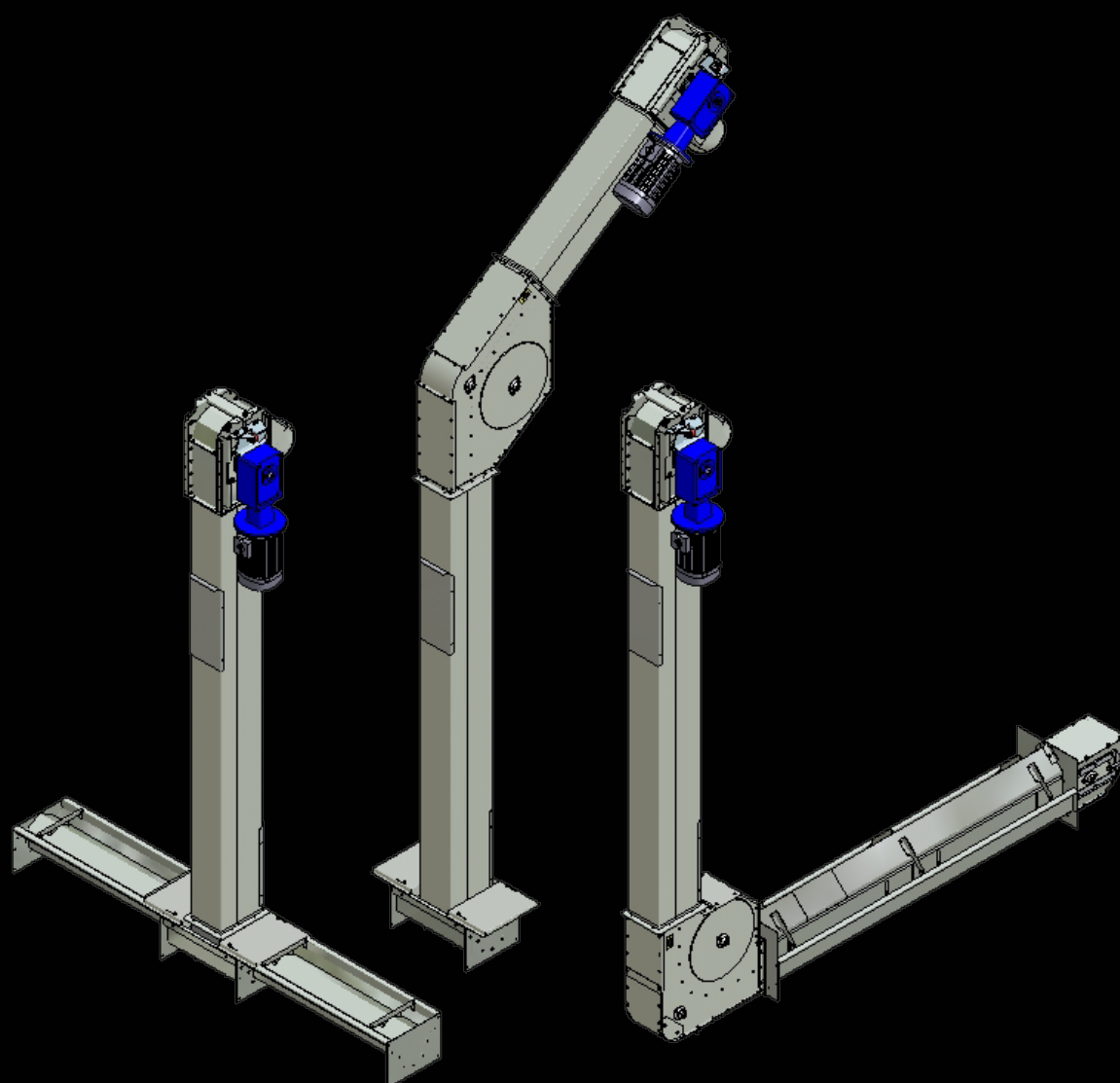


Manual Chain elevator T20/T40

Version 70501.1



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Introduction

JEMA AGRO A/S is a modern factory, which specializes in producing and delivering equipment for transport systems for raw or cleaned grain, seeds and granulates.

Our current product range is the result of more than 60 years experience in machine development especially for the agricultural sector in close collaboration with our customers – and our company is highly regarded in the industry due to the quality and versatility of our products.

JEMA AGRO A/S conveyors and transport systems are compatible with ALL types of dryer- and silage systems.

Important!

Please read these instructions carefully before assembly and use.

EU Declaration of conformity



The manufacturer: JEMA AGRO A/S
Kløservejen 2, Sahl
DK-8850 Bjerringbro
Phone +45 86 68 16 55

Hereby declares that:

Product: Chain elevator
Type: T20/T40
Year of production: 2006

- Conforms to the Machine directive 2006/42/EF with special reference to the directive appendix 1 regarding major health- and safety regulations regarding construction and production of the machines

The following standards have been applied:

EN ISO 12100-1:2005 Basic terminology and methodology
EN ISO 12100-2:2005 Technical principles
EN 1050:1997 Principles for risk assessment

- is in accordance with EMC-directive 04/108/EF of 15th December 2004 regarding electromagnetic compatibility.

Director Jens-Peter Pedersen

Title Name

04.12.2008

Date Signature

A handwritten signature in black ink, appearing to be "JP Pedersen", written over a horizontal line.

Conditions of use

JEMA AGRO A/S chain elevators T20/T40 have been constructed for transport of grain, granular materials and seed mix.

- The chain elevators T20/T40 must only be used for the product(s) specified in the contract.
- The electrical connections must be done by a qualified electrician.
- The chain elevators T20/T40 must be potential adjusted in accordance with the current local regulations
- The chain elevators have been thoroughly controlled regarding maintenance, and a checklist has been drawn up containing regular cleaning- and maintenance intervals. If these intervals are not observed, the JEMA AGRO conditions for a trouble-free operation cease to exist and the warranty will be invalid.
- During installation, maintenance or repair the electric supply to the chain elevators must be disconnected and secured against accidental reconnection.
- The user manual must be kept / be available in close proximity to the chain elevator T20/T40

General information

Delivery

The chain elevator is disassembled for shipment. Standard packing (pallet/wooden boxes, grid boxes, etc.) Regarding the actual transport there are no specific requirements apart from normal consideration.

The shipment includes the parts stated in the order confirmation.

Please read this manual carefully before installation and use.

Storage

There are no precautions regarding long-time storage.

After delivery the components must be kept in a suitable, dry storage area before installation.

Noise level

A noise level test was conducted for the chain elevator. The level has been measured in a distance of 1 m from the conveyor surface and at a height of 1.6 m from the floor level. During the test the chain elevator was running unloaded, which is the operational state of maximum noise level.

The measured noise level is not higher than **70 dB**

Type Plate

The type plated is fitted on the drive station.



Construction

The chain elevator type T20/T40 is made up of standard elements, which can be combined and easily integrated into all grain conveyor systems. It is characterized by a large capacity and compact dimensions. Both elevators work efficiently in all positions and compared to their capacity (output), they both have low power consumption.

The chain elevator is made of galvanized steel, which makes it perfectly suited for outdoor use. It is furthermore fitted with a high quality roller chain with bolted rubber flights.

The chain elevator can be combined for both vertical and horizontal transport by using side augers in troughs. These are driven from the elevator bottom shaft, so both elevator and side auger are driven by the same motor, alternatively the side auger can be driven separately by a directly connected gear motor.

The side auger in trough is available for both left and right elevator. The 135 diameter augers have an inclination of incl.60, incl.90, incl.125, available in lengths of 2.0m, 1.25m, 1.0m, and 0.5m.

Another combination of vertical and horizontal transport can be obtained by using a 90° bend. The inlet trough is fitted horizontally and attached with a 90° bend to the vertical part of the elevator. The inlet troughs are available in lengths of 2.0m, 1.25m, 1.0m and 0.5m.

A third combination is possible by using a 55° bend, which makes it possible to change from vertical position to 55°, e.g. above a silo roof.

The chain elevator consists of:

- Elevator head
- Elevator boot
- 2.5m extensions with inspection door
- Chain with rubber slats
- Extensions from 0.125m to 2.5m.
- Outlet
- Motor

Additional inlet piece is available.

