

SIOUX

DURA LIFE® POLYETHYLENE

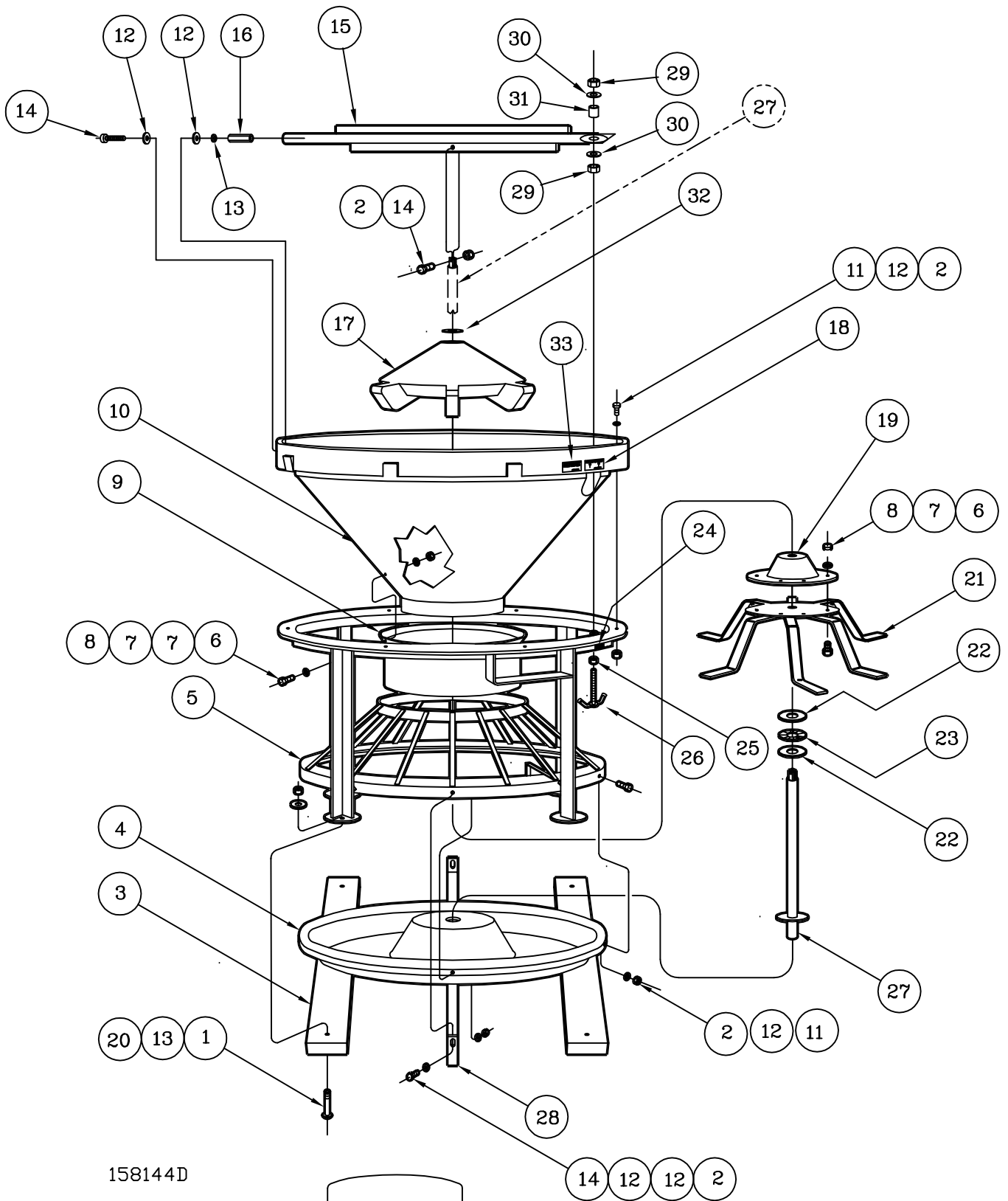
BIG O™ OSCILLATING FEEDER

16001	S15B
16006	S40HF
16007	S65HF
16008	S90HF

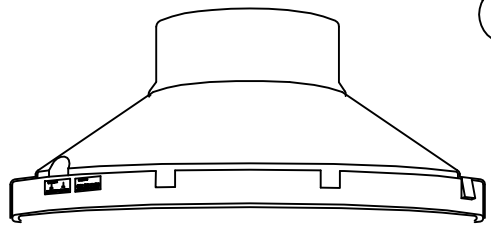
PARTS AND ASSEMBLY MANUAL

SIOUX BIG 'O' #16001
S15B, 15 BUSHEL, ALL-POLY FEEDER BASE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	164478	5/16-18 X 2 S.S. CARRIAGE BOLT	4
2	157296	5/16-18 S.S. LOCK NUT	11
3	157831	POLY FEEDER BASE SKID	2
4	157850	50" POLY FEEDER PAN	1
5	157805	FEEDER BASE WELDMENT	1
6	157898	1/4-20 X 1" S.S. HHCS	12
7	157903	1/4 S.S. FLAT WASHER	18
8	157900	1/4-20 S.S. LOCK NUT	12
9	157849	POLY RAIN GUARD	1
10	157846	56" POLY HOPPER	1
11	157893	5/16-18 X 1" HHCS	10
12	157895	5/16 S.S. FLAT WASHER	14
13	158078	5/16 S.S. LOCK WASHER	5
14	158049	5/16-18 X 1 1/4" S.S. HHCS	4
15	157842	FLOW ADJUSTER WELDMENT	1
16	158089	5/16 HEX COUPLER NUT	1
17	157847	UPPER SPIDER CONE	1
18	158023	"FEED FLOW ADJ." DECAL	1
19	157848	LOWER AGITATOR CONE	1
20	157259	5/16-18 S.S. HEX NUT	4
21	157828	36" AGITATOR WELDMENT	1
22	157838	1.13 ID X 1.73 OD MACHINE WASHER	2
23	157837	1.13 ID ROLLER THRUST BEARING	1
24	158048	"PATENT" DECAL	1
25	157797	1/2-13 S.S. HEX NUT	1
26	158080	FEED FLOW ADJ. HANDLE WELDMENT	1
27	157833	LEFT COLUMN WELDMENT	1
28	157825	PAN SUPPORT WELDMENT	1
29	160642	1/2-13 ELASTIC LOCK NUT	2
30	158087	1.057 OD X .654 ID FLAT WASHER	2
31	158086	SPACER SLEEVE	1
32	158270	2.0 OD X 1.125 ID FLAT WASHER	1
33	158792	"IMPORTANT UNEVEN FLOW" DECAL	1
34	167869	1/2-13UNC HEX COUPLER NUT x 1 1/2"	1
35	168826	WEAR RING	1
36	154003	1/4-20UNC X 3/4" BOLT - ZINC PLATED	9
37	13386	1/4" FLAT WASHER - ZINC PLATED	9
38	154046	1/4-20UNC TOP LOCK NUT - ZINC PLATED	9



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MANUAL NO. 16048
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SIoux BIG 'O'

S15B FEEDER BASE

P.N. 16001

ASSEMBLY INSTRUCTIONS

STEP 1: PLACE THE BASE WELDMENT (ITEM 5) UPSIDE-DOWN WITH THE LEG PADS UP.

STEP 2: SET THE 50" POLY FEEDER PAN (ITEM 4) WITH THE CENTER CONE FACING DOWN, IN THE ANGLE RING OF THE BASE WELDMENT.

STEP 3: FASTEN THE POLY FEEDER PAN (ITEM 4) TO THE FRAME ANGLE. FIRST, CHECK THE PAN FIT. IN SOME CASES, THE PAN WILL FIT SNUGLY. IF THE PAN IS NOT SNUG AND HAS AN EXCESS OF 1/8" CLEARANCE WITH THE PAN PUSHED TO ONE SIDE, IT WILL BE NECESSARY TO PLACE PLASTIC SHIMS BETWEEN THE PAN AND ANGLE AT EACH OF THE FOUR FASTENING HOLES. THIS PROCEDURE INSURES THAT THE PAN HOLE IS REASONABLY CENTERED IN THE FRAME.

