FEEDERS
Installation Manual

INDIV

Equipamiento para avicultura

INDIEX

1. ASSEMBLY OF THE FEEDERS.

1-1. GENERAL DESCRIPTION.

The feeder lines are characterized because of having transverse feeding at the end of the breeding house.

Next, items that constitute the feeding transverse line from the storage silo up to the longitudinal lines will be described:

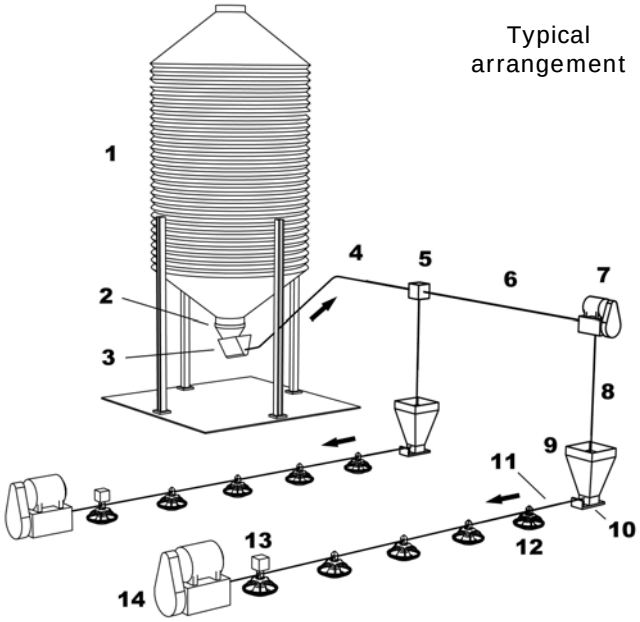
1-2. Automatic Fill System.

1- Silo
2- Discharge boot 30º**(1103459).**
3- Silo unloder **(11084500).**
4- PVC curve **(110CURPVC75).**
5- Intermediate drop **(BAJINTERM).**
6- PVC tube 57x6m **(110TUPVC756M).**
7- Drive unit **(1109273).**
8- Final drop **(BAJPRINC).**

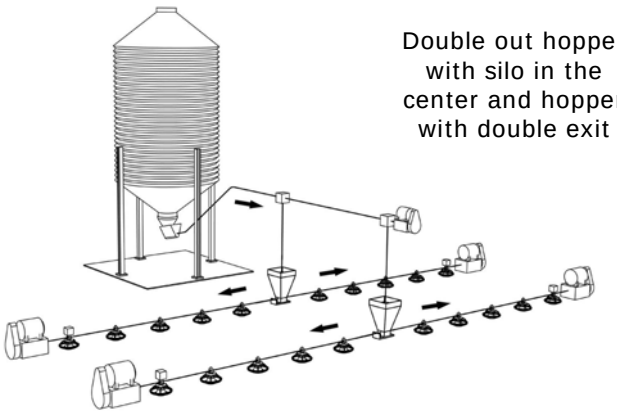
1-3. Longitudinal line

9- Hopper extensión **(11088330-I).**
10- Hopper base **(11082380-I).**
11- Auger pipe **(1108870-I).**
12- Feeder pan **(ARG-MAXPLUS-2010).**
13- Control pan **(1101045).**
14- Drive unit. **(1101020-25A).**

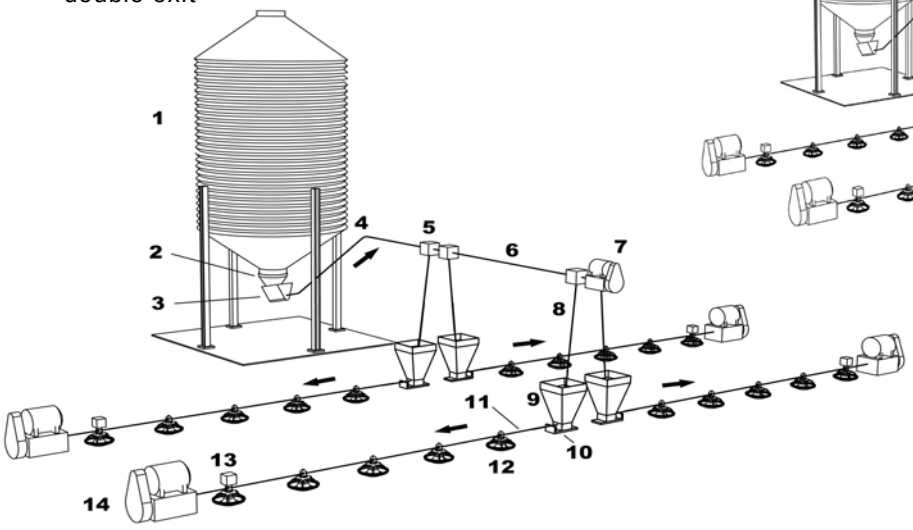
Typical arrangement



Double out hopper with silo in the center and hopper with double exit



Double out hopper with silo in the center and hopper with double exit



2. LONGITUDINAL LINE.

2-1. ASSEMBLY OF FEEDER LINE AUGER TUBES.

The line of auger tubes for the feeder houses the auger that drags the food to each of the individual pans.

VERY IMPORTANT:

" The first tubes of the drive unit has three holes and the other tubes 4 holes in each"

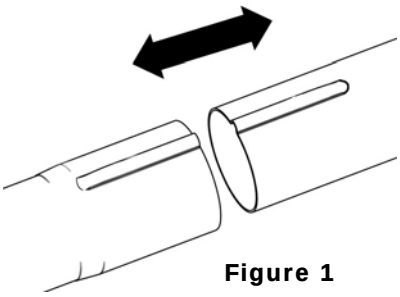


Figure 1

The tubes have to be assembled among them by matching the notches ant their ends (male tube into the female end of the next tube) (fig.1).
The feeding holes are located on the opposite side of the assembling slots. After that, the user has to verify visually that the assembling slots are properly aligned, this would certify that the discharge holes are aligned (fig.2).

"A deviation in the alignment of the feed holes can cause an incorrect filling of the pans."

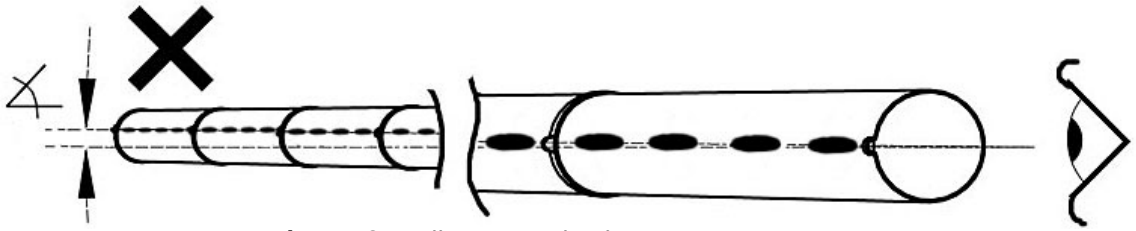


Figure 2 – Alignment Check

Once the tubes are assembled and the discharge holes are upwards, raise the blocking tabs. They are located on the discharge holes on each tube.

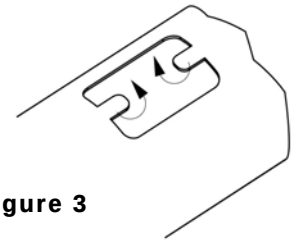
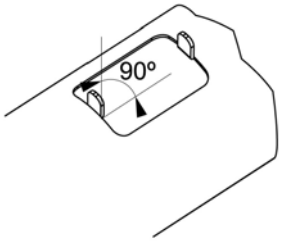


Figure 3

These tabs prevent the pans from sliding along the length of the tube, Consequently, the holes on each tube discharge the food freely on each pan.

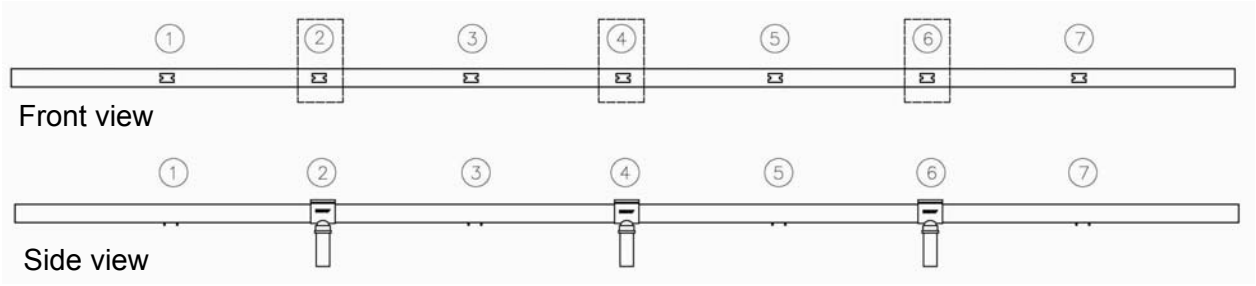


Once the assembly is completed**,** line will be turned leaving the holes facing down and the assemble slots facing up.