Capacity

The table below shows the various density capacities:

Density	T20 (33 m ³ /h)	T40 (60 m ³ /h)
650 kg. pr. m ³	21 t/h	39 t/h
700 kg. pr. m ³	23 t/h	42 t/h
750 kg. pr. m ³ (wheat)	25 t/h	45 t/h

*Measured in cleaned, storable material at a power supply of 50 Hz
The capacity varies according to the nature of the material.*

Capacity for chain elevator T20/T40:

T20, inlet from both sides without propeller	14 t/h
T20, inlet from both sides with propeller	25 t/h
T20 with d135, S60 auger from one side	14 t/h
T20 with d135, S90 auger from one side	19,5 t/h
T20 with d135, S125 auger from one side	25 t/h
T40, with inlet from both sides with propeller d135	45 t/h
T40 with d135, S125 auger from both sides	45 t/h

Above capacity measured in cleaned, storable material at a density of 750 kg/m³.

Capacity per side auger fitted on chain elevator T20/T40:

	Auger d135 S125	Auger d135 S90	Auger d135 S60
Elevator with gear motor 280 rpm Elevator with pulley kit motor 1440 rpm rpm.: bottom shaft / auger 315 rpm	22,0	17,0	13,0
Elevator with gear motor 180 rpm Elevator with pulley kit motor 1000 rpm rpm. bottom shaft / auger 210 rpm	15,0	11,0	9,0
Auger driven by separate gear motor 250 rpm	17,5	12,5	10,0
Auger driven by separate gear motor 280 rpm	19,5	15,0	11,5
Auger driven by separate gear motor 315 rpm	22,0	17,0	13,0
Auger driven by separate gear motor 405 rpm	28,0	22,0	17,0

Above capacity measured in cleaned, storable material at a density of 750 kg/m³.

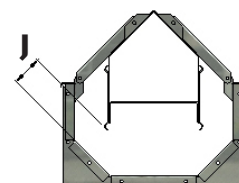
Inlet trough adjustment

T20	J opening	Capacity t/h	T40	J opening	Capacity t/h
Pulley drive with motor 1.500 rpm	15	5	Pulley drive with motor 1.500 rpm	15	25
	25	11		25	31
	35	18		35	38
	45	25		45	45
Gear motor 280 rpm	20	10	Pulley drive with motor 1.000 rpm	20	30
	35	16		35	40
	50	23		50	50
	65	30		65	60
Pulley drive with motor 1.000 rpm	20	10	Gear motor 180 rpm	20	30
	35	16		35	40
	50	23		50	50
	65	30		65	60
Gear motor 180 rpm	20	10	Pulley drive with motor 1.500 rpm	15	25
	35	16		25	31
	50	23		35	38
	65	30		45	45

The capacity is measured at a density of 750 kg/m³.

Important! – The J dimension in the sketch is just for guidance.

Important! - Remember to adjust the inlet plates before starting.



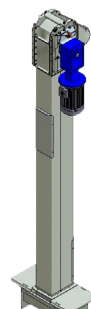
Technical specifications – power consumption

Chain elevator T20 - power consumption in kW:

Type	0-9 m	10-12 m	13-16 m	17-20 m
T20	2,2 kW	3,0 kW	4,0 kW	5,5 kW

Chain elevator T40 - power consumption in kW:

Type	0-7 m	8-10 m	11-14 m	15-20 m
T40	2,2 kW	3,0 kW	4,0 kW	5,5 kW

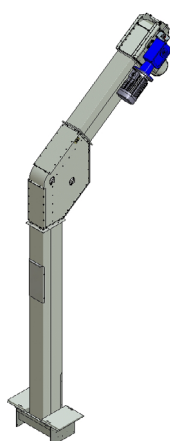


Conveyor T20 - power consumption in kW:

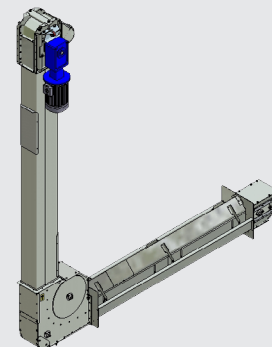
Type	15-17 m	18-20 m
T20	4,0 kW	5,5 kW

Conveyor T40 - power consumption in kW:

Type	15-20 m
T40	5,5 kW



Height, metres	Length		
	2,35 m	3,35 m	4,35 m
	kW T20/T40	kW T20/T40	kW T20/T40
3,65	2,2/3,0	2,2/3,0	2,2/3,0
4,61	2,2/3,0	2,2/3,0	2,2/3,0
5,61	2,2/3,0	2,2/3,0	3,0/3,0
6,61	2,2/3,0	3,0/3,0	3,0/4,0
7,57	3,0/3,0	3,0/4,0	3,0/4,0
8,57	3,0/4,0	3,0/4,0	4,0/4,0
9,66	3,0/4,0	4,0/4,0	4,0/4,0
10,66	4,0/4,0	4,0/4,0	4,0/5,5
11,66	4,0/4,0	4,0/5,5	4,0/5,5
12,62	4,0/5,5	4,0/5,5	5,5/5,5
13,62	4,0/5,5	5,5/5,5	5,5/5,5
14,58	5,5/5,5	5,5/5,5	5,5/5,5
15,58	5,5/5,5	5,5/5,5	5,5/5,5
16,58	5,5/5,5	5,5/5,5	
17,66	5,5/5,5		



Height, metres	Length			
	5,35 m	6,35 m	7,35 m	8,35 m.
	kW T20/T40	kW T20/T40	kW T20/T40	kW T20/T40
3,65	2,2/3,0	3,0/3,0	3,0/4,0	3,0/4,0
4,61	3,0/3,0	3,0/4,0	3,0/4,0	4,0/4,0
5,61	3,0/4,0	3,0/4,0	4,0/4,0	4,0/5,5
6,61	3,0/4,0	4,0/4,0	4,0/4,0	4,0/5,5
7,57	4,0/4,0	4,0/4,0	4,0/5,5	4,0/5,5
8,57	4,0/4,0	4,0/5,5	4,0/5,5	5,5/5,5
9,66	4,0/5,5	4,0/5,5	5,5/5,5	5,5/5,5
10,66	4,0/5,5	5,5/5,5	5,5/5,5	5,5/5,5
11,66	5,5/5,5	5,5/5,5	5,5/5,5	5,5/5,5
12,62	5,5/5,5	5,5/5,5	5,5/5,5	
13,62	5,5/5,5	5,5/5,5		
14,58	5,5/5,5			

Additional power consumption per meter auger in trough d135 = 0.35 kW.

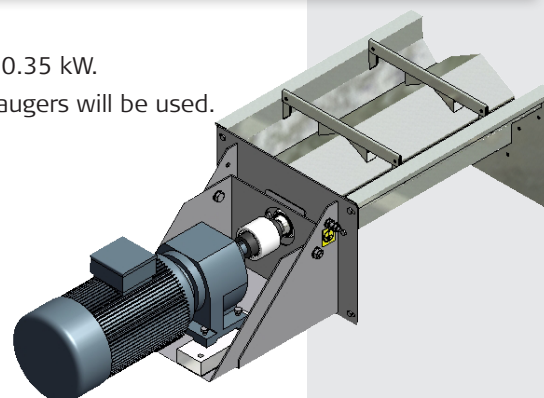
At a total consumption above 5.5 kW, separate drive for the side augers will be used.

