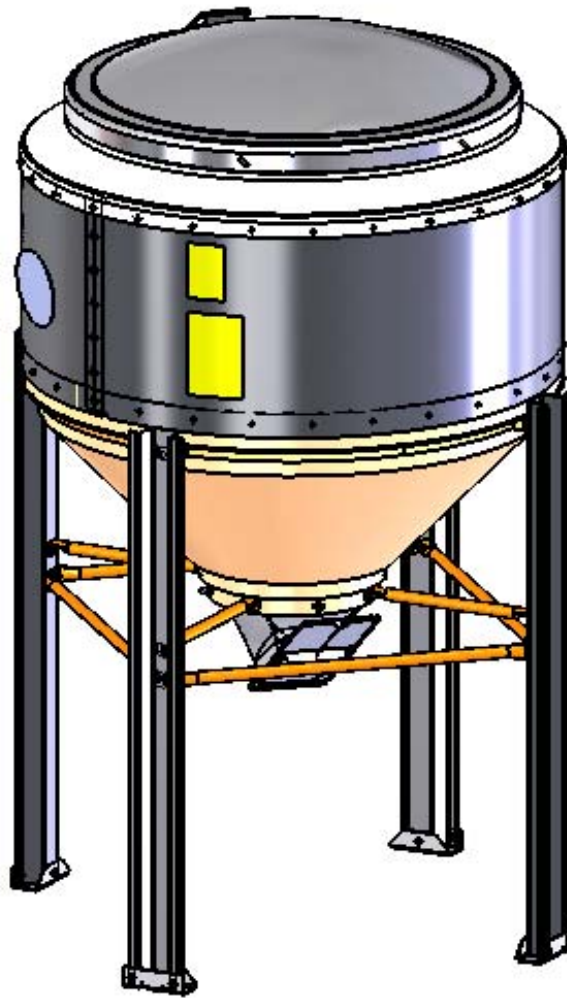


MANUAL NO. 182514
CREATED: 08/17/2007
REV C/12-099/7-9-12



40 BUSHEL MINI-BIN PARTS AND ASSEMBLY MANUAL

TABLE OF CONTENTS

SAFETY AND STATEMENTS OF IMPORTANCE...	2
GENERAL INFORMATION.....	3
ASSEMBLY INSTRUCTIONS.....	4
ASSEMBLY DIAGRAMS.....	5-9
ANCHOR BOLT LAYOUT.....	10
PARTS LIST.....	11
WARRANTY.....	12
RETURN GOODS AUTHORIZATION (RGA).....	13



SAFETY

RECOGNIZE SAFETY ALERT SYMBOL

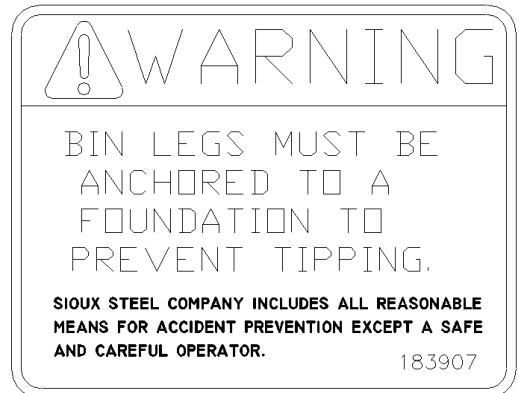
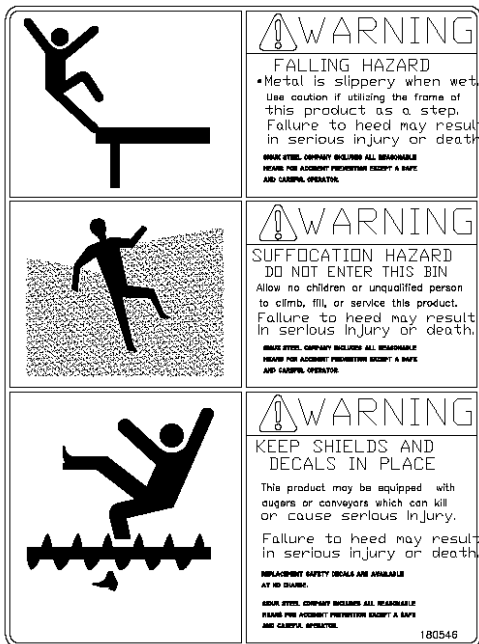
The above symbol means “ATTENTION! BE ALERT! YOUR PERSONAL SAFETY IS INVOLVED! Note this symbol in instructions for important issues concerning your personal safety. Read each message carefully to avoid personal injury or death.

SURFACE PREPARATION

Anchor the unit securely on a level surface to prevent tipping.

WARNING: KEEP CLEAR

Keep people (ESPECIALLY YOUTH) away from bin. Keep lid securely fastened except when filling.



