



# ***7' Bulk Bin Owner's Manual and Assembly Instructions***



***Quality Livestock and Poultry Equipment***



## TABLE OF CONTENTS

	<u>Page</u>
7' Bin Packing List	<u>2</u>
Safety Warnings	<u>3-4</u>
General Information	<u>5</u>
Tool List	<u>6</u>
Hardware List	<u>6</u>
Site Selection	<u>6</u>
Foundation and Anchoring Specifications	<u>7</u>
7' Bin Parts Summary List	<u>8</u>
Hardware and Assembly Summary	<u>9</u>
Corrugated Hopper Assembly	<u>10</u>
Taper Hopper and Collar Assembly	<u>11</u>
Roof Deck and Lid Collar Assembly	<u>12</u>
Leg and Braces Assembly	<u>13-14</u>
Roof Deck Ladder Assembly	<u>15</u>
Side Ladder Assembly	<u>16</u>
Tru-Lok Lid Opener Assembly	<u>17</u>
Tru-Lok Lid Tube Assembly	<u>18</u>
Erecting the Bin	<u>19</u>
Product Warranty	<u>20</u>



## 7' BIN PACKING LIST

**Check all parts with packing list below before starting assembly. Report any shortages immediately to your supplier. Save all cartons until bin is completed.**

7 FT. DIAMETER BIN			BIN SIZE & OPENING													7'					
REQUIREMENTS			OPENER TYPE													EXT					
NUMBER OF RINGS			CHAIN						TRU-LOK						PNEUMATIC						EXT
ORDER NUMBER			1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	EXT
CAT #	DESCRIPTION	WEIGHT	507001	507002	507003	507004	507005	507006	507701	507702	507703	507704	507705	507706	507604	507602	507603	507604	507605	507606	507090
			QTY REQ'D						QTY REQ'D						QTY REQ'D						QTY
507046	18 ga. Main Hopper - Plain With Drip Edge	62.0	1	2	2	2	2	2	1	2	2	2	2	2	1	2	2	2	2	2	
507047	18 ga. Main Hopper - Decal With Drip Edge	62.0	1	0	0	0	0	0	1	0	0	0	0	0	1	0	0	0	0	0	
507016	18 ga. Main Hopper - Plain	62.0	0	0	0	0	2	2	0	0	0	0	2	2	0	0	0	0	2	2	
507007	20 ga. Extension Hopper - Plain	45.0	0	1	3	5	5	7	0	1	3	5	5	7	0	1	3	5	5	7	2
507008	20 ga. Extension Hopper - Decal	45.0	0	1	1	1	1	1	0	1	1	1	1	1	0	1	1	1	1	1	
507024	Galv. Leg - 146" (1-4R)	52.0	4	4	4	4	0	0	4	4	4	4	0	0	4	4	4	4	0	0	
507039	Galv. Leg - 178" (5-6R)	64.0	0	0	0	0	4	4	0	0	0	0	4	4	0	0	0	0	4	4	
507230	Front Cross Tie Brace Angle	6.0	4	4	4	4	0	0	4	4	4	4	0	0	4	4	4	4	0	0	
507231	Rear Cross Tie Brace Angle	6.1	4	4	4	4	0	0	4	4	4	4	0	0	4	4	4	4	0	0	
507232	Leg-Collar Brace Angle	2.7	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	
507073	Brace Tie Bundle	44.0	0	0	0	0	1	1	0	0	0	0	1	1	0	0	0	0	1	1	
507074	"X" Brace Bundle	43.0	0	0	0	0	1	1	0	0	0	0	1	1	0	0	0	0	1	1	
507023	Roof Deck Section	10.0	6	6	6	6	6	6	6	6	6	6	6	6	4	4	4	4	4	4	
509167	Special Bracing Hardware Bag	1.8	0	0	0	0	1	1	0	0	0	0	1	1	0	0	0	0	1	1	
507503	Roof Deck Section - Pneumatic Fill	10.0	0	0	0	0	0	0	0	0	0	0	0	0	2	2	2	2	2	2	
507018	Taper Hopper Section	33.0	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	
507049	TH Reinforcement Angle	33.0	0	0	0	0	6	6	0	0	0	0	6	6	0	0	0	0	6	6	
507160	Basic Hardware Carton	50.0	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
509163	178" Leg Hardware Carton	4.5	0	0	0	0	1	1	0	0	0	0	1	1	0	0	0	0	1	1	
507072	Extension Hardware Carton	4.0	0	1	2	3	4	5	0	1	2	3	4	5	0	1	2	3	4	5	1
507166	Components Carton - Chain (1-4R)	40.0	1	1	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
507184	Components Carton - Chain (5-6R)	37.0	0	0	0	0	1	1	0	0	0	0	0	0	0	0	0	0	0	0	
500761	Components Carton - Pneumatic Fill	34.0	0	0	0	0	0	0	0	0	0	0	0	0	1	1	1	1	1	1	
507126	Components Carton - Tru Lok (1-6R)	40.0	0	0	0	0	0	0	1	1	1	1	1	1	0	0	0	0	0	0	
500226	TL Basic Tube (1-4R)	5.4	0	0	0	0	0	0	1	1	1	1	1	1	0	0	0	0	0	0	
500729	TL Extension Tube	2.0	0	0	0	0	0	0	1	2	3	4	5	6	0	0	0	0	0	0	
507763	TL Roof Tube	2.0	0	0	0	0	0	0	1	1	1	1	1	1	0	0	0	0	0	0	
500728	TL Tube Guide (3-6R)	3.0	0	0	0	0	0	0	0	0	1	1	1	1	0	0	0	0	0	0	
	<b>OPTIONAL LADDER</b>		507101	507102	507103	507104	507105	507106	507101	507102	507103	507104	507105	507106	507101	507102	507103	507104	507105	507106	
500190	Basic Ladder	38.0	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
500191	Extension Ladder	9.0	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	
507034	Ladder Stand-Off Ring	4.0	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
507042	Roof Ladder	9.0	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	



## SAFETY WARNINGS

Pax Steel Products primary concern is your safety. This section is included in the manual as a guide to help and encourage the safe operation of your feeding equipment. It is your responsibility to evaluate the hazards of each operation and implement the safest method of protecting yourself as owner and/or operator. We strongly encourage you to establish and promote a program of safety goals with owner/operator responsibilities that assure safe working practices in your operation.

## SAFETY ALERT SYMBOLS

The safety alert symbol shown below is always used on warning signs that involve your safety. Anytime you see this symbol heed the warning it identifies.



ATTENTION!!

BECOME ALERT!!

YOUR SAFETY IS INVOLVED

- **Avoid any alterations** to the equipment. Such alterations may produce a very dangerous situation where serious injury or death may occur.
- **Keep all safety guards on** equipment
- Ground all electrical equipment. **Do not bypass electrical safety equipment.** Make sure electrical equipment is properly installed and grounded by a qualified electrician.
- Wear a hard hat during construction
- Order and attach warning symbols to danger areas that are not already noted
- **Do not enter bin** during operation or at any time without proper safety precautions.

**This manual must be delivered with the equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment !**

ATTENTION: The decal shown below must be present on the inside of the roof lid cover. If it is not there or damaged contact our sales office at 1-800-531-1064 or 1-419-678-8731 for a free replacement.



# DANGER

## YOU CAN SUFFOCATE UNDER MATERIAL IN THIS TANK



**FLOWING MATERIAL  
TRAPS  
AND SUFFOCATES**

**CRUSTED MATERIAL  
COLLAPSES  
AND SUFFOCATES**

**NEVER ENTER THIS TANK DURING LOADING AND UNLOADING**

**AT OTHER TIMES ENTER TANK ONLY IF YOU**

- 1. SHUT OFF AND LOCK OUT ALL POWER.**
- 2. USE A SAFETY HARNESS AND SAFETY LINE.**
- 3. WEAR PROPER BREATHING EQUIPMENT.**
- 4. AVOID THE CENTER OF THE TANK.**
- 5. STATION PEOPLE TO HELP OUTSIDE THE TANK.**

500443



## GENERAL INFORMATION

- \* Read all safety information, instructions and illustrations before starting to assemble your new bulk bin. Please review the complete assembly manual twice before starting and be sure to check your shipment with the packing list for any shortages. Please report shortages promptly.
- \* Metric measurements are shown in millimeters and in parenthesis throughout the manual. Example: 13" (330mm)
- \* The terms horizontal and vertical refer to the bin in a standing position.
- \* Instructions for optional bin accessories are packaged with the components.
- \* To help decide which is the top and bottom of corrugated hoppers, a hole spacing of 3.125" (79mm) is used at the top of all extension hoppers and at the bottom of all main hoppers.
- \* Vertical seams must be staggered on all hopper rings. On 9' x 6 ring and 7' x 5 or 6 ring bins align leg holes on bottom two main hopper rings to accommodate longer legs.
- \* Taper hopper vertical seams and boot collar seam use truss head bin bolts with the head always on the inside of the bin to allow for better feed flow.
- \* Corrugated hoppers and roof deck seams use hex head bin bolts with the head to the outside except to fasten legs to corrugation where the bolt head goes to the inside.
- \* Tighten all bin bolts from the nut side to help reduce the possibility of damaging the rubber seal our bin bolts. Do not allow the bolt heads to spin when tightening.
- \* When assembling corrugation sheets, use a drift pin to help align holes and always overlap sheets in the same direction. Finger tighten nuts until the next ring is assembled.
- \* Remove protective paper from decal before raising bin. Paper may be difficult to remove if exposed to warm sunlight for several hours.



