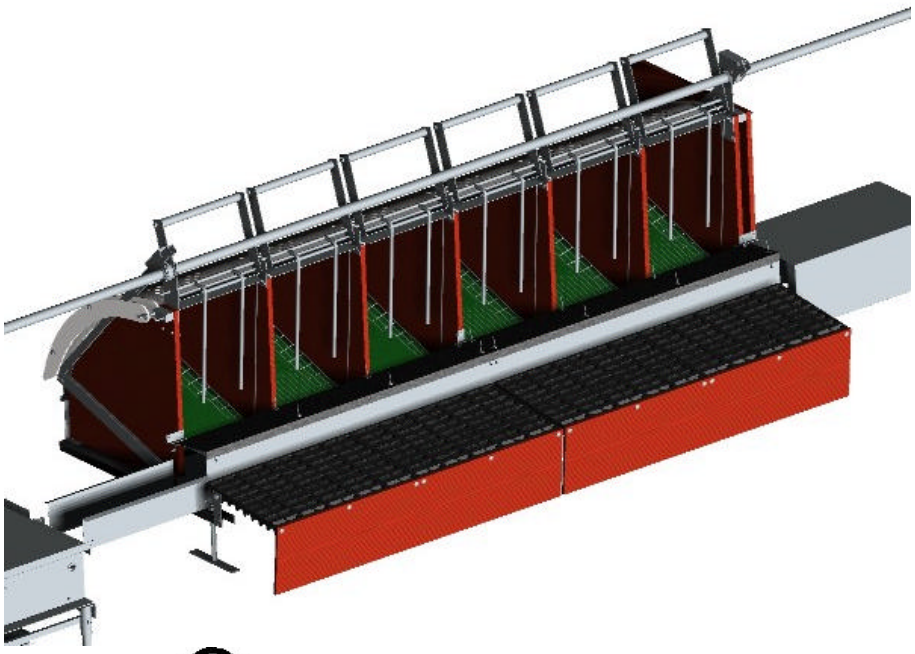
Installation Manual

Turkey Nest



Vencomatic®

IM Turkey Nest-01-en/March '04

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1 Foreword

1.1 This installation manual

This manual is meant as reference book for the machine that is represented on the cover of this document. Only authorized technicians and authorized users are allowed to move, install and place this equipment in operation in a safe and responsible way.

You can find information about the operation, periodic adjustment, cleaning and maintenance on the machine in the user manual.

All chapters and paragraphs have a document code. You will find this code at the bottom of every page.

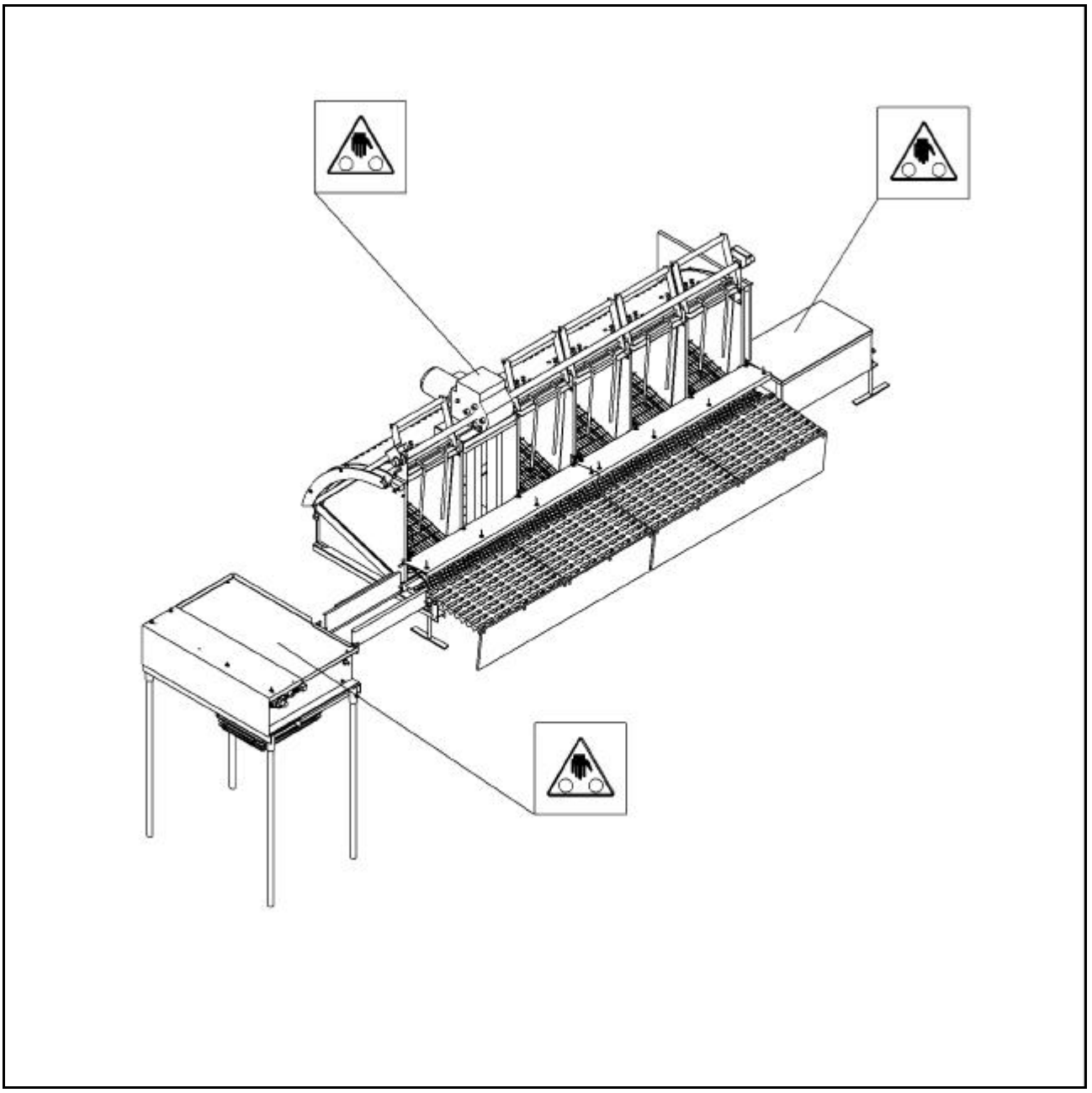
1.2 Document codes

The document code consists of six parts:

- Field 1: document type
- Field 2: product type
- Field 3: version number
- Field 4: language code
- Field 5: month of publication
- Field 6: year of publication

1.3 Stickers on the machine

Following stickers are applied to the machine. See picture below.



1.4 Icons in this document

In the manual of this machine the following icons are used:



Careful

Procedures that can cause damage to the product, surroundings or environment. This damage can occur if procedures are not carried out carefully.

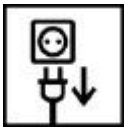


Warning

Danger for electricity / electrical power.



Remarks, suggestions and advices.



Pull out the plug first before proceeding operation.



Consult the indicated Information source first.



Protect against water and moisture.



Watch out!

Procedure that needs extra attention.

1.5 Available documentation

The following documentation of VenQuotation is available:

- user manual (VenQuotation01-en/Mei-2002)

1.6 List of terms

In this manual the following terms are used:

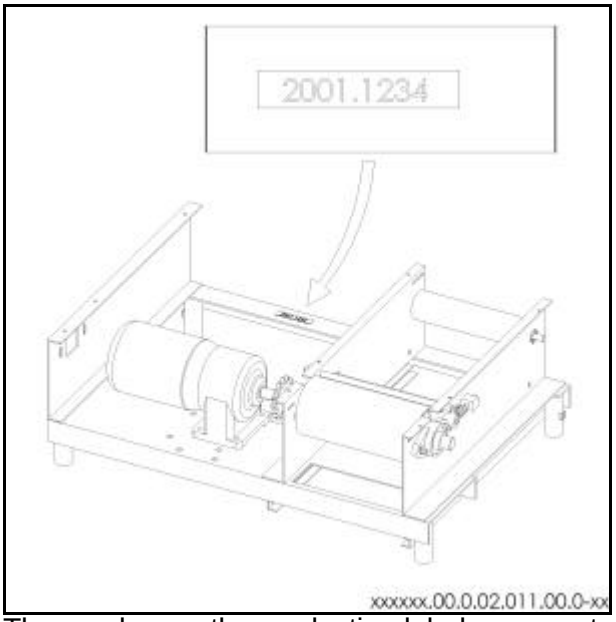
Technician	A trained -and therefore acquainted with the applied technique- expert familiar with the possible dangers of the machine. Technicians have a minimum age of 19 years. They have a solid knowledge of transport techniques. Technicians are authorized to transport, install, place in operation and repair the machine.
Authorized user	See 'User'. The 'authorized user' is also authorized to install and commission the machine.
User	The customer using the machine according to the purpose detailed in the concerning user manual. The user is responsible for the operation and the in the user manual described periodic adjustment, cleaning and maintenance of the machine.
Component	Identification for every separate connectable part of the machine.
Flock	Indication for the economic life cycle of the chickens.

1.7 Service and technical support

When an item is not discussed in this manual contact your local Vencomatic dealer for information about specific procedures.

1.8 Identification of the system

The production label is placed on the drive unit. See picture below.



The number on the production label represents the order number.

1.9 The machine and the environment

1.9.1 Packaging material

The packaging material mainly consists of:

- (corrugated) cardboard
- (untreated) wood
- plastic packaging material

Inform the customer to inquire about the possibilities for recycling and environmentally friendly disposal / re-use of the packaging materials.

1.10 Discard the machine

Discarded machines should be disposed of in an environmentally friendly way according to the local regulations. The used materials can be subdivided roughly in:

- plastic (egg carrier on chain, dirt tray, various plugs)
- untreated metal (shafts)
- coated metal (motor and bearing block)
- galvanized metal (sheet metal, fastening materials, legs)
- aluminum (side profiles of section)
- oil and grease (in motor, bearing block and oil lubrication system)

If an electrical control panel is supplied:

The printed circuit board(s) and their components in the control panel are electrical waste.

1.11 General safety instructions

Vencomatic B.V. will not accept any claim for damage or injury caused by not following the safety regulations and safety instructions, or carelessness during:

- transport,
- installation,
- commissioning,
- operation,
- maintenance,
- troubleshooting and repair,

of the machine and possible accessories. Depending on specific working circumstances or additional accessories, additional safety regulation can be needed. If during previous the aforementioned activities a potential danger occurs, please contact Vencomatic B.V. immediately.

1.11.1 Installation manual / user manual

- Every technician has to know the contents of the installation manual. The technician must follow the instructions in the installation manual conscientiously.
- Every (authorized) user has to know the contents of the user manual and follow the instructions in the user manual conscientiously.
- Never change the order of the “to do” actions.
- Store this manual carefully.

1.11.2 Stickers and instructions on the machine

Stickers, symbols and instructions are an integral part of this machine’s safety precautions. It is therefore not allowed to cover them up and / or remove them. They have to be present and legible during the whole life cycle of the system.

- Replace or repair illegible stickers, symbols and instructions immediately.

1.11.3 Technician

Transport, installation and commissioning of the machine is allowed for authorized and trained technicians only. (See 'Terms and Definitions'.) While carrying out their work they are always fully responsible for compliance of local safety regulations and guidelines. Temporary personnel and persons in training are allowed to work with the machine under supervision of an authorized technician only.

1.11.4 Authorized users

An authorized user is the customer using the machine. This use is in accordance with the purpose of the user guide. The user is responsible for the operation of the machine. The user takes care of periodic adjustment, cleaning and maintenance of the machine. These items are written down in the user manual.

The ‘authorized user’ is also authorized for installation and commissioning of the machine.

1.11.5 Technical specifications

The technical specifications cannot be changed.

1.11.6 Modifications

Modification of (or parts of) the machine is not allowed. Use original (spare)parts advised by the manufacturer only.

1.12 Tools

1.12.1 Added tools

The following tools have been included with your system:

- crosshead bit for taptite screw
- socket wrench flexible 33F 7mm

1.12.2 Remaining tools

All other tools which are necessary for installation of the machine are shown as icons in the following drawings.

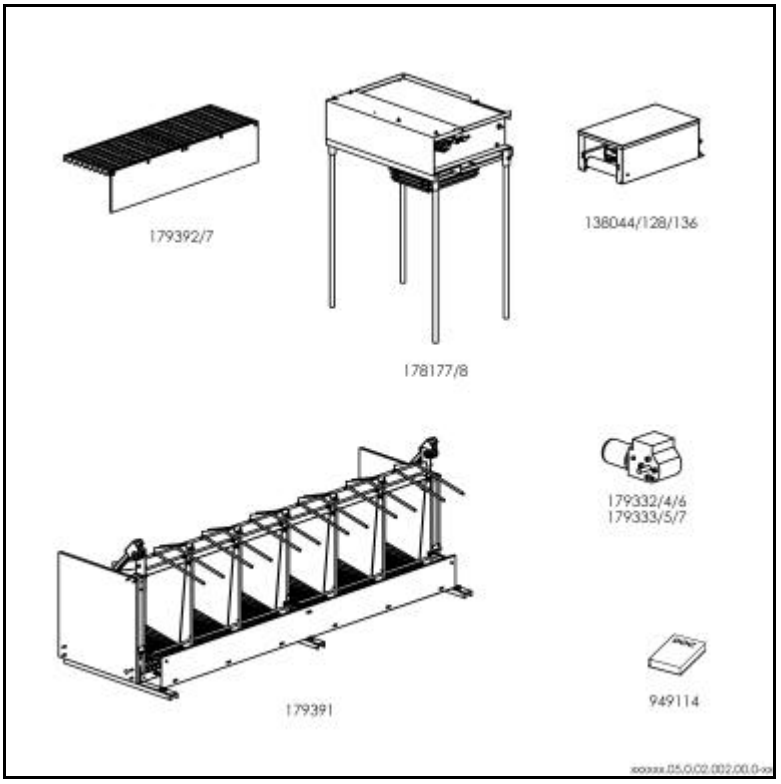
2 General description

2.1 Description Turkey nest

The Vencomatic Turkey nest is made up of modular components. This means that –depending on the use of the component- different configurations are possible.

The following components can be part of the Vencomatic Turkey nest.

- 178177/8 : drive unit
- 179391 : section
- 138044/128/136 : return unit
- 179332/3/4/5/6/7 : flapmotor
- 179392/7 : cuver plate
- 949114 : binder with bill of material and manuals



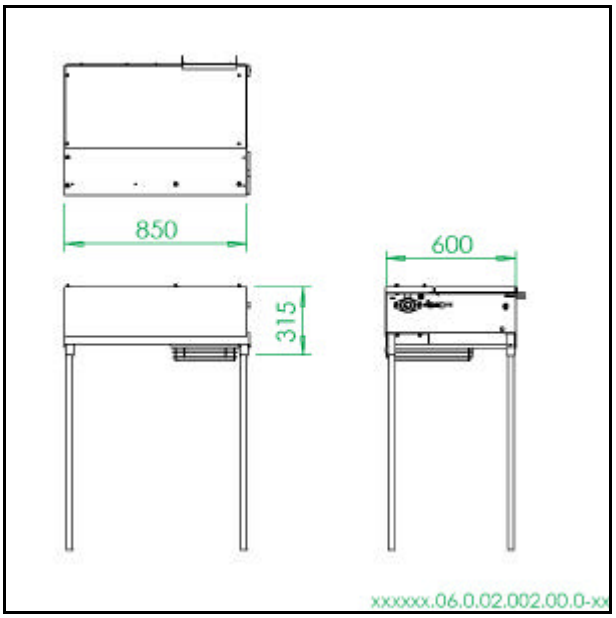
3 Technical data

3.1 Technical data drive unit

3.1.1 General drive unit

Description	Torque (Nm)	Max. length (m)
Belt motor	130	151,8

3.1.2 Dimensions drive unit



3.1.3 Electrical installation drive unit

Description	Power (Watt)	Mains voltage (V)
Belt motor	370	3x230 / 3x400

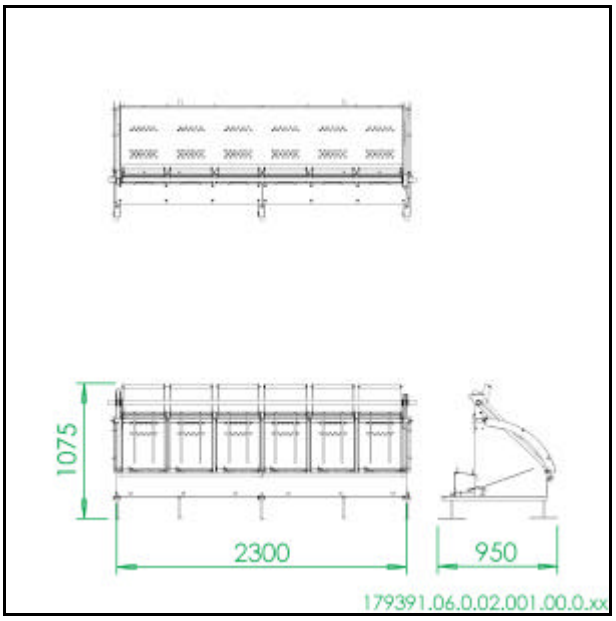
Electrical data is subject to changes.