WITH A SHORT 11/32" DRILL BIT OR BLOCK OF WOOD USED TO PREVENT DRILLING THROUGH THE INSIDE WALL OF THE PAN, TRANSFER DRILL THE FOUR (4) ANGLE FASTENING HOLES THROUGH THE OUTER PAN FLANGE. FASTEN THE PAN AS DESCRIBED IN STEPS 5 AND 6.

STEP 4: IF POLY SKIDS SHIPPED WITH YOUR FEEDER ARE NOT PRE-DRILLED, OBSERVE STEP 4A BELOW. IF PRE-DRILLED, SKIP THIS STEP AND PROCEED TO THE LAST PARAGRAPH.

STEP 4A: PLACE SKIDS (ITEM 3) ON LEG PADS WITH ENDS POINTING TOWARD THE STEP. CENTER EACH LEG ON THE PADS LENGTHWISE AND WIDTHWISE, AND THEN MARK THE LEG PAD HOLE LOCATIONS ON THE SKIDS. REMOVE SKIDS AND DRILL A 3/8" DIAMETER HOLE AT EACH MARK.

FASTEN SKIDS TO EACH LEG PAD (ORIENTATED PER STEP 4A) WITH 5/16 X 2 1/4" CARRIAGE BOLTS (ITEM 1), LOCKWASHERS (ITEM 13) AND HEX NUTS (ITEM 20).

STEP 5: PLACE THE PAN SUPPORT WELDMENT (ITEM 28) PARALLEL TO THE SKIDS AND OVER THE OUTSIDE OF THE ANGLE RING. FASTEN WITH A 5/16" X 1 1/4" BOLT (ITEM 14), 5/16" FLAT WASHER (OUTSIDE) (ITEM 12), 5/16" FLAT WASHER (INSIDE) (ITEM 12) AND 5/16" ELASTIC LOCK NUT (INSIDE) (ITEM 2) AT EACH END.

STEP 6: FASTEN THE POLY FEEDER PAN (ITEM 4) TO THE ANGLE RING AT THE HOLES PERPENDICULAR TO THE SKIDS (ITEM 3) WITH A 5/16" X 1" BOLT (ITEM 11), 5/16" FLAT WASHER (INSIDE) (ITEM 12) AND 5/16" ELASTIC LOCK NUT (INSIDE) (ITEM 2).

STEP 7: TURN THE FEEDER BASE OVER AND SET IT ON THE POLY SKIDS (ITEM 3).

STEP 8: SLIDE THE THRUST BEARING WASHER (ITEM 22), THRUST BEARING (ITEM 23), AND SECOND BEARING WASHER (ITEM 22) OVER LIFT COLUMN (ITEM 27) IN THAT ORDER. NEXT, SLIDE AGITATOR WELDMENT (ITEM 21) OVER LIFT COLUMN,

FOLLOWED BY THE LOWER POLY CONE (ITEM 19). CLAMP THE CONE (ITEM 19) TO THE AGITATOR DISC (ITEM 21) INSURING THAT THE CENTER HOLES ARE IN ALIGNMENT. WITH THE CONE PROPERLY CENTERED AND SECURELY CLAMPED TO THE AGITATOR DISC, TRANSFER DRILL THE SIX 9/32" DIAMETER HOLES THROUGH THE CONE FLANGE AND FASTEN WITH 1/4" X 1" BOLTS (ITEM 6), FLATWASHERS (ITEM 7) (POLY SIDE) AND ELASTIC LOCK NUT (ITEM 8) AT EACH HOLE.

STEP 9: INSTALL AGITATOR/LIFT COLUMN ASSEMBLY INTO FEEDER BASE BY FIRST TILTING THE ASSEMBLY SUFFICIENTLY TO GO THROUGH THE CENTER BAND RING ON BASE (ITEM 5), THEN INSERTING THE LOWER STUB END OF LIFT COLUMN INTO CENTER PAN HOLE.

STEP 10: SET THE POLY HOPPER (ITEM 10) UPSIDE-DOWN ON A FLAT SURFACE AND INSTALL THE WEAR RING (ITEM 35). THIS REQUIRES THAT THE WEAR RING BE SNAPPED IN PLACE ON THE INSIDE OF THE 19-3/8" ID OF HOPPER CONE WITH THE SHORT LIP OF WEAR RING FACING OUTWARD. FASTEN WEAR RING TO HOPPER BY DRILLING NINE (9) 1/4" HOLES THROUGH THE HOPPER AND INSTALLING 1/4" X 3/4" BOLTS (ITEM 36) FROM INSIDE OUT, 1/4" WASHERS (ITEM 37) (NEXT TO POLY), AND 1/4" LOCK NUTS (ITEM 38).

STEP 11: INSTALL THE RAIN GUARD (ITEM 9). THIS REQUIRES THAT THE 45 DEGREE FLANGE ON THE RAIN GUARD BE CENTERED ON THE HOPPER AND FASTENED BY DRILLING SIX (6) 11/32" HOLES AND INSTALLING 1/4" X 1" BOLTS (ITEM 6), 1/4" SS WASHERS (ITEM 7) (EACH SIDE OF POLY), AND 1/4" SS ELASTIC LOCK NUTS (ITEM8) ON THE INSIDE.

A DRILL FIXTURE TO ASSIST IN CENTERING THE GUARD IS AVAILABLE FROM SIOUX STEEL AS PART NO. 16057.

WITH RAIN GUARD (ITEM 9) PLACED ON THE HOPPER, INSTALL DRILL FIXTURE ON INSIDE OF RAIN GUARD AND FIRMLY POSITION BOTH AGAINST THE HOPPER. USING THE SIX (6) TABS ON THE FIXTURE AS A GUIDE, TRANSFER DRILL SIX (6) 9/32" DIAMETER HOLES THROUGH BOTH THE RAIN GUARD FLANGE AND HOPPER WALLS. WHEN DRILLING THESE HOLES, TRY TO CENTER ALL HOLES ON THE 45 DEGREE FLANGE ON RAIN GUARD. REMOVE FIXTURE AND FASTEN GUARD TO HOPPER WITH SIX (6) 1/4" X 1" BOLTS (ITEM 6), FLAT WASHERS (ITEM 7) (EACH SIDE OF POLY) AND ELASTIC LOCK NUTS (ITEM 8).

STEP 12: DRILL A 17/32" CLEARANCE HOLE FOR THE FLOW ADJUSTMENT SCREW AT THE DIMPLE LOCATED IN THE NOTCH OR EMBOSSMENT NEAR THE TOP RIM OF THE HOPPER. DIRECTLY OPPOSITE THIS EMBOSSMENT IS A SECOND DIMPLE LOCATED APPROXIMATELY 1" UP FROM THE BOTTOM OF THE TOP RIM (DRILL WITH 11/32" DRILL BIT). AT THIS HOLE INSTALL (FACING INSIDE) 5/16" X 1 1/4" BOLT (ITEM 14), FLAT WASHERS (ITEM 12) (EACH SIDE OF POLY), AND LOCKWASHER (ITEM 13). SECURELY TIGHTEN WITH COUPLER NUT (ITEM 16).

STEP 13: INSTALL 1/2" COUPLER NUT (ITEM 34) INTO THE NUT RETAINER AND REST ON THE MOUNT ANGLE THAT ARE WELDED TO THE FEEDER BASE. SET POLY HOPPER (ITEM 10) IN THE BASE FRAME (ITEM 5), ALIGNING THE SCREW EMBOSSMENT WITH THE 1/2" COUPLER NUT (ITEM 34). FULLY SEAT HOPPER INTO FRAME HOLES. NOTE: SOME HOPPERS MAY FIT SNUGLY INTO THE FRAME AND REQUIRE THAT THEY BE LIGHTLY TAPPED INTO POSITION WITH A WOODEN BLOCK AND HAMMER. TAP ONLY ON THE POLY SEATING SURFACE. USING THE SIX (6) HOLES IN THE TOP RING AS A GUIDE, TRANSFER DRILL EACH OF THE 11/32" DIAMETER HOLES UP THROUGH THE HOPPER WALL. FASTEN EACH OF THESE HOLES WITH A 5/16" X 1" BOLT (ITEM 11), FLAT WASHER (ITEM 12) (POLY SIDE) AND ELASTIC LOCK NUTS (ITEM 2).

STEP 14: SLIDE THE UPPER SPIDER CONE (ITEM 17) OVER THE CENTER LIFT COLUMN ASSEMBLY AND SEAT IT AGAINST THE INSIDE OF THE HOPPER (ITEM 10).