REPLACEMENT SAFETY AND WARNING DECALS ARE AVAILABLE AT NO CHARGE

GENERAL INFORMATION

- At the time of delivery, be sure to check all bundles and parts for proper quantity and condition. If a shortage or damage has occurred, do not accept delivery without making note on the freight bill or delivery receipt. If shortage or damage is found, notify your carrier immediately, so they can send an inspector to make a formal report. Compliance with the carrier's procedure is essential for settlement of a claim as the Company's responsibility ends when the carrier receives shipment.
- Carefully read and understand this manual before beginning construction of the foundation or assembly of the bin. Refer to the parts identification diagrams to familiarize yourself with each component and its relative location in the final assembly. A detailed assembly diagram is also included with each assembly step. Be sure to note when caulking is required for a weather-tight seal.
- It is recommended that the bin be assembled on its side, for convenience, and then set upright after it has been completed, but before the slide valve or boot has been installed.
- These bins are designed for free-flowing material contents only. High moisture or fat coated material are not free-flowing and may create a bridging condition. As a precaution, it is recommended that you consult your material dealer as to the flow ability of the material you intend to use.

MINI-BIN ASSEMBLY INSTRUCTIONS

REFER TO THE CORRESPONDING STEP ILLUSTRATIONS ON THE FOLLOWING PAGES.

STEP 1: APPLY A 3/16" DIA 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.

FORMING A RING, PLACE THE TWO SHEETS, WITH THE SLOTTED HOLED END OF EACH SHEET BEHIND THE ROUND HOLE END OF THE OTHER SHEET. CENTER THE ROUND HOLES WITH THE CENTER OF THE SLOTS AND FINGER TIGHTEN WITH (5) 1/4-20 X 1 BIN BOLTS, FLAT WASHERS, AND HEX NUTS AT EACH SEAM. LEAVE THE TOP AND BOTTOM HOLES OPEN FOR LATER ASSEMBLY TO THE TOP AND BOTTOM BIN PARTS.

STEP 2: PLACE THE STEEL SIDEWALL ASSEMBLY OVER THE POLY HOPPER AND PLACE THE TOP POLY RING TO THE OUTSIDE OF THE SIDEWALLS. THE SLOTTED HOLES GO TO THE TOP WITH THE POLY RING. ADJUST THE SIDEWALL DIAMETER TO FIT THE POLY HOPPER AND POLY RING AND SECURE THE BOLTS AT THE SIDEWALL JOINTS. USING THE HOLES AS GUIDES, DRILL 5/16 DIA HOLES IN THE POLY HOPPER. SECURE THE SIDEWALLS TO THE POLY HOPPER AND POLY RING USING (56) 1/4-20 X 1 BIN BOLTS, FLAT WASHERS, AND HEX NUTS. THE BOLT HEADS ARE ON THE OUTSIDE AND THE NUTS TO THE INSIDE. THE WASHERS ARE LOCATED ON ALL SLOTTED HOLES.

CLEAN THE SURFACES AND USE SILICONE CAULKING TO SEAL THE INTERIOR SEAMS BETWEEN THE STEEL SIDEWALLS AND POLY HOPPER. ALLOW SUFFICIENT TIME FOR THE SILICONE TO CURE BEFORE USE OF THE BIN.

STEP 3: ATTACH THE LATCH TO THE TOP OF THE POLY RING USING (1) 1/4-20 X 1 HEX HEAD BIN BOLT, LOCK NUT, AND (2) WASHERS. DO NOT TIGHTEN TO ALLOW THE LATCH TO ROTATE FREELY WHEN LOCKING THE HANDLE.

ATTACH THE HANDLE TO THE POLY LID USING (2) 1/4-20 X 3/4 TRUSS HEAD SCREWS AND NUTS. THE HEAD OF THE SCREW IS TO THE INSIDE OF THE LID TO ALLOW PROPER CLEARANCE.

INSERT THE STRAIGHT SECTION OF THE GUIDE RODS THROUGH THE HOLES OF THE RING, THEN THROUGH THE HOLES IN THE LID. AFTER INSTALLING (1) 5/16 HEX NUT AND WASHER ON THE HOOK END OF EACH ROD (SEE DIAGRAM), PASS THIS END THROUGH THE HOLES IN THE TOP OF THE LID. SECURE WITH (1) 5/16 WASHER AND HEX NUT ON EACH ROD.

STEP 4: ASSEMBLE THE MINI-BIN FRAME USING (32) 3/8-16 X 3/4 HEX HEAD BOLTS, AND NYLOCK NUTS. ASSEMBLE ALL PIECES FINGER TIGHT.

ATTACH THE LEG ANCHOR BRKTS

ATTACH THE TOP RING TO THE TOP TWO HOLES OF EACH LEG.

