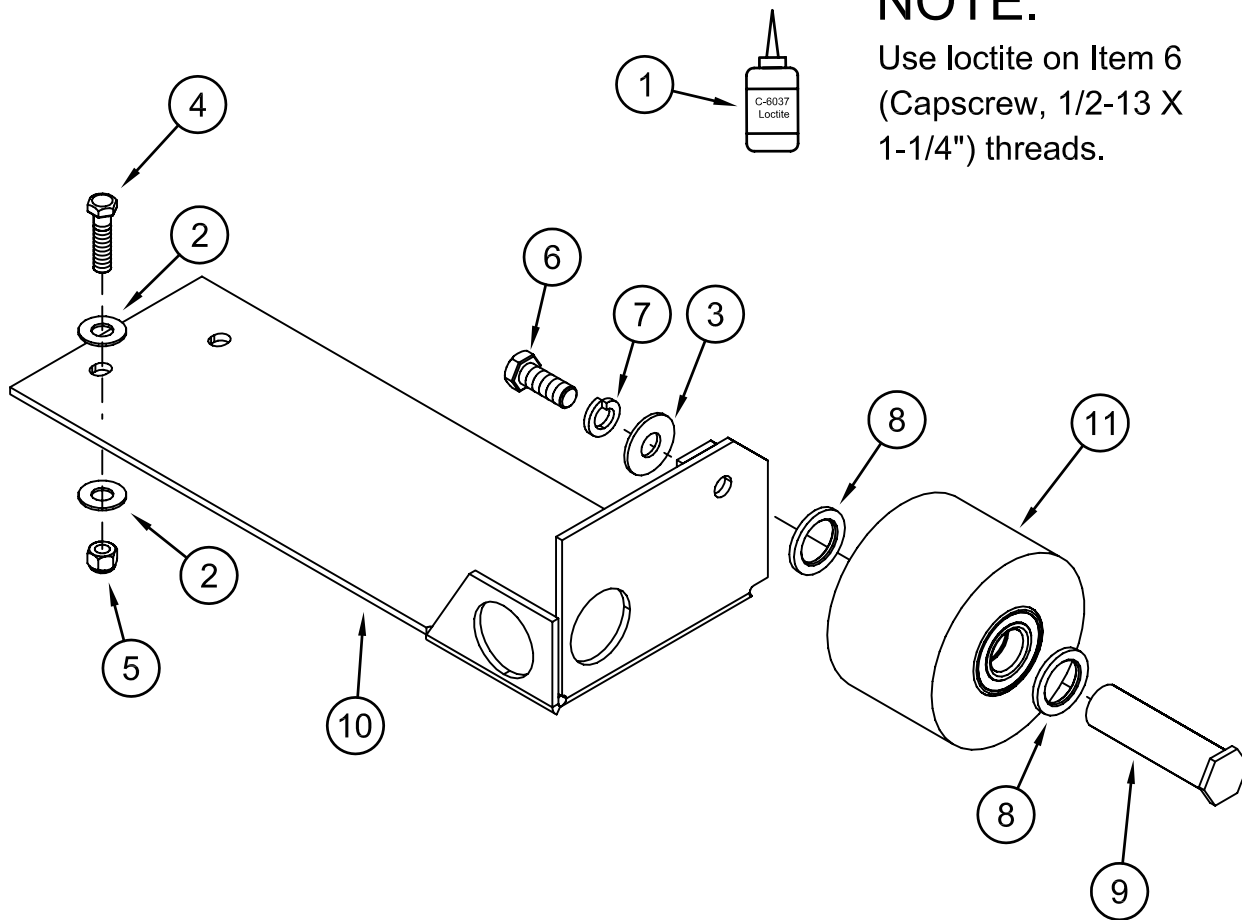
# DRI-FLO IDLER ASSEMBLY

## (672H-001A)

ITEM	DESCRIPTION	QTY	PART NO.	ITEM	DESCRIPTION	QTY	PART NO.
A	Sack, Dri-Flo Idler Hardware	1	672-078A	10	Dri-Flo Idler Mount	1	672-067W
1	Loctite Sealant, 5cc	1	C-6037	11	HTDK: Wide Idler Pulley	1	654-319A
2	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03				
3	Washer, Flat, Std, Steel 1/2"	1	F-1009-05				
4	Capscrew, 3/8-16 X 1-1/4", Gr. 5	4	F-1307				