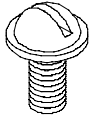
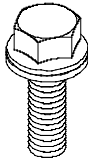
## HARDWARE LIST

501440 - 5/16" x 3/4"  
Truss Bin Bolt

010603 - 5/16  
Hex Nut

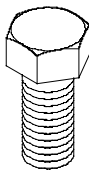
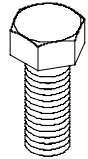
501441 - 5/16"  
Flange Nut

501442 - 5/16" x 1"  
Hex Bin Bolt



010253 - 3/8"  
Lockwasher

010664 - 3/8" x 1"  
Hex Bolt



010254 - 7/16"  
Lockwasher

012240 - 7/16" x 1"  
Hex Bolt

011115 - 3/8"  
Hex Nut

011116 - 7/16"  
Hex Nut

## TOOL LIST

Below is a list of tools required to assemble your new bin. The use of an electric or air impact wrench will greatly reduce your assembly time. However, you must be careful when using power equipment not to over-torque the fasteners.

- Open or Box End Wrenches (1/2", 9/16", 5/8", 11/16")
- Socket Set with Speed Wrench or Impact
- Hammer or Rubber Mallet
- Large Screwdriver
- 12" Drift Punches
- Nail Apron

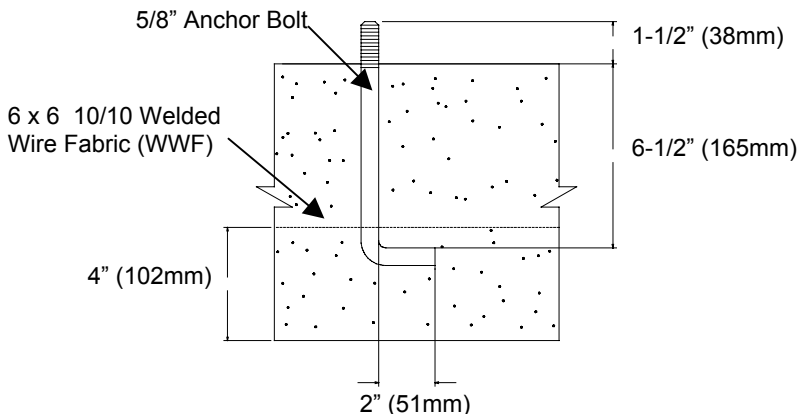
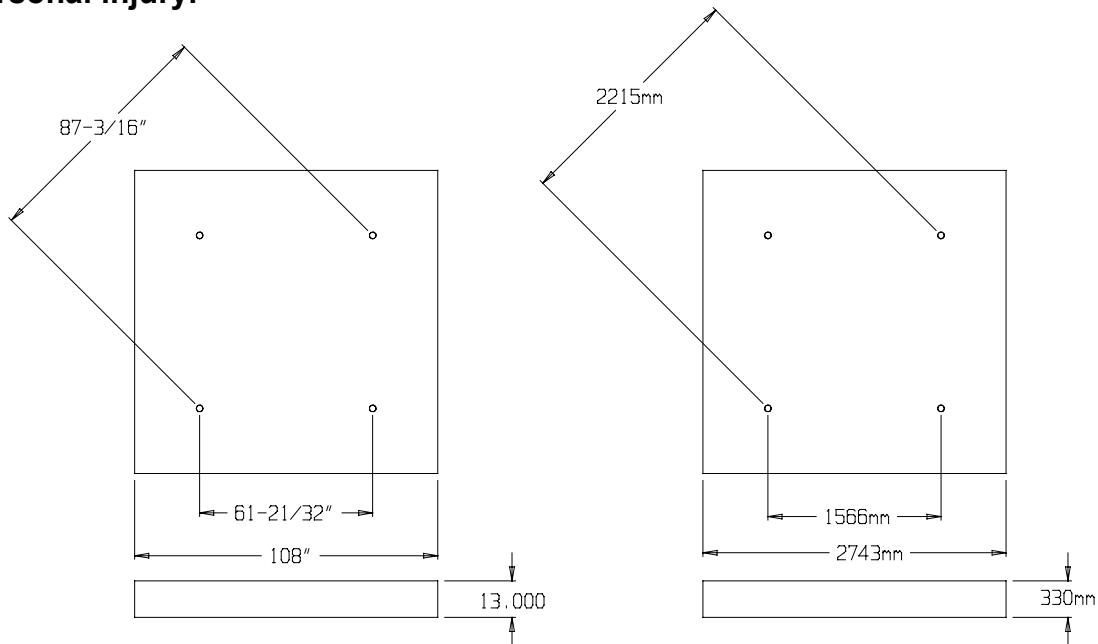
## SITE SELECTION

The success of all building projects begins with the ground you start on. This is also the case with assembling your new bulk bin. The selected site must be firm, level ground with good water drainage and a soil bearing capacity of 3500 lbs. per sq. ft. Check with your local soil engineer if you have any questions. When you have determined that the soil is acceptable, you should also consider the following factors: accessibility of feed handling equipment, space for future growth and the absence of overhead obstructions such as power lines or tree branches.

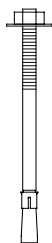


# FOUNDATION AND ANCHORING SPECIFICATION

After selecting the best site for your new bin and making sure the soil has the required 3500 psf, you are now ready to begin your foundation. It is extremely important that your bin has a firm and level foundation. The concrete used for this must have a minimum compression rate of 3000 lbs. per square inch at 28 days. The pad must meet the dimensions listed below and be poured both square and level. When laying out the bolt locations, it is very important to maintain the squareness of the bin. Be sure to check all (3) diagonal measurements and hold the same distance between holes as shown. The "L" shaped anchor bolt shown in diagram below can be purchased from local retailers. When using the optional anchor bolt shown below, holes can be drilled after concrete has set however you must use the same dimensions as shown below to assure bin maintains squareness. **Note: Locating anchor bolt holes by using the assembled bin legs does not assure the bin will be set squarely and can result in damage to equipment and/or personal injury.**



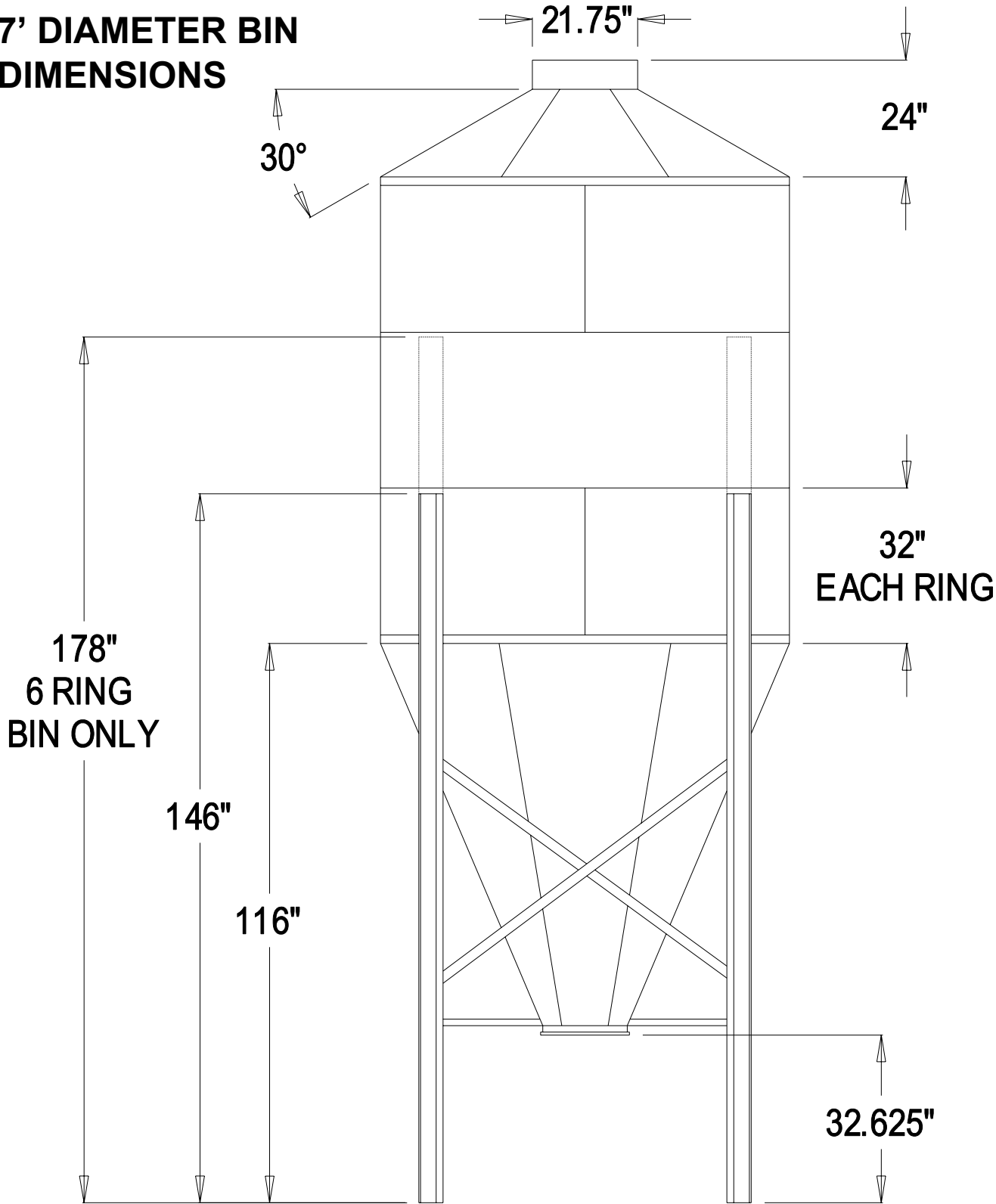
Optional style anchor bolts as shown here can be supplied by Pax. Order kit # 500220 for 7' bins.