2-1-1. Installation of the CHICK- MATES

If the feeder is provided with CHICK-MATES (discharge the food on the “mother zone” for the baby chicks), the assembly of them will be the following:

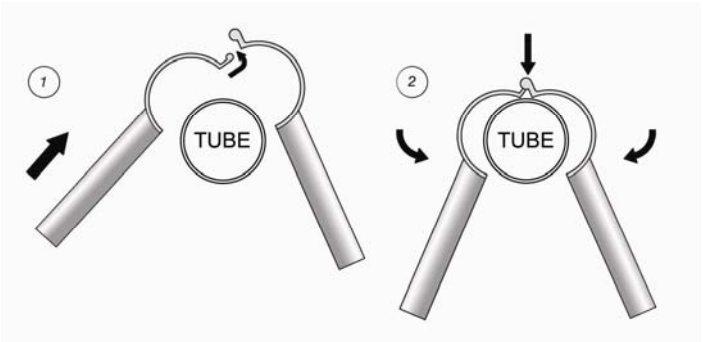
LOCATION OF CHICK MATE



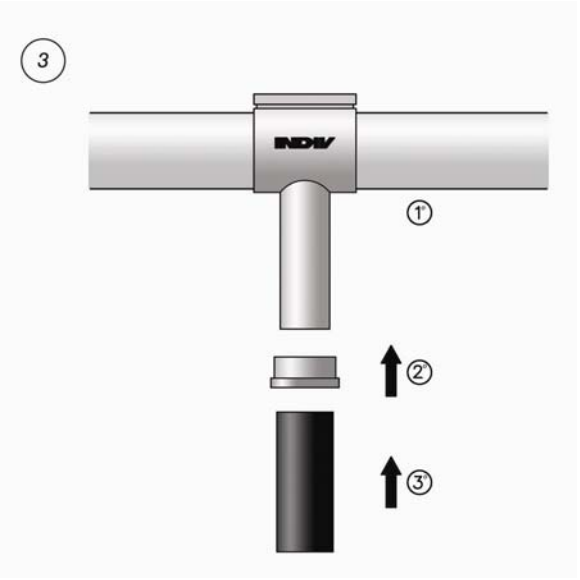
IMPORTANT

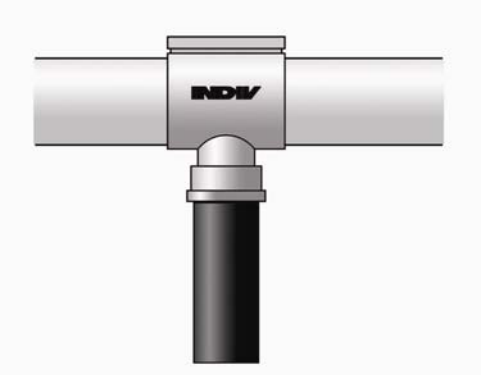
THE OPEN TABS 2, 4 AND 6,SHOULD NOT BE FOLDED IN ORDER TO BE ABLE TO WORK WITH THE CHICK MATES PROPERLY

ASSEMBLY SEQUENCE



FINAL MODEL





2-2. ASSEMBLY OF THE DRIVER UNIT.

The driver unit has to spin the auger that drags food from one side of the line to the other.

Food falls through every hole in the tube and fills the line from the feeding hopper to the driver unit.

The same is assembled at the end of the feeder line, consequently, it is located at the opposite end of the transverse feeder that comes from the silo.

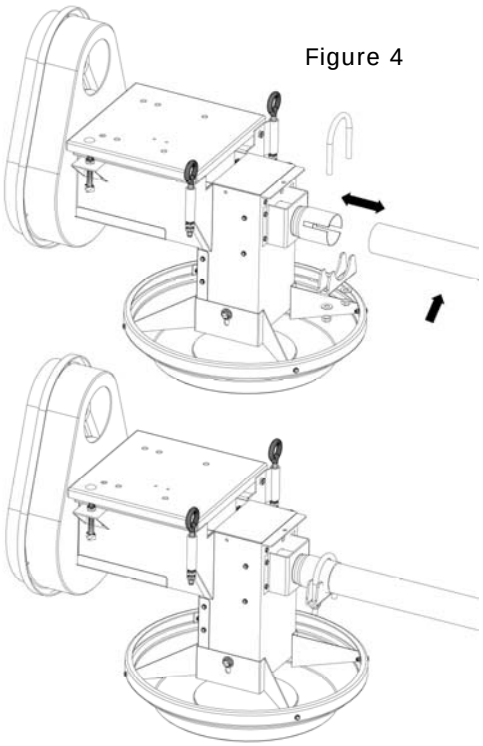
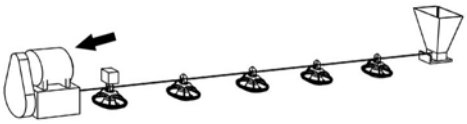


Figure 4



2-2-1. Recommendations:

- **Do not connect the engine** until the auger is connected with the axis of the driver unit.

- Once it is assembled the driver unit to the tube, **align it with itself** and hold it tightly with **the clamp (A1)** (Ver Fig.4).

- **In order to assemble an electrical engine**, open and remove the impulse stopper. Here, remove the nut and the external screw that hold the stopper.(the other screw is not removed because it is pressed tightly with the pulley cover) (fig.5)

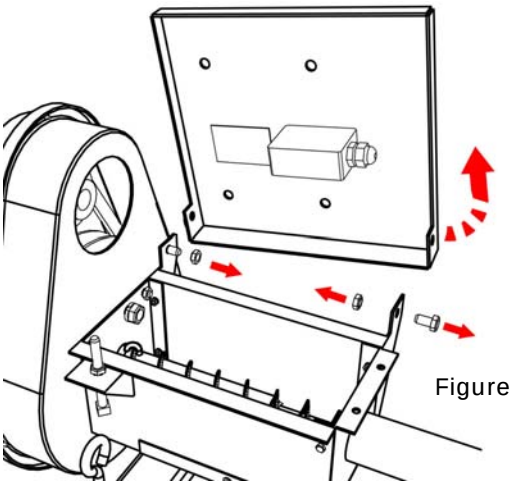


Figure 5

After that, put the engine to the top and reassemble the top to the unit.

- **Assembly** of the pulley and the belt, remove the top that covers the pulleys (1). Put the small pulley on the shaft of the engine, align it with the big pulley and then fix it to the axis of the engine. Assemble the belt and tighten it with the pin (2) (figure 6)

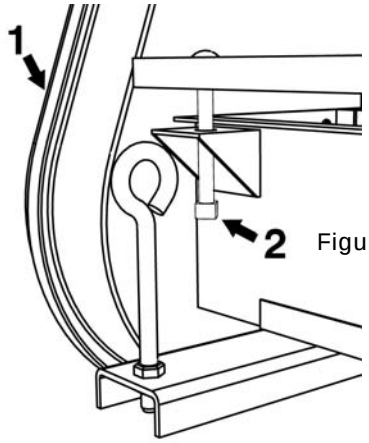
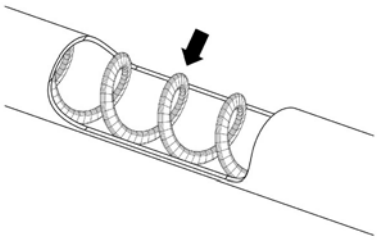


Figure 6

Once again put the top on the pulley cover.

2-3. INSTALLATION OF THE AUGER INSIDE THE AUGER TUBES.

The **auger** has to drag food along the feeder line. For its installation we strongly recommend the use of **three workers** and follow these steps.



IMPORTANT:

" Wear protection gloves during the entire procedure"

2-3-1. Procedure:

01- Place the roll of THE AUGER about 3 or 4 m in front of the end of the auger tubes (end of the hopper line).

02- One worker will lift the AUGER so that the spirals do not interconnect with other spirals in the roll.

03- The second worker will be in the middle of the distance between the roll and the end of the tubes, to help line up and facilitate the insertion of the AUGER into the tubes.

04- The third worker will insert the AUGER taking care not to pinch the fingers against the tube in the process.

05- Insert the AUGER coordinating the movements, until it meets the end of the drive unit.

06- Attach the AUGER to the shaft of the drive unit using the set "restraint block" (see figure 7) made up by the safety clamp **(A)**, the screw **(B)** and the self-locking nut (c).

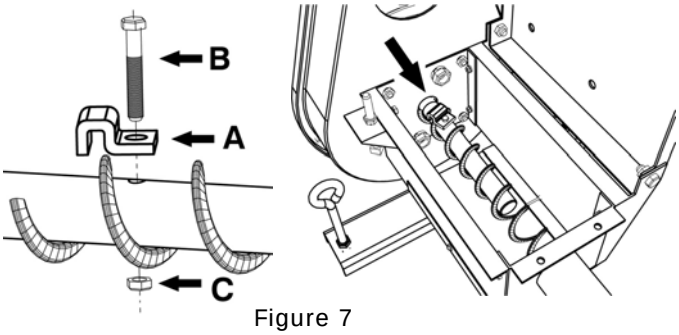


Figure 7

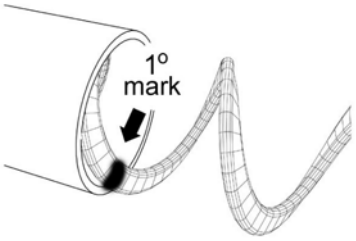
"Incorrect assembly could produce a disconnection of the auger."

07- Relax the auger inside the tube to avoid non- uniform tensioning in any part of the tube.

Consequently, the user should stretch the auger firmly from its entrance towards outside and jump it abruptly. This action produces a settling and relaxation of the AUGER along the length of the tube.

08- Repeat the operation 4 or 5 times.

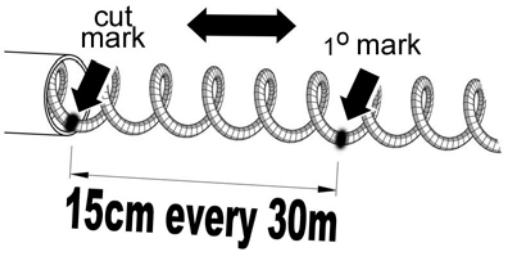
09- With the auger rested in the tube make a first mark inside it, making reference to the place where the tube goes.(with a piece of chock or marker).



10- Stretch the auger 15 cm every 30 m of line length and mark the auger again at the edge of the tube.

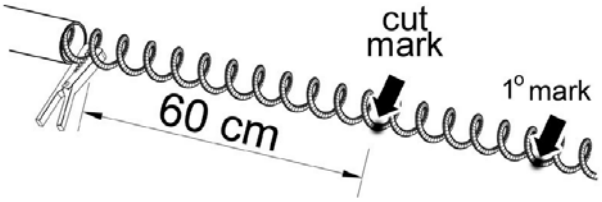
Example:

In a 90m length line, the auger should stretch 45 cm to the outside.



11- Stretch the auger approximately 60 cm and block it against the tube so that it does not go back inside the tube.

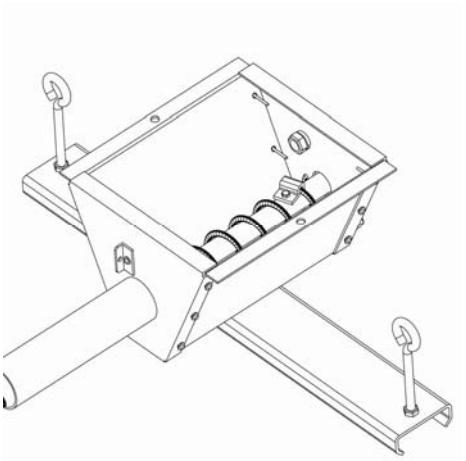
12- Cut the auger at the cutting mark.



13- Place the HOPPER BASE at the end of the auger.

14- Attach the auger with the lock dice to the shaft of the hopper base with the same criteria that was used to attach the auger to the impulsion shaft of the line**.**

15- Assemble the hopper base, holding it firmly and unblock the auger from the tube, being careful with the entrance and the end assembly of the unit and the end of the lie of tubes.