5	3/8" Lock Nut w/ Nyloc	4	F-1239				
6	Capscrew, 1/2-13 X 1-1/4", Gr. 5	1	F-1386				
7	Lockwasher, 1/2" Split	1	F-1464				
8	1" Washer, 10 Ga.	2	606-303P				
9	Idler Pulley Shaft, Dri-Flo	1	672-081P				

### NOTE:

Use loctite on Item 6 (Capscrew, 1/2-13 X 1-1/4") threads.

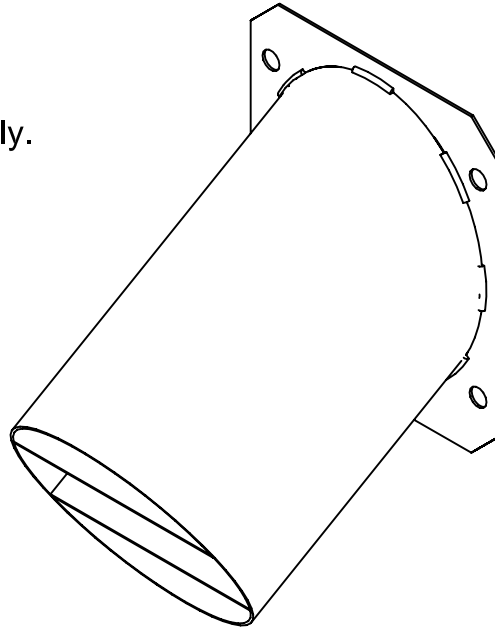


## 6" HORIZONTAL GRAIN OUTLET

(220-072W)

### NOTE:

Used on Dri-Flo Only.

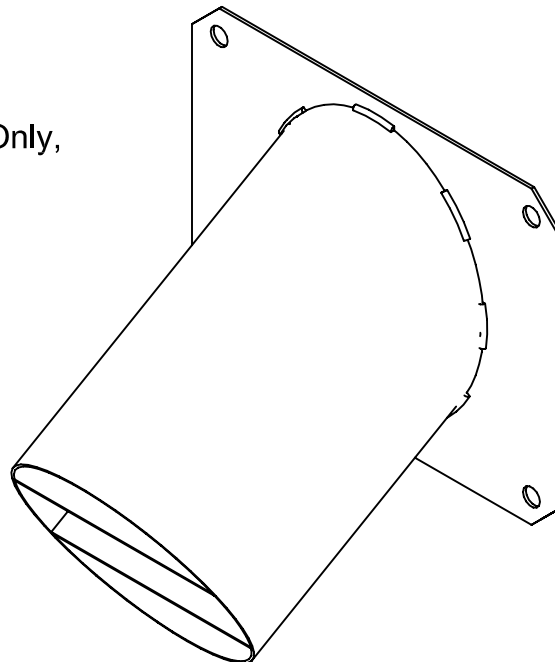


## 8" HORIZONTAL GRAIN OUTLET

(225-020W)

