W13

Portable Grain Auger Assembly Manual

This manual applies to the following models:

Westfield W13, Hutchinson W13, Mayrath W13:

31', 36', 41'

Read this manual before using product. Failure to follow instructions and safety precautions can result in serious injury, death, or property damage. Keep manual for future reference.

Part Number: 30749 R1

Revised: November 2021

Original Instructions

New in this Manual

The following changes have been made in this revision of the manual:

Description	Section
Updated manual format	various sections

CONTENTS

1. Introduction

Before assembling, please read this manual. Familiarize yourself with the process and the necessary precautions for efficient and safe assembly of this AGI Portable Grain Auger.

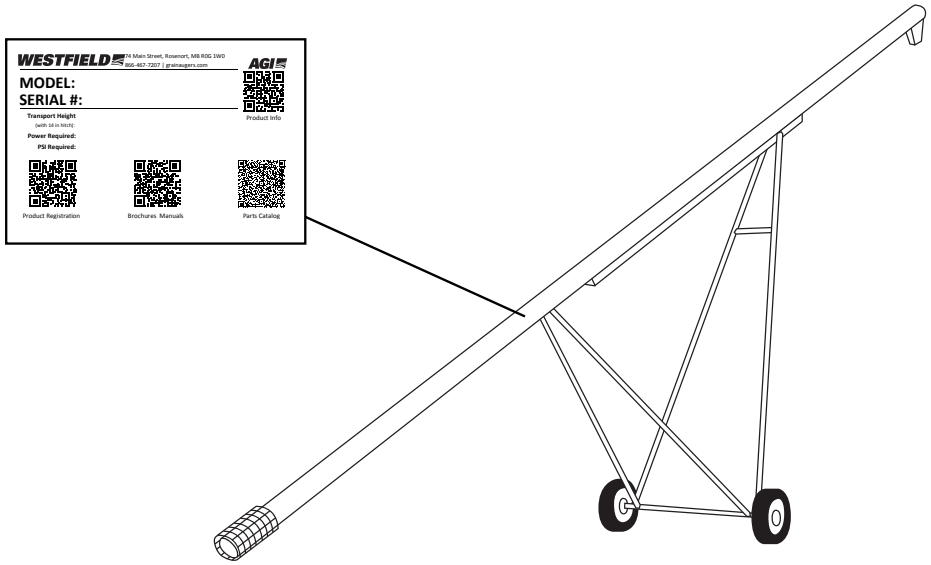
Everyone present at the assembly site is required to be familiar with all safety precautions.

Keep this manual available for frequent reference and review it with new personnel. Call your local distributor or dealer if you need assistance or additional information.

1.1. Serial Number Location

The serial number location for your auger is shown in the figure below. Have the serial number ready when ordering parts or requesting service or other information. Record information in the table below for easy reference.

Model Number	
Serial Number	
Date Received	



2. Safety

2.1. Safety Alert Symbol and Signal Words

This safety alert symbol indicates important safety messages in this manual. When you see this symbol, be alert to the possibility of injury or death, carefully read the message that follows, and inform others.

Signal Words: Note the use of the signal words **DANGER**, **WARNING**, **CAUTION**, and **NOTICE** with the safety messages. The appropriate signal word for each message has been selected using the definitions below as a guideline.

DANGER Indicates an imminently hazardous situation that, if not avoided, will result in serious injury or death.

WARNING Indicates a hazardous situation that, if not avoided, could result in serious injury or death.

CAUTION Indicates a hazardous situation that, if not avoided, may result in minor or moderate injury.

NOTICE Indicates a potentially hazardous situation that, if not avoided, may result in property damage.

2.2. General Safety Information

Read and understand all safety instructions, safety decals, and manuals and follow them when assembling the equipment.

- Only experienced personnel who are familiar with this type of assembly and installation should perform this work. Untrained assemblers/installers expose themselves and bystanders to possible serious injury or death.
- Do not modify the auger in any way or deviate from the instructions in this manual without written permission from the manufacturer. Unauthorized modification or methods may impair the function and/or safety. Any unauthorized modification will void the warranty.
- Follow a health and safety program for your worksite. Contact your local occupational health and safety organization for information.
- Contact your local representative or AGI if you need assistance or additional information.
- Always follow applicable local codes and regulations.

2.3. Rotating Flighting Safety

DANGER

- KEEP AWAY from rotating flighting.
- DO NOT remove or modify flighting guards, doors, or covers. Keep in good working order. Have replaced if damaged.
- DO NOT operate the auger without all guards, doors, and covers in place.
- NEVER touch the flighting. Use a stick or other tool to remove an obstruction or clean out.
- Shut off and lock out power to adjust, service, or clean.

2.4. Rotating Parts Safety

WARNING

- Keep body, hair, and clothing away from rotating pulleys, belts, chains, and sprockets.
- Do not operate with any guard removed or modified. Keep guards in good working order.
- Shut off and lock out power source before inspecting or servicing machine.

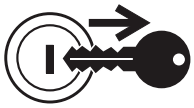
2.5. Hand Winch Safety

WARNING **When Equipped:**

- Inspect lift cable before using. Replace if frayed or damaged. Make sure lift cable is seated properly in cable sheaves and cable clamps are secure.
- Tighten brake lock by turning winch handle clockwise at least two clicks after lowering the auger.
- Lower the auger fully before towing, then rotate winch handle until cable has light tension.
- Do not lubricate winch brake discs.

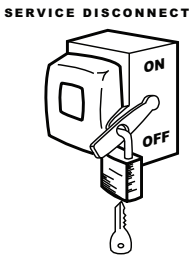
2.6. Drives and Lockout Safety

Inspect the power source(s) before using and know how to shut down in an emergency. Whenever you service or adjust your equipment, make sure you shut down the power source and unplug or remove the key (as applicable) to prevent inadvertent start-up and hazardous energy release. Know the procedure(s) that applies to your equipment from the following power source(s). Ensure that all personnel are clear before turning on power to equipment.



2.6.1 Electric Motor Safety

⚠ WARNING **Power Source**



- Electric motors and controls shall be installed and serviced by a qualified electrician and must meet all local codes and standards.
- Use a magnetic starter to protect the electric motor.
- You must have a manual reset button.
- Reset and motor starting controls must be located so that the operator has full view of the entire operation.
- Locate main power disconnect switch within reach from ground level to permit ready access in case of an emergency.
- Motor must be properly grounded.
- Ensure electrical wiring and cords remain in good condition; replace if necessary.

Lockout

- The main power disconnect switch should be in the locked position during shutdown or whenever maintenance is performed.
- If reset is required, disconnect all power before resetting motor.

2.6.2 PTO Driveline Safety

⚠ WARNING **Drive**

- Keep body, hair, and clothing away from rotating PTO driveline.
- Make certain the driveline shields telescope and rotate freely on driveline before attaching.
- Make certain the driveline is securely attached at both ends.
- Do not operate auger unless all driveline, tractor, and equipment shields are in place and in good working order.
- Do not exceed the specified operating speed.
- Keep universal joint angles small and equal. Do not exceed maximum recommended length for PTO driveline.
- Engage tractor park brake and/or chock wheels.

Lockout

- Position all controls in neutral, shut off tractor's engine, and remove key from tractor.
- If removing key is impossible, remove PTO driveline from tractor.

2.7. Tire Safety

⚠ WARNING Failure to follow proper procedures when mounting a tire on a wheel or rim can produce an explosion that may result in serious injury or death.

- DO NOT attempt to mount a tire unless you have the proper equipment and experience to do the job.
- Have a qualified tire dealer or repair service perform required tire maintenance.
- When replacing worn tires, make sure they meet the original tire specifications. Never undersize the replacement tire.
- DO NOT weld to the tire rim with the tire mounted on the rim. This action may cause an explosion which could result in serious injury or death.
- Inflate tires to the manufacturer's recommended pressure.
- Tires should not be operated at speeds higher than their rated speed.
- Keep wheel lug nuts tightened to manufacturer's recommendations.
- Never reinflate a tire that has been run flat or seriously under-inflated without removing the tire from the wheel. Have the tire and wheel closely inspected for damage before remounting.

2.8. Personal Protective Equipment

The following Personal Protective Equipment (PPE) should be worn when operating or maintaining the equipment.

Safety Glasses

- Wear safety glasses at all times to protect eyes from debris.

Hearing Protection

- Wear ear protection to prevent hearing damage.

Coveralls

- Wear coveralls to protect skin.

Hard Hat

- Wear a hard hat to help protect your head.

Steel-Toe Boots

- Wear steel-toe boots to protect feet from falling debris.

Work Gloves

- Wear work gloves to protect your hands from sharp and rough edges.

Dust Mask

- Wear a dust mask to prevent breathing potentially harmful dust.

2.9. Safety Equipment

The following safety equipment should be kept on site.

Fire Extinguisher

- Provide a fire extinguisher for use in case of an accident. Store in a highly visible and accessible place.

First-Aid Kit

- Have a properly-stocked first-aid kit available for use should the need arise, and know how to use it.

2.10. Safety Decals

- Keep safety decals clean and legible at all times.
- Replace safety decals that are missing or have become illegible. See decal location figures that follow.
- Replaced parts must display the same decal(s) as the original part.
- Replacement safety decals are available **free of charge** from your distributor, dealer, or factory as applicable.

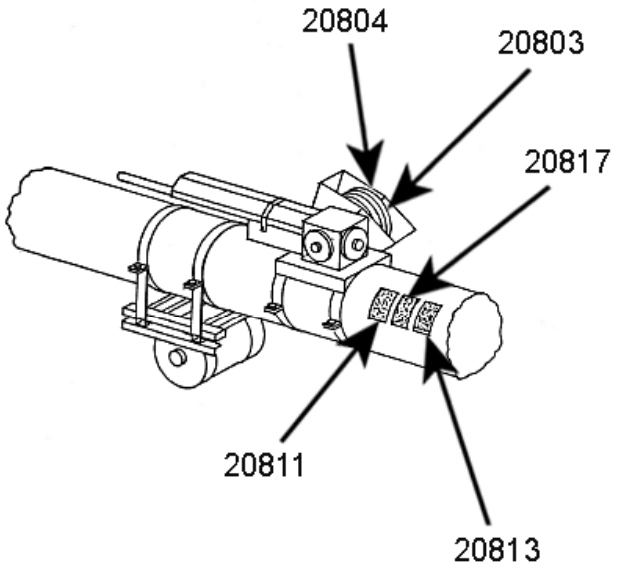
2.10.1 Decal Installation/Replacement

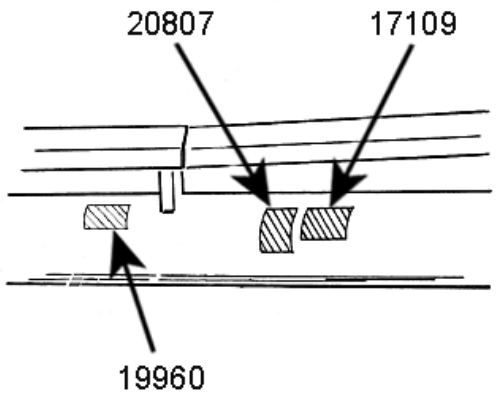
1. Decal area must be clean and dry, with a temperature above 50°F (10°C).

2. Decide on the exact position before you remove the backing paper.
3. Align the decal over the specified area and carefully press the small portion with the exposed sticky backing in place.
4. Slowly peel back the remaining paper and carefully smooth the remaining portion of the decal in place.
5. Small air pockets can be pierced with a pin and smoothed out using the decal backing paper.

