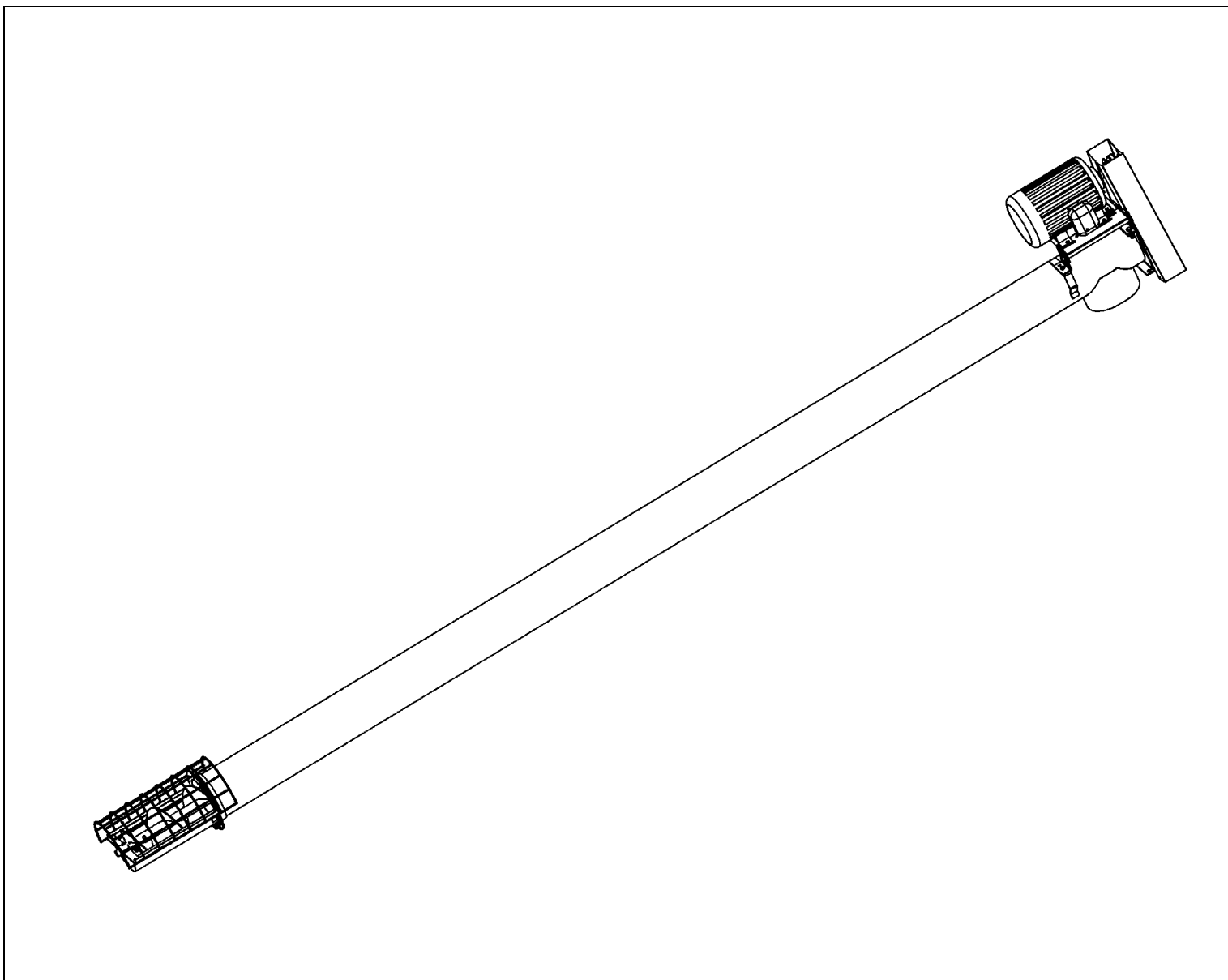




GRAIN AUGERS

UTILITY

ASSEMBLY & OPERATION MANUAL



Read this manual before using product. Failure to follow instructions and safety precautions can result in serious injury, death, or property damage. Keep manual for future reference.

Part Number: 30644 R1

Revised: 26/4/10



This product has been designed and constructed according to general engineering standards^a. Other local regulations may apply and must be followed by the operator. We strongly recommend that all personnel associated with this equipment be trained in the correct operational and safety procedures required for this product. Periodic reviews of this manual with all employees should be standard practice. For your convenience, we include this sign-off sheet so you can record your periodic reviews.

Date	Employee Signature	Employer Signature

a. Standards include organizations such as the American Society of Agricultural and Biological Engineers, American National Standards Institute, Canadian Standards Association, International Organization for Standardization, and/or others.

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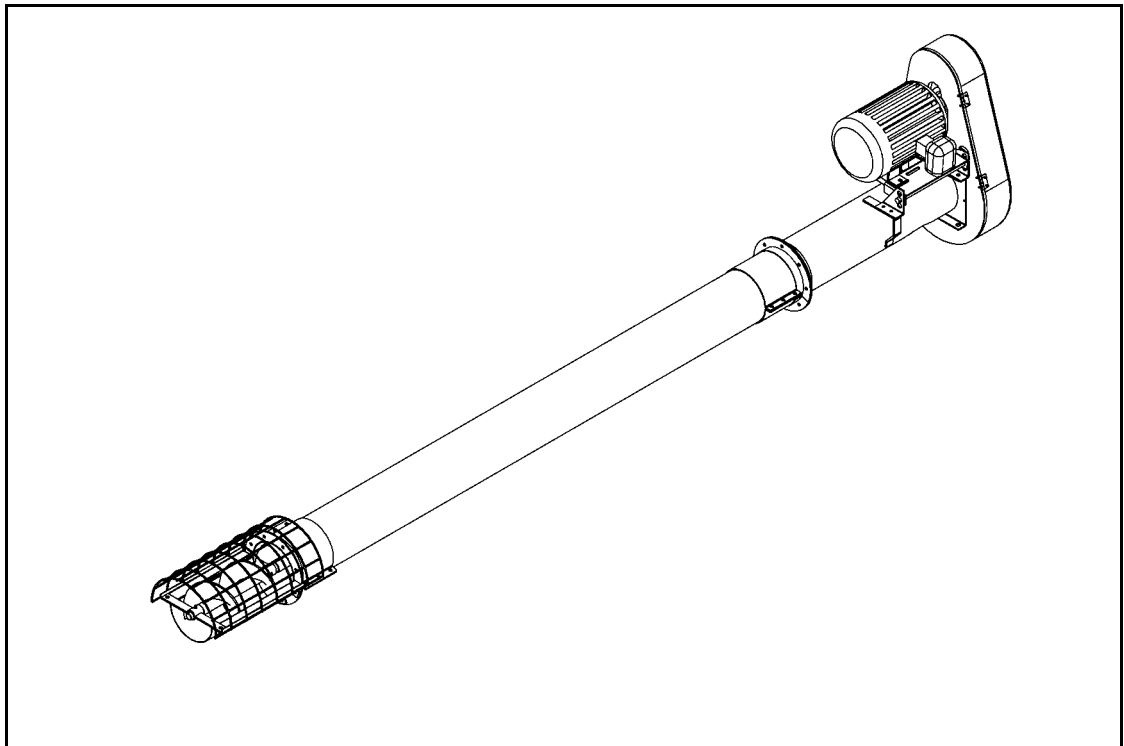
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1. Introduction