3.2 Technical data section

3.2.1 General section

Description	General
Material	Venco-board, Sendzimir, HMPE, PA 6 (Nylon). RVS, PP, Rubber

3.2.2 Dimensions section



3.3 Technical data return unit

3.3.1 General return unit

Description	General
Material	Sendzimir, HMPE, PA 6 (Nylon)

3.4 Technical data flapmotor

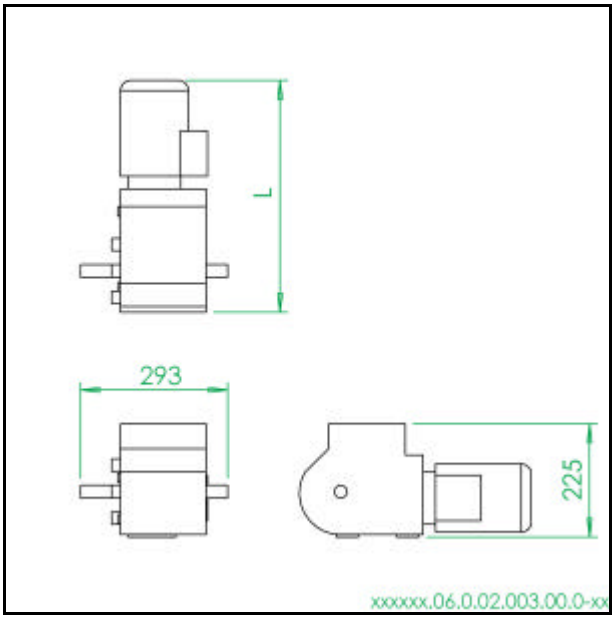
3.4.1 General flapmotor

Type	Torque (Nm)	Max. number of sections
179332 GW 20-3	200	15
179333 GW 20-1	160	12
179334 GW 40-3	400	30
179335 GW 40-1	320	24
179336 GW 80-3	800	50
179337 GW 80-1	640	40
179364 GW 80-3 BALDOR **USA**	400	30
179365 GW 80-1 BALDOR **USA**	800	50

* motor type to be installed after consultation with dealer.

3.4.2 Dimensions flapmotor

Type	**Dimensions**
179332 GW 20-3	L=400 W=293 H=225
179333 GW 20-1	L=400 W=293 H=225
179334 GW 40-3	L=460 W=293 H=225
179335 GW 40-1	L=460 W=293 H=225
179336 GW 80-3	L=460 W=293 H=225
179337 GW 80-1	L=460 W=293 H=225
179364 GW 40 BALDOR **USA**	On request
179365 GW 80 BALDOR **USA**	On request



3.4.3 Electrical installation flapmotor

Type	Power (Watt)	Main voltage (V)
179332 GW 20-3	180	3x230 / 3x400
179333 GW 20-1	180	220 - 240
179334 GW 40-3	250	3x230 / 3x400
179335 GW 40-1	300	220 - 240
179336 GW 80-3	370	3x230 / 3x400
179337 GW 80-1	370	220 - 230
179364 GW 80-3 BALDOR **USA**	On request	On request
179365 GW 80-1 BALDOR **USA**	On request	On request

* motor type to be installed after consultation with dealer.

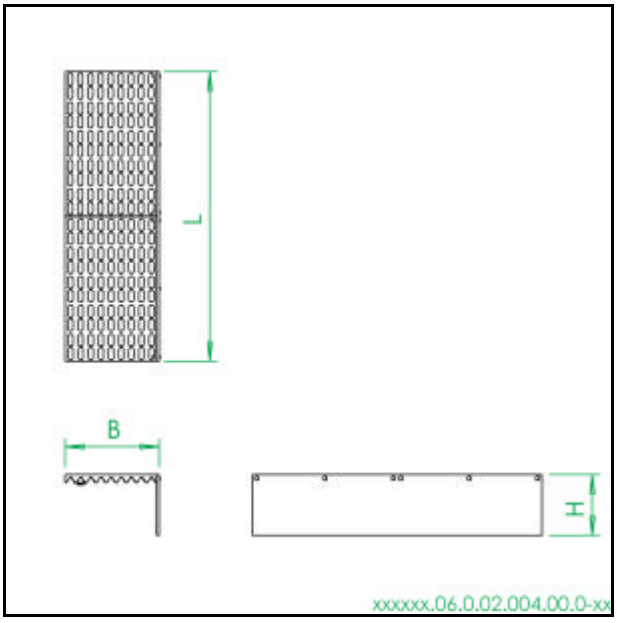
3.5 Technical data coverplate

3.5.1 General coverplate

Description	General
Material	Venco-board, HDPE, PP.

3.5.2 Dimensions coverplate

Type	Dimensions
179392	L=1150 H=230 B=600
179397	L=1150 H=270 B=500



4 Transport

4.1 Transport safety regulations

See also 'General safetyprescription and -instructions '.

5 Storage

5.1 Storage safety regulations

- See also 'General safety instructions'.
- Respect the surrounding conditions. Never store the system in a room where the temperature can get under +10 °C. Lower temperatures can damage sensitive parts.
- Store the system in a dry and dust free room.
- Place the system on a level floor.
- Never place heavy products on top of lighter products.

6 Preparations

6.1 Preparing safety regulations

- Always carefully look at the icons in the drawings before starting. Icons give information about which tools to use or the actions to be taken for correct assembly.
- Take care of scaffolding materials in case work has to be done on a higher level.
- See also 'General safety instructions'.

6.2 Bill of material system



Check if all components and parts are supplied conform to the bill of material. When a component or part is not present contact the local Vencomatic dealer. See ‘Service and technical support’.

6.3 Unpack



All boxes are numbered. The numbers on the boxes correspond with the numbers on the bill of material. Leave all components and parts in the boxes as long as possible, this makes the installation easier.

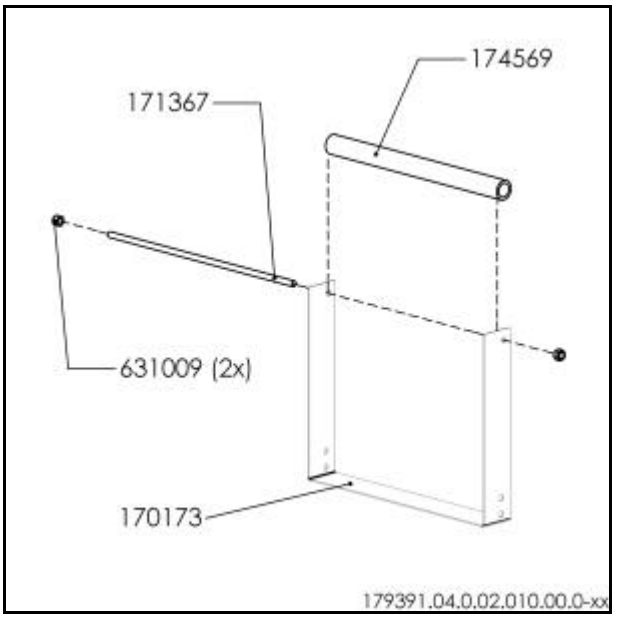
7 Pre-assembly

Read ‘This installation manual’ first before starting installation.

7.1 Traps

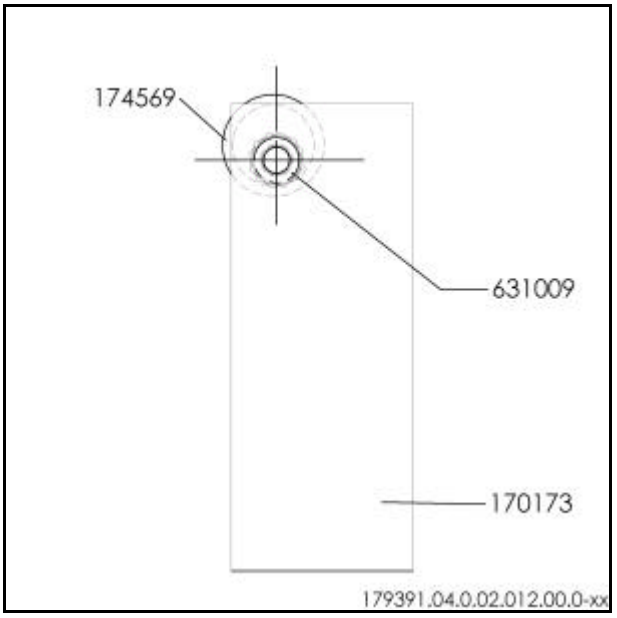
7.1.1 Fixing counterweight

1. Position the counterweight (174569) between trap plate (170173).
2. Slide the stud (171367) through the trap plate (170173) and the counterweight (174569).
3. Tighten the lock nuts (631009) to the stud (171367), fasten the lock nuts (631009) by hand.



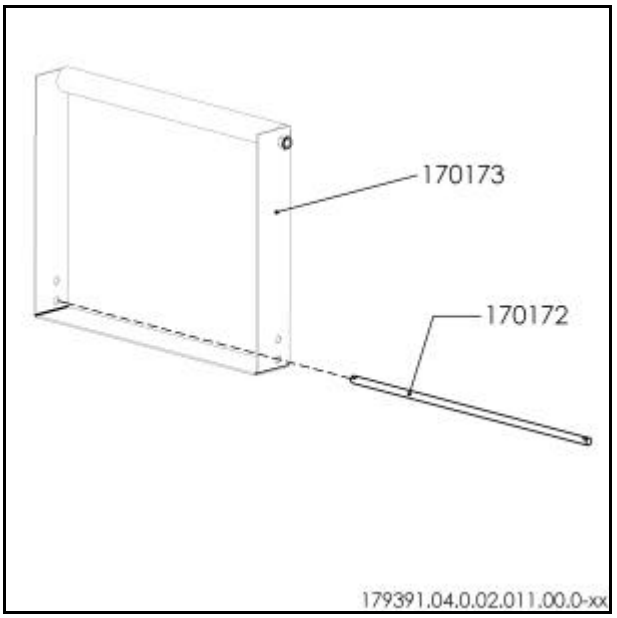
7.1.2 Positioning counterweight

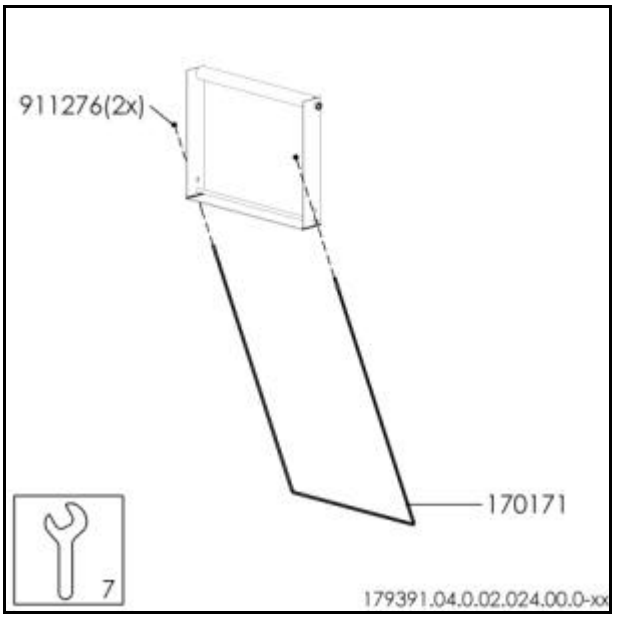
1. Loosen the lock nuts slightly (631009).
2. Position the counterweight (174569), make sure the opening of the counterweight is sealed by the trapplate in such a way no dirt can get into the counterweight.
3. Tighten the lock nuts (631009) until the counterweight (174569) is locked into place.



7.1.3 Fixing drawbar trap

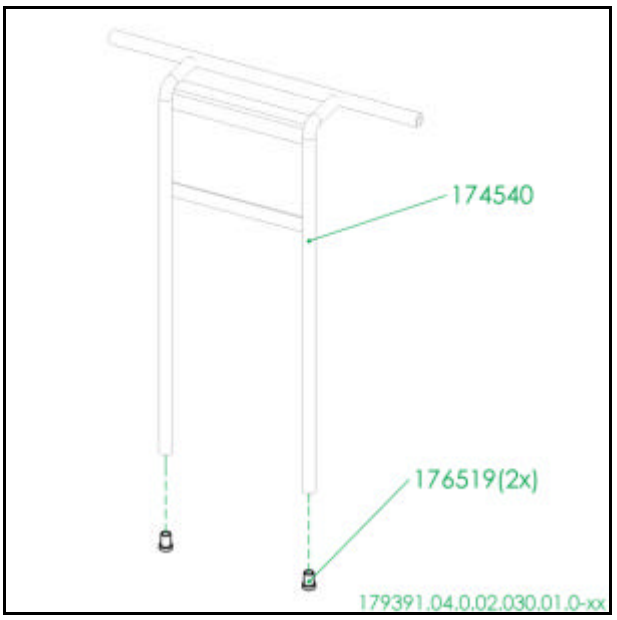
1. Slide the spindle (170172) through the trap plate.
2. Slide the drawbar trap (170171) through spindle (170172).
3. Tighten the lock nuts (911276) to the drawbar trap (170171).
3. Fasten the lock nuts (911276) with the socket wrench (976370) as far as 10mm to the screw-thread.





7.1.4 Laminae plug

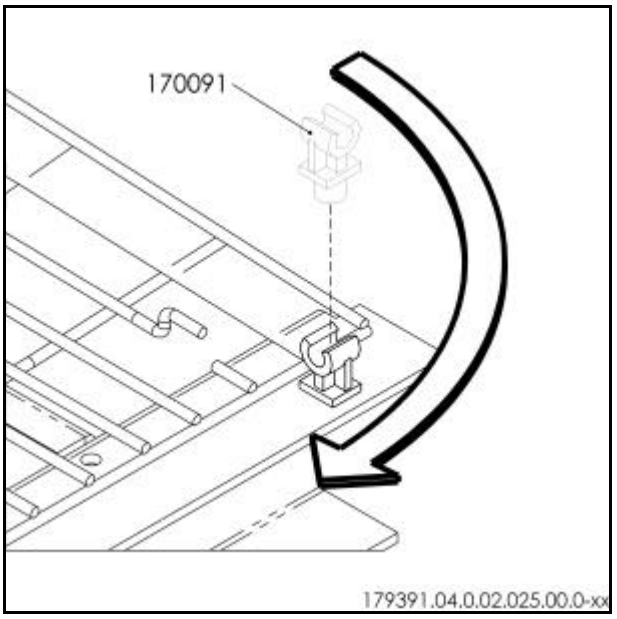
1. Place laminae plug (176519) in the trap (174540).