2.10.2 Safety Decal Locations and Details

Replicas of the safety decals that are attached to the auger and their messages are shown in the figure(s) that follow. Safe operation and use of the auger requires that you familiarize yourself with the various safety decals and the areas or particular functions that the decals apply to, as well as the safety precautions that must be taken to avoid serious injury, death, or damage.





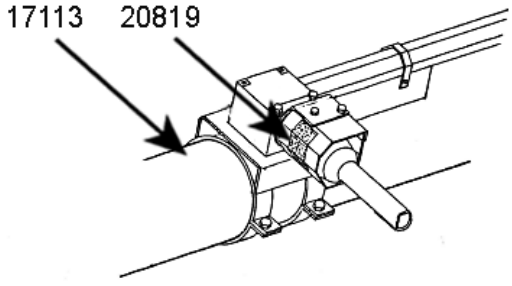


Table 1. Safety Decals

Part Number	Description
20813	
20817	

Table 1 Safety Decals (continued)

Part Number	Description
20819	

Table 1 Safety Decals (continued)

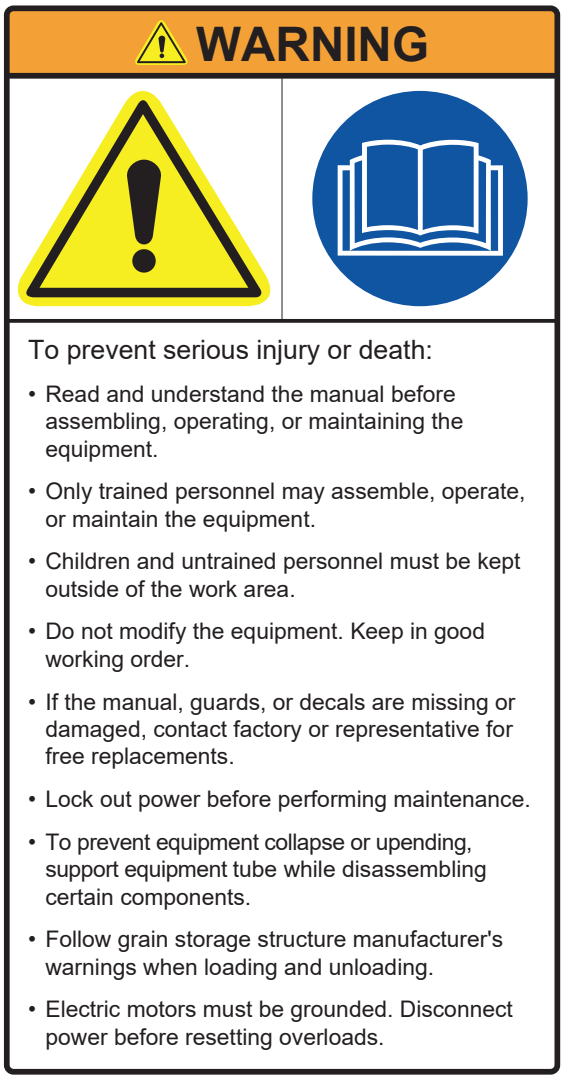
Part Number	Description
20807	

Table 1 Safety Decals (continued)

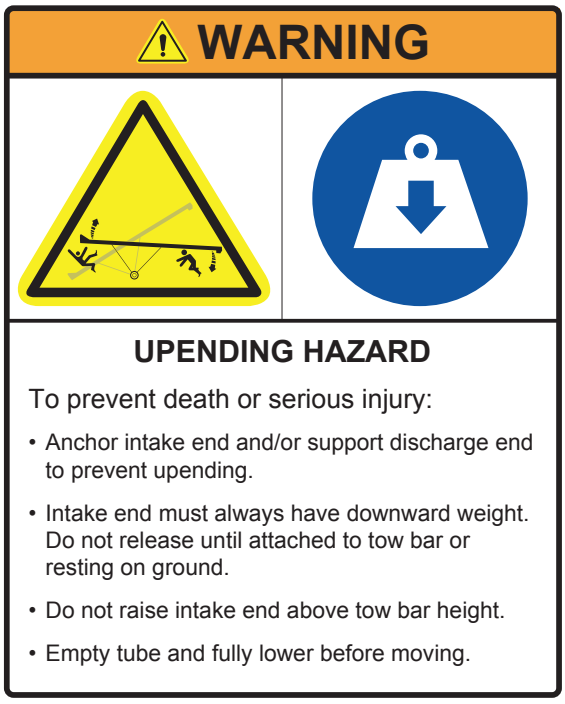
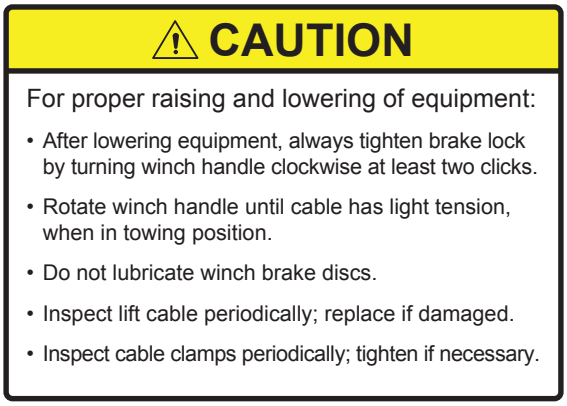
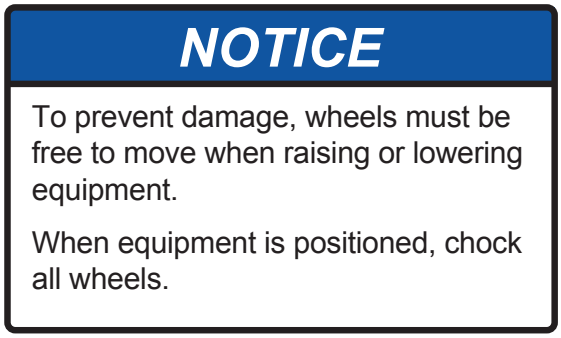
Part Number	Description
20811	
20804	

Table 1 Safety Decals (continued)

Part Number	Description
20803	
17113	
17109	
19960	

3. Assembly

Before continuing, ensure you have completely read and understood this manual's Safety section, in addition to the safety information in the section(s) below.

3.1. Assembly Safety

⚠ WARNING

- Do not take chances with safety. The components can be large, heavy, and hard to handle. Always use the proper tools, rated lifting equipment, and lifting points for the job.
- Carry out assembly in a large open area with a level surface.
- Always have two or more people assembling the auger.
- Make sure you have sufficient lighting for the work area.
- Tighten all fasteners according to their specifications. Do not replace or substitute bolts, nuts, or other hardware that is of lesser quality than the hardware supplied by the manufacturer.

3.2. Check Shipment

Unload the auger parts at the assembly site and compare the packing slip to the shipment. Ensure that all items have arrived and that none are damaged. Take pictures of shipments prior to or just after unloading if there are any damaged parts.

Report missing or damaged parts immediately to ensure that proper credit is received from AGI or your representative, and to ensure that any missing parts can be shipped quickly to avoid holding up the assembly process.

Important

Do not assemble or install damaged components.

3.3. Before You Begin

Before you assemble the auger:

- Familiarize yourself with all the sub-assemblies, components, and hardware that make up the equipment.
- Have all parts and components on hand, and arrange them for easy access.
- Separate the hardware (bolts, nuts, etc.) and lay them out into groups for easier identification during assembly.
- If assembling inside, confirm the ceiling and door width/height provide enough clearance when installing the undercarriage and to remove the auger from the building.
- Ensure there is adequate space to remove the assembled auger from the assembly area.

3.4. Arrange the Tubes and Apply Model Decals

Identify and Arrange the Auger Tube Sections

1. Align tube sections on a series of support stands, placing a support stand at the end of each tube (see the figures below for correct tube identification and positioning).
2. As tubes sections are added, make sure that support stands are at equal heights across all tubes to ensure that tubes are level with each other. Otherwise, use some form of shim to keep the tubes level across all of the support stands.

Important

Strap tubes to the support stands to prevent the tubes from rolling off the stands.