Power consumption separate drive for auger in trough d135:

Op to 6.0 m auger = 2.2 kW

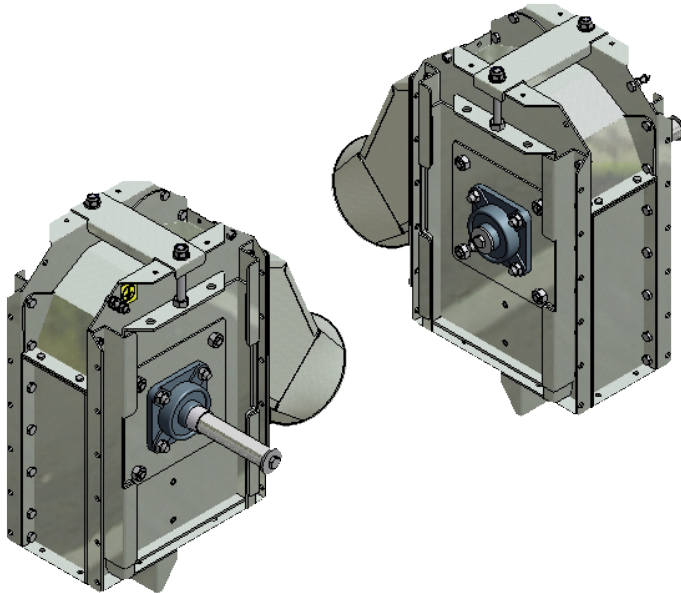
Above 6.0 m auger = 3.0 kW

Side augers separate drive



Elevator head

The elevator head is delivered as a complete unit. The motor is supplied separately.



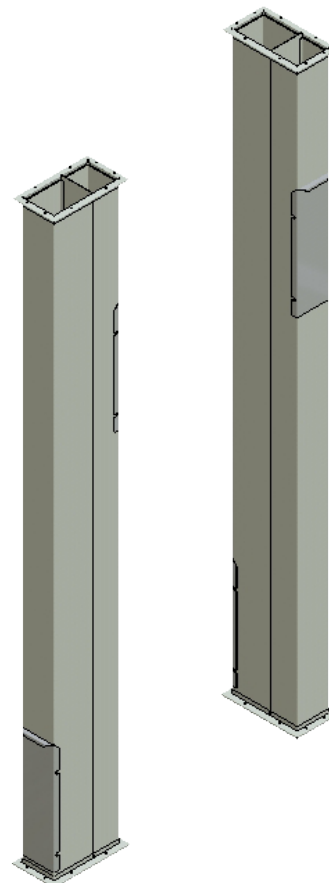
Elevator extensions

The extensions are available in various lengths:
2.5 m, 2.0 m, 1.0 m, 0.5 m, 0.25 m, 0.125 m.

Extensions with inspection doors are available in
lengths of 2.5 m.

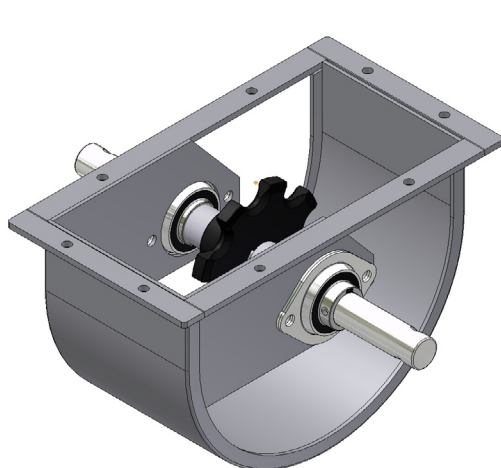
Inlet troughs are available in lengths of:
2.0 m, 1.25 m, 1.0 m, and 0.5 m.

The elements can be combined to obtain any
lengths - for the vertical elevator with steps
of 0.125 m. and with intervals of 0.25 m for the
horizontal elevator - up to a total length of 20.0 m.

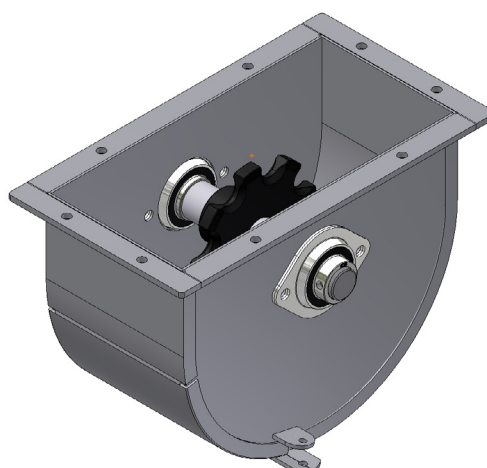


Elevator boot

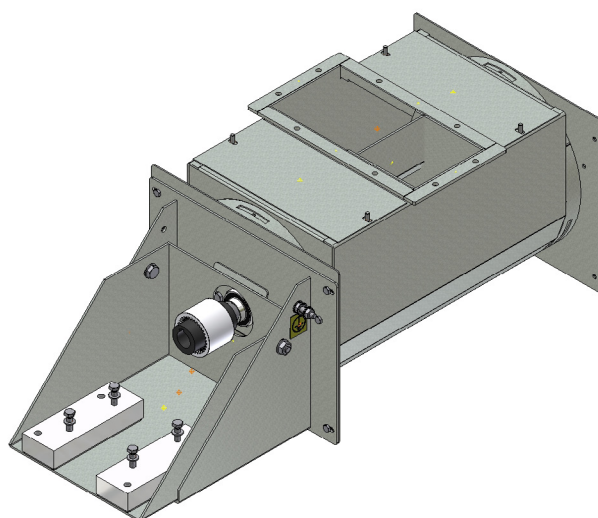
The boot section is fitted in trough from vertical position to 45°. Augers in trough can be fitted to the boot section in one or both sides.



Elevator boot with inlet



Closed boot

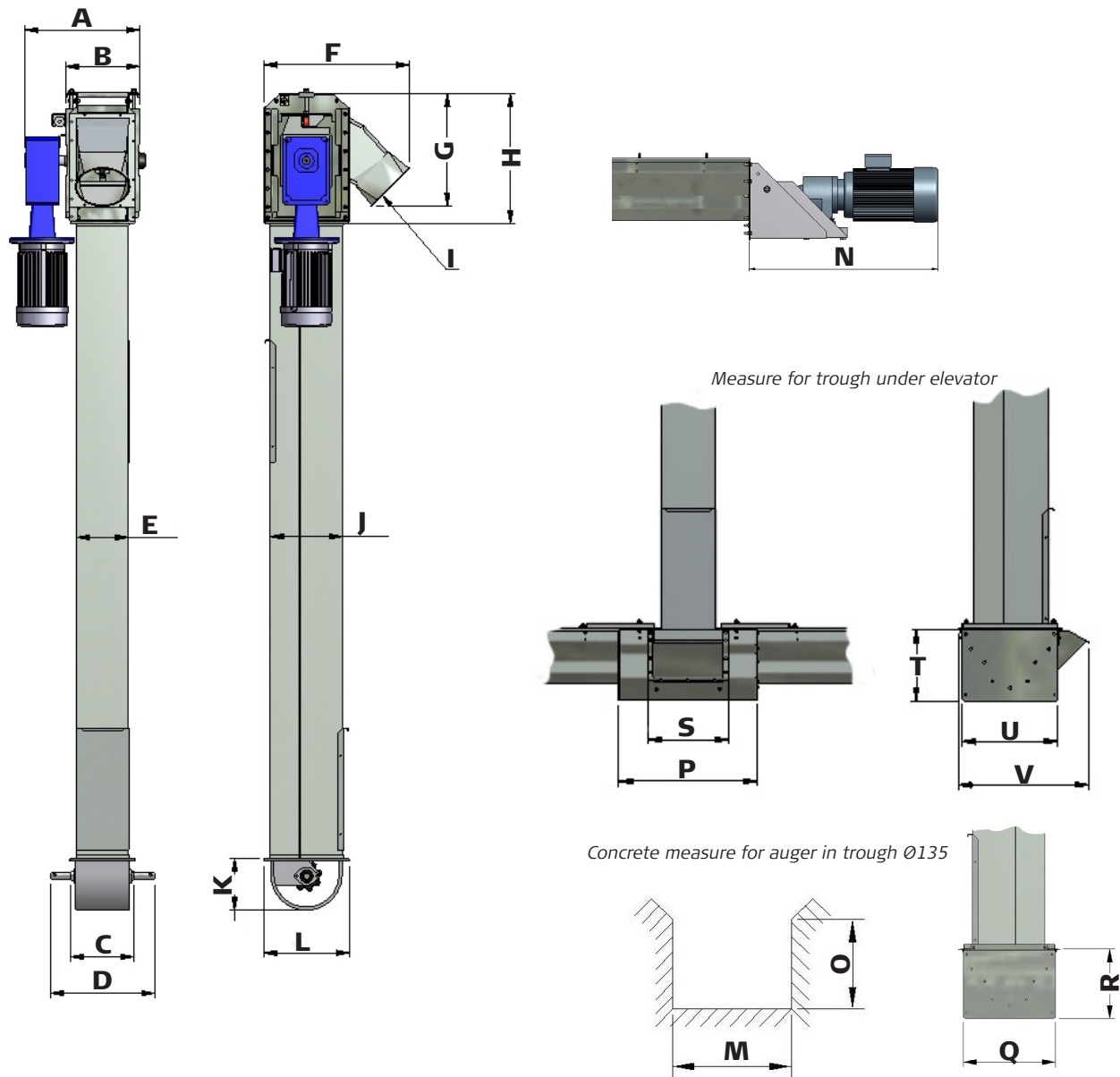


Flex-boot section with console and clutch

Scale drawing T20/T40 (gear motor)

