STANDARD BIN WELL CONTROL PIPE KIT

The center well should be located so that the sweep mounting tube is in the exact center of the bin. Intermediate well(s) should be equally spaced between the center of the bin and the bin wall. Wells must be positioned so that the gates will open when the control pipes are pulled out and away from the center of the bin. 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. For the center well, use the longer pipe, which is 1" auger pipe (.995" O.D.). For the intermediate well, use the shorter pipe, which is $1\frac{3}{8}$" auger pipe ($1\frac{3}{8}$" O.D.). The control pipe for the center well will slide inside the control pipe for the intermediate well(s). (See Figure 1)

ASSEMBLY INSTRUCTIONS

1. Install the wells to the unloading tubes.

2. Attach the intermediate bin well gate(s) to the $1\frac{3}{8}$" O.D. control pipe. (See also Assembly Manual provided with the well).

A. Shut the intermediate bin well gate(s).

B. Check the length of the control pipe by sliding it into place. Be sure there is at least 6" of control pipe extending past the back end of the last intermediate well, so that when the gate is opened, the end of the control pipe will not be drawn into the well. (See Figure 2).

C. Drill a $\frac{3}{8}$" diameter hole through one side of the $1\frac{3}{8}$" O.D. control pipe for each gate clamp. The dimple of the control gate clamps will fit into these holes when clamped to the intermediate gates. Determine the hole location by observing where the dimple will hit the control pipe when it is bolted in place.

D. Fasten the control gate clamps to the intermediate control gates and the control pipe. Secure in place using (2) two $\frac{5}{16}$" x 1" (Grade 5) hex head capscrews, lockwashers and nuts per each gate. To keep control gates from deforming, two or four $\frac{5}{16}$" flat washers may be needed for spacing between the clamp and gate.

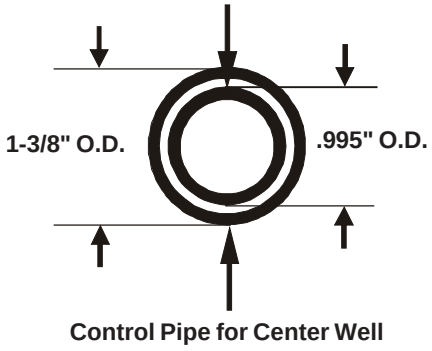

FIGURE 1- (Control Pipes)

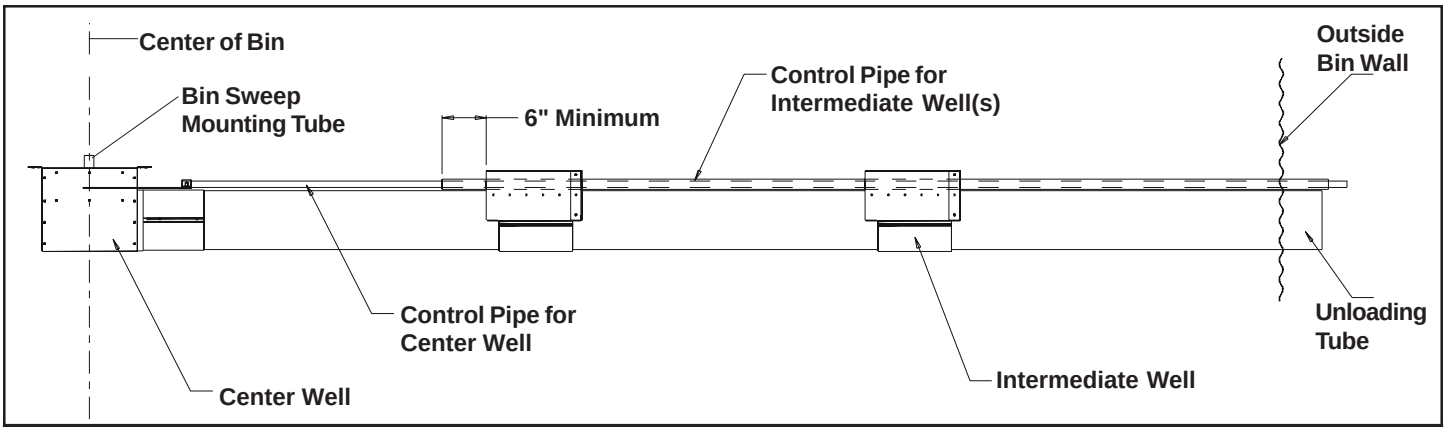

FIGURE 2 - (Full Assembly)