Figure 1. 31' Auger Tube Sections

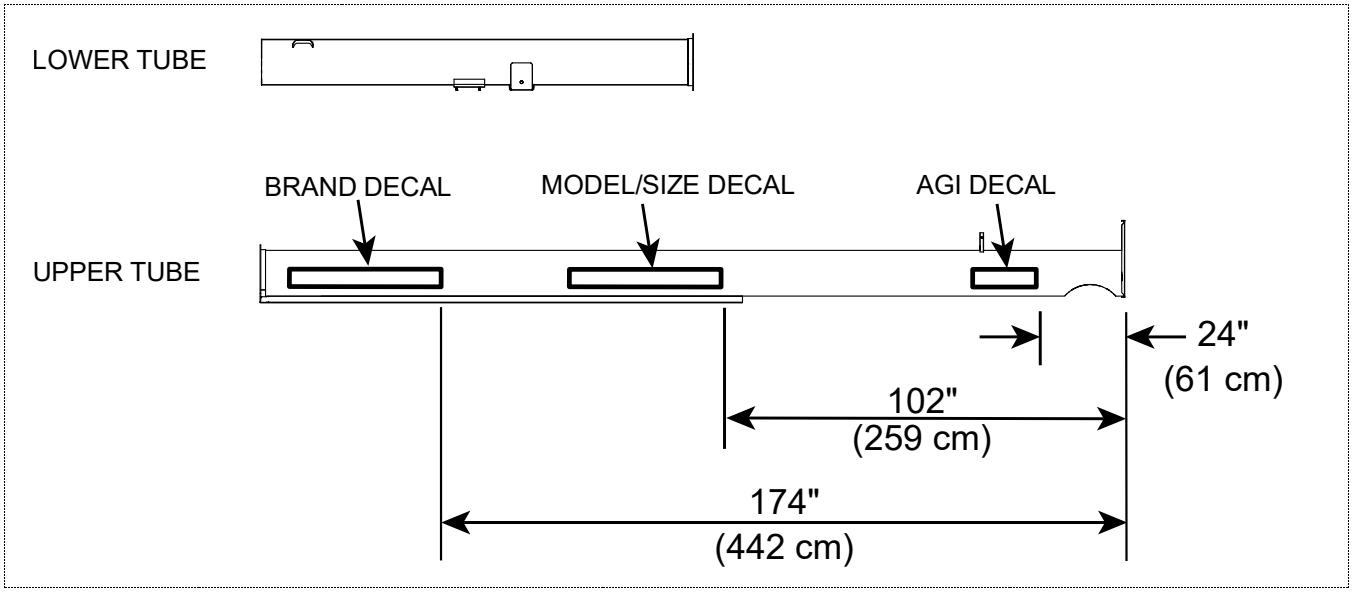


Figure 2. 36' Auger Tube Sections

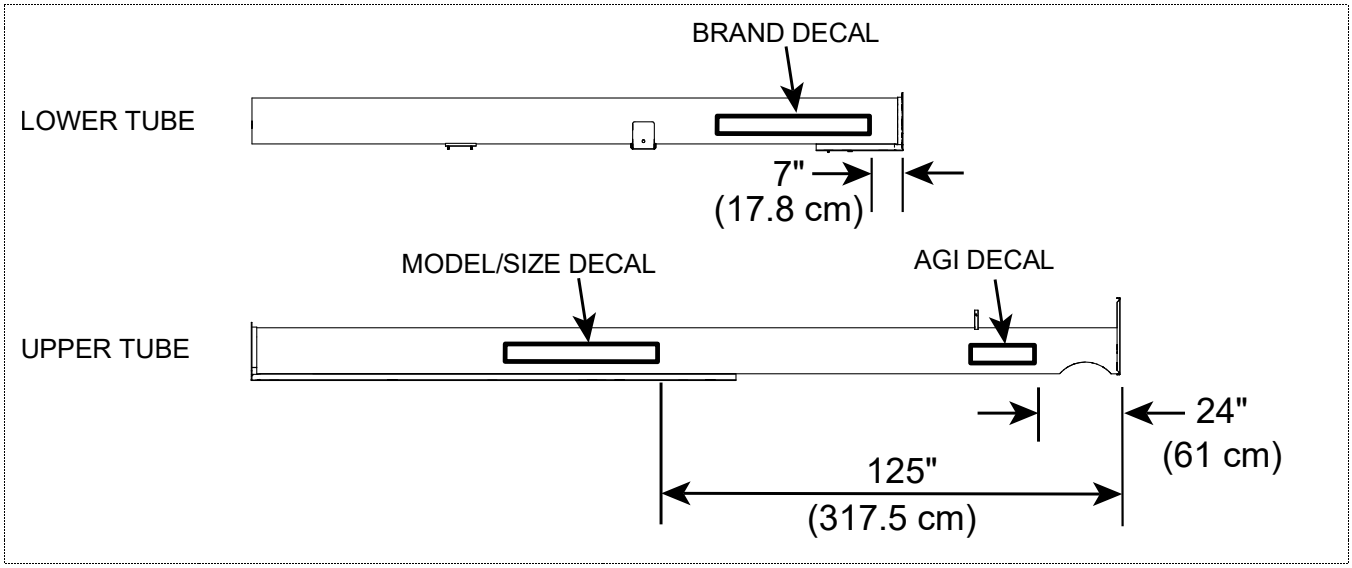
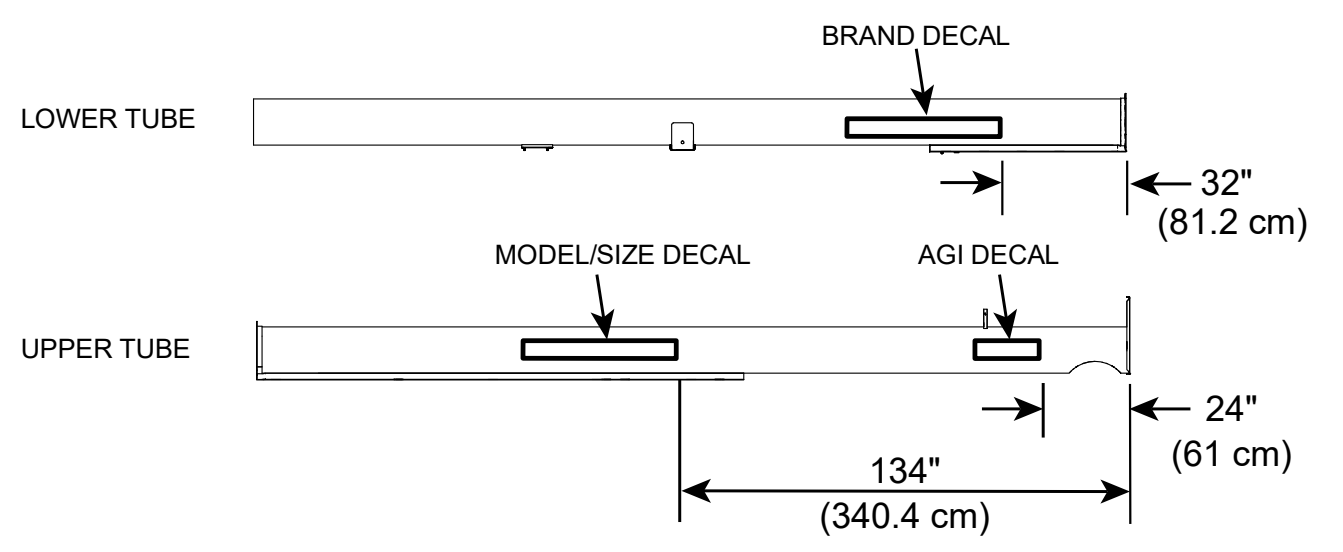


Figure 3. 41' Auger Tube Sections

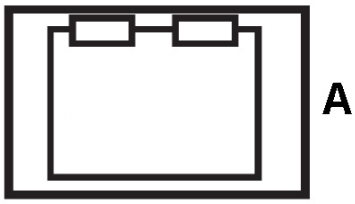


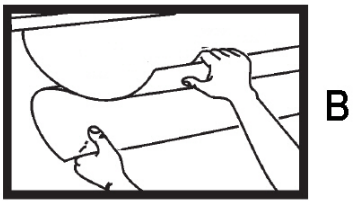
Apply the Logo and Model Decals on the Auger Tubes

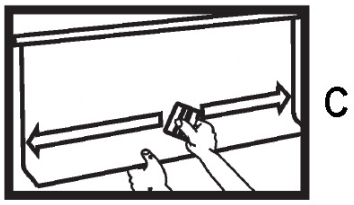
Important

Do not cover any existing safety or instruction decals with the model decals.

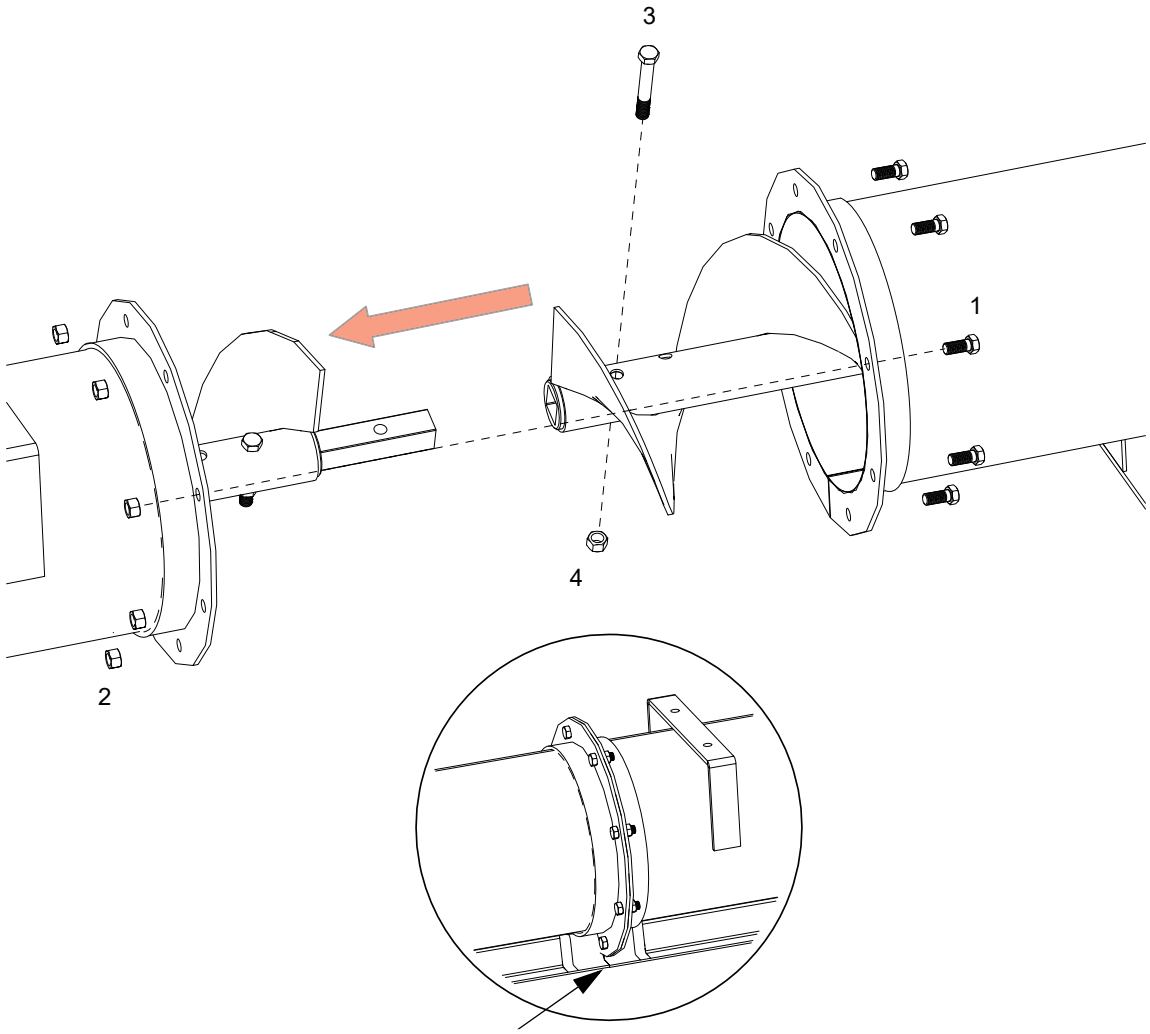
1. Prepare surface by cleaning thoroughly with soap and water. Surface must be clean and free of dirt, grime, rust and oil. To clean oily surface, wipe with clean cloth and solvent cleaner or isopropyl alcohol.
2. Apply decals to both sides of the auger tube. Center decals vertically on the tube and apply masking tape along the top, creating a gate hinge. Figure A demonstrates.
3. Remove backing paper from decal 6" (15.2 cm) from the top and use the squeegee to adhere decal to the tube, as seen in Figure B. Start at the top center of the decal and work your way outward both left and right using overlapping strokes.
4. As you work your way down the decal, peel back the backing paper 6" (15.2 cm) at a time. Repeat Step 3 until the entire decal has been applied to the tube. See Figure C as an example.
5. Once the entire decal has been properly adhered to the tube, remove tape hinge from front of decal. Remove the front application tape at a sharp 180° angle.
6. Inspect the entire decal for air pockets; if found, remove them by punching a tiny hole with a pin and then squeegee the surface flat.
7. As a final process, squeegee the corners and edges of the decal to ensure proper adhesion and to prevent premature peeling.


A


B


C

3.5. Connect the Auger Tubes



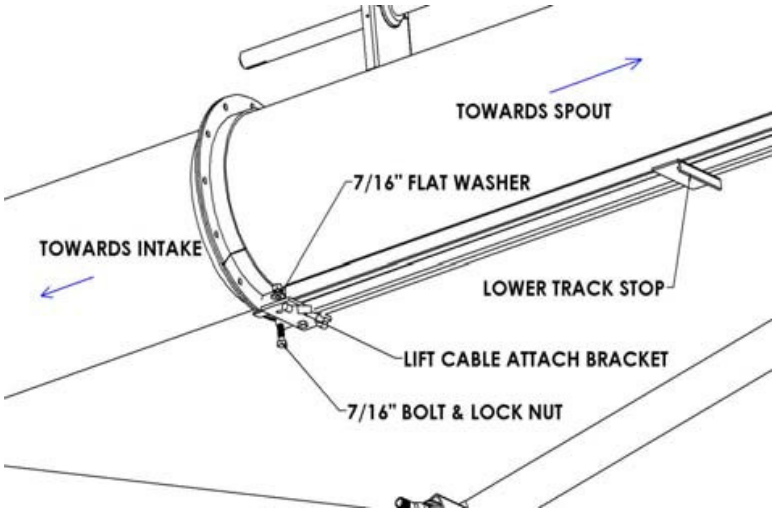
Assembly Note:

- Always strap tubes to the support stands to prevent the tubes from rolling off the stands.
- Assemble the auger tube starting with the discharge section and working toward the intake section.
- Use a straight edge to align tracks at the joint to ensure smooth slide for track shoe.