# MODEL 507 7' DIAMETER BIN DIMENSIONS





### 7' BIN PARTS LIST

#### CORRUGATED HOPPERS

##### 1 RING BIN

- 507046 18ga Main - (1)
- 507047 18ga Main w/Decal - (1)

##### 2 RING BIN

- 507046 18ga Main - (2)
- 507007 20ga Extension - (1)
- 507008 20ga Ext. w/Decal - (1)

##### 3 RING BIN

- 507046 18ga Main - (2)
- 507007 20ga Extension - (3)
- 507008 20ga Ext. w/Decal - (1)

##### 4 RING BIN

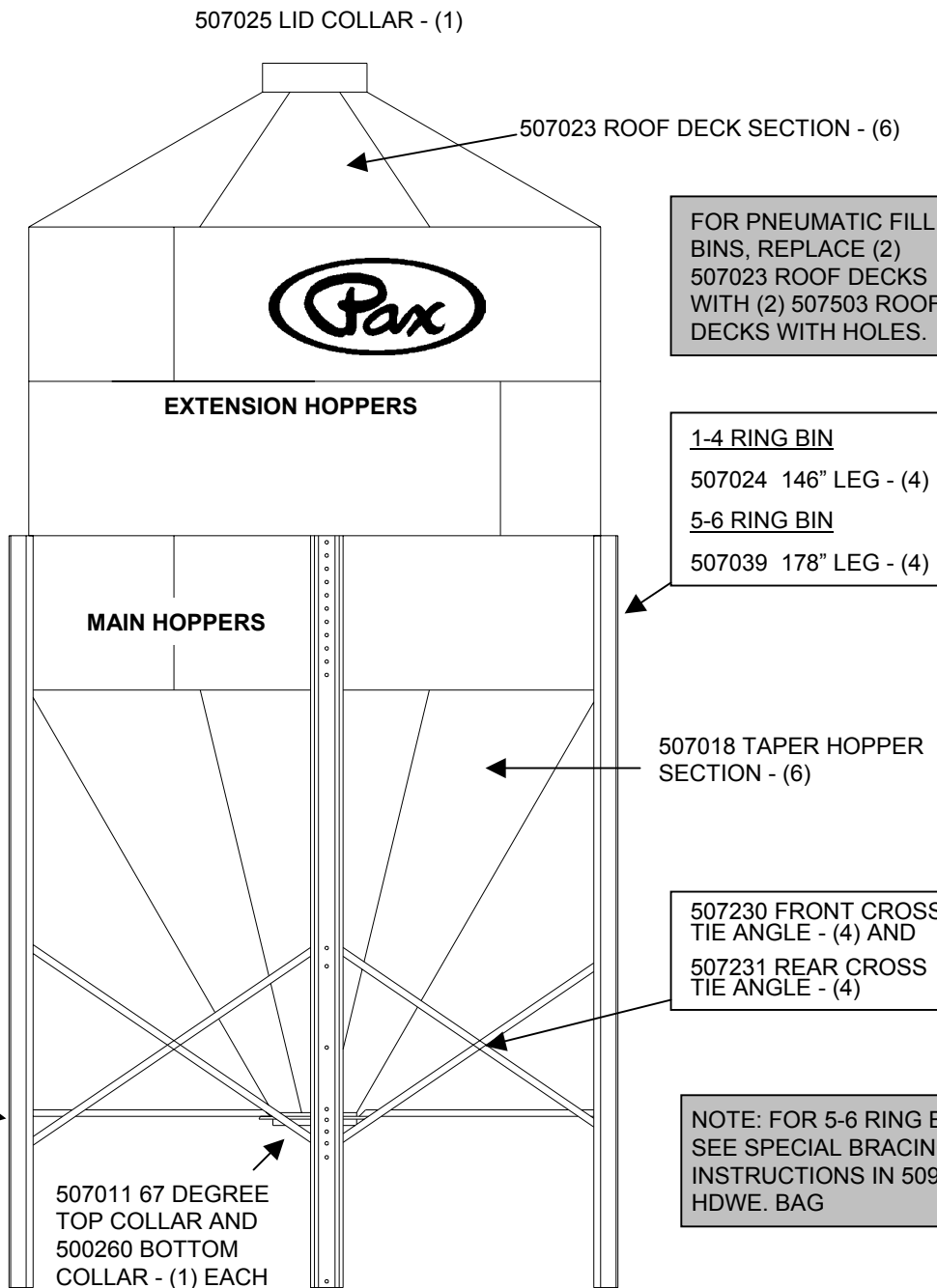
- 507046 18ga Main - (2)
- 507007 20ga Extension - (5)
- 507008 20ga Ext. w/Decal - (1)

##### 5 RING BIN

- 507046 18ga Main - (2)
- 507016 18ga Main Ext. - (2)
- 507007 20ga Extension - (5)
- 507008 20ga Ext. w/Decal - (1)

##### 6 RING BIN

- 507046 18ga Main - (2)
- 507016 18ga Main Ext. - (2)
- 507007 20ga Extension - (7)
- 507008 20ga Ext. w/Decal - (1)