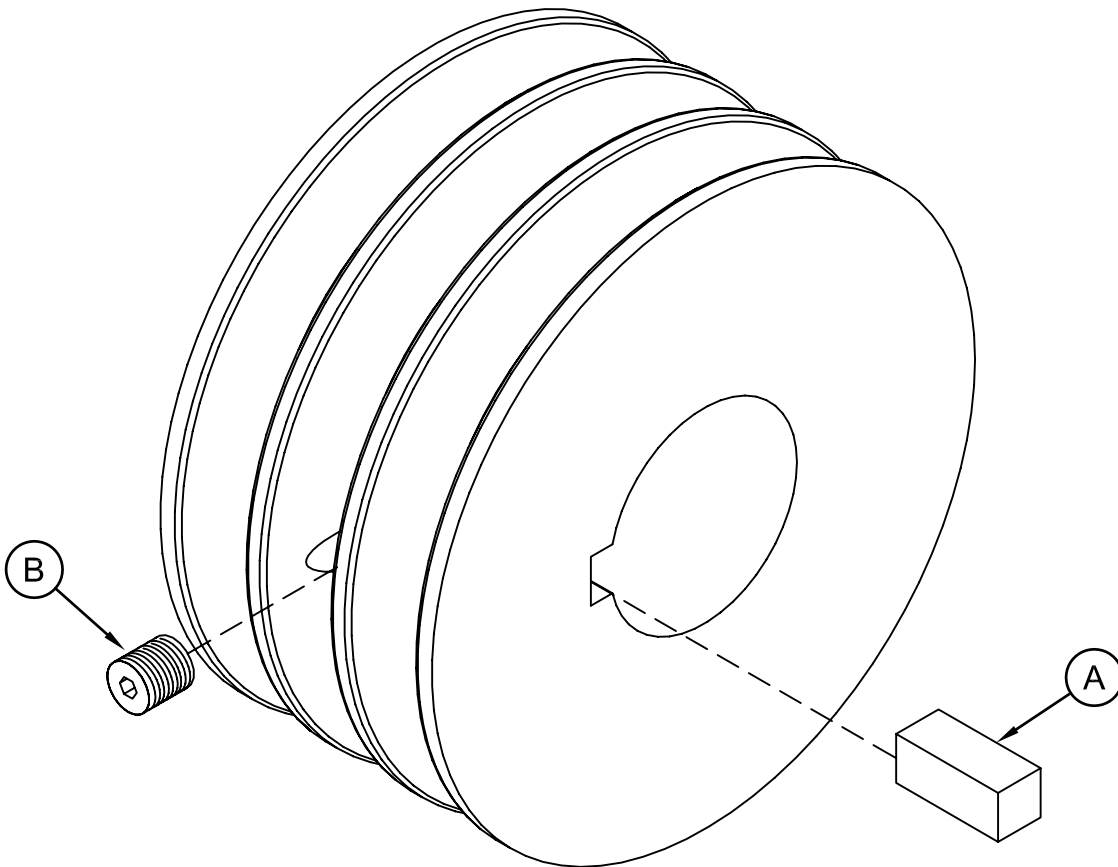
### NOTE:

Used on Dri-Flo Only,  
BEFORE 2007.