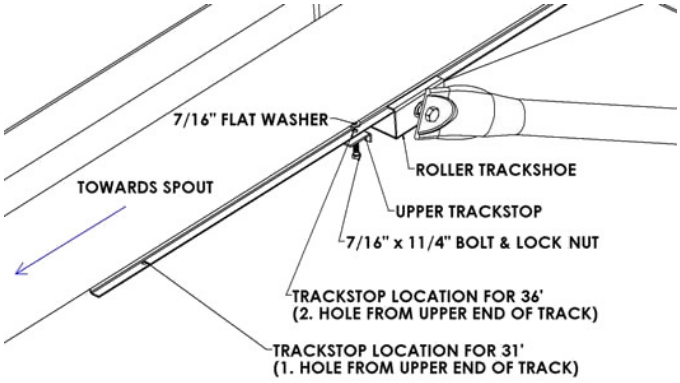
1	Bolt, 7/16" x 1" (For 31’/36’ Augers)	3	Bolt, 5/8" x 4-1/2"
	Bolt, 7/16" x 1-1/4" (For 41’ Augers)	4	Lock Nut, 5/8"
2	Lock Nut, 7/16"		

3.6. Install the Track Shoe and Track Stop

1. Slide the roller track shoe onto the track.
2. **For 31' models only:** Attach the angle track stop to the second set of holes from the bottom of the track. Secure using two 7/16" x 1-1/4" bolts and lock nuts.



3. Attach the angle track stop to the upper end of track. Secure using two 7/16" x 1-1/4" bolts, flat washers and lock nuts. Make certain the flat washers are on top of the track.



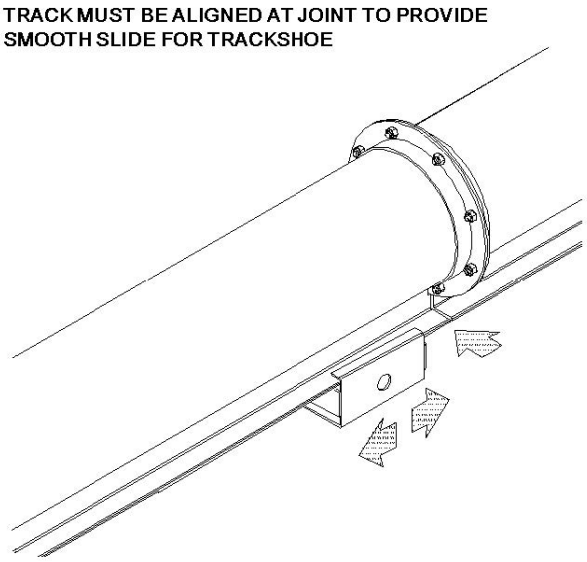
Auger	Track Stop
31'	1st set of holes from top
36'	2nd set of holes from top
41'	3rd set of holes from top

⚠ CAUTION Failure to locate track stop in the proper holes can result in damage to the auger and/or personal injury.

4. Slide the track shoe along full length of the track to make certain there is no binding and that track ends properly align.

Note

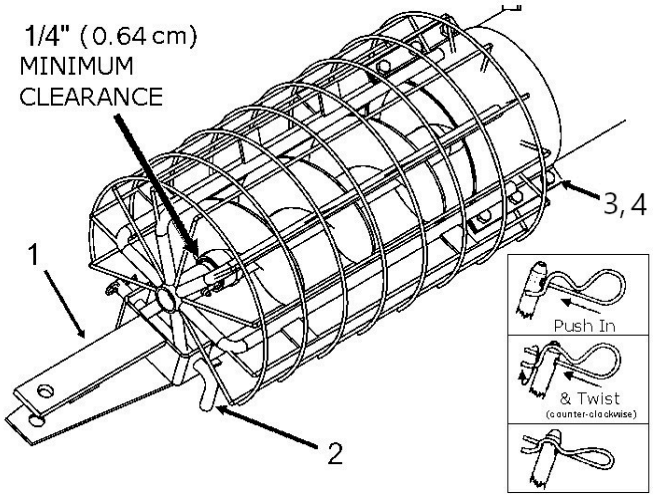
Align upper and lower tracks to allow track shoe to roll smoothly over this joint.



5. **For 31' models only:** Attach the lift cable attach bracket to the first set of holes from the bottom of the track. Secure using two 7/16" x 1-1/4" bolts, flat washers and lock nuts. Make certain the flat washers are on top of the track.

3.7. Install the Intake Hitch

1. Clean the dirt and paint from the lower flight stub and intake bushing.
2. Attach the intake hitch to the lower auger tube and tighten securely.
3. Maintain 1/2” (1.27 cm) clearance between the bushing and the end of the flight.
4. Attach the clevis to the intake hitch with clevis pin and grip clip.

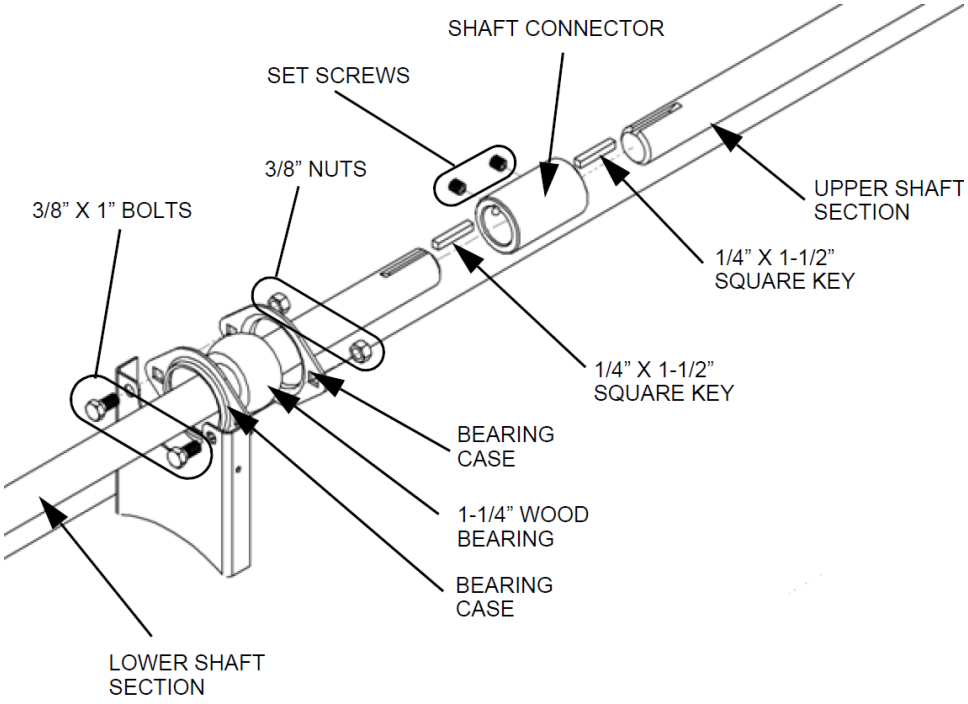


1	Clevis	3	Bolt, 7/16" x 1-1/4"
2	Clevis Pin, 3/4"	4	Lock Nut, 7/16"

3.8. Install the Two-Stage Driveshaft

Upper sections of the driveshaft are factory installed. To install the lower section follow the steps below.

1. Clean the paint and dirt from the driveshaft end and shaft connectors.
2. Slide the shaft connector halfway onto the last pre-installed driveshaft segment.
3. Slip the lower driveshaft segments through the bearings on the lower tube section. Install a Woodruff key, and slide into the shaft connector.
4. Place a few drops of oil at each driveshaft bearing to allow for break-in.
5. Tighten all set screws on the shaft connectors.



3.9. Install the PTO SD – Drive and Shield

The upper sections of the driveshaft are factory installed. To install the lower section follow the steps below.

1. Check the table below for correct sequence for your auger.

AUGER MODEL	LOWER DRIVESHAFT	
	LENGTH	DIAMETER
31'	6' 4"	1-1/4"
36'	11' 8"	1-1/4"
41'	6' 4"	1-1/4"
	9' 9"	

2. Clean the dirt and paint from the driveshaft ends, inside couplers, and PTO driveline yoke.

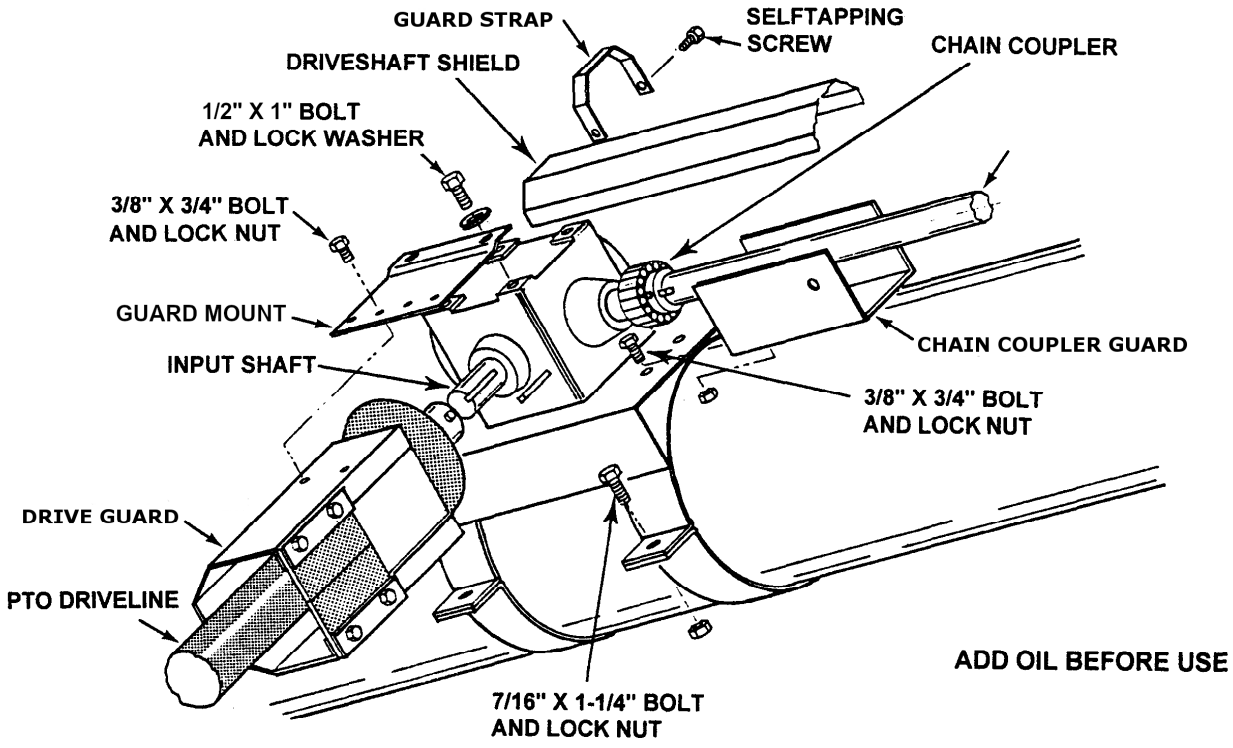
3. Remove the chain from chain coupler on gearbox, then attach the chain coupler sprocket to the driveshaft with a 1/4" x 1-1/2" square key. Tighten the set screws.
4. Place the gearbox assembly on the auger tube, then reinstall the chain-to-chain coupler leaving a minimum clearance of 1/16" (1.6 mm) between coupler sprockets.
5. Secure the gearbox assembly to the auger tube with two half bands and four 7/16" x 1-1/4" bolts and lock nuts. Tighten securely.