Congratulations. As the new owner of a grain auger, you will be working with equipment designed to complement and improve your farming operation. Before using this auger, please read this manual and all safety labels and familiarize yourself with the various features of the machine and the necessary precautions for efficient and safe operation.

In addition, anyone using this auger is required to comply with all safety precautions in this manual and in safety labels attached to the auger. A sign-off form is supplied on the inside front cover to record your safety reviews.

Thank you.



Serial Number:	
-----------------------	--

Serial number is located at top of tube.

2. Safety First



The Safety Alert symbol to the left identifies important safety messages on the product and in the manual. When you see this symbol, be alert to the possibility of personal injury or death. Follow the instructions in the safety messages. Why is SAFETY important to you?

Three big reasons:

- Accidents disable and kill.
- Accidents cost.
- Accidents can be avoided.

SIGNAL WORDS

Note the use of the signal words **DANGER**, **WARNING**, **CAUTION**, and **NOTICE** with the safety messages. The appropriate signal word for each message has been selected using the definitions below as a guideline.

The Safety Alert symbol means ATTENTION, BE ALERT!, YOUR SAFETY IS INVOLVED.

DANGER



Indicates an imminently hazardous situation that, if not avoided, will result in serious injury or death.

WARNING



Indicates a hazardous situation that, if not avoided, could result in serious injury or death.

CAUTION



Indicates a hazardous situation that, if not avoided, may result in minor or moderate injury.

NOTICE

Indicates a potentially hazardous situation that, if not avoided, may result in property damage.

2.1. GENERAL SAFETY

Important: *The general safety section includes instructions that apply to all safety practices. Any instructions specific to a certain safety practice (e.g., assembly safety), can be found in the appropriate section. Always read the complete instructional sections and not just these safety summaries before doing anything with the equipment.*

YOU are responsible for the **SAFE** use and maintenance of your equipment. **YOU** must ensure that you and anyone else who is going to work around the equipment understands all procedures and related **SAFETY** information contained in this manual.

Remember, **YOU** are the key to safety. Good safety practices not only protect you, but also the people around you. Make these practices a working part of your safety program.

- It is the equipment owner and the operator's responsibility to read and understand **ALL** safety instructions, safety decals, and manuals and follow them before assembling, operating, or maintaining the equipment. All accidents can be avoided.
- Equipment owners must give instructions and review the information initially and annually with all personnel before allowing them to operate this product. Untrained users/operators expose themselves and bystanders to possible serious injury or death.
- Use this equipment for its intended purposes only.
- Do not modify the equipment in any way. Unauthorized modification may impair the function and/or safety, and could affect the life of the equipment. Any modification to the equipment voids the warranty.
- Do not allow children, spectators, or bystanders within the work area.
- Have a first-aid kit available for use should the need arise, and know how to use it.
- Provide a fire extinguisher for use in case of an accident. Store in a highly visible place.
- Wear appropriate protective gear. This list includes, but is not limited to:
 - a hard hat
 - gloves
 - protective shoes with slip-resistant soles
 - protective goggles
 - hearing protection
- For Powered Equipment: before servicing, adjusting, or repairing powered equipment, unplug, place all controls in neutral or off position, stop the engine or motor, remove ignition key or lock out power source, and wait for all moving parts to stop.



- Follow good shop practices:
 - keep service area clean and dry
 - be sure electrical outlets and tools are properly grounded
 - use adequate light for the job at hand
 - Think SAFETY! Work SAFELY!



2.2. ASSEMBLY SAFETY

- Read through the instructions to get to know the sub-assemblies and hardware that make up the equipment.
- Do not take chances with safety. The components are large, heavy, and can be hard to handle. Always use the proper tools, stands, jacks, and hoists for the job.
- Always have 2 or more people assembling the equipment. Because of the weight, do not attempt assembly alone.

2.3. OPERATIONAL SAFETY

- Have another person nearby who can shut down the auger in case of accident. Always work with a second person around augers.
- Do not operate with any of the safety guards removed.
- Keep body, hair, and clothing away from moving parts. Stay away from intake during operation.
- Augers are not insulated. Keep away from electrical lines. Electrocutation can occur without direct contact.
- Ensure that auger is empty before moving.
- Inspect auger supports on a daily basis.
- Support auger securely to prevent upending or upsetting.

2.4. MAINTENANCE SAFETY

- Shut down and lock out all power before attempting maintenance of any kind. If applicable, disconnect PTO driveline from tractor or hydraulic hoses on units with hydraulic drive hoppers.
- After maintenance is complete, replace and secure all safety guards and safety devices, and if applicable, service doors and cleanout covers.
- Use only genuine Wheatheart replacement parts or equivalent. Replacement parts such as intake guards, pulley guards, PTO driveline shields, winches, and lift cables must meet ASAE standards or serious injury may result. Use of unauthorized parts will void warranty. If in doubt, contact Wheatheart or your Wheatheart dealer. Do not modify any auger components.

2.5. ELECTRIC MOTOR SAFETY

- Inspect the drive belts before using auger. Replace if frayed or damaged.
- Do not grab or touch drive belts during operation for any reason.
- Remember to ground electric motor before using auger.

2.6. SAFETY DECAL LOCATIONS

- Keep safety decals clean and legible at all times.
- Replace safety decals that are missing or have become illegible. See decal location figures below.
- Replaced parts must display the same decal(s) as the original part.
- Safety decals are available from your distributor, dealer, or factory.

2.6.1. DECAL INSTALLATION

1. Decal area must be clean and dry, with a temperature above 10°C (50°F).
2. Decide on the exact position before you remove the backing paper.
3. Align the decal over the specified area and carefully press the small portion with the exposed sticky backing in place.
4. Slowly peel back the remaining paper and carefully smooth the remaining portion of the decal in place.
5. Small air pockets can be pierced with a pin and smoothed out using the sign backing paper.