ATTACH HOPPER BRACES TO THE CENTER HOLE OF EACH LEG.

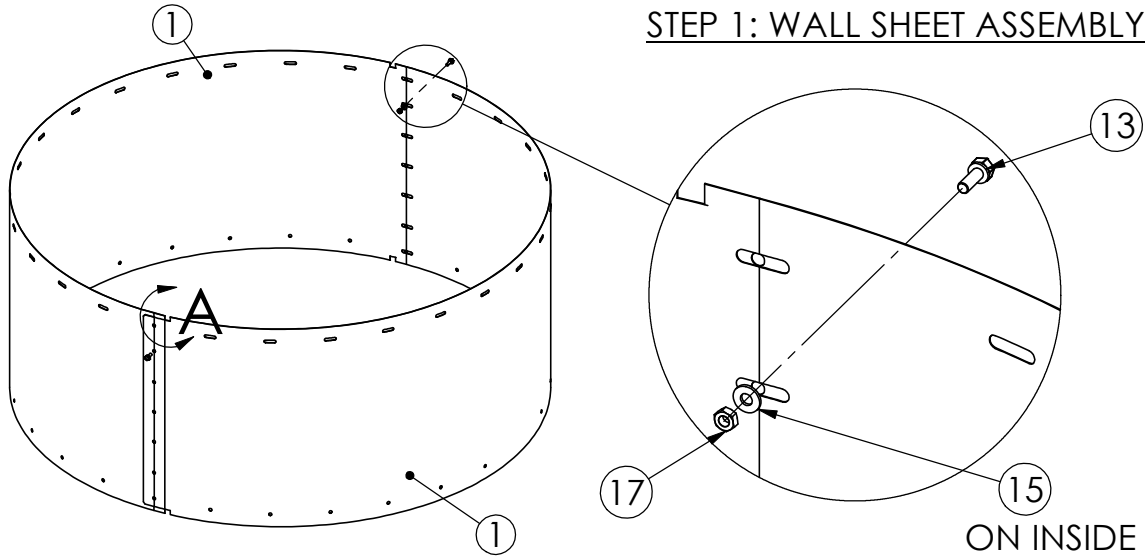
ATTACH THE LEG BRACE TO LEGS.

AFTER SQUARING THE FRAME, TIGHTEN ALL BOLTS.

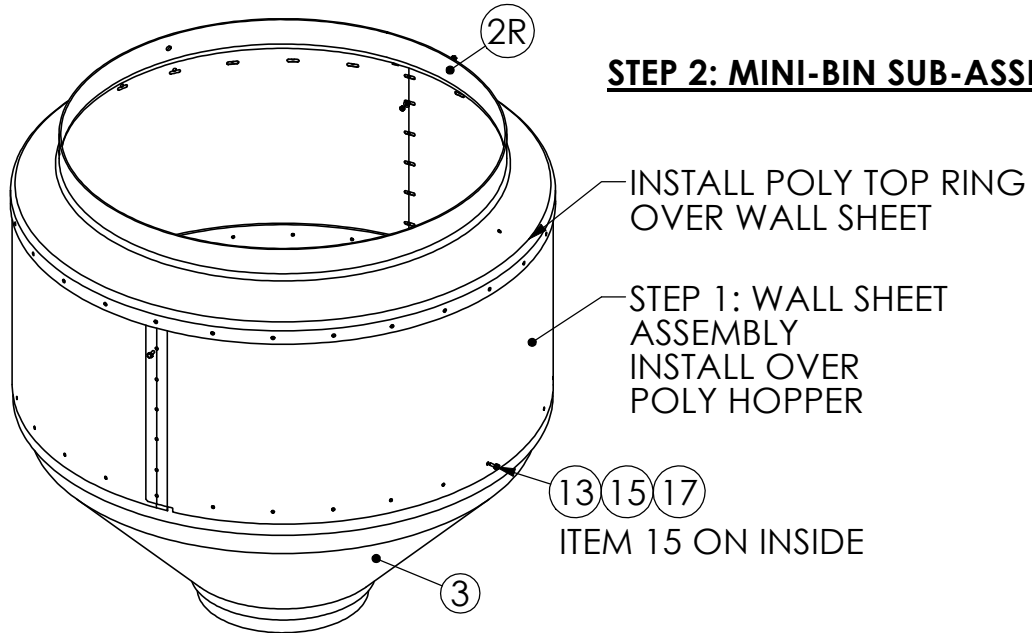
STEP 5: INSTALL THE MINI-BIN ASSEMBLY ONTO THE TOP RING OF THE FRAME ASSEMBLY. USE THE FRAME TOP RING AS A GUIDE AND DRILL (6) .281 DIA HOLES IN THE POLY HOPPER. SECURE USING (6) 1/4-20 X 1 HEX HEAD BIN BOLTS, WASHERS, AND HEX NUTS. INSERT THE POLY BOOT FROM THE TOP OF THE HOPPER AND ROTATE TO THE DESIRED POSITION. USING THE HOPPER BRACES AS A GUIDE, DRILL (4) .406 DIA HOLES AND SECURE THE BRACES, HOPPER, AND BOOT WITH (4) 3/8-16 X 2 HEX HEAD BOLTS, NUTS, AND FENDER WASHERS. USE FENDER WASHERS INSIDE THE HOPPER. ON HOOPER BETWEEN EACH HOPPER BRACE, DRILL (4) .406 DIA HOLES AND SECURE WITH ADDITION 3/8" HARDWARE AS MENTIONED ABOVE.