	A	B	C	D	E	F	G	H	I	J	K
T20	378	215	175	335	135	530	430	500	OK160	278	215
T40	457	277	240	400	200	550	480	500	SK200	278	215

	L	M	N	O	P	Q	R	S	T	U	V
T20	320	400	760	300	520	365	265	300	265	365	500
T40	320	400	760	300	520	365	265	300	265	365	500

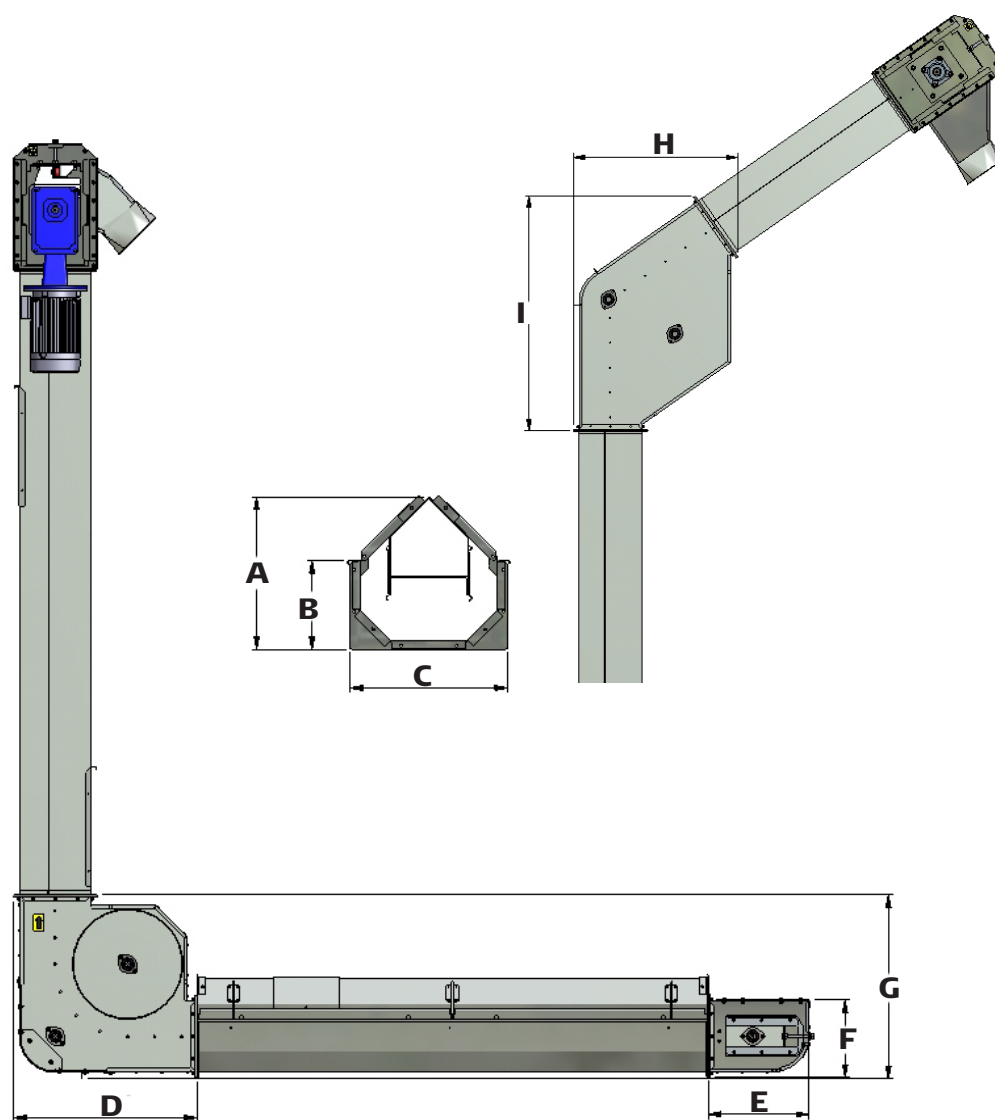


Fill up the auger trough with dry sand, and then trim around the edges.

Scale drawing T20/T40 90°/55° bend and chain conveyor T44/T45

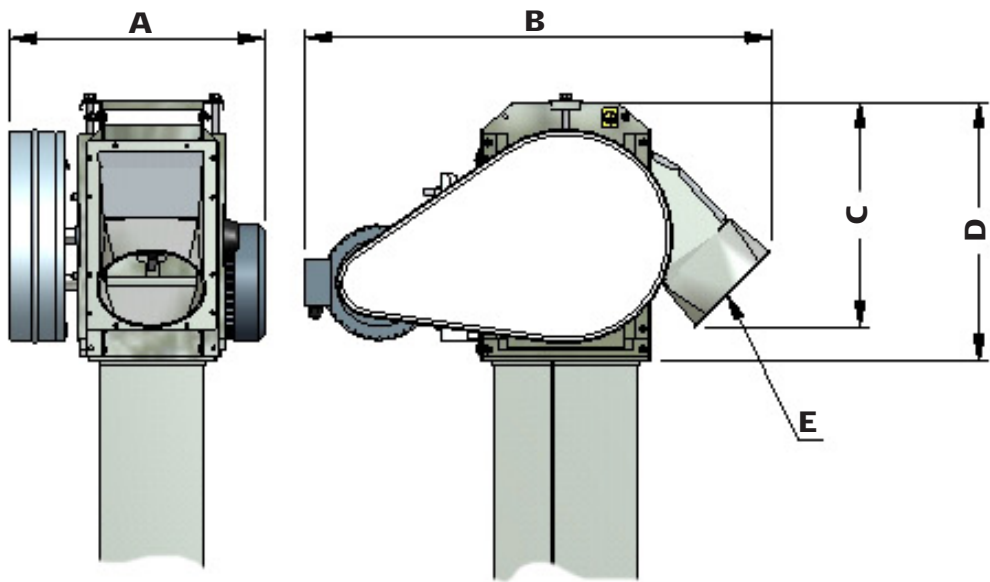
(gear motor)

	A	B	C	D	E	F	G	H	I
T20 / T44	375	230	355	720	430	300	720	730	1045
T40 / T45	390	230	415	720	430	300	720	730	1045



Scale drawing T20/T40 (pulley drive)

	A	B	C	D	E
T20	505	890	440	500	OK160
T40	525	940	450	500	Ø200



Upon receipt

Please check that all parts and components are included in the shipment and check for possible transport damages.

NB: Make sure that the relevant supplier documentation is attached to the gear and motor. In case of missing documentation, please contact JEMA AGRO A/S – remember to state the order no.

Remember all necessary safety equipment before installation.

Please read this manual carefully before assembly or installation work begins.

Warning labels

The chain elevator is fitted with warning labels.

Warning!

The covers and shields must never be opened or removed, when the machine is working.

Warning!

Always keep hands away from rotating augers/propellers.



Foundation

The chain elevator should be placed on a sufficiently hard, level surface that is able to carry the load in question.

