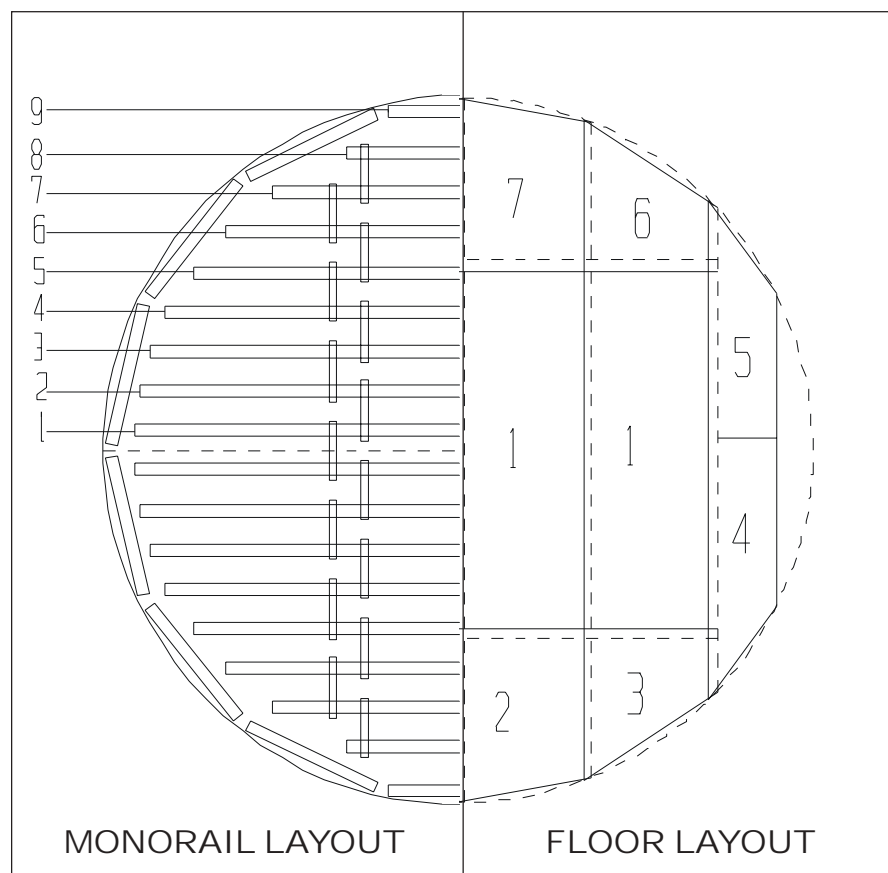


GSI Corrugated Floor and Monorail Layouts

Owner's Manual



a division of
THE GSI GROUP



PNEG-225

Manual # PNEG-225
Revised: 11/05/2002

SAFETY GUIDELINES

This manual contains information that is important for you, the owner/operator, to know and understand. This information relates to protecting **personal safety** and **preventing equipment problems**. It is the responsibility of the owner/operator to inform anyone operating or working in the area of this equipment of these safety guidelines. To help you recognize this information, we use the symbols that are defined below.

Please read the manual and pay attention to these sections. Failure to read this manual and it's safety instructions is a misuse of the equipment and may lead to serious injury or death.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



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



WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION

CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTE

NOTE indicates information about the equipment that you should pay special attention to.

General Safety Statement

The GSI Group, Inc.'s, principal concern is your safety and the safety of others associated with grain handling equipment. This manual is to help you understand safe operating procedures and some problems which may be encountered by the operator and other personnel.

As owner and/or operator, it is your responsibility to know what requirements, hazards and precautions exist and inform all personnel associated with the equipment or in the area. Safety precautions may be required from the personnel. Avoid any alterations to the equipment. Such alterations may produce a very dangerous situation, where serious injury or death may occur.

You should consider the location of the bin site relative to power line locations or electrical transmission equipment. We recommend you contact your local power company to review your installation plan or for information concerning required equipment clearance. Clearance of portable equipment that may be taken to the bin site should be reviewed and considered as well. Any electrical control equipment in contact with the bin should be properly grounded and installed in accordance with National Electric Code provisions and other local or national codes.

This product is intended for the use of grain storage only. Any other use is a misuse of the product!



This product has sharp edges! These sharp edges may cause serious injury. To avoid injury, handle sharp edges with caution and use proper protective clothing and equipment at all times.

Sidewall bundles or sheets must be stored in a safe manner. The safest method of storing sidewall bundles is laying horizontally with the arch of the sheet upward or over like a dome. Sidewall sheets stored on edge must be secured in a way that they cannot fall over and cause injury. Care should be taken in the handling and movement of sidewall bundles.

Personnel operating or working around equipment should read this manual. This manual must be delivered with equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

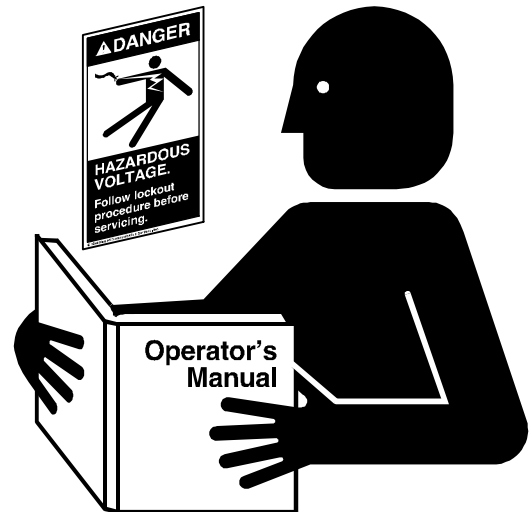
FOLLOW SAFETY INSTRUCTIONS

Carefully read all safety messages in this manual and on your machine safety signs. Keep signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from the manufacturer.

Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.

Keep your machinery in proper working condition. Unauthorized modifications to the machine may impair the function and/or safety and affect machine life.

If you do not understand any part of this manual and need assistance, contact your dealer.



PRACTICE SAFE MAINTENANCE

Understand service procedures before doing work. Keep area clean and dry.

Never lubricate, service, or adjust machine while it is in operation. Keep hands, feet, and clothing from all rotating parts.

Keep all parts in good condition and properly installed. Fix damage immediately. Replace worn or broken parts. Remove any build up of grease, oil, or debris.

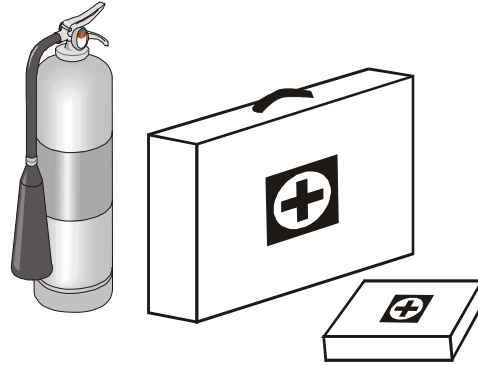


PREPARE FOR EMERGENCIES

Be prepared if fire starts.

Keep a first aid kit and fire extinguisher handy.

Keep emergency numbers for doctors, ambulance service, hospital, and fire department near your telephone.



WEAR PROTECTIVE CLOTHING

Wear close fitting clothing and safety equipment appropriate to the job.

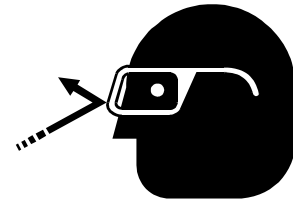
Safety glasses should be worn at all times to protect eyes from debris.

Wear gloves to protect your hands from sharp edges on plastic or steel parts.

A respirator may be needed to help prevent breathing potentially toxic fumes and dust.

Wear hard hat and steel toe boots to help protect your head and toes from falling debris.

Eye Protection



Gloves



Steel Toe Boots



Respirator

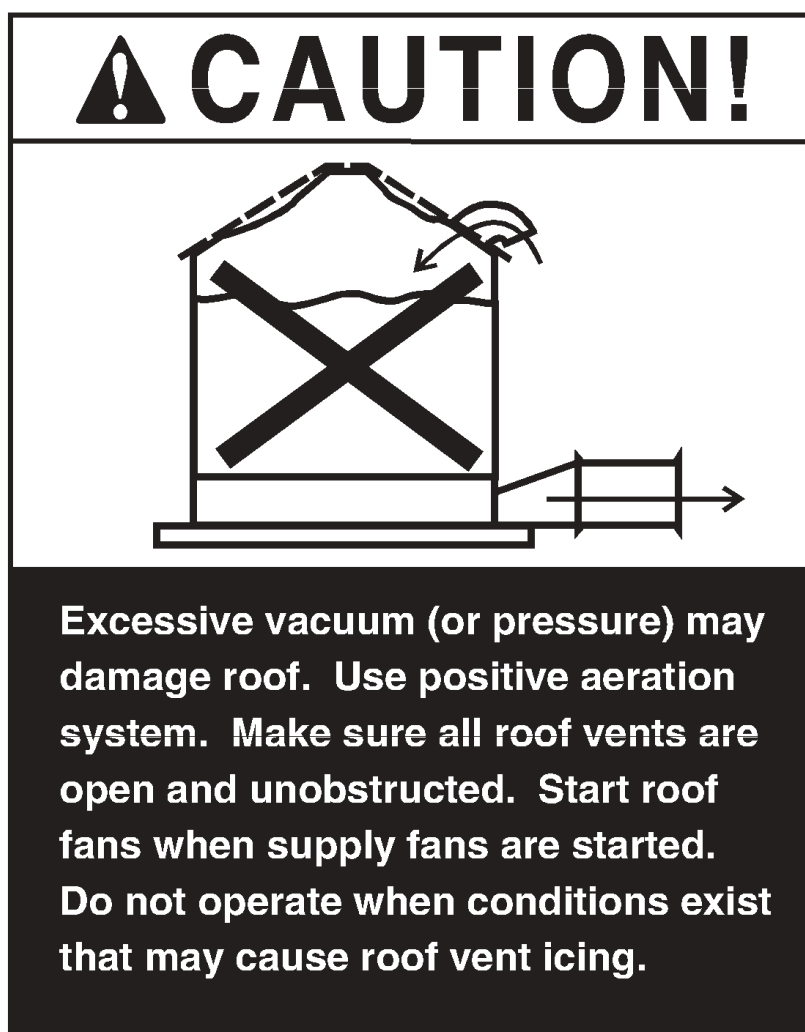


Hard Hat



CAUTION!

GSi DOES NOT WARRANT ANY ROOF DAMAGE CAUSED BY EXCESSIVE VACUUM OR INTERNAL PRESSURE FROM FANS OR OTHER AIR MOVING SYSTEMS. ADEQUATE VENTILATION AND/OR "MAKEUP AIR" DEVICES SHOULD BE PROVIDED FOR ALL POWERED AIR HANDLING SYSTEMS. GSi DOES NOT RECOMMEND THE USE OF DOWNWARD FLOW SYSTEMS (SUCTION). SEVERE ROOF DAMAGE CAN RESULT FROM ANY BLOCKAGE OF AIR PASSAGES. RUNNING FANS DURING HIGH HUMIDITY/COLD WEATHER CONDITIONS CAN CAUSE AIR EXHAUST OR INTAKE PORTS TO FREEZE.



ATTENTION: The decal shown below should be present on the outside of the outside of the door cover of the two ring, 24" porthole door cover and roof manway cover. If a decal has been damaged or is missing in any of these locations contact The GSI Group for a free replacement decal.

THE GSI GROUP
1004 EAST ILLINOIS STREET
ASSUMPTION, IL. 62510-00020
(217)-226-4421



DANGER



Rotating flighting will kill or dismember.



Flowing material will trap and suffocate.



Crusted material will collapse and suffocate.

Keep clear of all augers. DO NOT ENTER this bin!

If you must enter the bin:

1. Shut off and lock out all power.
2. Use a safety harness and safety line.
3. Station another person outside the bin.
4. Avoid the center of the bin.
5. Wear proper breathing equipment or respirator.

Failure to heed these warnings will result in serious injury or death.

DC-GBC-1A

ATTENTION: The decal shown below should be present on the outside of the outside of the door cover of the two ring, 24" porthole door cover and roof manway cover. If a decal has been damaged or is missing in any of these locations contact The GSI Group for a free replacement decal.

THE GSI GROUP
1004 EAST ILLINOIS STREET
ASSUMPTION, IL. 62510-00020
(217)-226-4421



WARNING



DON'T



DO

UNLOADING INSTRUCTIONS:

1. Use **CENTER FLOOR OUTLET ONLY** until **NO** grain remains above this outlet.
2. Side floor outlets to be used **ONLY** when above condition is satisfied.
3. Lock all side floor outlets to avoid accidental premature use.
4. See manufacturers instructions for proper use of factory supplied sidedraw (wall) discharge systems.

Failure to heed these warnings could result in serious injury, death, structural damage or collapse of tank.

DC-GBC-2A

Safety Sign-Off Sheet

It is necessary for the employer to train the employee in the safe operating and safety procedures for this equipment. We included this sign-off sheet for your convenience and personal record keeping. All unqualified persons are to stay out of the work area at all times. A person who has not read this manual and does not understands all operating and safety instructions is not qualified to operate this equipment.

DATE	EMPLOYER'S SIGNATURE	EMPLOYEE'S SIGNATURE
	1	
	2	
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	4	
	5	
	6	
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	9	
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Warranty	

All information, illustrations, photos, and specifications in this manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

Introduction

READ THIS MANUAL carefully to learn how to properly use and install equipment. Failure to do so could result in personal injury or equipment damage.

INSPECT the shipment immediately upon arrival. The Customer is responsible for ensuring that all quantities are correct. Report any damage or shortages by recording a detailed description on the Bill of Lading to justify the Customer's claim from the Transport Firm. Our responsibility for damage to the equipment ends with acceptance by the delivering carrier. Save all paperwork and documentation furnished with any of the equipment/components.

THIS MANUAL SHOULD BE CONSIDERED a permanent part of your equipment and should be easily accessible when needed.

WARRANTY is provided as part of the company's support program for customers who use and maintain their equipment as described in the manual. The warranty is explained on the warranty page located on the inside back cover of this manual.

This warranty provides you the assurance that the company will back its products where defects appear within the warranty period. In some circumstances, the company also provides field improvements, often without charge to the customer, even if the product is out of warranty. Should the equipment be abused, or modified to change its performance beyond the factory specifications, the warranty will become void and field improvements may be denied.

Properly Store Grain Bin/Silo Materials Prior to Construction to Prevent Wet Storage Stain:

Wet storage stain (rust) will develop when closely packed bundles of galvanized material such as sidewall and roof sheets have moisture present from any source. Roof and sidewall bundles should be inspected on arrival for the presence of moisture. If moisture is present, moisture must not be permitted to remain between the sheets. In the case of moisture presence, sheets or panels should be separated immediately, wiped down, dried and sprayed with a light oil or diesel fuel.

Where possible, sidewall bundles, roof sheets and other closely packed materials should be stored in a dry climate controlled building. Storage inside a dry building should be done if at all possible. Where outdoor storage is unavoidable, the materials should be raised out of contact from the ground or vegetation. Stacking and spacing materials should not be corrosive or wet. Materials must be protected from the weather. Weather protection that permits more air movement around the bundles are best.

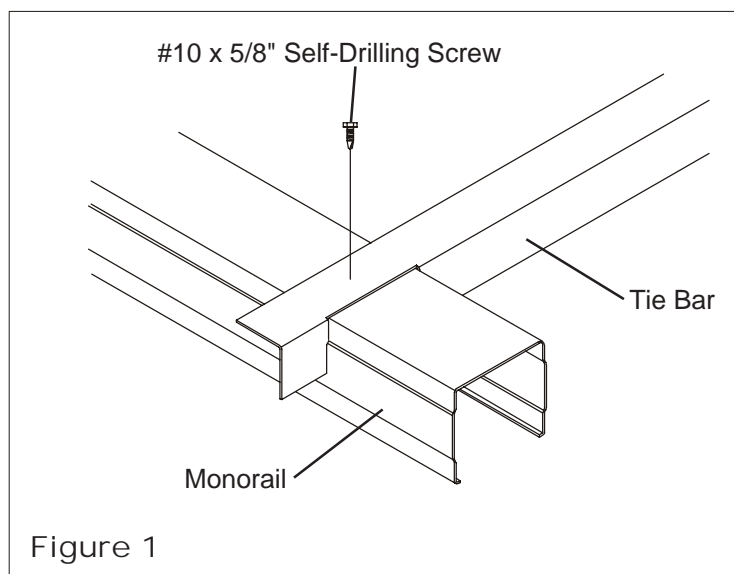
The storage method of the roof bundles and sidewall sheets may also help minimize moisture presence. Roof bundles should be stored inclined. The bundles should be stored and secured in a stable safe manner. Turning the bundles over and storing with the center of the dome “up” like a arch is a option. Sidewall bundles may be stored on edge, **however these bundles should be secured in such as way as they cannot fall over and cause injury.**

Should “white rust” or “wet storage stain” occur, contact GSI immediately concerning methods to minimize the adverse effect upon the galvanized coating.

Monorail Installation

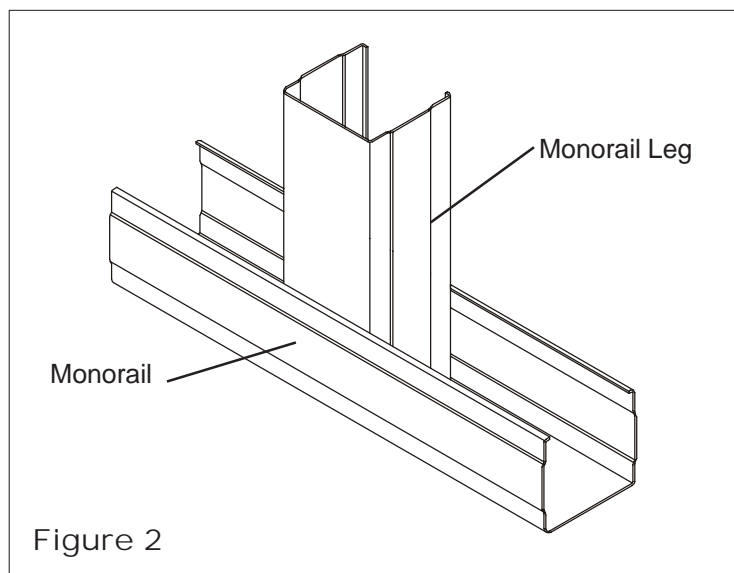
Tie Bar Detail

1. Locate the tie bars between the rails (Spaced evenly throughout the system.)
2. A single #10 self-drilling screw may be used to fasten the tie bars at each end to the rails as necessary. (See Figure 1.)



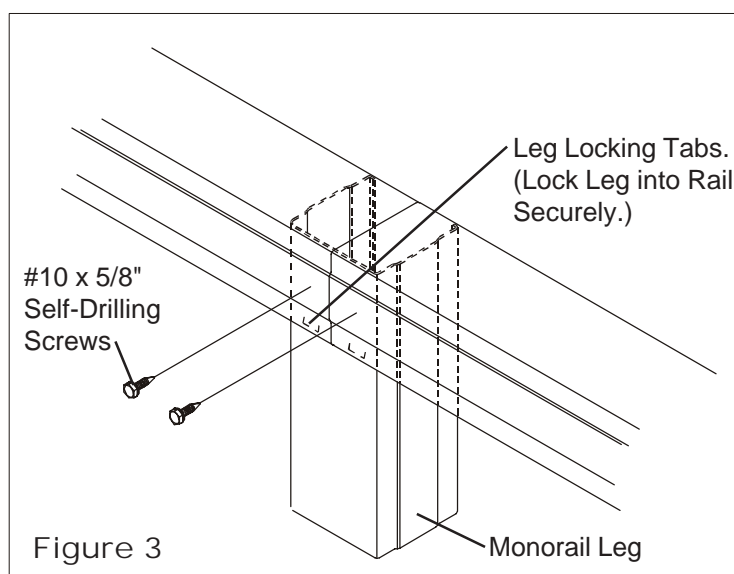
Assembling Legs to Rail

1. Place two corners of the monorail leg into the rails as shown.
2. By twisting the leg it will spread the rail enough to get the other corners inside.
3. The leg can then be pushed down into the rail until the tabs lock it into place. (See Figure 2.)



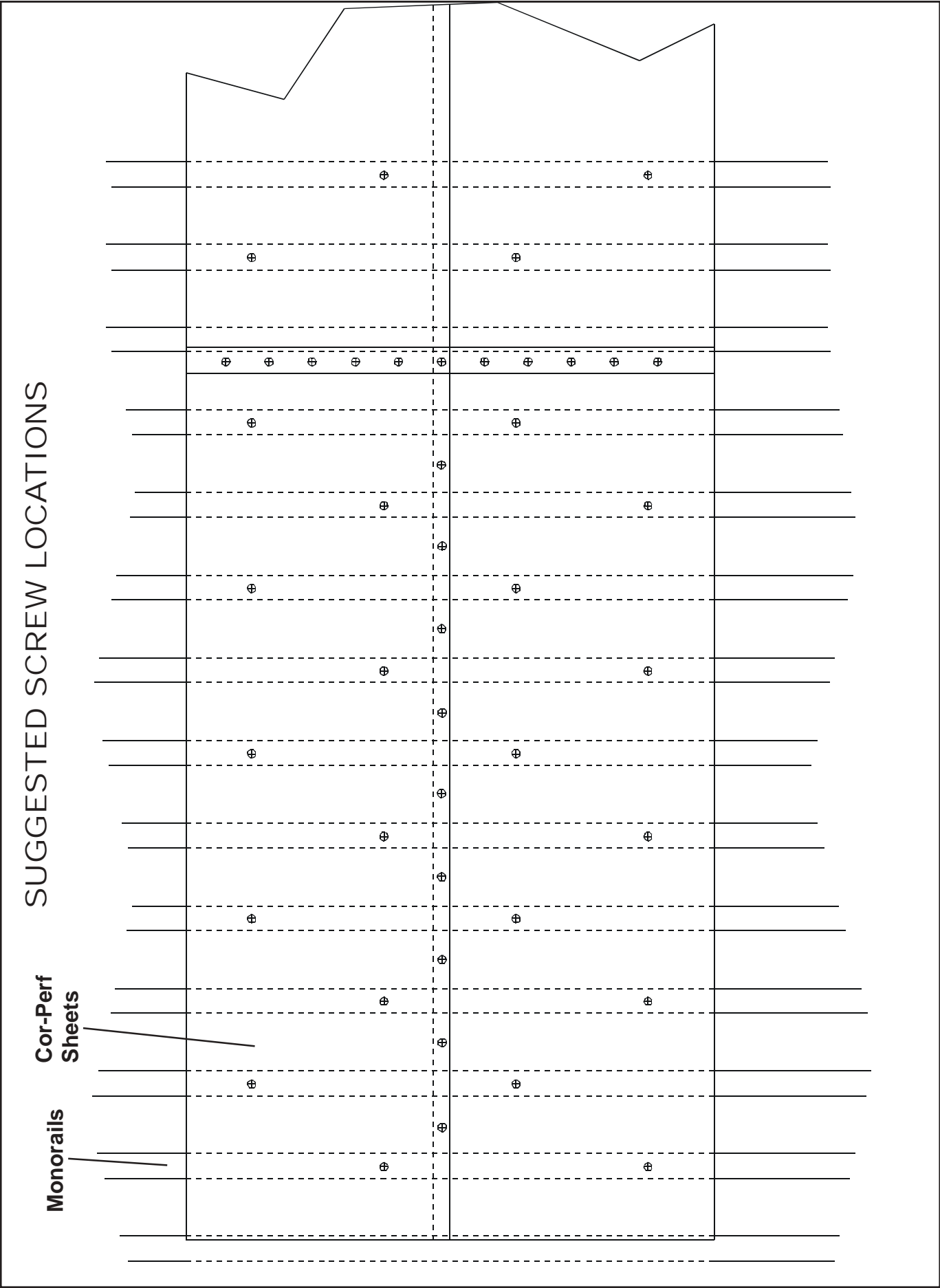
Splicing Rails

1. **A leg must be centered at each splice!**
2. The closest leg may be moved a few inches over to center it under the splice. If more than 3" of movement is required to center the leg under the splice, add an additional leg.
3. Fasten the rail to the leg with two #10 self-drilling screws (*splice locations only*). (See Figure 3.)