## 3 GROOVE MOTOR PULLEYS

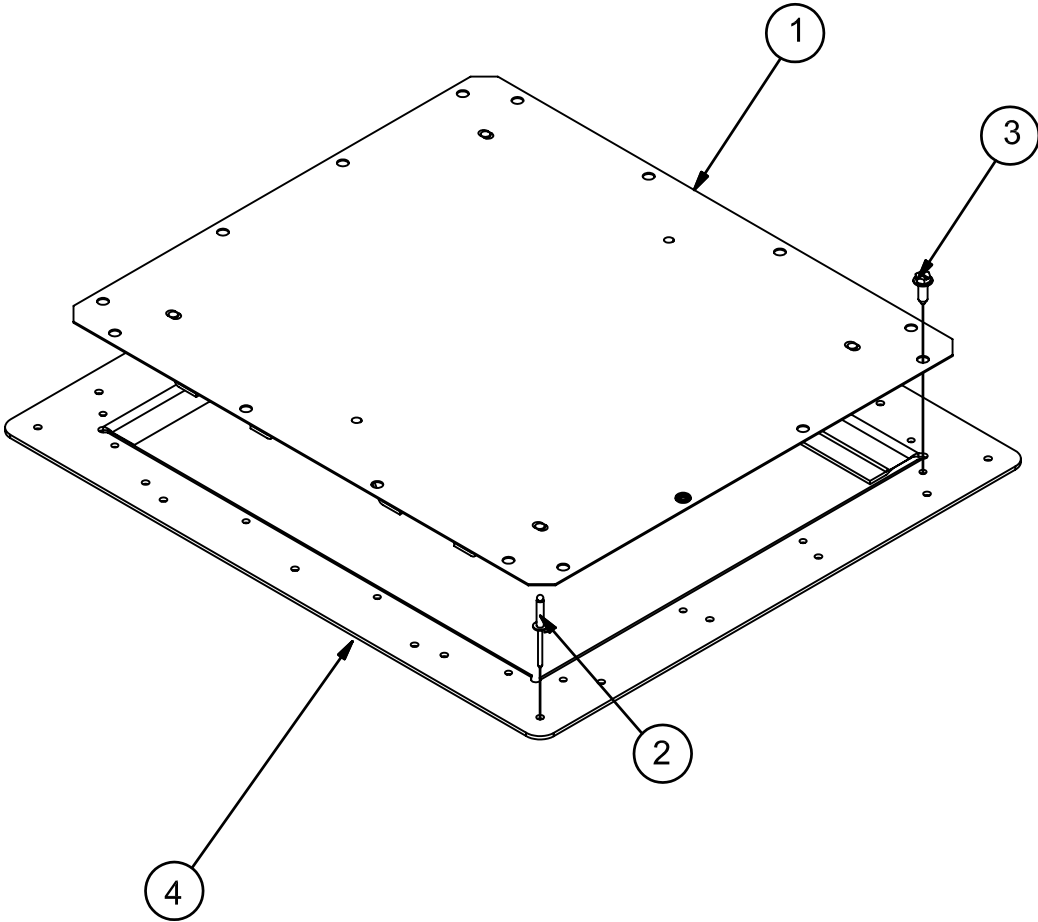
PULLEY ASSEMBLY #	3 GROOVE MOTOR PULLEY	(A) KEY	KEY SIZE	(B) SETSCREW	SETSCREW SIZE
249B-001A	3.25" O.D. and 1-1/8" Bore	249Z-018P	1/4" SQ. X 3/4" L	F-1007-22	5/16-18 X 3/8
249C-001A	3.25" O.D. and 1-3/8" Bore	249Z-019P	5/16" SQ. X 3/4" L	F-1007-21	5/16-18 X 1/4
249R-001A	3.75" O.D. and 1-3/8" Bore	249Z-019P	5/16" SQ. X 3/4" L	F-1007-21	5/16-18 X 1/4
249D-001A	4" O.D. and 1-1/8" Bore	249Z-018P	1/4" SQ. X 3/4" L	F-1007-21	5/16-18 X 1/4
249E-001A	4" O.D. and 1-3/8" Bore	249Z-019P	5/16" SQ. X 3/4" L	F-1007-21	5/16-18 X 1/4
249G-001A	4.5" O.D. and 1-3/8" Bore	249Z-019P	5/16" SQ. X 3/4" L	F-1007-21	5/16-18 X 1/4
249U-001A	3.75" O.D. and 1-5/8" Bore	249-027P	3/8" SQ. X 2" L	F-1007-21	5/16-18 X 1/4
249V-001A	4" O.D. and 1-5/8" Bore	249-027P	3/8" SQ. X 2" L	F-1007-21	5/16-18 X 1/4