2-3-2. Procedure for welding auger.

First, make sure that the sections of auger to be welded are NOT bent or curved, otherwise, once welded, the two parts may not be properly aligned with each other and will not take the proper form, causing premature wear to the auger tube. If after welding the auger seems to be curved, that section must be cut and welded again.

The steps to follow are:

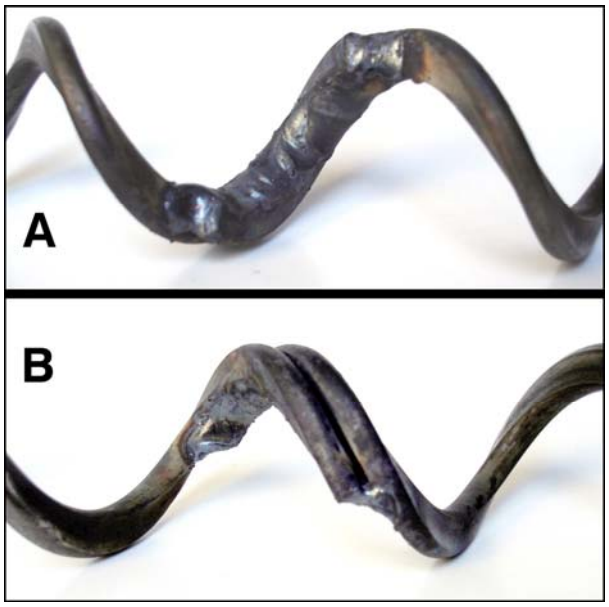
1- It is recommended that the end of the pieces to be placed on a piece of angle iron, approximately 1meter long. Hold the pieces with clamps or vice grips to assure a proper line up of the parts.

2- Overlap the parts 3 or 4 cm, as shown in figures A and B. be sure that once overlapped, the parts maintain the form of the auger.

3- Proceed to weld the part from the inside of the auger, making a continual weld. After welding let it cool with air.

4- Verify that the par remaining is correctly aligned one with the other.

5- File, if necessary, the welded surfaces, after cooling.



IMPORTANT:

It should not be welded over the curve of the auger to avoid a flange may wear the auger tube.

NOTE:

To weld, you can use a blue point electrode 2 or 2.5 mm in the diamter and amparage in the welder between 150 and 200 amps.

2-4. INSTALLATION OF THE HOPPER EXTENSION.

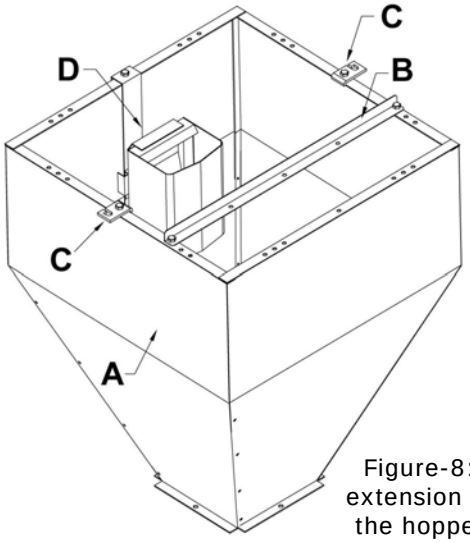


Figure-8: extension of the hopper

The extension of the hopper set should be made up of the following things:

1- Hopper face (extended)**(155W110).**

2- Fixing bar for the telescopic **(155W096).**

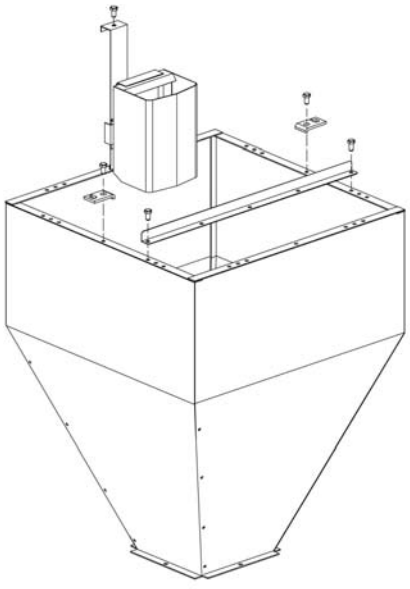
3- Hanging "G" to maintain the hopper in the vertical position **(155W044).**

4- Hopper level control (110720011).

IMPORTANT:

- When the hopper extension is made up the screws should be put from the inside out (the nut in the outside).

-The hopper extension should be made up when the hopper base is assembled.



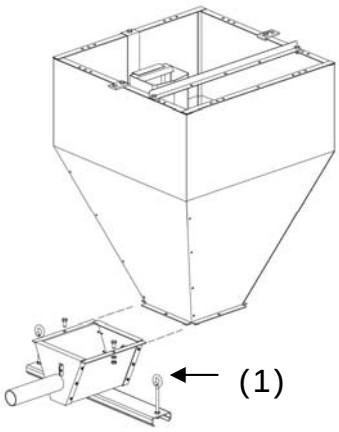
Installing procedure:

Once hanged in the feeder line

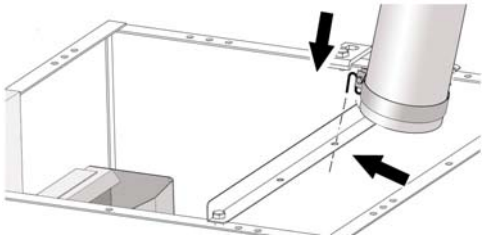
1- Snap on the set of **the hopper extension and the hopper base**, sliding it trough the guidelines inside the hopper.

2- Fix the hopper extension to the hopper base with screws.

3- Thread the eyebolt suspension cable (1) of the base through the "G" of the hanging extension of the hopper, previously assembled.



If the feeding line is already assembled, **put the feeling telescopic**, putting a hook in the inferior end of itself through the most convenient hole in the extension bar of the hopper.

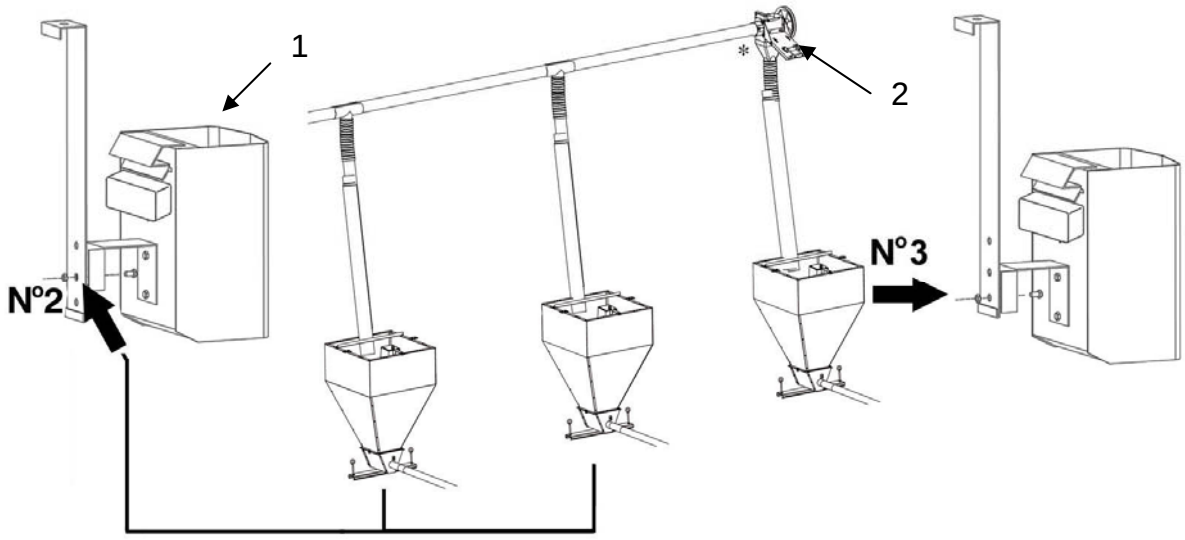


The position of the hopper level line and the discharge tube has to be such that the food fills the control and starts the micro switch properly.

See the specifications of the installation attached at the end of the manual

2-4-1. Assembly of the control level of the hopper.

For the proper working of the filling system of the hoppers, the position of the level control of each hopper is very important (1).



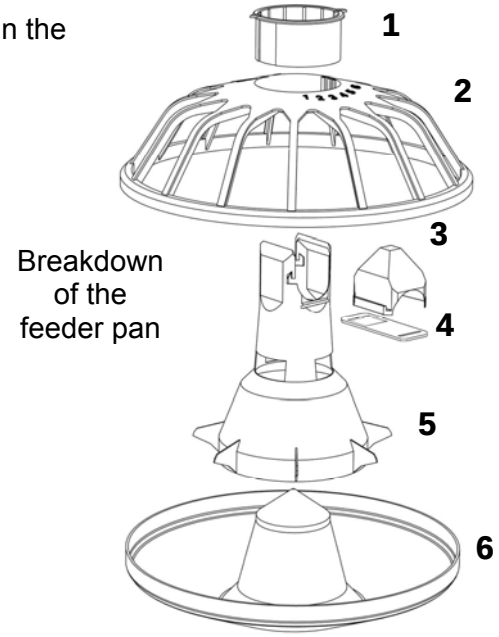
- The control level of the hopper has to assembled below the transversal driving, should be located in the ***inferior hole(nº4)*** of the assemble perch.

- In the ***rest of the lines***, the control level of the hoppers should be located in ***hole nº 2*** of the assembly perch.

2-5. ASSEMBLY OF THE FEEDER PAN.

2-5-1.MAX PLUS FEDEERS

The feeder pan is made up of 5 pieces shown in the figure.



Breakdown of the feeder pan

1- Collar **(110PL-1013).**
2- Grill **(110PL-1016).**
3- Cone top **(110PL-1010).**
4- Open and close valve **(110PL-1011).**
5- Center cone **(110PL-1012).**
6- Pan **(110PL-1014).**

2-5-1-1. Assembly process.

01- Put the arrow in the collar with nº3 in the grill.

02- Over a flat surface, take the collar firmly and push down until it is stuck in the grill like in figure 1.