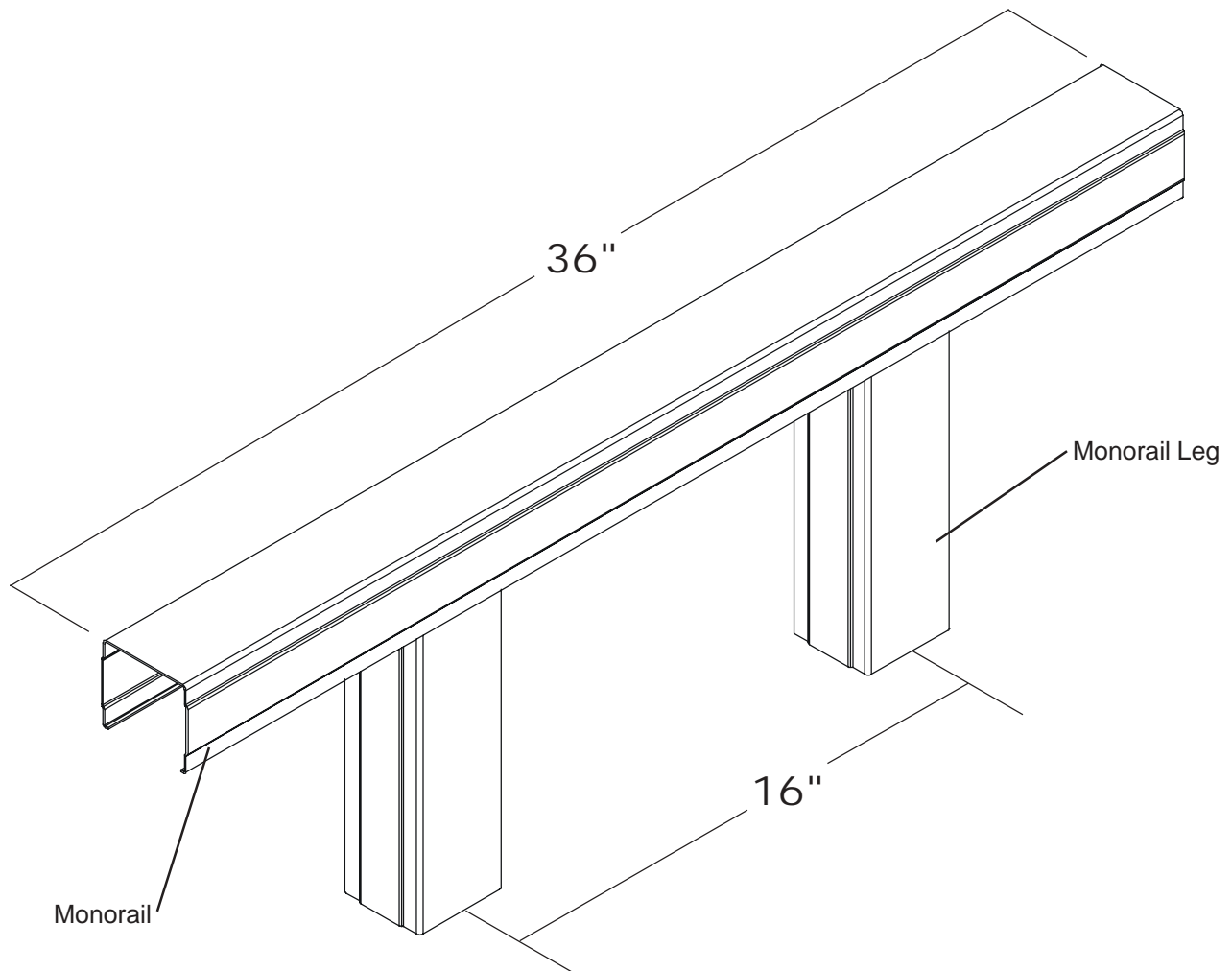


Leg Spacing Chart							
Eave Height Rings of 2.66		40'	60'	70'	80'	90'	100'
TANK DIAMETER		15R	22R	26R	30R	34R	
Spacing No of legs							
12'		26" 82	22" 91	20" 97	18" 104	17" 108	16" 113
15'		26" 113	21" 129	20" 133	18" 143	17" 149	16" 156
18'		26" 178	21" 207	20" 214	18" 232	17" 242	16" 254
20'		26" 208	21" 250	20" 260	18" 282	17" 295	16" 310
21'		26" 288	21" 341	20" 355	18" 387	17" 406	16" 427
24'		26" 310	21" 364	20" 378	18" 409	17" 428	16" 450
25'		26" 355	21" 415	20" 431	18" 467	17" 488	16" 512
27'		26" 387	21" 454	20" 473	18" 514	17" 538	16" 565
30'		25" 562	21" 632	20" 654	18" 706	17" 736	16" 770
33'		25" 690	21" 776	20" 803	18" 866	17" 904	16" 945
36'		25" 716	21" 820	20" 855	18" 930	17" 974	16" 1024
39'		24" 864	21" 958	20" 998	18" 1086	17" 1139	16" 1198
40'		24" 796	21" 880	20" 915	18" 995	17" 1042	16" 1094
42'		24" 932	21" 1034	20" 1076	18" 1172	17" 1228	16" 1292
45'		23" 1169	21" 1258	20" 1310	18" 1430	17" 1500	16" 1580
48'		23" 1243	20" 1400	19" 1454	18" 1520	17" 1595	16" 1680
54'		23" 1670	20" 1875	19" 1958	18" 2050	17" 2152	16" 2268
60'		23" 1950	20" 2180	19" 2276	18" 2384	17" 2502	16" 2640
72'		22" 2016	19" 2388	18" 2500	17" 2630	17" 2630	16" 2766
75'		22" 3272	19" 3712	18" 3890	17" 4088	17" 4088	16" 4314
78'		22" 3544	19" 4020	18" 4214	17" 4430	16" 4674	16" 4674
90'		22" 4650	19" 5280	18" 5538	17" 5826	16" 6150	15" 6520
105'		21" 6962	18" 7920	17" 8315	16" 8760	16" 8760	15" 9264

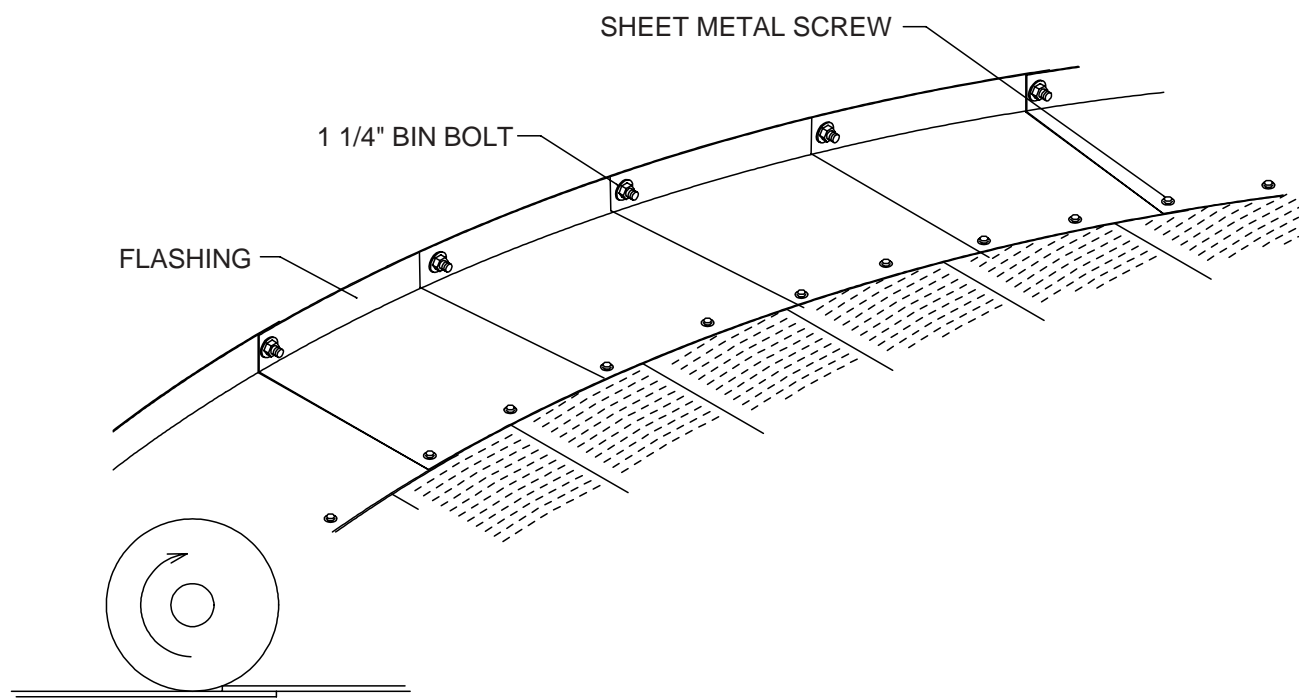
Monorail Installation



OUTER PERIMETER RAIL DETAIL



FLASHING INSTALLATION



GRAIN SYSTEMS FORMED FLASHING INSTALLATION

If bin sweep auger is to be used, overlap flashing such that rotation (usually clockwise) of the sweep will climb up on the next flashing section. This will prevent the rotating/slipping outer wheel of the sweep from catching on the flashing edges.

After the floor is in place, lay the flashing pieces on top of the floor place over the 1.1/4" bin bolts. See the details below to determine the correct sequence for placing the nuts and washers. Finger tighten the nuts. While holding flashing flat, fasten the flashing to the floor with sheet metal screws. Now tighten flashing nuts.

2.66" CORRUGATION

Bin bolt
Flat washer
Spacer, nut
Flashing
Sheet metal screw
Flooring

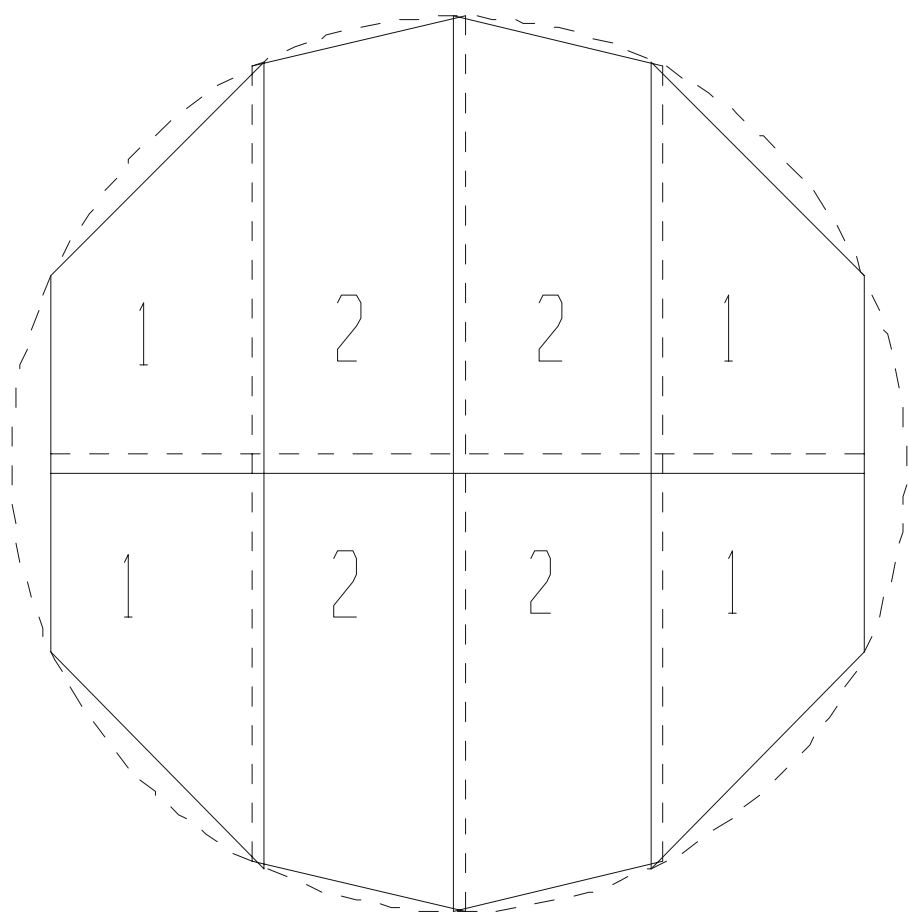
4.00" CORRUGATION

Flat washer
Bin bolt
Flashing
Sheet metal screw
Spacer, nut
Flooring
HIGH PLENUM
Bin bolt
Flat washer
Flashing
Sheet metal screw
Flooring
LOW PLENUM

NOTES

12' BIN FLOOR LAYOUTS

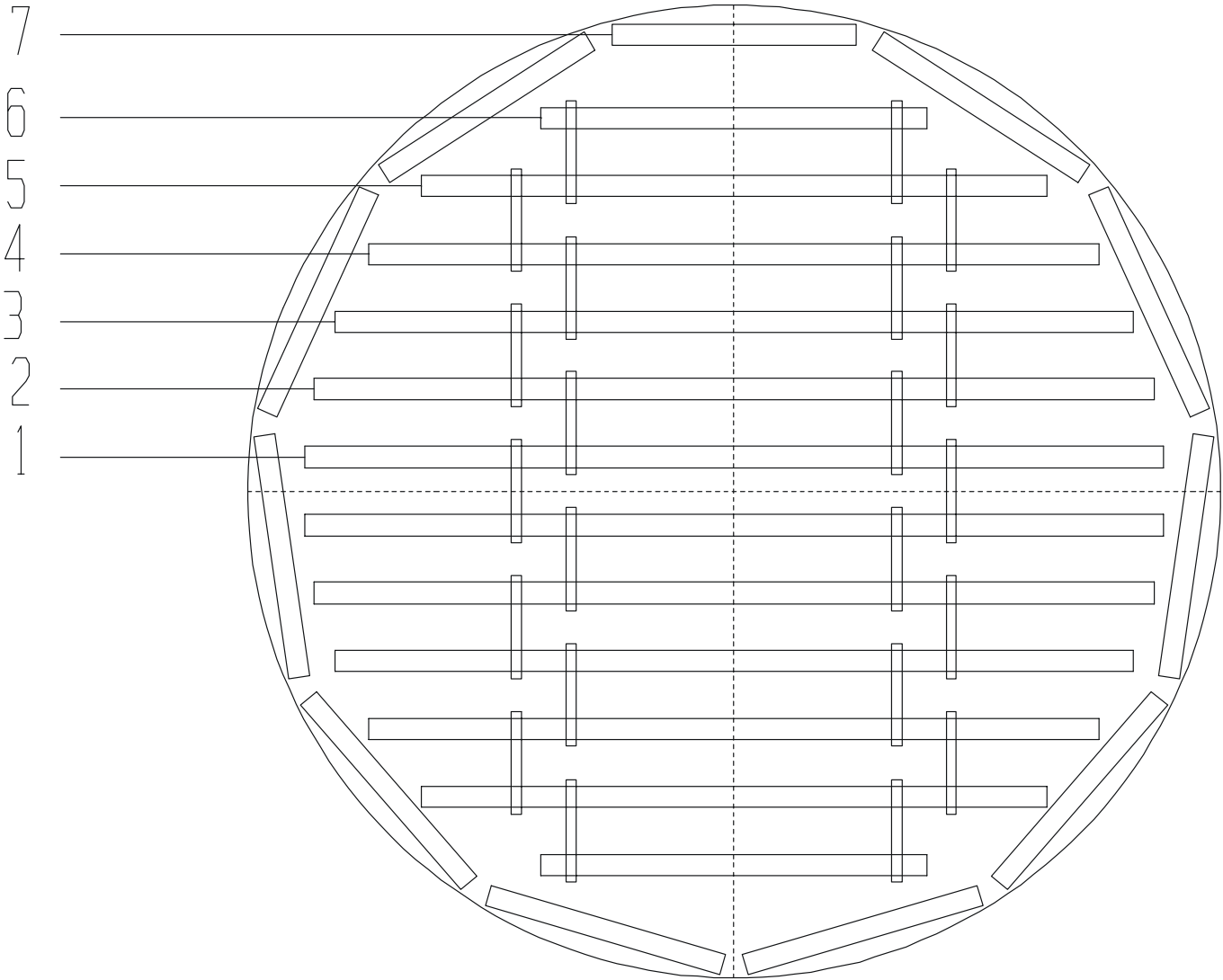
12' DIAMETER CORRUGATED FLOOR



12' Diameter Monorail Lengths	
Monorail Number	Sec 1.
1	128.0
2	125.0
3	118.0
4	107.0
5	90.0
6	63.0
7	36.0

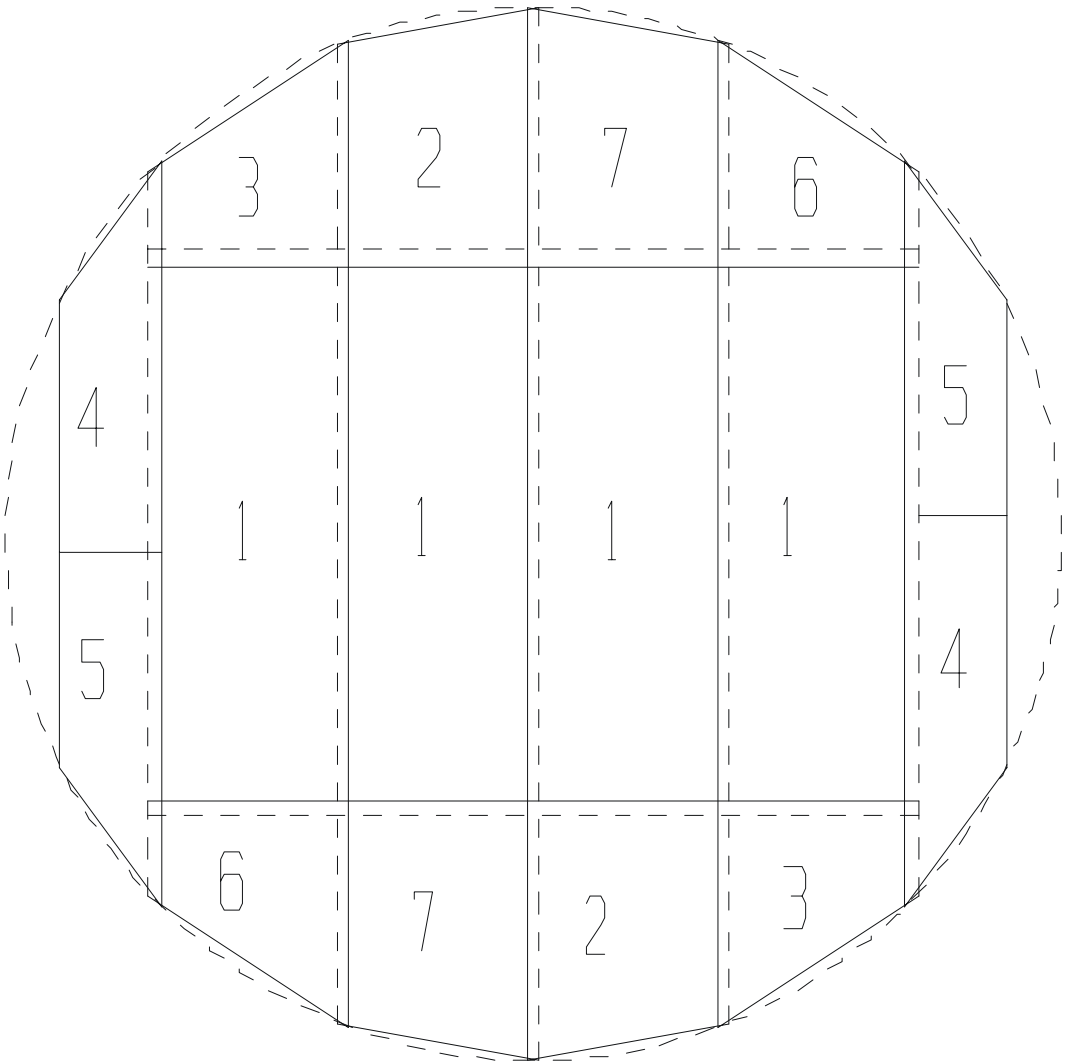
12' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES



15' BIN FLOOR LAYOUTS

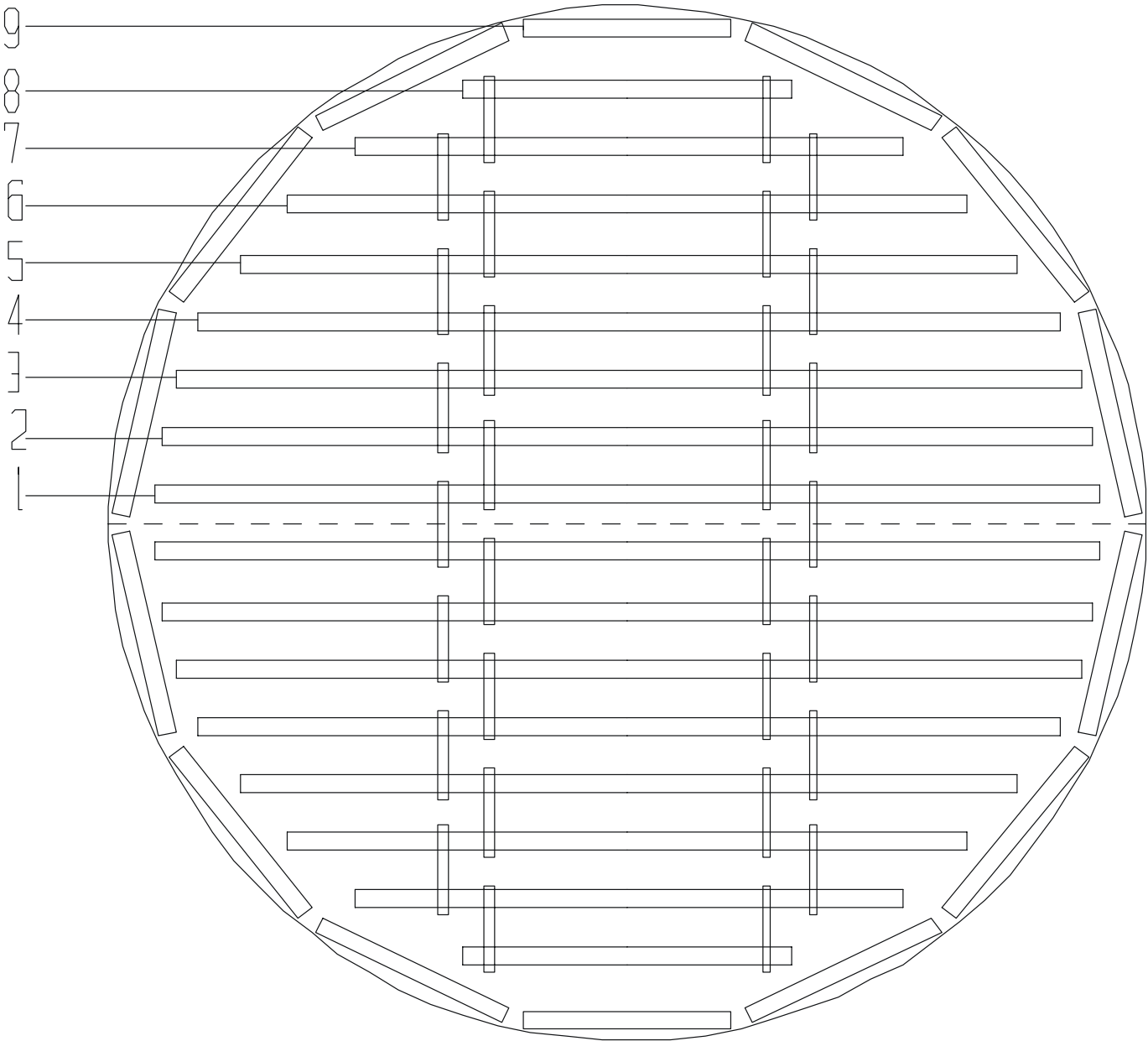
15' DIAMETER CORRUGATED FLOOR



15' Diameter Monorail Lengths	
Monorail Number	Sec 1.
14	163.0
15	157.0
16	149.0
17	137.0
18	122.0
19	99.0
20	65.0
21	36.0

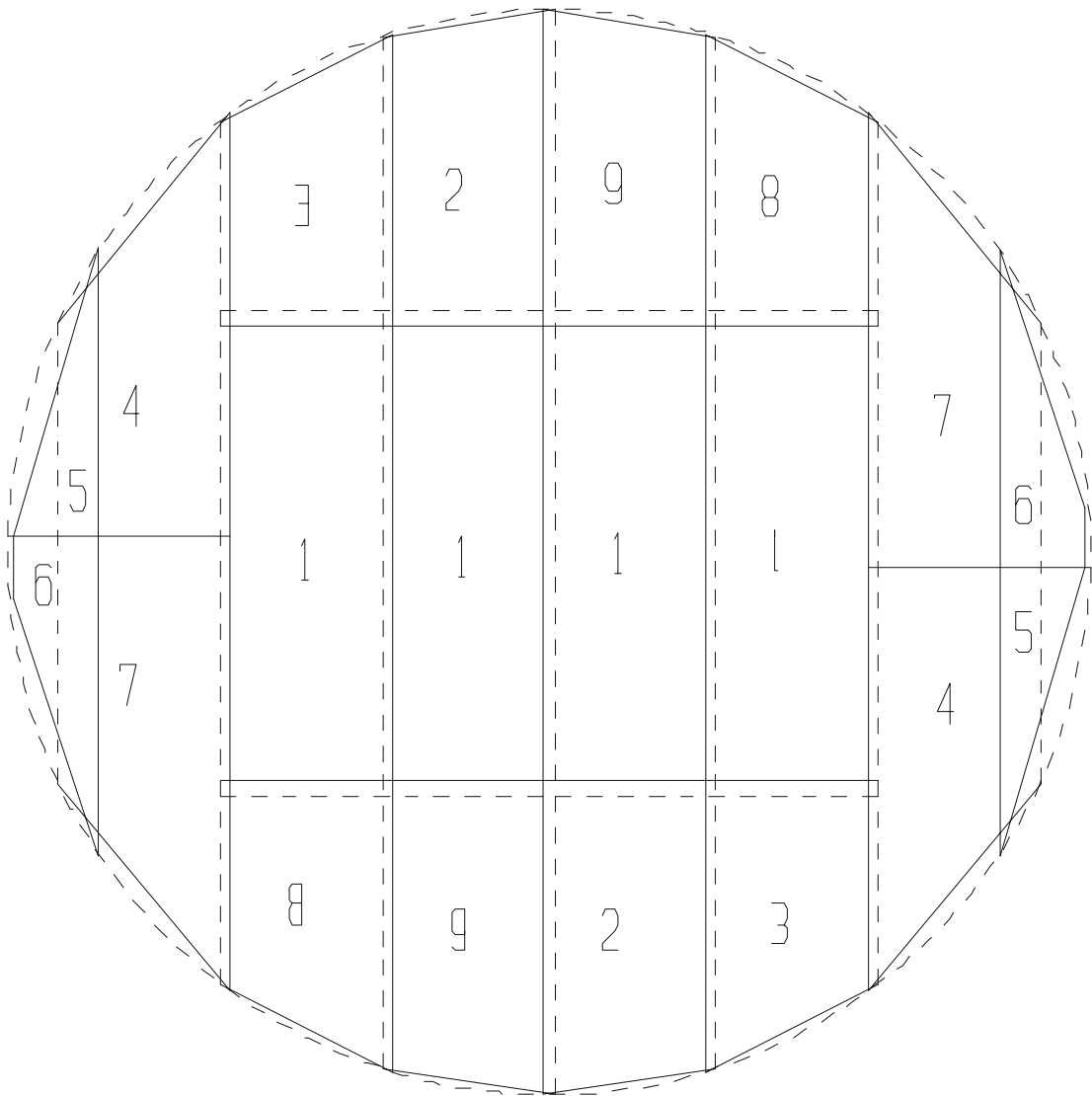
15' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES



18' BIN FLOOR LAYOUTS

18' DIAMETER CORRUGATED FLOOR

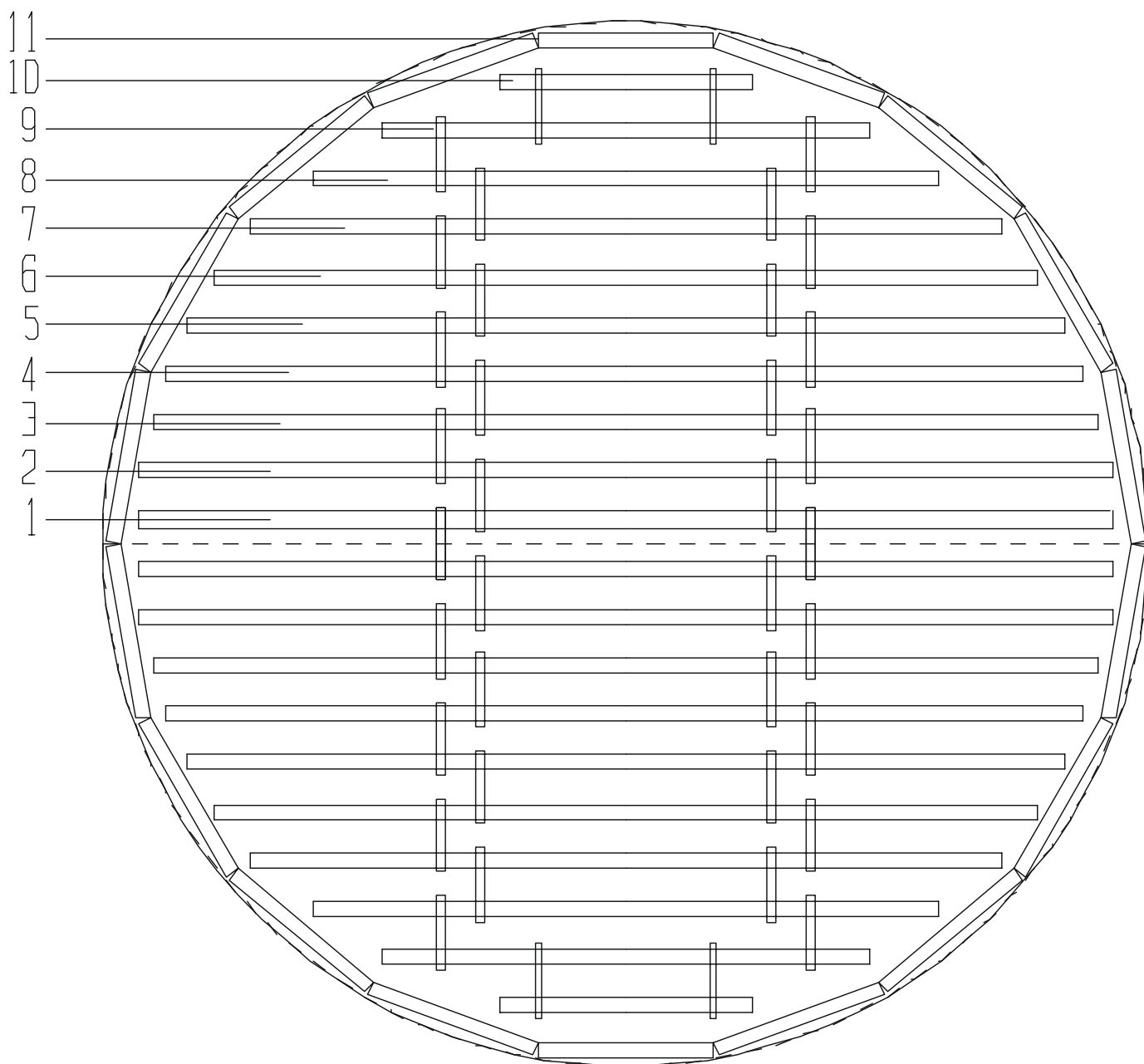


18' Diameter Monorail Lengths	
Monorail Number	Sec 1.
1	202.0
2	200.0
3	195.0
4	189.0
5	180.0
6	168.0
7	153.0
8	132.0
9	105.0
10	61.0
11	36.0