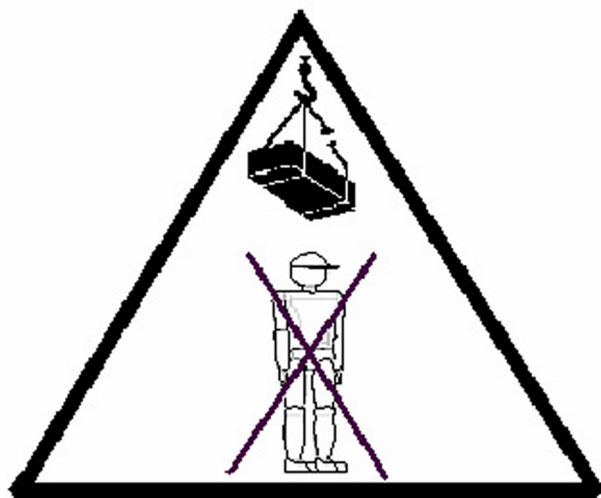
Lifting equipment

Make sure to have the required SWL-approved lifting equipment/crane, required for the actual job.

The lifting equipment must be approved to carry the load in question.

The load capacity for the individual components can be found in "Parts list T20/T40" in this manual.

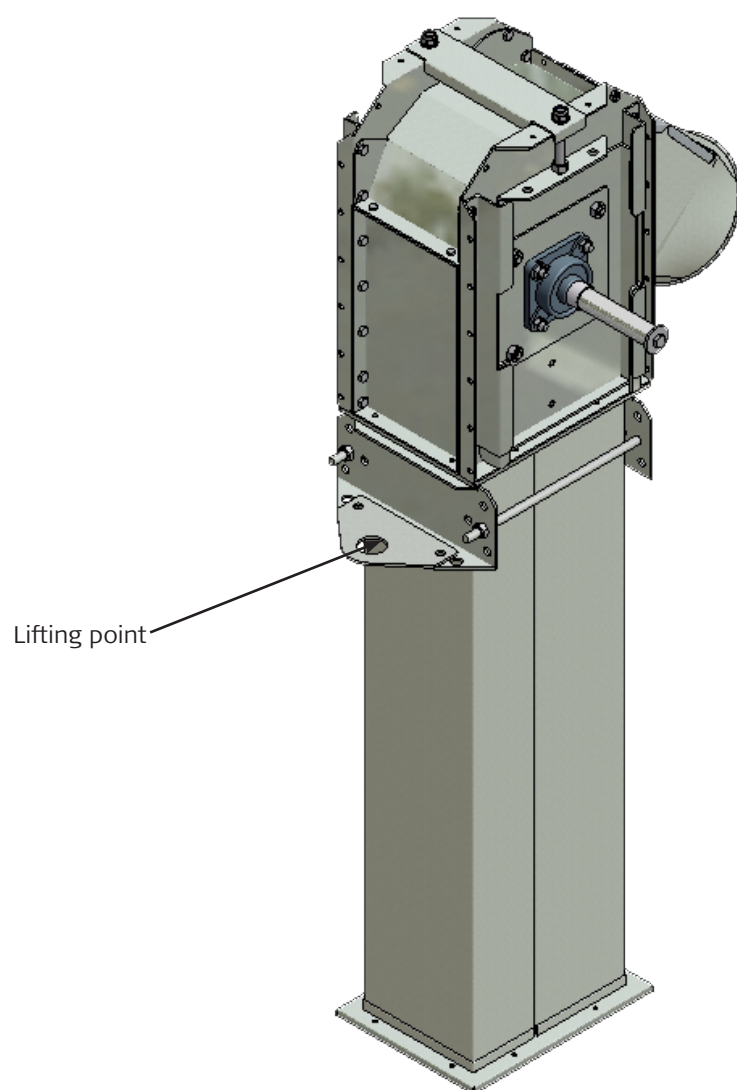
The total weight of the machine is stated in the section "Weight table chain elevator T20/T40".



NB: Always make sure that nobody is standing under a suspended load.

Lifting instructions

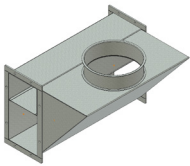
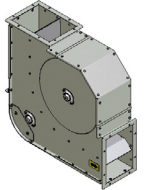
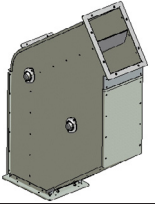
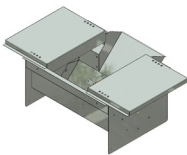
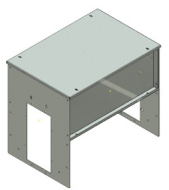

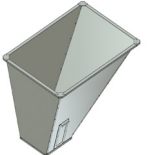
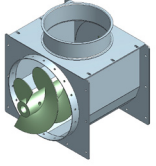
The drawing below shows how to lift the chain elevator using the attached brackets.



Weight table – individual components T20/T40

	Description	T20 Part no.	Weight kg	T40 Part no.	Weight kg
	Drive station for pulley drive	51577	36	52116	39
	Drive station for pinion gear motor, RHS	51583	36	52483	39
	Drive station for pinion gear motor, LHS	51585	36	52485	39
	Tension section	44095	12,61	45095	13,77
	Elevator boot d135, without chain	51142	7	52142	8
	Elevator boot d135, with ball bearings in sprocket, without chain	51143	8	52143	9
	Elevator boot, closed without chain	51231	6,6	52231	7,3
	Flex elevator boot, without chain	51312	20	52312	20,7
	Flex elevator boot, with ball bearings in sprocket, without chain	51316	22	52316	22,7
	Extension 2.5 m with inspection door	51012	35	52012	37
	Extension 2.5 m	51021	35	52021	37
	Extension, 2.0 m	51022	28	52022	32
	Extension, 1.0 m	51024	14	52024	16
	Extension, 0.5 m	51025	7	52025	8
	Extension, 0.25 m	51026	3	52026	5
	Extension 1.25 m	51027	2	52027	3

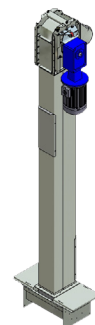
Weight table – individual components T20/T40

	Description	T20 Part no.	Weight kg	T40 Part no.	Weight kg
	Extension 0.5 m with side inlet d200 without chain	44130	10,5	45130	12
	90° bend without chain with sprocket	51060	37,00	52060	42,50
	55° bend without chain with sprocket	51030	35,2	52030	40,0
	Trough under elevator 45/90°	51056	13	51056	13
	Hopper kit with cover for 0.5 m inlet trough	44024	12	45024	13
	Chain complete, running metres	20028	2	40028	4
	Hopper for elevator	00082	35	00082	35
	Inlet d200 40 t/h for flex boot, one-way RHS	-		52320	15
	Inlet d200 40 t/h for flex boot, one-way LHS	-		52321	15

Weight table – chain elevator T20/T40

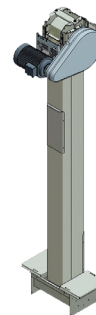
Complete with gear motor, trough under elevator and propeller with pin – LHS & RHS

Height, metres	T20	T40
	Pinion gear motor 280 rpm Kg.	Pinion gear motor 280 rpm Kg.
3,0	204,000	221,200
4,0	222,000	245,200
5,0	240,000	269,200
6,0	258,000	299,200
7,0	276,000	323,200
8,0	294,000	341,200
9,0	312,000	365,200
10,0	336,000	394,200
11,0	354,000	418,200
12,0	372,000	442,200
13,0	390,000	460,200
14,0	413,000	495,200
15,0	431,000	519,200
16,0	449,000	543,200
17,0	478,000	567,200
18,0	496,000	585,200
19,0	514,000	603,200
20,0	532,000	621,200



Complete with pulley drive, trough under elevator and propeller with pin – LHS & RHS

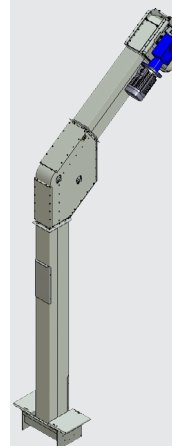
Height, metres	T20	T40
	Motor 1500 rpm pulley kit 71/355 Kg.	Motor 1500 rpm pulley kit 71/355 Kg.
3,0	207,000	224,200
4,0	225,000	248,200
5,0	243,000	272,200
6,0	261,000	302,200
7,0	279,000	326,200
8,0	297,000	344,200
9,0	315,000	368,200
10,0	339,000	397,200
11,0	357,000	421,200
12,0	375,000	445,200
13,0	393,000	463,200
14,0	416,000	498,200
15,0	434,000	522,200
16,0	452,000	546,200
17,0	481,000	570,200
18,0	499,000	588,200
19,0	517,000	606,200
20,0	535,000	624,200