STEP 15: INSTALLING THE ADJUSTMENT SCREW ASSEMBLY. FIRST, THREAD A ½" HEX NUT (ITEM 25) ON THE ADJUSTMENT SCREW (ITEM 26). RUN THIS NUT ABOUT 6" ON THE SCREW. NEXT, THREAD THIS ASSEMBLY UP INTO THE BASE COUPLER NUT (ITEM 34) THAT WAS INSTALLED IN STEP 13, UNTIL ABOUT 3" IS EXPOSED INSIDE FEEDER. THEN SCREW ½" ELASTIC LOCK NUT (ITEM 29) ONTO ADJUSTMENT SCREW (ITEM 26) UNTIL 1 ½" OF THREAD IS EXPOSED, THEN PLACE BUSHING (ITEM 31) ON TOP OF NUT AND WASHER (ITEM 30) OVER BUSHING (ITEM 31).

STEP 16: INSTALL FLOW ADJUSTER WELDMENT (ITEM 15). DO THIS BY FIRST ENGAGING THE OPEN END OF TUBE WITH COUPLER NUT (ITEM 16) INSTALLED IN STEP 12. PLACE THE FLATTENED END OF ADJUSTER WELDMENT OVER EXPOSED END OF ADJUSTMENT SCREW (ITEM 16) (INSTALLED IN STEP 15). SECURE THIS END BY FIRST PLACING A SECOND MACHINE WASHER (ITEM 30) THEN THE ½" ELASTIC LOCK NUT (ITEM 29) OVER THE EXPOSED SCREW. TIGHTEN SECURELY. NOTE THAT WHEN PROPERLY INSTALLED, THE UPPER LOCKNUT SHOULD BE NEARLY FLUSH OR SLIGHTLY BELOW THE TOP OF THE SCREW.

STEP 17: FASTEN THE LIFT COLUMN (ITEM 27) TO THE MIDDLE OF ADJUSTER WELDMENT (ITEM 15). DO THIS BY FIRST TURNING THE ADJUSTMENT SCREW (ITEM 16) IN ENOUGH TO ALLOW HOLE ALIGNMENT. FASTEN THE TWO ASSEMBLIES TOGETHER WITH A 5/16 X 1¼" BOLT (ITEM 14) AND ELASTIC LOCKNUT (ITEM 2). LOCK THE ADJUSTMENT IN PLACE BY RUNNING THE ½" NUT (ITEM 25) THAT WAS INSTALLED IN STEP 14 UP AGAINST THE FRAME (ITEM 5).

YOUR FEEDER BASE SHOULD NOW BE FULLY ASSEMBLED. PROCEED TO THE STEEL OR POLY SIDE INSTALLATION.

ADJUSTMENT OF THE FEED FLOW MECHANISM IS DEPENDENT UPON YOUR PARTICULAR FEED GRIND, FEED COHESIVENESS, AND THE FEED MOISTURE CONTENT. A PROPER SETTING IS ACHIEVED WHEN FEED IS DELIVERED ONLY WHEN THE AGITATOR IS SHAKEN OR BUMPED AGAINST THE ROTARY STOP.

IF FEED FLOW IS EXCESSIVE, TURN THE ADJUSTMENT SCREW IN (UP). IF MORE FEED FLOW IS DESIRED, TURN THE SCREW OUT (DOWN).

REMEMBER THAT THIS IS A RATION TYPE FEEDER AND NOT A GRAVITY STYLE WHERE EXCESS FEED IS ALWAYS AVAILABLE TO THE ANIMAL. THE PRINCIPLE BEHIND RATION FEEDING IS REQUIRING THAT THE ANIMAL WORK THE AGITATOR TO DISPENSE FEED. THIS INSURES THAT WASTE IS KEPT TO A MINIMUM.

WHEN PROPERLY SET, YOUR FEEDER WILL PROVIDE MAXIMUM FEED UTILIZATION.

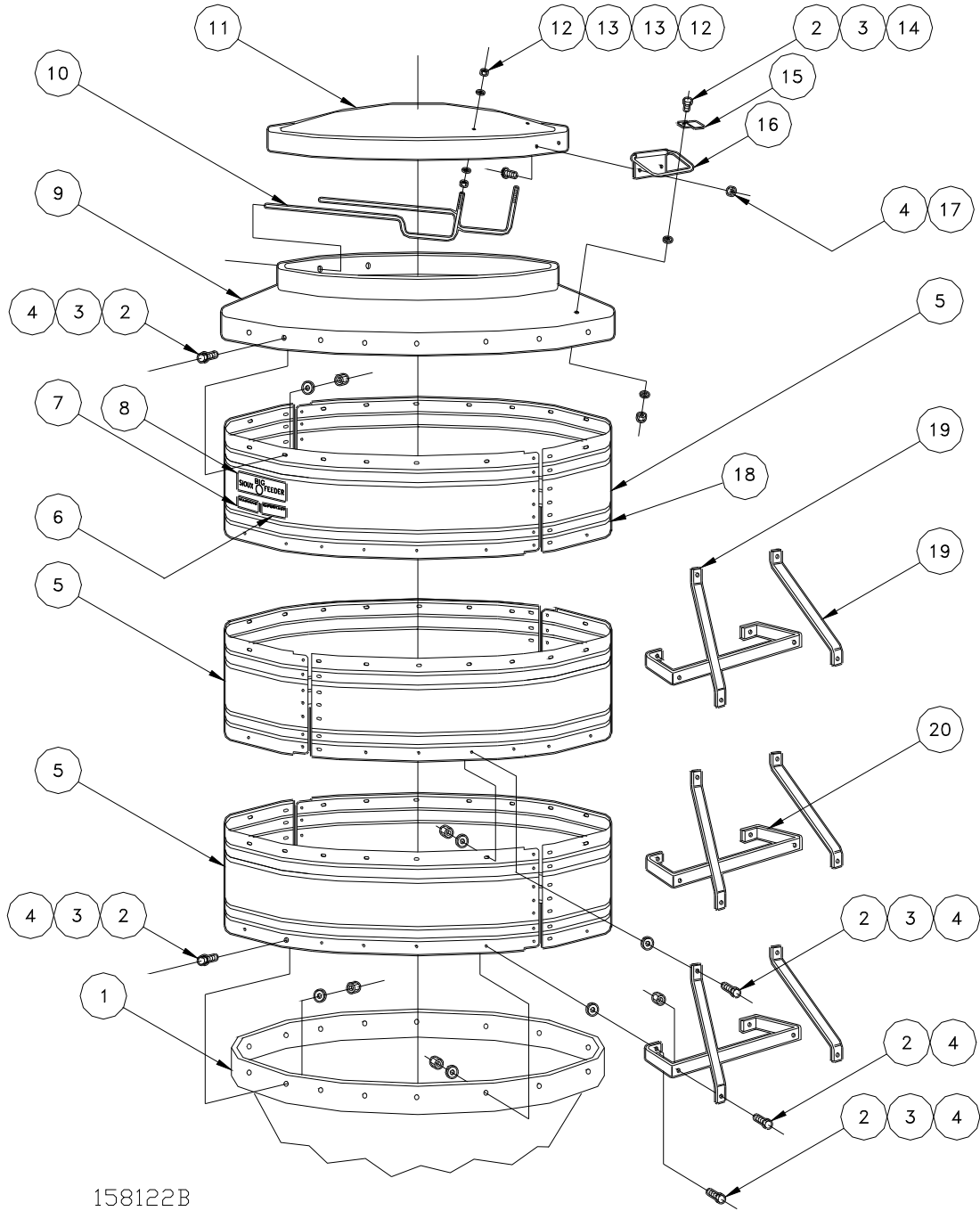
SIoux BIG 'O' #16006, 16007, 16008

*S40HF, S65HF, S90HF, 40, 65, 90 BUSHEL
GALVANIZED SIDEWALL POLY FEEDER*

PARTS LIST

KEY	PART NUMBER	DESCRIPTION	QTY.
1	16001	15 BU. POLY FEEDER BASE ASSEMBLY	1
2	157985	1/4-20 X 1" HEX HEAD BIN BOLT	67 (40 BU.) 107 (65 BU.) 145 (90 BU.)
3	13368	1/4" FLAT WASHER	67 (40 BU.) 107 (65 BU.) 145 (90 BU.)
4	13369	1/4-20 HEX NUT	66 (40 BU.) 106 (65 BU.) 144 (90 BU.)
5	157853	STEEL SIDE WALL SHEET	3 (65 BU.) 5 (90 BU.)
6	158043	"IMPORTANT...FEEDER SETUP" DECAL	1
7	158042	"WARNING...LADDER SAFETY" DECAL	1
8	157891	"SIoux BIG 'O' FEEDER" DECAL	1
9	157931	TOP POLY STIFFENER RING	1
10	157914	SLIDE ROD	2
11	157863	47 1/2" POLY LID	1
12	154048	5/16-18 HEX NUT	4
13	154063	5/16 FLATWASHER	4
14	157388	1/4-20 ELASTIC LOCKNUT	1
15	157936	HANDLE CATCH	1
16	157913	HANDLE	1
17	13322	1/4-20 X 3/4" SLOTTED TRUSS HEAD SCREW	2
18	157930	TOP STEEL SIDEWALL SHEET W/ DECALS	1
19	157928*	STEEL BRACE	6
20	157927*	STEP	3

