The following instructions are to be used for assistance with the set-up and installation of equipment, accessories, and serviceable parts used on this machinery and are not meant to replace any operating or safety procedures as outlined in the Operator’s Manual included with the conveyor.

This safety symbol 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. 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.

CHAIN MAINTENANCE ACCESS KIT
for use with
6”, 8”, 10” & 12”
Double Run Stationary Grain Pumps®
and Grain Pump® Loop Systems

Access Kit Part No’s.

3’ Long Assembly  5’ Long Assembly
P2686A f/6”       P2687A f/6”
P2886A f/8”       P2887A f/8”
P3086A f/10”      P3087A f/10”
P3286A f/12”      P3287A f/12”

This kit consists of the components needed for installation of the horizontal chain access assemblies. Before beginning the installation process it is suggested to read through these instructions and make sure all items from the kit are accounted for.

This not only helps you become familiar with the installation procedures, but also makes you aware of tools or materials you may need to complete the installation process.

Although the components in these kits vary in size, the following installation procedures are the same for all Chain Maintenance Access Kits.

WARNING! Make certain all power driven equipment is shut-down and locked-out.

Use caution when working in areas above ground. Persons servicing, repairing or assembling equipment that requires above ground work shall be properly secured with the use of “fall protection” equipment as set forth by OSHA guidelines and regulations.

Metal buildings, scaffolding and other types of work surfaces can become slippery, especially when surfaces are wet and/or oily. This can create hazardous working conditions. Use caution when working, climbing or walking on these surfaces.

Use proper PPE (personal protective equipment) such as eye, ear, head and hand protection when working with power tools and metal materials.

Do Not operate the conveyor when access doors or protective covers are open. Keep loose clothing, hands, feet and other body parts away from moving parts.
Determine Chain Access Location

The chain access assembly can be installed anywhere along the length of the conveyor.

For Stationary Double Run Models, install only on the top conveyor tube. For Grain Pump® Loop Systems, install only on a horizontal plane. Typically the chain access on a loop system is installed near the standard corner after the dump hopper, but can also be installed in the upper tubing if a catwalk is available.

Once location has been determined, a top portion of the conveyor tubing will need to be cut-out for installation of the chain access assembly.

To begin installation, remove the back bands from their shipping location.

Remove and retain the hardware securing the safety screen and remove the screen (when reinstalling the screen, make sure not to overtighten the hardware as this can cause the hopper to become deformed).

Install Chain Access Assembly

1. With the screen removed from the hopper, place the chain access assembly on top of the conveyor tubing at the predetermined location.

2. Mark the conveyor tube from the inside of the hopper so there is a minimum of 1/2” (13 mm) of tube left all around the inside of the hopper (See illustration below). Grain will leak if the opening is too large, so be careful when marking and cutting the opening). **NOTE: Do Not cut the openings when the chain and paddles are inside the tube. Damage to the chain and/or paddles can occur.**

The illustration shows the 3’ chain access assembly as a reference only. The same procedure is also used for the 5’ chain access cut-out.

3. After the tubing has been cut, make sure to grind any rough edges and remove any debris that may have fallen into the tube.

Secure the hopper assembly to the conveyor tube using the 5/16” x 1 1/4” bolts, non-lock nuts and back bands provided. **NOTE: It is recommended to add additional support beneath the cutout section of tubing.**

4. Reinstall the safety screen into the hopper using the hardware previously retained. **NOTE: Do Not overtighten the hardware as this will cause the hopper to become deformed.**
3' Chain Access Kit, Band-On Model
Parts List
f/ 6", 8", 10” & 12” Stationary Double Run Grain Pumps®
and Grain Pump® Loop Systems

Item No. 3 (Screen Weldment) is attached using:
33229 – 3/8” x 1 1/4” Bolts, D1150 – 3/8” Lock Washers,
D1149 – 3/8” Non-Lock Nuts
Items No. 4 (Back Bands) are attached using:
1002215 – 5/16” x 1 3/4” Bolts,
33151 – 5/16” Non-Lock Nuts