7.2 Floor turkey nest

7.2.1 Fixing the egg grid holder

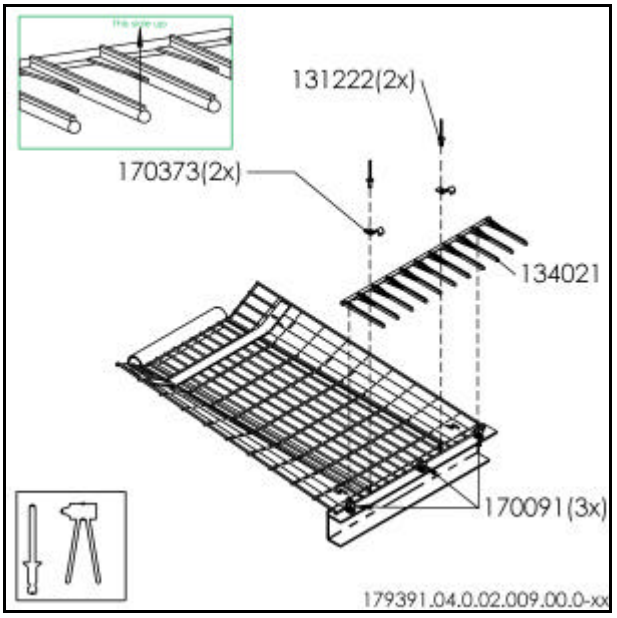
1. Push the egg grid holder (170091) in the floor turkey nest (170158).
2. Rotate the egg grid holder (170091) 90° until the egg grid holder (170091) is secured.



7.2.2 Fixing the egg grid

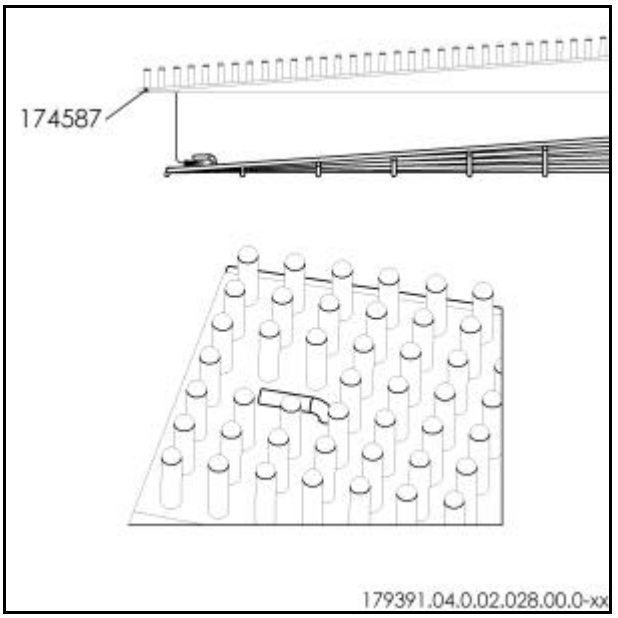
1. Snap the egg grid (134021) into the egg grid holder (170091).
2. Fix the secure bracket (170373) with the blind rivet (131222) to the egg grid, make sure the egg grid can hinge freely.

Position the egg grid with the right side up.



7.2.3 Vencomat

1. Pull the rubber vencomat (174587) over the 4 hooks of the gauze wire floor. While doing this DO NOT BEND the hook.

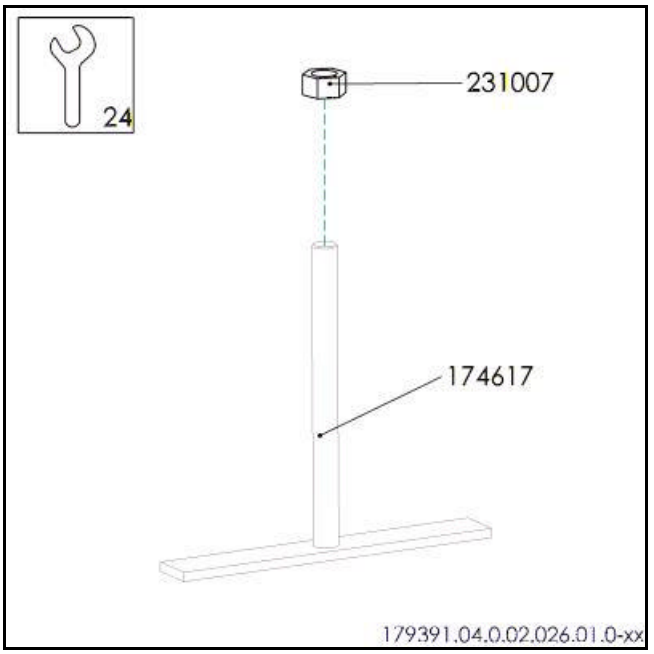




7.3 Leg

7.3.1 Leg underframe

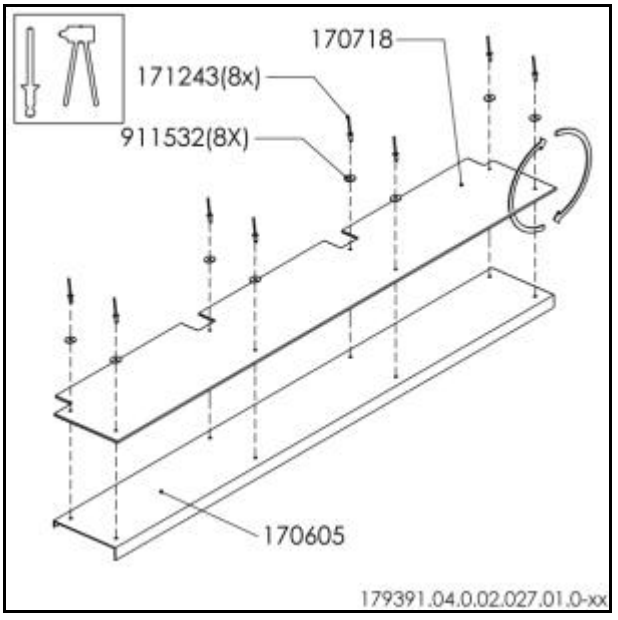
1. Thread the nut M16 (231007) to the leg (174617).



7.4 Run-in plate

7.4.1 Fixing rubber run-in plate

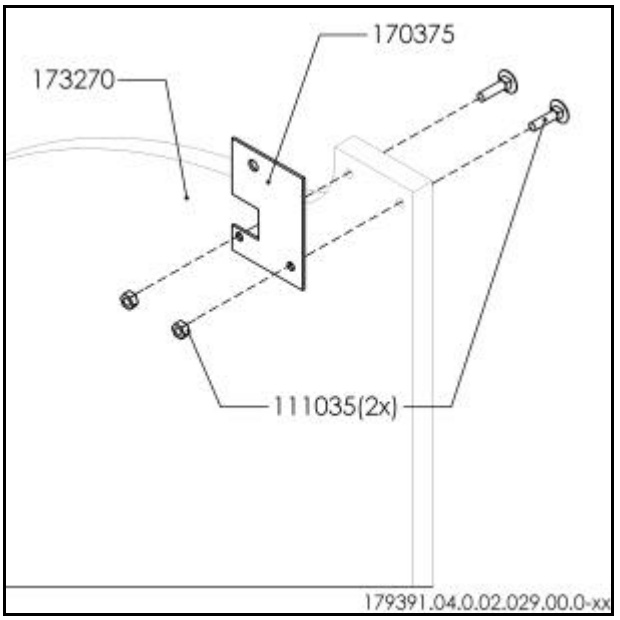
1. Position the rubber run-in plate (170718) on the run-in plate (170605).
2. Fix the rubber run-in plate (170718) with the washers (911532) and the blind rivets (171243).
2. Make half left-handed and half right-handed versions, to do so turn the rubber run-in plate 180°.



7.5 Separation board

7.5.1 Fixing support trap shaft

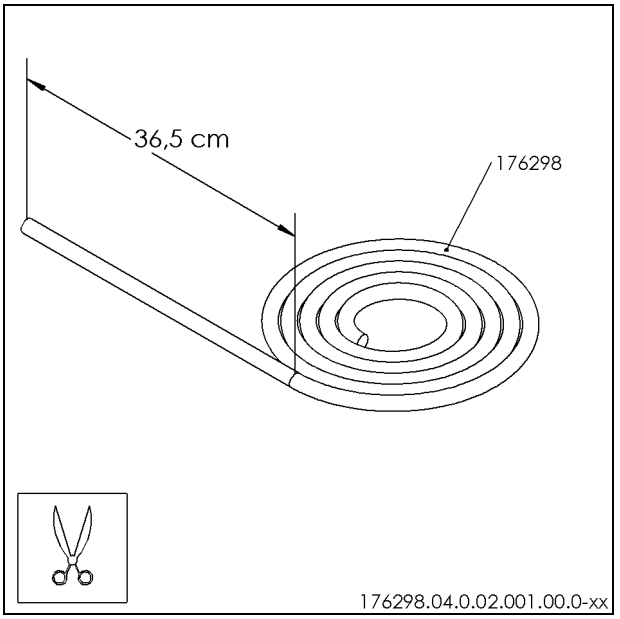
1. Fix the support trap shaft (170375) with the cariage bolt (111035) to the separation board (173270).



7.6 Hose

7.6.1 Cut hose to size

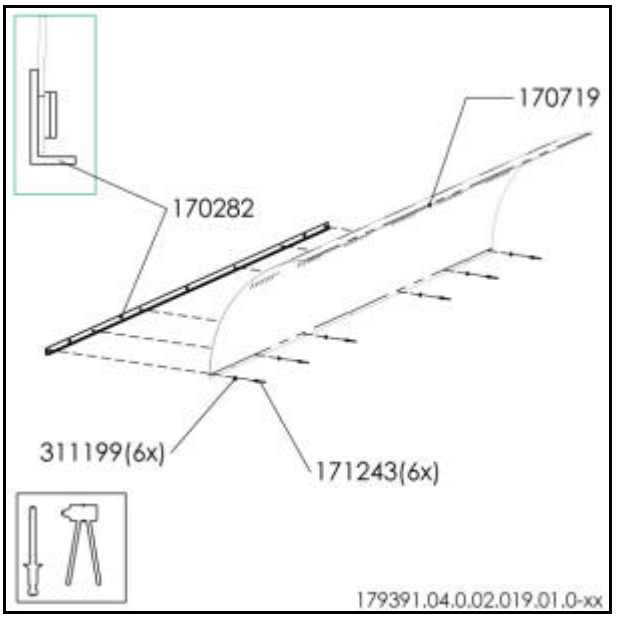
1. Cut the hose (176298) to a lenght of 36,5 cm.



7.7 Back wall

7.7.1 Fixing fixation profile back wall

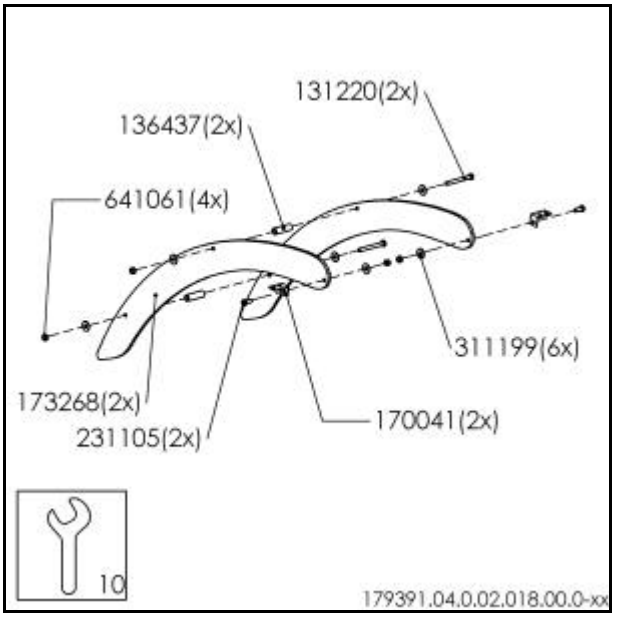
1. Fix the fixation profile back wall-under (170282) with the washers (311199) and the blind rivets (171243) to the back wall PP (170719).



7.8 Segment

7.8.1 Assemble segment

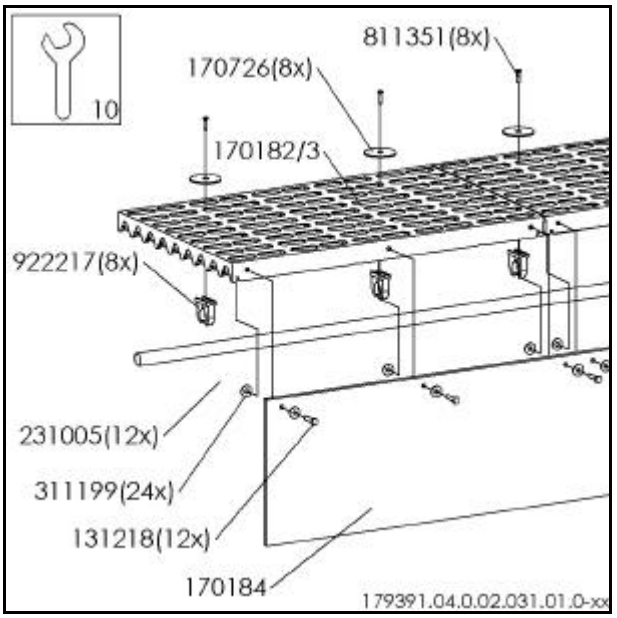
1. Fix the segment (173268) with the spacer (136437), washer (311199), bolt (131220) and lock nut (641061).
2. Fix the segment fixation bracket (170041) with the washer (311199), bolt (231105) and lock nut (641061).

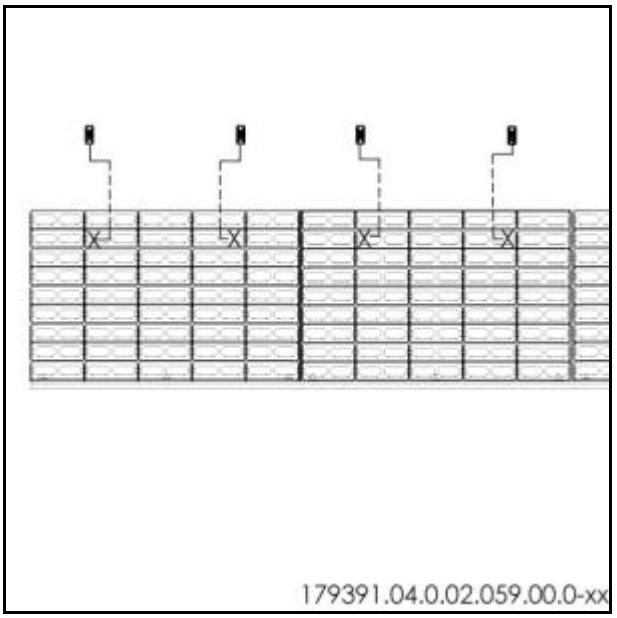


7.9 Run-in grid

7.9.1 Assemble plastic run-in grid

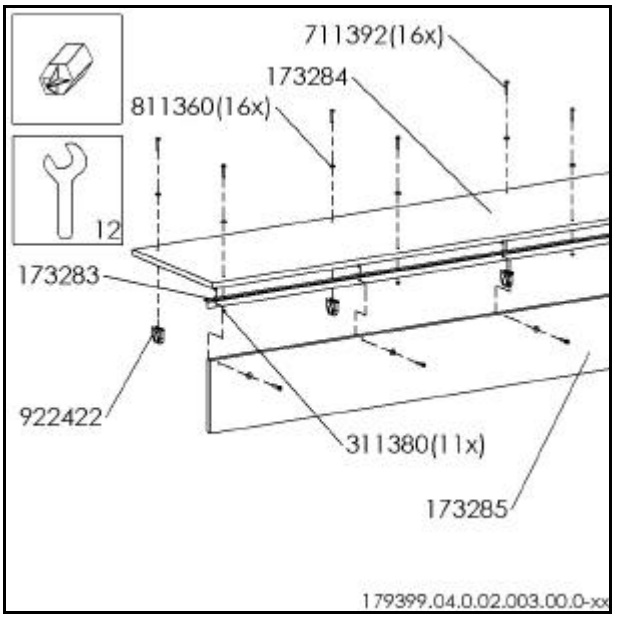
1. Position the underframe run-in grid (170184) against the front side of the Vencoslat (170182 or 170183), make sure the top sides are level.
2. Mark and drill the holes.
3. Fix the underframe run-in grid with the bolt (131218), the nut (231005) and the washer (311199) to the Vencoslat (170182 or 170183).
4. Turn the run-in grid.
5. Screw clip (922217) to the Vencoslat to the position marked X with the screw (811351).