# FLOOR DOOR KIT

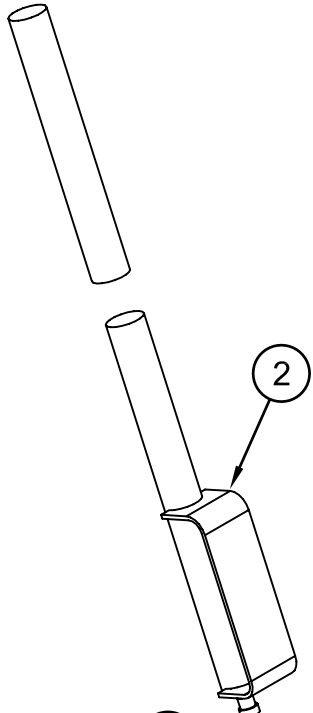
(423-397-001A)

Parts List			
ITEM	QTY	PART NO.	DESCRIPTION
1	1	665-042W	Access Cover Plate Wldt.
2	22	F-1095	Blind Rivet, 3/16
3	16	F-1785	Screw, Washerhead, #14 x 3/4"
4	1	665-043P	Access Frame
	1	P-12878	Installation Instructions

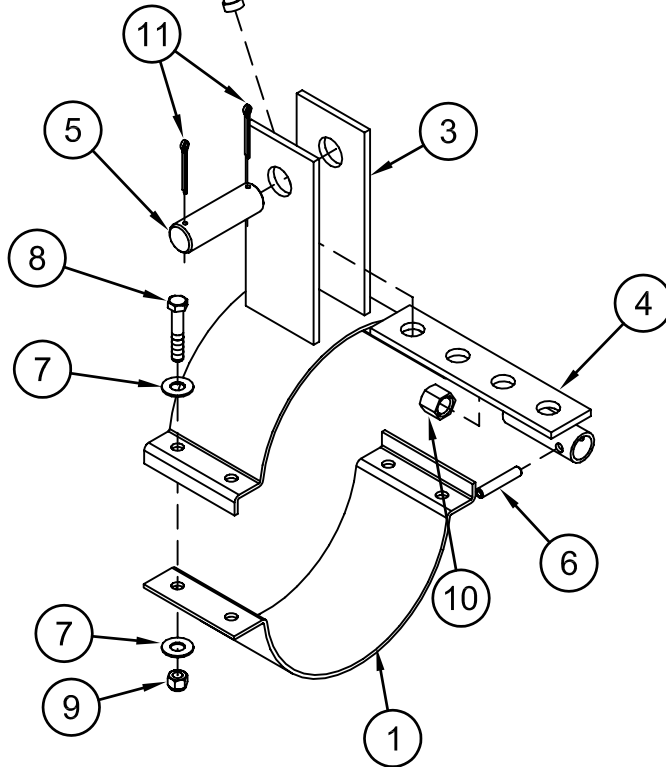


# 6" & 8" SLIDE GATE OPENER

(91A-001A) (91B-001A)



ITEM	DESCRIPTION	QTY	PART NO.
1	Half Band, 6" Half Band, 8"	1	201Z-023P 201B-024P
2	Lever Weldment	1	91-014W
3	Lever Pivot Weldment, 6" Lever Pivot Weldment, 8"	1	91A-002W 91B-002W
A	Slide Gate Opener Parts Sack	1	91-007A
4	Lever Rack Weldment	1	91-008W
5	Lever Pivot Pin	1	91-011P
B	Slide Gate Opener Hardware Sack	1	91-012A
6	Roll Pin, Single, 5/16 X 1-3/4"	1	F-1001-38
7	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
8	Capscrew, Hx, 3/8-16 X 2, Gr. 5	4	F-1073
9	Locknut, Hex, 3/8-16 w/ Nyloc	4	F-1239
10	Cap, 3/8"	1	H-1263
11	Plated Cotter Pin, 1/8 X 1-1/2"	2	H-1376
-	Install. Instr. Slide Gate Opener	1	P-8401



Control Rod from  
Bin Center

# SLIDE GATE OPENER, WINCH STYLE

91C-001A (8")

