GENERAL NOTES:
Locate the center bin well so the bin sweep mounting tube is in the exact center of the bin. The center bin well may be a type that mounts at the end of an unloading tube or one that rests on top of an unloading tube that passes through the bin. When an intermediate bin well(s) is used it may be placed on the unloading tube between the center well and the bin wall. Observe the minimum spacings shown in Fig. 3. Wells should be positioned on the tube so that the gates will open when control pipes are pulled out and away from the center of the bin.

A control pipe kit may be ordered from the factory. Follow the specifications given if the control pipes are provided locally.

For the center well use 1/2 inch Sch. 40 pipe (about 7/8" O.D.). For the intermediate well(s) use 1 inch Sch. 40 pipe (about 1 3/8" O.D.). The control pipe for the center well will slide inside the control pipe for the intermediate well(s).

It may be necessary to support the bin well(s) and/or unloading tube from below with blocks or other material.

The extending flange at the top of the bin wells is intended to lay on top of the bin floor. Consult the manufacturer of the bin floor for direction on cutting openings in the floor for bin wells, for sealing around bin wells and for proper support of the floor around the bin wells and unloading tube.
**INSTALLATION STEPS**

**Step 1.** For center wells that are attached to the end of unloading tube.
Slide the center well onto the end of the unloading tube, until the end of the tube contacts the front of the bin well. Use hex head cap screw to clamp the center well's mounting band to unloading tube.

For intermediate wells and center wells that rest on the top of the unloading tube.
A. Determine the well location and cut an opening into the top side of the tube. See Fig. 4. The inlet opening should not be longer than 11 1/2" or cut further than within 1/2" of center line of tube. Grain will leak if inlet opening is cut too large.

NOTE: Remove unloading flight or chain and paddles from the tube before cutting to avoid damage to them.

Fasten bin wells to unloading tube using back band and six 5/16" x 1 1/2" long (grade 5) hex head cap screws and nuts. Be sure the tops of all bin wells are level. Wells should be positioned on the tube so the gates will open when control pipes are pulled out and away from the center of the bin.

![Fig. 4](image)

**Step 2.** Attach the intermediate bin well gate(s) to 1 3/8" O.D. control pipe: (See Assembly Sheet provided with the well.)
A. Shut the intermediate bin well gate(s).
B. Check length of control pipe by sliding in into place. Be sure there is at least 14" of control pipe extending past the back end of the last intermediate well, so when the gate is opened the end of the control pipe will not be drawn into the well. See Fig.3.
C. Drill a 3/8" dia. hole through one side of the 1 3/8" O.D. control pipe. The dimple of the control gate clamp will fit into this hole when clamped to the control gate. Determine the hole location by seeing where the dimple will hit the control pipe when it is bolted in place.
D. Fasten the control gate clamp to the control gate and control pipe. Secure in place by using two 5/16" x 1" long (grade 5) hex head cap screws, lockwashers and nuts.

**Step 3.** Attach the center well gate to 7/8" O.D. control pipe. (See Assembly Sheet provided with well.)
A. Shut the center control gate.
B. Drill a 3/8" dia. hole through the 7/8" O.D. control pipe 5/8" from the end.
C. Check length of control pipe by sliding it through the control pipe of intermediate well(s). When the control pipe is fastened to the control gate clamp, the center well control pipe should extend past the end of the intermediate well control pipe a minimum of 2 1/2". See Fig. 2.
D. Attach control gate clamp to control pipe by sliding 5/16" x 1 3/4" long roll pin through clamp and control pipe.
E. Fasten clamp to top side of control gate by using two 5/16" x 3/4" long (grade 5) carriage bolt, flat washers, lockwashers and nuts. Install nuts so they secure the 5/16" x 1 3/4" long roll pin in place.

Keep the amount of control pipe extending outside the bin short. This will permit opening the bin well gates without the control pipe striking unloading equipment attached to the auger tube. If you are using a factory control pipe kit, it may be necessary to shorten the center control pipe and redroll the holes depending on exact bin size and type of center well used.

Configure the control pipe ends as shown in Fig. 2 when all bin well gates are closed. The intermediate well(s) is opened by placing a bolt through the intermediate control end and the center control and then operating the center well control pipe. Intermediate wells should not be opened until the bin has emptied to where grain will no longer flow into the center well.

Check gate operation by separately pulling on the control pipes, control gates should slide freely.

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