*65 & 90 BUSHEL ONLY



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SIoux BIG 'O' #16006, 16007, 16008
S40HF, S65HF, 40, 65, 90 BUSHEL
GALVANIZED SIDEWALL FEEDER ASSEMBLY INSTRUCTIONS

STEP 1: APPLY A 3/16" DIAMETER BEAD OF SILICONE CAULKING TO THE END OF TWO SIDEWALL SHEETS. MAKE CERTAIN TO APPLY THE SILICONE TO THE END OF THE SHEET WITH THE SEVEN ROUND HOLES (FIG. A)

STEP 2: FORMING A RING, PLACE THE TWO SHEETS, WITH THE SLOTTED END OF ONE SHEET, BEHIND THE HOLE END OF THE OTHER SHEET. REPEAT THIS CONFIGURATION FOR BOTH VERTICAL SEAMS. CENTER THE HOLES IN THE SLOTS AND FINGER TIGHTEN FIVE ¼ X 1" HEX BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS (TO THE INSIDE) AND ¼ HEX NUTS PER SEAM. PLACE THE FASTENERS THROUGH THE CENTER FIVE HOLES ON BOTH VERTICAL SEAMS ONLY, LEAVING THE TOP SLOTS AND BOTTOM HOLES EMPTY AT THIS TIME (FIG. B).

STEP 3: PLACE THE STEEL SIDEWALL OVER THE OUTSIDE OF THE POLY HOPPER FEED BASE WITH THE SLOTS ON BOTH SIDES TO THE TOP SIDE, AND WITH BOTTOM OF EDGE OF SHEETS RESTING ON TOP OF LOCATOR TABS. IT MAY BE NECESSARY TO INCREASE OR DECREASE THE DIAMETER OF THE STEEL SIDEWALL RING BY MOVING THE BOLTS IN THE SLOTS, IN OR OUT. ONCE THE DIAMETER OF THE SIDEWALL IS CORRECT, ROTATE THE STEEL SIDEWALL UNTIL ONE OF THE VERTICAL SEAMS IS CENTERED DIRECTLY OVER THE STEP ON THE FEEDER BASE (FIG C).

STEP 4: AT THIS POINT, THE FEEDER SIDEWALL SHOULD BE SITTING UP OFF OF THE TOP ANGLE RING APPROXIMATELY 3" EVENLY ALL THE WAY AROUND THE FEEDER. CHECK TO MAKE SURE IT IS UNIFORMLY SPACED BEFORE PROCEEDING TO THE NEXT STEP (FIG. D).

STEP 5: ON THE BOTTOM OF THE STEEL SIDEWALL, APPROXIMATELY 1" UP FROM THE BOTTOM EDGE, ARE 28 HOLES NECESSARY TO FASTEN THE SIDEWALL TO THE POLY HOPPER. USE THESE HOLES AS A GUIDE TO DRILL THROUGH THE POLY HOPPER WITH A 5/16 DIAMETER DRILL BIT (FIG E).

STEP 6: FASTEN THE SIDEWALL AND THE HOPPER TOGETHER AT THE HOLES DRILLED IN STEP 7 USING TWENTY-EIGHT (28) ¼ X 1" HEX BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS (TO THE INSIDE) AND ¼ HEX NUTS (FIG F). ***IMPORTANT: DO NOT TIGHTEN THE BOLTS DOWN AT THIS TIME. LEAVE THEM FINGER TIGHT.***

STEP 7: USE THE SILICONE CAULKING TO SEAL THE INTERIOR SEAM BETWEEN THE STEEL SIDEWALL AND THE POLY HOPPER IN THE EVENT SMALL GAPS DEVELOP BETWEEN THE BOLTS. CLEAN THE SEAM PRIOR TO UNSTALLATION AND ALLOW THE SILICONE SUFFICIENT DRYING TIME BEFORE USE OF THE FEEDER (FIG. F).

IMPORTANT: FOR ASSEMBLY OF THE 40 BU. FEEDER, PROCEED TO STEP 11.
FOR ASSEMBLY OF THE 65 OR 90 BU. PROCEED TO STEP 8.

STEP 8: REPEAT STEPS 1 AND 2 FOR THE NEXT SIDEWALL RING. PLACE THE RING ON THE OUTSIDE OF THE LOWER RING. ROTATE THE RING UNTIL THE VERTICAL SEAMS OF THE UPPER AND LOWER RINGS ARE SPACED 90 DEGREES APART (FIG. G).

STEP 9: FASTEN THE SIDEWALLS TOGETHER FINGER TIGHT AT THE HORIZONTAL SEAM USING (28) ¼ X 1" HEX BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS (TO THE INSIDE), AND ¼ HEX NUTS (FIG. H).

STEP 10: REPEAT STEPS 8 AND 9 FOR ASSEMBLY OF THE 90 BU., THREE-RING FEEDER.

STEP 11: ATTACH THE HANDLE CATCH TO THE POLY STIFFENER RING USING A ¼ X 1" HEX BOLT WITH NEOPRENE WASHER, ¼ FLATWASHER, AND ¼ ELASTIC LOCKNUT. DO NOT OVERTIGHTEN THIS BOLT AS THE CATCH MUST ROTATE FREELY TO LOCK AND UNLOCK THE LID HANDLE (FIG. I).

STEP 12: PLACE THE POLY STIFFENER RING ON THE OUTSIDE OF THE UPPERMOST SHEET. ROTATE THE POLY STIFFENER RING UNTIL THE HANDLE CATCH INSTALLED IN THE PREVIOUS STAGE IS ALIGNED WITH THE STEP ON THE FEEDER BASE (FIG. J).

STEP 13: FASTEN THE POLY STIFFENER RING TO THE SIDEWALL FINGER TIGHT WITH 28 ¼ X 1" HEX BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS, AND ¼ HEX NUTS. (FIG. K)

STEP 14: REMOVE THE BOLTS TO THE RIGHT OF THE VERTICAL SEAM ON THE BOTTOM MOST RING, AND TO THE RIGHT OF THE FEEDER BASE STEP. TAKE OUT THE TWO BOLTS AT THE HORIZONTAL SEAM AND AT THE TWO BOLTS AT THE STIFFENER RING, DIRECTLY ABOVE THOSE PREVIOUSLY REMOVED (FIG L).

STEP 15: ATTACH THE LOWER STEP IN THE BOTTOM TWO HOLES USING TWO ¼ X 1" BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS (FIG L).

STEP 16: ATTACH THE UPPER STEP IN THE TOP TWO HOLES USING TWO ¼ X 1" BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS. ATTACH THE FOUR STEP BRACES TO THE STEPS USING TWO ¼ X 1" HEX BOLTS (WITH NEOPRENE WASHERS REMOVED) AND ¼ HEX NUTS. FASTEN THE STEP BRACES TO THE SIDEWALL USING TWO ¼ X 1" BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS (FIG L). THE 65 BUSHEL FEEDER IS SHIPPED WITH ONE EXTRA STEP AND TWO BRACES. THESE CAN BE DISCARDED AT THIS TIME. ONCE THIS STEP IS COMPLETE, PROCEED TO STEP 21.