3. Attach the center well gate to the 1" O.D. control pipe. (See also Assembly Manual provided with well.)

A. Shut the center well and intermediate gates completly, before drilling holes.

B. Check the length of the center well control pipe by sliding it through the control pipe of the intermediate well(s). Attach the center well gate clamp to the control pipe by sliding a $^{5}/_{16}$" x 1-$^{3}/_{4}$" roll pin through the clamp and the control pipe. Fasten the clamp to the top side of the center well gate by using (2) two $^{5}/_{16}$" x $^{3}/_{4}$" (Grade 5) carraige bolts, flatwashers, lockwashers, and nuts. Install the nuts so that they secure the $^{5}/_{16}$" x 1-$^{3}/_{4}$" Roll Pin in place.

c. When the control pipe is fastended to the center well gate, the center well control pipe should extend past the end of the intermediate well control pipe a minimum of 2-$^{1}/_{2}$". (See Figure 3). It may be necessary to shorten the center control pipe and re-drill the holes, depending on the exact bin size and the type of center well used.

D. With gates still closed, measure back $^{5}/_{8}$" off the end of the intermediate well control pipe and drill a $^{3}/_{8}$" hole. The hole should be drilled through both sides of the intermediate pipe and the center well pipe. (See Figure 4)

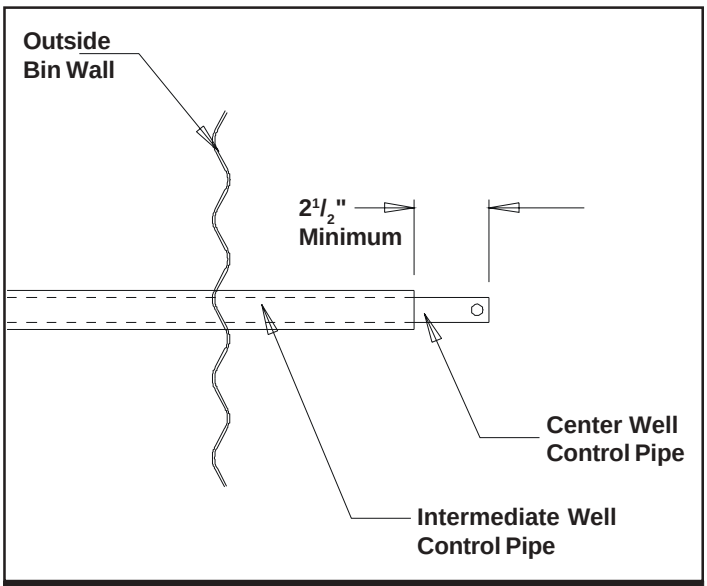

FIGURE 3 - (Center Pipe Length)

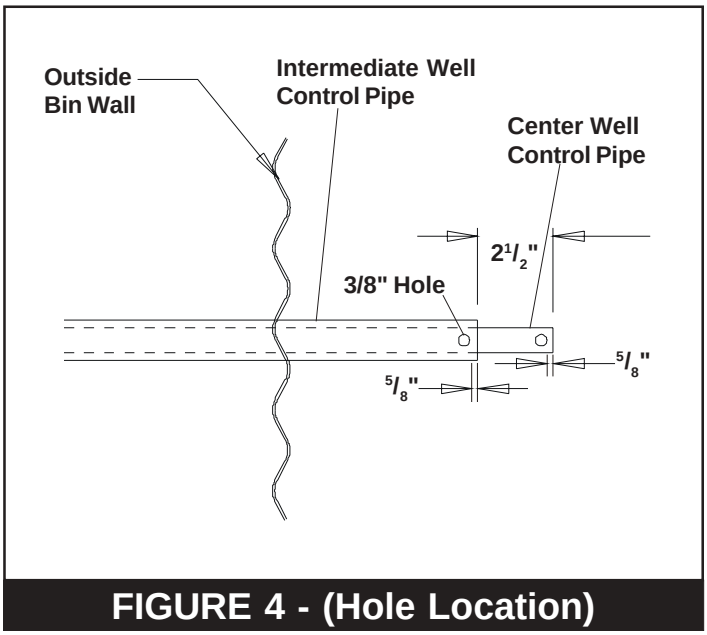

FIGURE 4 - (Hole Location)

4. Assemble the handle to the center control pipe on the outside of the bin.

A. Attach the clamp to the control pipe by sliding a $^{5}/_{16}$" x $^{3}/_{4}$" roll pin through the clamp and the control pipe.

B. Fasten the clamp to the handle by using two (2) $^{5}/_{16}$" x $^{3}/_{4}$" (Grade 5) carriage bolts, flatwashers, lockwashers, and nuts. Install the nuts so that they secure the $^{5}/_{16}$" x $1^{3}/_{4}$" roll pin in place. (See Figure 5)

5. Fasten intermediate control pipe to center well control pipe to open all wells at once.

A. Make sure all gates are closed by pushing both rods in toward the center wells.

B. Align the holes in the center well rod with the holes in the intermediate well rod. Place a $^{5}/_{16}$" x 2" bolt through aligned holes and secure it with a $^{5}/_{16}$" hex nut.