18' DIAMETER-MONORAIL-10" SPACING

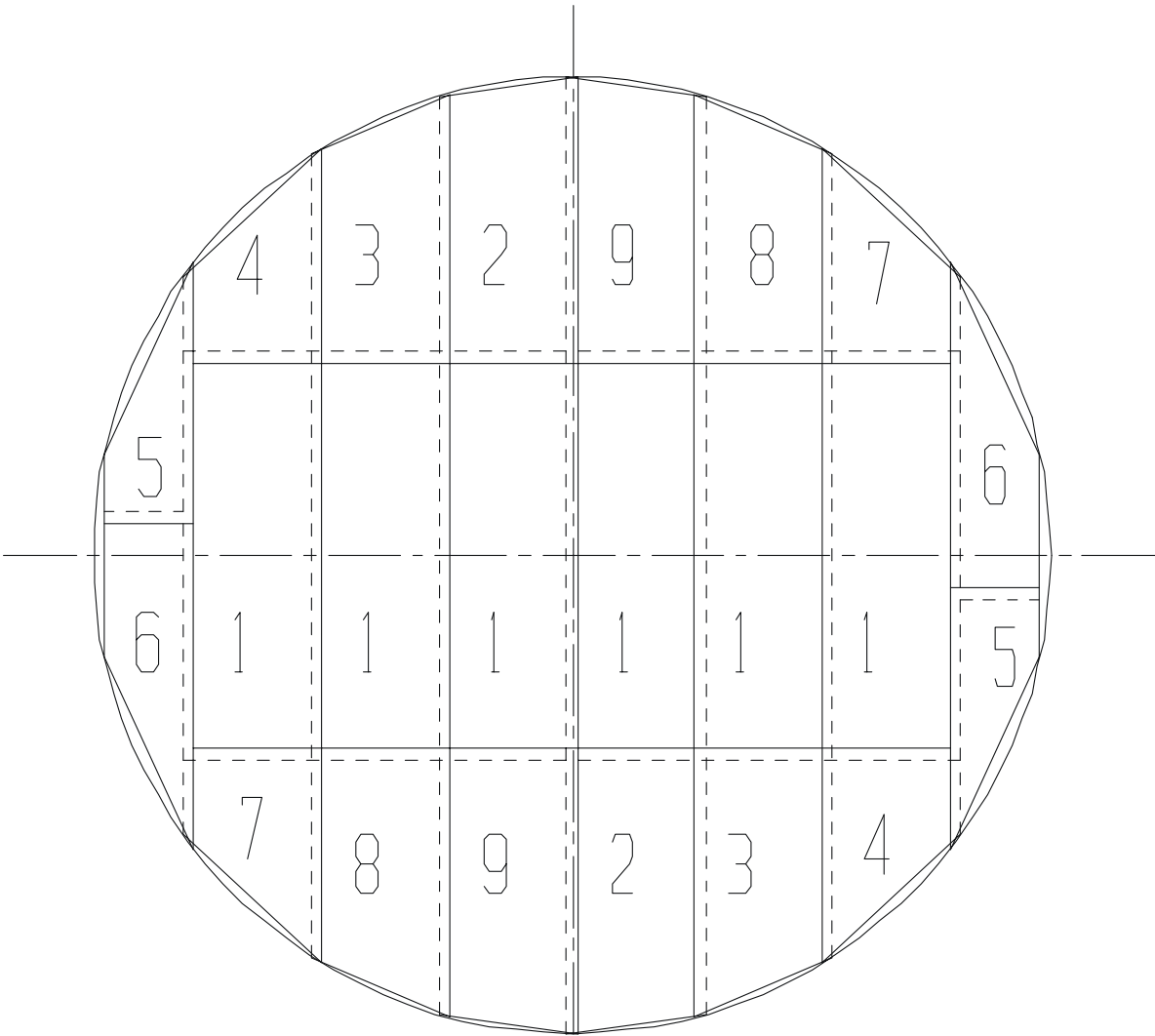
* MONORAIL LEGS NOT SHOWN

* DIMENSIONS IN INCHES



20' BIN FLOOR LAYOUTS

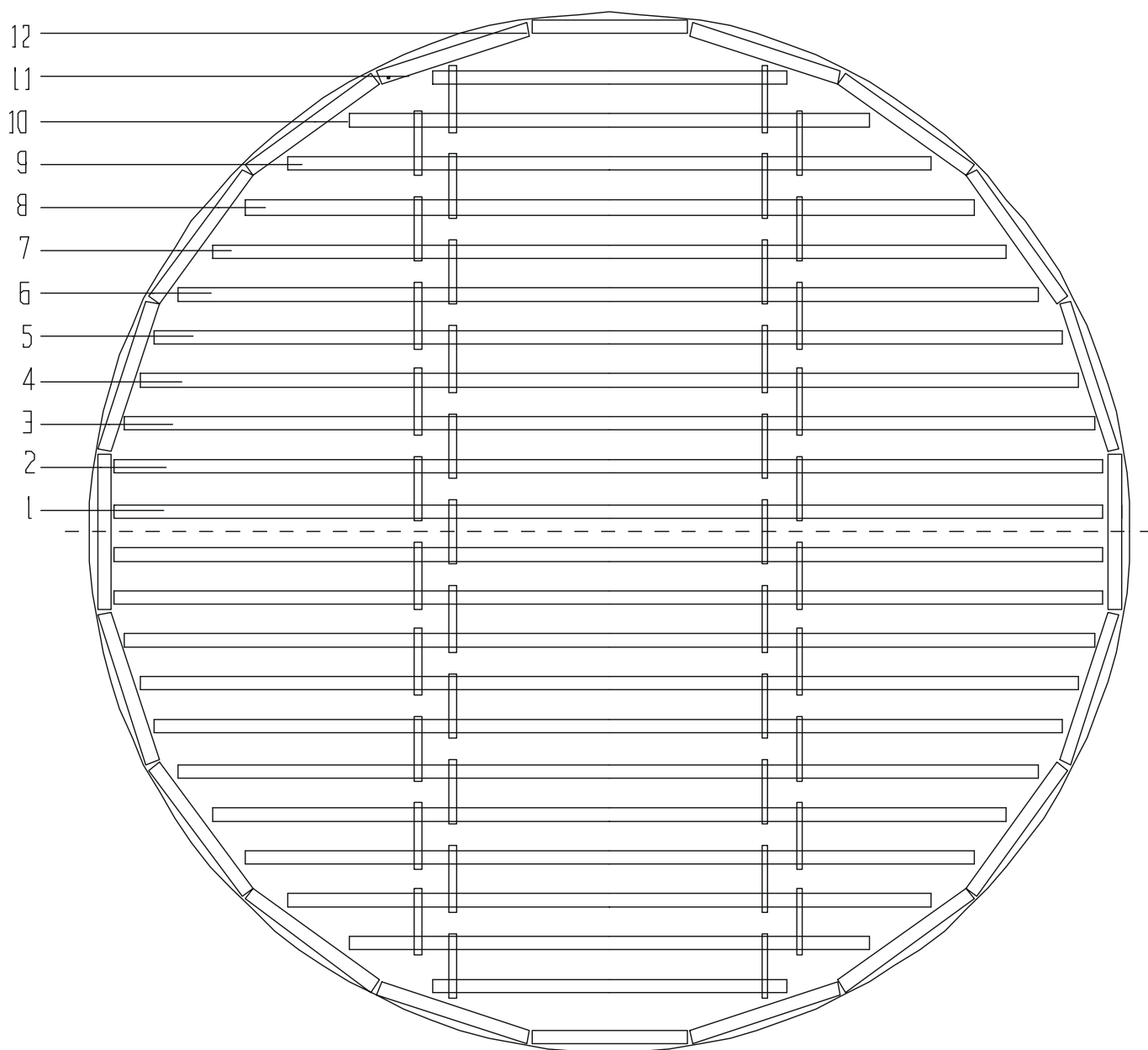
20' CORRUGATED FLOOR



20' Diameter Monorail Lengths	
Monorail Number	Sec 1.
1	226.0
2	224.0
3	220.0
4	214.0
5	207.0
6	196.0
7	183.0
8	167.0
9	146.0
10	119.0
11	78.0
12	36.0

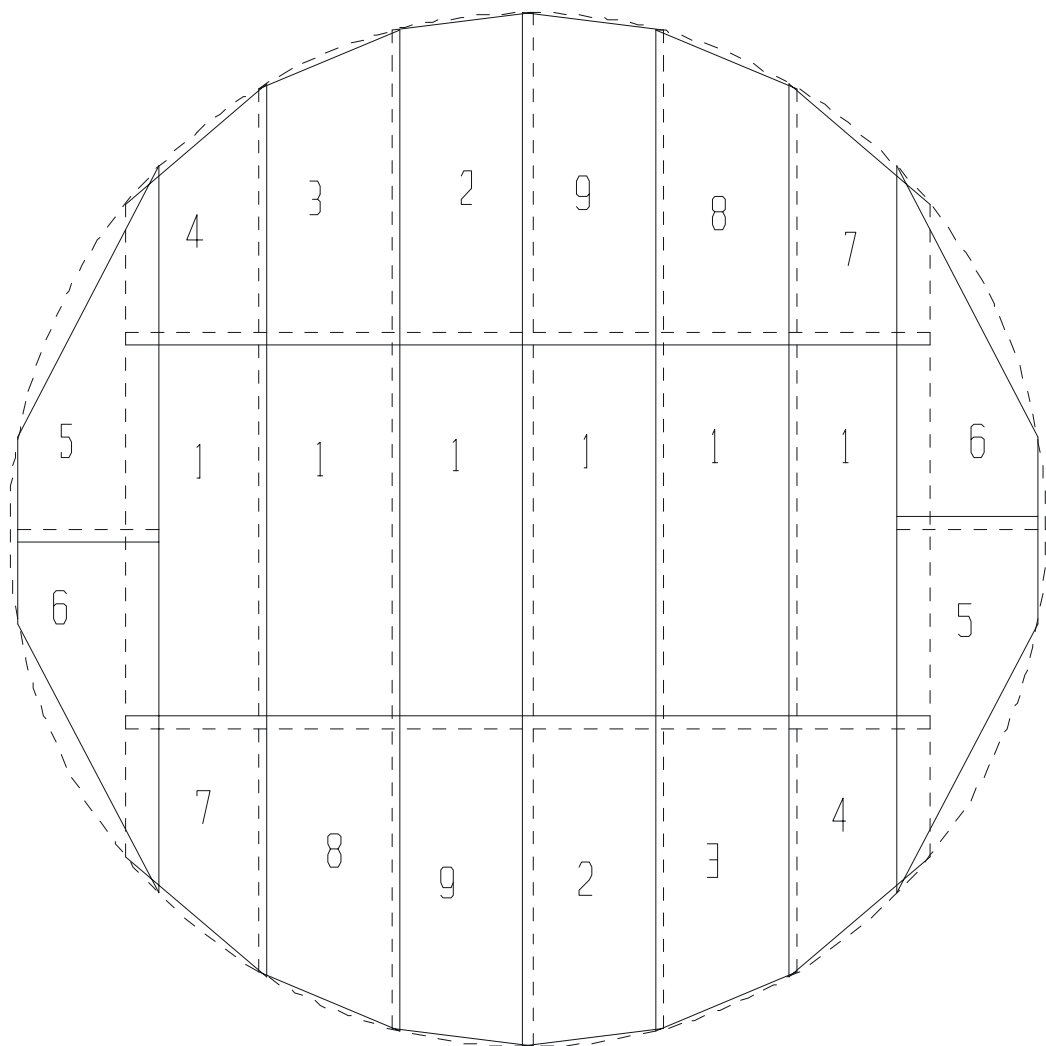
20' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 20 PIECES AROUND THE OUTSIDE OF THE BIN



21' BIN FLOOR LAYOUTS

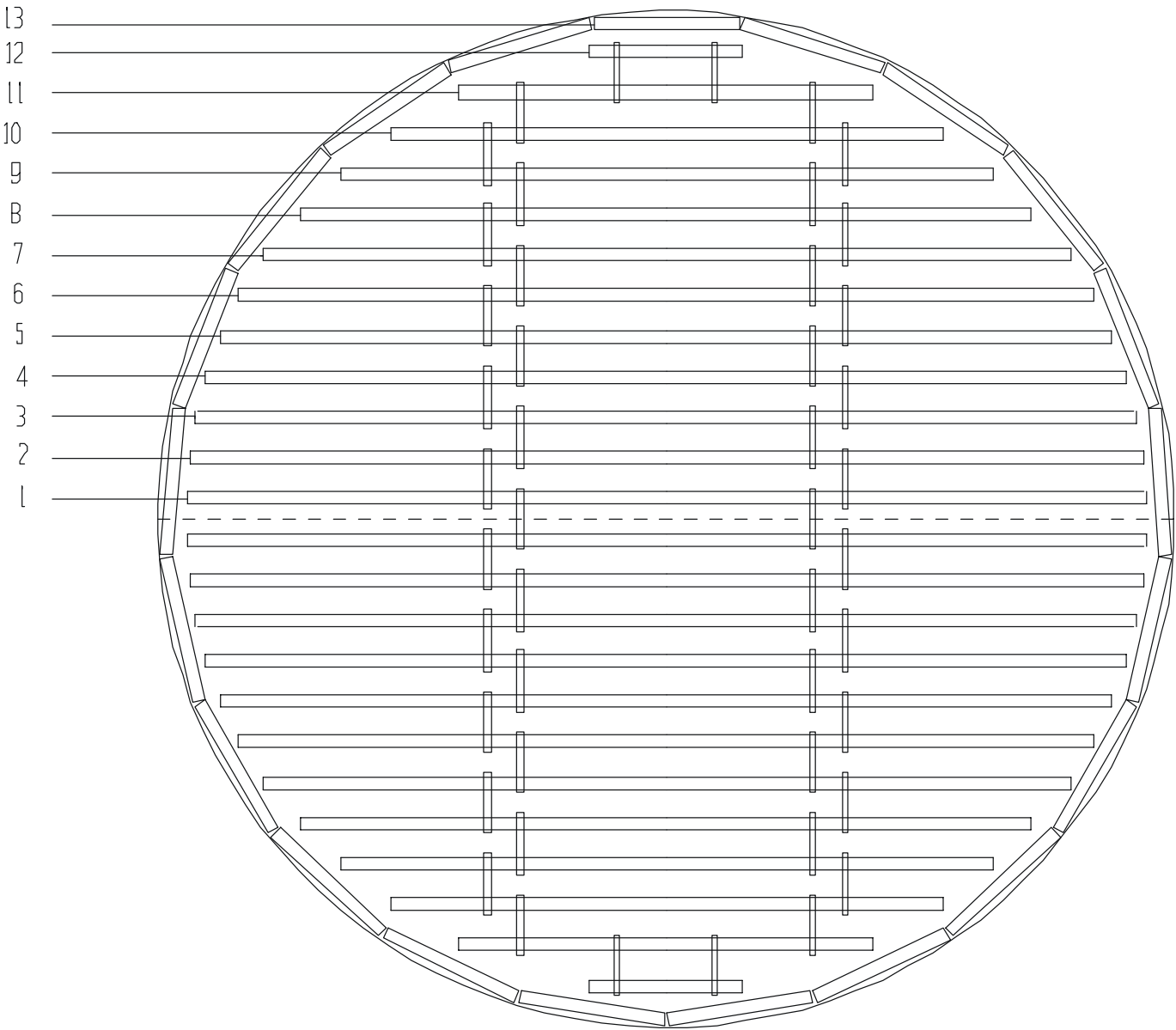
21' DIAMETER CORRUGATED BIN



21' Diameter Monorail Lengths	
Monorail Number	Sec 1.
1	238.0
2	236.0
3	233.0
4	227.0
5	220.0
6	210.0
7	198.0
8	183.0
9	164.0
10	140.0
11	108.0
12	52.0
13	36

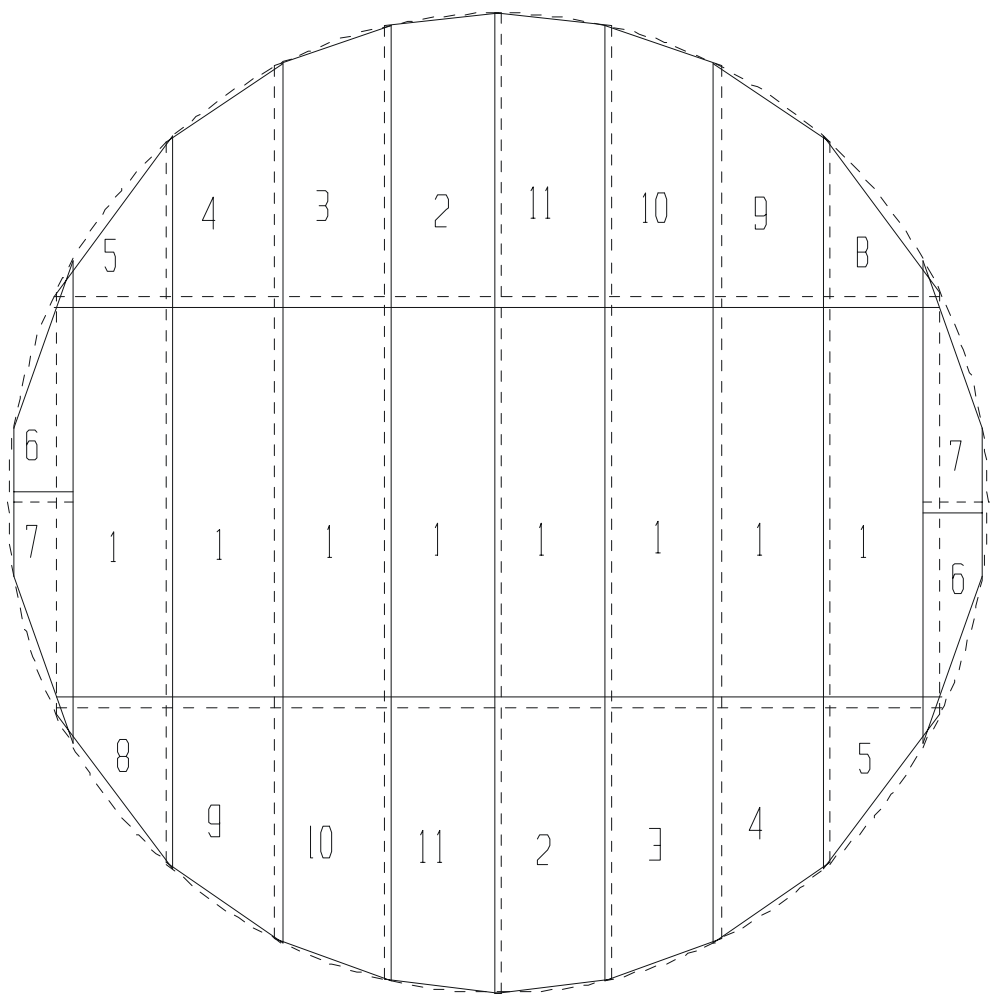
21' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES



24' BIN FLOOR LAYOUTS

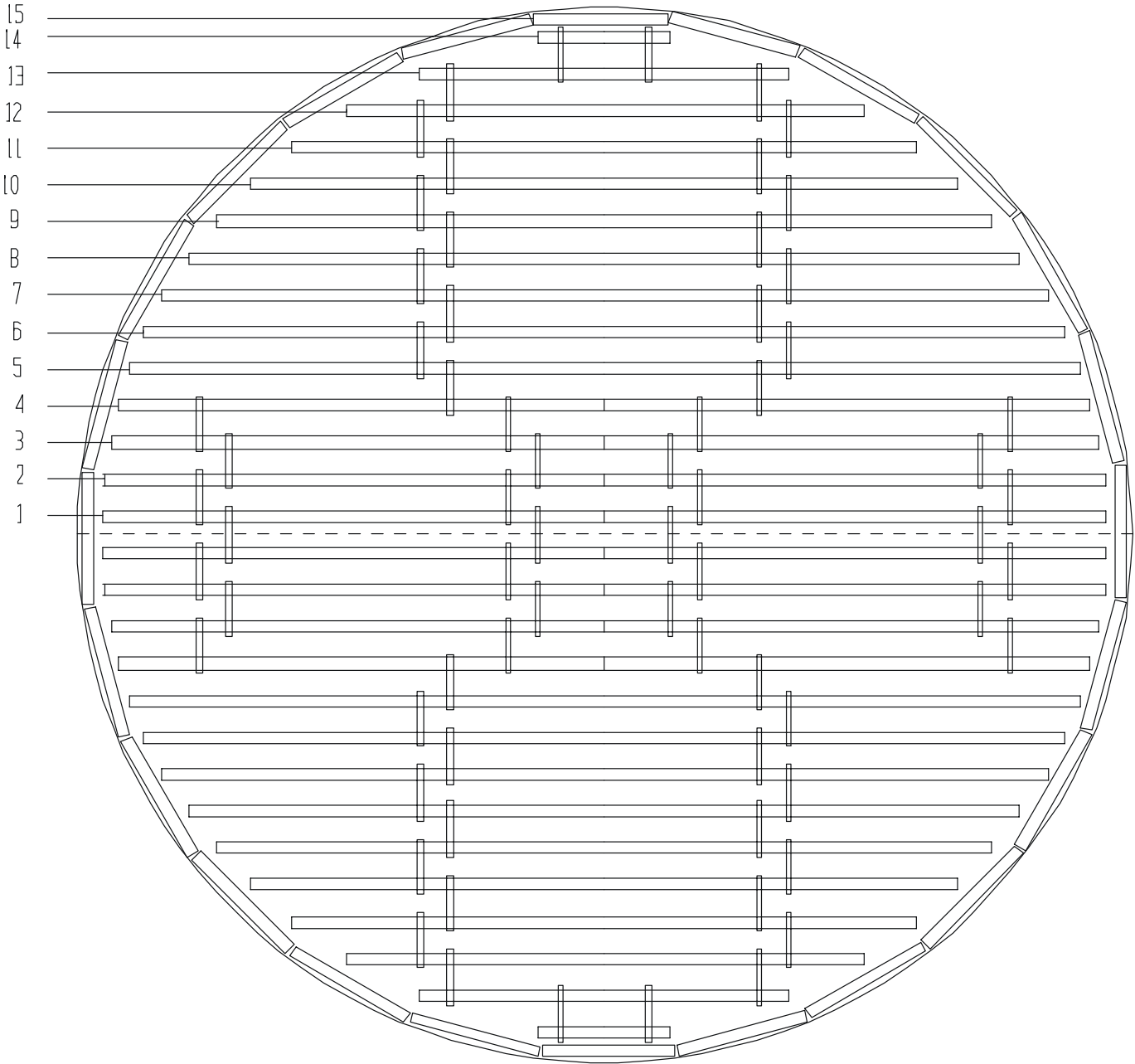
24' DIAMETER CORRUGATED FLOOR



24' Diameter Monorail Lengths		
Monorail Number	Sec 1.	Sec 2.
1	137.0	137.0
2	136.0	136.0
3	135.0	135.0
4	132.0	132.0
5	258.0	--
6	250.0	--
7	240.0	--
8	228.0	--
9	213.0	--
10	196.0	--
11	174.0	--
12	146.0	--
13	108.0	--
14	36.0	--
15	36.0	--

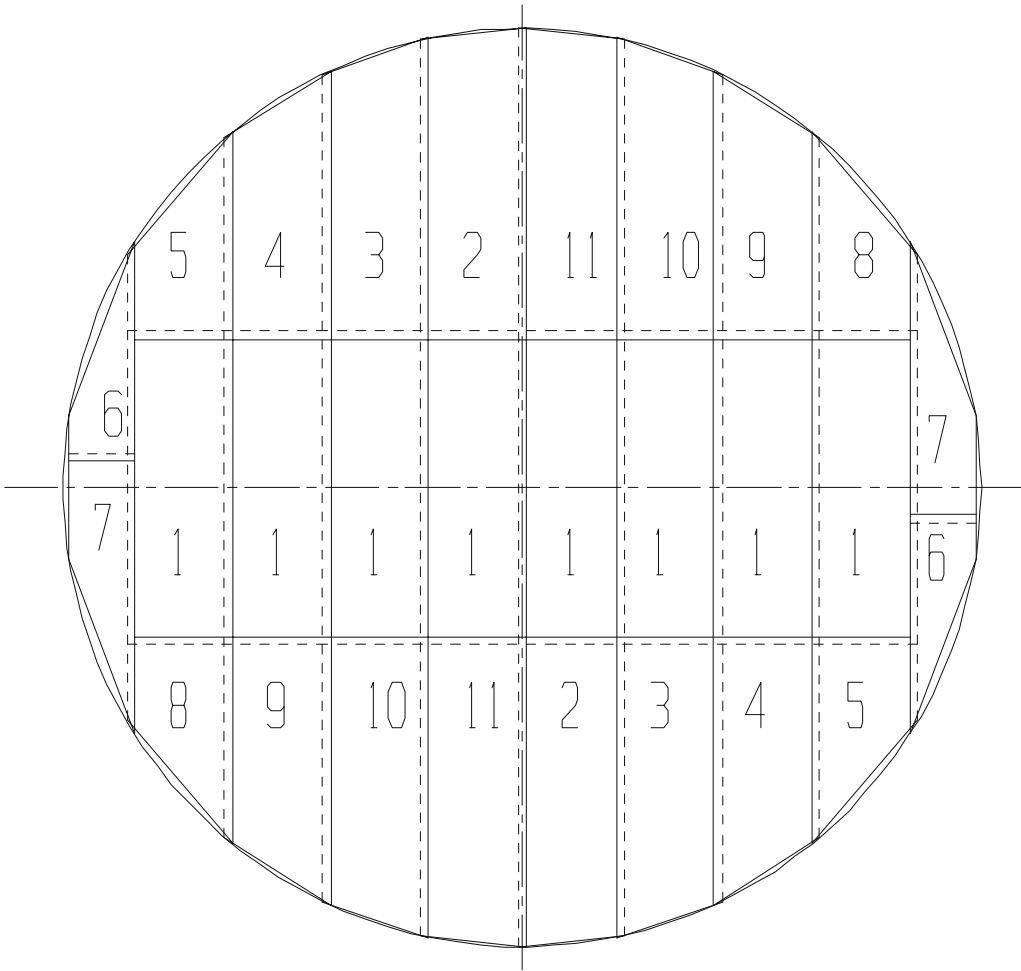
24' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES



25' BIN FLOOR LAYOUTS

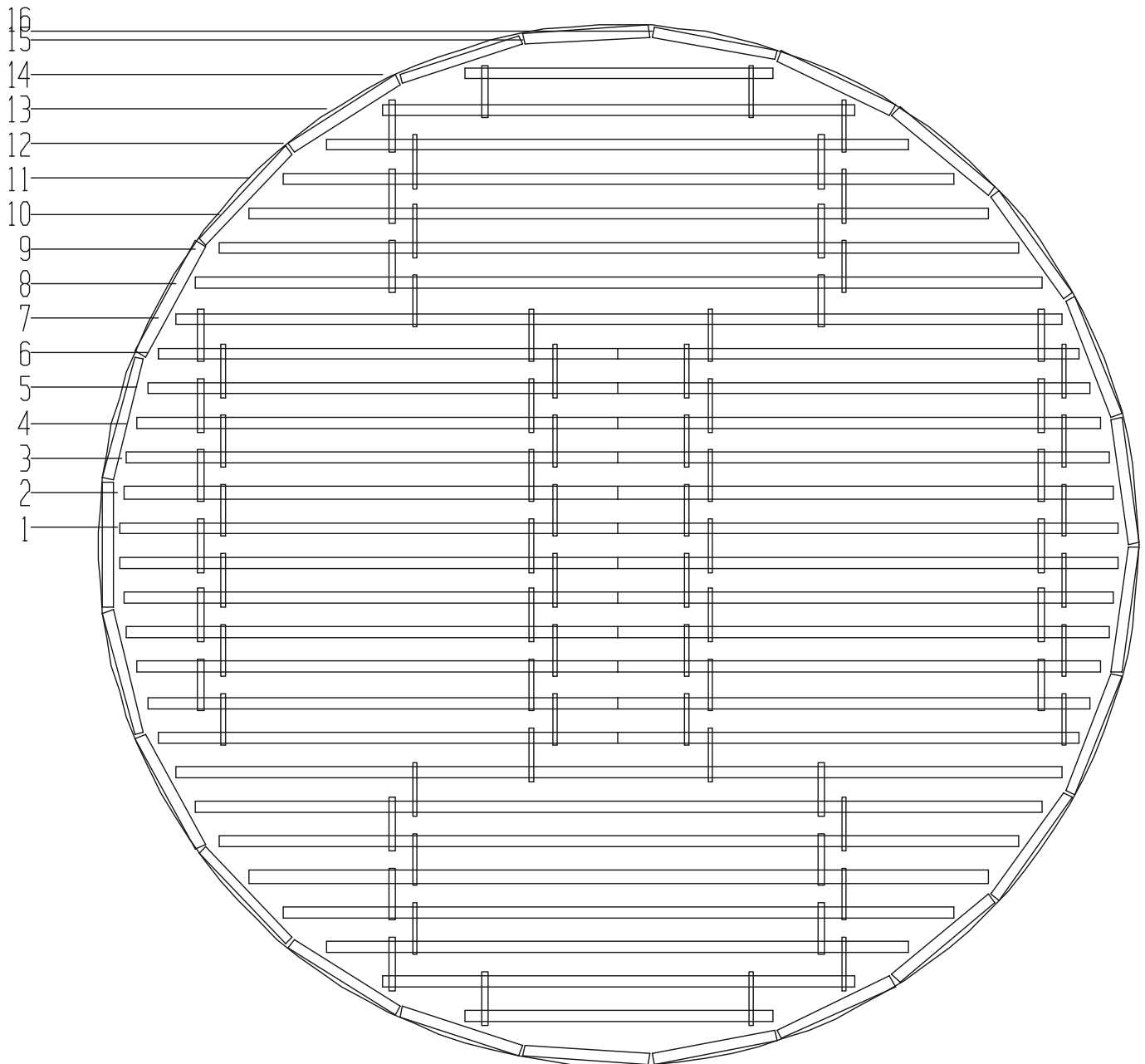
25' CORRUGATED FLOOR



25' Diameter Monorail Lengths		
Monorail Number	Sec 1.	Sec 2.
1	143.0	143.0
2	142.0	142.0
3	141.0	141.0
4	138.0	138.0
5	135.0	135.0
6	132.0	132.0
7	254.0	--
8	243.0	--
9	229.0	--
10	212.0	--
11	192.0	--
12	167.0	--
13	135.0	--
14	88.0	--
15	36.0	--
16	36.0	--

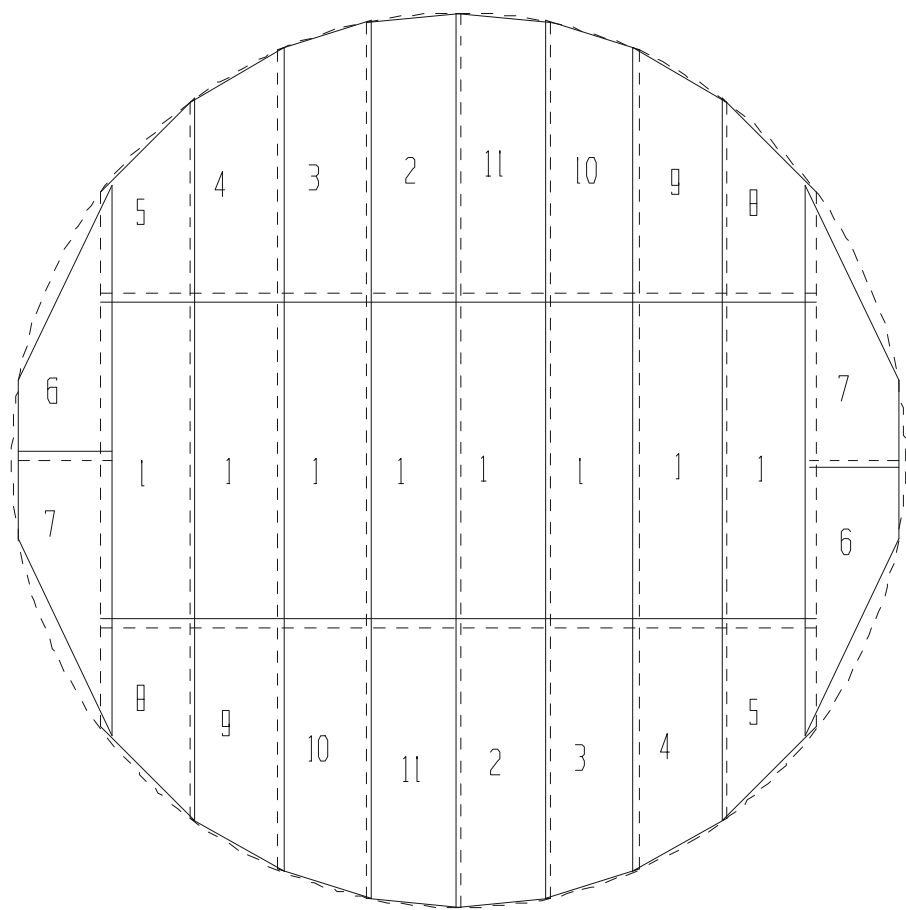
25' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 25 PIECES AROUND THE OUTSIDE OF BIN



27' BIN FLOOR LAYOUTS

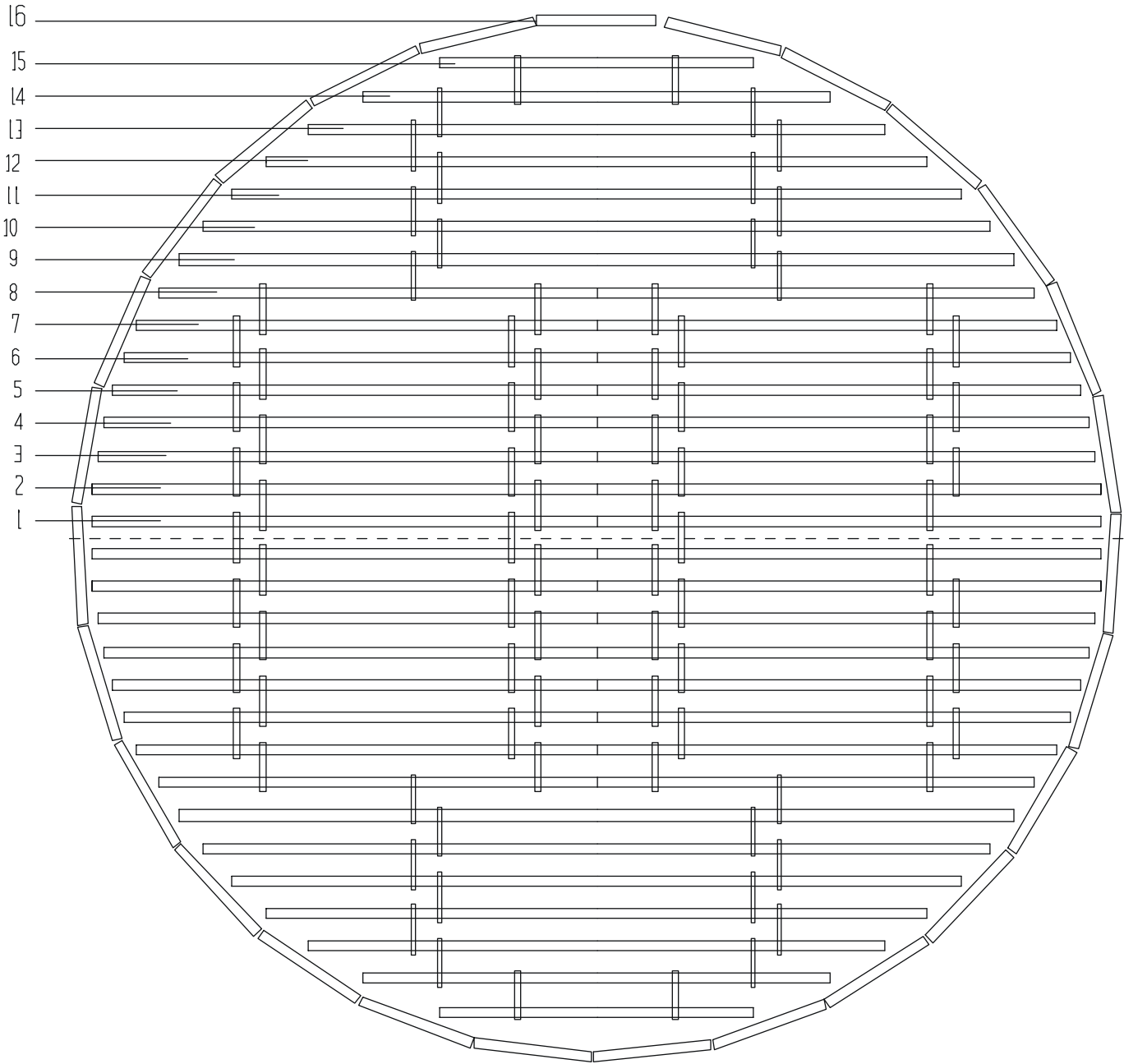
27' DIAMETER CORRUGATED BIN



27' Diameter Monorail Lengths		
Monorail Number	Sec 1.	Sec 2.
1	155.0	155.0
2	154.0	154.0
3	153.0	153.0
4	151.0	151.0
5	148.0	148.0
6	144.0	144.0
7	140.0	140.0
8	135.0	135.0
9	258.0	--
10	244.0	--
11	226.0	--
12	206.0	--
13	181.0	--
14	149.0	--
15	104.0	--
16	36.0	--

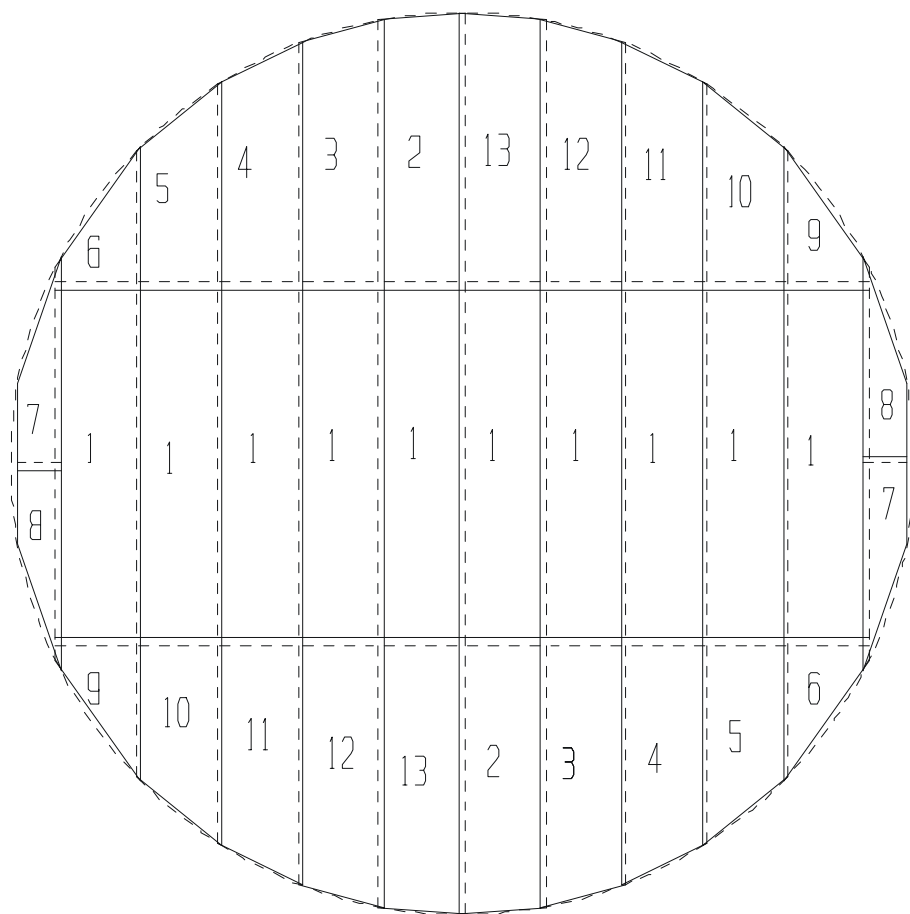
27' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES



30' BIN FLOOR LAYOUTS

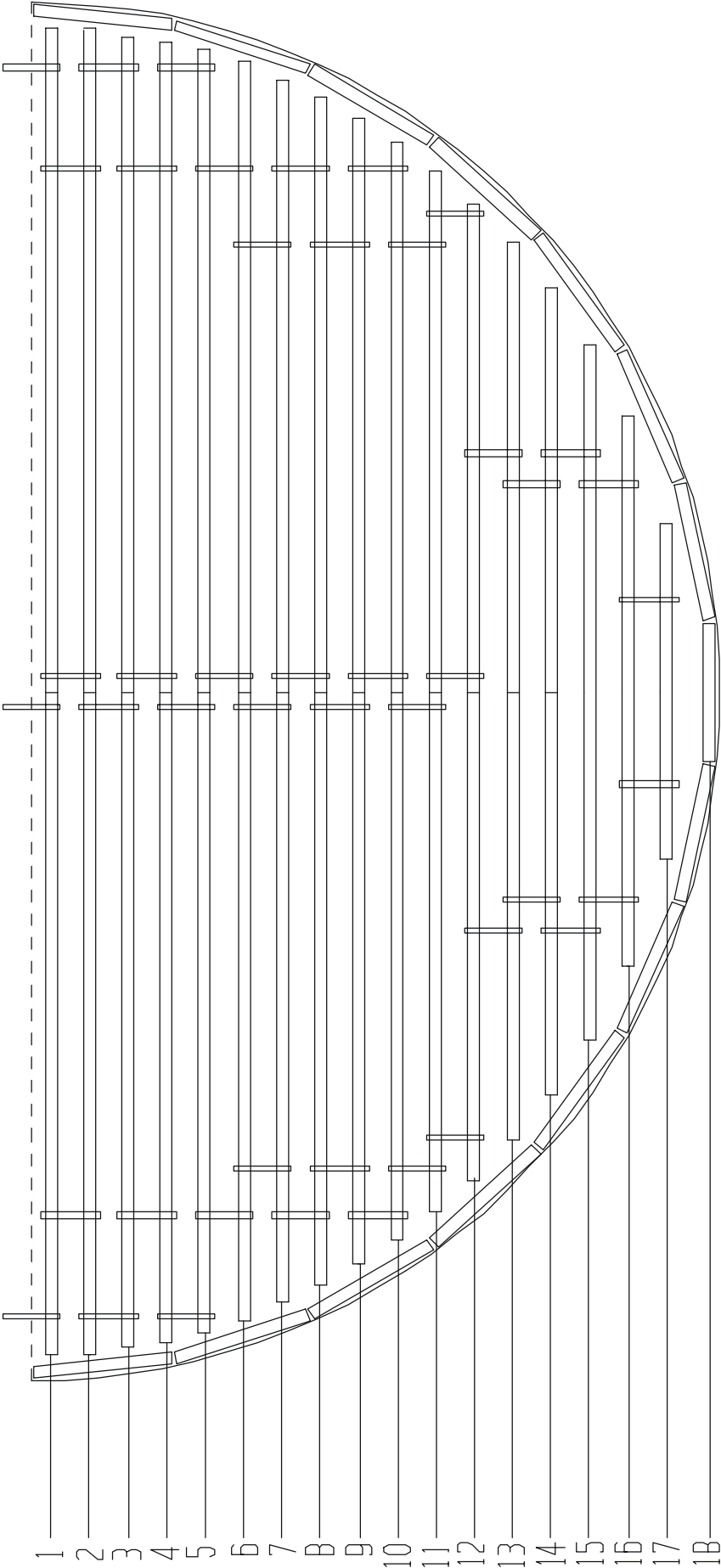
30' DIAMETER CORRUGATED FLOOR



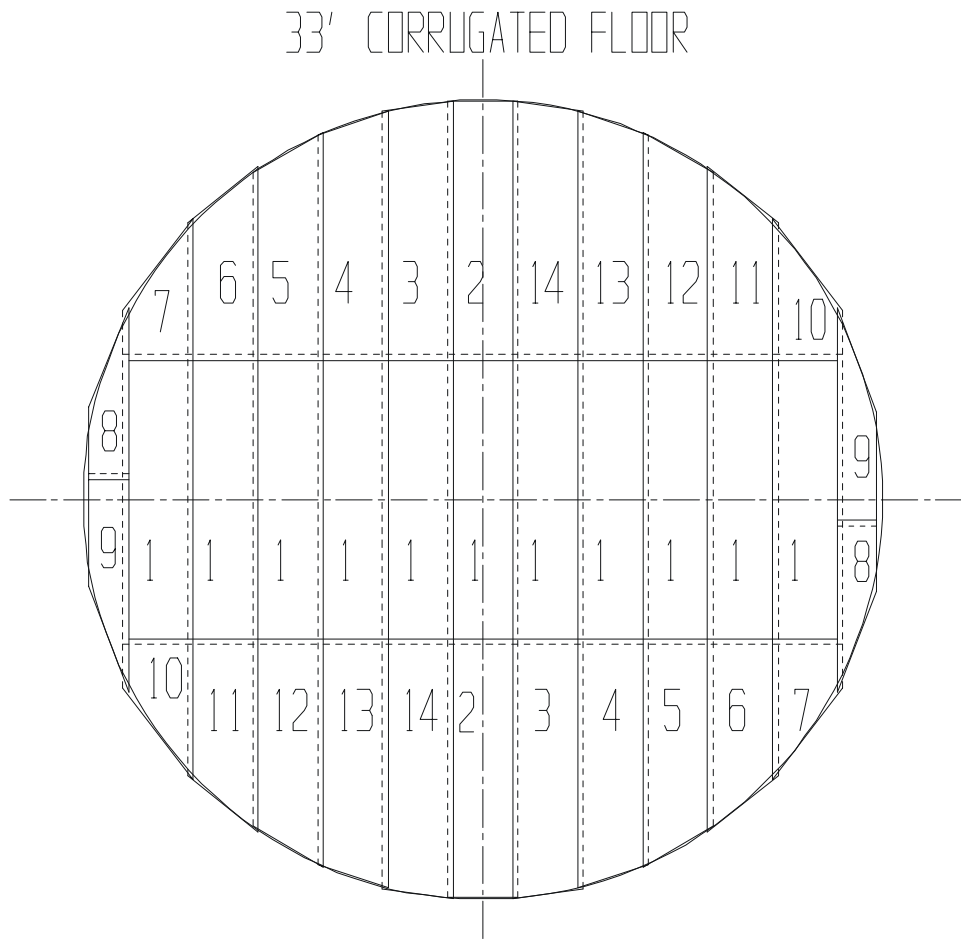
30' Diameter Monorail Lengths		
Monorail Number	Sec 1.	Sec 2.
1	172.0	172.0
2	172.0	172.0
3	170.0	170.0
4	168.0	168.0
5	167.0	167.0
6	164.0	164.0
7	160.0	160.0
8	155.0	155.0
9	150.0	150.0
10	144.0	144.0
11	137.0	137.0
12	257.0	--
13	237.0	--
14	214.0	--
15	186.0	--
16	150.0	--
17	98.0	--
18	36.0	--

30' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 30 PIECES AROUND THE OUTSIDE OF BIN



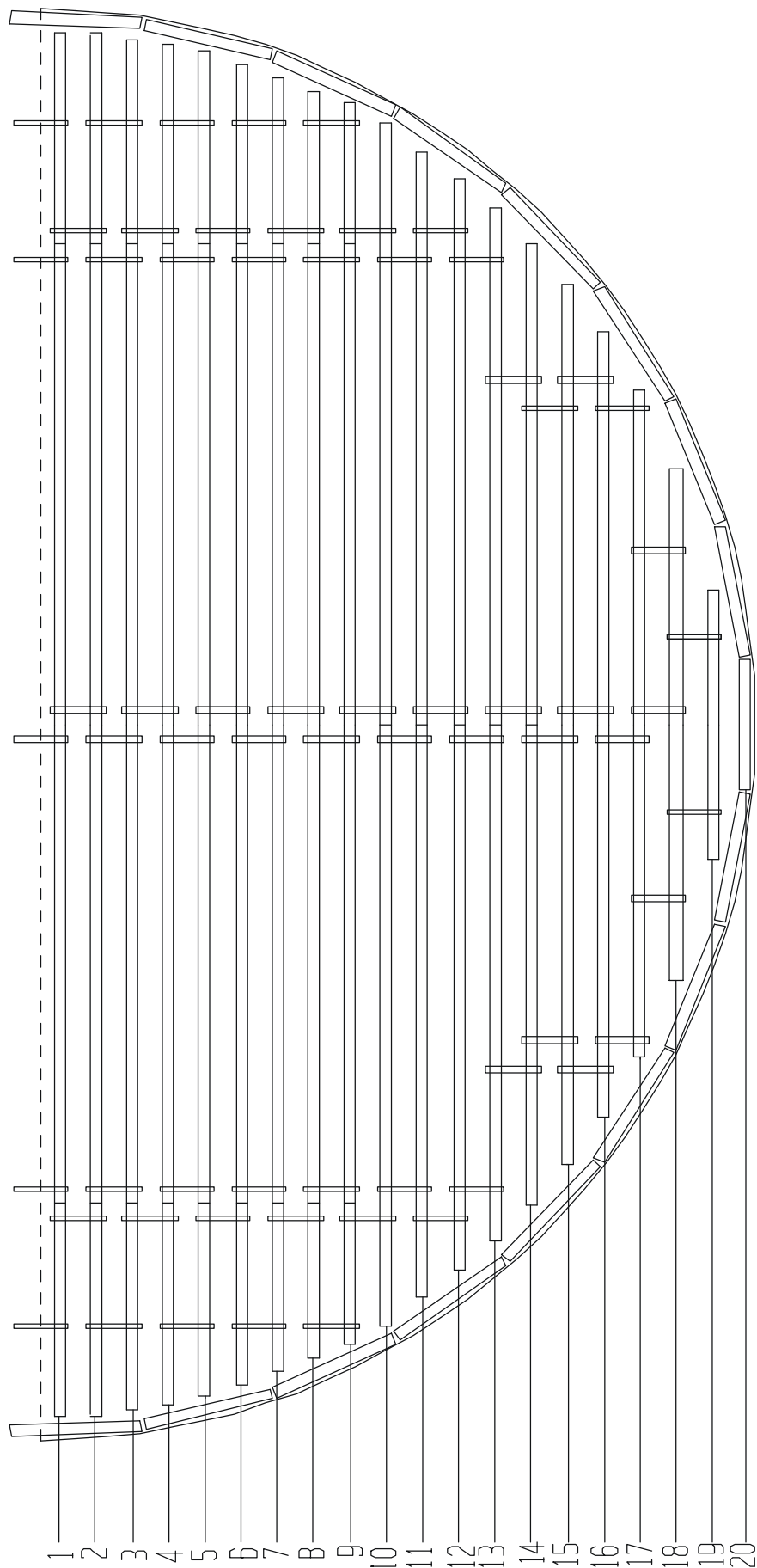
33' BIN FLOOR LAYOUTS



33' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	59.0	264.0	59.0
2	58.0	264.0	58.0
3	57.0	264.0	57.0
4	56.0	264.0	56.0
5	53.0	264.0	53.0
6	51.0	264.0	51.0
7	47.0	264.0	47.0
8	43.0	264.0	43.0
9	38.0	264.0	38.0
10	165.0	165.0	--
11	159.0	159.0	--
12	152.0	152.0	--
13	143.0	143.0	--
14	134.0	134.0	--
15	246.0	--	--
16	220.0	--	--
17	189.0	--	--
18	148.0	--	--
19	87.0	--	--
20	36.0	--	--

33' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 33 PIECES AROUND THE OUTSIDE OF BIN