   Important

   Add EP90 lube oil to the gearbox before operating the auger. Failure to do so will void warranty. Do not overfill. Fill half full only. It is easier to fill oil into gear box when in flat position.
6. Attach the chain coupler guard to the gearbox base with two 3/8" x 3/4" bolts and washer lock nuts.
7. Slide the non-spline end of PTO driveline onto the input shaft on the gearbox using a 1/4" x 1-1/2" square key. Tighten the set screws securely.

   Note

   The PTO driveline is non-separable. Do not extend beyond 80".
8. Install the PTO driveline transport saddle to the auger tube about 3' above the gearbox. Secure with two 7/16" x 1-1/4" bolts and lock nuts.
9. Attach the drive shield to the shield mount with two 3/8" x 3/4" bolts and washer lock nuts. Slide this assembly over the PTO driveline and attach to the gearbox with two 1/2" x 1" bolts and lockwashers.



⚠ CAUTION Never use a PTO driveline without a shield in good working order. Do not exceed the maximum recommended operating length or 15° angularity of PTO driveline u-joints.

3.10. Install the EMD Drive

Important

When using an electric motor:

- Use a qualified electrician to install the motor and controls. Installation should be in accordance with all local and national codes.
- Incorporate a magnetic starter to protect the motor. The motor must have a manual reset button.
- Locate reset and starter controls so that the operator has full view of the entire operation.
- Locate the main power disconnect switch within reach from the ground level for accessibility in case of an emergency.
- Provide a main power disconnect switch capable of being locked (in the off position only).

The upper sections of the driveshaft are factory installed. To install the lower section follow the steps below.

1. **For 41’ models only:**
   a. Remove the driveshaft segment nearest the intake end of auger (9' 9" long). This driveshaft is not used on EMD augers.
   b. Remove and discard driveshaft bearing at third bearing bracket from intake end.
2. Clean the dirt and paint from the driveshaft ends and inside couplers.
3. Remove the chain from chain coupler on gearbox, then attach the chain coupler sprocket to the driveshaft with a 1/4" x 1-1/2" square key. Tighten the set screws.
4. Place the gearbox assembly on the auger tube, then reinstall the chain coupler leaving a minimum clearance of 1/16" (1.6 mm) between coupler sprockets .
5. Secure the gearbox assembly to the auger tube with two half bands and four 7/16" x 1-1/4" bolts and lock nuts. Tighten securely.

   Important

   Add EP90 lube oil the gearbox before operating auger. Failure to do so will void warranty. Do not overfill. Fill half full only. It is easier to fill oil into gear box when in horizontal position.
6. Attach the chain coupler guard to the gearbox base with two 3/8" x 3/4" bolts and washer lock nuts.
7. Position the electric motor mount beneath the auger as shown, about 1-1/2" to 2" (3.81 cm - 5.08 cm) from the gearbox assembly. Secure with two half bands and four 7/16" x 1-1/4" bolts and lock nuts.
8. Slide the 15" pulley onto the gearbox shaft with hub facing the gearbox. Insert a 1/4" x 1-1/2" square key, then tighten securely.

   Note

   Complete Step 9 through Step 16 at this time or after auger tube and undercarriage have been assembled.
9. Place the drive pulley onto the motor shaft, then insert the square key and tighten set screws.

   Note

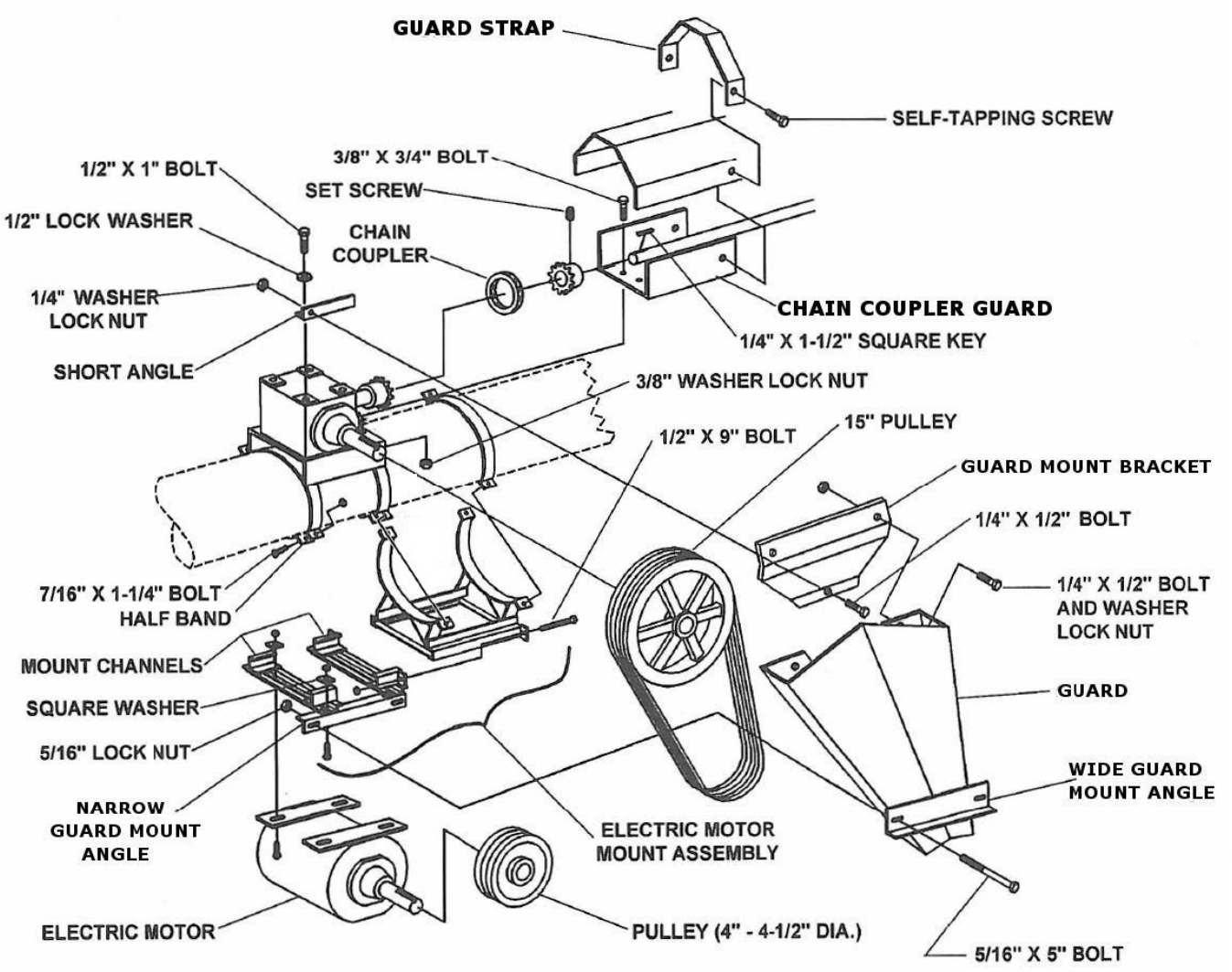
   Pulley and square key are not supplied. A 4" to 4-1/2" diameter pulley is recommended.
10. Attach the electric motor to the motor mount with four bolts and lock nuts (not provided) and four square washers (provided). The square washers go inside the mount channels.
11. Attach the "narrow" guard mount angle to the motor mount channels with two 7/16" x 1-1/4" bolts, square washers, and lock nuts. Align angle with outside edge of the mount channels.

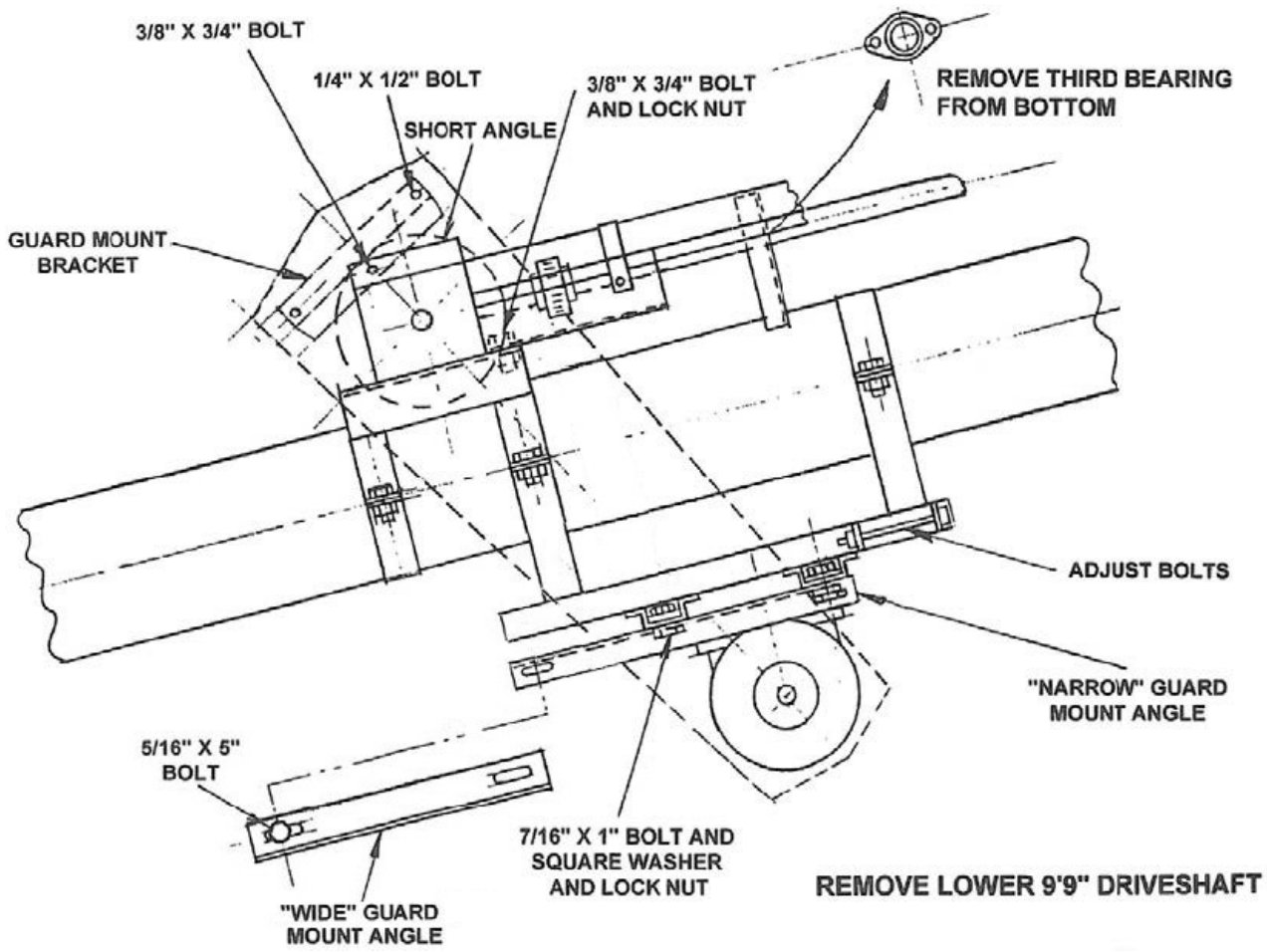
12. Place the belts on the pulleys and apply slight tension. Align the two pulleys with a straight edge, then tighten the set screws.
13. Apply final tension to the belts with the 1/2" x 9" adjusting bolts on the motor mount.