91D-001A (6")

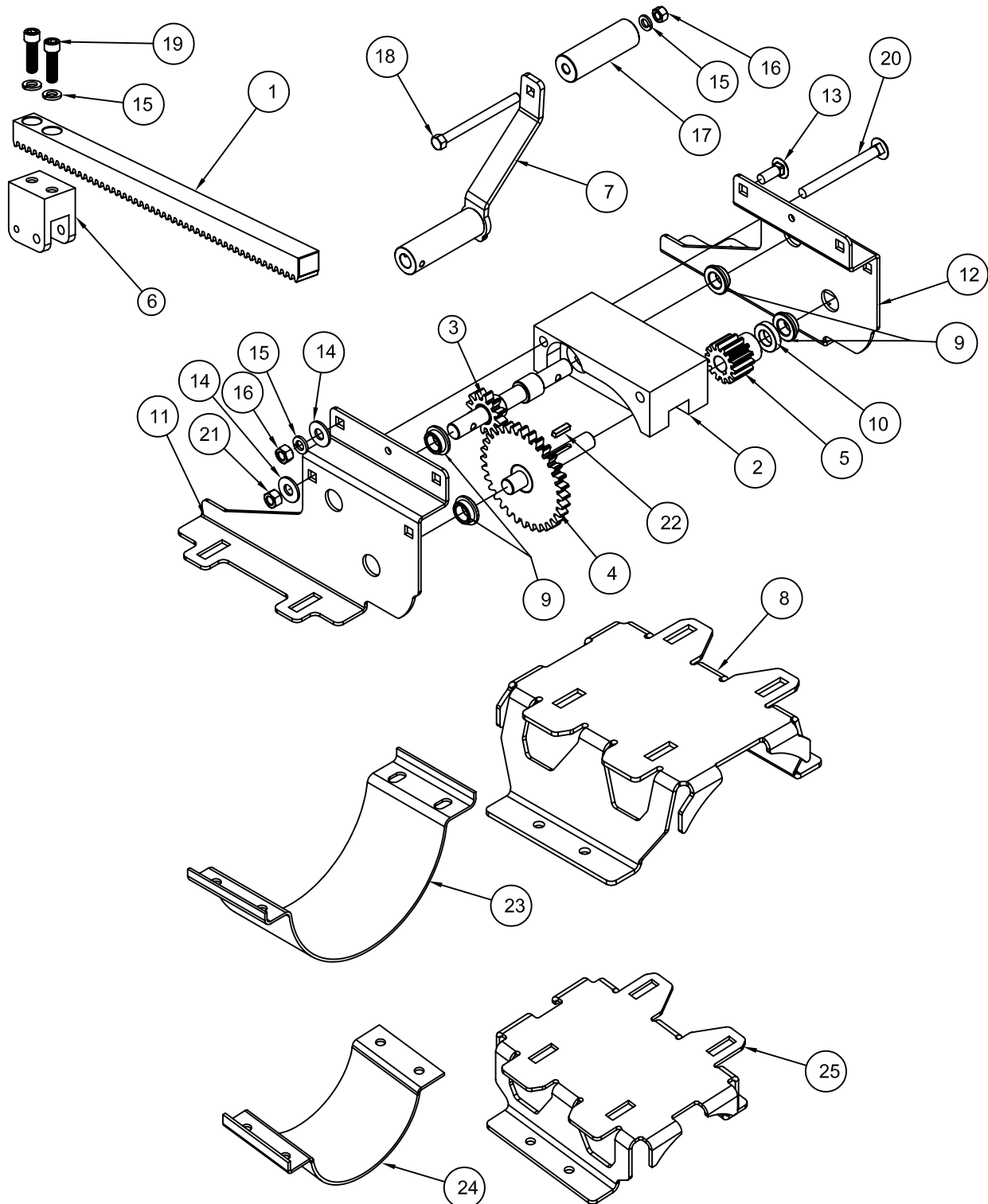
PART NO.	ITEM	DESCRIPTION
91-030P	1	SGO: RACK, 1 X 1 X 16
91-020P	2	SGO: GUIDE BLOCK
91-026W	3	SGO: SM GEAR SHAFT
91-028W	4	SGO: LG GEAR SHAFT
91-044P	5	GEAR, PINION: 10DP X 14T X 5/8"ID
91-043P	6	SGO: YOKE BLOCK
91-034W	7	SGO: CRANK
91-042P	8	SGO: MOUNTING BRKT.
91-031P	9	BEARING, FLANGED
91-032P	10	SPACER: 5/8IDX1-1/8OD
91-041P	11	SGO: EXT. SIDE: LH
91-040P	12	SGO: EXT. SIDE: RH
F-1274	13	CARRIAGE BOLT, 3/8 X 1"
F-1009-03	14	WASHER, FLAT, 3/8"
F-1019-03	15	LOCKWASHER, 3/8
F-1011-03	16	NUT, HEX, 3/8-16
91-038P	17	CRANK HANDLE
F-1541	18	CAPSCREW, 3/8-16 X 4-1/2
F-1170	19	SHCS, 3/8-16 X 1-1/4"
F-2094	20	CARRIAGE BOLT, 3/8-16 x 4" L
F-1005-03	21	LOCK NUT, 3/8-16
D-3937	22	KEY, SQ: 3/16X3/16X3/4L
201B-024P	23	HALF BAND, 8 IN X 4"
201Z-023P	24	HALF BAND, 6 IN X 4"
91-046P	25	SGO: MOUNTING BRKT, 6"