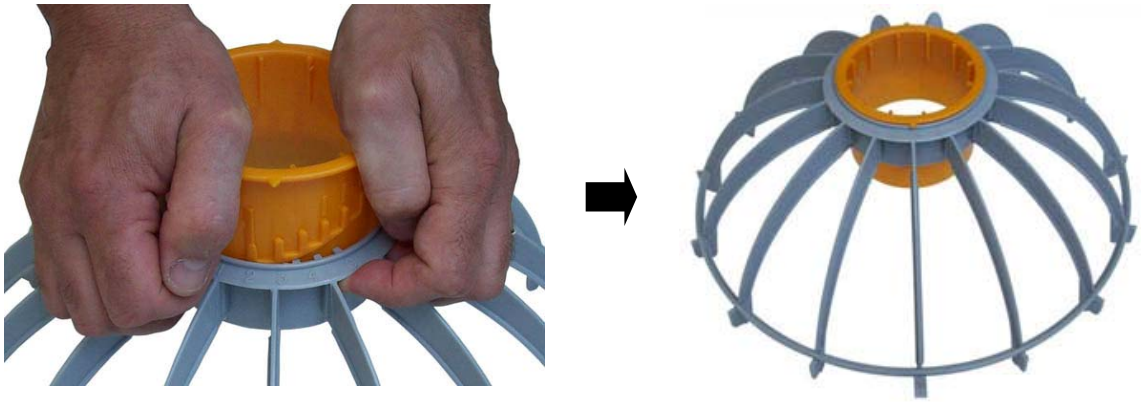


Figure 01: **collar inserted in the grill**

03- Hook the grill with the pan.

04- Insert the center cone.

05- Take the grill and close its inferior part in such a way that the inferior edge of the pan is inserted.

"An incorrect assembly of the grill to the pan can bring up serious inconvenient with its performance"

06- Finish by coupling the hooks of the grill to the pan.

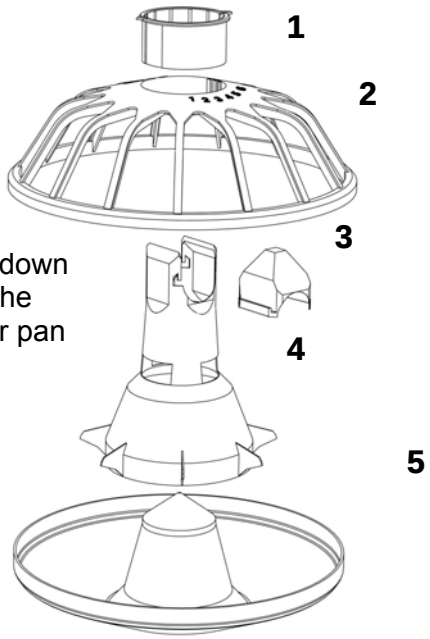
07- Put the open and close valve.

NOTE:

*For **breeding** adjust the level to **position number 1** (arrow in position 1).*

2-5-2. MAX GROW FEEDERS.

The feeder pan is made up of 5 elements that are shown in the following picture.

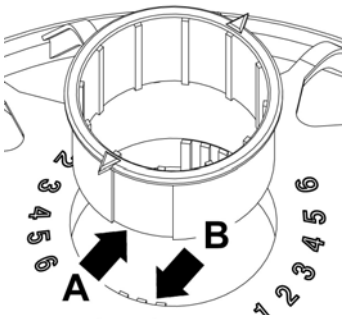


Breakdown of the feeder pan

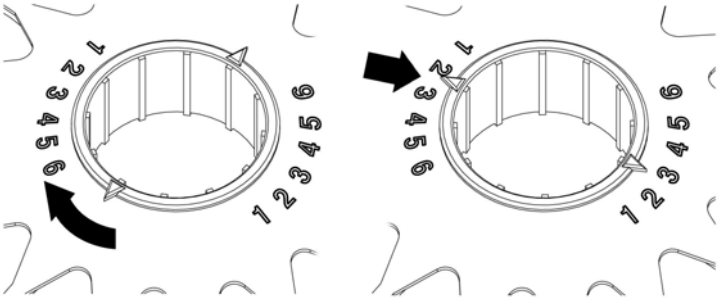
1- collar (110PL-1001).
2- grid (110PL-1015).
3- Lid. Feeder pan(110PL-1004).
4- central cone (110PL-1002).
5- pan (110PL-1003).

2-5-2-1. Assembly process

01- Assembly the feeder regulation collar in the grid. In order to do this, the crack in the collar A and the guiding stripes in B must coincide, these are located in the interior face of the opening of the grid.



02- Twist the collar strongly until the arrows of the edge of the collar are positioned in the food number regulation area of the grid. One can be helped putting a cone from top inside the collar to obtain a better twist.

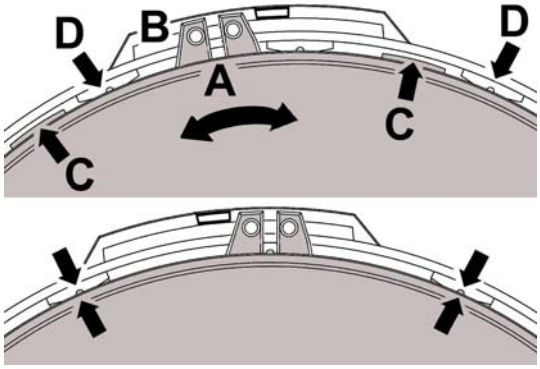


03- Put the central cone inside the pan.

04- Assemble the grid in the pan .

"*An incorrect assembly of the grid to the pan can create a great number of problems in its development*"

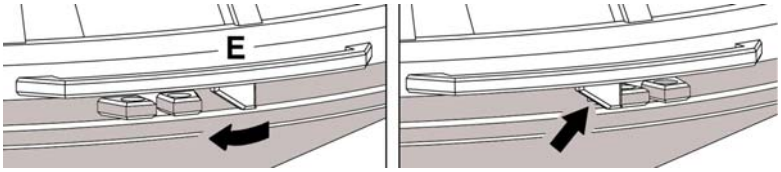
Having a look to the pan from below one has to place the blocking tabs binding of the plate " A" on the left end of the binding of the grid " B" (figure 1) in this way the interior tabs of the grid "D" gets inserted in the exterior tabs of the pan.



Once the pan is perfectly located, twist it strongly, in such a way that the tabs of the pan get below the tabs of the grid until the anti twist wedge "E" gets to the other side of the tabs of the biding.

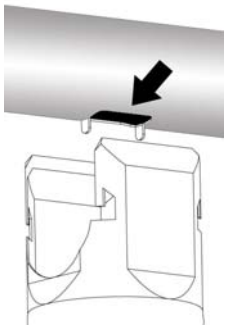
05- Put the biding

06- Momentarily put the toe of the cone in the central cone (in order not to loose it)until the pan is assembled in the line of tubes.

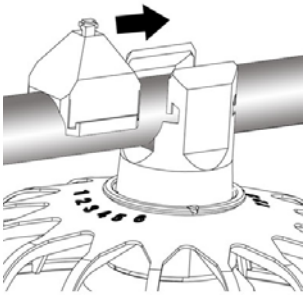


2-6. ASSEMBLY OF THE FEEDER PANS O.

In order to assemble the feeder pans to the feeder line the following steps need to be followed..

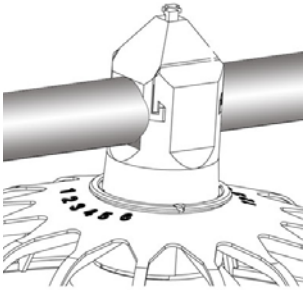


1- **Put the assembled pan** without the cone top, below the feeder line **making it coincide with the inferior opening and its tabs** (folded previously) with the superior cone opening.



2- **Put the superior cone top** of the feeder in the tube, on one side of the cone.

3- **Slide the top to the cone** assembling it completely through the insert guides that exist for that end.

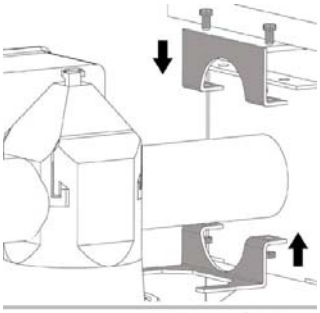


It is very important than the top lid of the cone fits completly centered on the cone.

2-6-1. Assembly of the control pan of the feeder.

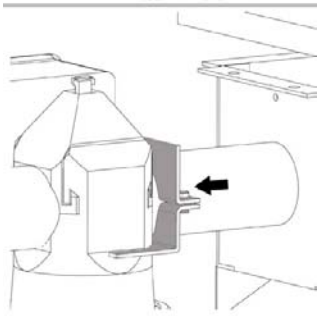
VERY IMPORTANT:

*He assemble of the line control pan, the same steps that were used to assemble and ordinary pan should be followed. this time **two clamps** will be used (supplied with the control pan) **one on each side of the neck of the pan** to preven it from spinning. conseuently it will remain in its vertical position and the food will fall freely.*



Procedure

1- **Place both halves of the clamp** as shown in the figure and then put it close to the pan in such way that the nails in the inferior half blocks the cone of the pan.



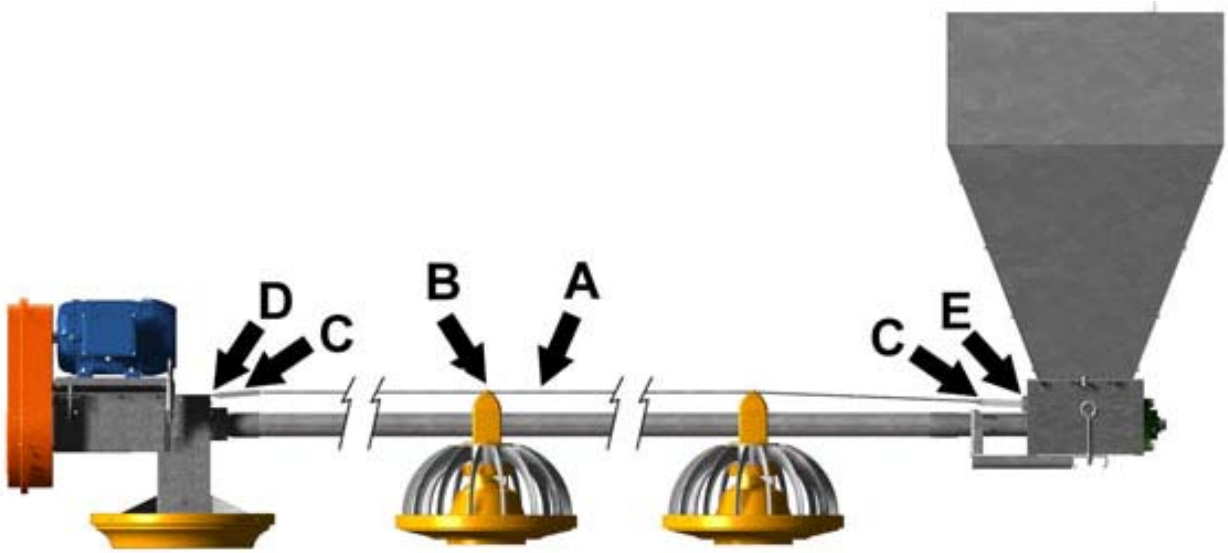
2- **Fasten the screws** to the clam to press it against the tube.