2.6.2. DECAL LOCATIONS

Replicas of the safety decals that are attached to the equipment are shown in the figure(s) that follow. Good safety requires that you familiarize yourself with the various safety decals and the areas or particular functions that the decals apply to as well as the safety precautions that must be taken to avoid serious, injury, death, or damage.

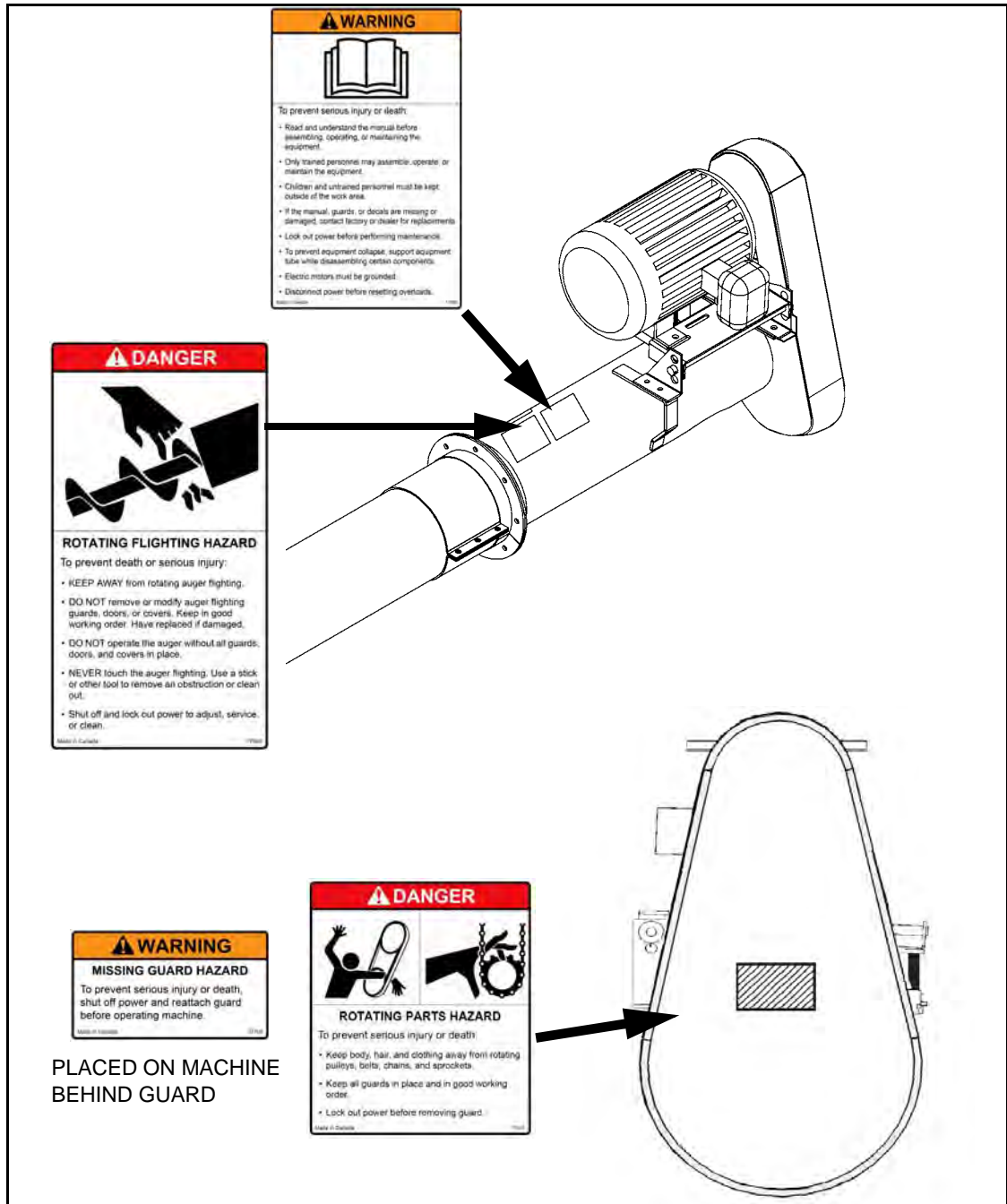


Figure 2.1

* *Wheatheart reserves the right to update safety decals without notice. Safety decals may not be exactly as shown.*

3. Assembly


Warning: Before continuing, please reread the safety information relevant to this section at the beginning of this manual. Failure to follow the safety instructions can result in serious injury, death, or property damage.

Before beginning assembly, familiarize yourself with all the sub-assemblies and hardware making up the auger. Have all parts on hand and arrange them for easy access. Carry out assembly in a large open area with a level surface.

Important: *Always have 2 or more people assembling the equipment. Because of the weight, do not attempt assembly alone.*

➔ Augers are available in various combinations. In most cases, the following instructions will apply to all augers. Where the assembly information varies, additional instructions will be included and will be indicated with an arrow.

3.1. TUBE / FLIGHT EXTENSIONS

CAUTION	
	<p>Block tube sections to prevent rolling. Do not drop. Damage to equipment or personal injury will result.</p>

1. Position tube sections. Align tube sections on a flat surface or on a series of benches.

Note: *When assembling more than 2 sections, start from spout end and work towards hopper.*

2. Screw or slide lower flight shaft onto upper flight shaft until flight ends butt together and flighting spiral matches up. Secure with hardware listed in table below. Repeat, if necessary, for any remaining flight shafts.

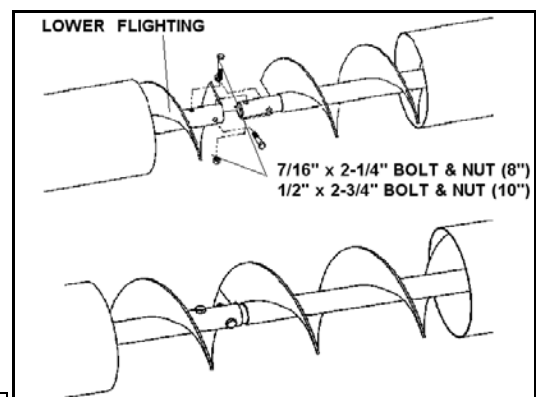


Figure 3.1

Auger	Hardware	Amt.
8"	7/16" x 2-1/4"	2
10"	1/2" x 2-3/4"	2

3. Slide tube sections together and secure.
4. Place the tube connectors onto the tubes with tube joint in the center of the connectors.
 - Fasten tube connectors together with twelve 7/16" x 1" bolts and whiznuts and tighten securely (Figure 3.2).