STEP 17: REMOVE THE BOLTS TO THE RIGHT OF THE VERTICAL SEAM ON THE BOTTOM RING AND TO THE RIGHT OF THE FEEDER BASE STEP. TAKE OUT THE TWO BOLTS AT THE TWO SIDEWALL SHEET HORIZONTAL SEAMS AND AT THE STIFFENER RING, DIRECTLY ABOVE THOSE PREVIOUSLY REMOVED (FIG. M)

STEP 18: ATTACH THE LOWER STEP IN THE BOTTOM TWO HOLES USING TWO ¼ X 1" BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS. ATTACH THE LOWER STEP'S VERTICAL BRACES TO THE STEP USING TWO ¼ X 1" BOLTS (WITH NEOPRENE WASHERS REMOVED), ¼ FLATWASHERS AND ¼ HEX NUTS (FIG. M).

STEP 19: PLACE THE MIDDLE STEP BETWEEN THE SIDEWALL SHEET AND THE VERTICAL BRACES OF THE LOWER STEP. FASTEN WITH TWO ¼ X 1" BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS. ATTACH THE MIDDLE STEP'S VERTICAL BRACES TO THE STEP USING TWO ¼ X 1" BOLTS (WITH NEOPRENE WASHERS REMOVED), ¼ FLATWASHERS AND ¼ HEX NUTS (FIG M).

STEP 20: PLACE THE UPPER STEP BETWEEN THE SIDEWALL SHEET AND THE VERTICAL BRACES OF THE MIDDLE STEP. FASTEN WITH TWO ¼ X 1” BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS. ATTACH THE UPPER STEP’S VERTICAL BRACES TO THE SIDEWALL AT THE STIFFENER RING USING TWO ¼ X 1” BOLTS WITH NEOPRENE WASHERS, ¼ FLATWASHERS AND ¼ HEX NUTS (FIG M).

STEP 21: DOUBLE CHECK TO MAKE SURE ALL VERTICAL SEAMS ON THE SIDEWALL SHEETS ARE STRAIGHT. ONCE THE SEAMS ARE VERIFIED, TIGHTEN ALL OF THE FASTENERS ON THE HORIZONTAL AND VERTICAL SIDEWALL SEAMS. **IMPORTANT:** DO NOT OVER TIGHTEN THESE BOLTS, AS THE WATERPROOFING ABILITY OF THE NEOPRENE WASHERS WILL BE LOST. TIGHTEN ONLY UNTIL THE NEOPRENE JUST BEGINS TO SQUEEZE OUT LARGER THAN THE STEEL BACKING OF THE WASHER.

STEP 22: ATTACH THE HANDLE TO THE LID USING TWO ¼ X ¾” SLOTTED TRUSS HEAD SCREWS AND ¼ HEX NUTS. MAKE SURE TO PUT THE HEADS OF THE SCREWS ON THE INSIDE OF THE LID TO PROVIDE PROPER CLEARANCE (FIG N).

STEP 23: THREAD A 5/16” NUT ON THE THREADED END OF EACH SLIDE ROD USING ALL BUT APPROXIMATELY 1/8” OF THE AVAILABLE THREADS (FIG O.)

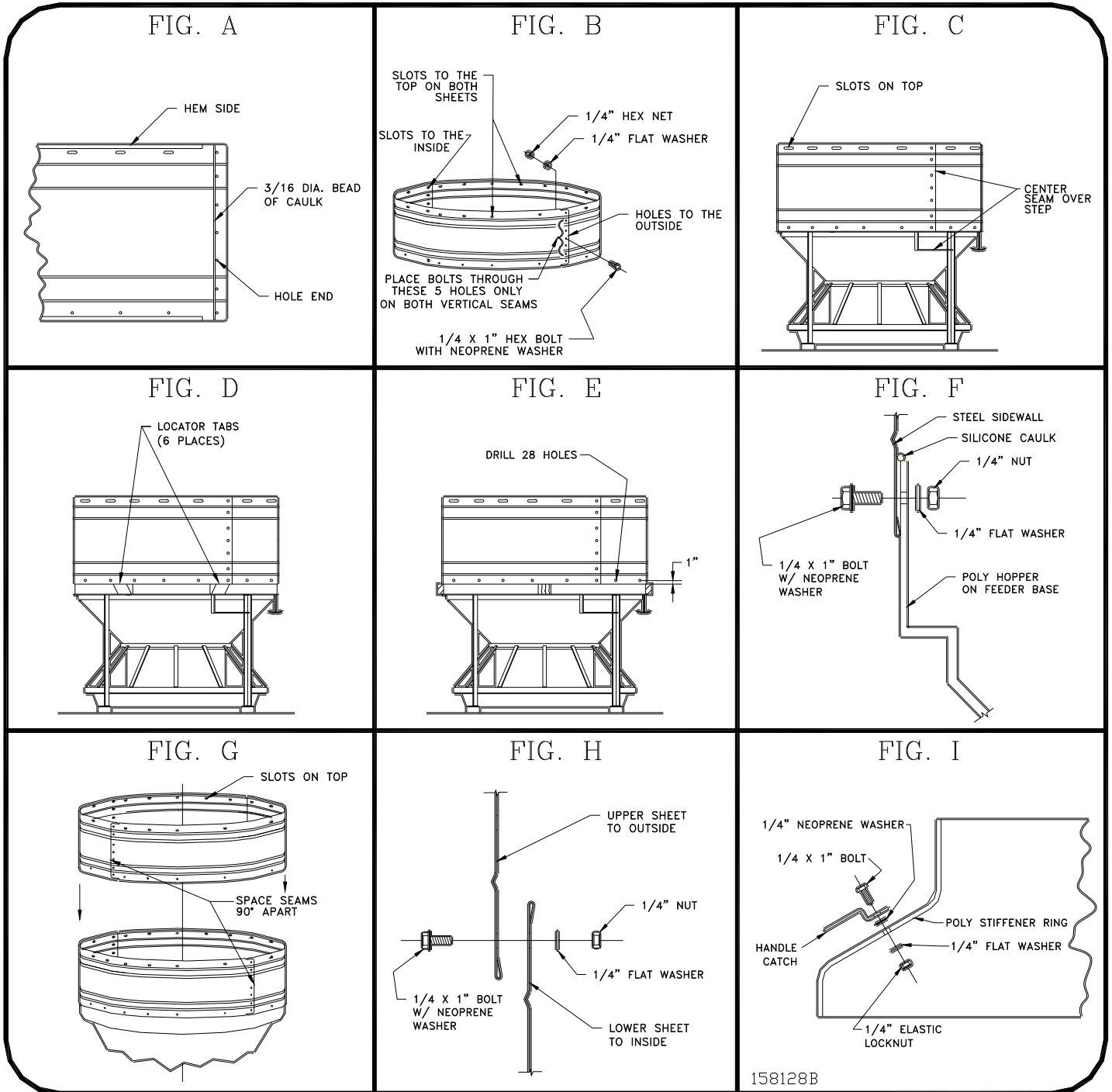
STEP 24: PLACE THE LID ON THE STIFFENER RING. ROTATE THE LID, ALIGNING THE TWO ½” HOLES ON THE LID WITH THOSE ON THE STIFFENER RING. OPEN THE LID SUFFICIENTLY TO INSERT THE UNTHREADED ENDS OF THE SLIDE RODS THROUGH BOTH THE STIFFENER RING AND THE LID HOLES (FIG P).

STEP 25: PLACE A 5/16 FLATWASHER ON THE THREADED END OF EACH SLIDE ROD. ALIGN AND PUSH THE THREADED ENDS OF THE SLIDE RODS THROUGH THE TOP LID HOLES AND FASTEN EACH WITH A SECOND 5/16” WASHER AND HEX NUT (FIG Q).