Weight table – chain elevator T20/T40

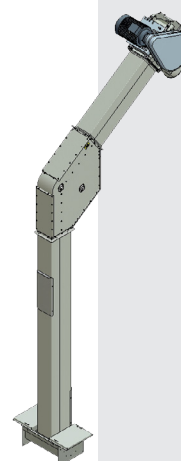
Complete with gear motor, 55° bend, trough under elevator, propeller with pin – LHS & RHS

Height in metres	T20	T40
	Pinion gear motor 280 rpm	Pinion gear motor 280 rpm
	Kg.	Kg.
15,0	385,000	476,000
16,0	399,000	496,000
17,0	413,000	516,000
18,0	438,000	536,000
19,0	452,000	556,000
20,0	466,000	576,000



Complete with pulley drive, 55° bend, trough under elevator, propeller with pin – LHS & RHS

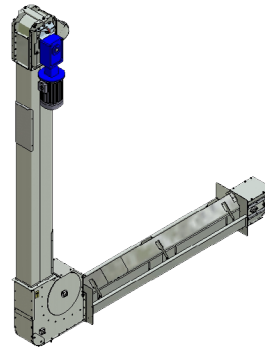
Height in metres	T20	T40
	Motor 1500 rpm pulley kit 71/355	Motor 1500 rpm pulley kit 71/355
	Kg.	Kg.
15,0	385,000	476,000
16,0	399,000	496,000
17,0	413,000	516,000
18,0	438,000	536,000
19,0	452,000	556,000
20,0	466,000	576,000



Weight table – T20 (gear motor)

Complete with gear motor, 90° bend and inlet trough.

Height in metres	Length		
	2,0 m.	3,0 m.	4,0 m.
	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm
	Kg	Kg	Kg
4,0	256,000	292,000	312,500
5,0	274,000	310,000	332,500
6,0	292,000	328,000	354,500
7,0	310,000	352,000	372,500
8,0	334,000	370,000	390,500
9,0	352,000	388,000	408,500
10,0	370,000	406,000	431,500
11,0	388,000	429,000	449,500
12,0	411,000	447,000	467,500
13,0	429,000	465,000	485,500
14,0	447,000	483,000	512,500
15,0	465,000	512,000	530,500
16,0	494,000	530,000	548,500
17,0	512,000	548,000	
18,0	530,000		

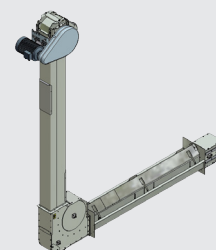


Height in metres	Length			
	5,0 m.	6,0 m.	7,0 m.	8,0 m.
	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm
	Kg	Kg	Kg	Kg
4,0	349,000	375,000	411,000	432,000
5,0	367,000	393,000	429,000	450,000
6,0	389,000	411,000	447,000	473,000
7,0	409,000	429,000	470,000	491,000
8,0	427,000	452,000	488,000	509,000
9,0	450,000	470,000	506,000	527,000
10,0	468,000	488,000	524,000	556,000
11,0	486,000	506,000	553,000	574,000
12,0	504,000	535,000	571,000	592,000
13,0	533,000	553,000	589,000	
14,0	551,000	571,000		
15,0	569,000			

Weight table – T20 (pulley drive)

Complete with pulley drive, 90° bend and inlet trough.

Height in metres	Length		
	2,0 m	3,0 m	4,0 m
	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit
	Kg	Kg	Kg
4,0	259,000	295,000	315,500
5,0	277,000	313,000	335,500
6,0	295,000	331,000	357,500
7,0	313,000	355,000	375,500
8,0	337,000	373,000	393,500
9,0	355,000	391,000	411,500
10,0	373,000	409,000	434,500
11,0	391,000	432,000	452,500
12,0	414,000	450,000	470,500
13,0	432,000	468,000	488,500
14,0	450,000	486,000	515,500
15,0	468,000	515,000	533,500
16,0	497,000	533,000	551,500
17,0	515,000	551,000	
18,0	533,000		

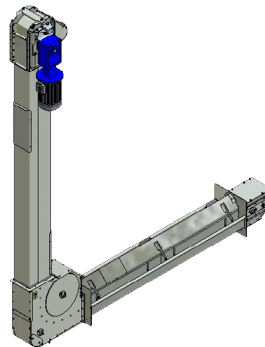


Height in metres	Length			
	5,0 m	6,0 m	7,0 m	8,0 m
	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit
	Kg	Kg	Kg	Kg
4,0	352,000	378,000	414,000	435,000
5,0	370,000	396,000	432,000	453,000
6,0	392,000	414,000	450,000	476,000
7,0	492,000	432,000	473,000	494,000
8,0	430,000	455,000	491,000	512,000
9,0	453,000	473,000	509,000	530,000
10,0	471,000	491,000	527,000	559,000
11,0	489,000	509,000	556,000	577,000
12,0	507,000	538,000	574,000	595,000
13,0	536,000	555,000	592,000	
14,0	554,000	574,000		
15,0	572,000			

Weight table – T40 (gear motor)

Complete with gear motor, 90° bend and inlet trough.

Height in metres	Length		
	2,0 m	3,0 m	4,0 m
	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm
	Kg	Kg	Kg
4,0	298,000	334,000	354,500
5,0	316,000	352,000	374,500
6,0	334,000	370,000	396,500
7,0	352,000	394,000	414,500
8,0	376,000	412,000	432,500
9,0	394,000	430,000	450,500
10,0	412,000	448,000	473,500
11,0	430,000	471,000	491,500
12,0	453,000	489,000	509,500
13,0	471,000	507,000	527,500
14,0	489,000	525,000	556,500
15,0	507,000	554,000	574,500
16,0	536,000	572,000	592,500
17,0	554,000	590,000	
18,0	572,000		

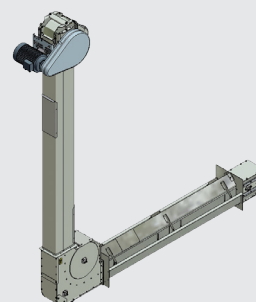


Height in metres	Length			
	5,0 m	6,0 m	7,0 m	8,0 m
	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm	Motor 280 rpm
	Kg	Kg	Kg	Kg
4,0	391,000	417,000	453,000	474,000
5,0	415,000	435,000	471,000	492,000
6,0	433,000	453,000	489,000	515,000
7,0	451,000	471,000	512,000	533,000
8,0	469,000	494,000	530,000	551,000
9,0	492,000	512,000	548,000	569,000
10,0	510,000	530,000	566,000	598,000
11,0	528,000	548,000	595,000	616,000
12,0	546,000	577,000	613,000	634,000
13,0	575,000	595,000	631,000	
14,0	593,000	613,000		
15,0	611,000			

Weight table – T40 (pulley drive)

Complete with pulley drive, 90° bend and inlet trough.

Height in metres	Length		
	2,0 m	3,0 m	4,0 m
	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit
	Kg	Kg	Kg
4,0	301,000	337,000	357,500
5,0	319,000	355,000	377,500
6,0	337,000	373,000	399,500
7,0	355,000	397,000	417,500
8,0	379,000	415,000	435,500
9,0	397,000	433,000	453,500
10,0	415,000	451,000	476,500
11,0	433,000	474,000	494,500
12,0	456,000	492,000	512,500
13,0	474,000	510,000	530,500
14,0	492,000	528,000	559,500
15,0	510,000	557,000	577,500
16,0	539,000	575,000	595,500
17,0	557,000	593,000	
18,0	575,000		



Height in metres	Length			
	5,0 m	6,0 m	7,0 m	8,0 m
	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit	Motor 1500 rpm pulley kit
	Kg	Kg	Kg	Kg
4,0	394,000	420,000	456,000	477,000
5,0	418,000	438,000	474,000	495,000
6,0	436,000	456,000	492,000	518,000
7,0	454,000	474,000	515,000	536,000
8,0	472,000	497,000	533,000	554,000
9,0	495,000	515,000	551,000	572,000
10,0	513,000	533,000	569,000	601,000
11,0	531,000	551,000	598,000	619,000
12,0	549,000	580,000	616,000	637,000
13,0	578,000	598,000	634,000	
14,0	596,000	616,000		
15,0	614,000			

Assembly

Please check the foundation and the transport direction (location of inlet and outlet), before starting the assembly.