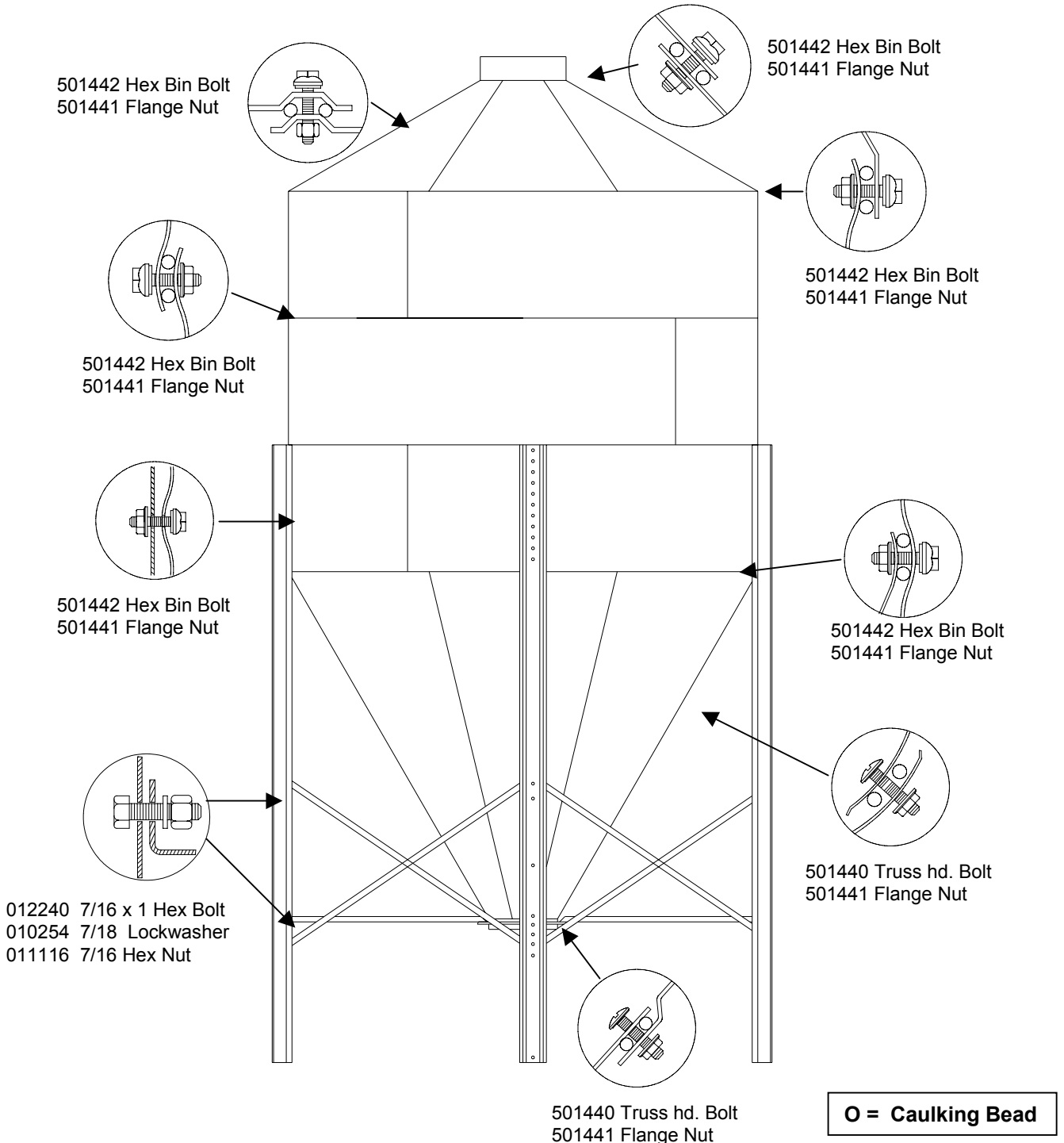


NOTE: FOR 5-6 RING BINS SEE SPECIAL BRACING INSTRUCTIONS IN 509167 HDWE. BAG



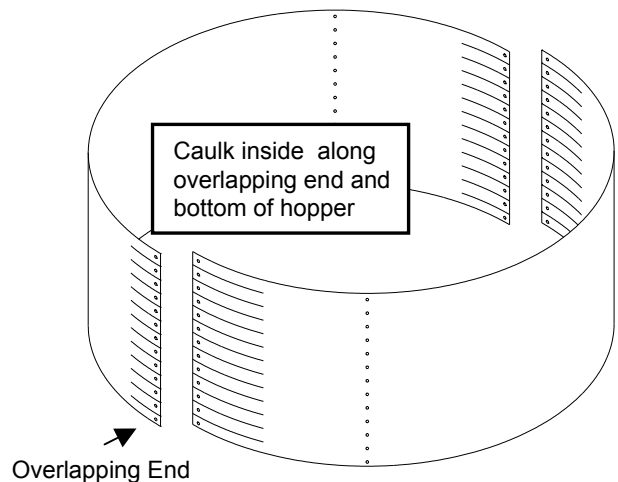
# HARDWARE AND ASSEMBLY SUMMARY

This illustration shows the type of fasteners, position of caulking and the location they are used. It can be used as a quick reference when assembling your bin. Refer to the step-by-step instructions for complete assembly details.



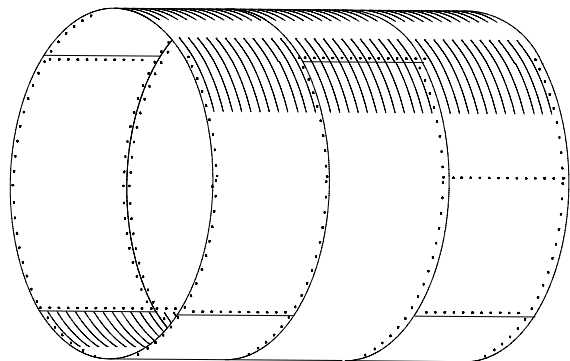
## CORRUGATED HOPPER ASSEMBLY

Bin assembly starts with the (2) heaviest corrugated hopper sheets. You can identify them by referring to the color coded tag, the extra row of vertical holes and the bottom row of holes having a 3-1/8" spacing. Apply caulking to the inside of the hoppers along both sides of the bottom row of holes and the left end holes. Place the caulked end **over** the uncaulked end of each adjacent hopper. Assemble ends with 501442 bin bolts and 501441 flange nuts. Do not tighten until all (3) sheets of ring are assembled. **Be sure caulking covers both sides of holes to prevent leaking.**



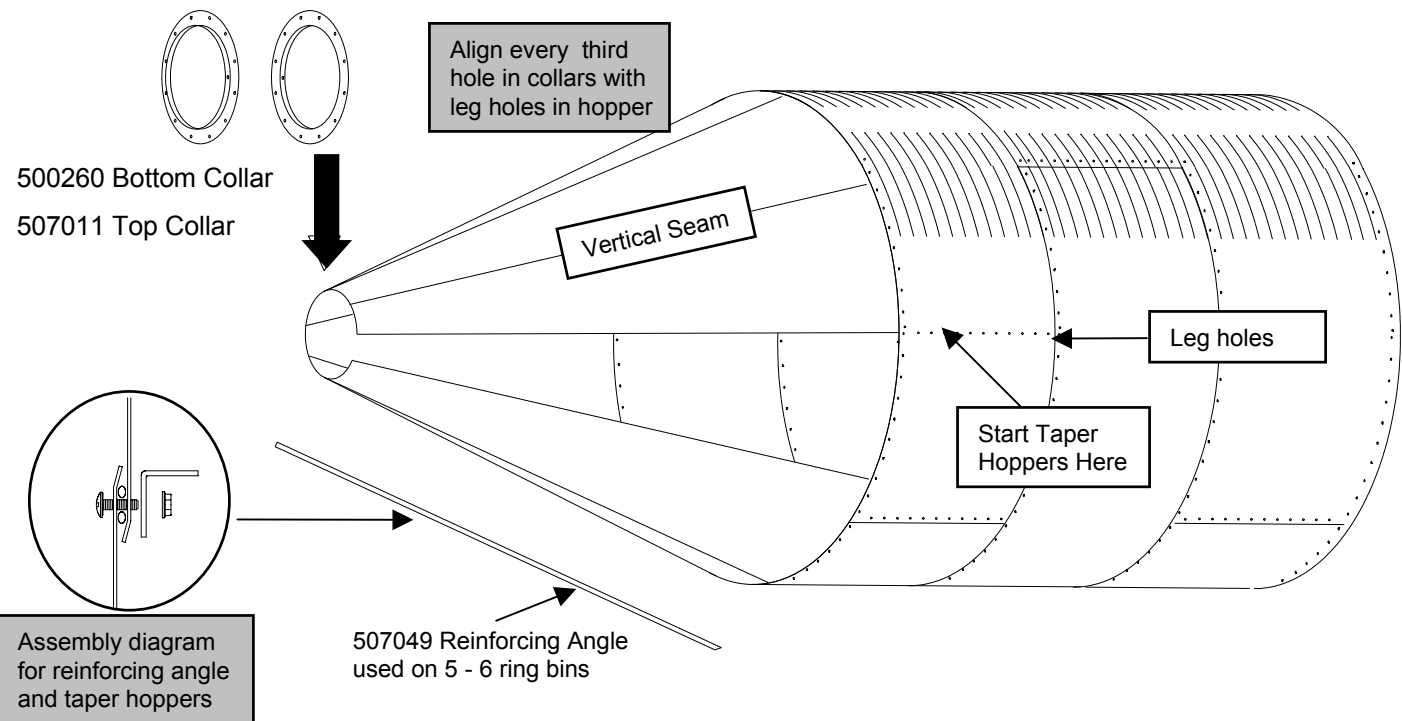
COLOR CODE	HOPPER THICKNESS
GREEN	16 GA. HOPPER
RED	18 GA. HOPPER
BLACK	20 GA. HOPPER

Refer to parts list on page 8 to determine the next sheets required to build additional rings. Place (1) 2nd ring hopper on top of the assembled 1st ring making sure ends are in center of bottom ring hoppers. On 5-6 ring bins you will need to align leg holes with bottom ring leg holes. Align corner hole where the (3) hoppers meet first for easiest assembly. After completing the second ring you should lay assembly on its' side so hoppers can be rolled to make it easier to assemble additional rings. Assemble and caulk each additional ring same as instructed above. Remember to complete entire ring before tightening nuts. Tighten horizontal seams by starting in center of hopper and working toward ends. When all hoppers are assembled you should have the heaviest corrugation on the bottom and the decaled sheet on top.



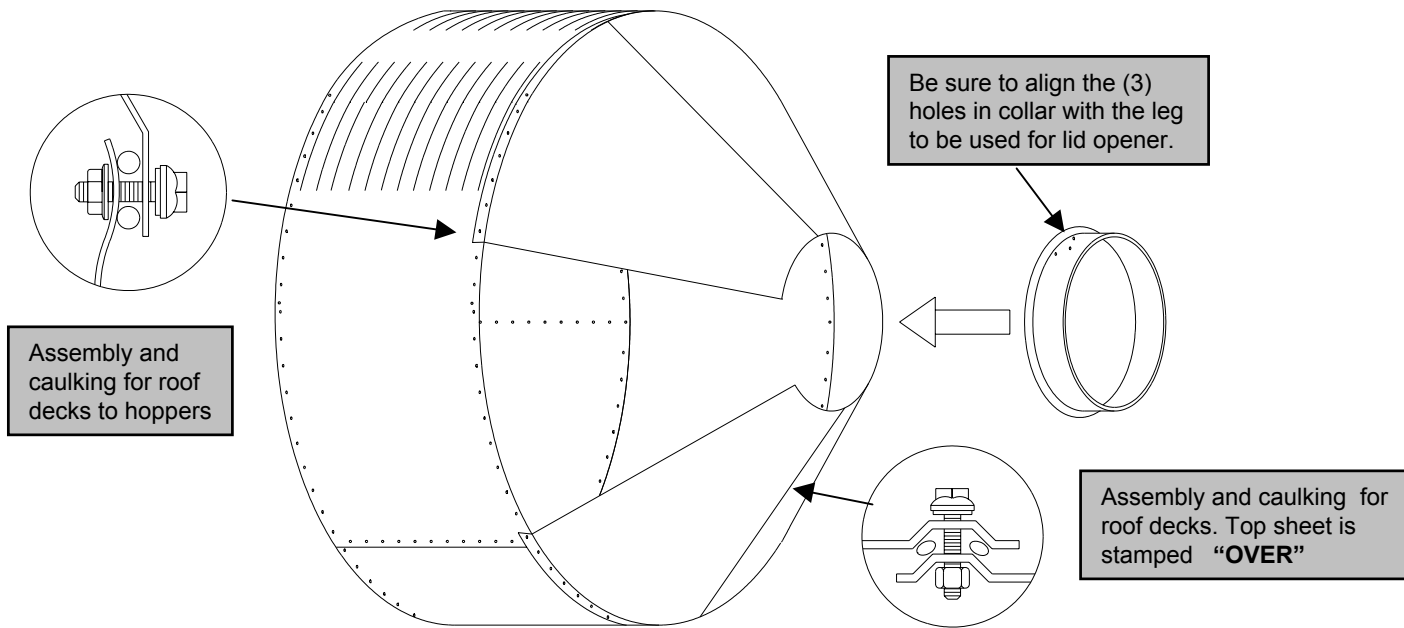
**IMPORTANT: Hardware must be tightened from the nut side and held on bolt side to prevent damage to seal on bin bolt**