ASSEMBLY INSTRUCTIONS

FOR SIOUX BIG '0' #16006, 16007, 16008

40, 65, & 90 BUSHEL GALVANIZED SIDEWALL FEEDERS



158128B

ASSEMBLY INSTRUCTIONS

FOR SIOUX BIG '0' #16006, 16007, 16008

40, 65, & 90 BUSHEL GALVANIZED SIDEWALL FEEDERS

FIG. J

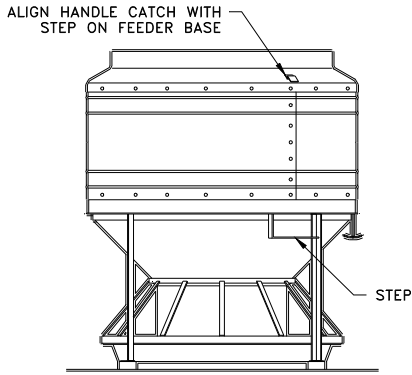


FIG. K

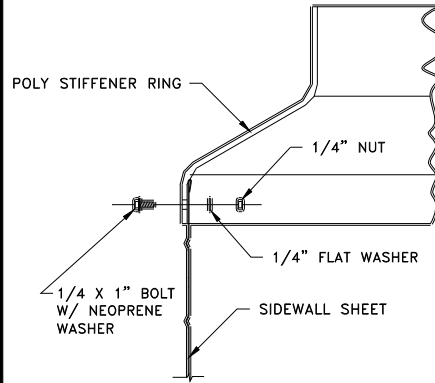


FIG. L

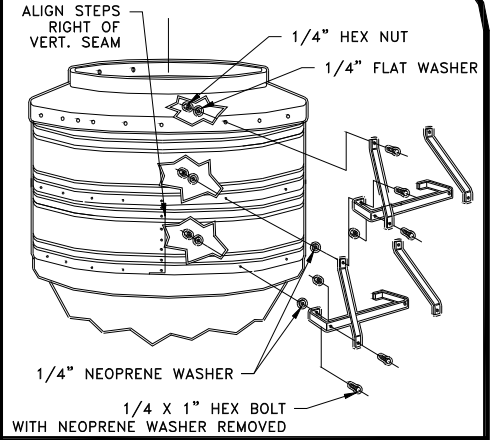


FIG. M

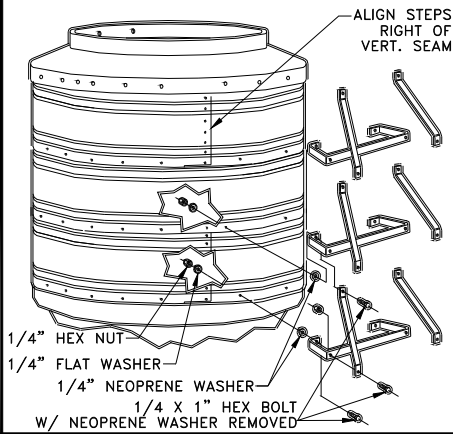


FIG. N

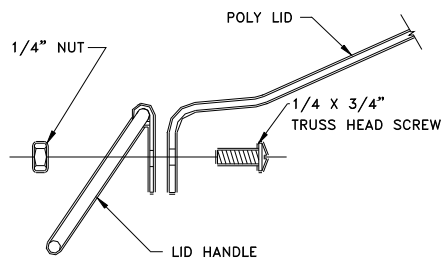


FIG. O

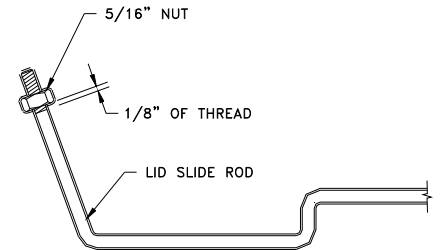


FIG. P

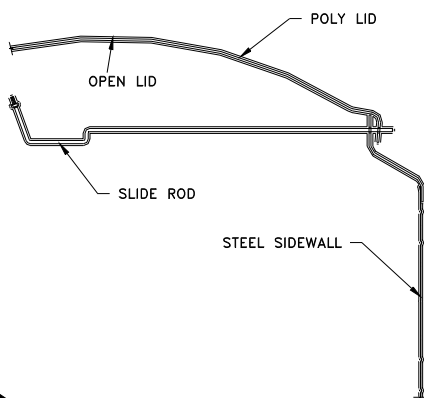
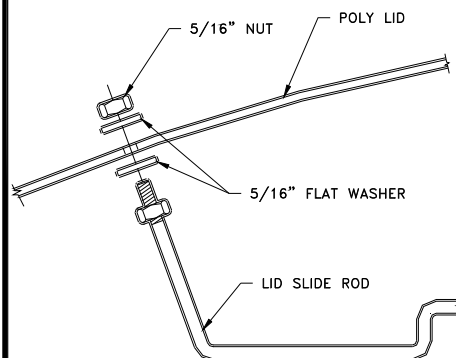


FIG. Q

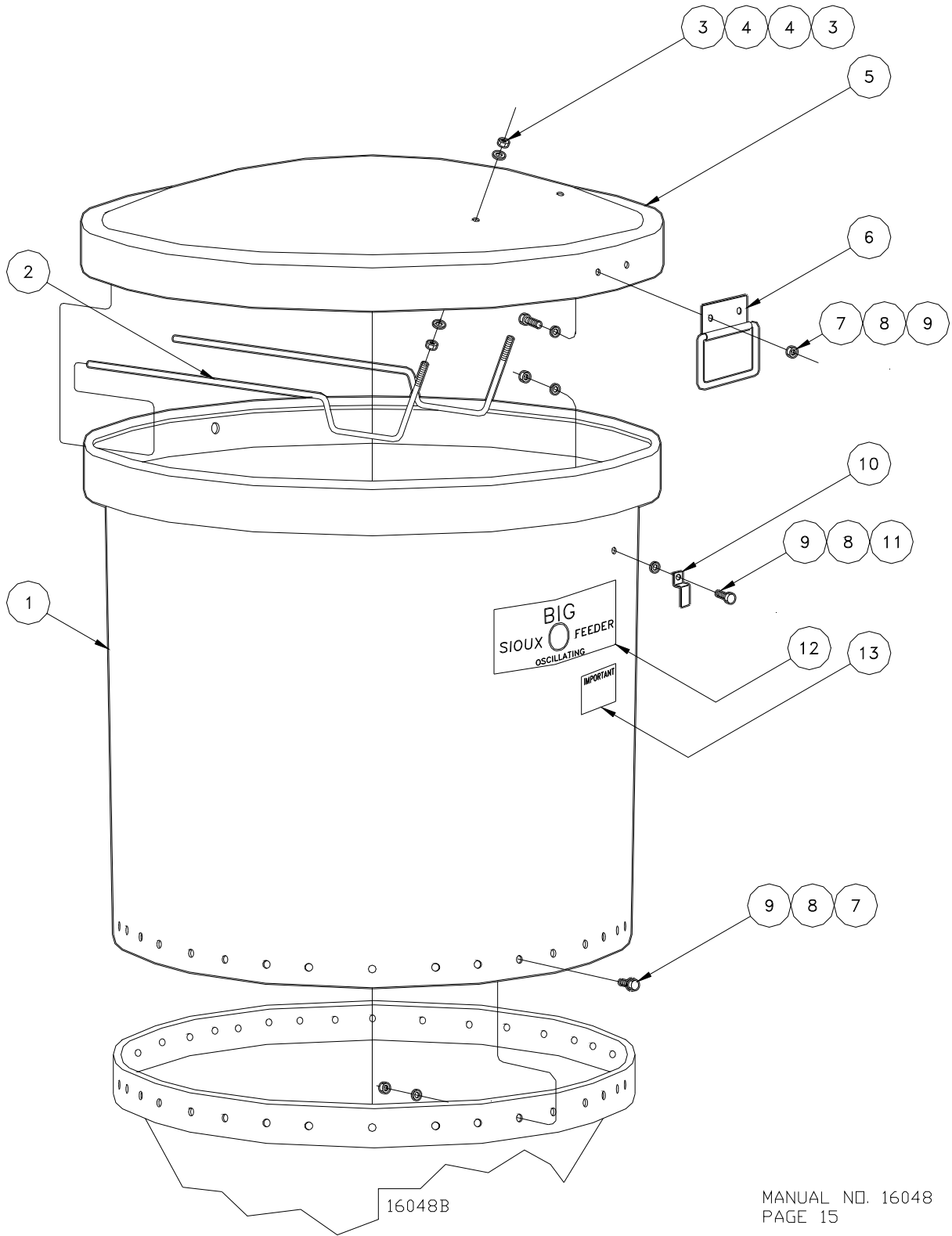


158129C

SIOUX BIG 'O' #16020
S60HF-P, 60 BUSHEL, ALL-POLY FEEDER

PARTS LIST

KEY	PART NUMBER	DESCRIPTION	QTY.
1	157909	POLY SIDE WALL	1
2	157914	SLIDE ROD	2
3	154048	5/16-18 HEX NUT	4
4	154063	5/16 FLAT WASHER	4
5	157884	62" POLY LID	1
6	157913	HANDLE ASSEMBLY	1
7	13369	1/4 HEX NUT	30
8	13368	1/4 FLAT WASHER	31
9	157985	1/4-20 X 1" HEX HEAD BIN BOLT	31
10	157936	HANDLE CATCH	1
11	157388	1/4-20 ELASTIC LOCK NUT	1
12	157891	"SIOUX BIG 'O' FEEDER" DECAL	1
13	158043	"IMPORTANT...FEEDER SETUP" DECAL	1