It is important to read these instructions carefully before starting the assembly.

Check that there is sufficient space available.

Attention!

Before starting the assembly work, check that the required safety equipment is at disposal, e.g. work gloves, safety footwear, helmet, safety glasses and a lifeline, if necessary. This equipment is not included as standard.

Assemble the elevator in two parts, top and bottom section:

- The bottom part consists of the elevator boot, 2.5 m extension with inspection door (the assembly of the chain is made through this door) and elevator extensions corresponding to half the height of the elevator.
- The top section consists of the elevator head and the remaining number of extensions, and must be assembled with the chain - remember that the overlapping plate must be facing downward.
- The elevator extensions with inspection doors must be fitted at the elevator base plate, and the end with inspection door in the return channel must be facing downward.

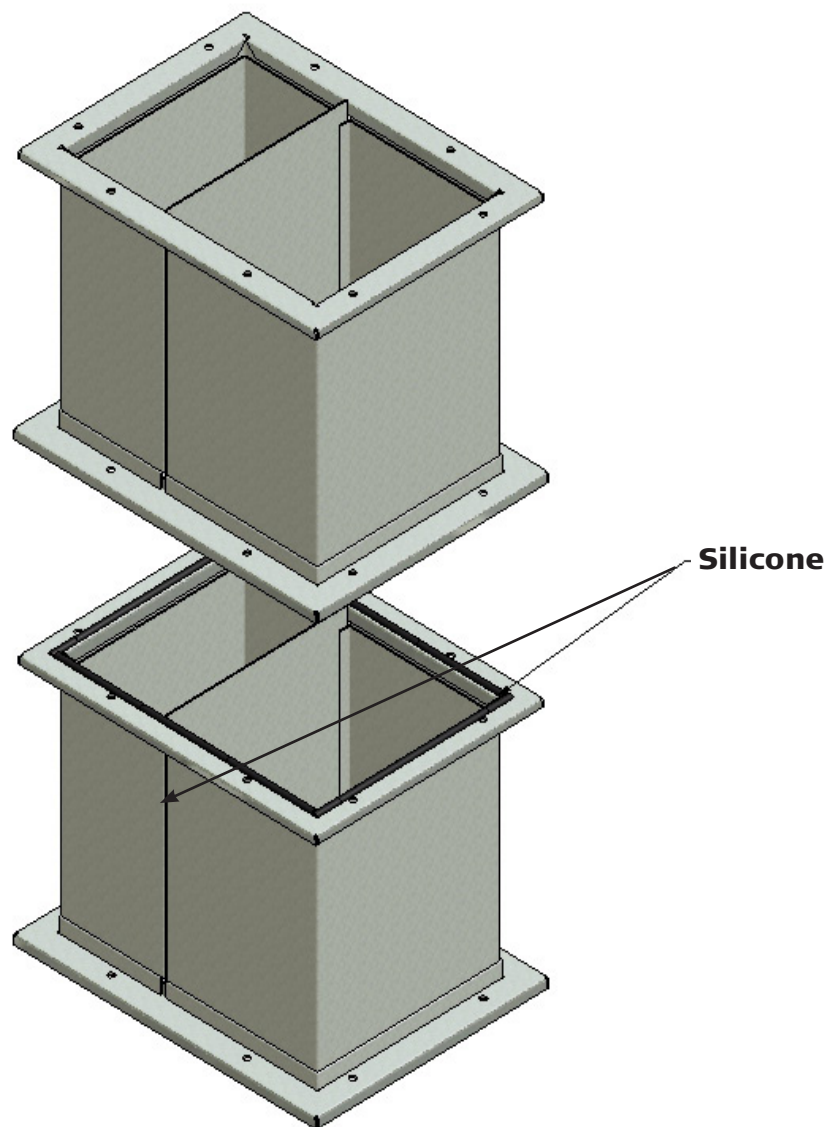
Assemble the top- and bottom section, once the individual sections have been assembled.

Sealing

All the joints must be sealed with a sealing compound in order to avoid dust and moisture nuisance.

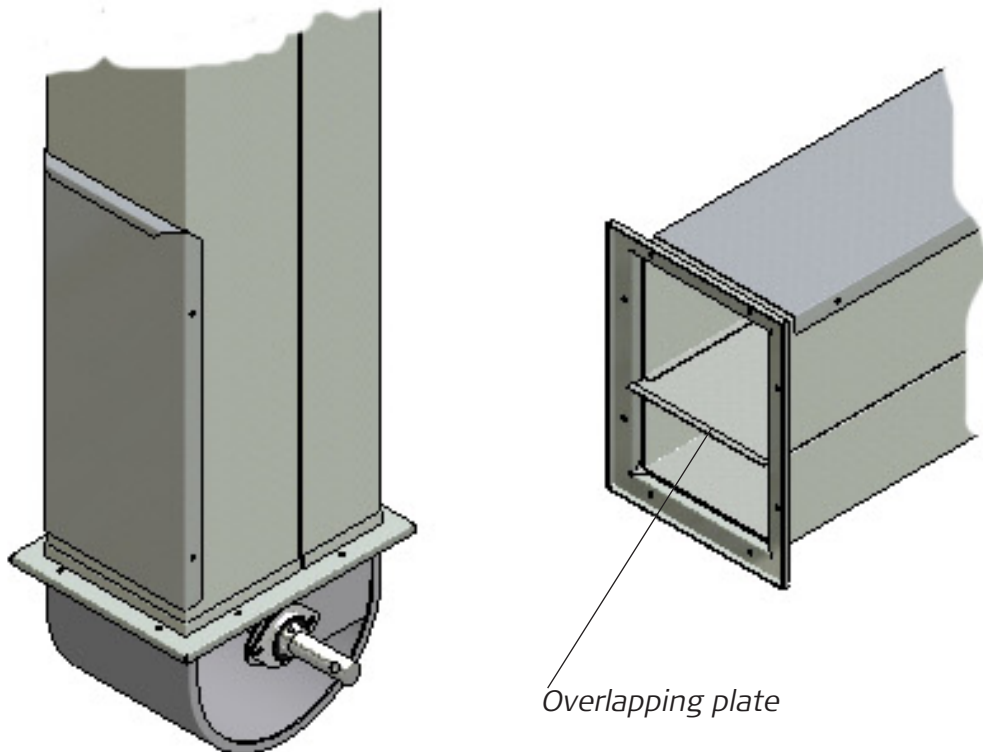
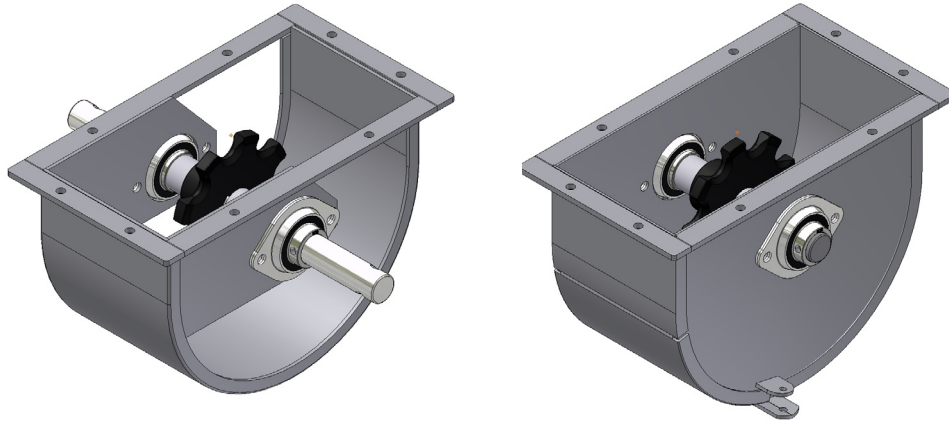
The sealer must be applied at the flanges inside the holes.