    Note

    The correct operating tension is the lowest tension at which the belts will not slip under peak load conditions.

14. Place the short angle on the top of the gearbox as shown and attach with two 1/2" x 1" bolts and lockwashers.
15. Attach the guard to the gearbox assembly by bolting the guard mount bracket to the short angle with one 3/8" x 3/4" bolt and washer lock nut.
16. Secure the other end of the guard by bolting the "wide" guard mount angle to the "narrow" guard mount angle with two 5/16" x 5" bolts and lock nuts. Adjust the width of guard at the motor pulley to suit the pulley diameter.




3/8" X 3/4" BOLT
1/4" X 1/2" BOLT
SHORT ANGLE
3/8" X 3/4" BOLT AND LOCK NUT
REMOVE THIRD BEARING FROM BOTTOM
GUARD MOUNT BRACKET
ADJUST BOLTS
"NARROW" GUARD MOUNT ANGLE
5/16" X 5" BOLT
7/16" X 1" BOLT AND SQUARE WASHER AND LOCK NUT
"WIDE" GUARD MOUNT ANGLE
REMOVE LOWER 9'9" DRIVESHAFT

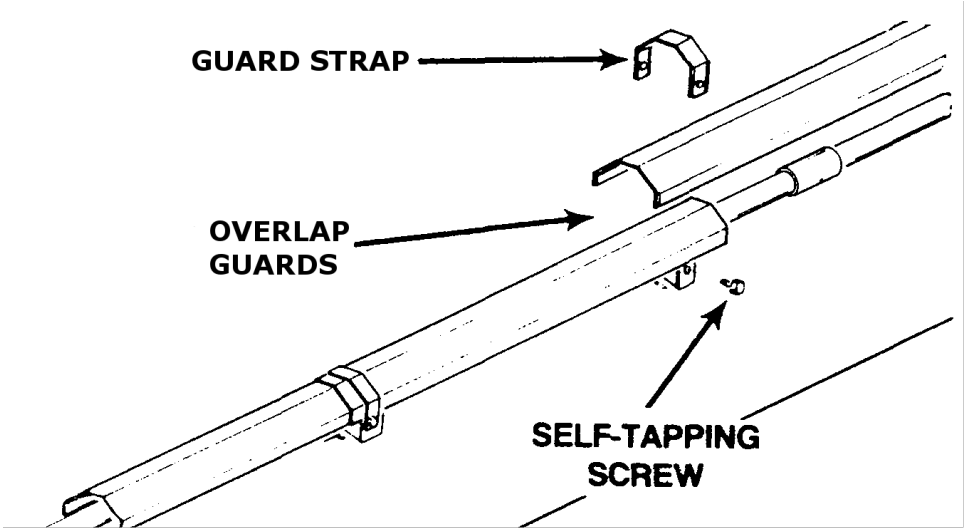
3.11. Install the Driveshaft Shield

Refer to Table 2 for the proper sequence for your particular auger. Shielding is installed working from the gearbox assembly up to the discharge end.

Table 2. Driveshaft Shielding Sequence

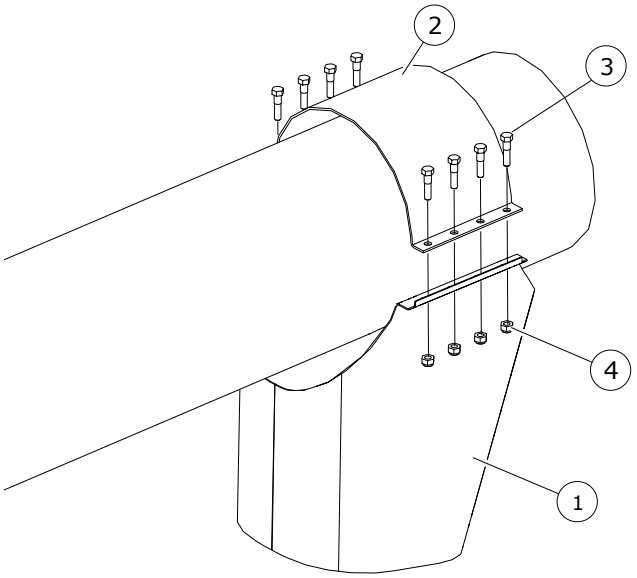
	13-31 SD		13-31 EMD	
STEP	QTY	LENGTH	QTY	LENGTH
1	1	42" (1.07 m)	1	42" (1.07 m)
2	6	48" (1.23 m)	4	48" (1.23 m)
3	-	42" (1.07 m)	1	42" (1.07 m)
	13-36 SD		**13-36 EMD**	
STEP	QTY	LENGTH	QTY	LENGTH
1	1	42" (1.07 m)	1	42" (1.07 m)
2	3	48" (1.23 m)	5	48" (1.23 m)
3	5	60" (1.52 m)	1	60" (1.52 m)
	13-41 SD		**13-41 EMD**	
STEP	QTY	LENGTH	QTY	LENGTH
1	1	60" (1.52 m)	1	60" (1.52 m)
2	3	42" (1.07 m)	5	48" (1.23 m)
3	5	48" (1.23 m)	1	42" (1.07 m)
4	1	42" (1.07 m)	-	-

1. Place driveshaft shield against gearbox and over chain coupler guard, then secure with a shield strap and 2 self-tapping screws. See Section 3.9 – Install the PTO SD – Drive and Shield on page 23.
2. Install remainder of the driveshaft shielding, work from the bottom up. Shields should overlap at bearing support brackets.



3. Fasten with shield strap and self-tapping screws. Do not tighten until all shielding is in place.

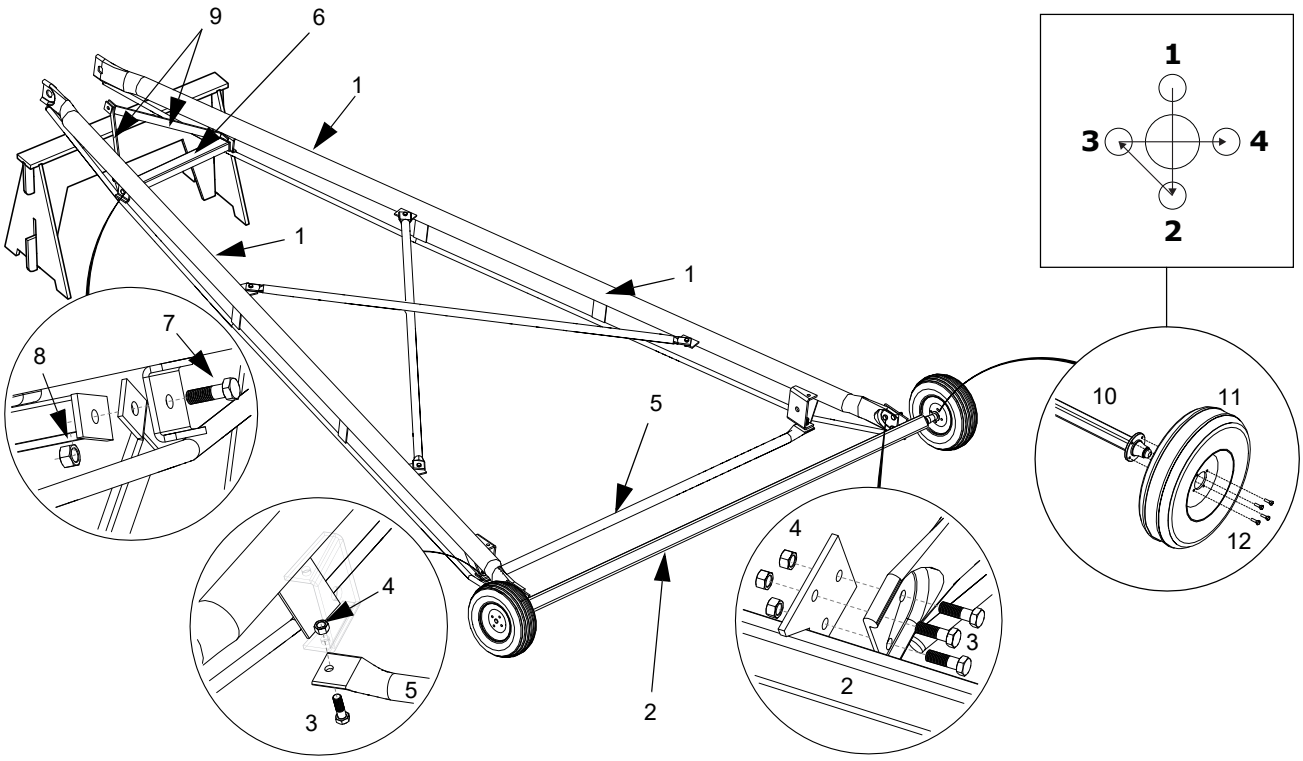
3.12. Install the Spout



Assembly Note:	
• Apply caulking to seal the seam of spout to tube.	
1	Spout
2	Wide Half Clamp
3	Bolt, 7/16" x 1–3/4"
4	Lock Nut, 7/16"

3.13. Assemble the Frame

⚠ WARNING Components are heavy and create a crushing and pinching hazard if improperly handled. Be sure to use proper hoisting equipment and procedures, and ensure lifting apparatus is secure. Lockout the lifting apparatus before working around or under the raised components. Failure to do so may cause serious personal injury.



Assembly Note:

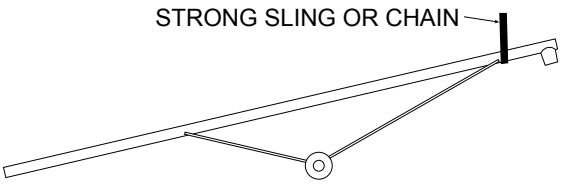
- Loosely attach short cross member between the lower reach arms, sandwiching the stabilizer braces between the short cross member and small frame brackets on each side. Leave loose until the other ends of the stabilizer braces are connected.
- Do not remove tube support until the assembly in this section has been completed.
- Check that pressure of pre-inflated tires matches pressure indicated on tire sidewall.