ASSEMBLY INSTRUCTIONS

FOR SIOUX BIG 'O' #16020

S60HF-P, 60 BUSHEL ALL-POLY FEEDER

STEP 1: PLACE THE POLY SIDE WALL OVER THE OUTSIDE OF THE FEEDER BASE WITH RIM UP. NOTE THAT FEEDERS ARE BUNDLED FOR SHIPMENT WITH THE SIDEWALL PLACED UPSIDE DOWN ON THE BASE ASSEMBLY.

STEP 2: APPROXIMATELY 31½" UP ON ONE SIDE OF THE POLY SIDEWALL IS A ¼" HOLE. ROTATE THE SIDEWALL UNTIL THIS HOLE IS DIRECTLY OVER THE STEP ON THE FEEDER BASE (FIG A).

STEP 3: THERE ARE 6 LOCATOR TABS LOCATED AROUND THE HOPPER RIM. USE THESE TABS TO SPACE THE HOPPER THE PROPER DISTANCE UP FROM THE TOP SUPPORT RING.

STEP 4: AT THIS POINT, THE FEEDER SIDEWALL SHOULD BE SITTING UP OFF THE TOP ANGLE 3" EVENLY ALL THE WAY AROUND THE FEEDER. CHECK TO MAKE SURE IT IS EVENLY SPACED BEFORE DRILLING ANY HOLES (FIG B).

STEP 5: AT THE BASE OF THE POLY SIDEWALL, APPROXIMATELY 1" UP FROM THE BOTTOM EDGE, THERE ARE 28 DIMPLES EQUALLY SPACED 6½" APART. USE THESE DIMPLES TO LOCATE AND DRILL THE (28) 9/32" DIA. HOLES NECESSARY TO FASTEN THE SIDEWALL TO THE HOPPER (FIG C). BE CAREFUL THAT THE SPACER BLOCKS REMAIN IN PLACE.

STEP 6: FASTEN THE SIDEWALL AND HOPPER TOGETHER AT THE HOLES DRILLED IN STEP 6 WITH ¼ X 1" HEX BOLTS WITH NEOPRENE WASHERS ATTACHED, FLATWASHERS (TO THE INSIDE), AND HEX NUTS (FIG D).

IMPORTANT: DO NOT OVER TIGHTEN THESE BOLTS, AS THE WATERPROOFING ABILITY OF THE NEOPRENE WASHERS WILL BE LOST. TIGHTEN ONLY UNTIL THE NEOPRENE JUST BEGINS TO SQUEEZE OUT LARGER THAN THE STEEL-BACKED WASHER.

STEP 7: A TUBE OF SILICONE CAULKING IS SUPPLIED TO SEAL THE INTERIOR SEAM BETWEEN SIDEWALL AND HOPPER IN THE EVENT SMALL GAPS DEVELOP BETWEEN BOLTS. CLEAN SEAM PRIOR TO INSTALLATION AND ALLOW SUFFICIENT DRYING TIME BEFORE USE.

STEP 8: BOLT THE HANDLE TO THE LID USING TWO ¼ X 1" BOLTS, TWO ¼ FLATWASHERS AND TWO NUTS. MAKE SURE TO PUT THE HEAD OF THE BOLT AND THE WASHERS ON THE INSIDE OF THE LID TO PROVIDE THE PROPER LID OPERATING CLEARANCE (FIG E).

STEP 9: TO INSTALL THE LID SLIDE RODS, FIRST INSTALL A 5/16 HEX NUT ON THE THREADED END OF EACH ROD USING ALL BUT APPROXIMATELY 1/8" OF THE AVAILABLE THREADS (FIG F).

NOTE: INSTALLATION OF THE FEEDER LID MAY REQUIRE ASSISTANCE.

STEP 10: INSTALL THE LID ON THE SIDEWALL. ROTATE THE LID ALIGNING THE TWO

½" HOLES ON THE LID RIM WITH THOSE ON THE SIDEWALL RIM. OPEN THE LID SUFFICIENTLY TO INSERT THE UNTHREADED END OF THE LID RODS THROUGH BOTH SIDEWALL AND LID RIM HOLES (FIG G).

STEP 11: INSTALL A 5/16 FLATWASHER ON THE THREADED END OF EACH SLIDE ROD. ALIGN AND PUSH THE THREADED ENDS THROUGH THE TOP LID HOLES AND FASTEN EACH WITH A SECOND 5/16 WASHER AND HEX NUT (FIG H).

STEP 12: THE HARDWARE USED IN STEP 13 REQUIRES THAT YOU REMOVE THE NEOPRENE WASHER FROM A ¼ X 1" HEX BOLT.

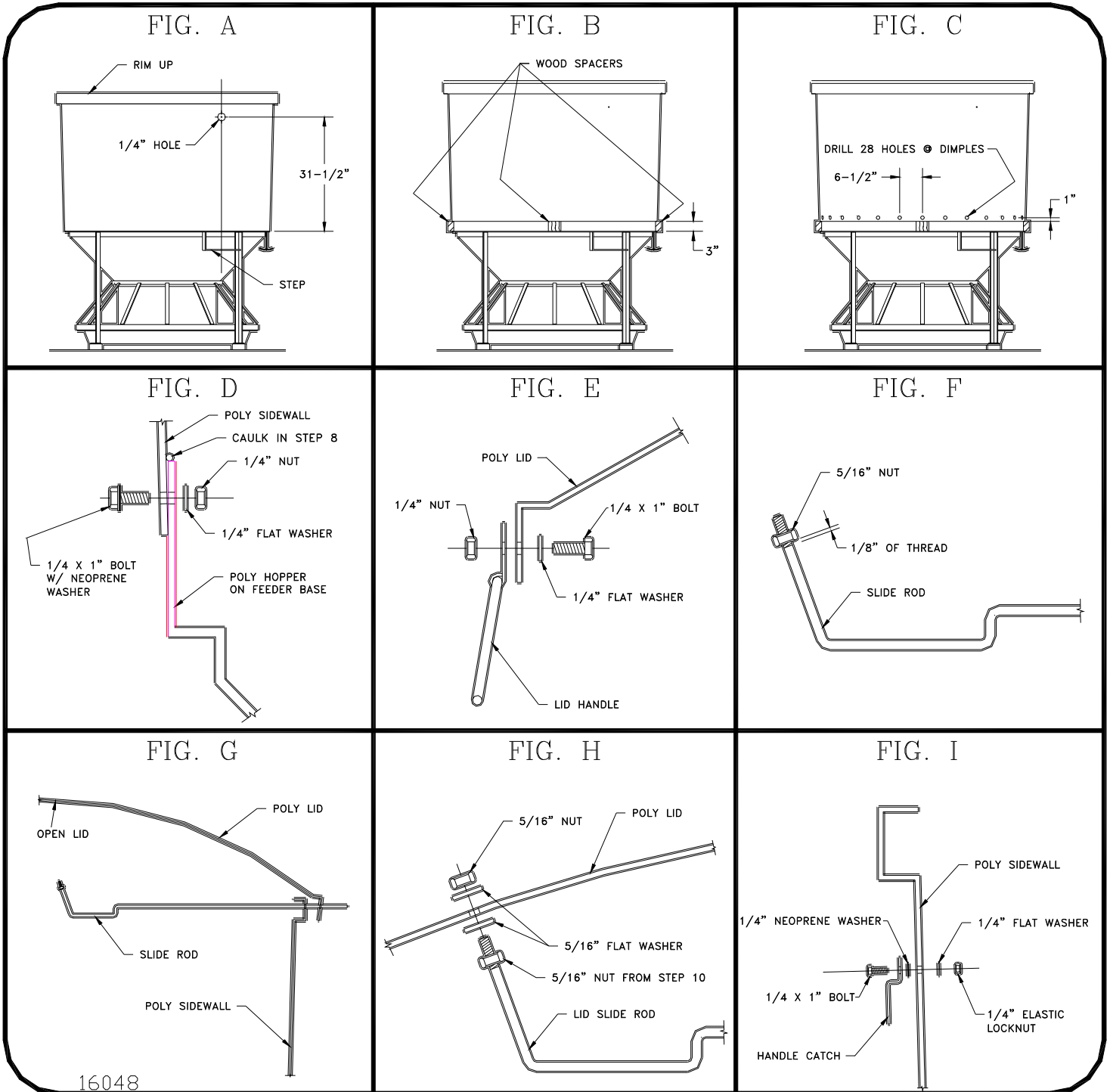
STEP 13: INSTALL THE HANDLE CATCH BY PLACING A ¼ NEOPRENE WASHER BETWEEN THE CATCH AND THE SIDEWALL, THEN FASTEN WITH A ¼ X 1" HEX BOLT, ¼ FLATWASHER, AND ¼ ELASTIC LOCK NUT. (WASHER AND LOCKNUT TO THE INSIDE). DO NOT OVER TIGHTEN THIS BOLT AS THE CATCH MUST ROTATE TO LOCK AND UNLOCK THE LID HANDLE (FIG I).