7.9.2 Assemble wooden run-in grid

1. Fix the steel angle (173283) with the screw (711392) an the nut (311380) to the wooden ramp (173284).
2. Fix the wooden underframe (173285) with the screw (711392) and the nut (311380) to the steel angle.
3. Turn the run-in grid.
4. Screw clip (922422) to the Vencoslat with the screw (711392).

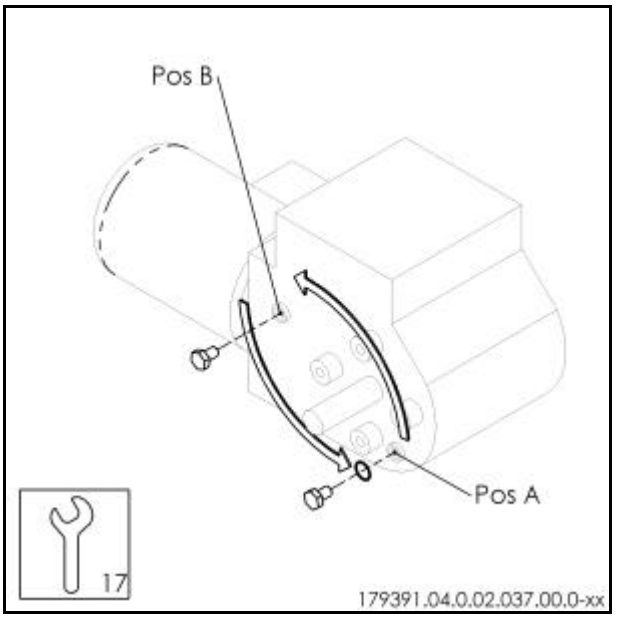


7.10 Motor

7.10.1 Vent plug

1. Loosen vent plug (Pos A) and plug (Pos B).
2. Replace vent plug with rubber ring from Pos A to Pos B.
3. Replace plug from Pos B naar Pos A.
4. Fasten vent plug (Pos B) and plug (Pos A).

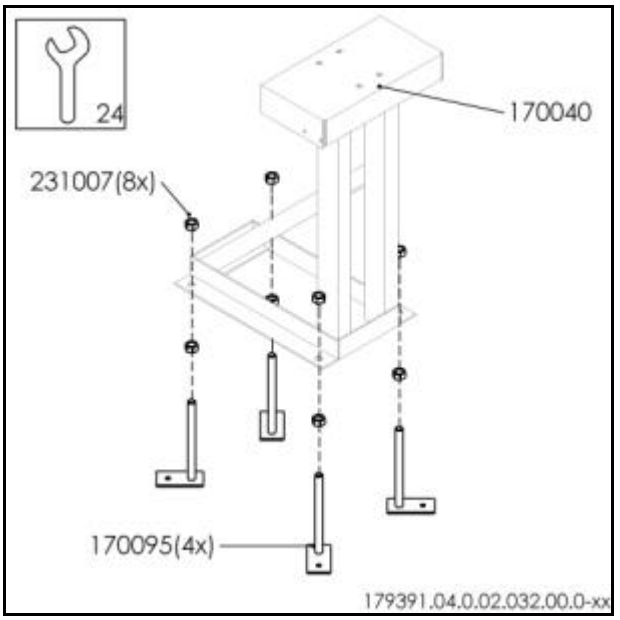
1. Loosen vent plug before commissioning (Pos B).
2. Remove the rubber ring.
3. Fasten the vent plug.



7.11 Flapmotor support

7.11.1 Fixing legs flapmotor support

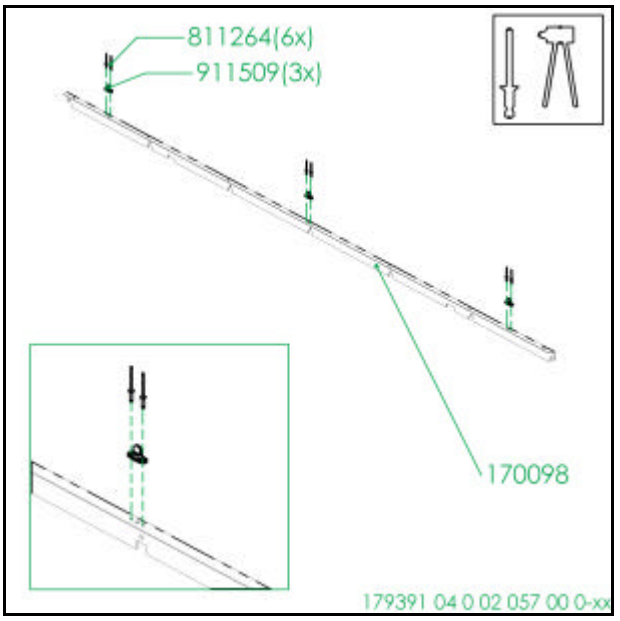
1. Fix the legs flapmotor support (170095) with the nut (231007) to the flapmotor support (170040).
2 To make the flapmotor support adjustable in height later, leave the nuts hand-tight only.



7.12 Tourniquets

7.12.1 Fixing tourniquets

1. Fix the tourniquets (911509) with the blind rivets (811264) to the partition profile (170098).



8 Installation

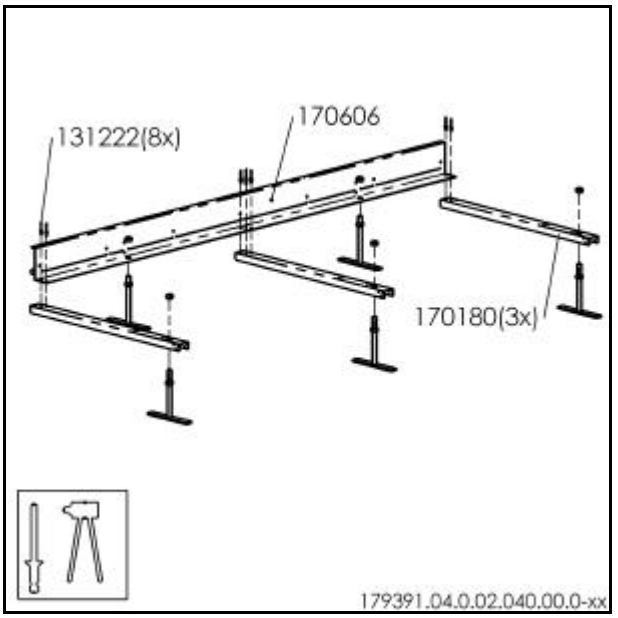
Read ‘This installation manual’ first before starting installation.

8.1 Turkey nest

8.1.1 Underframe

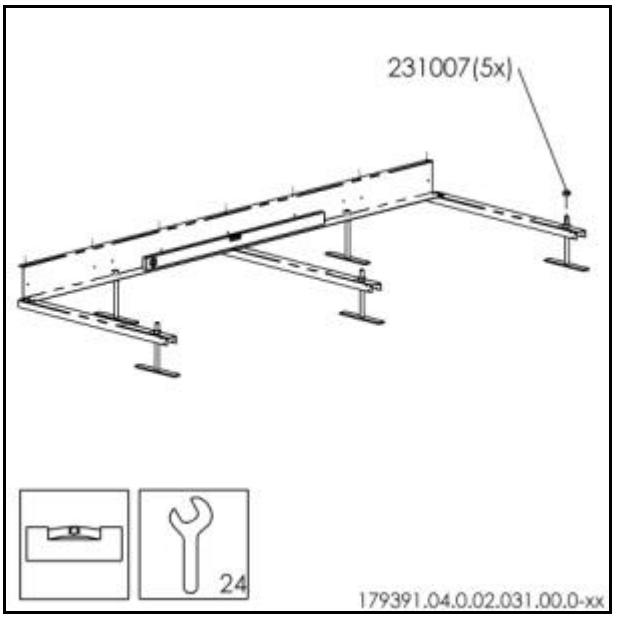
8.1.1.1 Installation underframe

1. Position the pre assembled legs under the cross underframe (170180) and the rear underframe (170606).
2. Fix the rear underframe (170606) with the blind rivets (131222) to the cross underframe (170180).
3. Build the whole installation this way.



8.1.1.2 Level the underframe

1. Place the water-level on the component. Level the water-level by changing the height of the adjustable leg.
2. Repeat this action for all components.
3. Secure the legs of the underfame by tightening the check nut (231007) on the legs.

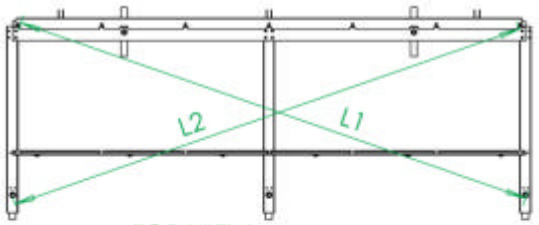


8.1.1.3 Fixing partition profile and beltguide

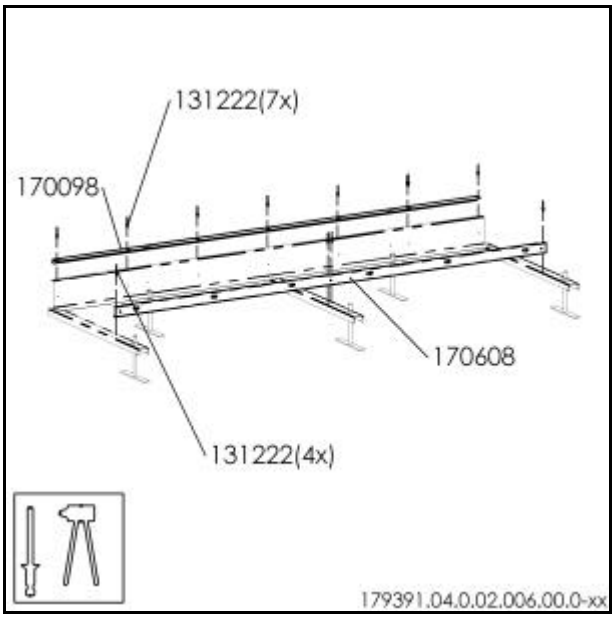
1. Fix the partition profile (170098) with the blind rivets (131222) to the rear underframe.
2. Fix beltguide low (170608) with the blind rivets (131222) to the cross underframe.



Check after assembly of the first underframe if this is square by making a comparison between the diagonals.



TOP VIEW
L1=L2, frame is square

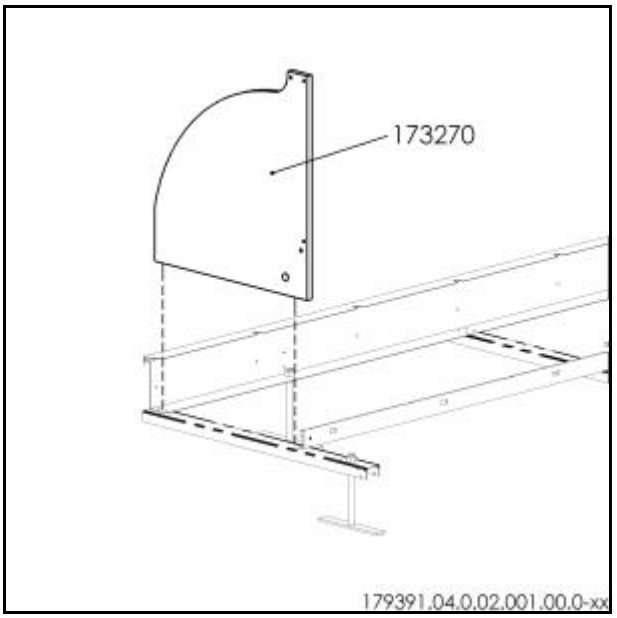


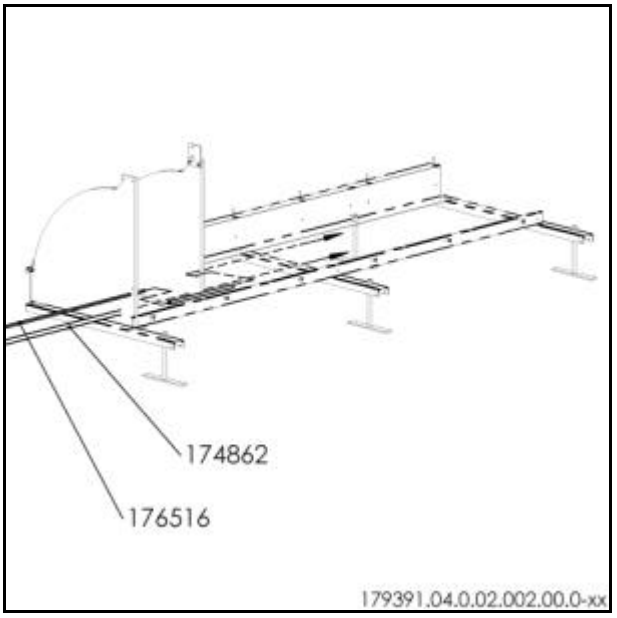
8.1.2 Separation board

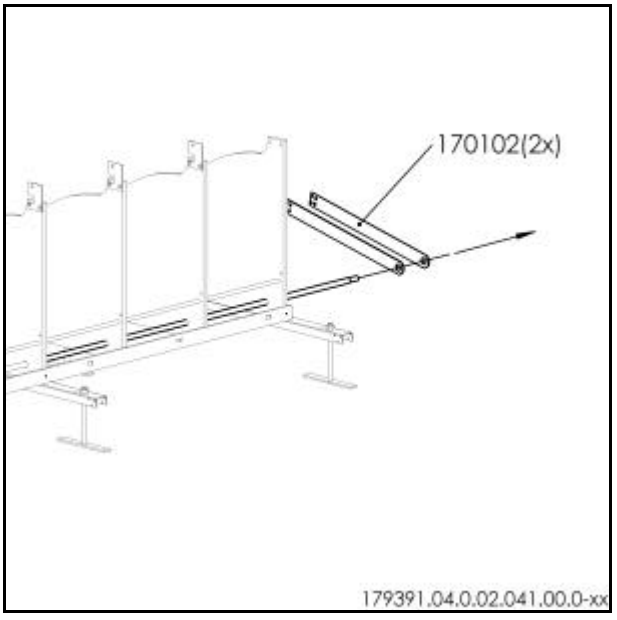
8.1.2.1 Fixing separation board

1. Slide the seperation board (173270) in the first and last notch of the underframe.
2 Slide the pre assembled separation board in the remaining notches of the underframe. See “Seperation board”
3. Slide the galvanized tube (174862) through the 21mm hole in the seperation boards, slide the galvanized tube further after fixing every single separation board.
4. Slide the bar (176516) through the 8.5mm hole in the seperation boards. Fix the prepared hose between two separation boards to the bar (176516), slide the bar further after fixing every single separation board. See “Hose”
5. Repeat this action for the whole system.