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

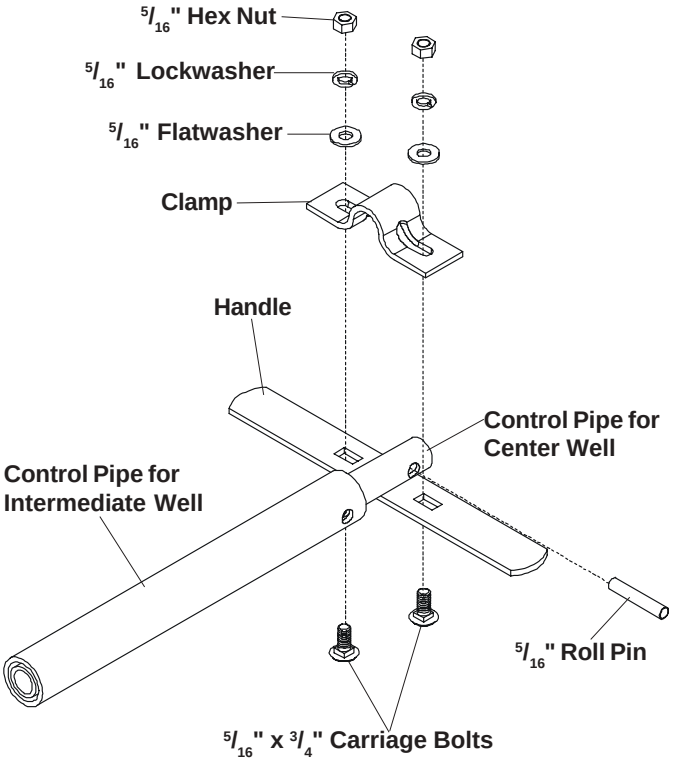

FIGURE 5 - (To Open Center Well)

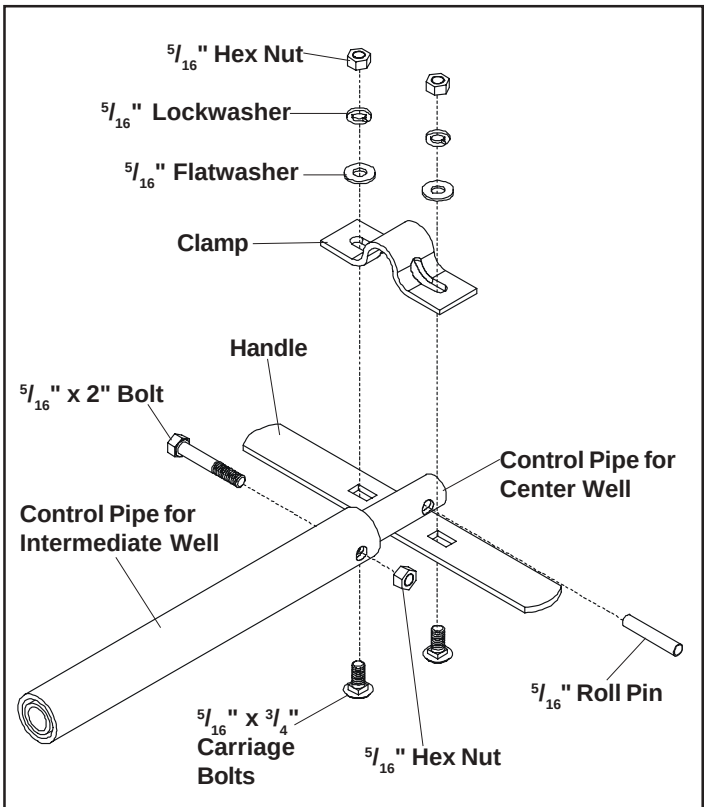

FIGURE 6 - (To Open All Wells)

OPERATION

A. Configure the control pipe ends as shown in Figure 7 when all bin well gates are closed.

B. To open the center well, pull the handle out away from the bin (See Figure 7).

NOTE The intermediate well(s) should not be opened until the bin has emptied to the point that the grain will no longer flow into the center well.