IMPORTANT:

"Putting a lamp over each pan is advisable, to be sure that they will be properly lighted"

2-7. ASSEMBLY OF THE ANTI -PERCH CABLE IN THE FEEDER LINE.

Once the line is assemble an anti-perch cable (A), made of galvanized steel Ø1/6mm **(1605192)** is put along the whole line making it go through the upper part of the cone of every feeder **(B)** and using the springs **(C).**



At the end of the engine the spring has to hold the central hole and the engine **(D).**

At the end of the hopper the hole of the sheet in “L” is held place in the hopper body. **(E).**

3. TRANSVERSE LINE.

3-1. GENERAL DESCRIPTION.

The feeder lines are characterized because of having a transverse feeding at the end or in the middle of the breeding house.

Typical cross line

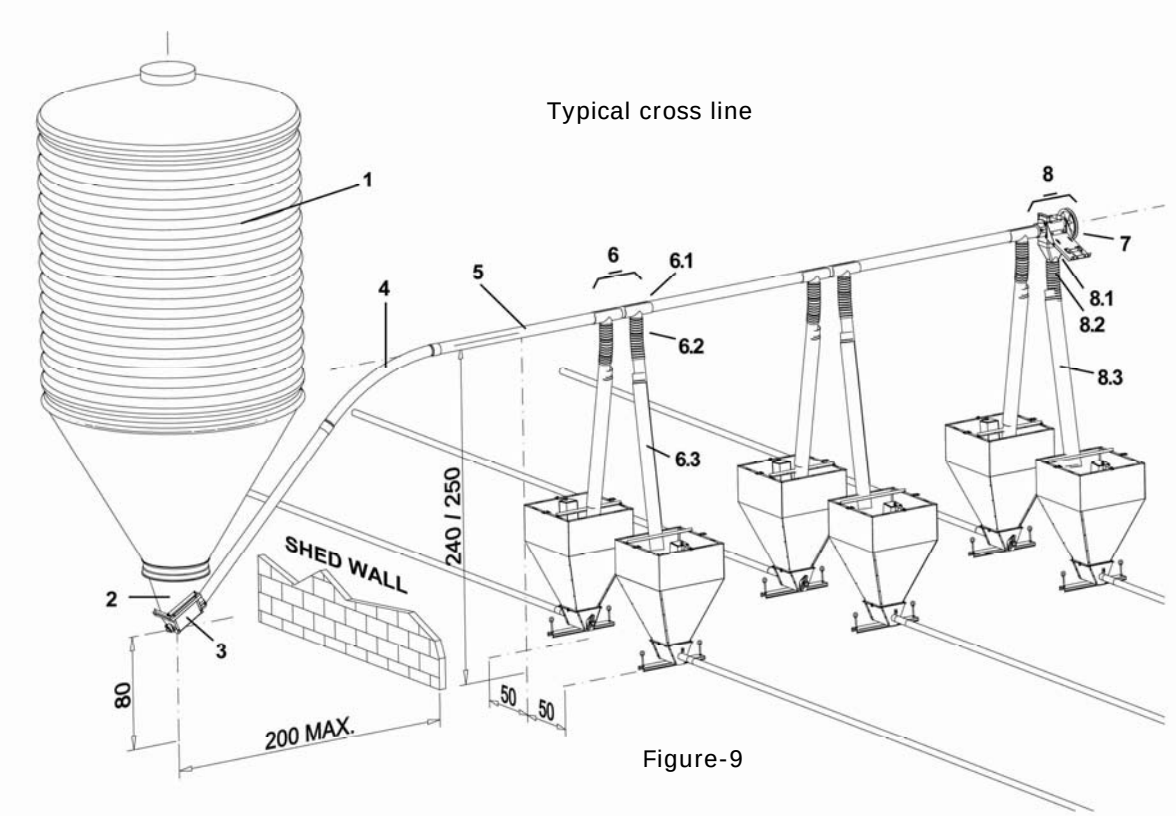


Figure-9

In the following graph the elements that make up a transverse line are numbered and shown. The feeders located in the middle of the house and longitudinal feeding take the food towards both sides of the house using individual hoppers.

"The measurements are only suggestions and are in centimeters".

3-1-1. Items that make up a transverse line.

1- Silo.
2- Discharge boot **(1103459).**
3- PVC elbow **(simple: 11084500-1;pasante:11084501-1).**
4- PVC elbow **(110CURPVC75).**
5- Tube, 6cm **(110TUPVC756M).**
6- Intermediate drop **(BAJINTERM).**
6.1- Tee **(110TPVC75).**
6.2- Flexible tube **(110FLEX75350).**
6.3- Telescopic tube **(110TELES75-1).**
7- Drive unit **(1109273-1).**
8- Final drop **(BAJPRINC).**
8.1- Drive hopper **(110BOTRANS).**
8.2- Flexible Tube **(110FLEX75350).**
8.3- Telescopic tube **(110TELES75-1).**

3-2. ASSEMBLY OF THE SILO UNLOADER.

In the silo discharge, the Plastic discharge boot **(A)** and the unload hopper **(B)** are interconnected (see figure 10).

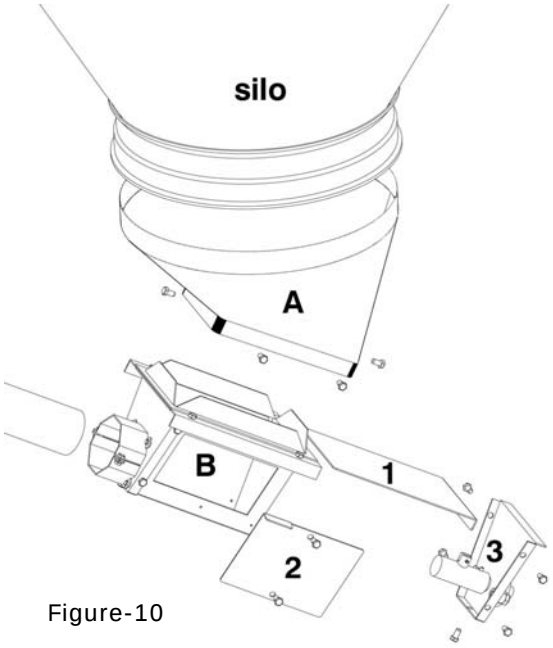


Figure-10

Procedure:

1- Attach the boot to the silo. this procedure may very according to the silo that is being installed.

At **this point it is important to avoid possible water leaks to the inside of the boot**.

2- **From the unloader hopper (B), remove** the cover plate (1), the side inspection panel (2) and the bearing holder (3)**.**

3- **Firmly attach** the body **of the unloader** (b) to the lower opening of the plastic boot (a).

4- **Make 6 holes** of 9mm in the unloader with the plastic boot- two on each long side and two on each short side.

5- **Attach the unloader to the plastic boot with bolts**, placing the flat washer on each bolt to protect the plastic boot.

3-3. ASSEMBLY OF THE TRANSVERSE LINE.

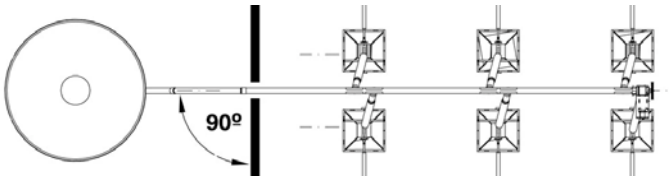
Depending on the elements available in the assembly, the assembly may begin having as a reference the place of the silo or the place of the hoppers in the feeder lines

3-3-1. General recommendations.

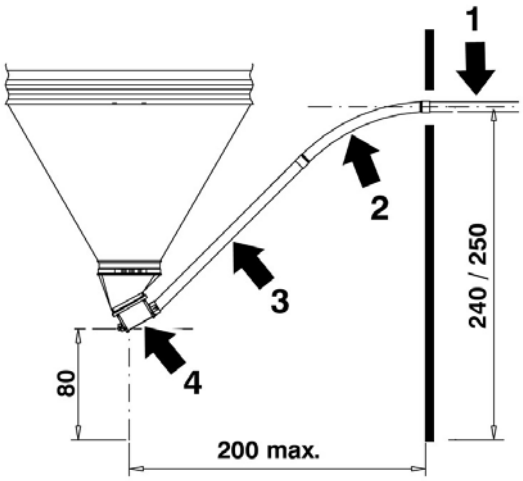
The following are general recommendations that **should be followed if the house assembly** allows it.

"The measurements are suggested and are in centimeters"

1- The transverse tube should be aligned **with the shaft of the silo** and come in or out in a perpendicular way to the house**.**



2- The height to assemble the transverse tube (1) will be **around 240 or 250 cm** in relation to the **interior floor** of the house**.**

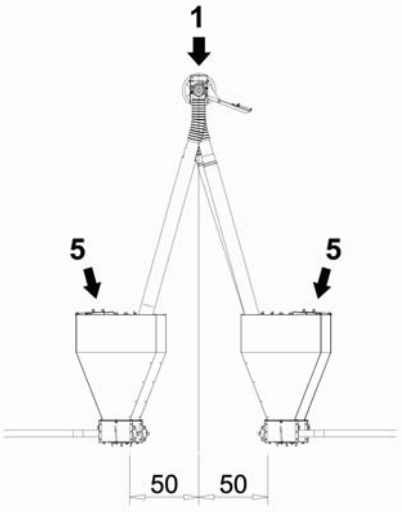


3- The outside hopper of the silo (4) (shaft from the silo) should be **about 200 cm** top of the interior wall **of the house** and **80 cm** from **the exterior ground of the field**.

