ASSEMBLY INSTRUCTIONS

STATIONARY & PORTABLE DRIVE OVER CHAIN CONVEYOR
DRIVE OVER PLATE REINFORCEMENT

RIGHT and LEFT DESIGNATION
When referencing the left, right, front, or rear of the conveyor, it is always determined by standing at the inlet end of the conveyor and looking towards the discharge end.

INSTALLATION

1. Remove main hopper cover plates and side dump opening cover. It may also be necessary to remove the screen and hopper belting. It is not required to remove the chain & paddles for installation. However, it may be necessary to loosen the chain to provide adequate working clearance.

2. Clean hopper and surrounding area of flammable material.

Figure 1. Cover Plates Removed
3. Remove the four flat bars as shown in Fig. 2. The two flat bars on edge will remain in place.

4. Cut out the current upper paddle guides as shown in Fig. 3. Grind any protruding welds.
   **Note:** The old guides are tabbed into the side panels, which may make removal more difficult.

5. Install the new lower paddle guides (1042225) and upper paddle guides (1042223) as shown in Figure 4. The new paddle guides should be welded to the old paddle guides, and with a 1” weld every 3” along the side panel. It may be beneficial to only tack the guide panels in place until the hopper support bars are in place to ensure proper fit.
6. Install the new support bars as shown in Fig. 5. The bars should be flush with the top of the side panels. The two 1-1/4” tall bars (1042222) are used under the strip of metal between the main hopper opening and the side dump hopper opening. Weld this corner 2” every 5”. Weld all around the ends of the support bars. Finish welding the guide panels in place.

![Figure 5. Hopper Bar Installation](image)

7. Re-install cover panels & screen. Re-tension chain if necessary.