# SLIDE GATE OPENER, WINCH STYLE

91C-001A (8")

91D-001A (6")



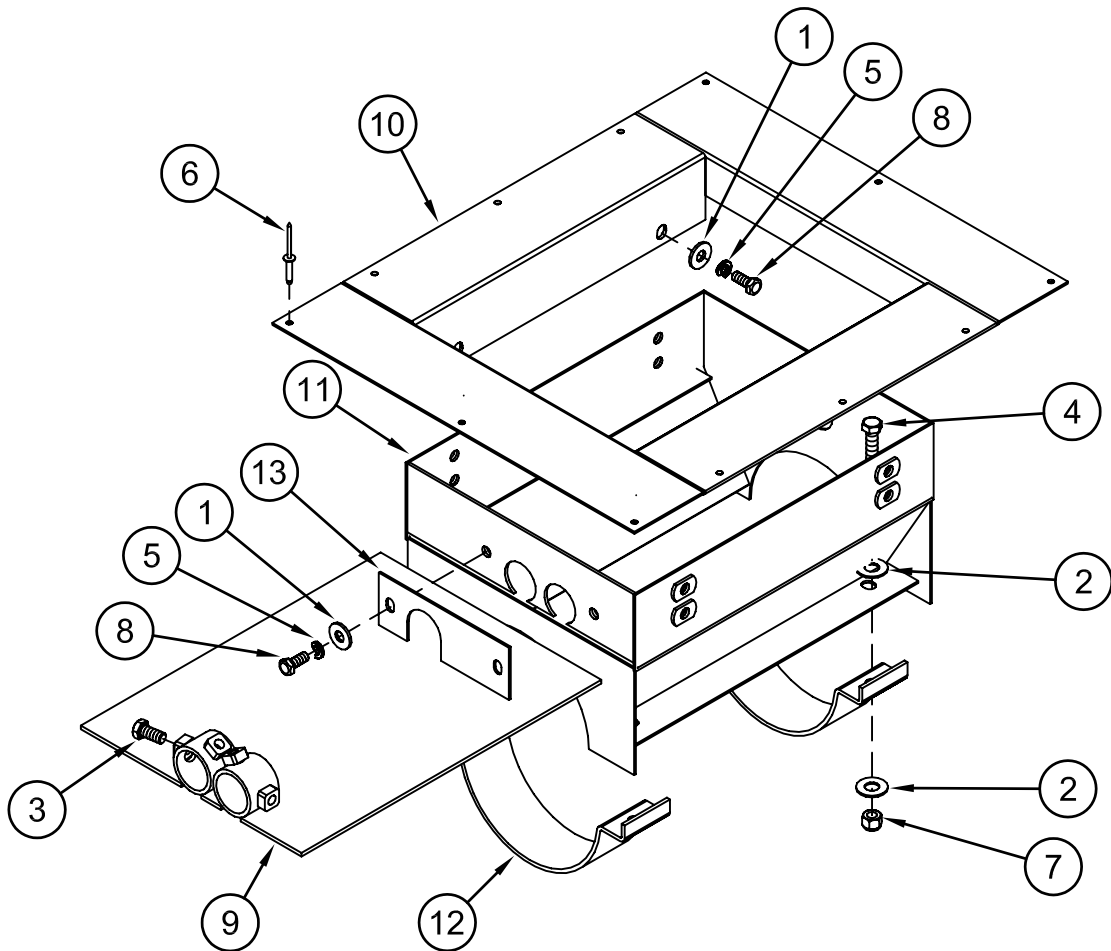
# 6" INTERMEDIATE WELL

## (555A-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Hardware Sack, Inter. Well	1	555-015A
1	Washer, Flat, Std, Steel, 5/16"	8	F-1009-02
2	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
3	Capscrew, Hx, 3/8-16 X 3/4", Gr. 5	2	F-1015-23
4	Capscrew, Hx, 3/8-16 X 1-3/4", Gr. 5	4	F-1015-28
5	Lockwasher, 5/16 Heavy Spring	8	F-1019-02
6	Rivet, Blind, 3/16D, .501-.615	14	F-1095
7	Locknut, Hex, 3/8-16 w/ Nyloc	4	F-1239
8	Capscrew, Hx, 5/16-18 X 3/4", Gr. 5	8	F-1546
9	Slide Gate Weldment	1	555-012W
10	6" Cover Flange Weldment	1	555-002W
11	Well Weldment, 6"	1	555-005W
12	Half Band, 6" X 2" Wide	2	222-079P
13	Slide Gate Cover Plate	1	556-007P
-	Instructions, Int. Well	1	P-11584