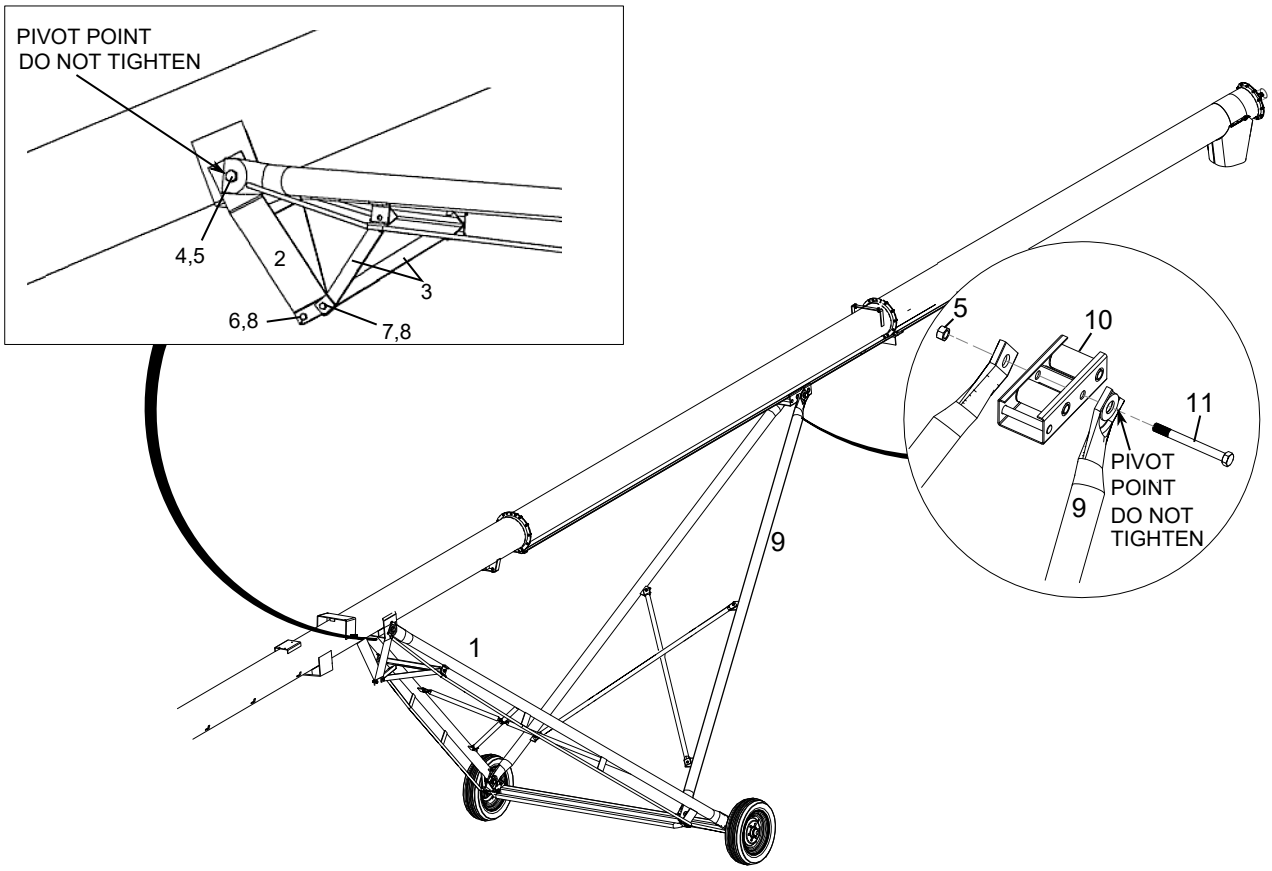
1	Lower Reach Arm	7	Bolt, 1/2" x 1-1/2"
2	Axle	8	Lock Nut, 1/2"
3	Bolt, 7/16" x 1-1/4"	9	Stabilizer Brace
4	Lock Nut, 7/16"	10	Axle Assembly
5	Long Cross Member	11	Wheel
6	Short Cross Member	12	Wheel Bolt, 1/2" x 1"

3.14. Connect the Auger Tube to the Frame

Important

Be sure to use proper hoisting equipment and procedures when raising the discharge end of the auger. Lock out the hoist apparatus prior to working around or under the raised tube.



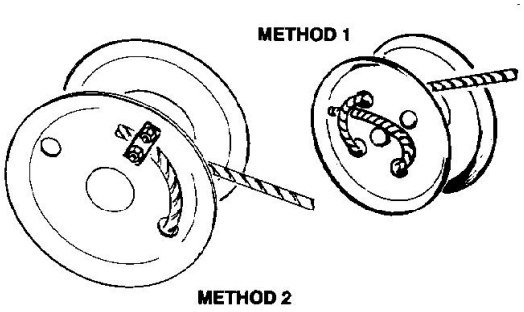


Assembly Note:

- Do not remove tube support until the assembly in this section has been completed.

1	Lower Reach Arm	7	Bolt, 7/16" x 1-3/4"
2	Stabilizer Bracket	8	Lock Nut, 7/16"
3	Stabilizer Brace	9	Upper Lift Arm
4	Bolt, 3/4" x 2"	10	Track Shoe
5	Lock Nut, 3/4"	11	Bolt, 3/4" x 6-1/2"
6	Bolt, 7/16" x 1-1/4"		

3.15. Hydraulic Winch Installation

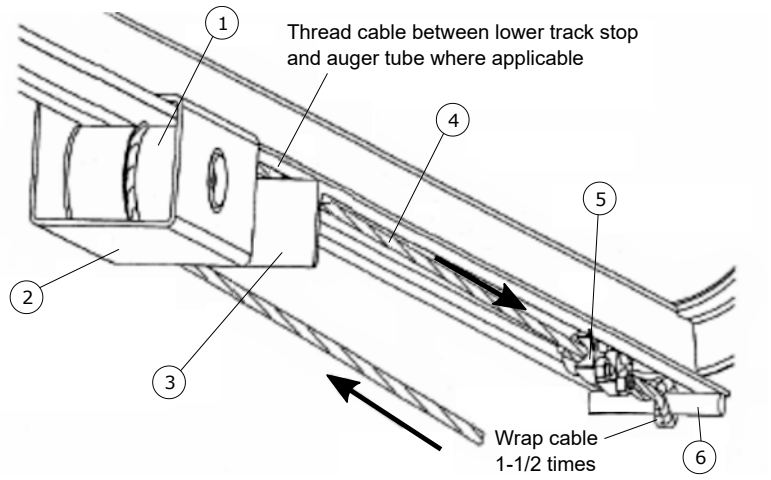


Assembly Notes:

- Attach cable to winch using one of the 2 methods shown, depending on supplied winch. Cable must enter the winch on the top side of the drum and must have a minimum of 3 wraps on the drum when the auger is in the transport position.

  Important

  If **method 2** is used, the nut must be on the outside of the drum to prevent damage to the cable. Leave about one inch (2.54 cm) of cable extending past the clamp. Cable must leave winch from bottom side.



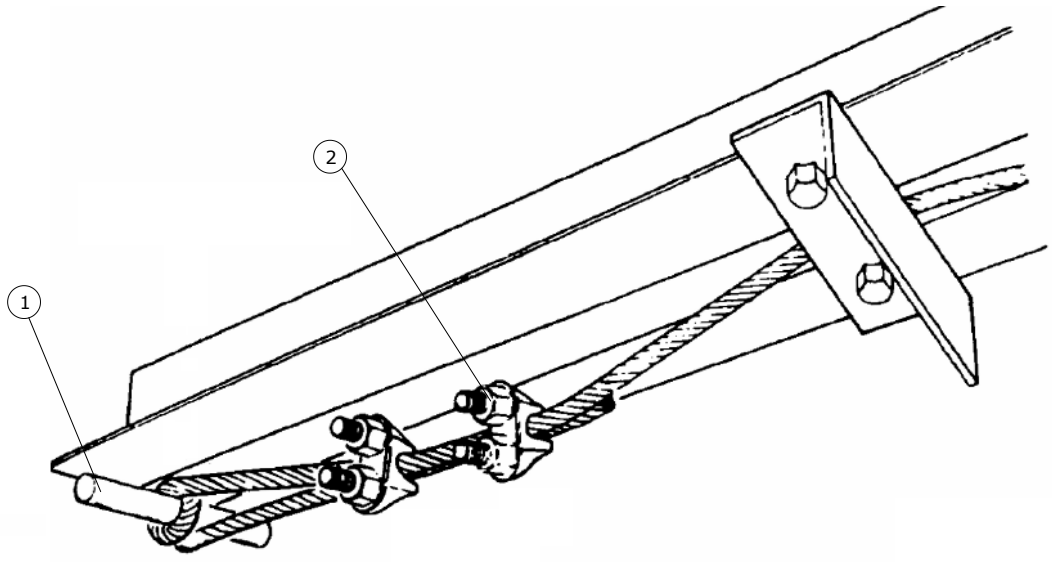
Assembly Notes:

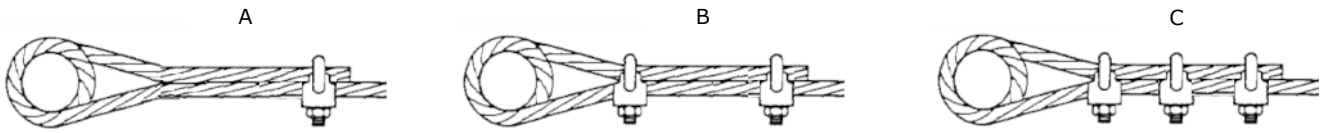
- Thread lift cable under and around roller on track shoe, then back to cable attach rod welded to lower end of track.
- Wrap the cable 1-1/2 times around the cable attach rod and double-back 7" (18 cm) of the cable.

  Important

  Winch handle must be positioned on the left side of the auger (determine left by standing at the intake end, facing the discharge end).

1	Roller	4	Lift cable
2	Track shoe	5	Cable clamp (2 pieces)
3	Lower track stop	6	Cable attach rod





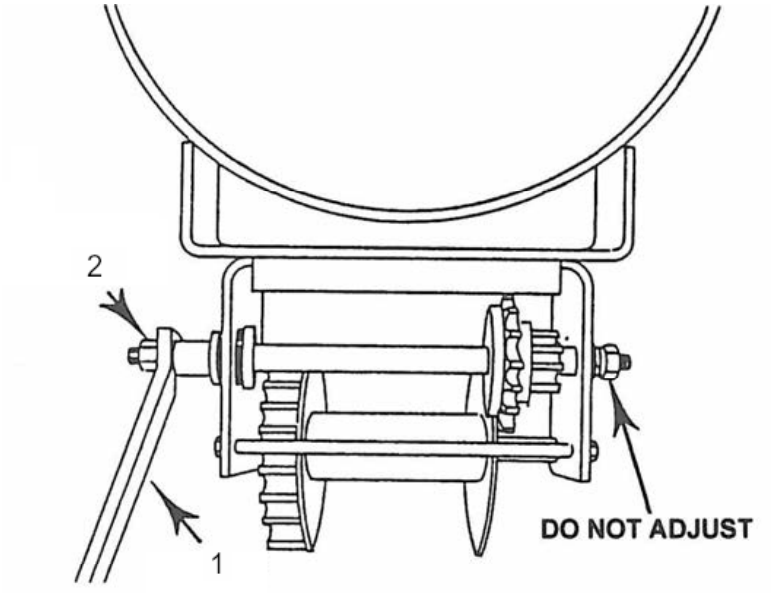
Assembly Notes:

- Secure the cable in place by installing and tightening the 1/4" cable clamps.
- Live end rests in the clip saddle.
- Apply tension and tighten all nuts evenly to the recommended torque of 15 ft·lb.

1	Cable attach rod	2	Cable clamp

3.16. Install the Winch Handle

⚠ CAUTION Winch handle assembly must follow the instructions below. Improper assembly will result in sudden winch failure causing damage to equipment and/or personal injury.



Assembly Note:

- Before installing handle on the main winch assembly, check the model number stamped on winch housing and follow the correct set of instructions.
- **MODEL K2550:** Slide handle over flat sides of input shaft. Fasten with 1/2" lock nut.

  Important

  Do not remove or loosen the lock nut on brake side of winch: it is an important part of the brake system of the winch.