5. For additional tube/flight sections, repeat steps.

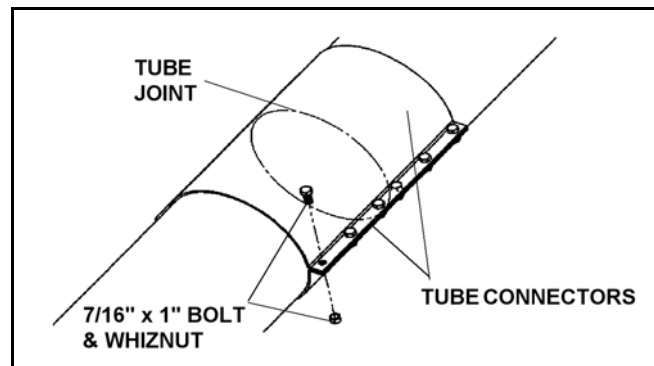


Figure 3.2

3.2. CLAMP-ON ANGLE RING

1. Slide clamp-on angle ring onto the end of the galvanized tube (Figure 3.3).
2. Slide ring on until the end of the angle ring is flush with the end of the tube. Secure angle ring to the tube using six 7/16" x 1" bolts and whiznuts; tighten bolts and nuts securely.
3. Secure second clamp-on angle ring on opposite end of galvanized tube following steps 1 and 2.

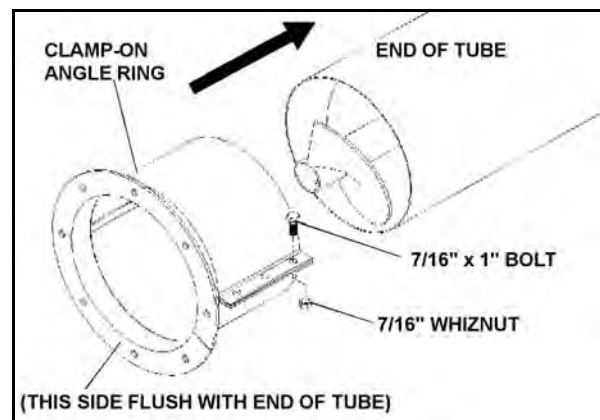


Figure 3.3

3.3. POWERHEAD

See Figure 3.4.

1. Pull flighting out of the galvanized tube enough to obtain access to the 2 holes at the end of the flighting pipe.
2. On powerhead, remove bearing collar from the flighting shaft. Slide powerhead flighting out of tube and attach to the flighting of galvanized tube. Ensure that the 2 flightings overlap. Use two 7/16" x 2-1/4" (for 8") or two 1/2" x 2-3/4" (for 10") bolts and locknuts and tighten securely.
3. Re-install flighting onto powerhead tube and replace bearing collar onto flighting stub shaft.
4. Connect the 2 angle flanges together using eight 7/16" x 1" bolts and locknuts. Tighten securely.

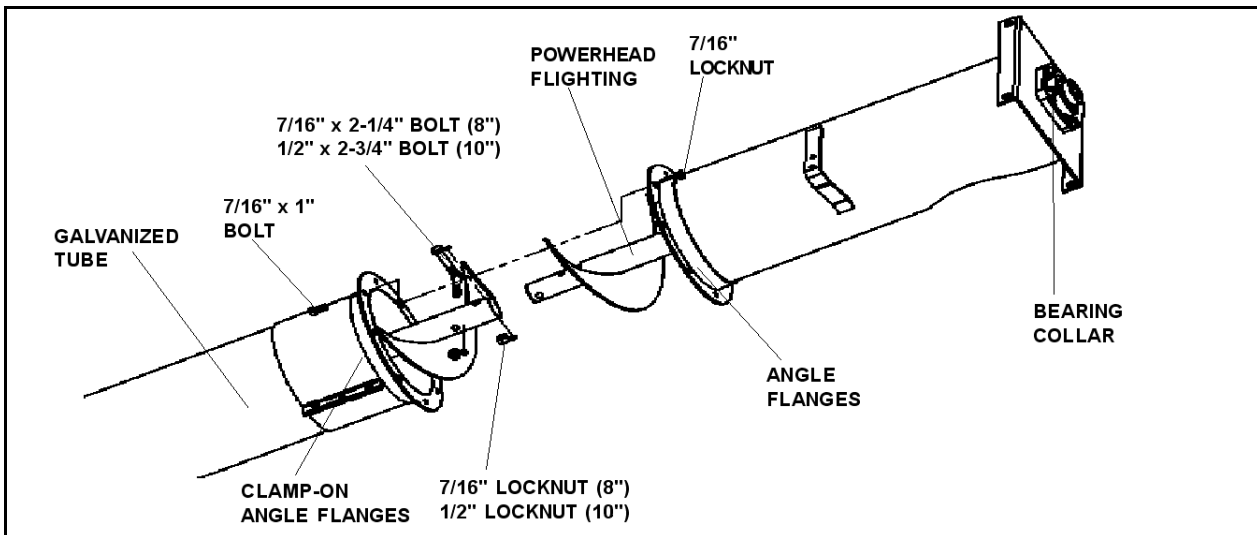


Figure 3.4

3.4. INTAKE

See Figure 3.5.

Note: To replace intake assembly with hopper assembly or to install hopper assembly, see Section 3.8.

- ➔ 1. Attach intake flighting to the flighting of galvanized tube. Ensure that the 2 flightings overlap. Use two 7/16" x 2-1/4" (for 8") or two 1/2" x 2-3/4" (for 10") bolts and locknuts and tighten securely.
2. Place intake assembly over intake flighting, ensuring that the stub shaft is properly seated in the bushing.
3. Attach intake to the clamp-on angle flange of galvanized tube with four 7/16" x 1" bolts and locknuts.