MINI-BIN HOPPER SUB-ASSEMBLY

STEP 1: WALL SHEET ASSEMBLY



ITEM	PART #	QTY	DESCRIPTION
1	157853	2	STEEL SIDE WALL
13	157985	10	1/4-20 X 1 BIN BOLT
15	13368	10	1/4 FLAT WASHER
17	13369	10	1/4-20 HEX NUT

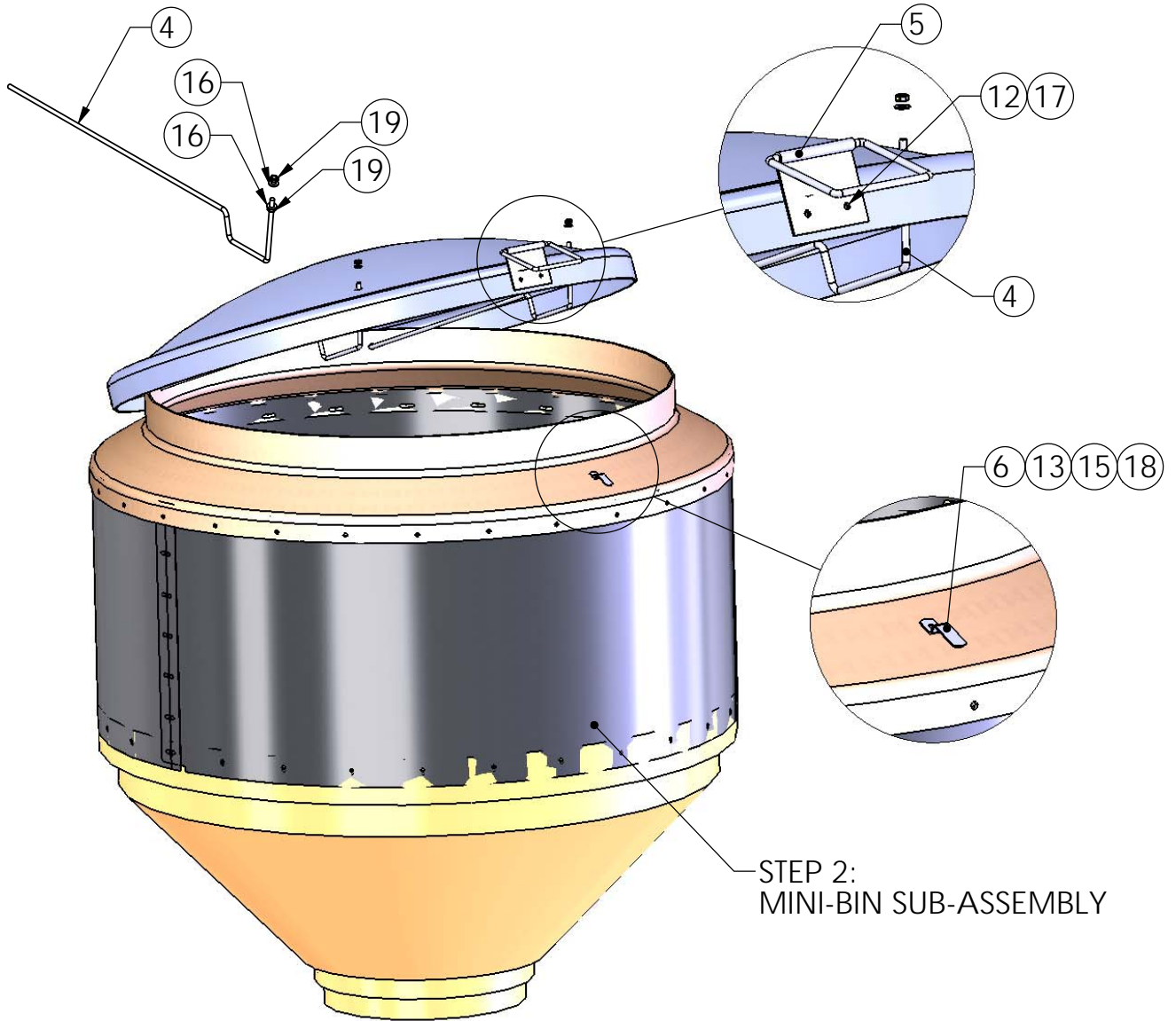


STEP 2: MINI-BIN SUB-ASSEMBLY

ITEM	PART #	QTY	DESCRIPTION
2R	180287-RING	1	POLY RING
3	180168	1	HOPPER- 15 BUSHEL
13	157985	56	1/4-20 X 1 BIN BOLT
15	13368	56	1/4 FLAT WASHER
17	13369	56	1/4-20 HEX NUT