1	Handle	2	Lock Nut, 1/2"

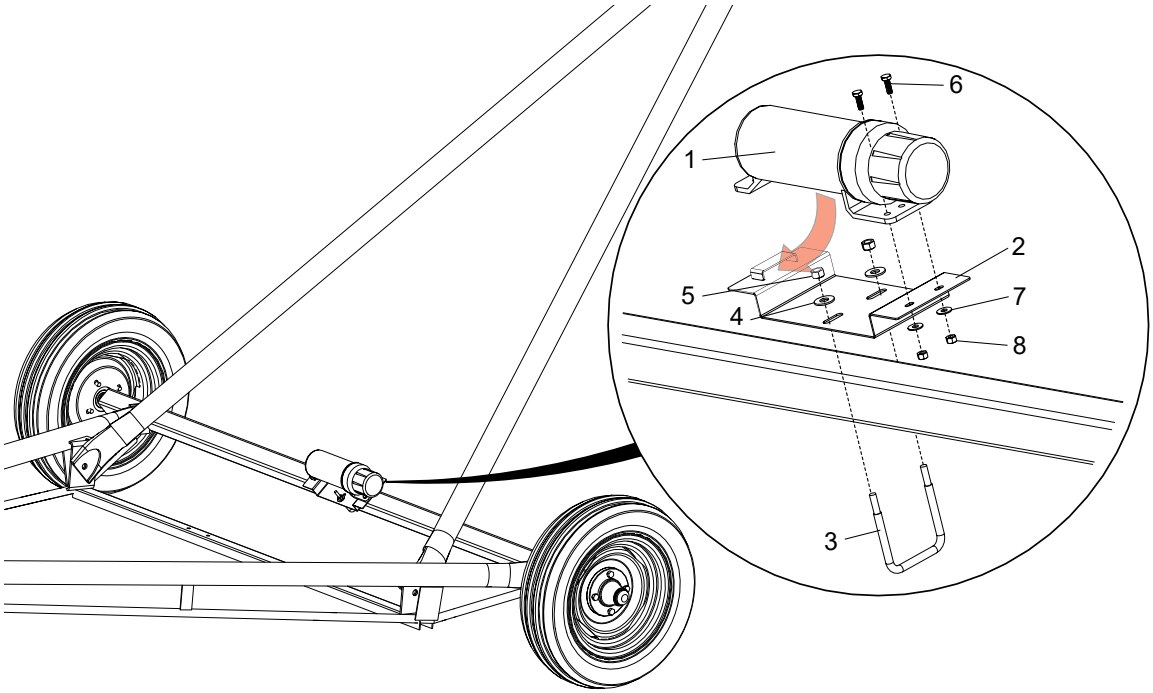
3.17. Apply the Lubricant to the Upper Housing

Fill enclosed upper drive housing with grease.

2200g	78oz

For continuous use in extreme cold conditions, semi-fluid arctic grease or heavy oil may be used.

3.18. Install the Plastic Manual Container



Assembly Note:

- Attach the manual container bracket to the top of the axle, centered between the two wheels.
- Slide the tab on the bottom of the manual into the raised slot in the manual holder bracket.

1	Plastic Manual Container	5	Lock Nut, 3/8"
2	Manual Holder Mount	6	Bolt, 1/4" x 3/4"
3	Square U-bolt, 3/8" x 3-1/16" x 4"	7	Flat Washer, 1/4"
4	Flat Washer, 3/8"	8	Lock Nut, 1/4"

4. Specifications

SPECIFICATION	31	36	41
Tube Size	13" (33.0 cm)		
CAPACITIES			
Unloading Rate	6600-7800 Bu/Hr		
TRANSPORT DIMENSIONS			
Length	32' 7" (9.93 m)	37' 7" (11.5 m)	42' 7" (13 m)
Width	10' 10"	10' 10"	9' 10"
Height	10' 1"	10' 4"	12' 6"
DISCHARGE CLEARANCE DIMENSIONS			
Min	7' 7"	7' 10"	10' 0"
Max	19' 3"	22' 1"	28' 3"
TIRES			
Type	15" Radial		
Inflation Pressure	See Manufacturer Recommended Pressure on Tire Sidewall		
WEIGHT			
Total Weight (EMD)	1787* lb	1920* lb	2210* lb
Total Weight (SD)	1796* lb	1951* lb	2160* lb
POWER RECOMMENDATIONS			
Electric Motor	20 HP	20-25 HP	25 HP
PTO Drive	40 HP	40-50 HP	50 HP
PART SPECIFICATIONS			
Lubricating Grease	SAE multi-purpose high-temperature grease with extreme pressure (EP) performance. (SAE multi-purpose lithium-based grease is also acceptable)		
Gearbox Oil	SAE approved 90W or equivalent gear oil		
Gearbox Oil Capacity	0.9 US quarts (0.85 L)		
Upper Drive Housing Grease Quantity	2200 g (78 oz)		
Belt Size (EMD)	B95		
PTO Maximum Operating Angle	15°		

* Weights are estimated.

5. Appendix

5.1. Bolt Torque

Table 3 gives the correct torque values for various hardware. Tighten all bolts to the torque specified, unless otherwise noted. Check tightness periodically, using Table 3 as a guide. Replace the hardware with the same strength bolt, contact AGI if you are unsure.

Table 3. Recommended Bolt Torque[a]

Size	Dry or Lubricated	Threads per inch (Course/ Fine)	Area of Bolt (sq in.)		Recommended Torque (ft-lb)							
					Grade 2		Grade 5		Grade 8		8.8 S/S	
			Coarse	Fine	Coarse	Fine	Coarse	Fine	Coarse	Fine	Coarse	Fine
1/4"	Dry	20/28	0.0318	0.0364	5.5	6.3	8	10	12	14	6.3	7.8
	Lubricated				6.3	4.7	6.3	7.2	9	10	-	-
5/16"	Dry	18/24	0.0524	0.058	11	12	17	19	24	27	11	11.8
	Lubricated				8	9	13	14	18	20	-	-
3/8"	Dry	16/24	0.0775	0.0878	20	23	30	35	45	50	20	22
	Lubricated				15	17	23	25	35	35	-	-
7/16"	Dry	14/20	0.1063	0.1187	32	36	50	55	70	80	31	33
	Lubricated				24	27	35	40	50	80	-	-
1/2"	Dry	13/20	0.1419	0.1599	50	55	75	85	110	120	43	45
	Lubricated				35	40	55	65	80	90	-	-
9/16"	Dry	12/18	0.182	0.203	70	80	110	120	150	170	57	63
	Lubricated				55	60	80	90	110	130	-	-
5/8"	Dry	11/18	0.226	0.256	100	110	150	170	210	240	93	104
	Lubricated				75	85	110	130	160	180	-	-
3/4"	Dry	10/16	0.334	0.373	175	200	260	300	380	420	128	124
	Lubricated				130	140	200	220	280	310	-	-
7/8"	Dry	9/14	0.462	0.508	170	180	430	470	600	670	194	193
	Lubricated				125	140	320	350	180	180	-	-
1"	Dry	8/14	0.606	0.679	250	280	640	720	910	1020	287	289
	Lubricated				190	210	480	540	680	760	-	-
1-1/8"	Dry	7/12	0.763	0.856	350	400	790	890	1290	1440	288	290
	Lubricated				270	300	590	670	970	1080	-	-
1-1/4"	Dry	7/12	0.989	1.073	500	550	1120	1240	1820	2010	289	291
	Lubricated				380	420	840	930	1360	1510	-	-
1-1/2"	Dry	6/12	1.405	1.581	870	960	1950	2200	3160	3560	-	-
	Lubricated				650	730	1460	1640	2370	2670	-	-

[a]Torque value for bolts and cap screws are identified by their head markings. Established at 75% of yield strength of bolt given the cross-sectional area.

Note

Torque figures in table are valid for non-greased or non-oiled threads and head unless otherwise specified. Therefore, do not grease or oil bolts or cap screws unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

6. AGI Limited Warranty

This warranty relates to AGI Augers (the "Product") sold by AGI, (referred to herein as the "Seller") and applies only to the first user of the Product (meaning a purchaser directly from the Seller or from an authorized dealer or distributor of the Product, referred to herein as the "Buyer").

This warranty shall only be effective if properly registered with the Seller in accordance with information provided to the Buyer at the time of sale.

1. The Seller warrants to the Buyer that the Product is free from defects in material and workmanship **under normal and reasonable use**.
2. This warranty applies only to defects in materials and workmanship and not to damage incurred in shipping or handling, through normal wear and tear, or damage due to causes beyond the control of the Seller such as lightning, fire, flood, wind, earthquake, excessive voltage, mechanical shock, water damage, or damage arising out of abuse, alteration, improper assembly, improper installation, improper maintenance or improper repair of the Product.
3. **The warranty period for the Product shall be two years from delivery of the Product to the Buyer where the Product is used in a normal farm operation. First year of warranty coverage of parts and labour, second year warranty coverage of parts only. Warranty period for the Product shall be 90 days from delivery of the Product to the Buyer where the Product is used in a commercial operation.**In the event that any part incorporated into the Product is manufactured and sold to the Seller by a third party vendor, such part is only warranted to the extent of the warranty given by that third party.
4. The obligations set forth in this warranty are conditional upon the Buyer promptly notifying the Seller of any defect and completing reasonably required documentation and, if required, promptly making the Product available for correction. The Seller shall be given reasonable opportunity to investigate all claims and no Product shall be returned to the Seller or part disposed of until after inspection and approval by the Seller and receipt by the Buyer of written shipping instructions, with transportation charges prepaid.
5. Upon return of the Product, or such part of the Product that requires correction, the Seller shall, at the Seller's option, either repair or replace the Product or such part. The Seller shall replace or attempt to repair and return the Product or such part within a reasonable period of time from receipt of an approved warranty claim from the Buyer. If the Seller is unable to repair or replace the Product, the Buyer shall be entitled to a credit note in the amount of the purchase price for the Product.
6. The total liability of the Seller on any claim, whether in contract, tort or otherwise, arising out of, connected with, or resulting from the manufacture, sale, delivery, repair, replacement or use of the Product or any part thereof **shall not exceed the price paid for the Product** and the Seller shall not be liable for any special indirect, incidental or consequential damages caused by reason of the installation, modification, use, repair, maintenance or mechanical failure of the Product. **Consequential or special damages as used herein include, but are not limited to, lost or damaged products or goods, costs of transportation, lost sales, lost orders, lost income, increased overhead, labor and incidental costs and operational inefficiencies.**
7. **Notwithstanding anything contained herein to the contrary, the foregoing is the Buyer's sole and exclusive remedy for breach of warranty by the Seller in respect of the Product. The Seller, for itself, its agents, contractors, employees and for any parent or subsidiary of the Seller, expressly disclaims all warranties, either express or implied, written or oral, including implied warranties of merchantability or fitness for a particular purpose and undertakes no obligation with respect to the conformity of the Product except as set out in the purchase agreement, if any, or marketing materials.**
8. The foregoing warranty is the entire warranty of the Seller to the Buyer and the Buyer shall not be entitled to rely upon any representation or warranty contained in any marketing material of the Seller in respect of the Product. The Seller neither assumes, nor authorizes any other person purporting to act on its behalf to modify or to change this warranty, nor to assume for it any other warranty or liability concerning the Product.

WARRANTY VOID IF NOT REGISTERED

AGI is a leading provider of equipment solutions for agriculture bulk commodities including seed, fertilizer, grain, and feed systems with a growing platform in providing equipment and solutions for food processing facilities. AGI has manufacturing facilities in Canada, the United States, the United Kingdom, Brazil, South Africa, India and Italy and distributes its products globally.

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If you have any comments or questions on this manual, or find an error, email us at comments@aggrowth.com.
Please include the part number listed on the cover page in your message.