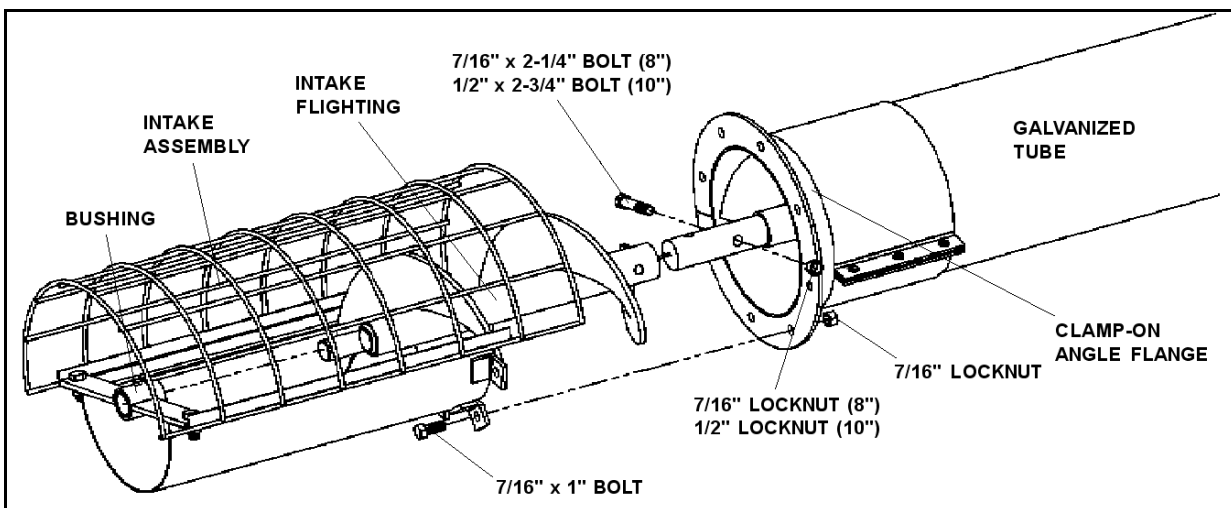


Figure 3.5

3.5. MOTOR MOUNT

See Figure 3.6 and 3.7.

1. Install front mount plate onto head plate of powerhead using two 1/2" x 1-1/2" bolts, locknuts, and 1/2" flat washers (Figure 3.6). Tighten securely.
2. Place 5/8" adjust bolt through available hole in front mount plate and secure in place using two 5/8" hex nuts (one top, one bottom). Leave adjust bolt loose to allow for later adjustment.

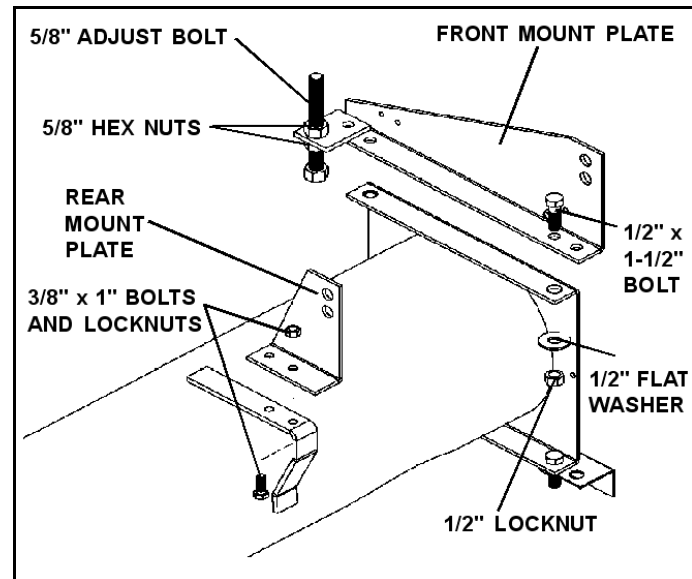


Figure 3.6

Note: The 5/8" nuts and adjust bolt are used to adjust belt tension (Section 3.7.).

3. Assemble rear mount plate onto tube bracket (Figure 3.6) with two 3/8" x 1" bolts and locknuts; tighten securely.
4. Place motor mount assembly in between the two mount plates and insert hinge rod (Figure 3.7). Secure hinge rod with a 1/8" x 1-1/2" cotter pin.
5. Attach lower pulley guard angle to the head plate with two 1/2" x 1-1/2" bolts and locknuts and 1/2" flat washers (Figure 3.7). Tighten securely.

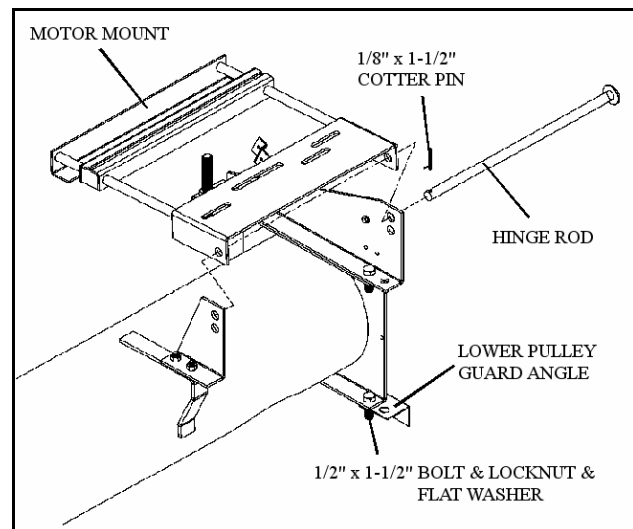


Figure 3.7

3.6. POWERHEAD DRIVE

1. Remove dirt from upper end of flight shaft.
2. Install the woodruff key provided (or square key), slide the larger pulley onto the flight shaft with the hub facing away from the auger and do not tighten set screws at this time (see Table 3.1 for proper pulley size).

Table 3.1 Pulley Sizes / Combinations^a

Galvanized Utility Auger	Recommended Sizes		
	Auger Pulley	Motor Pulley	*Flight Speed (rpm)
8" Utility	12.7"	3 -1/4"	440
	12.7"	3 -1/2"	475
10" Utility	15"	3 -1/4"	375
	15"	3 -1/2"	402

To determine flight speed (rpm):^b

Divide the speed (rpm) of the motor by the outside diameter of the large auger pulley, then multiply by the outside diameter of the small motor pulley.

Example: $1725 \text{ (rpm)} \div 15" \times 3.5" = 402 \text{ rpm}$

- a. Speed calculated using a 1725 rpm electric motor.
- b. If a slower flight speed is desired, install a smaller motor pulley.

3.7. ELECTRIC MOTOR INSTALLATION / ALIGNMENT

1. Place electric motor (see Table 3.2 for proper horsepower requirements) onto motor mount and secure. Ensure that motor shaft is parallel to and centered on discharge tube. Tighten adjust bolt.

Table 3.2 Horsepower Requirements^a

Length	8"	10"
16'-21'	3	3-5
26'-31'	5	5 - 7-1/2
36'-41'	5 - 7-1/2	7-1/2 - 10
46'-51'	7-1/2 - 10	10-15
56'-61'	10	15-20

- a. Approximate electric motor horsepower requirements under normal conditions. When augering full tube of high moisture grain, additional horsepower will be needed.