Between 2 sections the galvanized tube also has to be slided through the side plate for floor (170102).







8.1.2.2 Fixing separation board with bearing plate

1. Push bronze plain bearing (136215) into the bearing plate (170374).
2. Fix the bearing plate (170374), the fastening bracket top plate (170100) and the plastic distance block (170026) with the carriage bolt (111035), bolt (131139) and lock nut (641061) to the separation board (173270).
3 Fix the top plate (170174) with the screw for chipboard (231003) on top of the seraration boards.

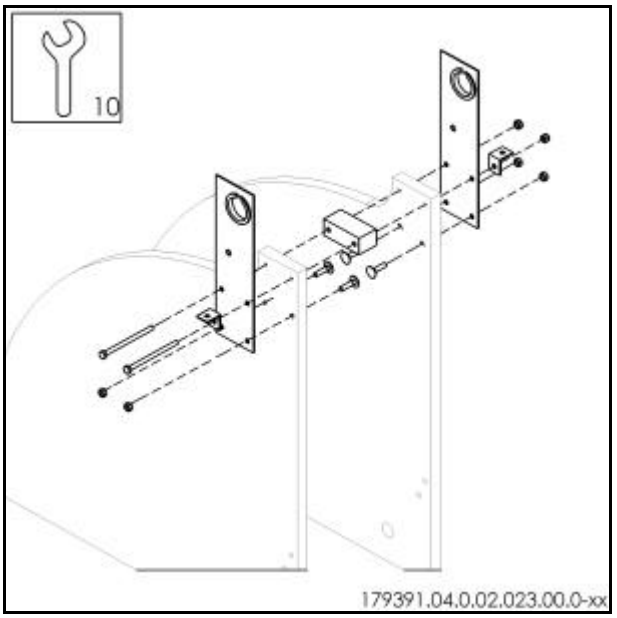
Position the hole of the bearing plate (170374) as far as posible to the right hand side.

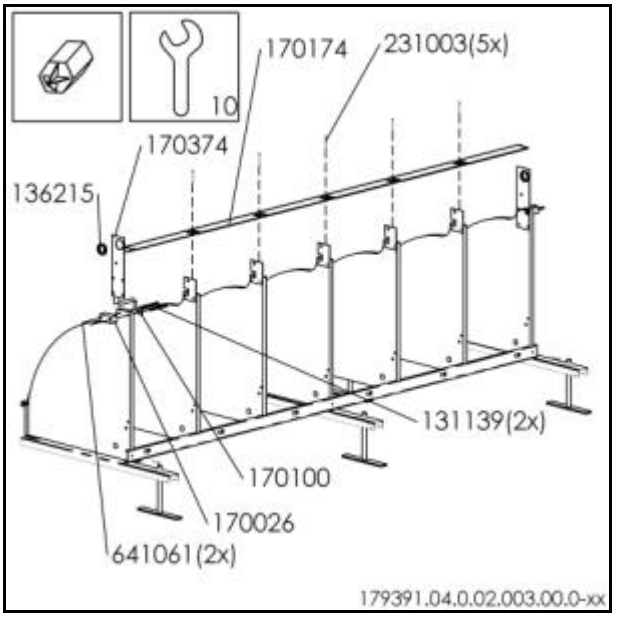
Join two sections together:

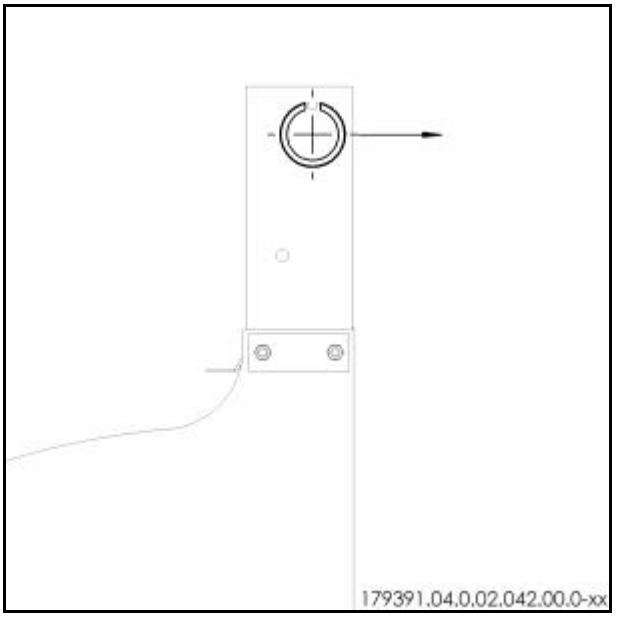
Push bronze plain bearing (136215) into the bearing plate (170374).

Fix the bearing plate (170374), the fastening bracket top plate (170100) and the plastic distance block (170026) with the carriage bolt (111035), bolt (131139) and lock nut (641061) to the separation board (173270).

Use the plastic distance block (170026) as distance holder between the two separation boards.

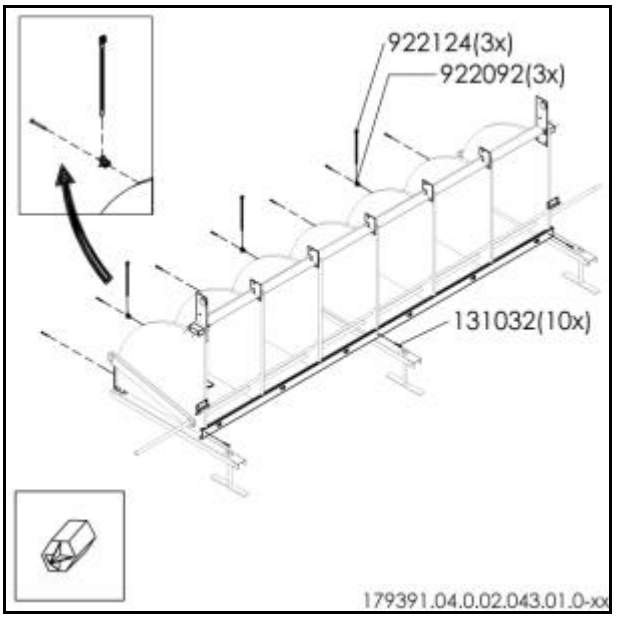






8.1.2.3 Secure separaration boards

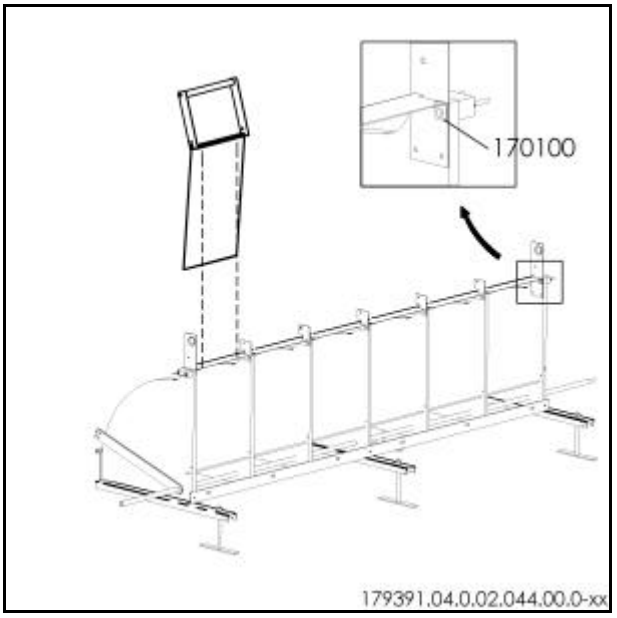
1. Push the first and last separation board firmly in the notches of the partition profile.
2. Fix the separation board and the connecting piece for tyrap (922092) with the screw for chipboard (131032).
3. Slide the tyrap (922126) into the connecting piece for tyrap (922092).



8.1.3 Traps

8.1.3.1 Fixing traps

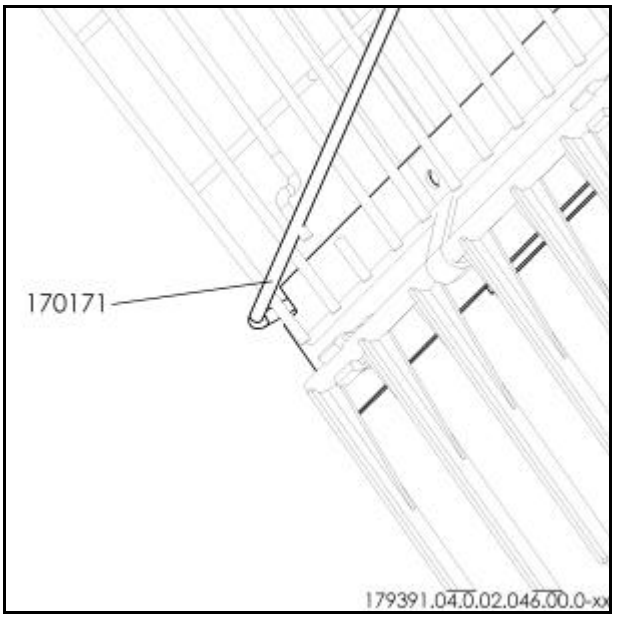
1. Loosen fastening bracket top plate (170100), in such a way the bracket can be moved to position the trap.
2. Position the pre assembled trap on top of the top plate, position the trap in such a way the holes in the trap are closest to the back.
3. Make sure the drawbar trap (170171) is positioned behind the bar 8mm (176516) and the tube 20mm (174862).
3. Fasten the bracket top plate (170100).

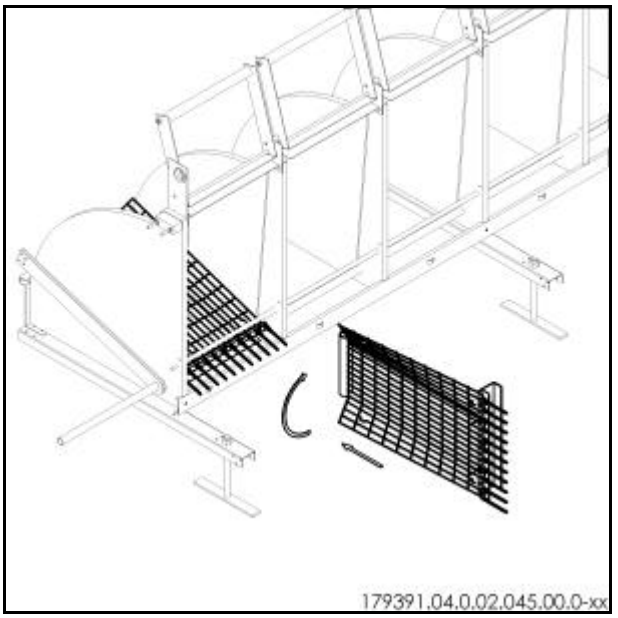


8.1.4 Floor

8.1.4.1 Fixing floor

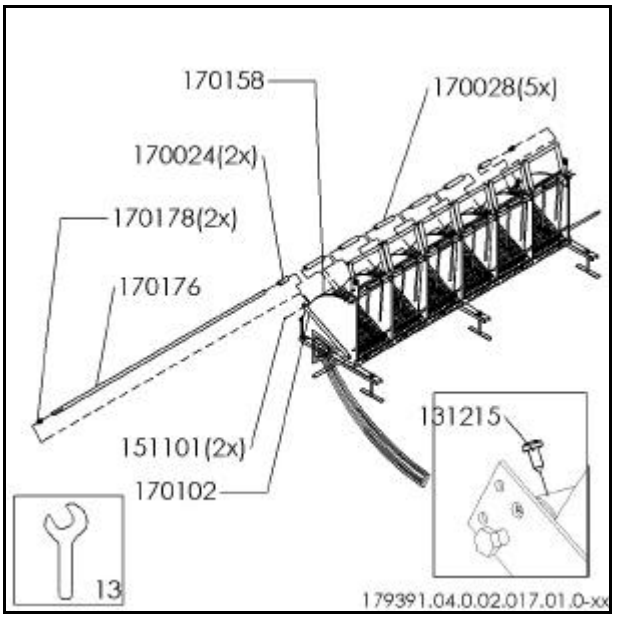
1. Slide the gauze wire floor (170158) vertical between the drawbar.
2. Hook the gauze wire floor (170158) at one side in the drawbar (170171) then turn the gauze wire floor (170158) 90° in horizontal position.





8.1.4.2 Fixing floor tube

1. Push plug floor tube (170178) into tube ¾" (170176).
2. Slide tube ¾" (170176) through the PVC tube (170024), the gauze wire floor (170158), the PVC tube (170028), the gauze wire floor (170158) etc.
3. Slide after the last gauze wire floor (170158) the tube ¾" (170176) through the PVC tube (170024) and push the plug floor tube (170178) into tube ¾" (170176).
4. Secure the tube ¾" with the screw (131215) at the beginning and end of every row and at the passages.
5. Fix the tube ¾" (170176) with the bolt (151101) to the side plate floor (170102).



In the section where the flap motor is situated at the position of the flap motor the gauze wire floor (170158) is replaced by the PVC tube (170028).

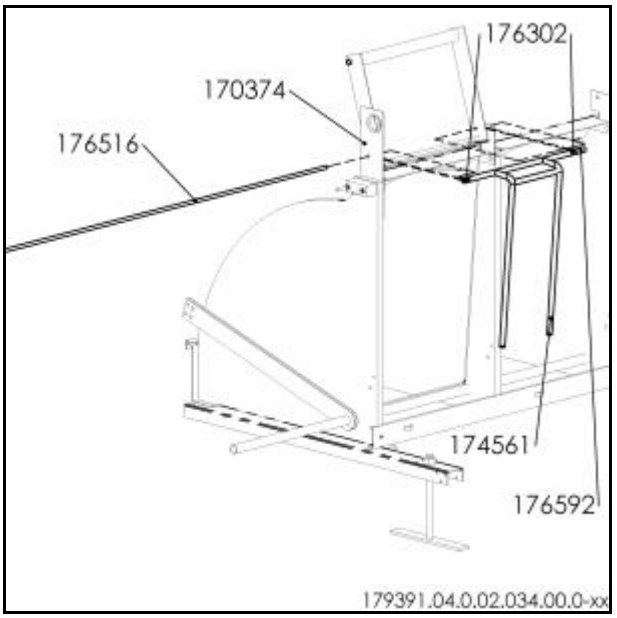
8.1.5 Traps

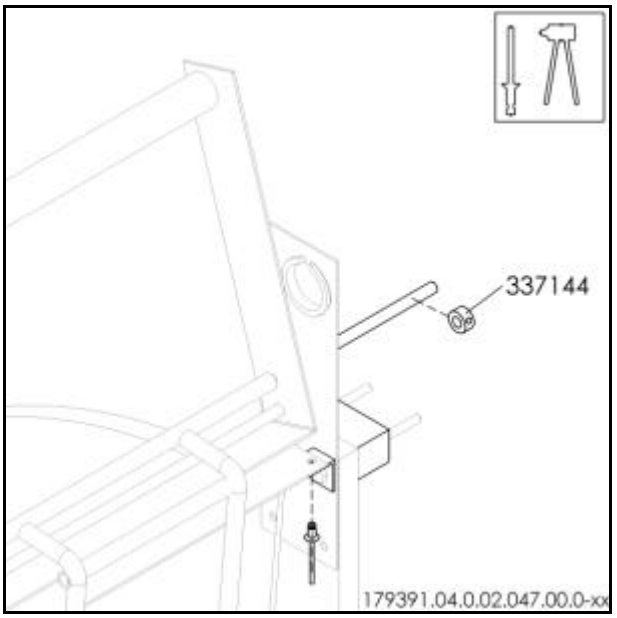
8.1.5.1 Fixing traps

1. Slide the bar 8mm (176516) through the bearing plate (170374), through the spacer sleeve (176302), through the trap (174540), through the spacer sleeve (176302), through the support for trapshaft (170375), through the space sleeve (176592) and again through the trap (174540) etc.
2. Secure the bar ∅8 (176516) with the adjusting ring (337144) at the end of the first section and also before the end of the last section.
3. Last action: Fix the fastening bracket top plate (170100) with the blind rivets to the top plate. See also “Fixing traps”



Check if the traps can move free around the bar. There is a possibility of welding spatters in the tube.