## TAPER HOPPER AND COLLAR ASSEMBLY



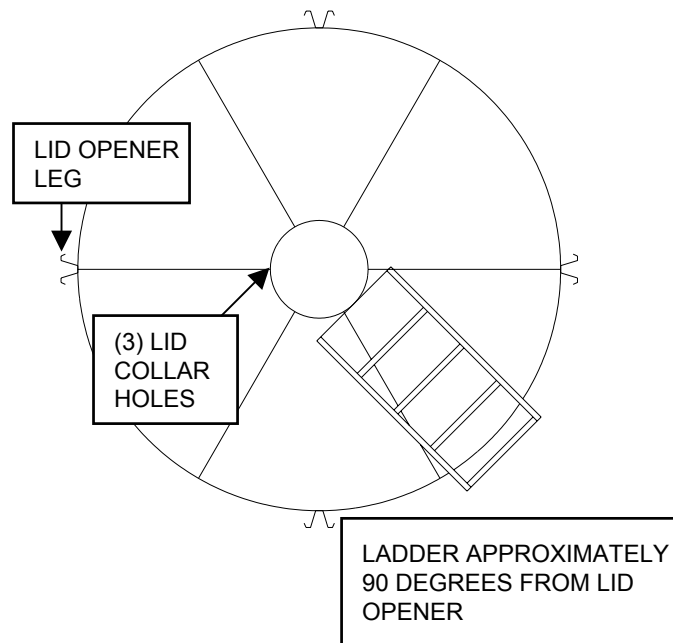
Before assembling taper hopper sections to corrugated hoppers you must apply the proper caulking to assure a watertight seal. Begin caulking around the inside of the bottom row of holes on the bottom ring of corrugated hoppers. **Be sure to caulk both sides of all holes.** Next caulk taper hoppers along the vertical side with the bend towards the inside. Caulk all taper hoppers on same side and apply to both sides of holes. Align first taper hopper section with one set of leg holes and assemble to inside of corrugated hoppers using 501442 hex bin bolts and 501441 flange nuts. Keep bolt heads on outside of assembly. Leave holes that align with leg holes open until assembling legs to bin. Place next taper hopper over previous one and align holes with drift pins. Assemble loosely to corrugated hoppers and place 507049 reinforcing angle along seam. (Note: Reinforcing angles not used on 1 - 4 ring bins.) Align all holes and assemble as shown in diagram above using 501440 truss head bin bolts and 501441 flange nuts. Truss head bolts go on **inside** of hoppers. Tighten nuts after each sheet. Continue assembling all sections until the last two. Caulk 507011 top collar on both sides of holes on outside of top flange. Place inside the end of the assembled hoppers. Align holes in collar so every third hole is aligned with a row of leg holes in corrugated hoppers. Assemble loosely with same hardware as above. Finish assembling the final (2) sections and top collar. Tighten all hardware. Caulk 500260 bottom collar around opening on top side of collar. Assemble to top collar with (6) 012240 7/16" x 1" hex bolts, 010254 lockwashers and 011116 nuts using the six holes that **do not** align with legs.

## ROOF DECK AND LID COLLAR ASSEMBLY

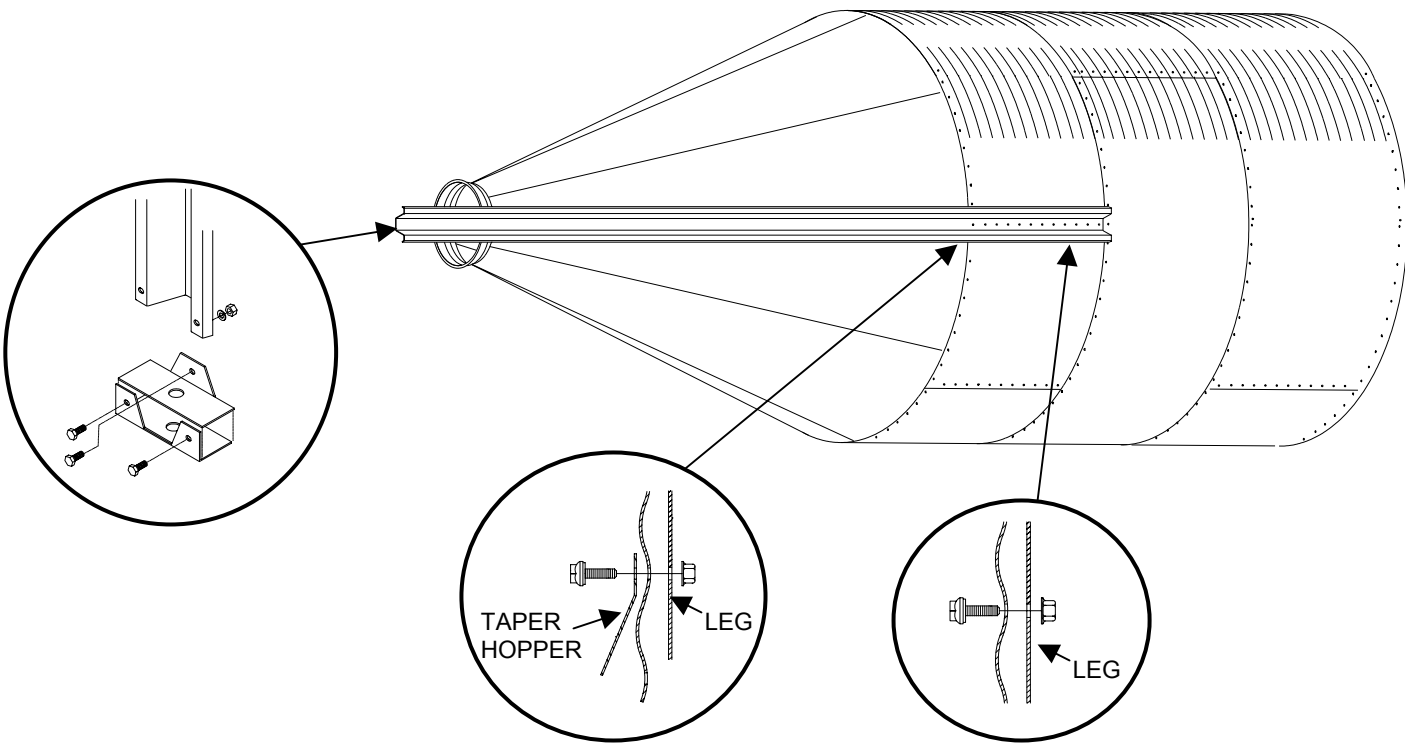


Before assembling roof deck you must decide where the lid opener and ladder will be located. Drawing below shows the preferred layout for locating the lid opener and ladder. Tru-lok lid openers must be located on a roof deck seam that aligns with a leg. Chain openers do not need to align with leg. Ladders should be located approximately 90 degrees from lid opener. After deciding on proper layout, you need to begin caulking roof decks along both sides of bottom holes and holes along side marked "OVER". Assemble roof decks over the top of corrugated hoppers starting with one end aligned with lid opener leg. Refer to drawings. Use 5/16" hex bin bolts and flange nuts. Keep bolt heads to the outside. Overlap sections as marked "over" or "under". Tighten nuts after each section. Double caulk around holes on bottom of 507025 lid collar and position on roof decks so the (3) lid hinge holes align with leg to be used for lid opener. Refer to drawing. Tighten collar and roof decks secure with same hardware as above.