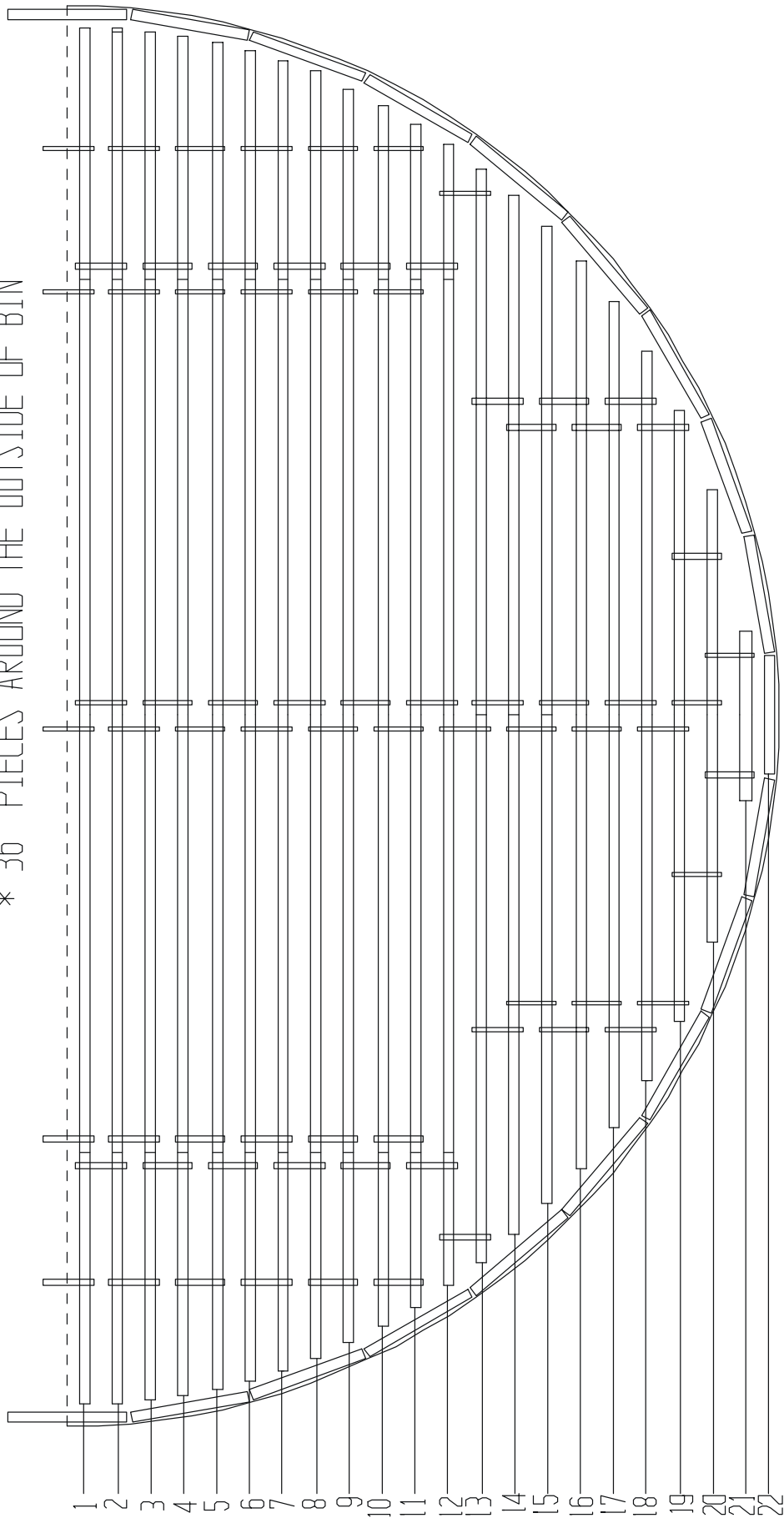


36' BIN FLOOR LAYOUTS

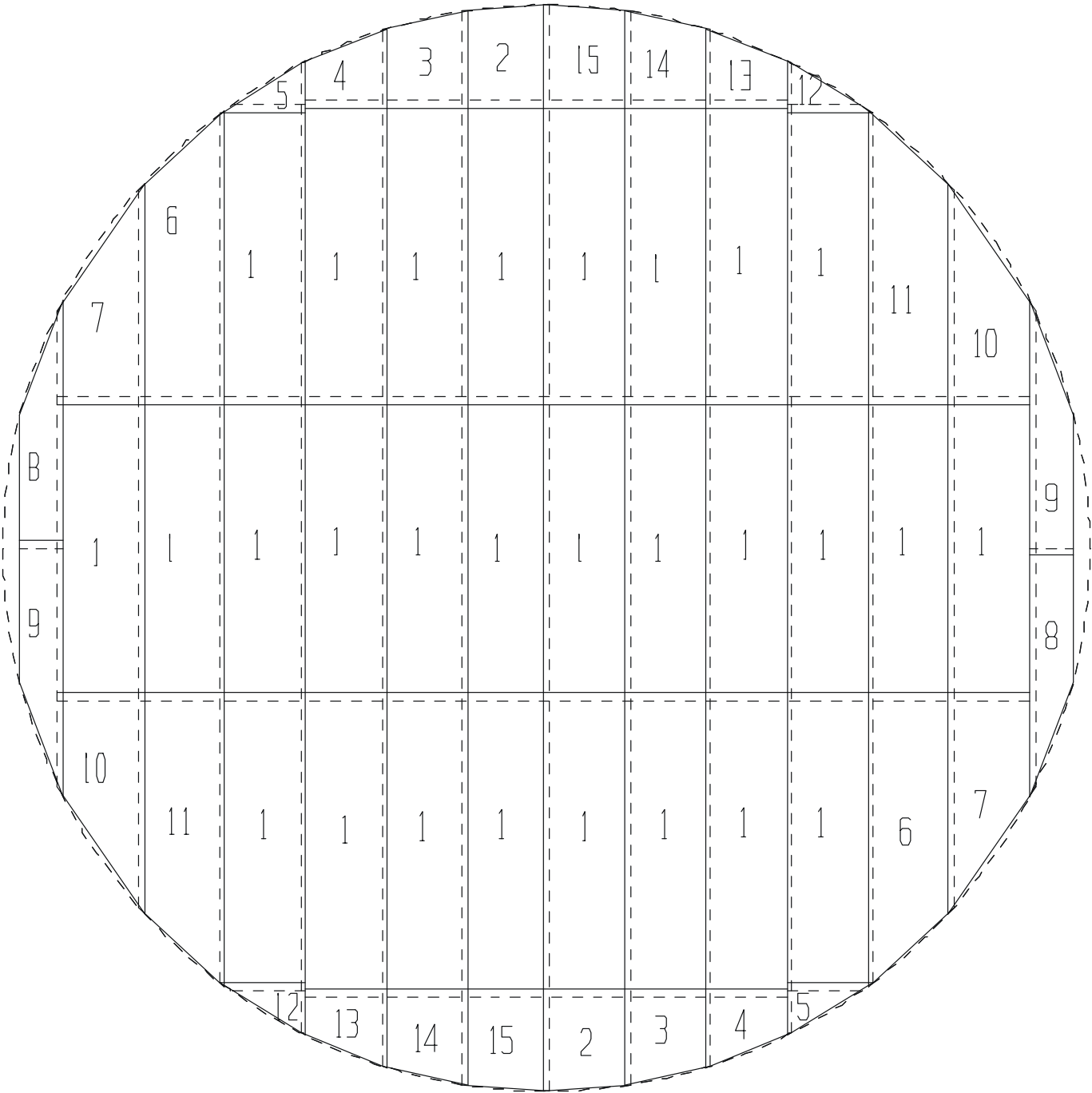
36' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	77.0	264.0	77.0
2	76.0	264.0	76.0
3	75.0	264.0	75.0
4	74.0	264.0	74.0
5	72.0	264.0	72.0
6	69.0	264.0	69.0
7	66.0	264.0	66.0
8	63.0	264.0	63.0
9	58.0	264.0	58.0
10	54.0	264.0	54.0
11	48.0	264.0	48.0
12	42.0	264.0	42.0
13	167.0	167.0	--
14	159.0	159.0	--
15	149.0	149.0	--
16	139.0	139.0	--
17	254.0	--	--
18	225.0	--	--
19	191.0	--	--
20	145.0	--	--
21	71.0	--	--
22	36.0	--	--

36' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 36 PIECES AROUND THE OUTSIDE OF BIN

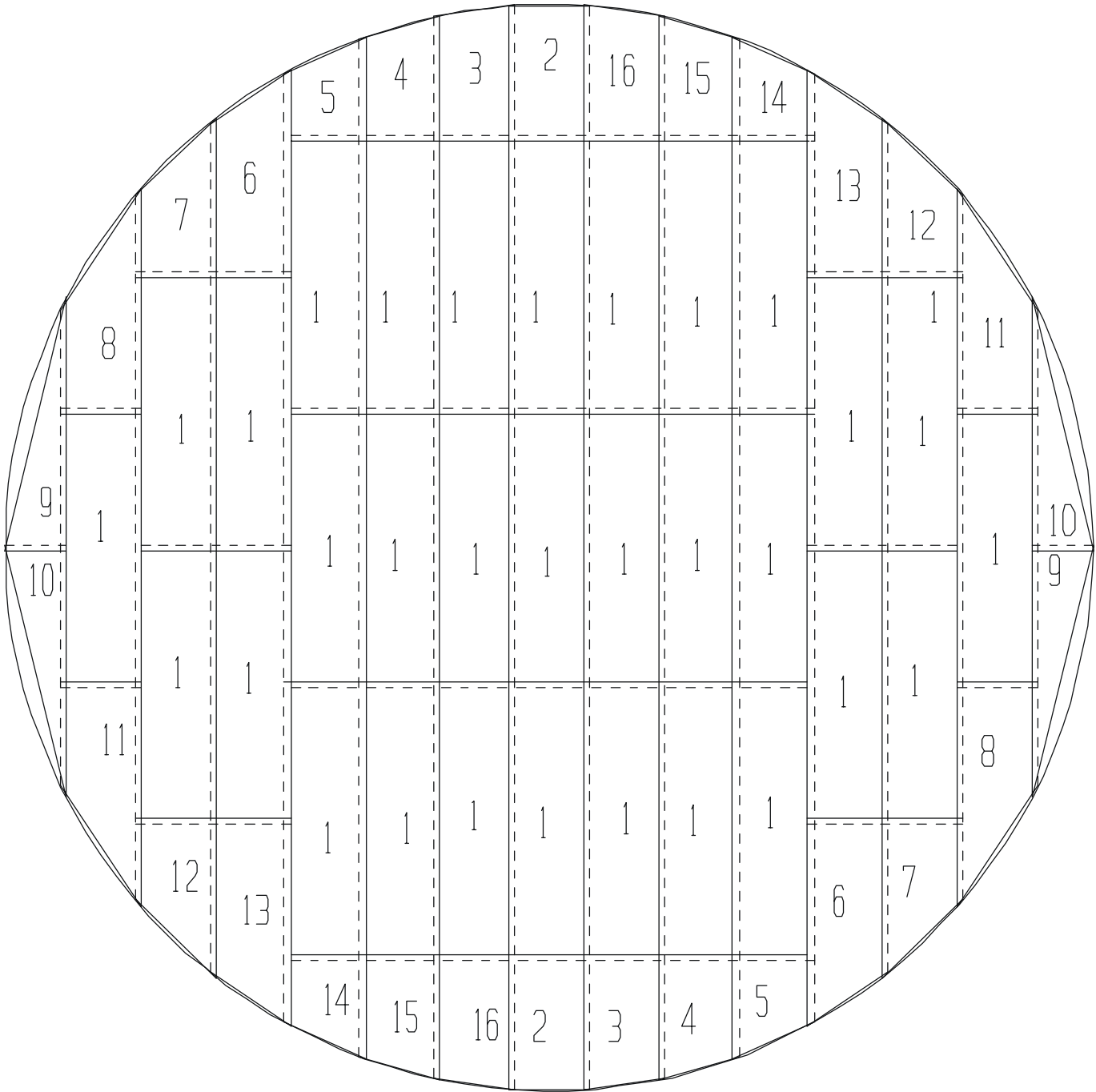


36' DIAMETER CORRUGATED FLOOR



39' BIN FLOOR LAYOUTS

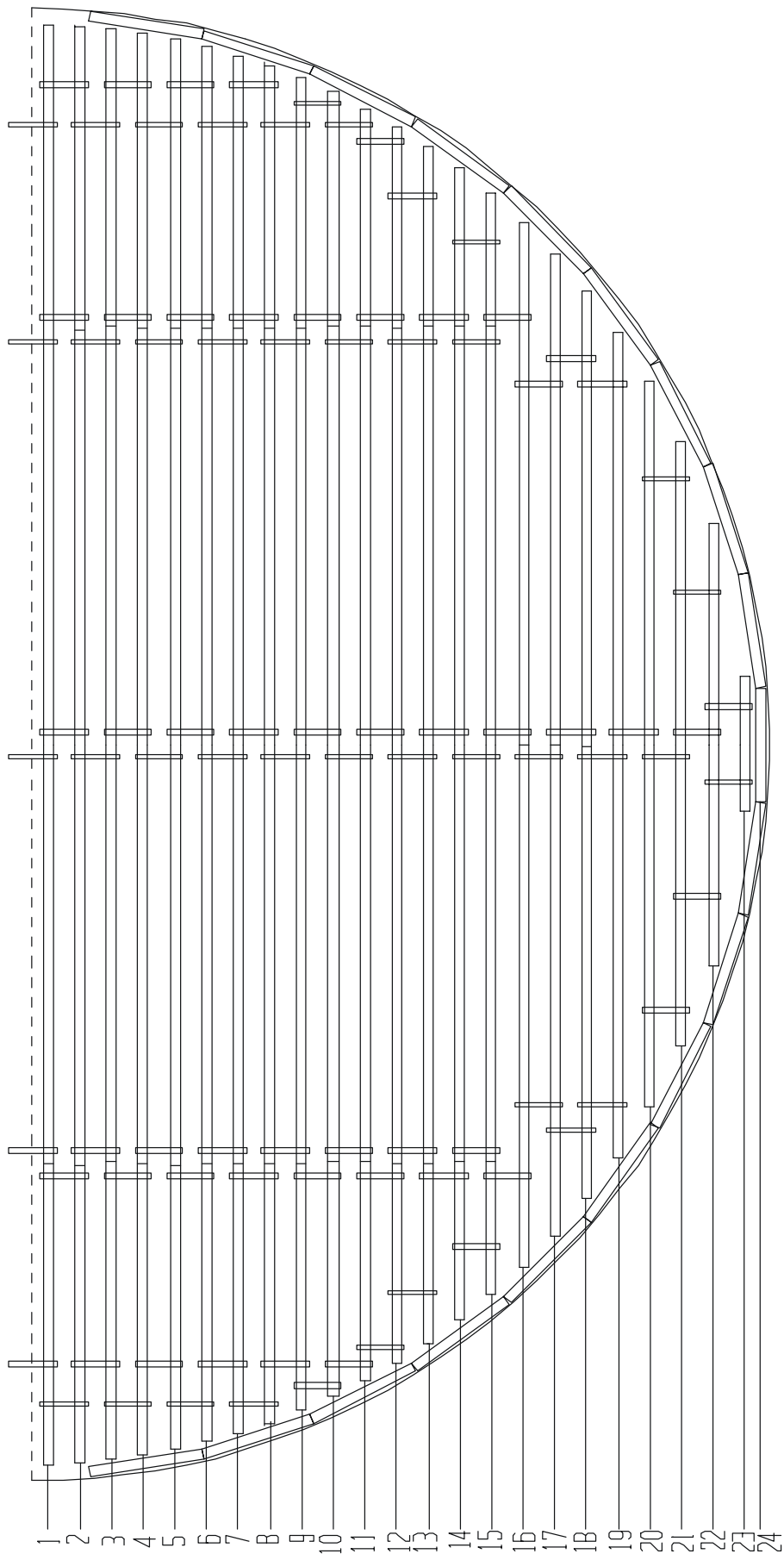
39' DIAMETER CORRUGATED FLOOR



39' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	95.0	264.0	95.0
2	94.0	264.0	94.0
3	94.0	264.0	94.0
4	92.0	264.0	92.0
5	90.0	264.0	90.0
6	88.0	264.0	88.0
7	85.0	264.0	85.0
8	82.0	264.0	82.0
9	78.0	264.0	78.0
10	74.0	264.0	74.0
11	69.0	264.0	69.0
12	63.0	264.0	63.0
13	57.0	264.0	57.0
14	50.0	264.0	50.0
15	42.0	264.0	42.0
16	165.0	165.0	--
17	155.0	155.0	--
18	143.0	143.0	--
19	260.0	--	--
20	229.0	--	--
21	190.0	--	--
22	139.0	--	--
23	42.0	--	--
24	36.0	--	--

39' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 40 PIECES AROUND THE OUTSIDE OF BIN

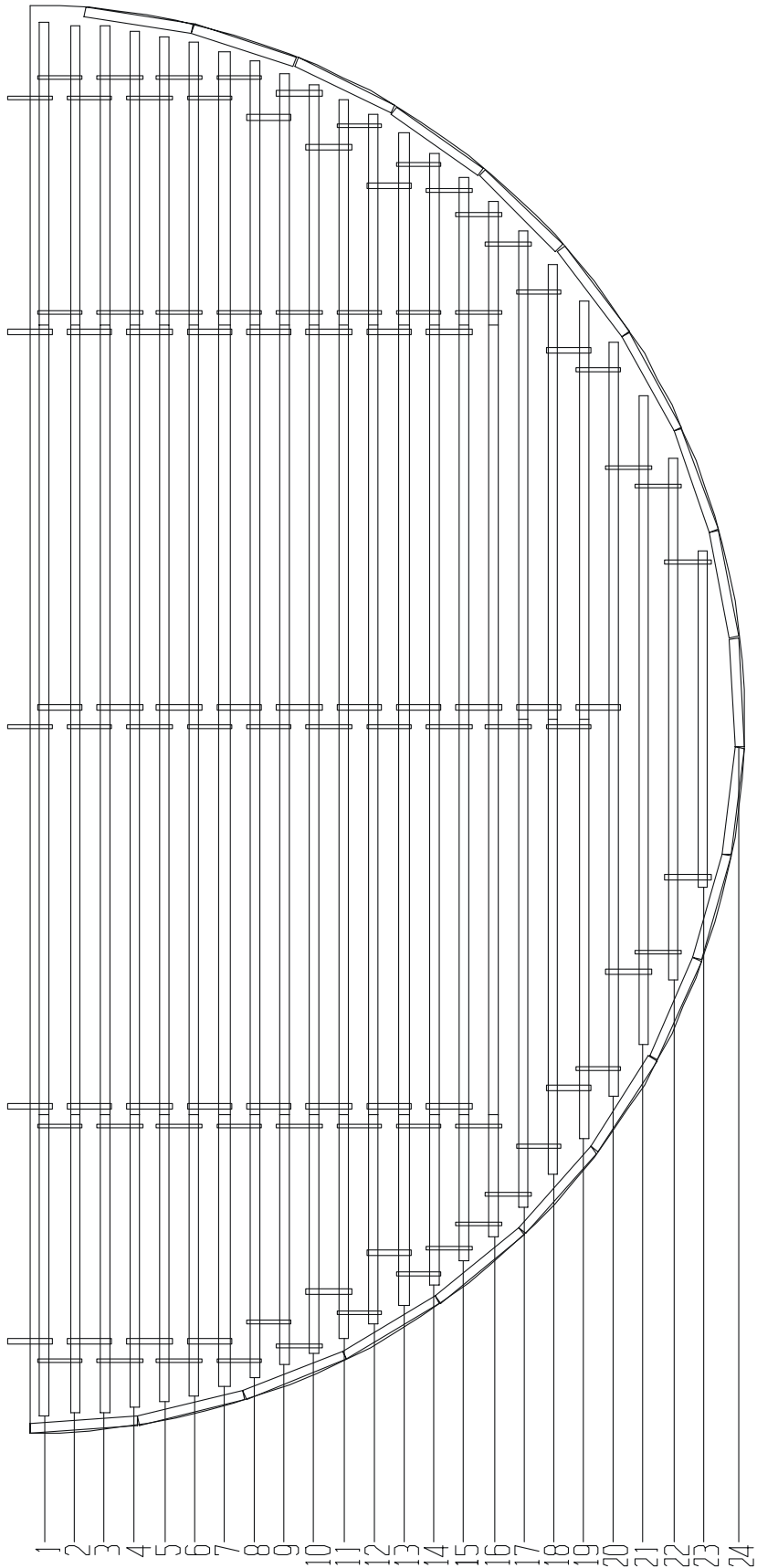


40' BIN FLOOR LAYOUTS

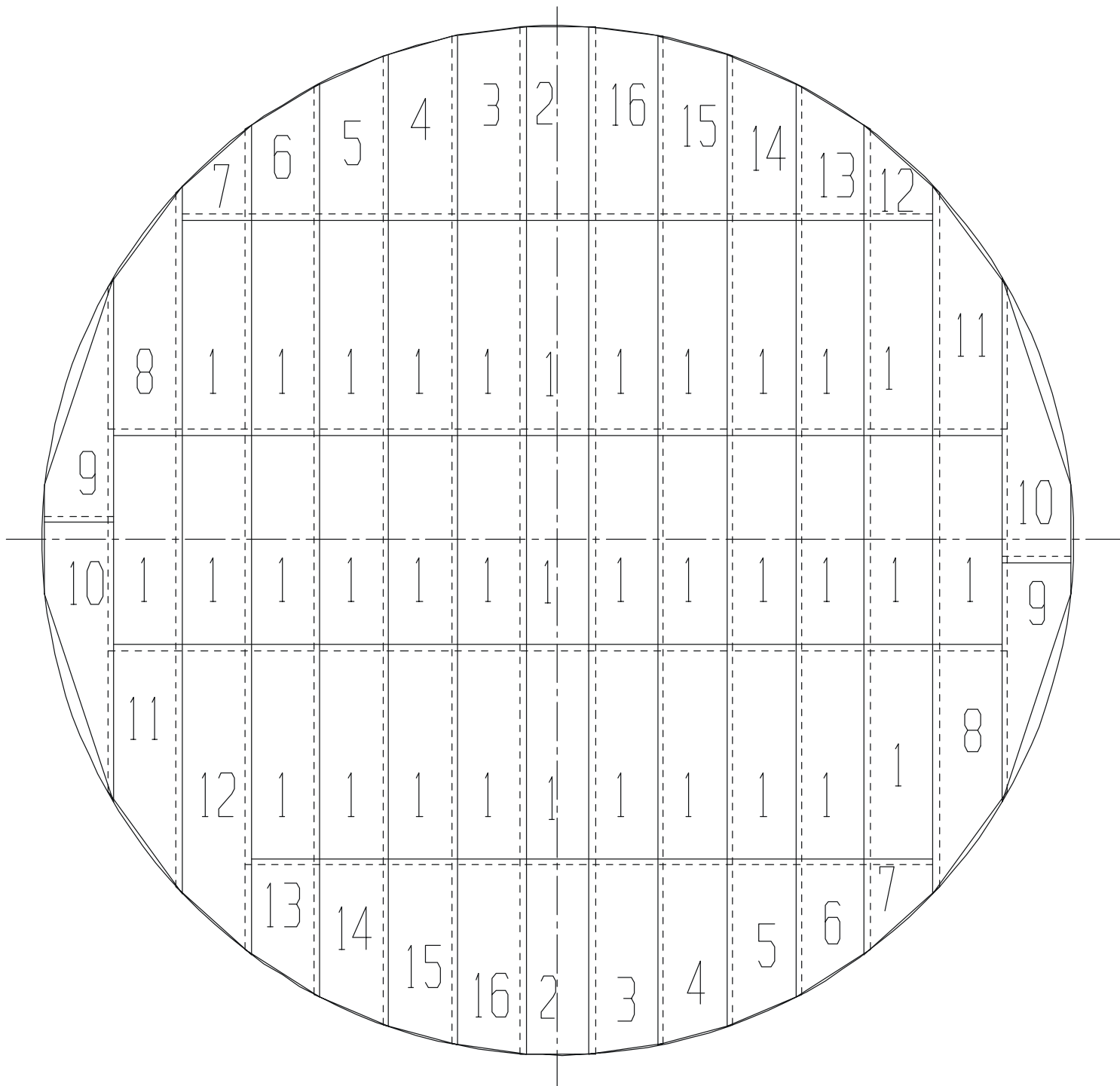
40' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	101.0	264.0	101.0
2	100.0	264.0	100.0
3	100.0	264.0	100.0
4	98.0	264.0	98.0
5	96.0	264.0	96.0
6	94.0	264.0	94.0
7	91.0	264.0	91.0
8	88.0	264.0	88.0
9	84.0	264.0	84.0
10	80.0	264.0	80.0
11	75.0	264.0	75.0
12	70.0	264.0	70.0
13	64.0	264.0	64.0
14	57.0	264.0	57.0
15	49.0	264.0	49.0
16	41.0	264.0	41.0
17	163.0	163.0	--
18	152.0	152.0	--
19	140.0	140.0	--
20	252.0	--	--
21	217.0	--	--
22	174.0	--	--
23	113.0	--	--
24	36.0	--	--
25		--	--

40' DIAMETER - MONORAIL - 10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 41 PIECES AROUND THE OUTSIDE OF BIN

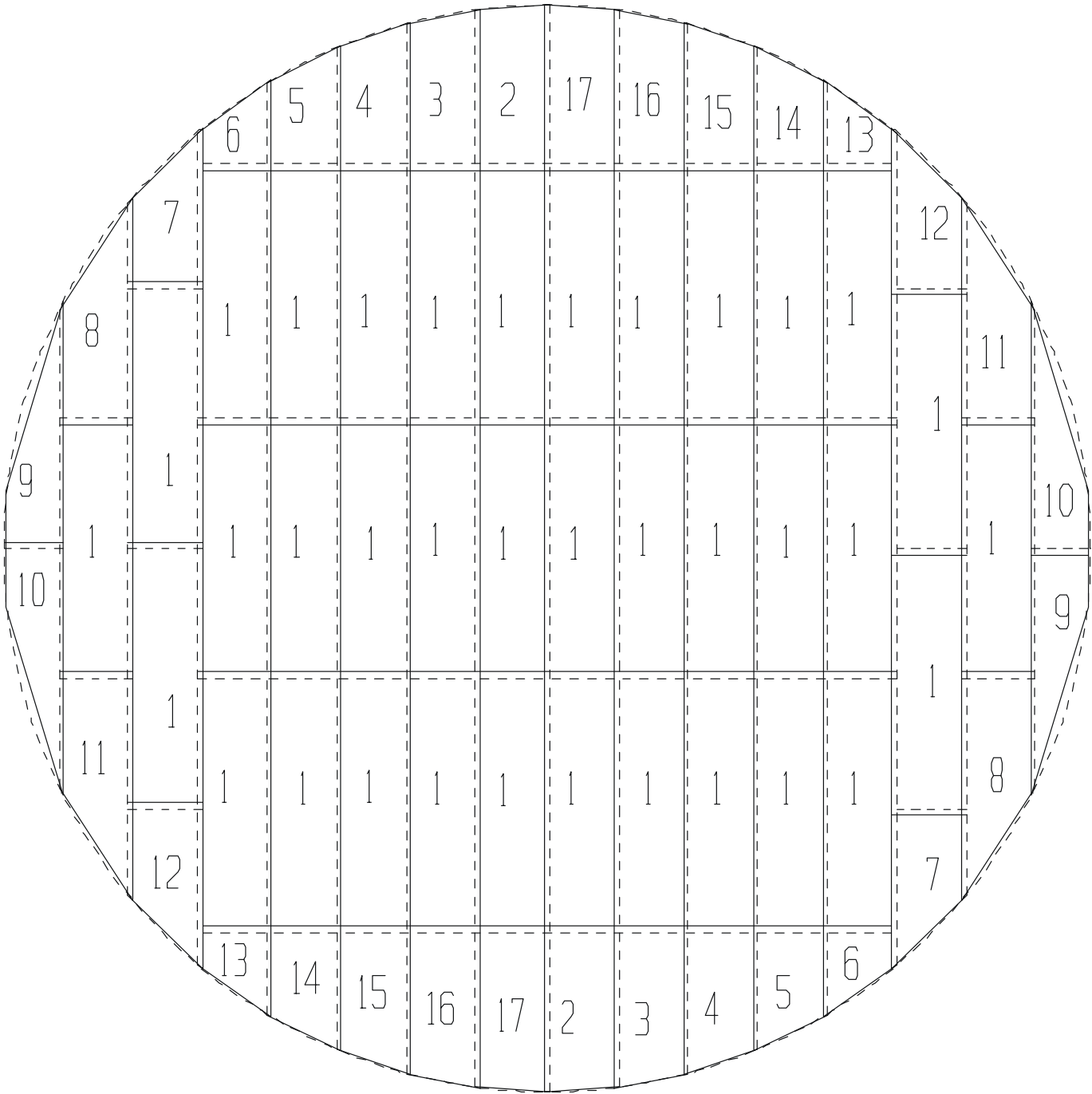


40' CORRUGATED FLOOR



42' BIN FLOOR LAYOUTS

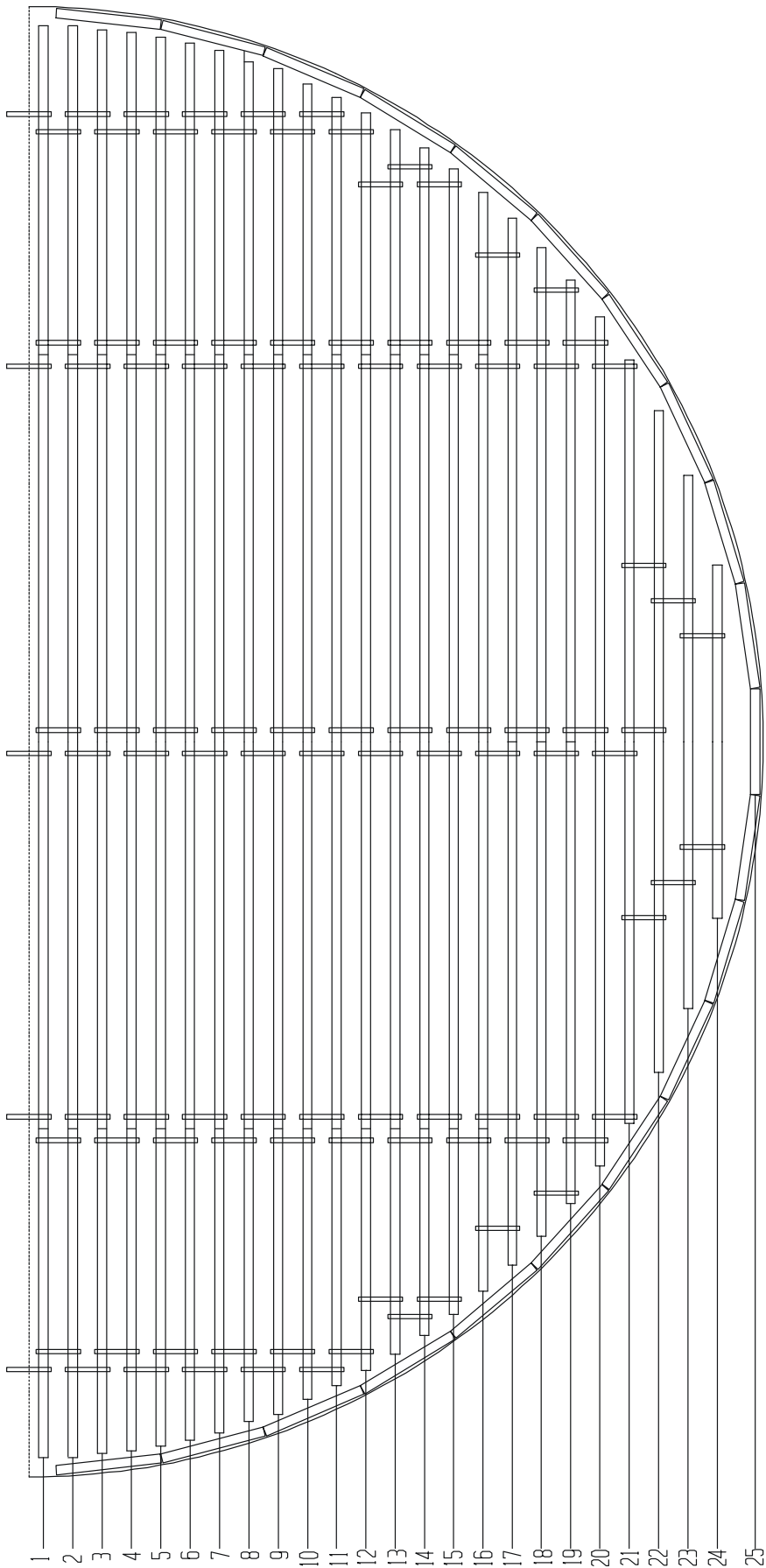
42' DIAMETER CORRUGATED FLOOR



42' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	101.0	264.0	101.0
2	100.0	264.0	100.0
3	100.0	264.0	100.0
4	98.0	264.0	98.0
5	96.0	264.0	96.0
6	94.0	264.0	94.0
7	91.0	264.0	91.0
8	88.0	264.0	88.0
9	84.0	264.0	84.0
10	80.0	264.0	80.0
11	75.0	264.0	75.0
12	70.0	264.0	70.0
13	64.0	264.0	64.0
14	57.0	264.0	57.0
15	49.0	264.0	49.0
16	41.0	264.0	41.0
17	163.0	163.0	--
18	152.0	152.0	--
19	140.0	140.0	--
20	252.0	--	--
21	217.0	--	--
22	174.0	--	--
23	113.0	--	--
24	36.0	--	--
25		--	--

42' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 43 PIECES AROUND THE OUTSIDE OF BIN

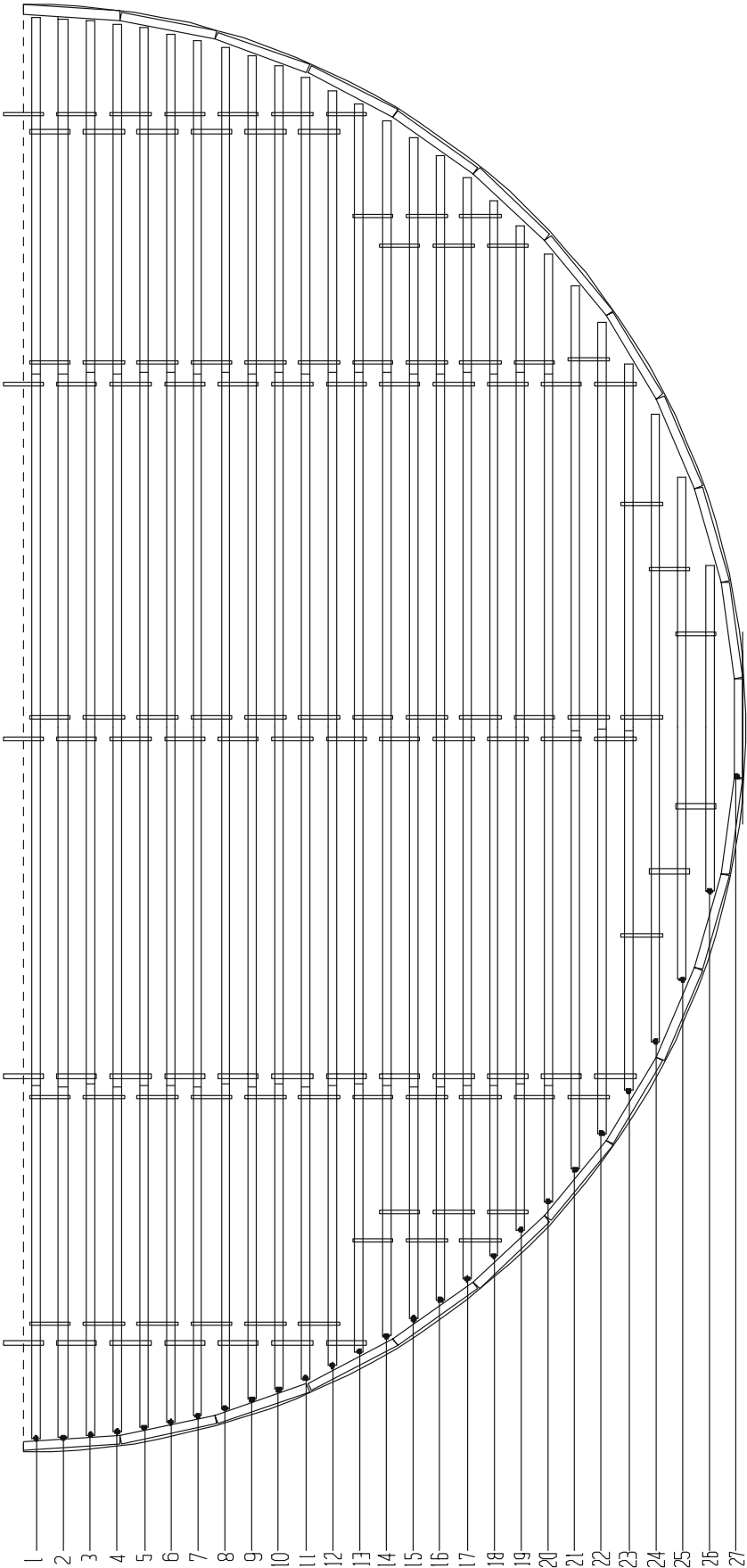


45' BIN FLOOR LAYOUTS

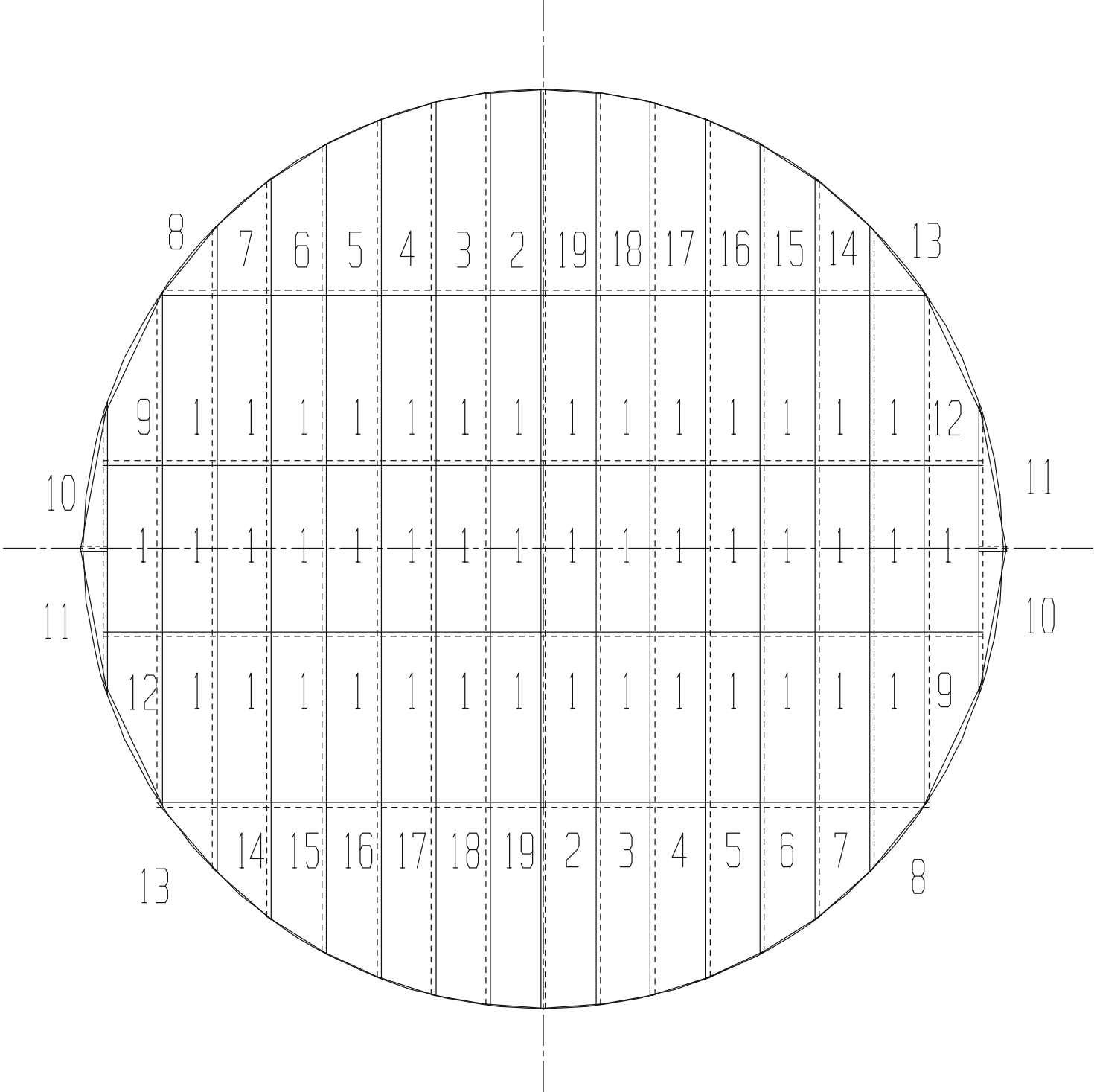
45' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	131.0	264.0	131.0
2	130.0	264.0	130.0
3	130.0	264.0	130.0
4	128.0	264.0	128.0
5	127.0	264.0	127.0
6	125.0	264.0	125.0
7	122.0	264.0	122.0
8	120.0	264.0	120.0
9	116.0	264.0	116.0
10	113.0	264.0	113.0
11	108.0	264.0	108.0
12	104.0	264.0	104.0
13	99.0	264.0	99.0
14	93.0	264.0	93.0
15	86.0	264.0	86.0
16	79.0	264.0	79.0
17	72.0	264.0	72.0
18	63.0	264.0	63.0
19	54.0	264.0	54.0
20	43.0	264.0	43.0
21	163.0	163.0	--
22	150.0	150.0	--
23	134.0	134.0	--
24	231.0	--	--
25	185.0	--	--
26	119.0	--	--
27	36.0	--	--

45' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 46 PIECES AROUND THE OUTSIDE OF BIN

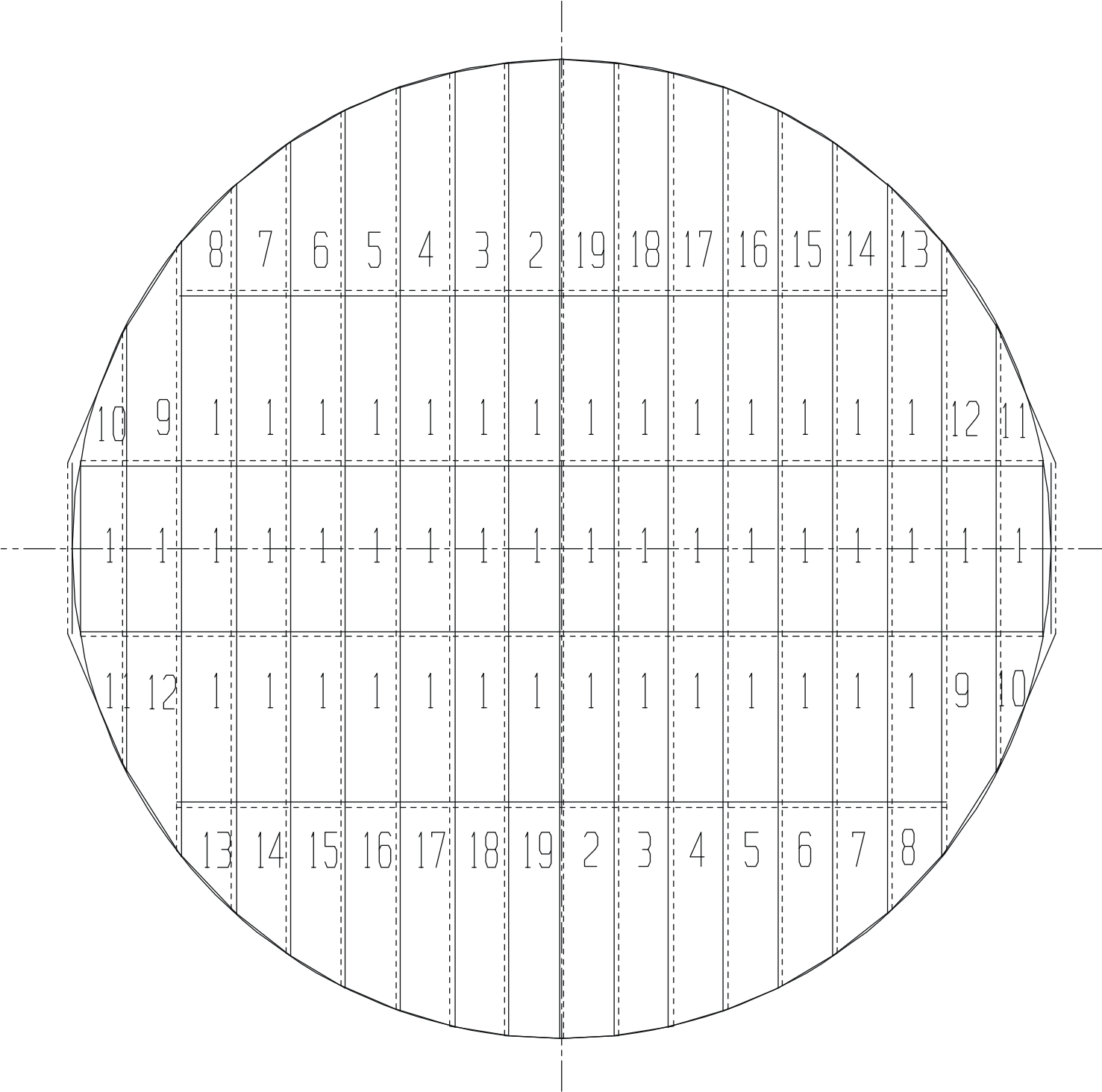


45' CORRUGATED FLOOR



48' BIN FLOOR LAYOUTS

48' CORRUGATED FLOOR



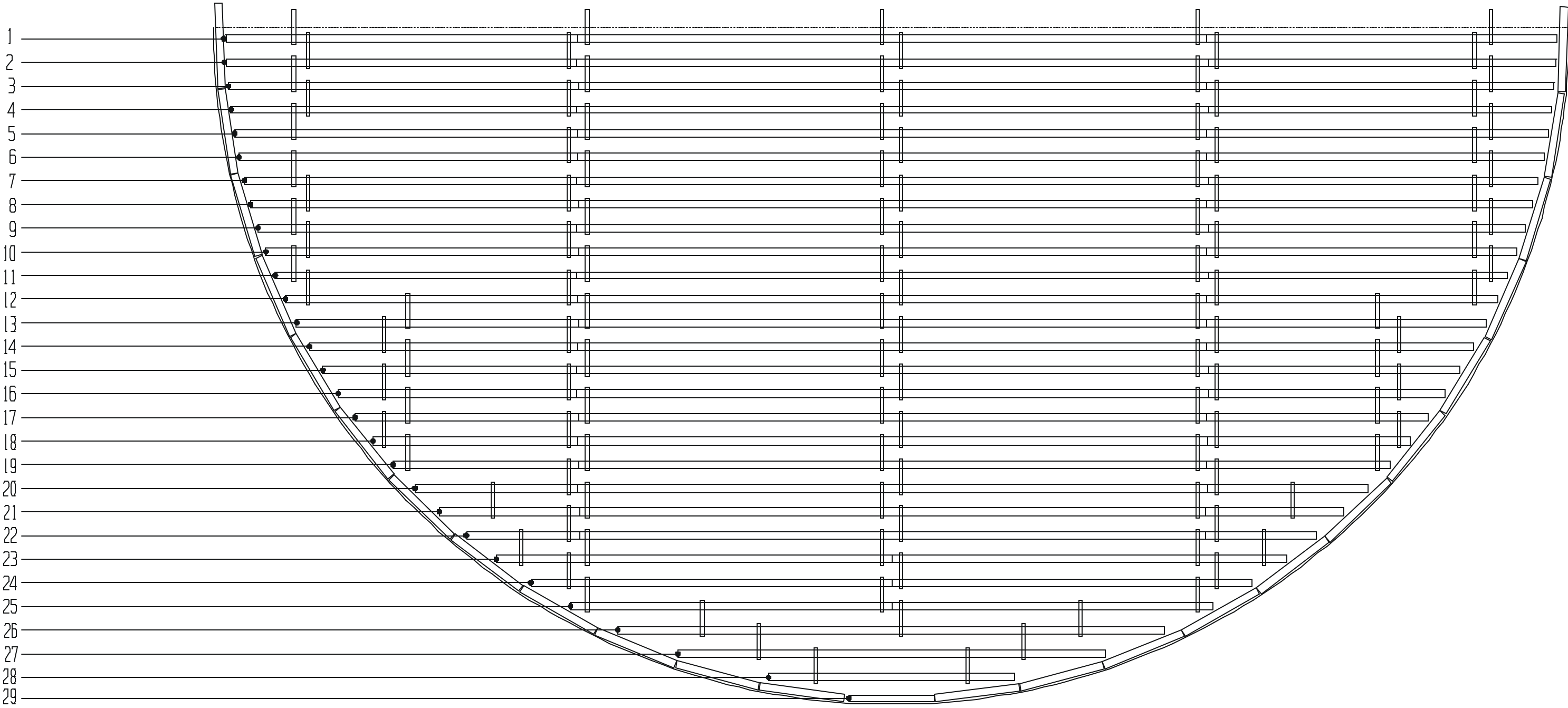
48' Diameter Monorail Lengths			
Monorail Number	Sec 1.	Sec 2.	Sec 3.
1	149.0	264.0	149.0
2	148.0	264.0	148.0
3	148.0	264.0	148.0
4	147.0	264.0	147.0
5	145.0	264.0	145.0
6	143.0	264.0	143.0
7	141.0	264.0	141.0
8	138.0	264.0	138.0
9	135.0	264.0	135.0
10	132.0	264.0	132.0
11	128.0	264.0	128.0
12	124.0	264.0	124.0
13	119.0	264.0	119.0
14	114.0	264.0	114.0
15	108.0	264.0	108.0
16	101.0	264.0	101.0
17	94.0	264.0	94.0
18	87.0	264.0	87.0
19	78.0	264.0	78.0
20	69.0	264.0	69.0
21	59.0	264.0	59.0
22	47.0	264.0	47.0
23	166.0	166.0	--
24	152.0	152.0	--
25	135.0	135.0	--
26	231.0	--	--
27	180.0	--	--
28	104.0	--	--
29	36.0	--	--

48' DIAMETER-MONORAIL-10" SPACING

* MONORAIL LEGS NOT SHOWN

* DIMENSIONS IN INCHES

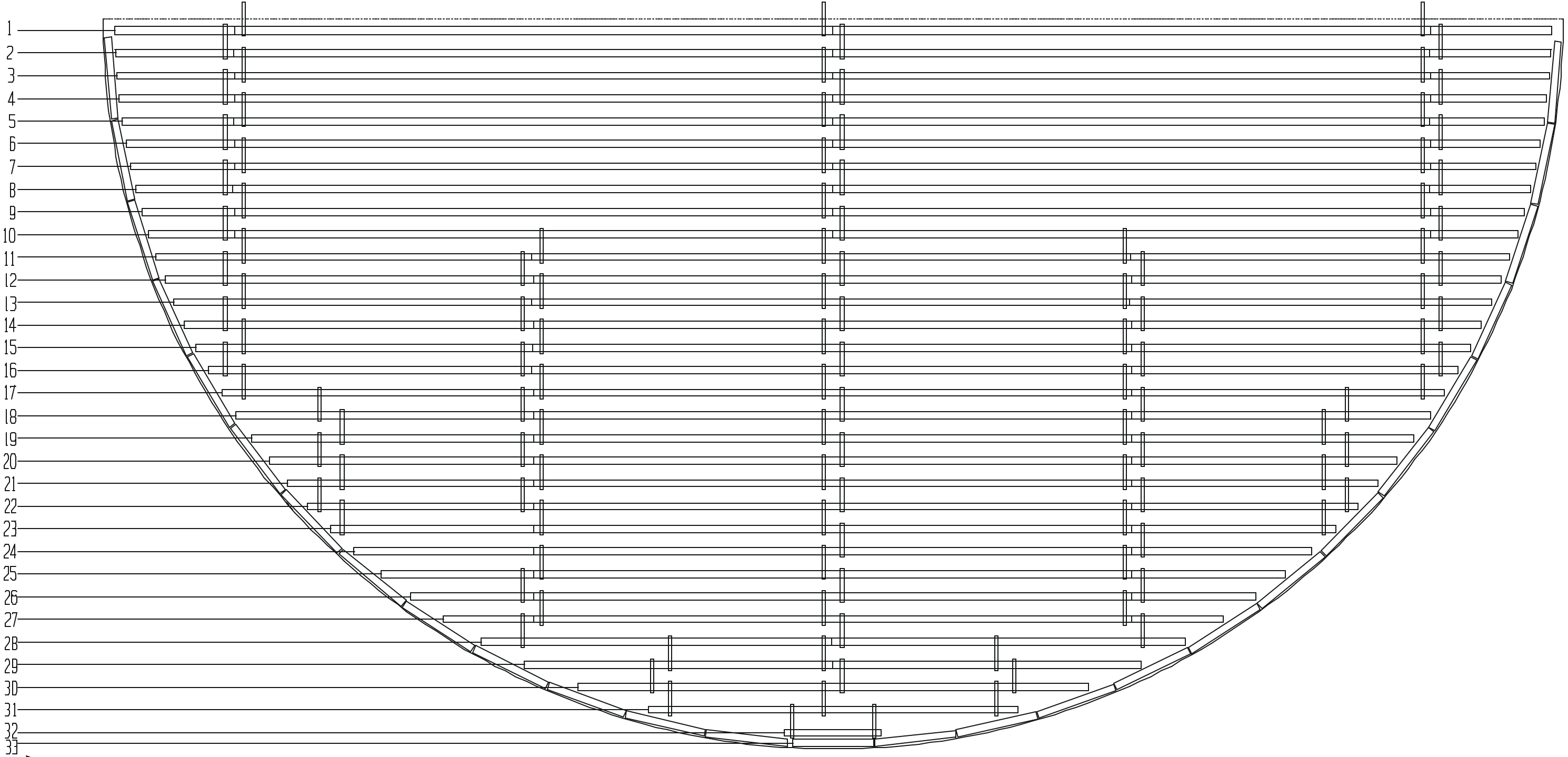
* 49 PIECES AROUND THE OUTSIDE OF BIN



54' BIN FLOOR LAYOUTS

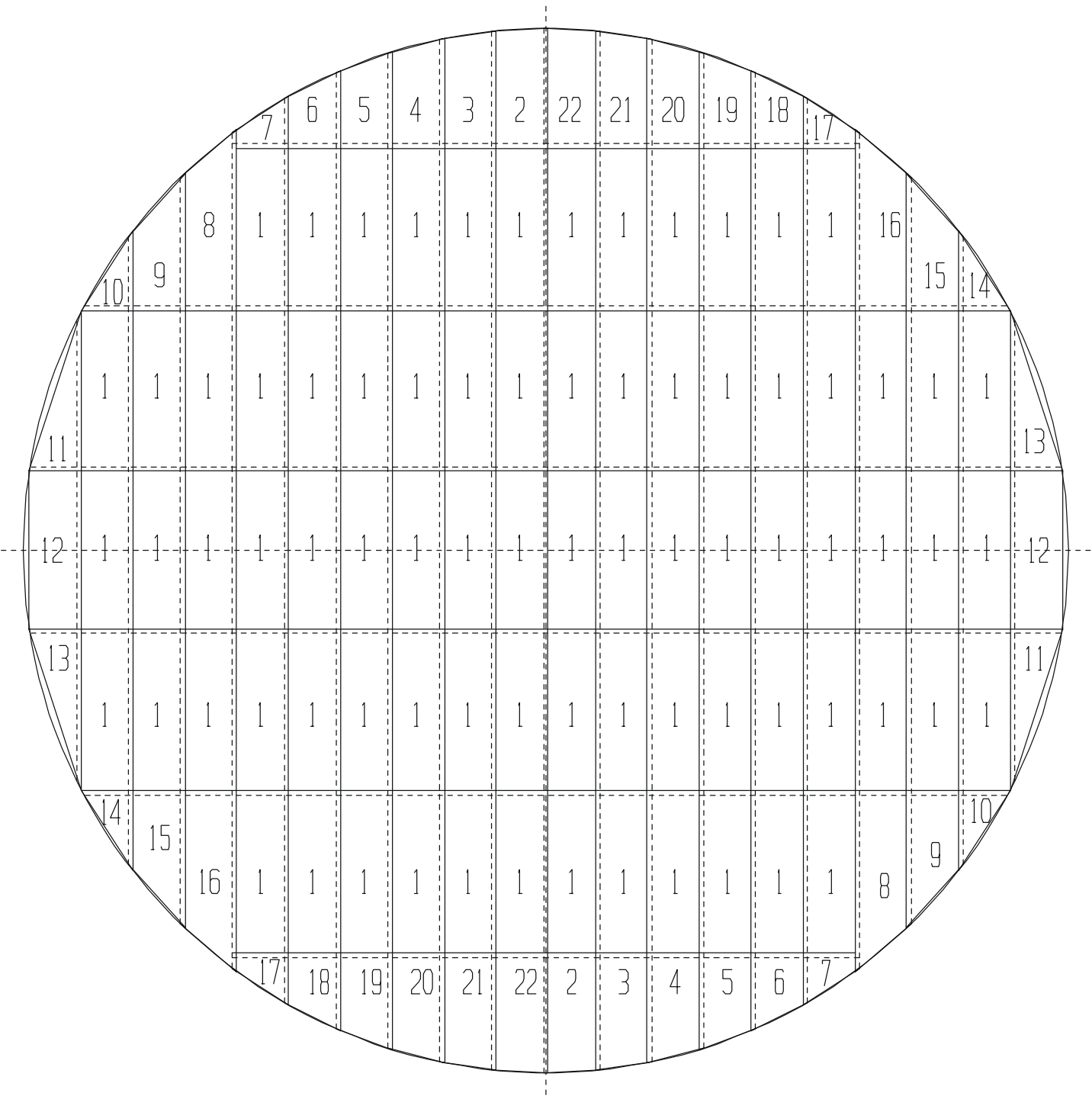
54' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 55 PIECES AROUND THE OUTSIDE OF BIN