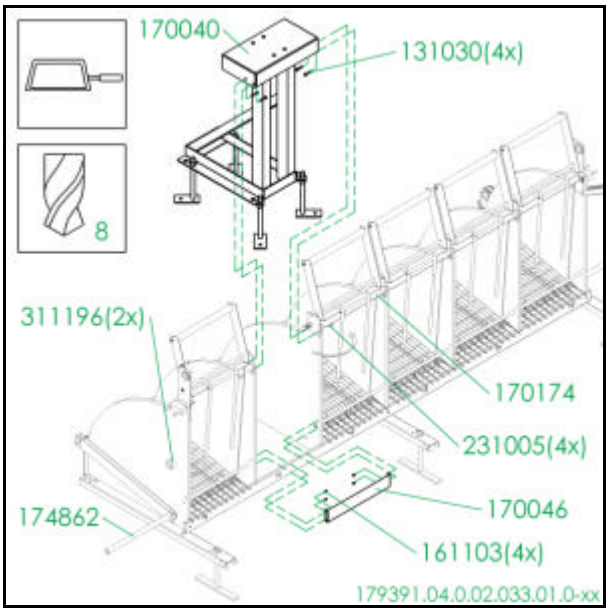




8.1.6 Motor

8.1.6.1 Fixing flapmotor support

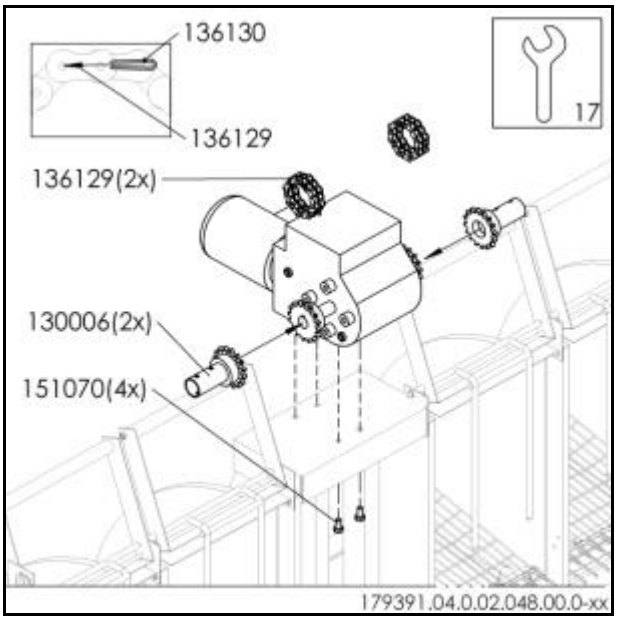
1. Saw off the top plate (170174) flush to the inside of the separation board in the compartment where the flapmotor should be positioned.
2. Reposition the support for trapshaft (170375) to the other side of the separation board.
3. Saw off the tube (174862) in the compartment where the flapmotor should be positioned, push the tube aside to create the space to position the flapmotor support.
4. Fix the flapmotor support guide (170046) with the screw for chipboard (161103) to the separation boards.
5. Fix the flapmotor support in the free compartment with the bolts (131030) and nuts (231005) to the separation boards.
6. Push the tube back against the flapmotor support and secure the tube in this position with the two adjust rings (311196) between the floor side plates.



Always position the flapmotor support in the second compartment of a section.

8.1.6.2 Fixing flapmotor

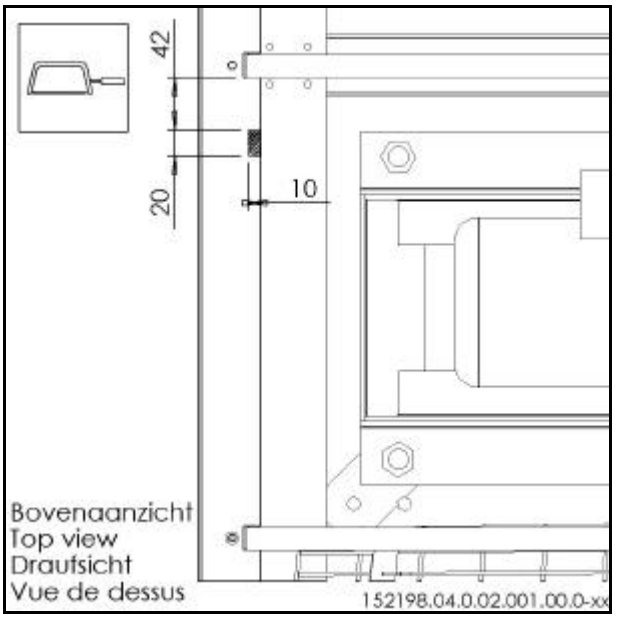
1. Fix the flapmotor with the bolt (151070) to the flapmotor support (170040).
2. Join the connecting cog for flap (130006) with the double chain (136129) and the chain losing link (136130).

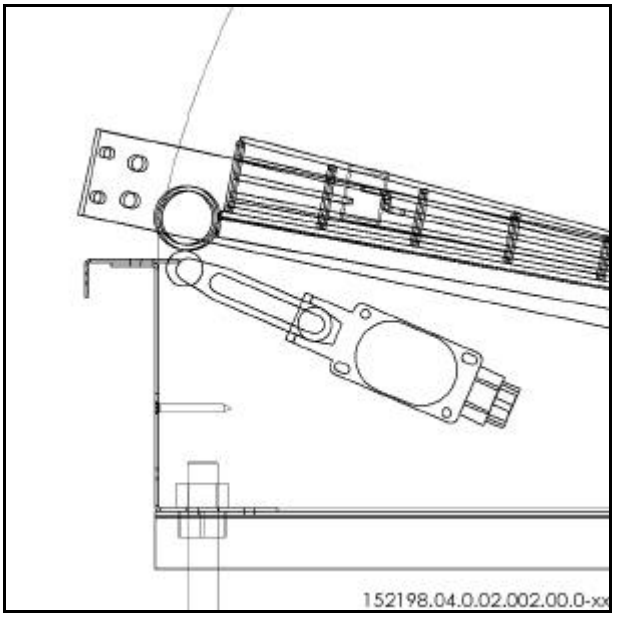


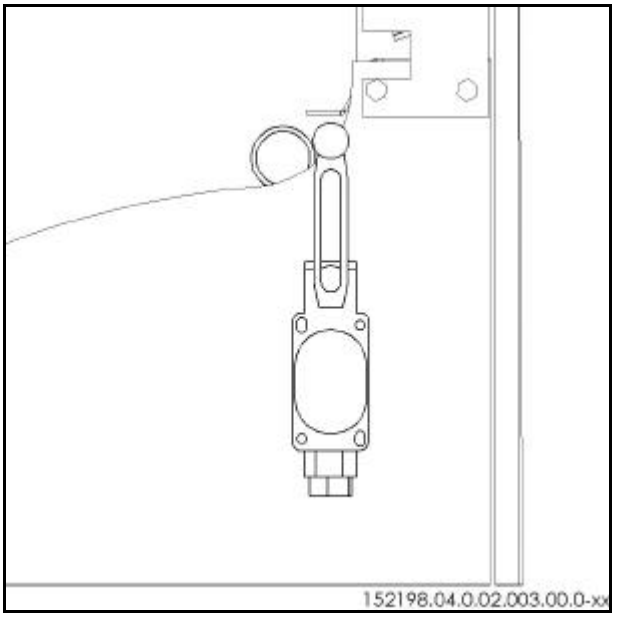
8.1.6.3 Fixing end switch flapmotor

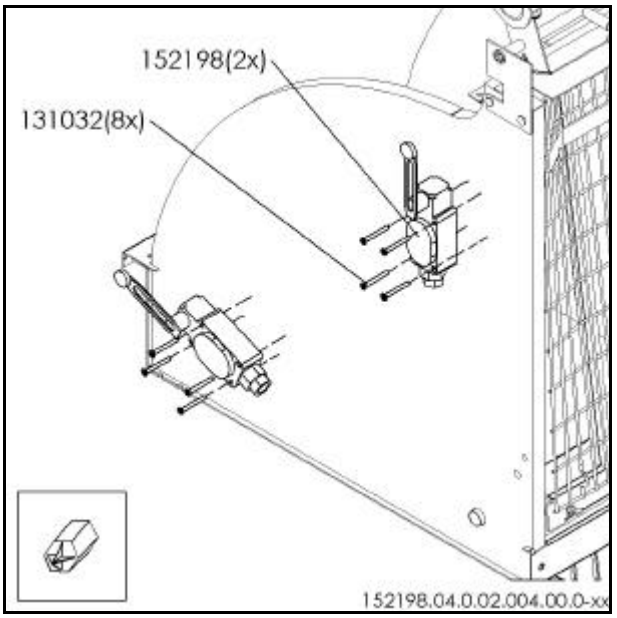
Place the end switches in the same compartment where the flapmotor is positioned.

1. Saw out the hole in the partition profile according to the drawing.
2. Position the lower end switch according to the drawing so the switch is activated just before the tube hits the partition profile.
3. Fix the end switch to the separation board with the screw for chipboard (131032).
4. Position the upper end switch according to the drawing so the switch is just not activated before the tube reaches it highest point. The end switch should be activated when the tube gets past its highest point.
5. Fix the end switch to the separation board with the screw for chipboard (131032).





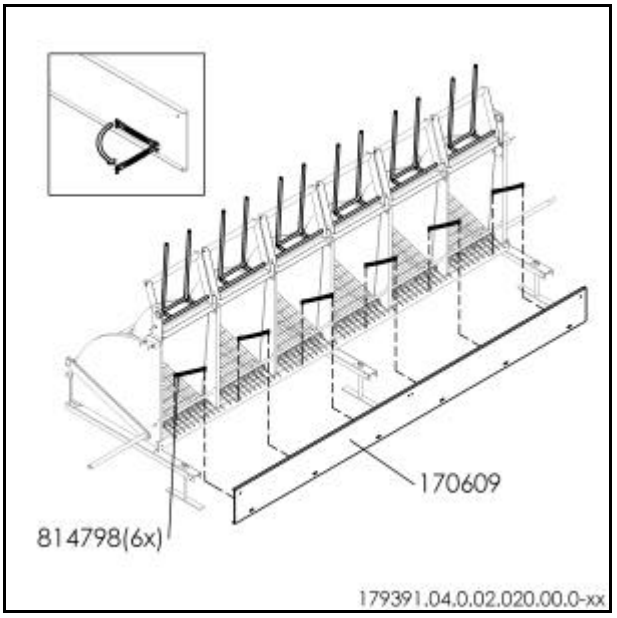




8.1.7 Beltsupport

8.1.7.1 Fixing beltsupport

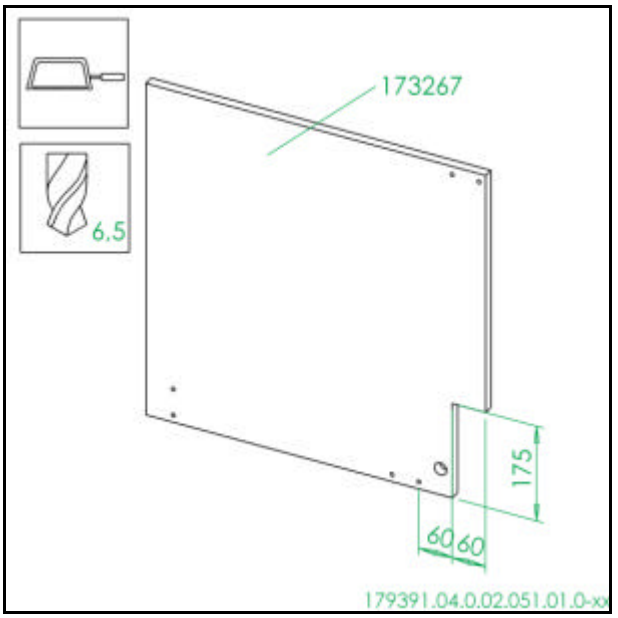
1. Turn the traps upwards.
2. Push the beltsupport (814798) into the punch-outs of the beltguide low (170608).
3. To do this turn the beltsupports (814798) 90° back so that the beltsupports can slide into the punch-outs.
4. Push the beltsupport (814798) into the punch-outs of the beltguide high (170609).
5. To do this turn the assembly 90° back again locking the beltsupports.



8.1.8 End plate

8.1.8.1 Fixing end plate

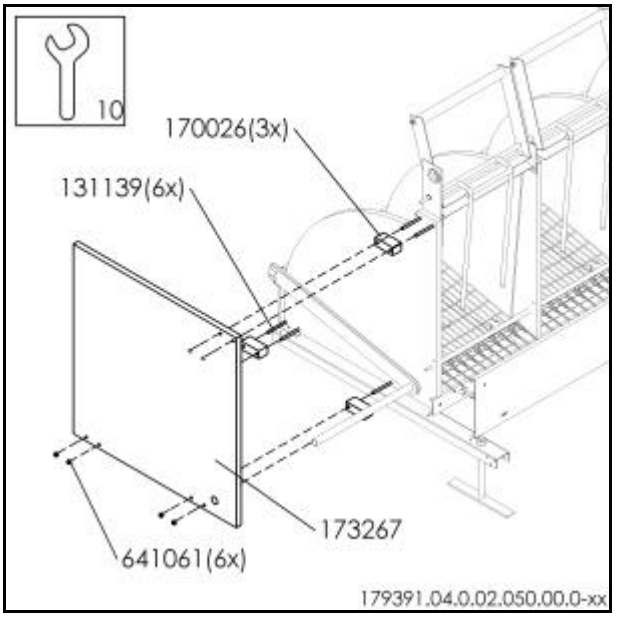
1. Saw out the marked rectangle in the end plate (173267) according to the drawing.
2. Use the plastic distance block (170026) to copy the holes onto the end plate.
3. Drill the holes in the end plate.
4. Copy the holes onto the separation board (173270), drill the holes in the separation board.
5. Fix the end plate (173267) with the plastic distance block (170026), bolt (131139) and lock nut (641061) to the separation board.

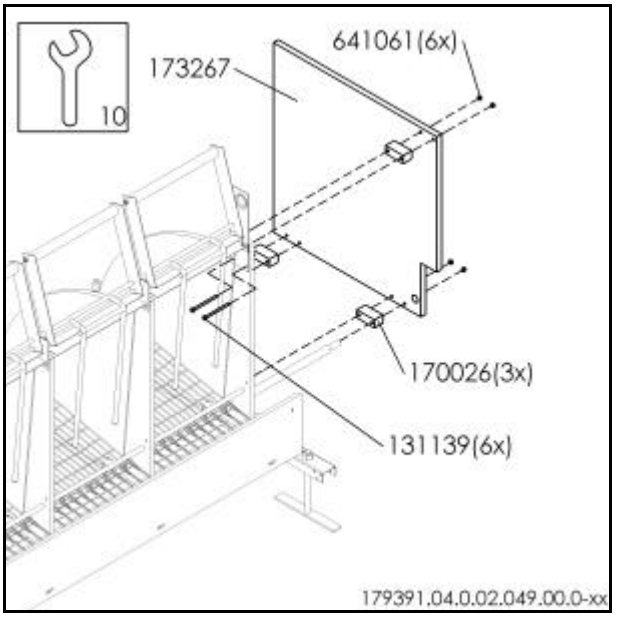


Do not saw out the marked rectangle in the end plate that is to be used for the drive unit side.