ON PNEUMATIC FILL BINS, REPLACE (2) 507023 ROOF DECKS WITH (2) 507503 ROOF DECKS WITH HOLES. POSITION DIRECTLY ACROSS FROM EACH OTHER



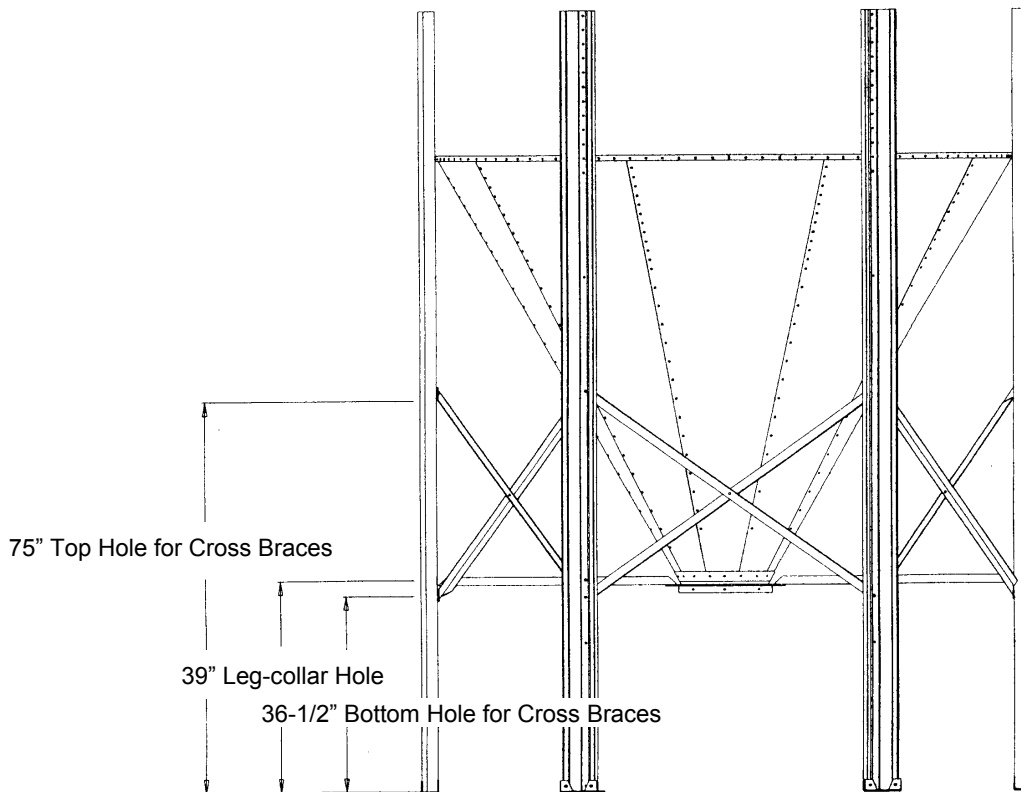
## LEG AND TANK ASSEMBLY



After you have finished assembling the tank it is time to attach the bin legs. The 507024 146" bin leg attaches to the (12) leg holes in the bottom ring while the 507039 178" bin leg will require the bottom two rings or (24) holes. To assemble legs you will need someone inside the bin to push bolts thru holes. Align holes with drift pin from outside bin. Hand tighten 501442 bin bolts and 501441 flange nuts on all holes. Refer to drawings above. Roll bin and assemble next leg until all legs are complete. Tighten all nuts secure. Before person exits bin have them check for missing bolts or caulking by darkening bin and looking for light thru open holes. After legs are secure you can now assemble top and bottom leg base plates to each leg. Use (3) 010664 3/8 x 1 hex bolts, (3) 101253 3/8" lockwashers and (3) 011115 3/8" nuts per leg. Refer to drawing above. Tighten nuts secure.

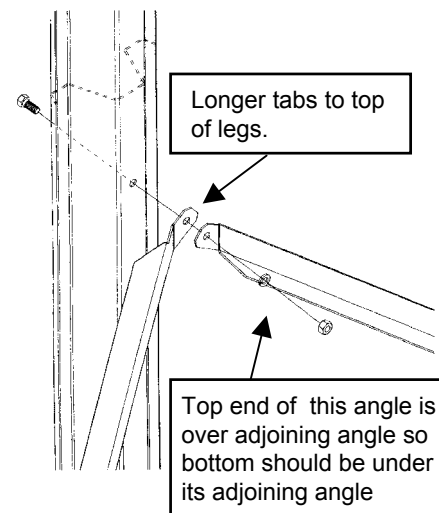
Note: While someone is still in bin you can assemble the ladder brackets as described on pages 15 and 16 and lid tube bracket on page 18 to eliminate having to reenter bin later.

## LEG AND BRACE ASSEMBLY



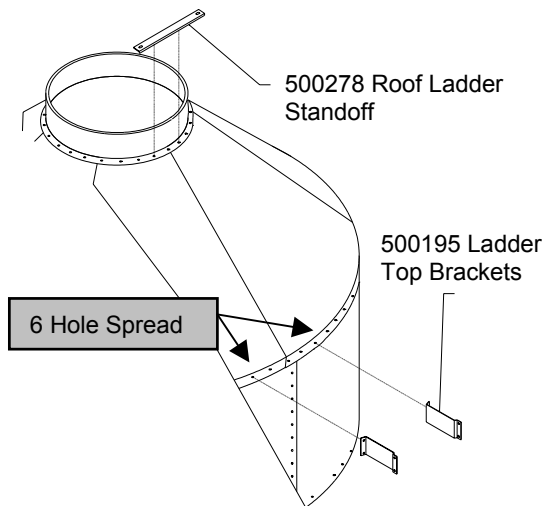
Assemble 507230 Front cross angle and 507231 Rear cross angle together in center with 012240 7/16" x 1" hex bolt, 010254 7/16" lockwasher and 011116 nut. Position between pair of legs using holes as shown in drawing and fasten with same 7/16" hardware as above. Ends of angles with longer tabs go to the top of the legs. Alternate positioning of ends is recommended for best fit. (Ex: If top end of angle is over adjoining angle then bottom end of that angle should be under the adjoining angle) Repeat assembly until all cross braces are assembled. Do not tighten nuts until all bracing is finished.

Fasten 507232 Leg-Collar brace between each leg and the top of collar with the same 7/16" hardware as rest of bracing. Use leg hole shown above and aligning hole in collar to assemble braces. Tighten all hardware secure when bracing is completed.

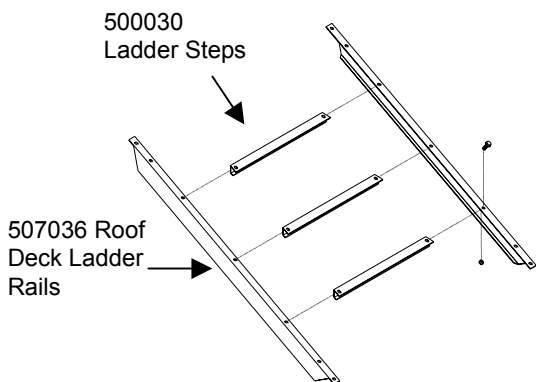




## ROOF LADDER ASSEMBLY

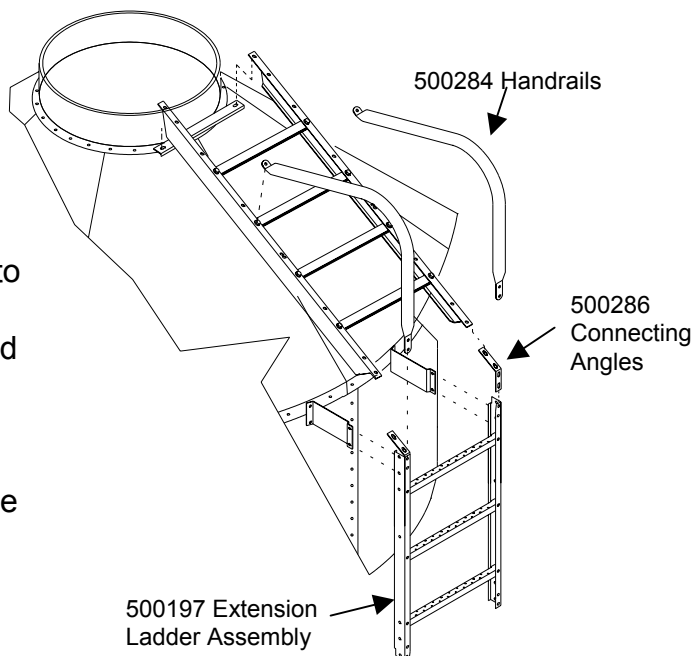


Before assembling the roof deck sections and lid collar we determined where the roof ladder would be located. Remove the (2) bolts in lid collar that align with the holes in the 500278 roof ladder standoff and assemble standoff to lid collar with the same hardware. **The following part of this assembly requires someone inside bin and can be done previously at the same time you are assembling the legs.** Now find the (2) holes in the roof deck and hopper seam that align with the outside holes of the ladder standoff. (6 hole spread) Remove the existing hardware and fasten (2) 500195 top ladder brackets to bin with same hardware using the top hole in each bracket..



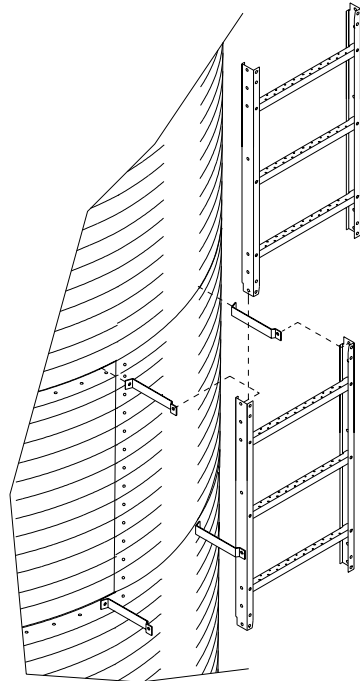
Assemble (2) 507036 roof deck ladder rails and (3) 500030 ladder steps with 501442 bin bolts and 012789 locknuts. Keep locknuts to inside of rails. Refer to drawing to determine proper spacing for rails

After roof ladder is assembled, fasten to roof standoff with (2) 010643 5/16" x 3/4" hex bolts and 012789 locknuts. Get (1) 500197 ladder extension assembly and fasten 500286 connecting angle to inside of top end of both rails and 500284 handrail to outside of rails using same hardware as above. Position extension ladder rails over top brackets and slide open end of connecting angles under roof ladder. Align the (2) holes in top brackets and connecting angles with the ladders and loosely assemble parts with hardware above. Assemble the top end of the (2) 500284 handrails with same hardware and tighten all nuts secure. All nuts should be to inside of ladders.