C. To open the intermediate well(s), lock control pipes together by putting a $^{5}/_{16}$" x 2" bolt through both pipes, and secure it with a $^{5}/_{16}$" hex nut. (See Figure 8)

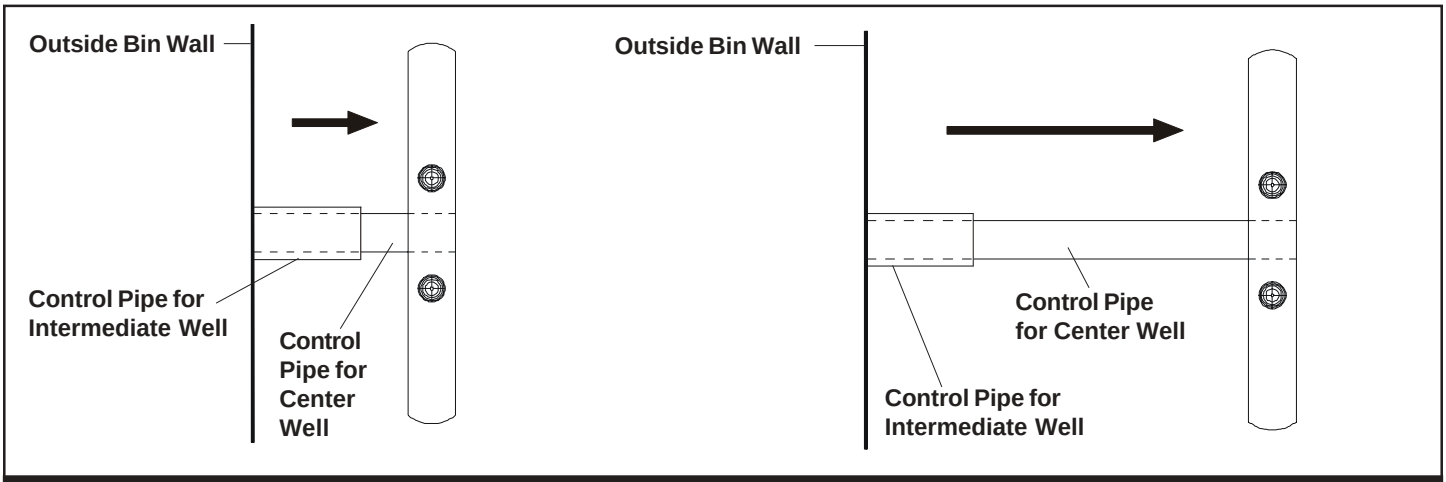

FIGURE 7 - (Open Center Well)

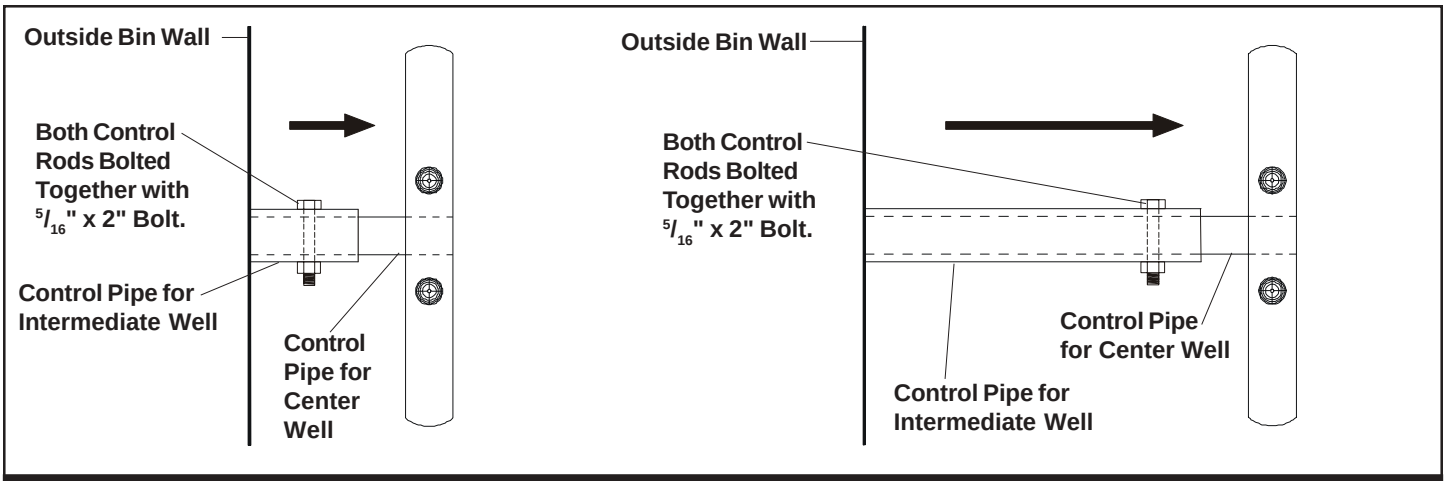

FIGURE 8 - (Open Center and Intermediate Wells)