Ref. Part
No. No. Description
1 1044237 3’ Chain Access Assembly f/ 6”
(1) 1044194 3’ Chain Access Assembly f/ 8”
(1) 1042204 3’ Chain Access Assembly f/ 10”
(1) 1044220 3’ Chain Access Assembly f/ 12”
2 1044238 Chain Access Weldment, f/ 6”
(2) 1044195 Chain Access Weldment, f/ 8”
(2) 1042205 Chain Access Weldment, f/ 10”
(2) 1044221 Chain Access Weldment, f/ 12”
3 1044240 Screen, f/ 6” Chain Access
(3) 1044198 Screen, f/ 8” Chain Access
(3) 1039835 Screen, f/ 10” Chain Access
(3) 1044222 Screen, f/ 12” Chain Access

Ref. Part
No. No. Description
4 1044236 Back Band, f/ 6” Tube
(4) 1044193 Back Band, f/ 8” Tube
(4) 1042207 Back Band, f/ 10” Tube
(4) 1043274 Back Band, f/ 12” Tube
5 4000A1 Hinge, 1/4” pin, 4” long
6 1018308 Rubber Latch
7 1018271 Bolt, #6 x 3/8” Pan Head
8 1018272 Washer, #6 Lock
9 1018273 Nut, #6 Non-Lock
10 1012872 Decal, Danger, Do Not Operate with Cover Open!

* Indented Parts Names Indicate these Parts are Included in the Previous Assembly.
# 5' Chain Access Kit, Band-On Model

## Parts List

**f/ 6”, 8”, 10” & 12” Stationary Double Run Grain Pump® and Grain Pump® Loop Systems**

<table>
<thead>
<tr>
<th>Ref. No.</th>
<th>Part No.</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1044228</td>
<td>5' Chain Access Assembly f/ 6&quot;</td>
</tr>
<tr>
<td>(1)</td>
<td>1044184</td>
<td>5' Chain Access Assembly f/ 8&quot;</td>
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<tr>
<td>(1)</td>
<td>1044172</td>
<td>5' Chain Access Assembly f/ 10&quot;</td>
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<tr>
<td>(1)</td>
<td>1043265</td>
<td>5' Chain Access Assembly f/ 12&quot;</td>
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<td>Chain Access Weldment, f/ 8&quot;</td>
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<td>(2)</td>
<td>1044173</td>
<td>Chain Access Weldment, f/ 10&quot;</td>
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<td>(2)</td>
<td>1046266</td>
<td>Chain Access Weldment, f/ 12&quot;</td>
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<td>1044231</td>
<td>Screen, f/ 6&quot; Chain Access</td>
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<tr>
<td>(3)</td>
<td>1041460</td>
<td>Screen, f/ 8&quot; Chain Access</td>
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<tr>
<td>(3)</td>
<td>1037557</td>
<td>Screen, f/ 10&quot; Chain Access</td>
</tr>
<tr>
<td>(3)</td>
<td>1039507</td>
<td>Screen, f/ 12&quot; Chain Access</td>
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</tbody>
</table>

**Cover Removed to Show Screen Detail**

**Top View (5' Chain Access Assembly)**

<table>
<thead>
<tr>
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<th>Description</th>
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<tbody>
<tr>
<td>4</td>
<td>1044236</td>
<td>Back Band, f/ 6&quot; Tube</td>
</tr>
<tr>
<td>(4)</td>
<td>1044193</td>
<td>Back Band, f/ 8&quot; Tube</td>
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<tr>
<td>(4)</td>
<td>1042207</td>
<td>Back Band, f/ 10&quot; Tube</td>
</tr>
<tr>
<td>(4)</td>
<td>1043274</td>
<td>Back Band, f/ 12&quot; Tube</td>
</tr>
<tr>
<td>5</td>
<td>4000A1</td>
<td>Hinge, 1/4&quot; pin, 4&quot; long</td>
</tr>
<tr>
<td>6</td>
<td>1018308</td>
<td>Rubber Latch</td>
</tr>
<tr>
<td>7</td>
<td>1018271</td>
<td>Bolt, #6 x 3/8&quot; Pan Head</td>
</tr>
<tr>
<td>8</td>
<td>1018272</td>
<td>Washer, #6 Lock</td>
</tr>
<tr>
<td>9</td>
<td>1018273</td>
<td>Nut, #6 Non-Lock</td>
</tr>
<tr>
<td>10</td>
<td>1012872</td>
<td>Decal, Danger, Do Not Operate with Cover Open!</td>
</tr>
</tbody>
</table>

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