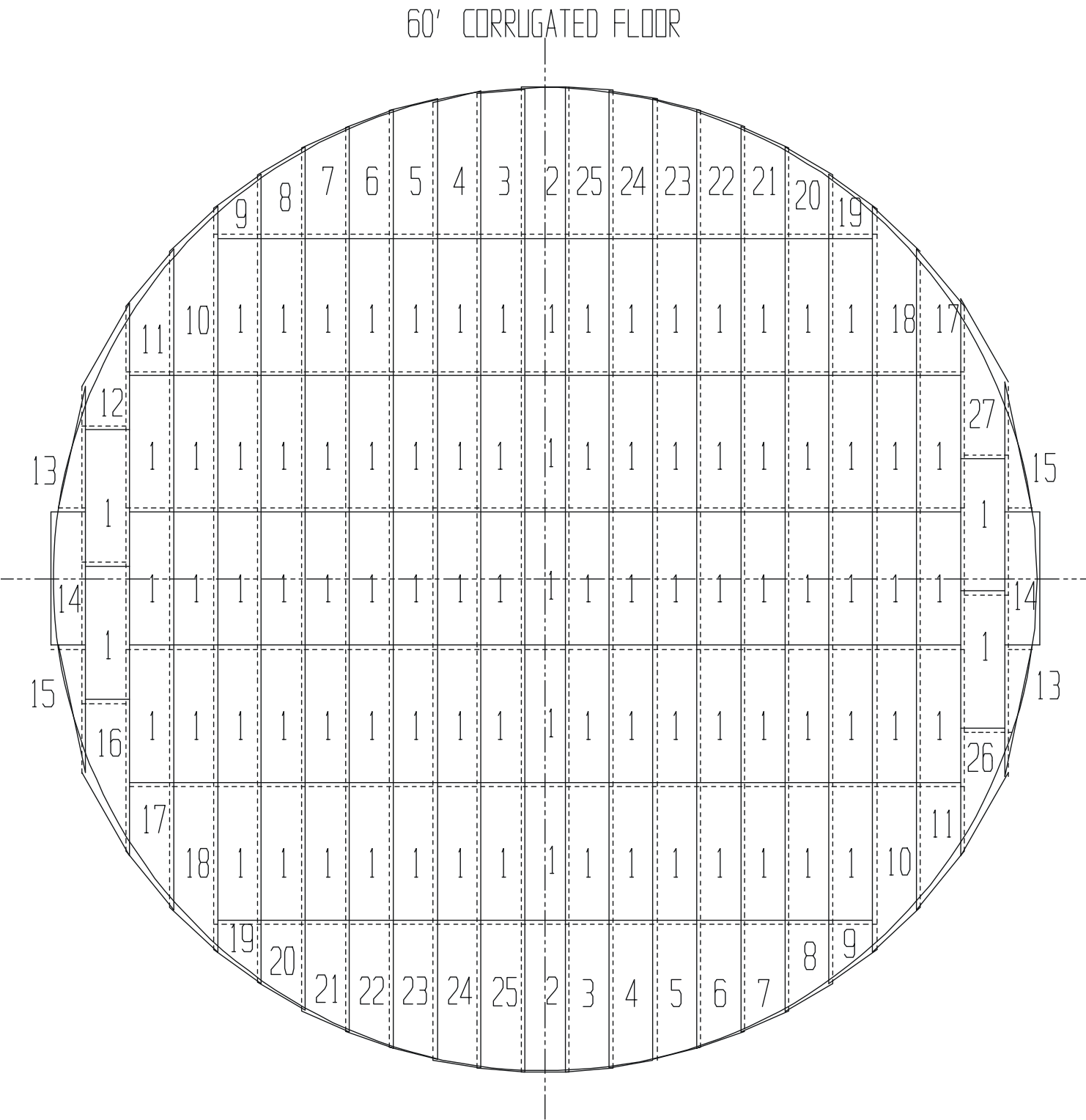


54' Diameter Monorail Lengths				
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.
1	53.0	264.0	264.0	53.0
2	52.0	264.0	264.0	52.0
3	52.0	264.0	264.0	52.0
4	51.0	264.0	264.0	51.0
5	49.0	264.0	264.0	49.0
6	48.0	264.0	264.0	48.0
7	46.0	264.0	264.0	46.0
8	43.0	264.0	264.0	43.0
9	41.0	264.0	264.0	41.0
10	38.0	264.0	264.0	38.0
11	166.0	264.0	166.0	--
12	163.0	264.0	163.0	--
13	158.0	264.0	158.0	--
14	154.0	264.0	154.0	--
15	149.0	264.0	149.0	--
16	143.0	264.0	143.0	--
17	138.0	264.0	138.0	--
18	131.0	264.0	131.0	--
19	124.0	264.0	124.0	--
20	117.0	264.0	117.0	--
21	108.0	264.0	108.0	--
22	99.0	264.0	99.0	--
23	90.0	264.0	90.0	--
24	79.0	264.0	79.0	--
25	67.0	264.0	67.0	--
26	54.0	264.0	54.0	--
27	40.0	264.0	40.0	--
28	155.0	155.0	--	--
29	136.0	136.0	--	--
30	225.0	--	--	--
31	163.0	--	--	--
32	42.0	--	--	--
33	36.0	--	--	--

54' DIAMETER CORRUGATED FLOOR



60' BIN FLOOR LAYOUTS



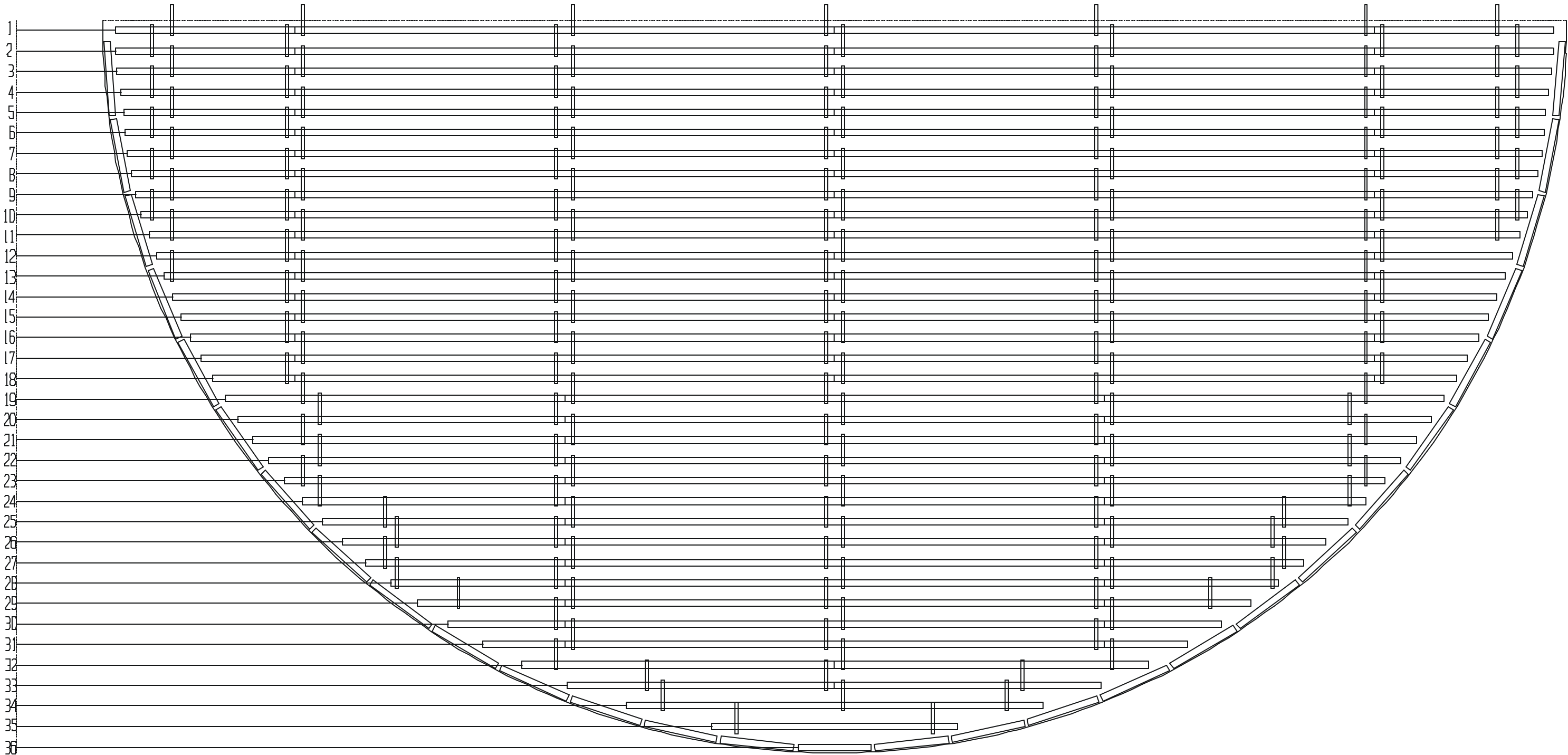
60' Diameter Monorail Lengths				
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.
1	89.0	264.0	264.0	89.0
2	88.0	264.0	264.0	88.0
3	88.0	264.0	264.0	88.0
4	87.0	264.0	264.0	87.0
5	86.0	264.0	264.0	86.0
6	84.0	264.0	264.0	84.0
7	82.0	264.0	264.0	82.0
8	80.0	264.0	264.0	80.0
9	78.0	264.0	264.0	78.0
10	75.0	264.0	264.0	75.0
11	72.0	264.0	264.0	72.0
12	69.0	264.0	264.0	69.0
13	65.0	264.0	264.0	65.0
14	61.0	264.0	264.0	61.0
15	57.0	264.0	264.0	57.0
16	52.0	264.0	264.0	52.0
17	47.0	264.0	264.0	47.0
18	41.0	264.0	264.0	41.0
19	167.0	264.0	167.0	--
20	161.0	264.0	161.0	--
21	154.0	264.0	154.0	--
22	146.0	264.0	146.0	--
23	138.0	264.0	138.0	--
24	130.0	264.0	130.0	--
25	120.0	264.0	120.0	--
26	110.0	264.0	110.0	--
27	99.0	264.0	99.0	--
28	87.0	264.0	87.0	--
29	74.0	264.0	74.0	--
30	59.0	264.0	59.0	--
31	43.0	264.0	43.0	--
32	156.0	156.0	--	--
33	134.0	134.0	--	--
34	213.0	--	--	--
35	135.0	--	--	--
36	36.0	--	--	--

60' DIAMETER-MONORAIL-10" SPACING

* MONORAIL LEGS NOT SHOWN

* DIMENSIONS IN INCHES

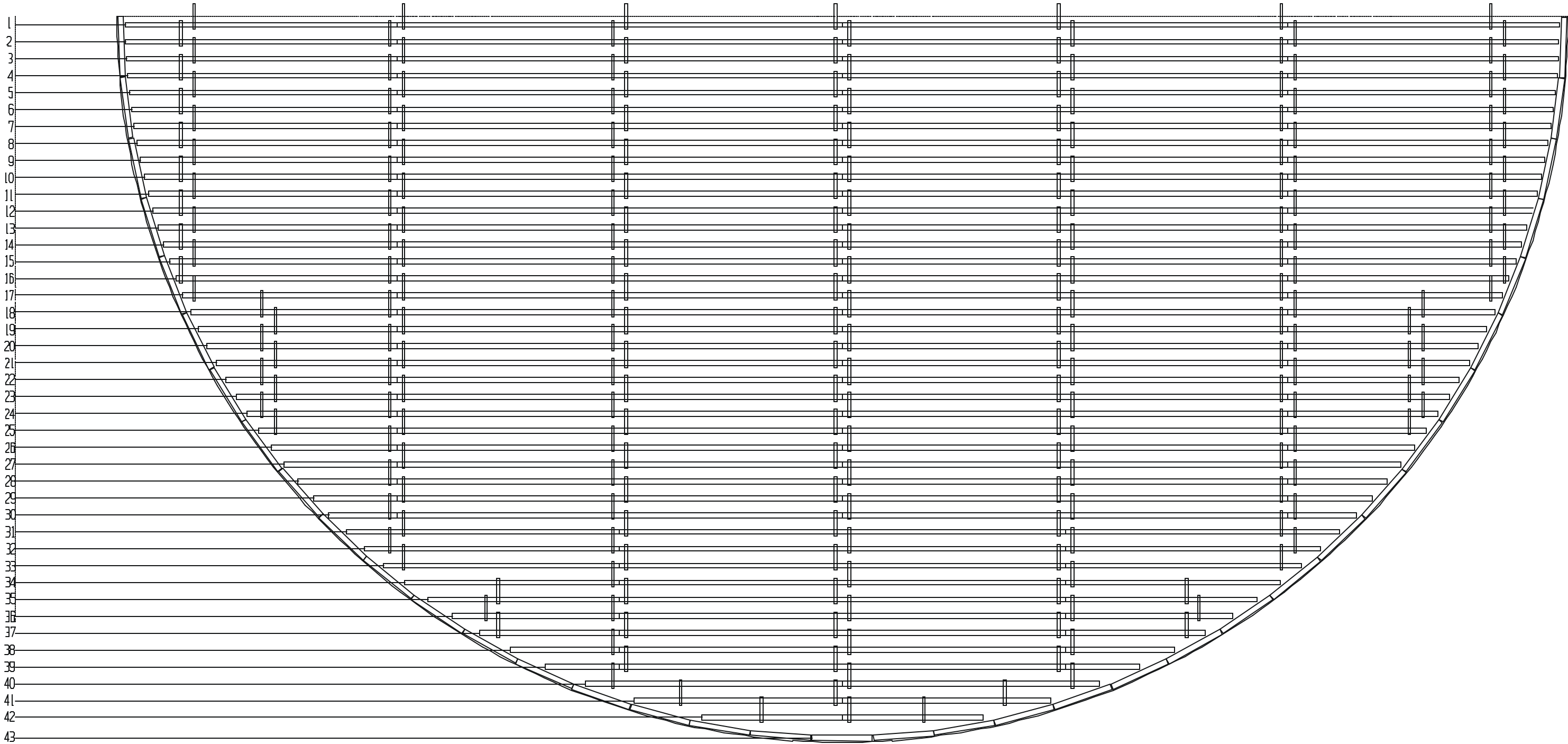
* 59 PIECES AROUND THE OUTSIDE OF BIN



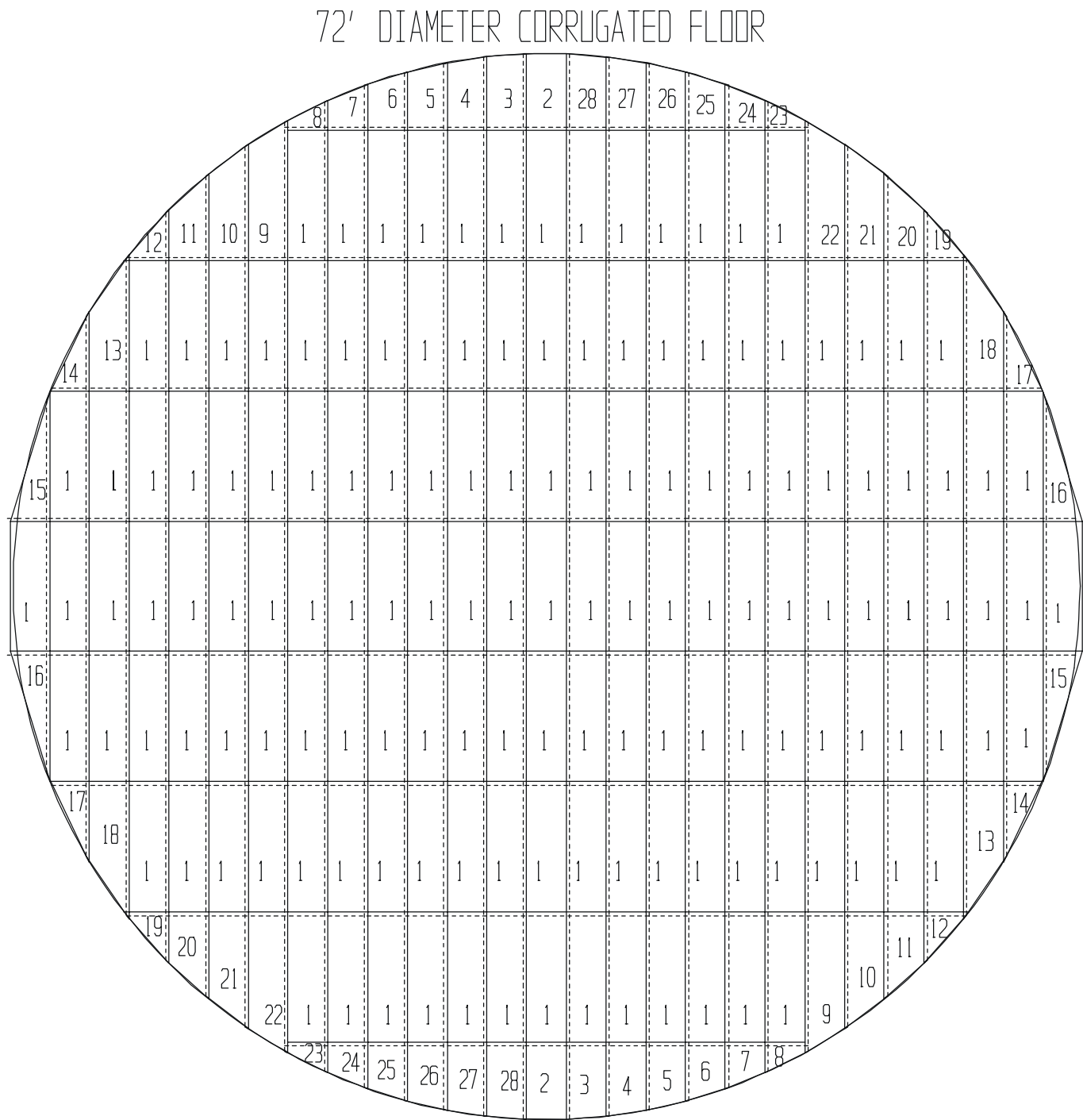
72' BIN FLOOR LAYOUTS

72' DIAMETER-MONORAIL-10' SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 74 PIECES AROUND THE OUTSIDE OF BIN

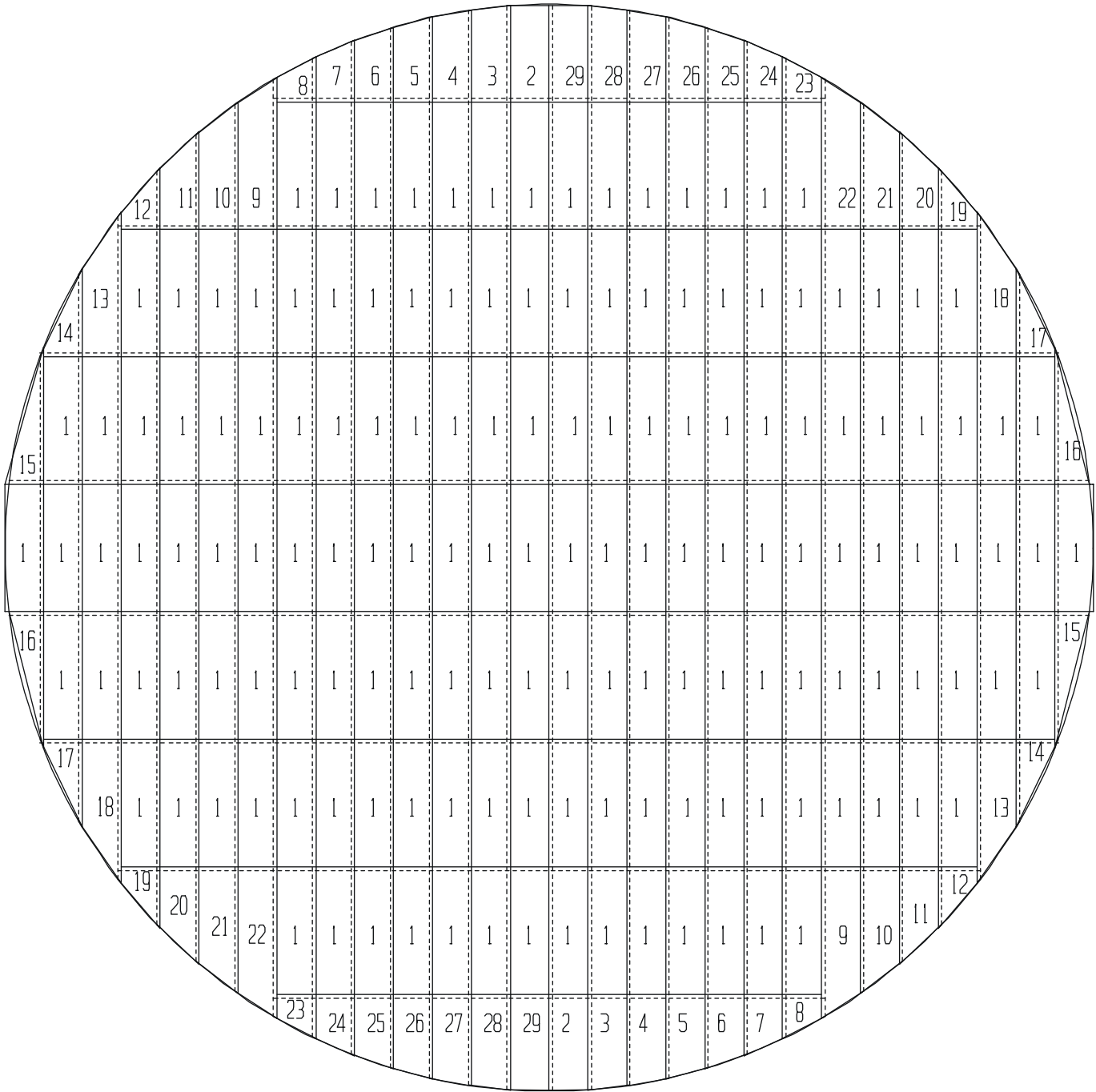


72' Diameter Monorail Lengths				
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.
1	160.0	264.0	264.0	160.0
2	160.0	264.0	264.0	160.0
3	160.0	264.0	264.0	160.0
4	159.0	264.0	264.0	159.0
5	158.0	264.0	264.0	158.0
6	157.0	264.0	264.0	157.0
7	155.0	264.0	264.0	155.0
8	153.0	264.0	264.0	153.0
9	151.0	264.0	264.0	151.0
10	149.0	264.0	264.0	149.0
11	147.0	264.0	264.0	147.0
12	144.0	264.0	264.0	144.0
13	141.0	264.0	264.0	141.0
14	138.0	264.0	264.0	138.0
15	134.0	264.0	264.0	134.0
16	130.0	264.0	264.0	130.0
17	126.0	264.0	264.0	126.0
18	122.0	264.0	264.0	122.0
19	117.0	264.0	264.0	117.0
20	112.0	264.0	264.0	112.0
21	107.0	264.0	264.0	107.0
22	101.0	264.0	264.0	101.0
23	95.0	264.0	264.0	95.0
24	88.0	264.0	264.0	88.0
25	81.0	264.0	264.0	81.0
26	74.0	264.0	264.0	74.0
27	66.0	264.0	264.0	66.0
28	58.0	264.0	264.0	58.0
29	49.0	264.0	264.0	49.0
30	40.0	264.0	264.0	40.0
31	162.0	264.0	162.0	--
32	151.0	264.0	151.0	--
33	139.0	264.0	139.0	--
34	127.0	264.0	127.0	--
35	113.0	264.0	113.0	--
36	98.0	264.0	98.0	--
37	82.0	264.0	82.0	--
38	64.0	264.0	64.0	--
39	44.0	264.0	44.0	--
40	152.0	152.0	--	--
41	246.0	--	--	--
42	166.0	--	--	--
43	36.0	--	--	--



75' BIN FLOOR LAYOUTS

75' DIAMETER CORRUGATED FLOOR



75' Diameter Monorail Lengths					
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.	Sec 5.
1	46.0	264.0	264.0	264.0	46.0
2	46.0	264.0	264.0	264.0	46.0
3	45.0	264.0	264.0	264.0	45.0
4	45.0	264.0	264.0	264.0	45.0
5	44.0	264.0	264.0	264.0	44.0
6	43.0	264.0	264.0	264.0	43.0
7	41.0	264.0	264.0	264.0	41.0
8	40.0	264.0	264.0	264.0	40.0
9	38.0	264.0	264.0	264.0	38.0
10	36.0	264.0	264.0	264.0	36.0
11	165.0	264.0	264.0	165.0	--
12	163.0	264.0	264.0	163.0	--
13	160.0	264.0	264.0	160.0	--
14	157.0	264.0	264.0	157.0	--
15	153.0	264.0	264.0	153.0	--
16	150.0	264.0	264.0	150.0	--
17	146.0	264.0	264.0	146.0	--
18	142.0	264.0	264.0	142.0	--
19	137.0	264.0	264.0	137.0	--
20	132.0	264.0	264.0	132.0	--
21	127.0	264.0	264.0	127.0	--
22	122.0	264.0	264.0	122.0	--
23	116.0	264.0	264.0	116.0	--
24	110.0	264.0	264.0	110.0	--
25	103.0	264.0	264.0	103.0	--
26	96.0	264.0	264.0	96.0	--
27	89.0	264.0	264.0	89.0	--
28	81.0	264.0	264.0	81.0	--
29	73.0	264.0	264.0	73.0	--
30	64.0	264.0	264.0	64.0	--
31	55.0	264.0	264.0	55.0	--
32	45.0	264.0	264.0	45.0	--
33	166.0	264.0	166.0	--	--
34	155.0	264.0	155.0	--	--
35	143.0	264.0	143.0	--	--
36	130.0	264.0	130.0	--	--
37	116.0	264.0	116.0	--	--
38	100.0	264.0	100.0	--	--
39	83.0	264.0	83.0	--	--
40	64.0	264.0	64.0	--	--
41	43.0	264.0	43.0	--	--
42	150.0	150.0	--	--	--
43	237.0	--	--	--	--
44	147.0	--	--	--	--
45	36.0	--	--	--	--