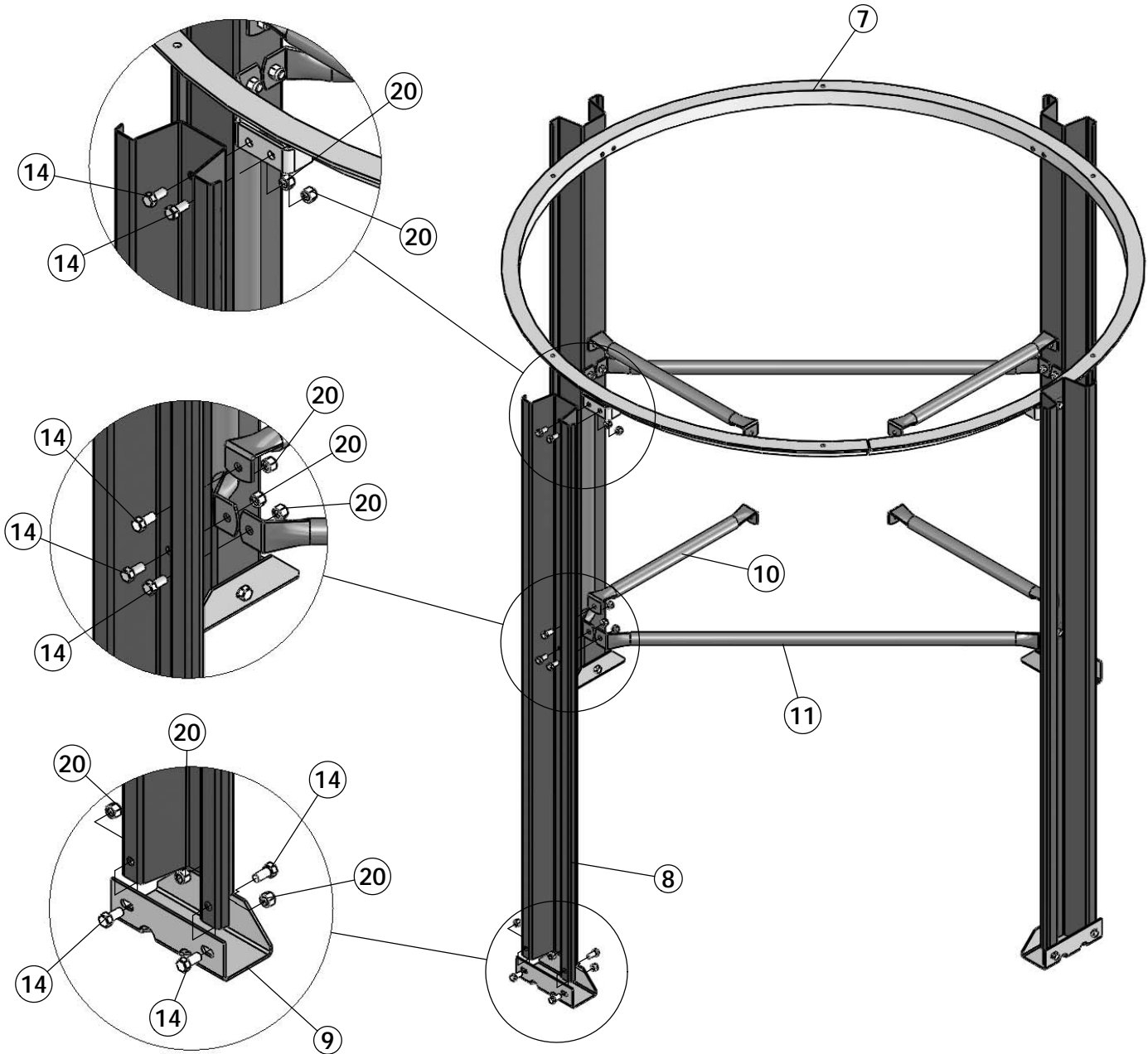
MINI-BIN HOPPER ASSEMBLY

STEP 3



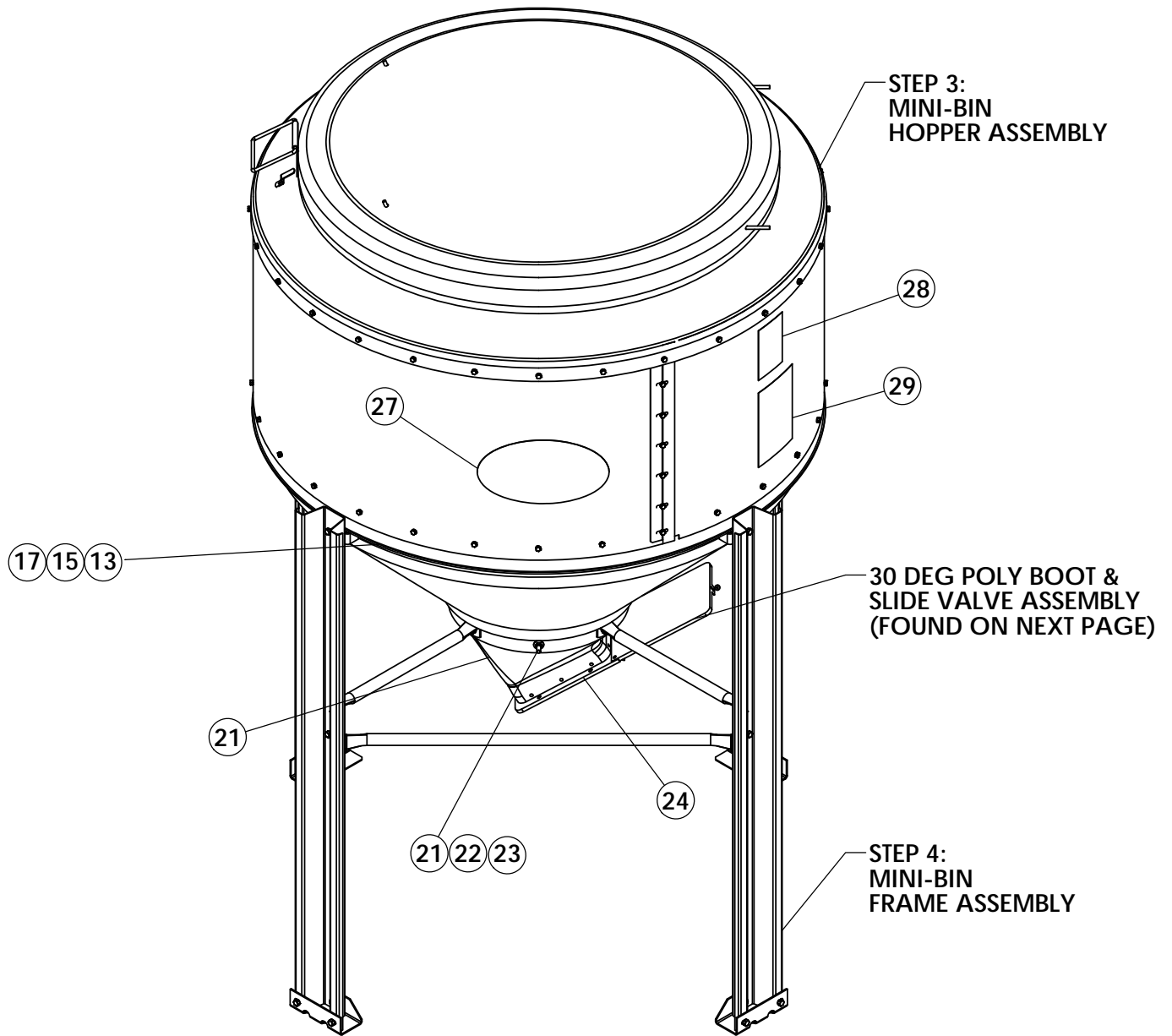
ITEM	PART #	QTY	DESCRIPTION
4	157914	2	GUIDE ROD
5	157913	1	HINGE / HANDLE ASM
6	157936	1	LOCK CLIP
12	13322	2	1/4-20 X 3/4 TRUSS HEAD SCREW
13	157985	1	1/4-20 X 1 BIN BOLT
15	13368	2	1/4 FLAT WASHER
16	154063	4	5/16 FLAT WASHER
17	13369	2	1/4-20 HEX NUT
18	157388	1	1/4-20 ELASTIC LOCK NUT
19	154048	4	5/16-18 HEX NUT