When using an electric motor:

- The motor and controls should be installed by a qualified electrician in accordance with all local and national codes.
 - Incorporate a magnetic starter to protect the motor.
 - The motor must have a manual reset button.
 - Locate reset and starter controls so that the operator has full view of the entire operation.
 - Locate main power disconnect switch within reach from ground level to permit ready access in case of an emergency.
 - A main power disconnect switch capable of being locked (in the off position only) must be provided.
2. Slide drive pulley onto motor shaft (see Table 3.1 for suggested sizes). Insert the appropriate size of square key. Do not tighten set screw until belts are aligned.
 3. Place belts on pulleys. Adjust the 5/8" adjust bolt on front mount plate until the belts have the proper tension with about a 1/8" deflection.

Note: *The correct operating tension is the lowest tension at which the belts will not slip under peak load conditions.*

4. Align the two pulleys using a straight edge. Once belts are aligned and under tension, lock the 5/8" hex nuts and tighten pulley set screws.

Note: *Once all bolts and set screws are tightened, re-check alignment. Proper alignment will prolong belt life.*

5. Assemble the adjustable three-piece pulley guard with four 1/4" x 1/2" bolts and washer locknuts (see Figure 3.8).

Note: *A guard extension is required on all powerheads using a 15" pulley.*

6. Attach the pulley guard to the lower pulley guard angle and the end plate with self-tapping screws. The guard on the 10" powerhead is mounted to the end plate with two guard spacers, and attached with self-tapping screws.

Note: *The 8" powerhead uses a single guard angle (attached using two self-tapping screws) instead of two guard spacers for the 10" powerhead to anchor the top of the pulley guard to the front mount plate.*

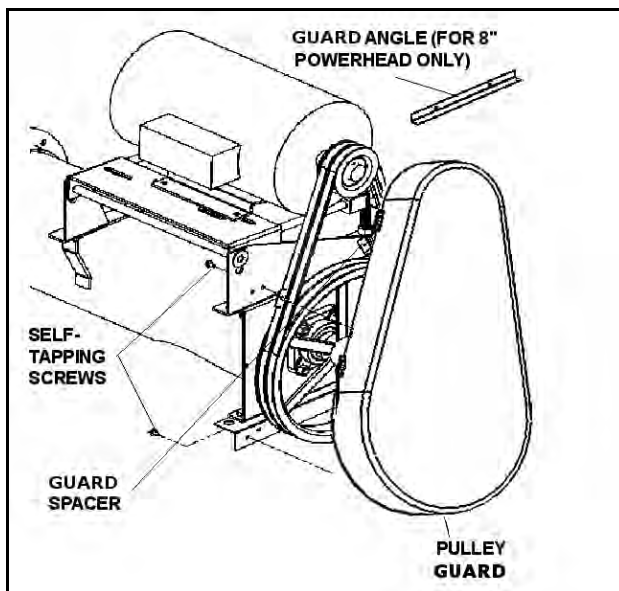


Figure 3.8

3.8. HOPPER (OPTIONAL)

See Figure 3.9.



If the optional hopper assembly is being installed in place of the intake assembly, proceed as follows:

1. Attach intake flighting to the flighting of the galvanized tube with the 2 flightings overlapping. Use two 7/16" x 2-1/4" (for 8") or two 1/2" x 2-3/4" (for 10") bolts and locknuts and tighten securely.
2. Place hopper over lower flighting with stub shaft properly seated in the hopper bearing.
3. Attach hopper assembly to lower end of auger tube with four 7/16" x 1" bolts and locknuts.

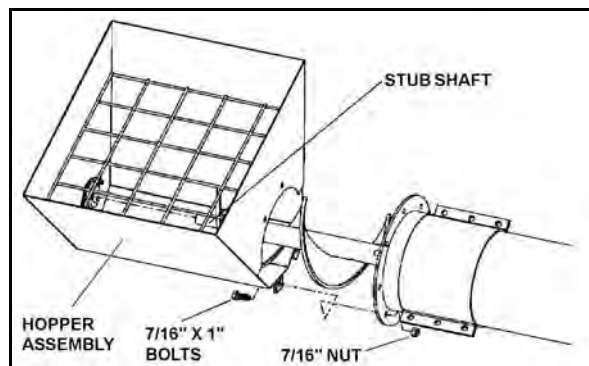


Figure 3.9


3.9. SITE INSTALLATION PROCEDURES

Site installation procedures will vary depending on auger length, location, and intended use. Because of these variables, the following instructions are meant to be used as a guide only. It is the installer's responsibility to ensure that the auger is properly braced and/or supported before operating, with the primary concern being on safety. As a general rule, we suggest the following:

1. Check that all bolts are tightened as per instructions.
2. Ensure that all safety devices are in place and secure.
3. Use a safe lifting device such as a front-end loader or crane to raise and position the auger, ensuring that the entire area in line of travel is clear of any obstructions or electrical wires.

Once auger is in position, we recommend:

- Where possible, secure both the intake and discharge ends of the auger to prevent upending or upsetting from factors such as high wind, vibration, or grain weight shift.
- If auger is used in a free standing position, it must be braced and/or supported to prevent upending or upsetting from factors such as high wind, vibration, or grain weight shift.

WARNING	
	Operating a utility auger that is not properly anchored or secured is unsafe. To do so will result in damage to equipment and/or personal injury.

Note: *Longer utility augers may require trussing or additional bracing. Cable truss kits and tube clamps for the attachment of bracing are available from Westfield as options. See Section 3.10. for trussing installation.*

- Ensure that on/off switches are conveniently located and marked in case of emergency.

3.10. TRUSSING (OPTIONAL)

See Figure 3.10.

If trussing is required on your auger, 30' and 40' truss kits are available from Westfield as an option. Before purchasing, determine the unsupported length of auger in order to obtain the proper kit. The following procedure is offered as a guide for installing the trussing but can be changed if circumstances warrant it. To install:

1. Once auger is in place and secure, find the center of the unsupported length (lowest point of sag) and mount the truss struts with 7/16" x 1" bolts and locknuts. Do not tighten.
2. Attach strut braces (Figure 3.10) with 7/16" x 1" bolts and locknuts and secure.

3. Rotate strut assembly to a 45° angle and tighten half ring bolts.
4. Mount the truss attach angles to the truss anchor half rings with two 7/16" x 1" bolts and locknuts each.
5. Locate and mount the half ring assemblies above and below the strut assembly with 7/16" x 1" bolts and locknuts. Do not tighten at this time.