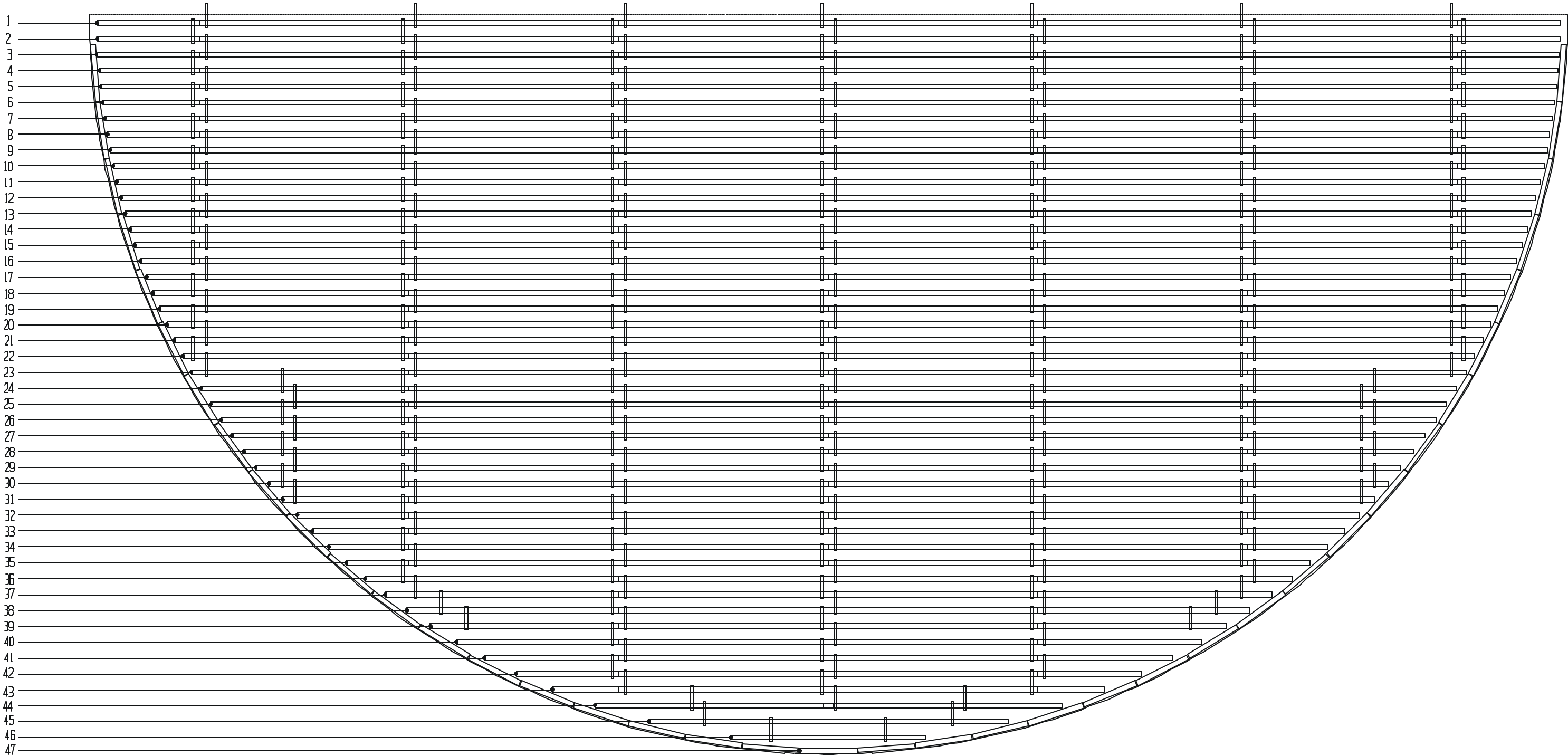
* 77 PIECES AROUND THE OUTSIDE OF BIN



78' BIN FLOOR LAYOUTS

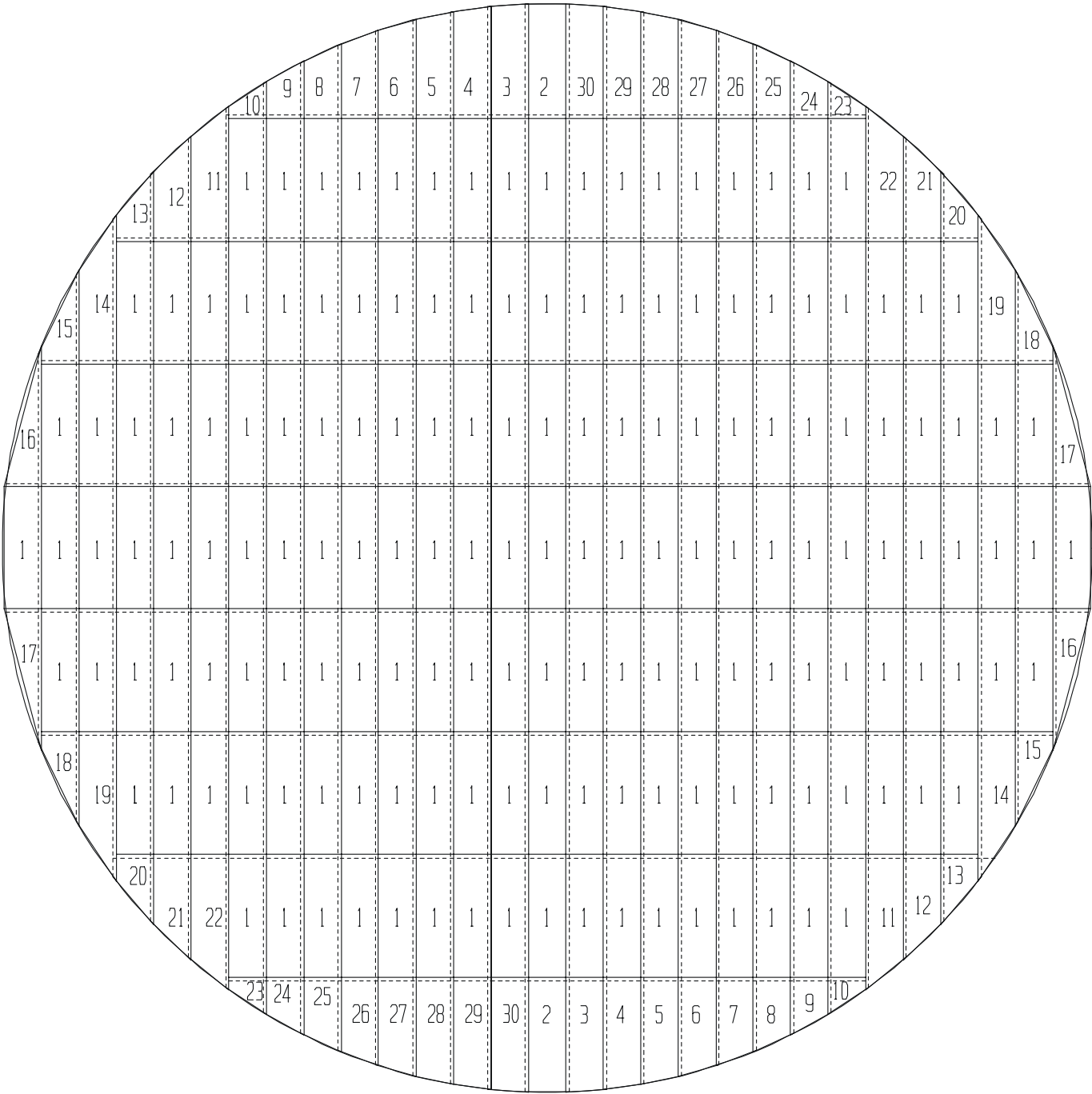
78' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 80 PIECES AROUND THE OUTSIDE OF BIN



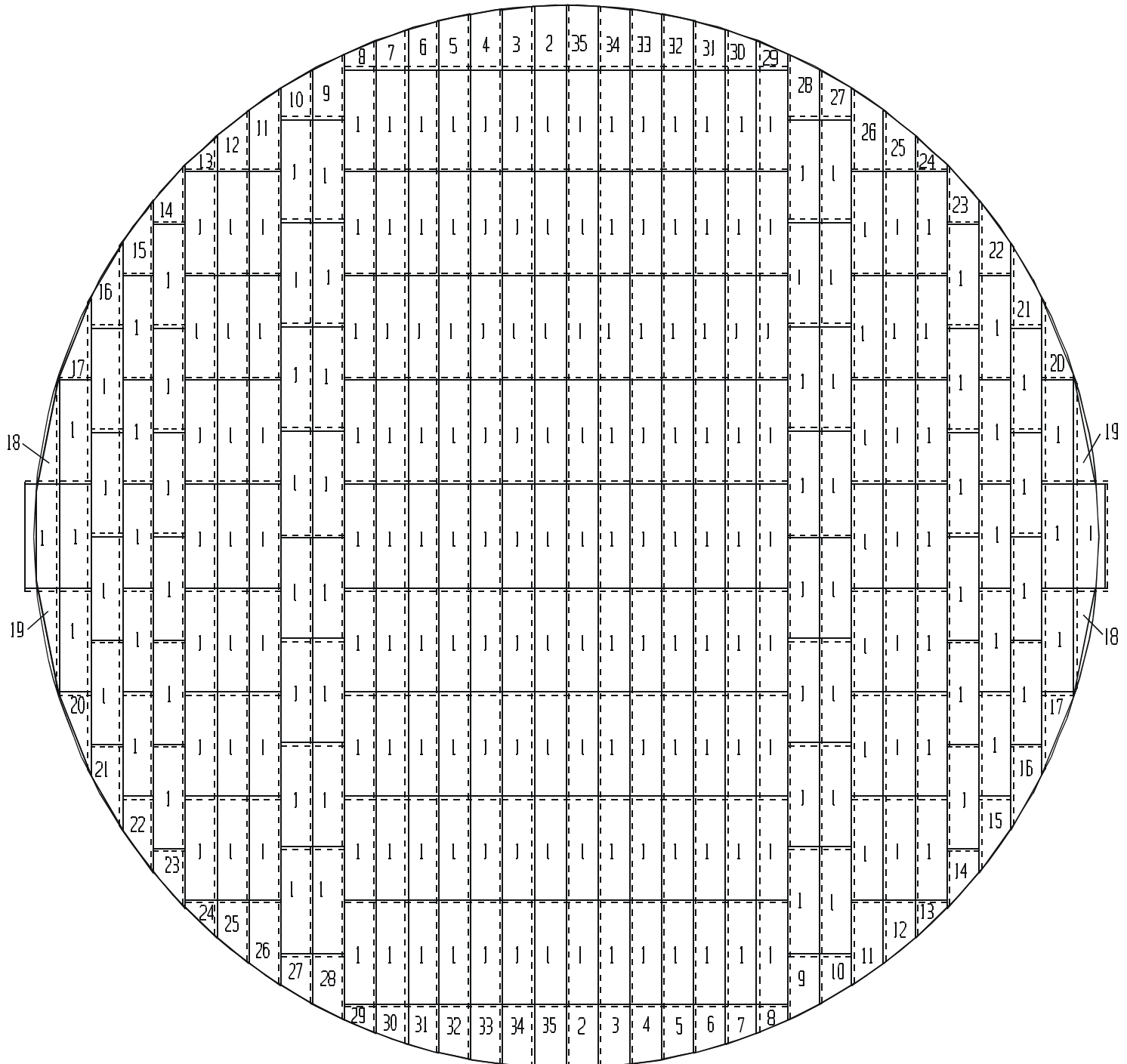
78' Diameter Monorail Lengths					
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.	Sec 5.
1	64.0	264.0	264.0	264.0	64.0
2	64.0	264.0	264.0	264.0	64.0
3	63.0	264.0	264.0	264.0	63.0
4	63.0	264.0	264.0	264.0	63.0
5	62.0	264.0	264.0	264.0	62.0
6	61.0	264.0	264.0	264.0	61.0
7	59.0	264.0	264.0	264.0	59.0
8	58.0	264.0	264.0	264.0	58.0
9	56.0	264.0	264.0	264.0	56.0
10	54.0	264.0	264.0	264.0	54.0
11	52.0	264.0	264.0	264.0	52.0
12	49.0	264.0	264.0	264.0	49.0
13	46.0	264.0	264.0	264.0	46.0
14	43.0	264.0	264.0	264.0	43.0
15	40.0	264.0	264.0	264.0	40.0
16	37.0	264.0	264.0	264.0	37.0
17	165.0	264.0	264.0	165.0	--
18	161.0	264.0	264.0	161.0	--
19	157.0	264.0	264.0	157.0	--
20	152.0	264.0	264.0	152.0	--
21	147.0	264.0	264.0	147.0	--
22	142.0	264.0	264.0	142.0	--
23	137.0	264.0	264.0	137.0	--
24	131.0	264.0	264.0	131.0	--
25	125.0	264.0	264.0	125.0	--
26	118.0	264.0	264.0	118.0	--
27	111.0	264.0	264.0	111.0	--
28	104.0	264.0	264.0	104.0	--
29	96.0	264.0	264.0	96.0	--
30	88.0	264.0	264.0	88.0	--
31	79.0	264.0	264.0	79.0	--
32	70.0	264.0	264.0	70.0	--
33	60.0	264.0	264.0	60.0	--
34	50.0	264.0	264.0	50.0	--
35	39.0	264.0	264.0	39.0	--
36	159.0	264.0	159.0	--	--
37	147.0	264.0	147.0	--	--
38	133.0	264.0	133.0	--	--
39	118.0	264.0	118.0	--	--
40	102.0	264.0	102.0	--	--
41	84.0	264.0	84.0	--	--
42	64.0	264.0	64.0	--	--
43	41.0	264.0	41.0	--	--
44	147.0	147.0	--	--	--
45	226.0	--	--	--	--
46	122.0	--	--	--	--
47	36.0				

78' DIAMETER CORRUGATED FLOOR



90' BIN FLOOR LAYOUTS

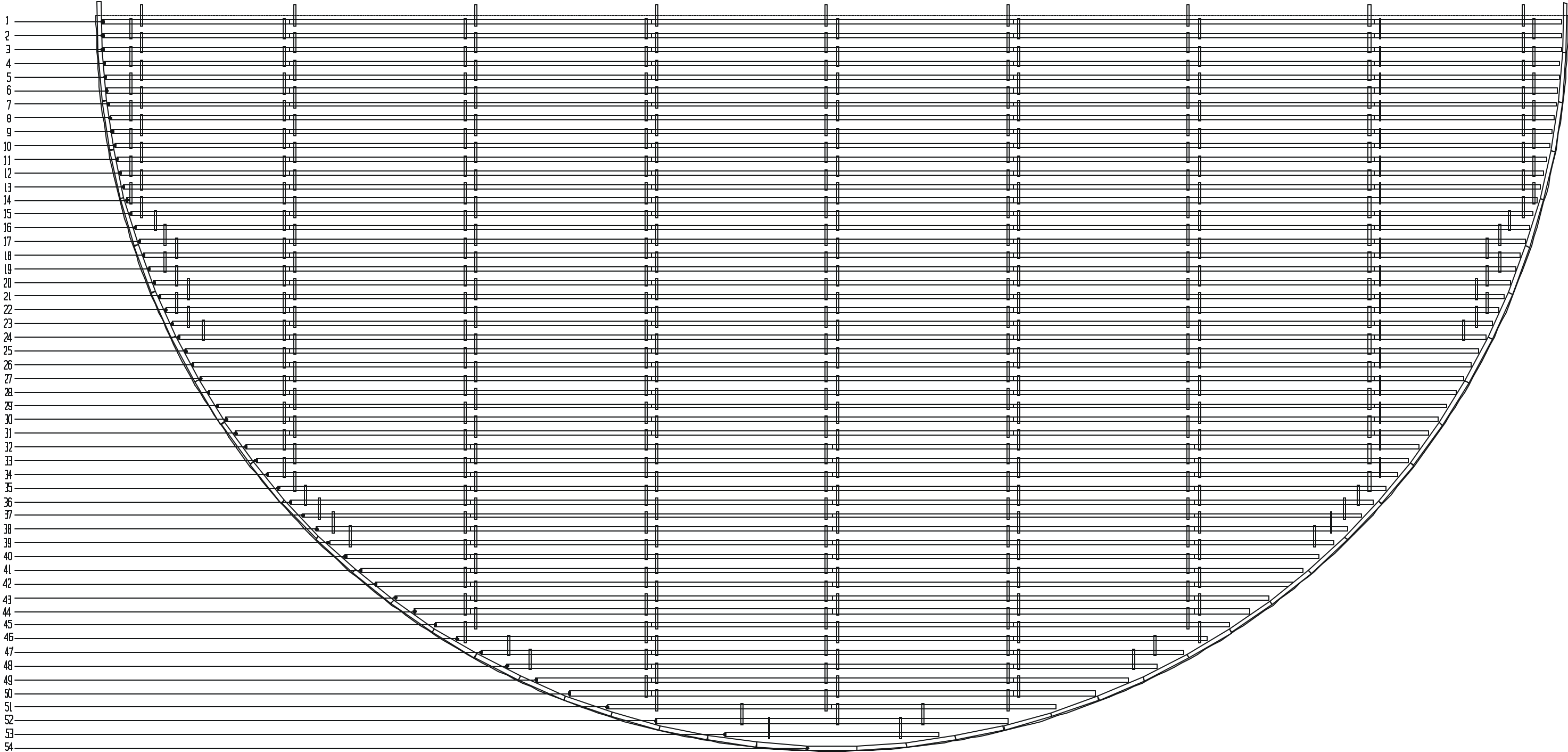
90' DIAMETER CORRUGATED FLOOR



90' Diameter Monorail Lengths					
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.	Sec 5.
1	136.0	264.0	264.0	264.0	136.0
2	136.0	264.0	264.0	264.0	136.0
3	135.0	264.0	264.0	264.0	135.0
4	135.0	264.0	264.0	264.0	135.0
5	134.0	264.0	264.0	264.0	134.0
6	133.0	264.0	264.0	264.0	133.0
7	132.0	264.0	264.0	264.0	132.0
8	130.0	264.0	264.0	264.0	130.0
9	129.0	264.0	264.0	264.0	129.0
10	127.0	264.0	264.0	264.0	127.0
11	125.0	264.0	264.0	264.0	125.0
12	123.0	264.0	264.0	264.0	123.0
13	121.0	264.0	264.0	264.0	121.0
14	118.0	264.0	264.0	264.0	118.0
15	115.0	264.0	264.0	264.0	115.0
16	112.0	264.0	264.0	264.0	112.0
17	109.0	264.0	264.0	264.0	109.0
18	106.0	264.0	264.0	264.0	106.0
19	102.0	264.0	264.0	264.0	102.0
20	98.0	264.0	264.0	264.0	98.0
21	94.0	264.0	264.0	264.0	94.0
22	90.0	264.0	264.0	264.0	90.0
23	85.0	264.0	264.0	264.0	85.0
24	80.0	264.0	264.0	264.0	80.0
25	75.0	264.0	264.0	264.0	75.0
26	70.0	264.0	264.0	264.0	70.0
27	64.0	264.0	264.0	264.0	64.0
28	58.0	264.0	264.0	264.0	58.0
29	52.0	264.0	264.0	264.0	52.0
30	46.0	264.0	264.0	264.0	46.0
31	39.0	264.0	264.0	264.0	39.0
32	163.0	264.0	264.0	163.0	--
33	156.0	264.0	264.0	156.0	--
34	148.0	264.0	264.0	148.0	--
35	140.0	264.0	264.0	140.0	--
36	131.0	264.0	264.0	131.0	--
37	122.0	264.0	264.0	122.0	--
38	112.0	264.0	264.0	112.0	--
39	102.0	264.0	264.0	102.0	--
40	91.0	264.0	264.0	91.0	--
41	79.0	264.0	264.0	79.0	--
42	67.0	264.0	264.0	67.0	--
43	54.0	264.0	264.0	54.0	--
44	40.0	264.0	264.0	40.0	--
45	157.0	264.0	157.0	--	--
46	141.0	264.0	141.0	--	--
47	124.0	264.0	124.0	--	--
48	105.0	264.0	105.0	--	--
49	83.0	264.0	83.0	--	--
50	59.0	264.0	59.0	--	--
51	163.0	163.0	--	--	--
52	257.0	--	--	--	--
53	156.0	--	--	--	--
54	36.0	--	--	--	--

90' DIAMETER-MONORAIL-10" SPACING

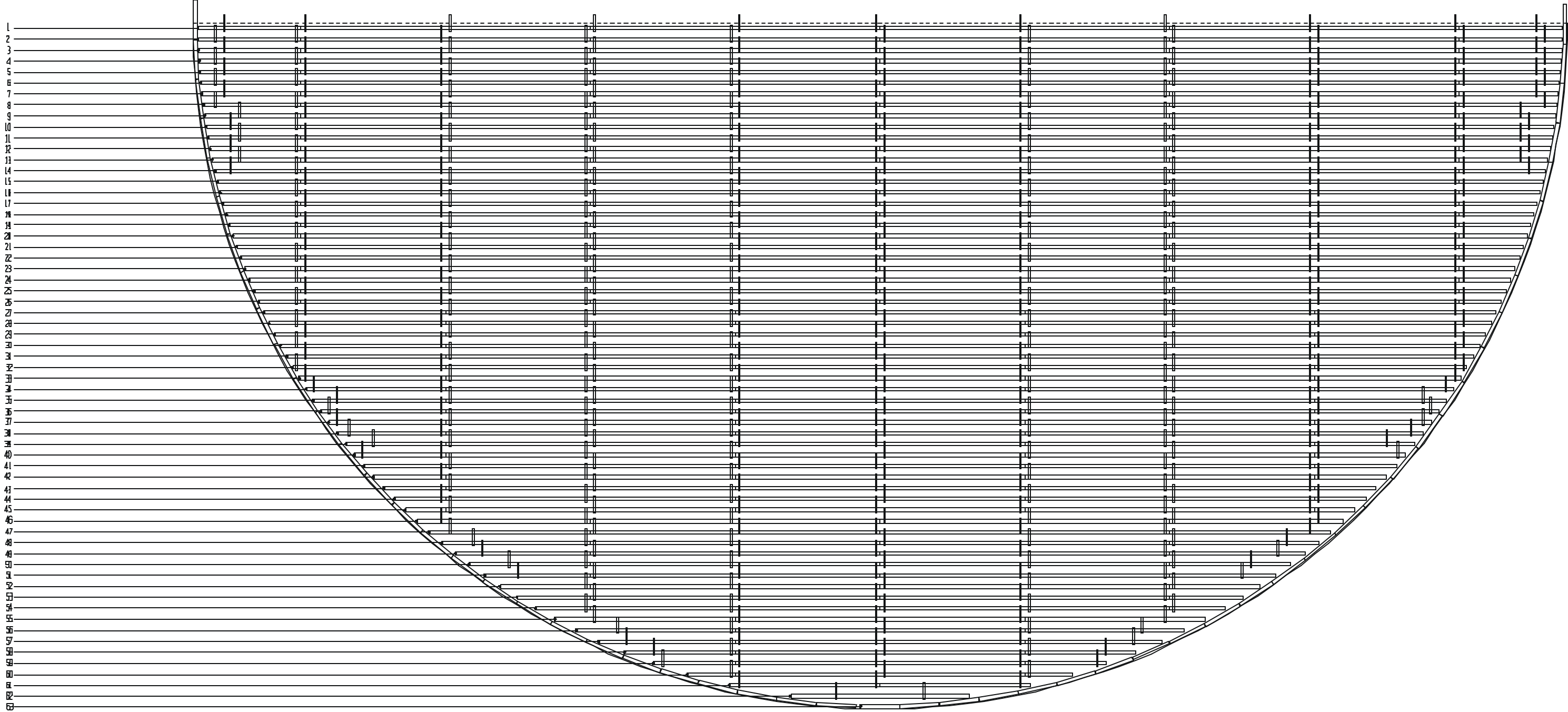
- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 93 PIECES AROUND THE OUTSIDE OF BIN



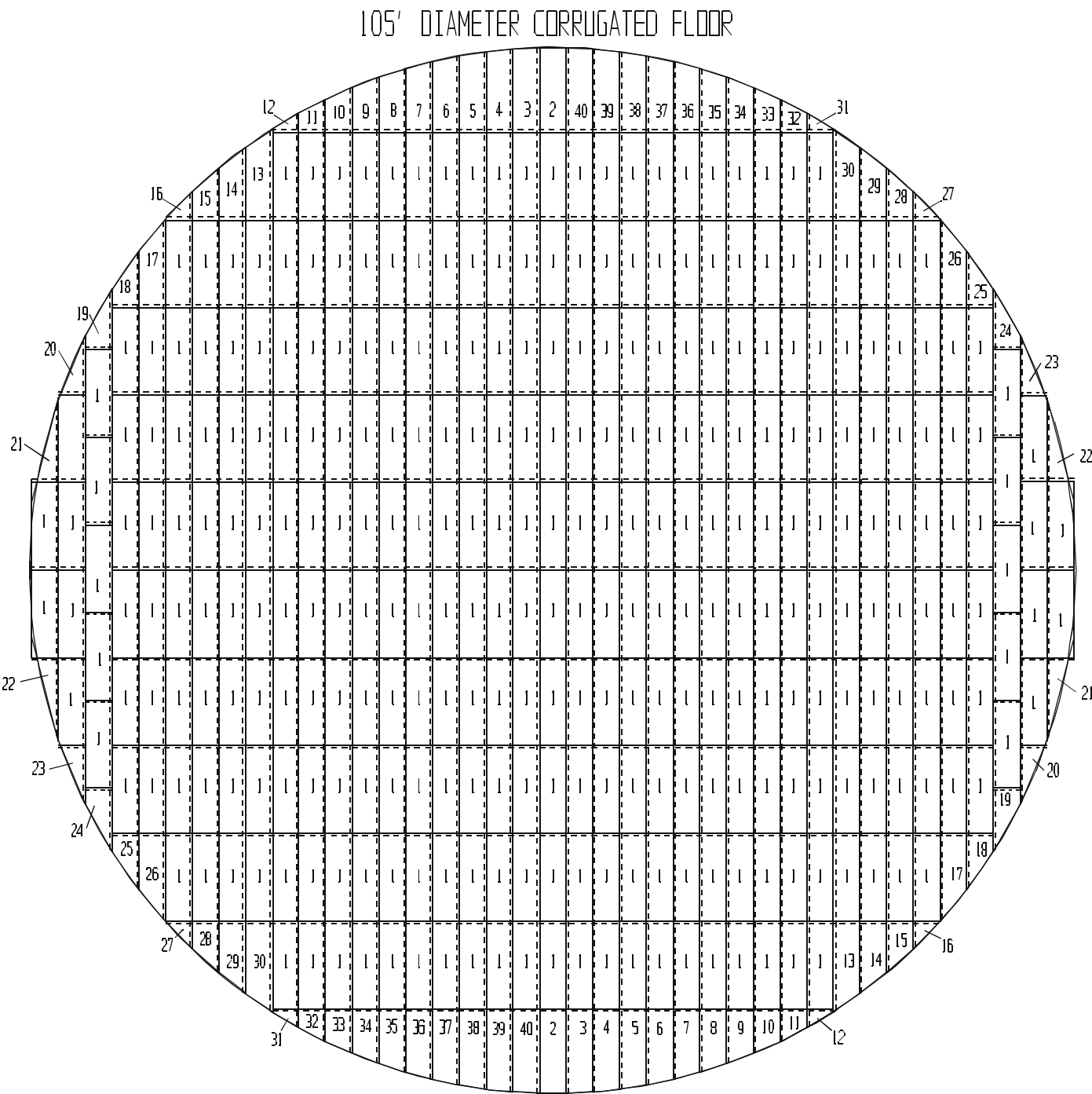
105' BIN FLOOR LAYOUTS

105' DIAMETER-MONORAIL-10" SPACING

- * MONORAIL LEGS NOT SHOWN
- * DIMENSIONS IN INCHES
- * 108 PIECES AROUND THE OUTSIDE OF BIN



105' Diameter Monorail Lengths						
Monorail Number	Sec 1.	Sec 2.	Sec 3.	Sec 4.	Sec 5.	Sec 6.
1	93.0	264.0	264.0	264.0	264.0	93.0
2	93.0	264.0	264.0	264.0	264.0	93.0
3	93.0	264.0	264.0	264.0	264.0	93.0
4	92.0	264.0	264.0	264.0	264.0	92.0
5	92.0	264.0	264.0	264.0	264.0	92.0
6	91.0	264.0	264.0	264.0	264.0	91.0
7	90.0	264.0	264.0	264.0	264.0	90.0
8	89.0	264.0	264.0	264.0	264.0	89.0
9	87.0	264.0	264.0	264.0	264.0	87.0
10	86.0	264.0	264.0	264.0	264.0	86.0
11	84.0	264.0	264.0	264.0	264.0	84.0
12	82.0	264.0	264.0	264.0	264.0	82.0
13	80.0	264.0	264.0	264.0	264.0	80.0
14	78.0	264.0	264.0	264.0	264.0	78.0
15	76.0	264.0	264.0	264.0	264.0	76.0
16	73.0	264.0	264.0	264.0	264.0	73.0
17	71.0	264.0	264.0	264.0	264.0	71.0
18	68.0	264.0	264.0	264.0	264.0	68.0
19	65.0	264.0	264.0	264.0	264.0	65.0
20	62.0	264.0	264.0	264.0	264.0	62.0
21	58.0	264.0	264.0	264.0	264.0	58.0
22	54.0	264.0	264.0	264.0	264.0	54.0
23	51.0	264.0	264.0	264.0	264.0	51.0
24	47.0	264.0	264.0	264.0	264.0	47.0
25	42.0	264.0	264.0	264.0	264.0	42.0
26	38.0	264.0	264.0	264.0	264.0	38.0
27	165.0	264.0	264.0	264.0	165.0	--
28	161.0	264.0	264.0	264.0	161.0	--
29	155.0	264.0	264.0	264.0	155.0	--
30	150.0	264.0	264.0	264.0	150.0	--
31	145.0	264.0	264.0	264.0	145.0	--
32	139.0	264.0	264.0	264.0	139.0	--
33	133.0	264.0	264.0	264.0	133.0	--
34	126.0	264.0	264.0	264.0	126.0	--
35	120.0	264.0	264.0	264.0	120.0	--
36	113.0	264.0	264.0	264.0	113.0	--
37	106.0	264.0	264.0	264.0	106.0	--
38	98.0	264.0	264.0	264.0	98.0	--
39	91.0	264.0	264.0	264.0	91.0	--
40	83.0	264.0	264.0	264.0	83.0	--
41	74.0	264.0	264.0	264.0	74.0	--
42	65.0	264.0	264.0	264.0	65.0	--
43	56.0	264.0	264.0	264.0	56.0	--
44	46.0	264.0	264.0	264.0	46.0	--
45	36.0	264.0	264.0	264.0	36.0	--
46	158.0	264.0	264.0	158.0	--	--
47	147.0	264.0	264.0	147.0	--	--
48	135.0	264.0	264.0	135.0	--	--
49	123.0	264.0	264.0	123.0	--	--
50	110.0	264.0	264.0	110.0	--	--
51	96.0	264.0	264.0	96.0	--	--
52	82.0	264.0	264.0	82.0	--	--
53	66.0	264.0	264.0	66.0	--	--
54	50.0	264.0	264.0	50.0	--	--
55	164.0	264.0	164.0	--	--	--
56	145.0	264.0	145.0	--	--	--
57	124.0	264.0	124.0	--	--	--
58	101.0	264.0	101.0	--	--	--



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T H E G S I G R O U P



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