4- The union between the transverse line (1) and the outside hopper of the silo (4) will be done with a part of the 6m tubes (1 and 3) and the curve administered, in such way that all the changes of way and **the curves are tangent on its way.**

" **This is very important for the proper work of the auger inside the tube"**

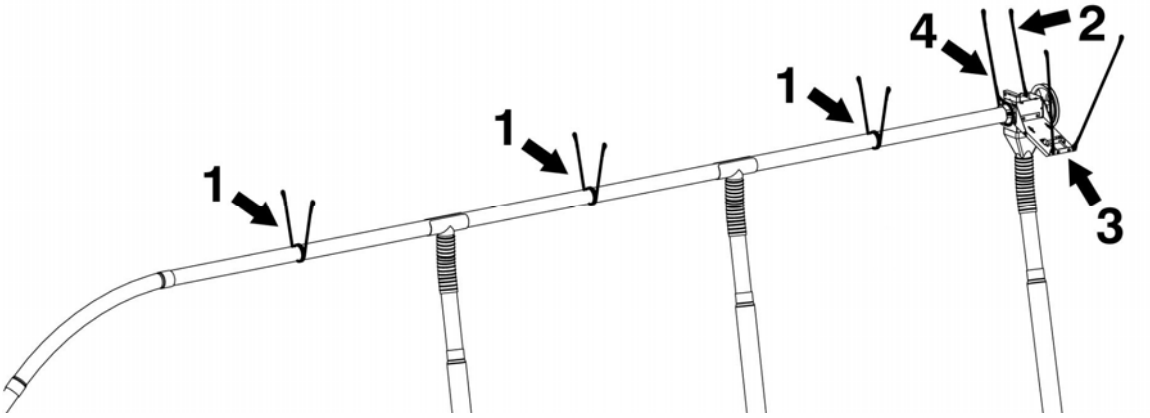
5- The transverse line should be **50 cm away from the hopper** in the longitudinal line. If there are two hoppers it will be 50 cm away from each other.



3-4. SUSPENSION OF THE TRANSVERSE LINE OF THE FEEDERS.

3-4-1. General description.

For the assembly of the transverse line, it is recommended that certain concepts and general details are bared in mind.



For the suspension assembly these items should be placed:

- **One** hanger **for each section (1)** of intermediate tube between drops and one hanger at **the entry point** to the house, **wrapping the hangers around the tube to** reduce the chances of movement.

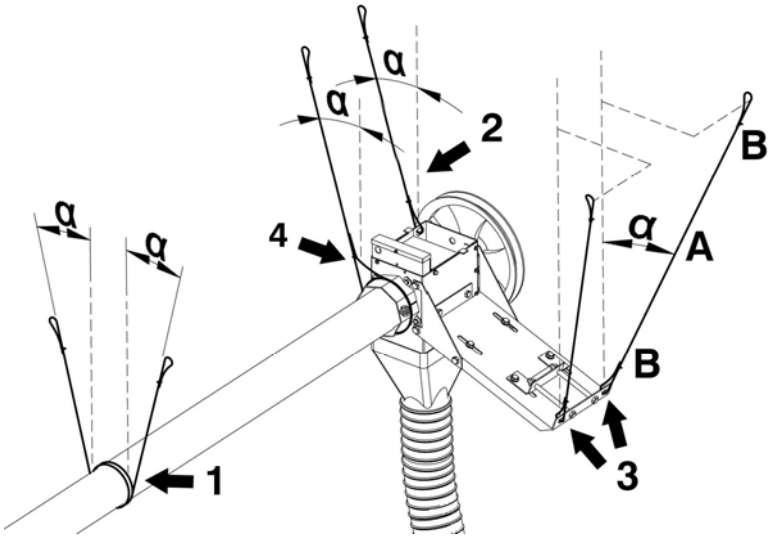
- **One** hanger in the **opening (2) of the motor body** of the fill system.

- **One** hanger in the **motor neck (4)** of the transverse.

- **Two** hangers in the **openings (3) of the motor mounting** base**.**

For the hanging reins 3m of cable will have to be used (A) administered by the individual hangers on the feeder **and the clamps (B)** to close the hanging loops.

It is **very important to open and angle** (α) every tie **respect to the tub**e in order to avoid any wobbling or vibration with the system.



3-5. ASSEMBLY OF THE TEE IN THE TRANSVERSE TUBE.

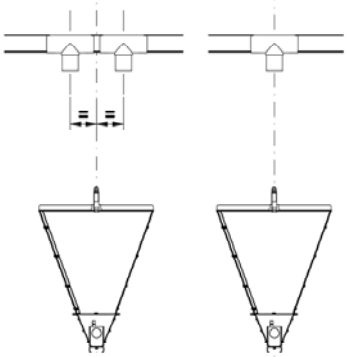
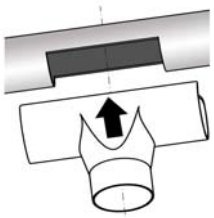


Fig. 2 Fig. 1

The amount of Tees that are assembled in the transverse tube **will depend on the numbers of hoppers** that are fed with that transverse line.

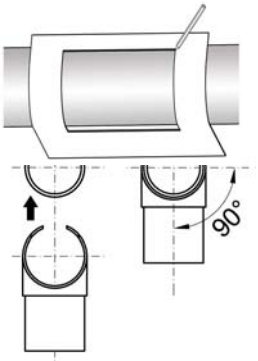
The location of the tees will be made so that the outlet is **perfectly aligned** with feeder lines they will work with (fig 1). If there are two drops that are fed together (transverse in the centre of the house), they will be aligned at equal distance from the outlet of the respective longitudinal lines.(fig.2).

PROCEDURE

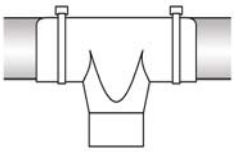


1- Make a hole in the transverse tube for each drop using this same paper as pattern, make a mark in the transverse tube and then open the hole.

*" **This is very important** to assure that all food arrive to the Tee, drop through the hole and do not go to the next track."*



2- Fasten the Tee with clamps making sure that the Tee are perfectly aligned with the food out hole of the transverse tube and perfectly vertical to itself

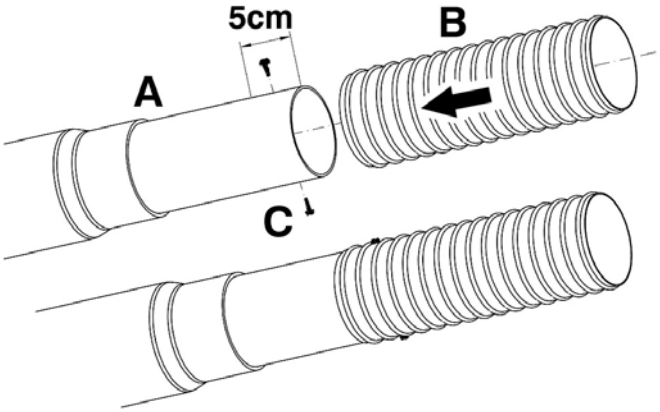


Cutout for Cross Tube

3-6. ASSEMBLY OF THE DROPS.

The drops are used to direct the food from the transverse line to the hoppers in the longitudinal line.

They consist of the **telescopic tube (A) and the flexible tube (B).**



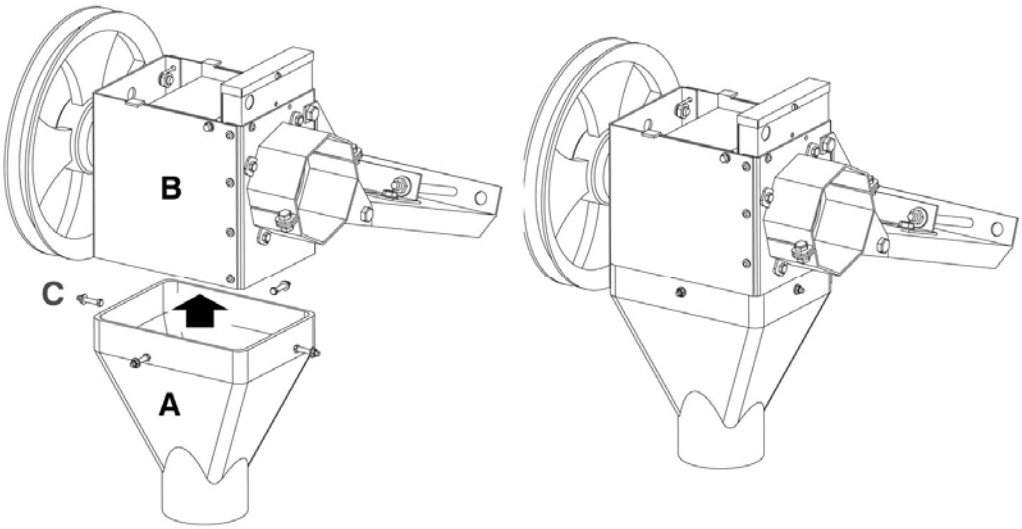
ASSEMBLY PROCEDURE

1- **Insert** the telescopic tube **(A) 5cm** into the flexible tube **(B).**

2- **Attach** both **with** two **metal screws (C).**

The transverse feeder is the set in charge of giving power to the transverse line and unload the feed hopper from the exit of the silo up to the hoppers in the longitudinal lines. This is made of the drive (A) and the little hopper that unloads the food on the last extension of the hopper.

1109273-1



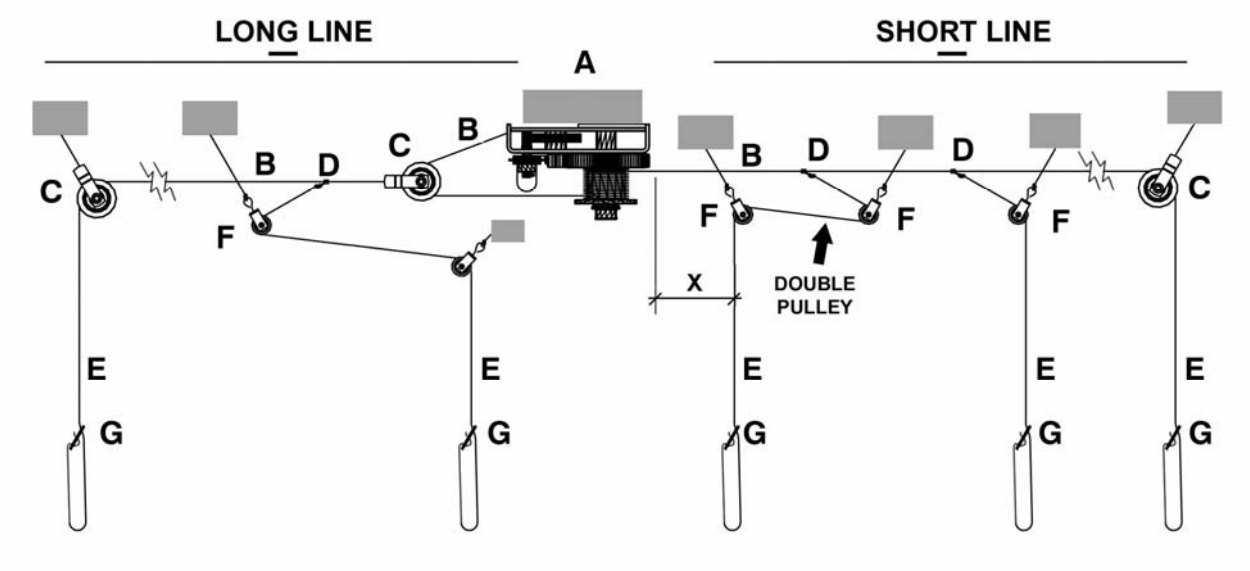
3-6-1. Assembly procedure:

1- **Introduce the little hopper (A)** placing it with the inferior exit of the drive (B).
2- **Fix using 4 screws** the little hopper to the drive

4. HANGING OF THE FEEDER LINES.

4-1. GENERAL DESCRIPTION.