Note: *The distance for mounting the half ring assemblies is limited by the length of cable in your kit. Maximum distance for the 30' kit is approximately 28'. Maximum for the 40' kit is 38' (Figure 3.10).*

6. Put cable clamps in place on the strut assembly and place the eyebolts into the truss attach angles.
7. String the cable through the cable clamps, center the cable, and tighten the cable clamps.
8. Thread the cable through the eyebolts (upper cables to lower eyebolts), pull snug, and install cable clamps.
9. Once cables are in place, tighten bolts on the half ring assemblies.
10. Tighten eyebolts until sag is eliminated. Proper alignment is important to maintain the life of the equipment.

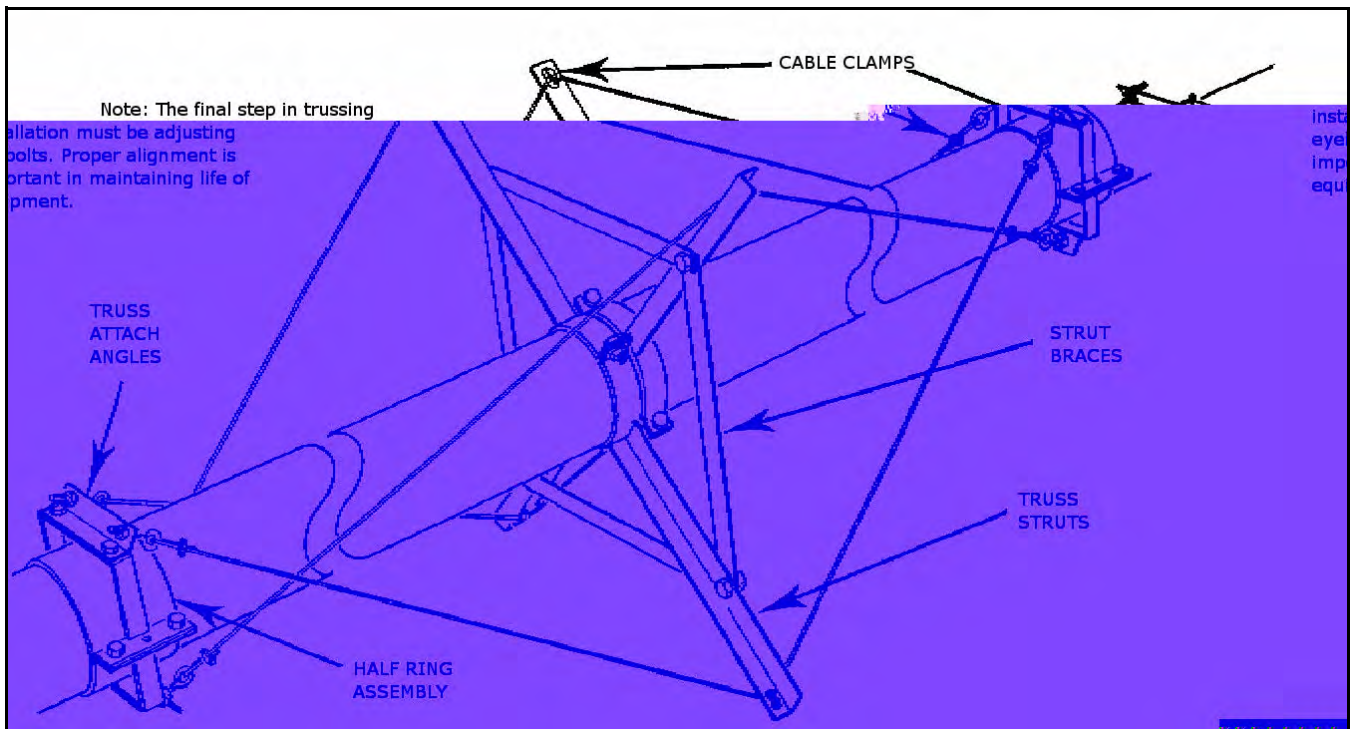


Figure 3.10

4. Operation & Maintenance

Warning: Before continuing, please reread the safety information relevant to this section at the beginning of this manual. Failure to follow the safety instructions can result in serious injury, death, or property damage.

Operators must observe safety procedures at all times and follow the pre-operational checklist before each start-up.

4.1. PRE-OPERATIONAL CHECKLIST

Before operating auger each time, the operator must confirm the following:

- All fasteners are secure as per assembly instructions.
- Drive belt(s) are not frayed or damaged.
- Drive belt(s) are properly adjusted and aligned.
- Tube alignment is reasonably straight.
- Intake area and discharge spout are free of obstructions.
- Proper maintenance has been performed.
- Inspect auger supports frequently.


4.2. AUGER DRIVE & LOCKOUT

Drive Type	Before Operation	Lockout
Electric Motor	Before starting motor, ensure <ul style="list-style-type: none"> • motor is properly grounded • pulley shields are in place and secure 	The electric motor should be equipped with a main power disconnect switch capable of being locked in the off-position only. The switch should be in the locked position during shutdown or whenever maintenance is performed on the auger. <ul style="list-style-type: none"> • If reset is required, disconnect all power before resetting motor.

4.3. OPERATION PROCEDURE

4.3.1. INITIAL START-UP & BREAK-IN

1. Complete the checklist at the beginning of this chapter. If everything is satisfactory, prepare for a 30-minute operation at half speed.
2. Correctly position portable grain hopper (if used) and secure to auger with both straps (where applicable).

CAUTION	
	Maintain a hazard zone of 20' around the work site. Do not start auger until area is clear of all untrained personnel.

Note: For safety, clear the 20' hazard zone around the work site.

3. Start electric motor and feed grain immediately.


Important: When starting auger for the first time, be prepared for an emergency shutdown in case of excessive vibration or noise. Note that the auger may run rough until tube is polished.

4. Upon completion of initial run, shut down auger. See "Shutdown" on page 23.

5. Lock out motor and conduct a complete inspection of auger following the checklist in Section 4.1.

4.3.2. OPERATING WITH A FULL LOAD

1. When operating the auger, always work with a second person in a position to monitor the operation and initiate a shutdown in case of emergency.
2. Monitor the auger during operation for abnormal noises or vibrations.
3. Shut off all power before making adjustments, servicing, or clearing the machine.

DANGER	
	<p>Rotating Flighting Hazard!</p> <p>To prevent death or serious injury:</p> <ul style="list-style-type: none">• Keep away from rotating auger flighting.• Do not remove or modify auger flighting guards, doors, or covers. Keep in good working order. Have replaced if damaged.• Do not operate the auger without all guards, doors, and covers in place.• Never touch the auger flighting. Use a stick or other tool to remove an obstruction or clean out.• Shut off and lock out power to adjust, service, or clean.