MINI-BIN FRAME ASSEMBLY STEP 4



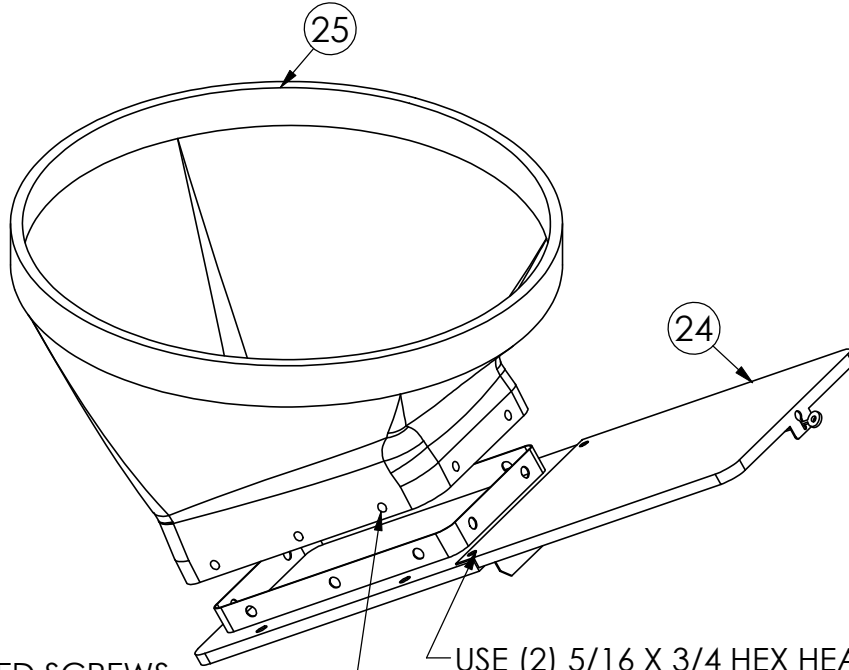
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
7	183677	TOP RING	1
8	183681	MINI BIN LEG	4
9	158309	leg anchor bracket	4
10	183684	HOPPER BRACE	4
11	195834	LEG BRACE	4
14	169705	3/8-16UNC x 3/4" GR5 ZP BOLT	32
20	159781	NUT- .375 HEX -16 ELASTIC LOCK GR5 ZP	32

MINI-BIN FINAL ASSEMBLY STEP 5



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
13	157985	1/4-20 X 1 BIN BOLT	6
15	13368	1/4 FLAT WASHER	6
17	13369	1/4-20 HEX NUT	6
21	154024	3/8-16 X 2 HH CAPSCREW	8
22	154066	3/8 WASHER	16
23	154050	3/8 HEX PUNCH LOCK NUT	8
24	500471	SLIDE VALVE	1
25	500475	BOOT UPPER POLY 30DEG	1
27	166564	DECAL- SIOUX LOGO	1
28	171264	DECAL- READ MANUAL	1
29	180546	DECAL- MINI BIN WARNING	1

30 DEG POLY BOOT AND SLIDE VALVE ASSEMBLY



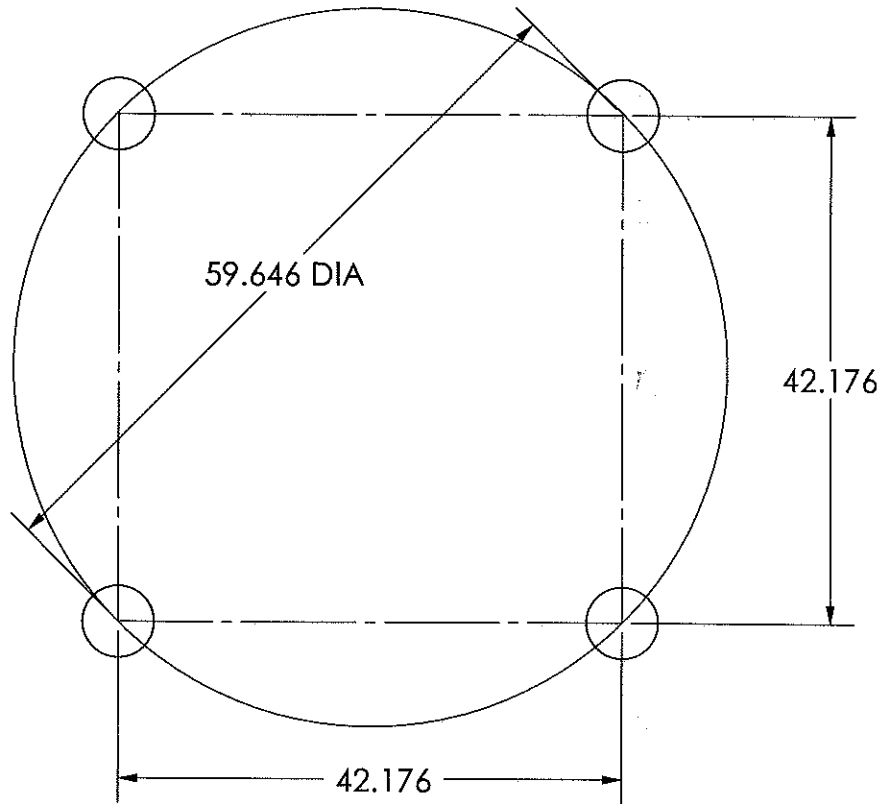
USE (8) 5/16 X 1 SLOTTED SCREWS
WITH NYLON WASHERS & NUTS
(SUPPLIED WITH THE SLIDE VALVE PACKAGE)