The following are concepts and general information to bare in mind for the proper performance of the holding system and the hoisting of the feeder lines.



A- 300lb winch (1500kg) **(160RG1825).**

B- Galvanized cable of 5mm **(160AR1050).**

C- Welded ion pulley 90mm **(160AS5011).**

D- Clamp for cable **(160ABRAZ5MM).**

E- Galvanized cable of 3mm or 4\5 nylon cord **(160AR1030),** o cordón de nylon de Ø 4/5 mm **(1601021-H).**

F- Nylon spinning pulley **(160AS5030).**

G- Height adjuster for the iron cable **(160AS1165)** or height adjuster for the nylon cord **(105AJUS-AL).**

4-2. HOLDING SYSTEM ASSEMBLY.

The following is a suggested sequence for the assembly of the holding suspension system of the feeders.
It is supposed that the feeder line is on the floor and completely assembled.

1- Fix the winch firmly (A) in the middle of the house.

2- Fix the welded iron pulleys of 90 mm in the ends.

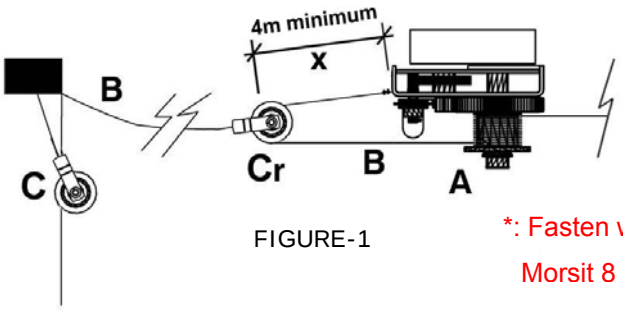


FIGURE-1

*: Fasten with 2 Morsit 8 mm

- At the end of the motor align the pulley verticallywith its eyebolts and then hang the end of the drive using a 5mm cable annico sleeves as it is shown in the picture at the right. **Do not forget to make a loop** with the with the cable and the nico sleeve to avoid unwanted sliding

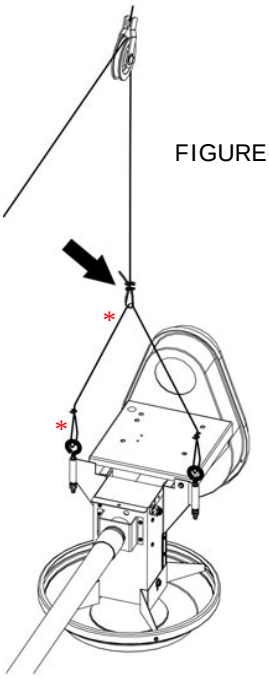


FIGURE-2

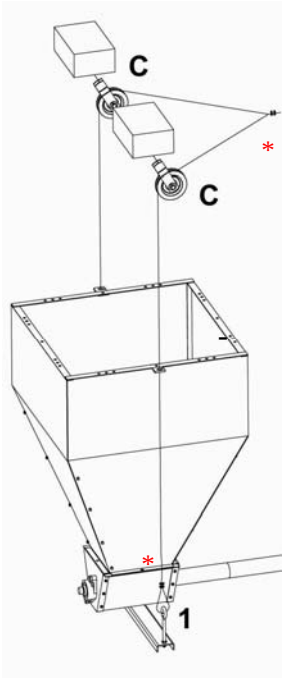


FIGURA-3

If the top height raising is not enough, **a second pulley could be assembled** to gain some height. In this case it is very important to **leave at least 60 cm between the grip**, when the line is totally on the floor (fig 4).

- At the end of **the hopper**, install a pulley (C) and take its hanger (1) hook.

3- Unroll the cable (B):
a- **For short lines (without reducer pulley Cr)**unroll the cable from one end of the lines to another end, passing it through the hole in the drum winch.
b- **For long lines (with reducer pulley Cr)**
b1- Unroll the cable from one end of the line to the winch and attach it to the bracket on the reducer **pulley).**

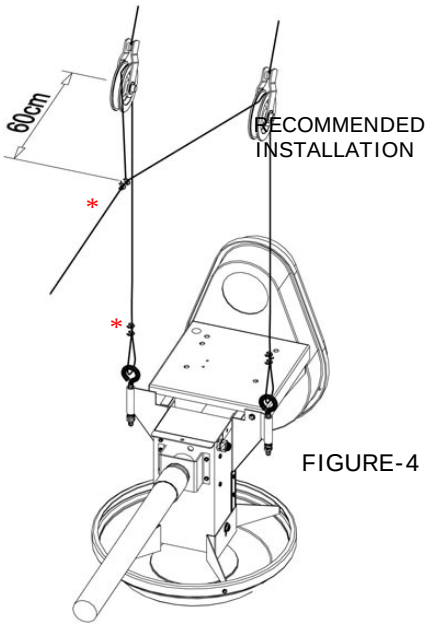


FIGURE-4

2- Install the reducer pulley (Cr),(see figure) making sure the distance (X) is 4 cm or double the maximum lifting height of the line.

4- Attach temporarily both ends of the cable to the pulleys (C) at the ends.

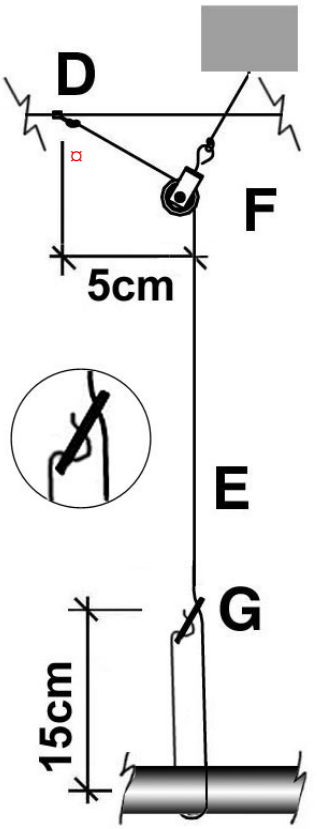
5- Tighten the cable with the winch so that the cable raises and remains tight.

6- **From the winch** start locating the **hanging sets** made up of **the galvanized cable of Ø3mm (E),** the 5mm **cable clamp (D)** the **Ø2" nylon spinning pulley (F)** and **the height adjuster** for the steel cable **(G)**.

IMPORTANT:

- The maximum distance between hangers **is 3m.**

- Be sure that **the feeder line is completely assembled and resting on the floor.**



¤: Use Morsit 5 mm

7- Attach the **Ø 2" nylon pulleys (F).**

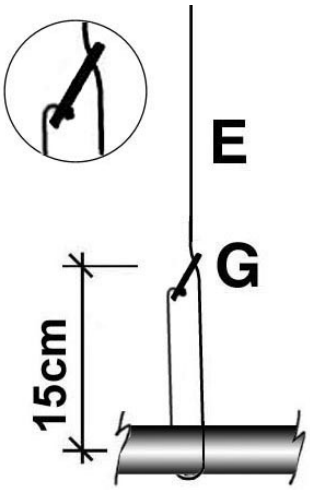
8- Pass the Ø1/8 (3mm) cable through the pulley (F), through the height adjuster (G), around the bottom of the feeder tube and again through the 2 remaining holes in the cable height adjuster (G) leaving 15 cm between the tube and the height adjuster to make adjustments.

9- Attach the Ø1/8" (3mm) cable (E) with the clamp (D), to the main suspension cable (B), coming from the winch 5 cm before reaching the pulley (F).

10- Cut the cable Ø 3mm (E).

11- Repeat the above steps with each hanger section until you reach the end of the line, paying close attention to the maximum and minimum distance between hangers, which should not exceed 3m.

NOTE:
Detail of the assembly when the nylon cord is used to hold the feeder tubes.



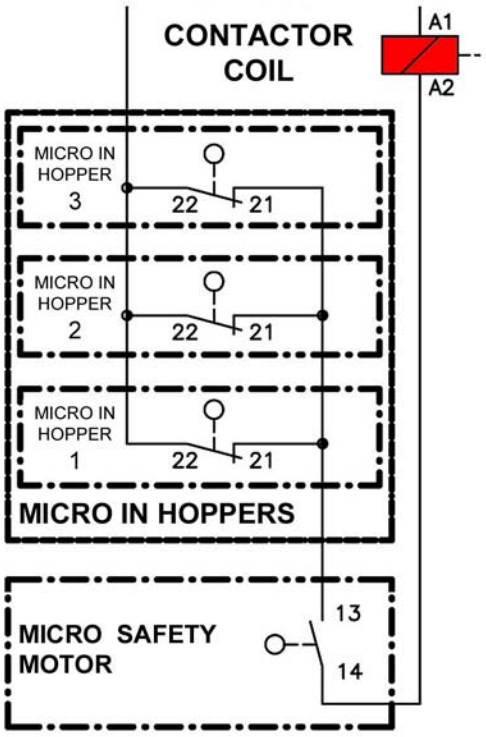
5. ELECTRICAL INSTALLATION OF THE FEEDERS.

VERY IMPORTANT

1. **All the motors must be started by using a contactor.**
2. **The micro switches will not work to start the motors directly.**
   They only activate the coils in the contactors through the control circuit.

5-1. ELECTRICAL VERIFICATION OF THE TRANSVERSE SYSTEM.