Copy the holes onto the separation board (173270), drill the holes in the separation board.

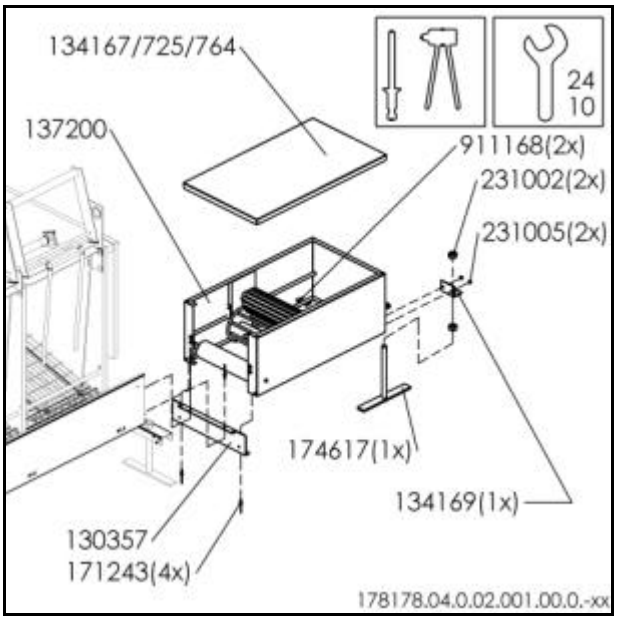
Fix the end plate (173267) with the plastic distance block (170026), bolt (131139) and lock nut (641061) to the separation board.





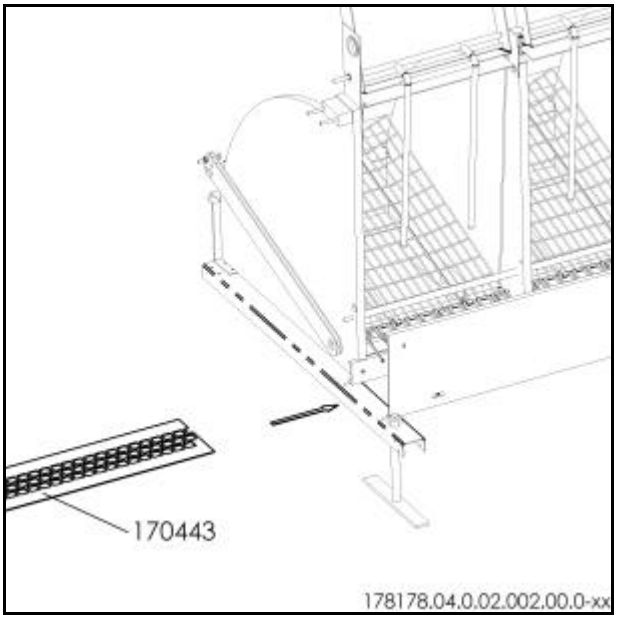
8.2 Return unit

8.2.1 Fixing return unit



1. Fix the Z-bracket return unit (130357) with the blind rivets (171243) to the return unit.
2. Hang the return unit (137200/1/2) in the Z-bracket return unit (130357), level the return unit by adjusting the bolt (231002) of the leg (174617).
3. Fix the leg support return unit (134169) with the bolt (911168) and the nut (231005) to the return unit (137200).
4. Fix the leg (174617) with the nut (231002) to the leg support return unit (134169), tighten the nuts by hand.
5. Fix the underframe with the blind rivets (171243) to the Z-bracket return unit (130357).
6. Check if the return unit (137200/1/2) is still level.
7. Tighten the nuts (231002).
8. Place the cover return unit (134167/725/764) on top of the return unit.

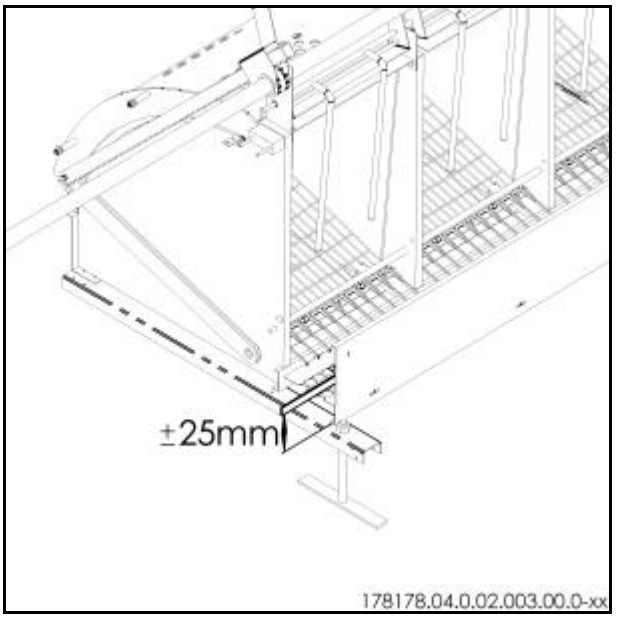
8.2.2 Fixing egg belt



1. Pull the egg belt PP (170443) over the belt support.

8.2.3 Fixing cellular tape

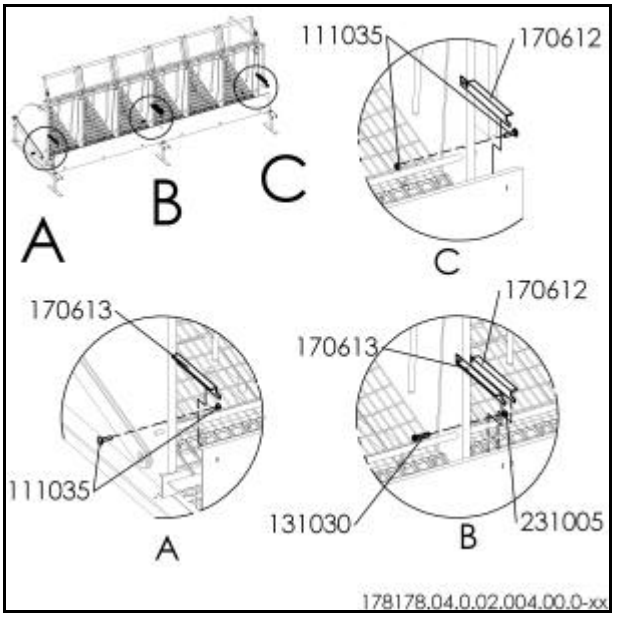
1. Stick the cellular tape (136016) ± 25mm from the bottom of beltguide high (170609) at the inside of the beltguide high.



8.3 Turkey nest

8.3.1 Fixing run-in plate underframe

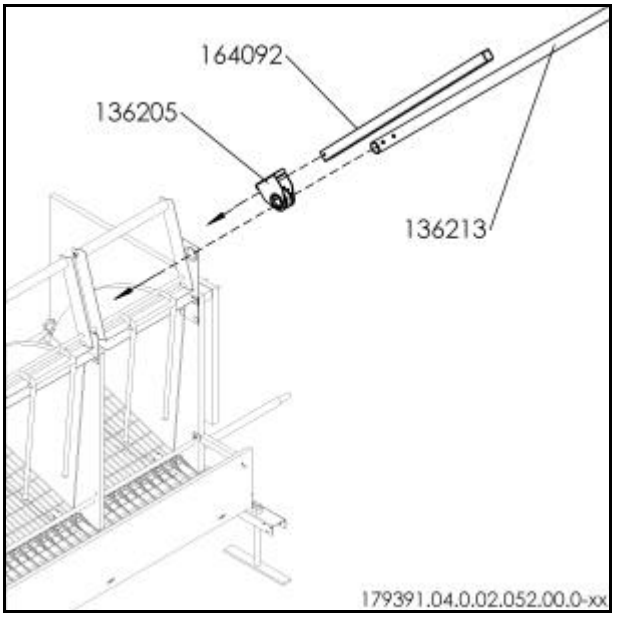
1. Hook run-in plate support right (170613) and run-in plate support left (170612) in the beltguide high (170609).
2. Fix the run-in plate support right (170613) and the run-in plate support left (170612) with the carriage bolt (111035) to the first and last separation board of a section.
3. Fix the run-in plate support right (170613) and the run-in plate support left (170612) with the bolt (131030) and nut (231005).



Make sure the traps are turned back downwards to their original position.

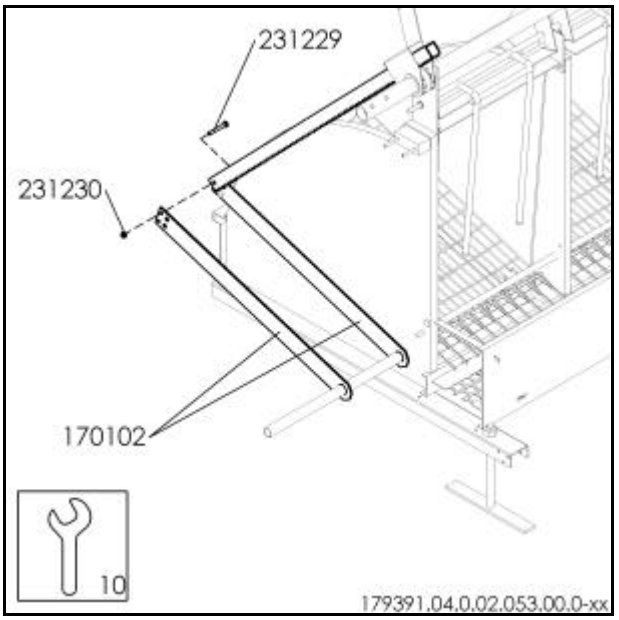
8.3.2 Fixing pinion house and geared rack

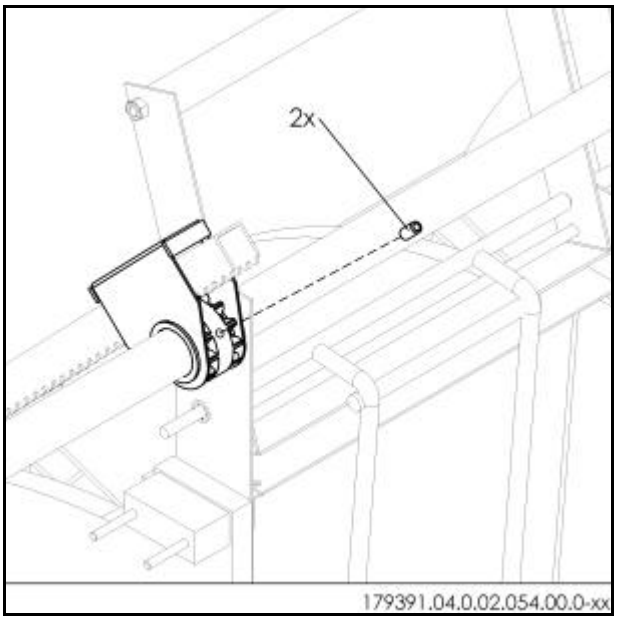
1. Slide the pinion house unit (136205) over the extentionshaft (136213).
2. Slide the extentionshaft (136213) through the bearing plate.
3. Slide the geared rack (164092) through the pinion house unit (136205).
4. Repeat this action at the beginning and end of every section.



8.3.3 Fixing geared rack

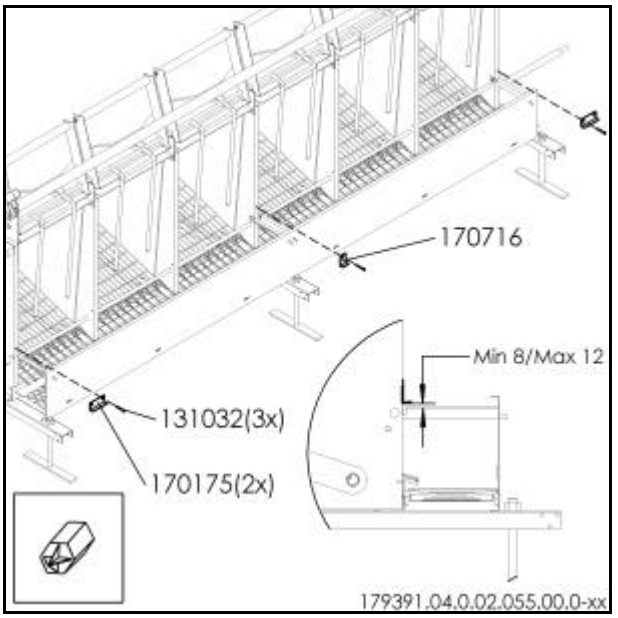
1. Fix the geared rack (164092) with the bolt (231229) and the nut (231230) between the side plates for floor (170102).
2. Secure the pinion house unit (136205) to the extention shaft (136213) by fastening the setscrews of the pinion house unit (136205).
3. Repeat this action at the beginning and end of every section.





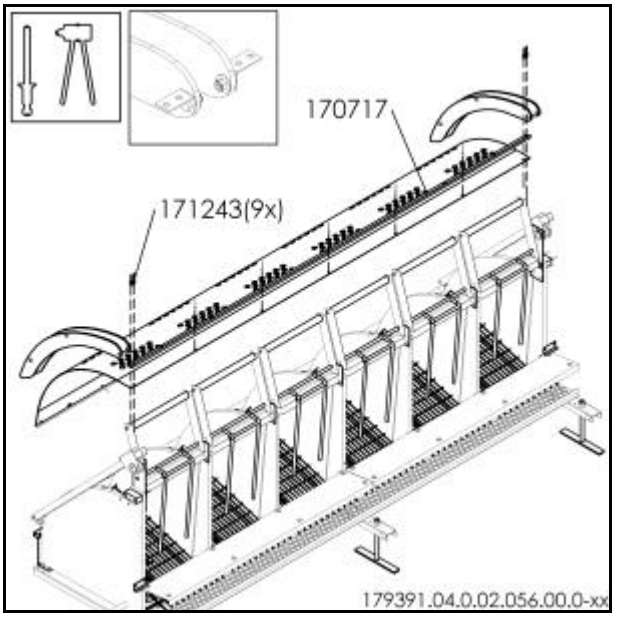
8.3.4 Fixing locking plate for run-in plate

1. Fix the locking plate for run-in plate (170715) with the screw for chipboard (131032) to the first and last separation board (173270) of the section.
2. Fix the locking plate for run-in plate (170716) with the screw for chipboard (131032) to the center separation board of the section. Fasten the screw for chipboard by hand.
3. Turn the locking plate for run-in plate (170716) 90° so that the locking plate for run-in plate is pointing up.



8.3.5 Fixing backwall

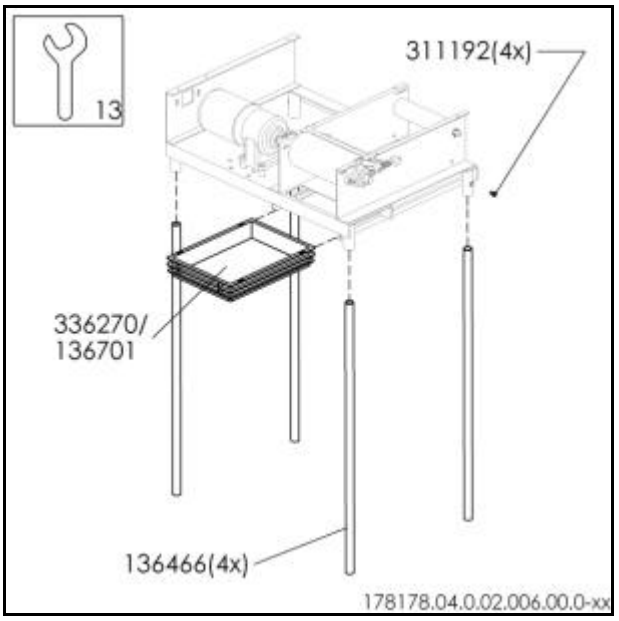
1. Fix the fastening corner backwall top (170717) with the blind rivets (171243) to the pre assembled backwall.
2. Fix the pre assembled segments with the blind rivets (171243) to the pre assembled backwall, make sure the segment fixation bracket is up.