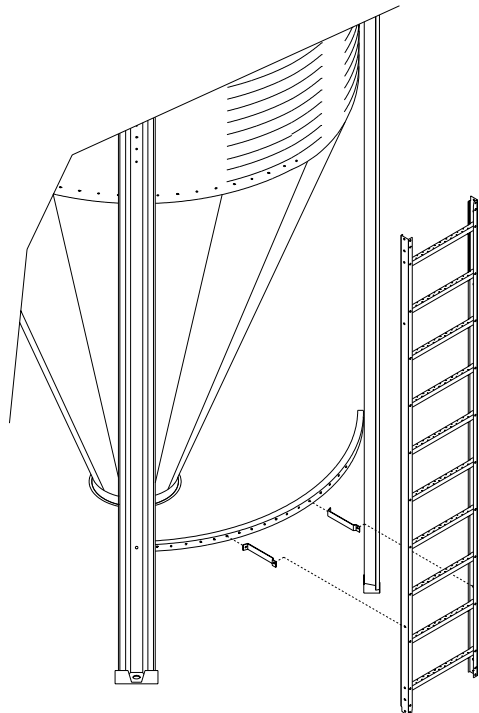


## SIDE LADDER ASSEMBLY

In each corrugated hopper seam we must attach (2) 500031 ladder brackets in alignment with the top brackets assembled previously. **This part of assembly requires someone inside bin and can be done previously at same time you are assembling legs.** Remove the bin hardware in each hole that aligns with the top brackets and assemble (2) 500031 ladder brackets per hopper ring using the same hardware just removed. Slip next extension ladder assembly inside bottom of previous ladder and assemble to each other and adjacent ladder brackets with (4) 010643 5/16" x 3/4" hex bolts and 012789 locknuts. Repeat until all ladder extensions are assembled.



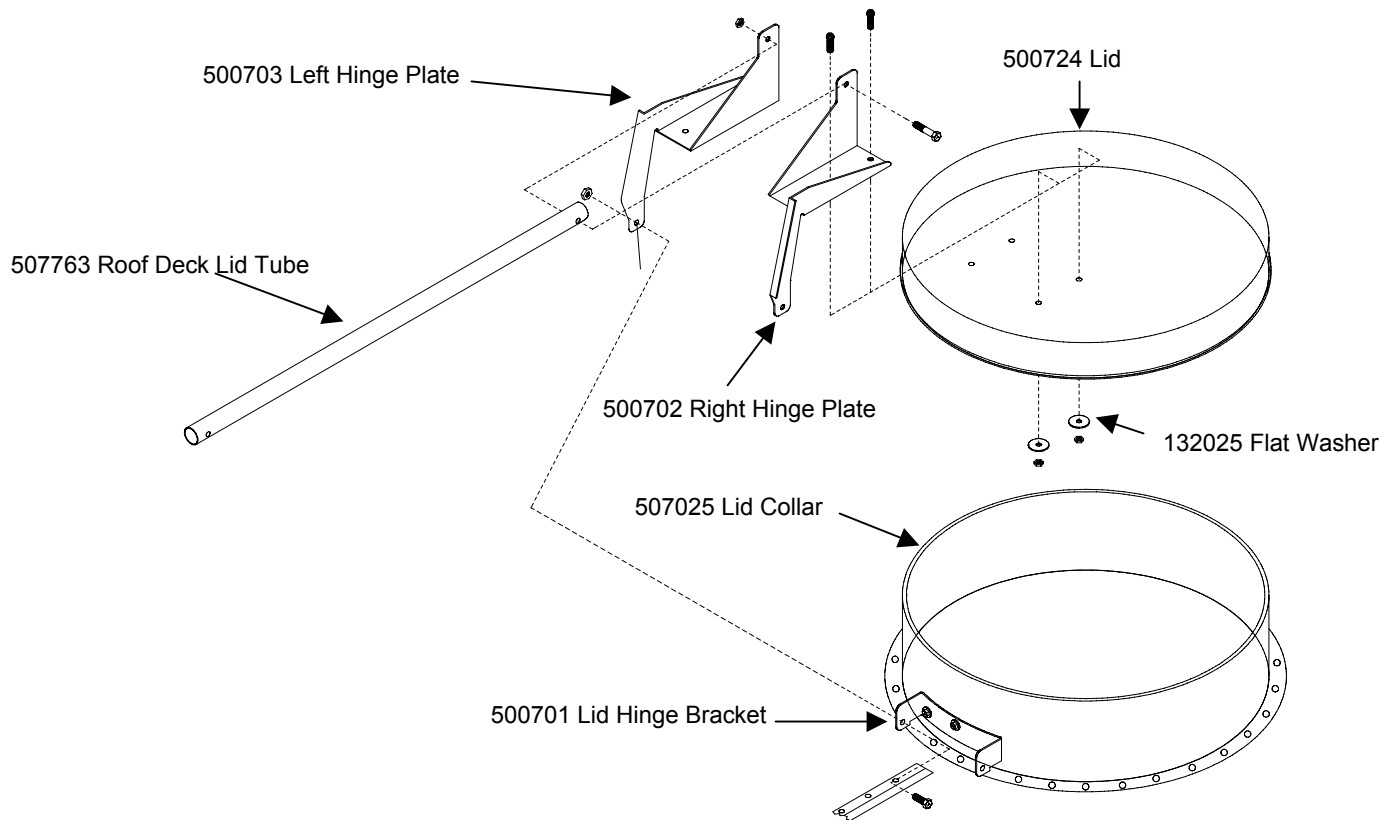
After all extension ladders are assembled, get 507034 ladder standoff rail and assemble between legs below ladders using the bottom hole of each leg (approximately 21" from bottom of leg) and 501442 bin bolts and flange nuts. Align (2) 500031 ladder brackets with ladder brackets above and fasten to standoff rail with 010643 bolts and 012789 locknuts. Slide 500196 basic ladder assembly under bottom rails of extension ladder and assemble to extension ladder and both ladder brackets on standoff rail using 010643 bolts and 012789 locknuts. After ladder is assembled tighten all locknuts.



**Make sure all locknuts are tightened securely before proceeding to next step.  
Do not overtorque locknuts.**

## TRU-LOK LID OPENER ASSEMBLY

**FOR BINS USING CHAIN STYLE LID OPENERS, REFER TO INSTRUCTIONS IN THE CHAIN OPENER COMPONENTS CARTON.**



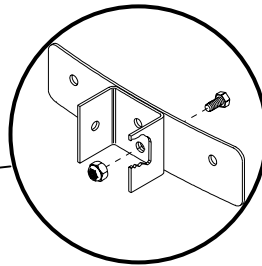
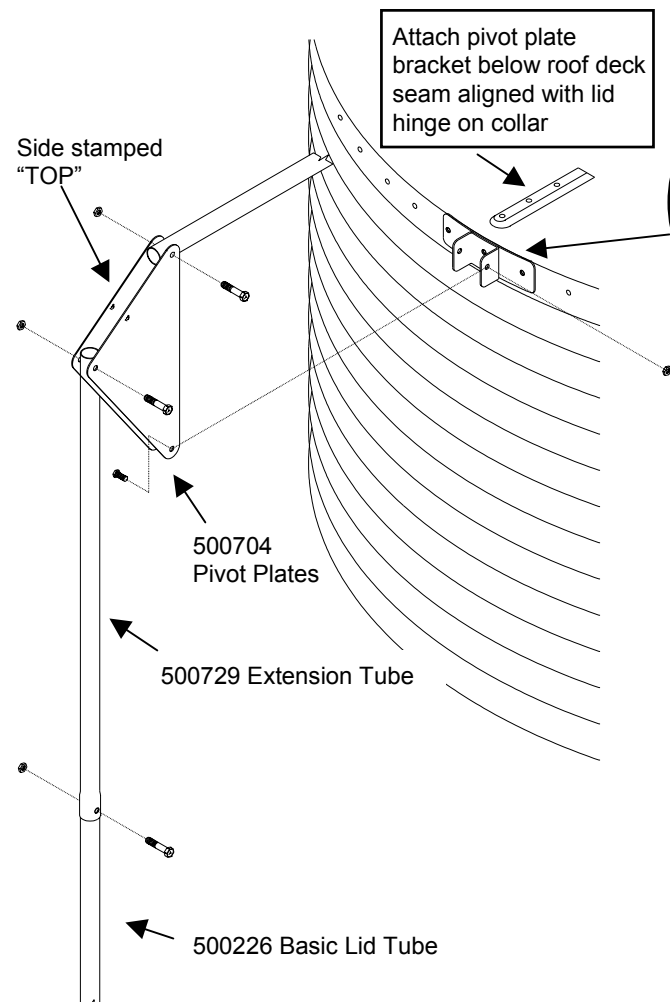
Attach 500701 hinge bracket to 507025 lid collar with (3) 501442 bin bolts and locknuts. Keep bolt heads to the outside. Bracket should be centered over the roof deck seam that aligns with the leg to be used for the lid tube. Tighten bolts securely.