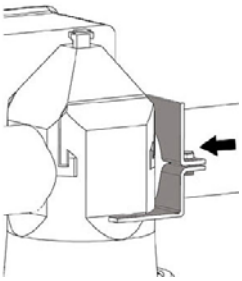
THIS VERIFICATION IS OF PARAMOUNT IMPORTANCE FOR THE PROPER WORKING OF THE AUTOMATIC TRANSVERSE LINE



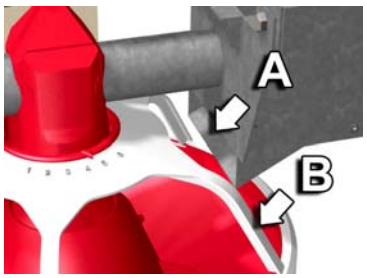
1. Verify that all the **contactors are being used** for the activation of the motor.
2. Verify that the **PARALELL CONNECTORS** of all **THE HOPPER CONTROL AND THE SERIES CONNECTIONS** respecting the others, **AND THE SECURITY MICRO** are below the extern top of the motor of the transverse line.
3. **Verify** a tester with **the micros of the hopper** working to check its performance.

5-2. FINAL VERIFICATION OF THE OF THE AUTOMATIZATION ON THE FEEDER LINES.

1. **Verify** if the **control pans** are properly assembled in the middle of the house as an the end of it.



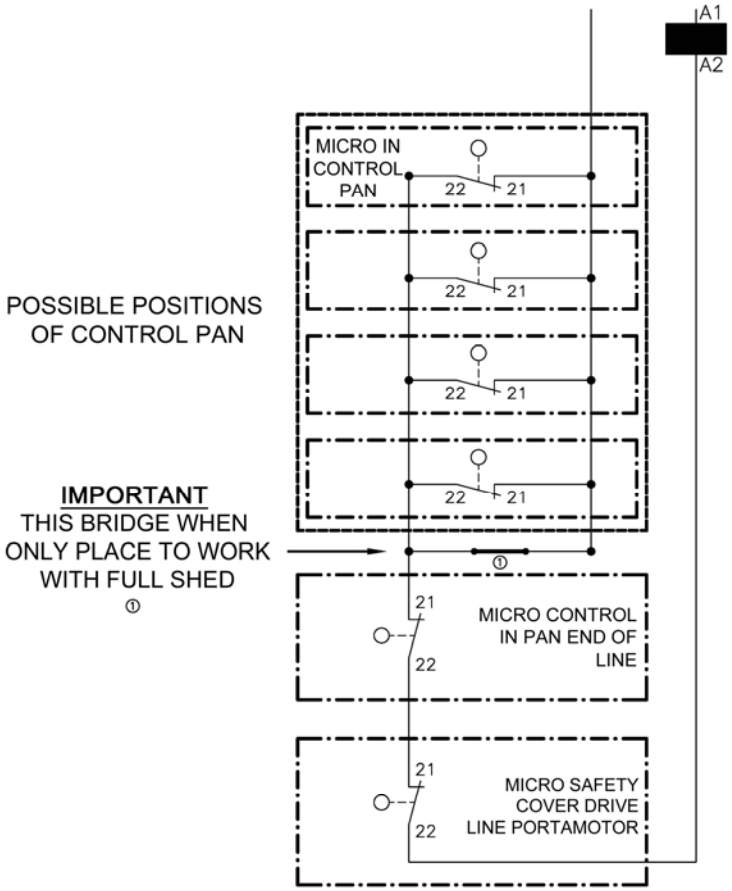
BOTH SHOULD BE FIRMLY ATTACHED TO THE TUBE WITH CLAMS TO IMMOBILIZE THEM



2. **The control pan motor** (at the end of the line) verify that **the opening of return of the motor (A)** is located **between two ribs of the grill.(B)**

5-3. ELECTRIC VERIFICATION.

THIS VERIFICATION IS VERY IMPORTANT FOR THE PROPER AUTOMATIC WORKING OF THE LINE OF THE FEEDER



1. Verify if the activation **contactors** of all the motors are **being used**.

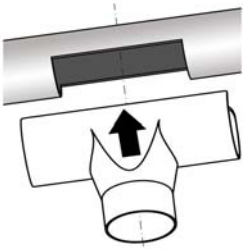
2. Verify **in each line** of the feeder, **SERIES CONNECTION OF THE LAST CONTROL PAN AND THE SECURITY MICRO** below the top of the base of the motor.

3. **Verify** the tester **of the micros of the control pans** to check its proper working.

4. **For breeding in the middle of the house**, **the control pan should be assembled in the middle of the house, without the bridge** (see fig 1), to allow the line works with the pan in the middle of the pan.

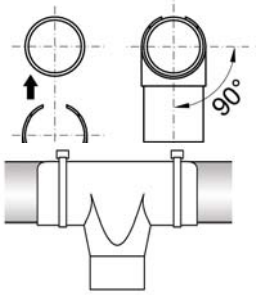
5. **To breed in the whole house, the pans in the middle of the house should be disassembled without putting the bridge (see fig 1)** to allow the line work with a pan at the end of the line.

5-4. FINAL VERIFICATION OF THE TRANSVERSE SYSTEM.



1. Verify that **the food discharge holes** are done on the transverse, **leave an opening not inferior to 11 cm long** (along the tube**) and half tube of height** (9cm previously measured) in order to perform this activity the Tee cutting pattern should be used.

THE FOOD SHOULD NOT GO TO DISCHARGE UNTIL THE PREVIOUS DISCHARGE IS COMPLETELY FULL



2. Verify that the discharge Tee are pointing vertically to the floor (perpendicular to the floor) in this way the food discharge will be done on its discharge hole.
3. Verify that all the Tees have 2 clamps placed and fixed to avoid the Tee twist and change its vertical position when the telescopic tube is directed to the corresponding hopper.

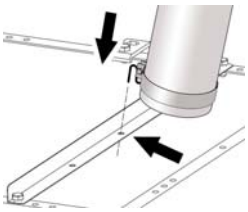
NOTE:

When the discharge holes are not enough or the discharge tubes are wrongly positioned, the food goes through the discharge to the hopper and overflows up to the end of the transverse tube activated by the security micro.

Once it acts it cuts the power of the whole system disabling the control micros of the hoppers.

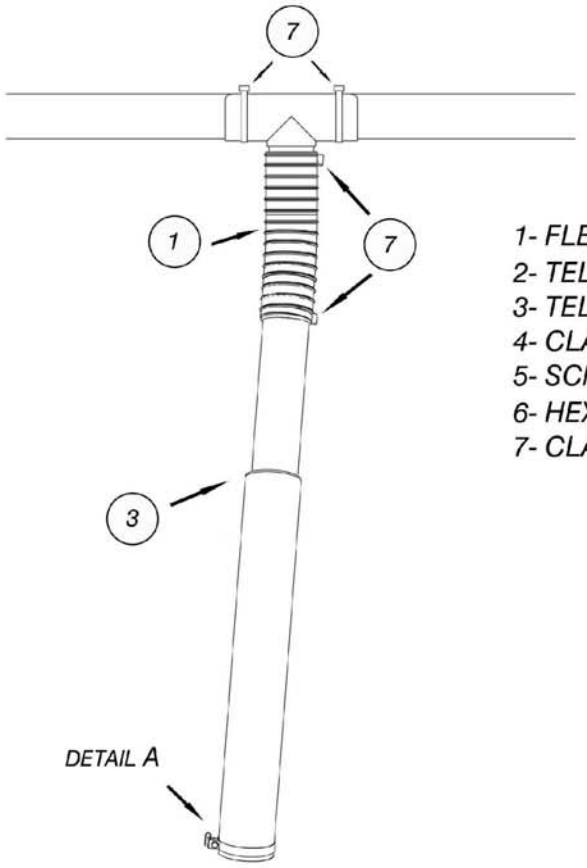
This would make the hoppers control micros look as if they were not working but it would not be the case.

4. Verify that **every immediate discharge** (from the transverse tube up to the hoppers of the line of feeders) **are complete** (Tee, flexible and telescopic tube)
5. Verify that **the upper part of the telescopic is united to the flexible** with a screw.
6. Verify that **the interior tube of the telescopic does not move freely outside of the superior tube**



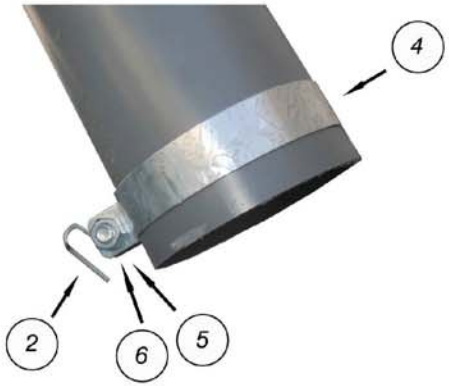
7. Verify that the **hook of the inferior tube of the telescopic** goes through one of the holes of the upper crossbar of the hopper.
8. Verify **that the discharge direction of the telescopic** is in the direction to **the control of the hoppers** and is not to the sides of itself.

INTERMEDIATE DISCHARGE

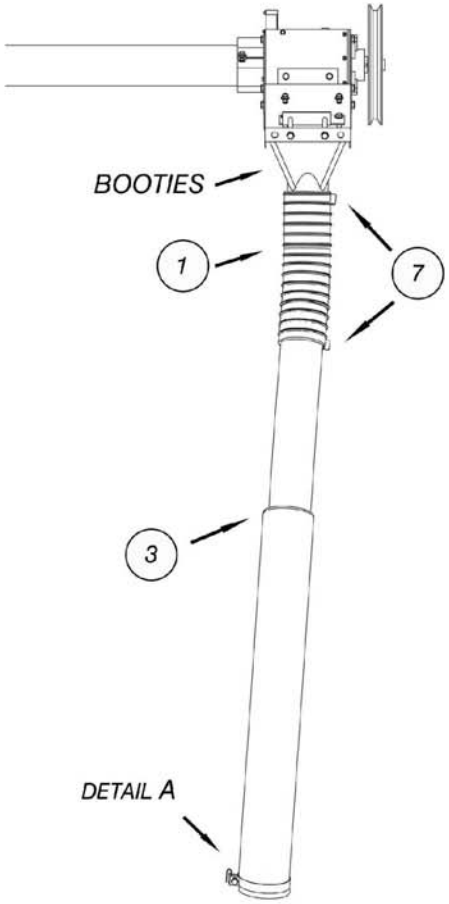


1- FLEXIBLE TUBE Ø75mm x 320mm (110FLEX75350).
2- TELESCOPIC HANGING HOOK (110GANTELES).
3- TELESCOPIC (110TELES75-1).
4- CLAMP 18mm (155W125).
5- SCREW 5/16" x 3/4" (170R51634).
6- HEXAGONAL NUT RW 5/16" AUTOF. (170TW 516F).
7- CLAMP 70-90 FLEJE 12 (T) (175ABR709012).

DETAIL A :



FINAL DISCHARGE



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