### NOTE:

1" Pipe, Schedule 40, is required for Control Rod, but is not supplied with kit.



# 8" INTERMEDIATE WELL

## (556A-001A)

ITEM	DESCRIPTION	QTY	PART NO.
A	Hardware Sack, Inter. Well	1	555-015A
1	Washer, Flat, Std, Steel, 5/16"	8	F-1009-02
2	Washer, Flat, Std, Steel, 3/8"	8	F-1009-03
3	Capscrew, Hx, 3/8-16 X 3/4", Gr. 5	2	F-1015-23
4	Capscrew, Hx, 3/8-16 X 1-3/4", Gr. 5	4	F-1015-28
5	Lockwasher, 5/16 Heavy Spring	8	F-1019-02
6	Rivet, Blind, 3/16D, .501-.615	14	F-1095
7	Locknut, Hex, 3/8-16 w/ Nyloc	4	F-1239
8	Capscrew, Hx, 5/16-18 X 3/4", Gr. 5	8	F-1546
9	Slide Gate Weldment	1	555-012W
10	8" Cover Flange Weldment	1	555-020W
11	Well Weldment, 8"	1	556-002W
12	Half Band, 8" X 2" Wide	2	556-005P
13	Slide Gate Cover Plate	2	556-007P
-	Instructions, Int. Well	1	P-11584

### NOTE:

1" Pipe, Schedule 40, is required for Control Rod, but is not supplied with kit.