FEEDER ASSEMBLY IS NOW COMPLETE IS READY FOR USE.

ASSEMBLY INSTRUCTIONS

FOR SIOUX BIG 'O' #16020

S65HF-P, 65 BUSHEL ALL-POLY FEEDER



16048

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NEW PRODUCT WARRANTY LIVESTOCK EQUIPMENT

LIMITED WARRANTY FOR NEW SIOUX STEEL COMPANY PRODUCTS		
<p>A. GENERAL PROVISIONS. "Sioux Steel" means Sioux Steel Company, 196 1/2 East Sixth Street, Sioux Falls, South Dakota 57104. The warranties described below are provided by Sioux Steel to the original purchasers of new products purchased from Sioux Steel or from an authorized Sioux Steel Dealer (the "Products"). Under these warranties, Sioux Steel will, at its option, repair or replace at its factory any Product covered under these warranties which is found to be defective in material and workmanship during the applicable warranty term or refund the purchase price paid for the defective Product. Customer will be responsible for labor charges for removing the defective Product and reinstalling the repaired or replacement Product, any premium charge for overtime labor requested of Sioux Steel and shipping charges to and from Sioux Steel's factory. These warranties are not transferrable.</p>		
<p>B. WARRANTY PERIOD. Subject to exclusions and limitations set forth herein, each new Product is warranted for the number of years specified below. Each warranty term begins from the date of purchase regardless of delay in receipt of the Product by Customer due to the time required to process, handle, ship, assemble, construct and install the Product. Customer must retain proof of the date of purchase. Replacement parts for and repairs to the Product will be warranted only for the remainder of the original warranty term. The replacement parts for or repairs to the Product will not extend the warranty term beyond the original warranty term. Products described below include all parts, components and accessories.</p>		
LIVESTOCK EQUIPMENT		
All Poly Products		2 years
Post Puller/Pounder	Consumer Use	1 Year
	Commercial or Government Use	6 Months
All Other Livestock Equipment, including Bulk Bins		1 Year
<p>Exclusions specific to Livestock Equipment: Damage or loss of any kind from (1) storage of feed products that are not free-flowing or that have a density greater than 40 pounds per square foot; and (2) the storage of materials other than free-flowing livestock feed.</p>		
<p>C. ITEMS COVERED SEPARATELY. The Sioux Steel warranties do not cover any parts, components or materials that are part of the Product, or used in conjunction with the Product, that are not manufactured by Sioux Steel. Such parts, components and materials will be subject to the warranties provided by the manufacturer, if any.</p>		
<p>D. WHAT IS NOT WARRANTED. Sioux Steel does not warrant and is not responsible for the following: (1) used products; (2) modification or alteration of the Products; (3) Products that have not been properly installed or not installed in accordance with the instruction manual, improper assembly, or improper construction by any persons other than Sioux Steel employees; (4) depreciation, damage or loss caused by the use of parts, components or accessories not provided by Sioux Steel, unauthorized repairs, normal wear, lack of necessary and proper maintenance, a failure to follow operating instructions/recommendations, misuse, lack of proper protection during storage, vandalism or theft, exposure to the elements or corrosive materials, accidents or acts of nature including lightning, flooding, hail, straight winds and tornadoes; and (5) cosmetic damage or damage that does not hinder the functionality of the Products.</p>		
<p>E. LIMITATIONS OF WARRANTIES AND CUSTOMER'S REMEDIES. To the extent permitted by law, neither Sioux Steel, the Dealer nor any person or company affiliated with either of them makes any warranties, representations, conditions or promises express or implied as to the quality, performance or freedom from defects of the Products covered by these warranties other than those set forth herein. THERE ARE NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. NEITHER SIOUX STEEL, THE DEALER, NOR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM WILL BE LIABLE FOR ANY DAMAGES, INCLUDING, BUT NOT LIMITED TO, INCIDENTAL, SPECIAL, EXEMPLARY, CONSEQUENTIAL, LOST PROFITS AND REVENUES, LOST USE OF THE PRODUCTS OR ANY OTHER PROPERTY, BODILY INJURY OR PROPERTY DAMAGE CLAIMS OF ANY PERSON, LOST COMMODITIES, REMOVAL OR STORAGE COSTS FOR THE PRODUCTS, OTHER EQUIPMENT AND COMMODITIES, DAMAGE TO THE ENVIRONMENT ARISING FROM OR IN ANY MANNER RELATED TO ANY RELEASE OF HAZARDOUS MATERIALS, AND REMEDIATION EXPENSES THEREFORE, WHETHER BASED ON CONTRACT, TORT, STRICT LIABILITY OR ANY OTHER LEGAL BASIS, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGES. IN NO INSTANCE WILL SIOUX STEEL, THE DEALER OR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM BE LIABLE TO CUSTOMER OR ANY PERSON IN AN AMOUNT IN EXCESS OF THE PURCHASE PRICE PAID BY CUSTOMER FOR THE PRODUCT.</p>		
<p>F. NO DEALER WARRANTY. THE DEALER HAS NO AUTHORITY TO MAKE ANY WARRANTY, REPRESENTATION, CONDITION OR PROMISE ON BEHALF OF SIOUX STEEL, OR TO MODIFY THE TERMS OR LIMITATIONS OF THIS WARRANTY IN ANY WAY.</p>		
<p>G. GOVERNING LAW/VENUE. These warranties, and all terms set forth herein, are governed by the laws of the State of South Dakota and, where applicable, the laws of the United States of America. Any and all disputes arising from these warranties, the purchase and use of the Products, bodily injury and property damage claims or otherwise must be venued in the South Dakota Circuit Court sitting in Minnehaha County, South Dakota. Customer agrees to such venue and waives any challenge to such court's jurisdiction based upon lack of personal jurisdiction or inconvenience.</p>		
<p>H. SECURING WARRANTY SERVICE. In order to receive warranty services, customer must give Sioux Steel written notice of a warranty claim within 30 days of the date of discovery of the defective materials or workmanship, and Customer must complete the following steps:</p>		
(1)	<p>Obtain from Sioux Steel a Return Goods Authorization Number ("RGA Number") by calling the Customer Service Department at 1-800-557-4689, and providing the following information:</p> <ul style="list-style-type: none"> > An explanation as to why the Product is being returned. > The name of the territory representative, Dealer or Sioux Steel salesperson from whom the Product was purchased. > The Dealer's identification number. > The invoice number and date of purchase. > Customer's name, phone number, fax number, mailing address and email address. > The date that the Product will be returned. 	
(2)	<p>Pay the shipping charges to ship the Product to Sioux Steel's factory, and the return shipping charges.</p>	
(3)	<p>Ship the Product to Sioux Steel at 196 1/2 East Sixth Street, Sioux Falls, South Dakota 57104.</p>	