USE (2) 5/16 X 3/4 HEX HEAD BOLTS & NUTS
(SUPPLIED WITH THE SLIDE VALVE PACKAGE)

NOTE: INSTALL THE POLY BOOT FROM THE TOP OF THE HOPPER PER STEP 5 AND SECURE. THEN INSTALL THE VALVE PLATE ASSEMBLY AS SHOWN.

ITEM	PART #	QTY	DESCRIPTION
24	500471	1	SLIDE VALVE
25	500475	1	30 DEG POLY BOOT

ANCHOR BOLT LAYOUT



USING THE DIAGRAM ABOVE, ANCHOR THE LEGS OF THE MINI-BIN TO CONCRETE USING 1/2" STUDS. (THE STUDS ARE NOT PROVIDED BY SIOUX STEEL)

**MINI-BIN PARTS LIST
186315**

ITEM	ITEM #	QTY	DESCRIPTION
1	157853 P	2	STEEL SIDE WALL
2L	180287-LID	1	LID SECTION, POLY LID / RING SET (SEE NOTE)
2R	180287-RING	1	RING SECTION, POLY LID / RING SET (SEE NOTE)
3	180168	1	HOPPER- 15 BUSHEL
4	157914	2	GUIDE ROD
5	157913	1	HANDLE
6	157936	1	LOCK CLIP
7	S183677P	1	TOP SUPPORT RING
8	S183681	4	LEG- MINI BIN
9	S158309	4	LEG ANCHOR BRACKET
10	S183684	4	HOPPER BRACE
11	S195834	4	LEG BRACE
			ACCUMULATED HARDWARE ITEMS
12	13322	2	1/4-20 X 3/4 TRUSS HEAD SCREW
13	157985	73	1/4-20 X 1 BIN BOLT
14	169705	32	3/8-16 X 3/4 HH CAPSCREW
15	13368	74	1/4 FLAT WASHER
16	154063	4	5/16 FLAT WASHER
17	13369	74	1/4-20 HEX NUT
18	157388	1	1/4-20 ELASTIC LOCK NUT
19	154048	4	5/16-18 HEX NUT
20	159781	32	3/8-16 HEX NYLOCK NUT
21	154024	8	3/8-16 X 2 HH CAPSCREW
22	154066	16	3/8 WASHER
23	154050	8	3/8 HEX PUNCH LOCK NUT
24	500471	1	SLIDE VALVE
25	500475	1	BOOT UPPER POLY 30DEG
26	165406	1	10 OZ TUBE CLEAR SILICONE CHALK
			DECALS
27	166564	2	DECAL- SIOUX LOGO
28	171264	1	DECAL- READ MANUAL
29	180546	1	DECAL- MINI-BIN WARNING
	NOTE:		THESE PARTS ARE A SET & ORDERED AS 180287

Sioux Steel Co.
 196 1/2 East 6th Street
 P.O. Box 1265
 Sioux Falls, SD 57101-1265



Phone:(800) 557-4689
 (605) 336-1750
 (605) 557-4689
 Sales Fax:(605) 357-8597
 Fax:(605) 336-2528

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>	

RETURN GOODS AUTHORIZATION (RGA)

Any product returned to Sioux Steel Company for warranty or non-warranty consideration must have an RGA number assigned to the product and tagged onto the product that is to be returned. **ANY PRODUCT BEING RETURNED WITHOUT AN RGA NUMBER WILL BE REFUSED. IT IS THE PURCHASER'S RESPONSIBILITY FOR ANY TRANSPORTATION CHARGES. NO C.O.D.'S WILL BE ACCEPTED.** An RGA number can be obtained by calling the Warranty Department at 1-800-557-4689

Please have the following information available:

- Why are items being returned?
- Territory Representative or inside sales contact.
- Invoice number and date.
- Part number, description and quantity.
- Dealer ID number.
- Contact name, phone number, fax number and e-mail address.
- When will items be returned?

Custom built, special order or obsolete equipment may not be returned.

There will be a 10% restocking charge on all equipment authorized for return unless the equipment is under warranty, or was shipped incorrectly. If the equipment requires repainting or repackaging, a 25 % restocking and refurbishing charge will apply.