8.4 Drive unit

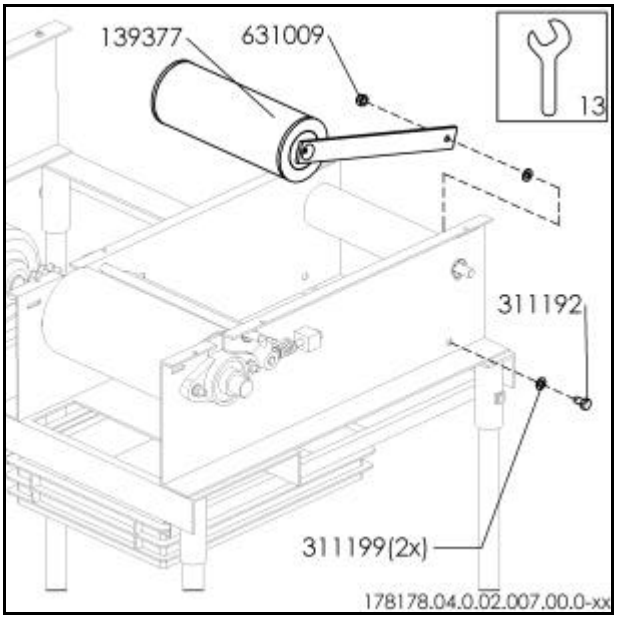
8.4.1 Fixing legs and dirt tray

1. Fix the legs (136466) to the drive unit.
2. Slide the dirt tray (336270/136701) under the drive unit.



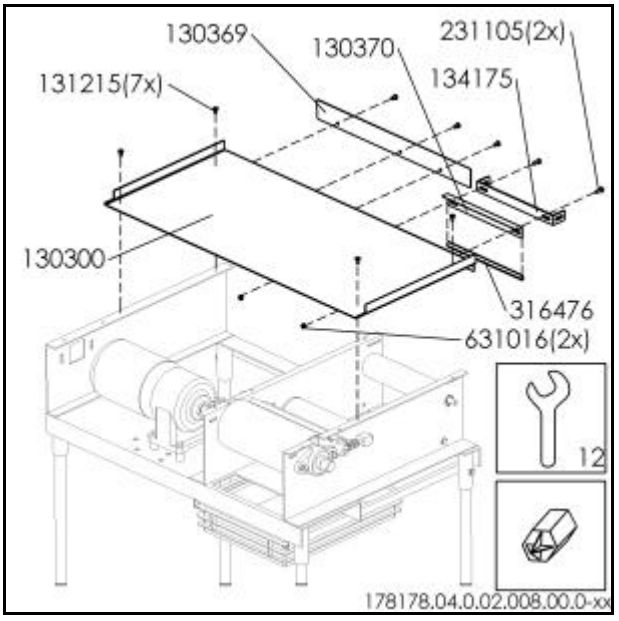
8.4.2 Fixing weight roller

1. Fix the weight roller (139377) with the bolt (311192), the washers (311199) and the lock nut (311192) to the side of the drive unit.



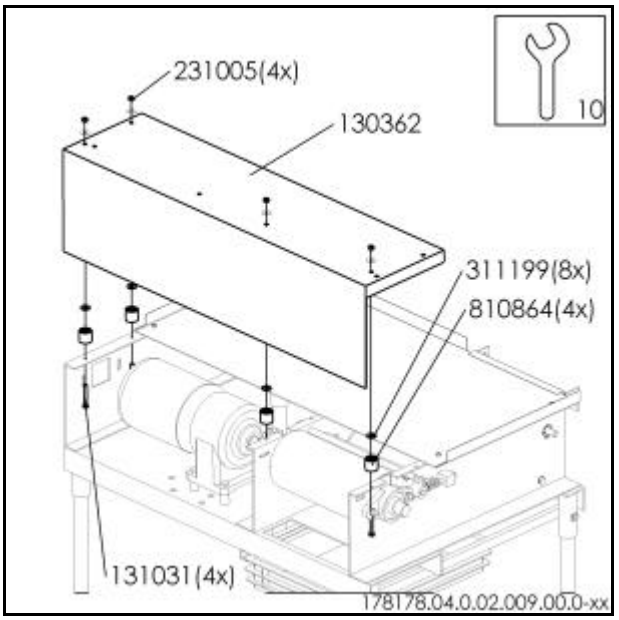
8.4.3 Fixing drive unit

1. Fix the table top (130300) with the screw (131215) to the drive unit.
2. Push the slidingstrip (316476) on the protecting angle (130370).
3. Fix the protecting angle (130370) with the slidingstrip (316476), the connecting strip table/beltguide (134175), the bolt (231105) and the nut (631016) to the table top.
4. Fix the alu strip (130369) with the screws (131215) to the table top.



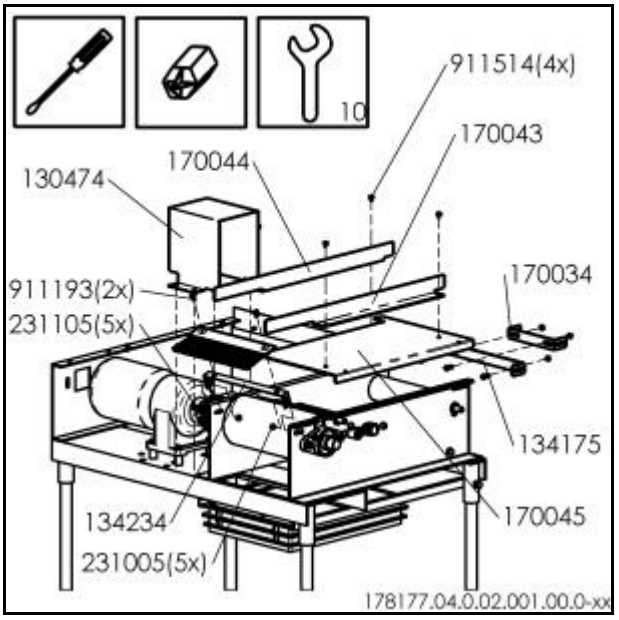
8.4.4 Fixing guard for drive unit

1. Fix guard for single drive unit (130362) with the bolt (131031), washer (311199), plug (810864) and nut (231005) to the drive unit.



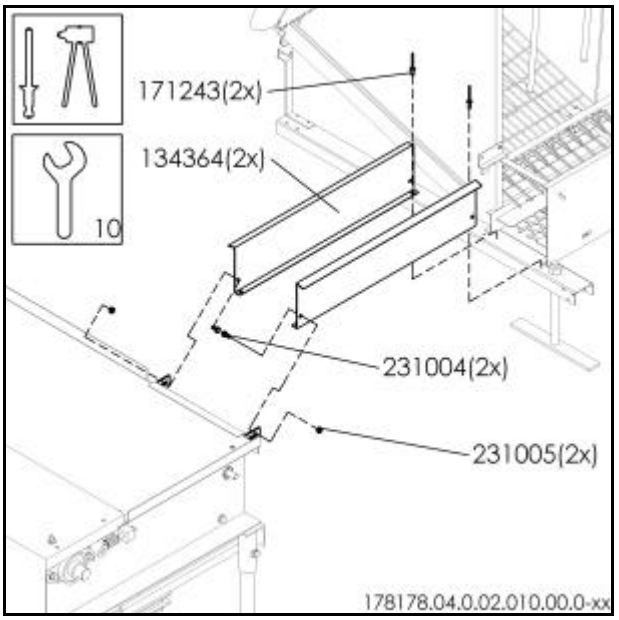
8.4.5 Fixing drive unit with transfer

1. Fix the dirtplate (170045) to the drive unit.
2. Fix the egg guide left (170043) and the egg guide right (170044) with the screws (911514) to the drive unit.
3. Fix the connecting strip table beltguide (134175) and support wall duct (170034) with the bolt (231105) and nut (231005) to the drive unit.
4. Fix the bracket for brush lath transfer (134234) with the bolt (231105) and nut (231005) to the drive unit.
5. Fix the brush lath transfer (135043) with the screw (911193) to the bracket for brush lath transfer (134234).
6. Slide the protecting cover (130474) over the motor



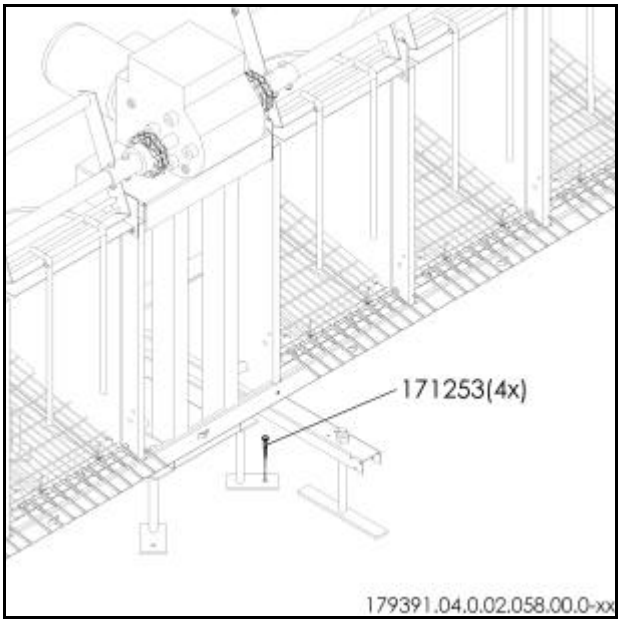
8.4.6 Fixing beltguide walkover

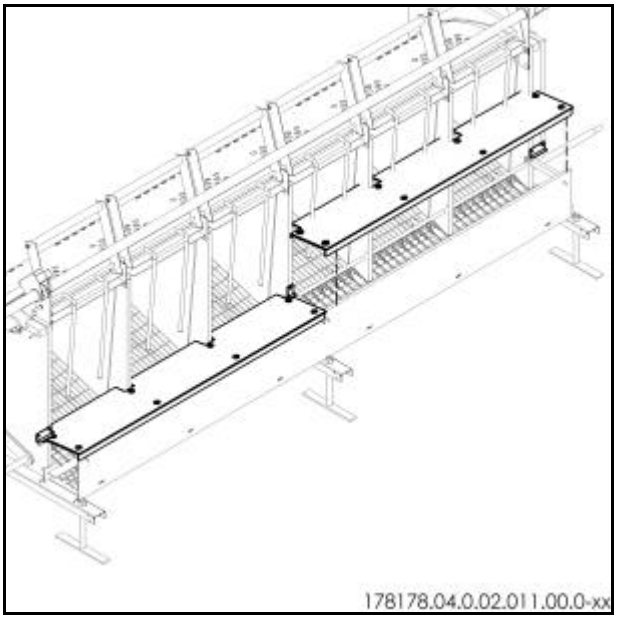
1. Fix the beltguide walkover (134364) with the blind rivets (171243) to the underframe of the section.
2. Fix the beltguide walkover (134364) with the bolts (231004) and the nuts (231005) to the drive unit.



8.4.7 Fixing run-in plate

1. Tighten a string between the frst and the last section of a row.
2. Check if the whole row is in alignment.
3. Fix the motor with the anchor bolts (171253) to the floor.
4. Test if the installation is working correct.
5. Place the pre assembled run-in plate on the run-in plate support.
6. Turn the locking plate (170716) back 90° so that the run-in plates are secured. Seie “Fixing locking plate for run-in plate”.

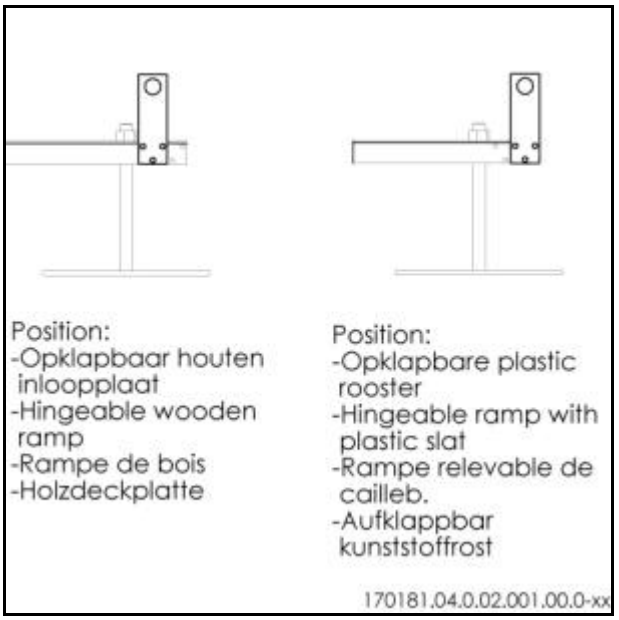


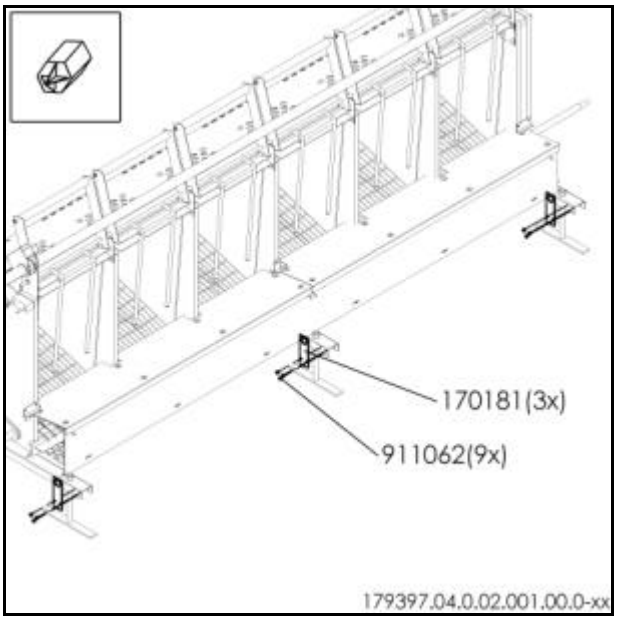


8.5 Run-in grid

8.5.1 Fixing bracket grid

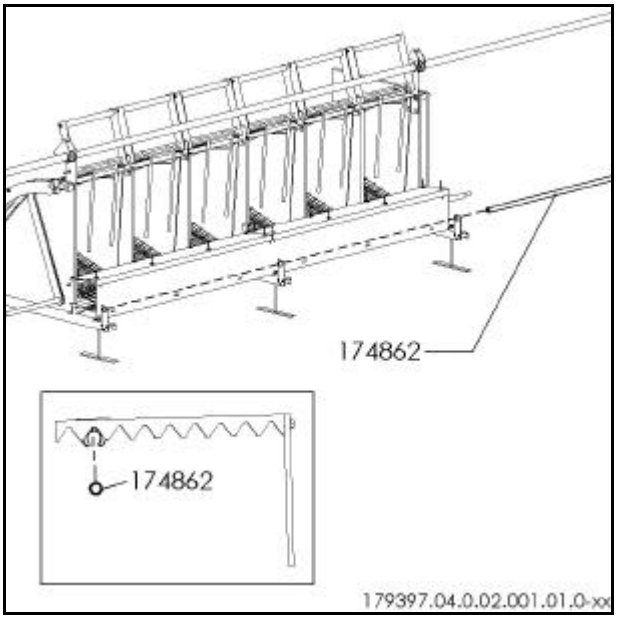
1. Fix the bracket grid (170181) with the taptites (911062) to the underframe.





8.5.2 Fixing hingable run-in grid

1. Slide the ½" tube (174862) through the bracket grid.
2. Place the hingable run-in grid by clicking the clips over ½" tube.



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