Assemble 500703 left hinge plate and 500702 right hinge plate to the 500724 lid with (2) 501442 bin bolts, 132025 flat washers and locknuts per bracket. Be sure to place washers on inside of lid. Tighten bolts securely.

Attach lid assembly to lid collar by fastening lid hinge plates to lid hinge bracket with (2) 010643 5/16" x 3/4" hex bolts and locknuts. Bolt heads go on inside of hinge bracket. Do not overtighten bolts, lid must open freely.

Fasten 507763 roof deck tube between top holes in both lid hinge plates with 010649 5/16" x 1-3/4" hex bolt and locknut. Do not overtighten bolt, tube must move freely.

## TRU-LOK LID TUBE ASSEMBLY



**Attaching pivot plate to bin requires someone inside bin. This assembly can be done previously at same time you are assembling legs.**

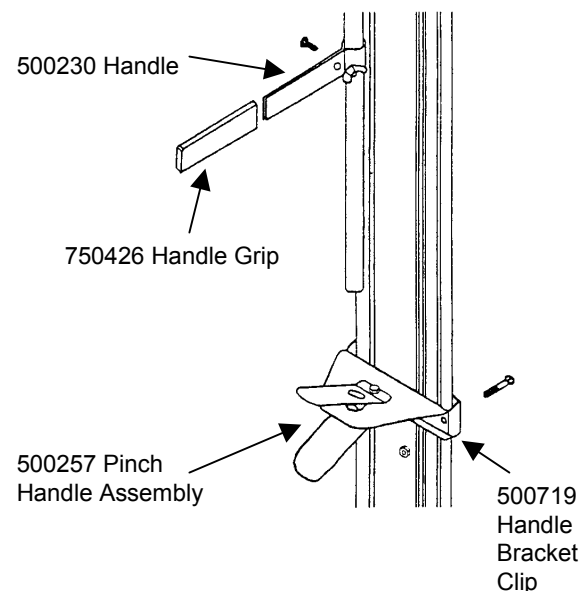
Assemble 500709 pivot plate bracket to 500710 back-up plate with 010643 5/16" x 3/4" bolt and locknut thru bottom holes as shown above. To assemble pivot plate to bin remove (3) bin bolts from holes in roof deck & hopper seam in line with roof deck seam aligned with lid hinge bracket. Reuse bin bolts to attach bracket to bin.

Assemble side marked "TOP" of (2) 500704 pivot plates to end of roof deck tube with 010649 5/16" x 1-3/4" bolt and locknut. Assemble bottom side of pivot plates to the pivot plate bracket with (2) 010643 bolts and locknuts. Bolt heads go on inside of plates. Refer to drawing. Do not overtighten bolts, pivot plates need to move freely.

Attach all 500729 tube extensions to 500226 basic lid tube with (1) 010649 bolt and locknut per tube. Fasten top extension tube to pivot plates with same hardware.

Place 500257 pinch handle assembly on bin leg approximately 40" from bottom of bin and fasten with (2) 500719 clips and (2) 010649 bolts and locknuts. Exact height can be adjusted for your comfort after bin is erect.

Slide 500230 tube handle over bottom of tube and place tube thru pinch handle. Close lid and secure handle approximately 40" above pinch handle with 011434 1/4" x 1" carriage bolt and 010943 wing nut. Wet inside of rubber handle grip and slide over handle.



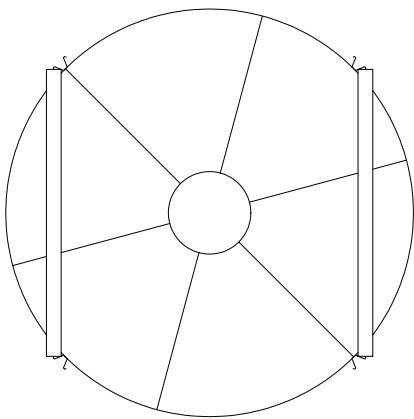
# ERECTING THE BIN

Before erecting your new bin be sure all parts are assembled properly and hardware tightened securely. Peel protective paper off "Pax" decal before raising bin. Place 2" x 4" bracing between legs as shown below to provide extra support. Use of a small crane with cables or slings will be necessary to raise most bins. Be sure to proper strength equipment. After bin is raised you need to level legs to assure stability. Leg shims are available under Pax # 500249.

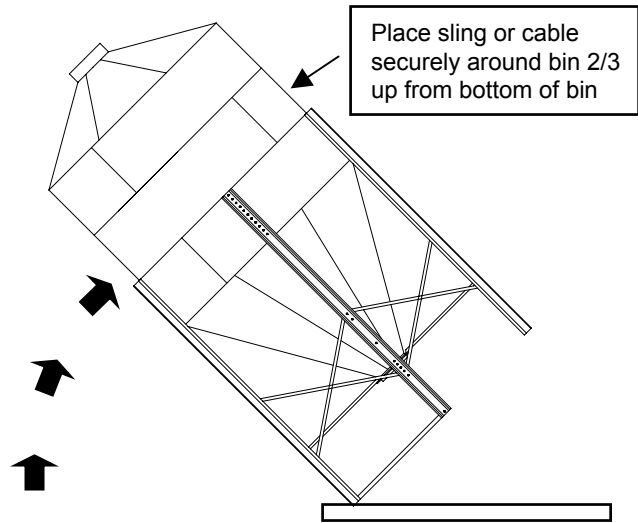


**CAUTION: BEFORE RAISING BIN, CHECK FOR OVERHEAD OBSTRUCTIONS SUCH AS POWER LINES !**

**Bottom End View**



Cut 2" x 4" braces to 59-7/8" long and fasten between legs as shown.

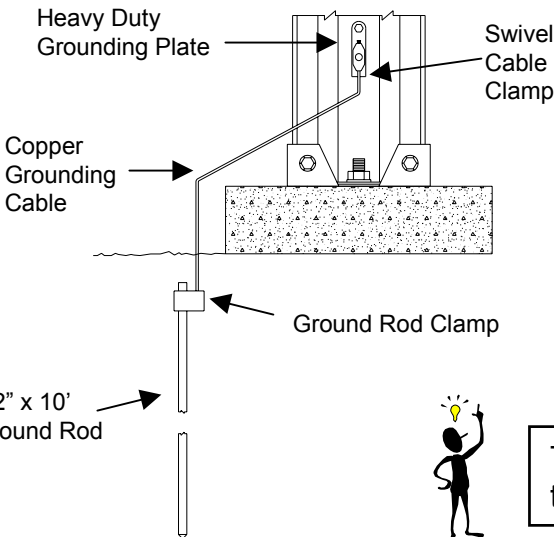


Raise bin with braced legs on bottom.



## BIN GROUNDING INSTRUCTIONS

All bins should have (2) ground connections placed at equal distances around bin. Refer to drawing for proper grounding. Parts can be purchased at local electrical retailers. **Be sure bin is grounded according to the National Electrical Code.**



To avoid cable hanging over edge of slab, place a PVC tube thru slab before pouring to drive ground rod thru.



## PRODUCT WARRANTY

Pax Steel Products, Inc. (Pax) warrants to the original purchaser that Pax manufactured products will be free of defects in material and workmanship for one year from date of purchase when used in usual and customary service.

Pax will, at its option, (a) repair or replace products found to have a defect in material or workmanship when the defective product is returned prepaid for inspection within one year of date of retail sale, or (b) refund to the original purchaser the original purchase price in lieu of such repair or replacement. All returned merchandise must be authorized and prepaid. Pax will not be liable for any unauthorized expenses incurred in regard to any item presented for warranty adjustment. Pax will not, under any circumstances, be liable for any kind of special, incidental, consequential, or contingent damages (including, but not limited to, lost or damaged product goods, cost of transportation, lost sales, lost orders, lost income, increased overhead, labor and incidental costs and operational inefficiencies) and the warranty liability will be limited to the invoiced price of the product from Pax to the purchaser.

Products which are abused, misused, altered, neglected, damaged by accident, or installed different than instructions are not covered under this warranty. Products not manufactured by Pax and supplied by outside manufacturers are warranted separately by the respective manufacturer. This warranty applies only to products used for the care of livestock and poultry - other applications in industry or commerce are not covered by this warranty.

Pax reserves the right to make design or specification changes at any time without any contingent obligation to purchasers of products already sold.

Pax feed bins are designed for storage of material having a density of no more than 40 pounds per cubic foot. The feed bins are designed for the storage of free-flowing materials only; soybean meal, meat scraps and certain other materials are not considered free-flowing and should not be stored in Pax feed bins.

Pax is not responsible for any undertaking, representation, or warranty made by any dealer, distributor, or other persons, beyond those expressly set forth in this warranty.

Any exceptions to this warranty must be authorized in writing by an officer of the company.



*Pax Steel Products, Inc.*  
*Manufacturers of Quality*  
*Livestock & Poultry Equipment*

**MAIN OFFICE**

**210 E. Main St.**

**P.O. Box 117**

**Coldwater, OHIO 45828 USA**

**PHONE: 419-678-8731 - FAX: 419-678-2200**

**TOLL FREE: 800-531-1064 (USA only)**