USE OF GRAIN SPREADERS: Many grain spreaders cannot handle the large capacity of some augers. Some augers plug, causing damage to the flighting and other drive components. This type of damage is not covered by warranty. Hints on how to avoid this...

- Get a larger spreader, if available.
- Remove the spreader.
- Make sure spreader is turned on and operating.
- When using a flex down spout, center auger spout above spreader and do not lower auger spout into spreader.
- Suspend the spreader lower from bin ceiling leaving extra room for excess grain to flow over the spreader.

BIN LEVEL INDICATORS: These augers are fast and bins fill up quickly. A full bin will cause auger to plug, which can damage the flighting and other drive components. Installing quality grain-level indicators on your bins will allow you to monitor bin filling and help prevent damage to your auger.

4.3.3. SHUTDOWN

NORMAL SHUTDOWN:

1. Near the end of a load, decrease the flow of grain until auger is clear.
2. Once auger is clear, stop motor and lock out power (Section 4.2.)

Note: *Remember that the flighting rpm on augers equipped with electric motors is not adjustable except with a change of pulley size.*

EMERGENCY RESTART:

1. If the auger is shut down for an emergency, lock out motor before correcting problem.
 - If the problem is plugging, clear as much of the grain as possible using a piece of wood, vacuum cleaner, or other tool before restarting. **Do not reach in and used your hands.** (See “Auger Drive & Lockout” on page 21.)

NOTICE

Starting the auger under load may result in damage to the unit. Be sure there is no blockage.

4.4. MAINTENANCE

Proper maintenance habits on the auger mean a longer life, better efficiency, and safer operation. Please follow the guidelines below.

GENERAL MAINTENANCE PROCEDURES

Area	Maintenance	Frequency
General	While auger is in use, observe the operation checklist on 4.1.	Daily
General	If for any reason a part becomes damaged, replace it immediately. If possible, lower auger to replace parts.	Regularly
Drive Belt	Check and replace if frayed or damaged. Ensure tension is correct under load (correct tension is the lowest at which the belts will not slip under peak load conditions)	Frequently
Auger Supports	Inspect.	Frequently
Intake Bushing	Lubricate.	Daily
Truss Cables	If truss cables are used, adjust to keep tube reasonable straight.	As needed
Motor Cover	Protect motor from weather by covering.	During off season or when not in use

Important: *Use only genuine Wheatheart replacement parts or equivalent. Replacement parts such as intake guards, pulley guards, winches and lift cables must meet ASAE standards or serious injury may result. Use of unauthorized parts will void warranty. If in doubt, contact Westfield or your Westfield dealer. Do not modify any auger components.*

5. Troubleshooting

Problem	Possible Cause	Remedy
Excessive noise or vibration. *Remember to follow proper break-in procedures—auger may run rough until tube is polished. If noise is extreme from outset or continuous after several loads of grade are fed, continue with troubleshooting below	Truss cables incorrectly adjusted.	Support end of auger and adjust cables so auger is flat or curves slightly upwards.
	Flighting peeled back due to plugging.	Inspect spout end of auger for flight condition. Remove and replace flight sections as necessary.
	Bent flighting sections.	Support auger and remove all flight sections. Check for straightness of flight stubs by rolling across flat concrete section. Straighten stub or replace as necessary. Take care not to bend flighting when reinstalling.
	Obstruction in tube.	Visually inspect for cloth or trash wrapped around flighting, or buildup of gum from oily crops such as flax or canola.
Drive belts jumping off pulleys.	Motor misaligned.	Ensure drive and driven pulleys are correctly aligned.
	Belts mismatched.	Check Assembly Section for correct belt sizes and only replace in pairs.
	Belt tension inadequate.	Maintain correct tension as per assembly section.
	Using a lower horsepower motor than recommended.	See Assembly Section for recommended motor sizes.
Premature wear on auger tubes.	Auger being run at low capacity or empty for extended period of time.	Frequently occurs on farms using grain wagons. Auger should not be left unattended when filling bins.
	Bent flighting.	
	Flighting allowed to wear beyond normal point of replacement.	When flighting becomes razor-thin at intake, replacement is critical. Since flight material is double thickness at welded lap joints, high spots on flight occur and can accelerate spot tube wear.

LIMITED WARRANTY

Wheatheart warrants to the buyer that the new machinery is free from defects in material and workmanship.

This warranty is only effective for any new machinery that has not been altered, changed, repaired, or treated since its delivery to the buyer, other than by Wheatheart or its authorized dealers or employees, and does not apply to accessories, attachments, tools, or parts sold or operated with the new machinery if they have not been manufactured by Wheatheart.

Wheatheart shall only be liable for defects in the material or workmanship attributed to faulty material or bad workmanship that can be proved by the buyer, and specifically excludes liability for repairs arising as a result of normal wear and tear of the new machinery or in any other manner whatsoever, and without limiting the generality of the foregoing, excludes application or installation of parts not completed in accordance with Wheatheart operation manual, specifications, or printed instructions.

A Warranty Registration Form and Inspection Report must be completed at the time of delivery and returned to Wheatheart Manufacturing within thirty (30) days.

Warranty Period

Private Farm Use	One (1) year from date of purchase.
Commercial, Custom, or Rental Use	Ninety (90) days from date of purchase.
Replacement Parts	Ninety (90) days from date of replacement

Defective parts are subject to inspection by a Wheatheart representative prior to approval of a warranty claim. All returned parts must be sent to the factory, freight pre-paid, in order to qualify for warranty replacement. Repaired or replaced parts will be returned freight collect.

If these conditions are fulfilled, Wheatheart shall at its own cost and its own option either repair or replace any defective parts provided that the buyer shall be responsible for all expenses incurred as a result of repairs, labor, parts, transportation, or any other work, unless Wheatheart has authorized such expenses in advance. Normal wear and service items such as belts, hoses, flashing, etc. are excluded from warranty.

The warranty shall not extend to any repairs, changes, alterations, or replacements made to the new equipment other than by Wheatheart or its authorized dealers or employees.

This warranty extends only to the original owner of the new equipment.

This warranty is limited to the terms stated herein and is in lieu of any other warranties whether expressed or implied, and without limiting the generality of the foregoing, excluded all warranties, expressed or implied, or conditions whether statutory or otherwise as to quality and fitness for any purpose of the new equipment, Wheatheart disclaims all liability for incidental or consequential damages.

This machine is subject to design changes and Wheatheart shall not be required to retro-fit or exchange items on previously sold units except at its own option.

WARRANTY VOID IF NOT REGISTERED

WHEATHEART

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