After sealing the joints must be bolted together.



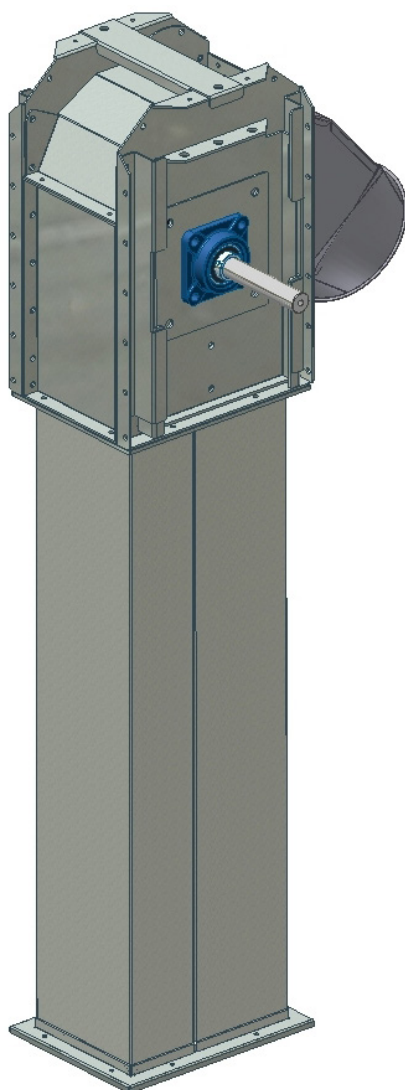
Elevator boot section

Fit and properly attach the boot part to the foundation. Fit the extensions – remember that the overlapping plate must be facing downward.



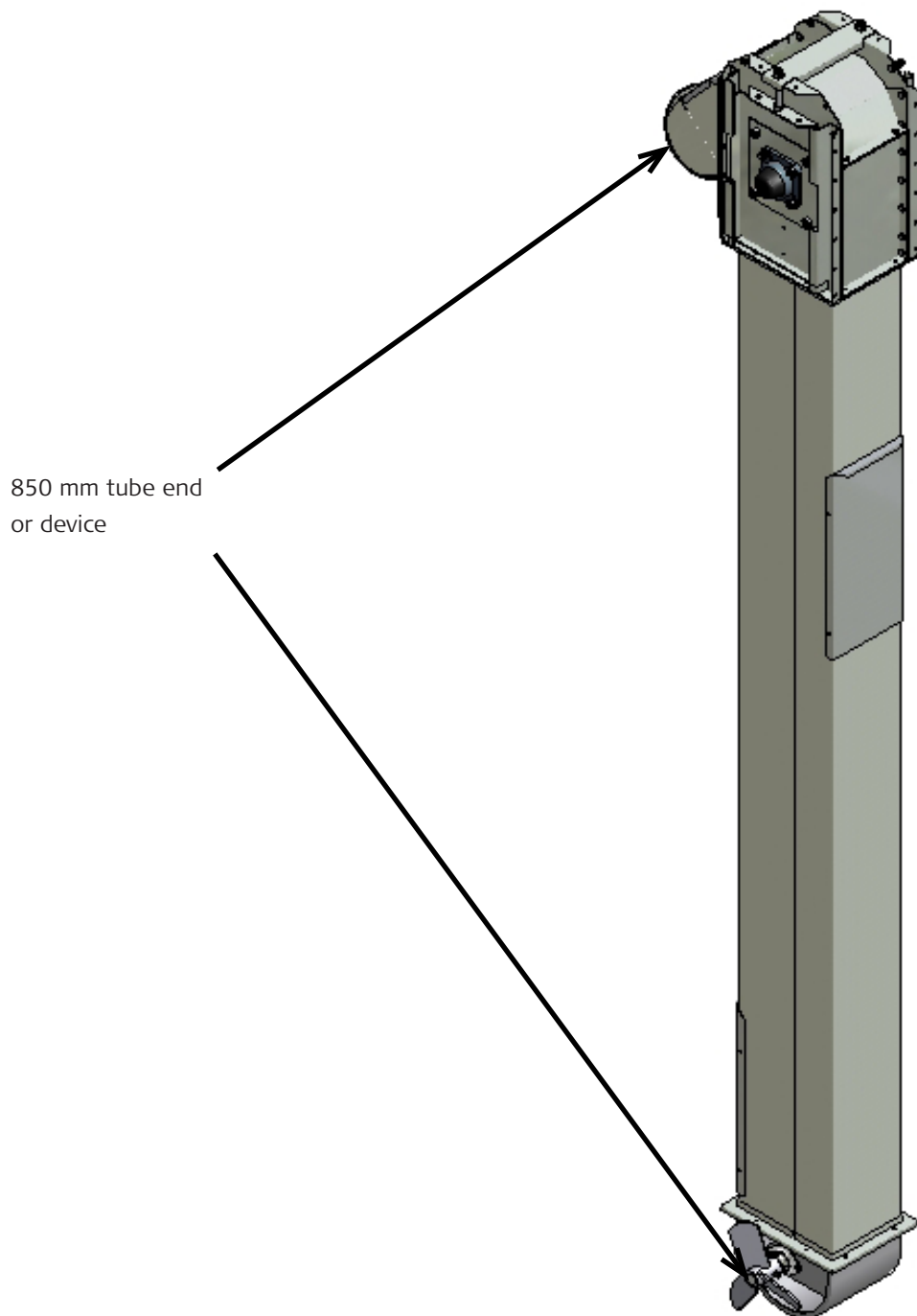
Elevator top section

Assemble the elevator top section on the floor. Fit extensions to the elevator head in dimensions corresponding to half of the total elevator height. When the extensions are fitted, fit the chain with rubber slats (see instructions in the section "Elevator chain").



Warning!

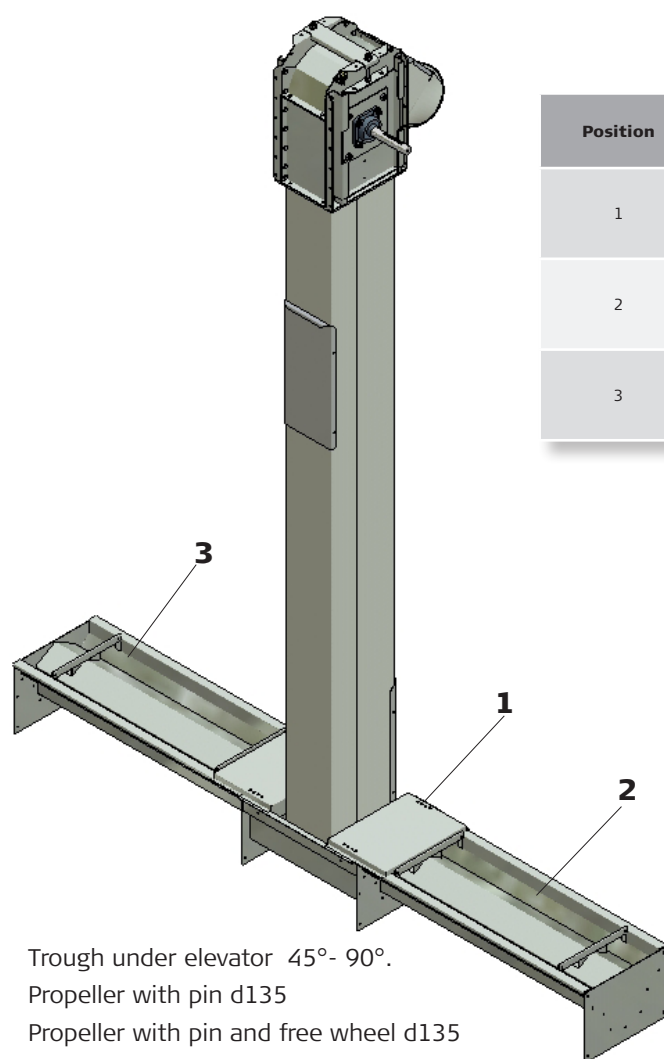
It is important to fit a tube of min. 850mm or another type of blocking device to avoid the risk of somebody sticking a hand or arm into the machine.



Chain elevator with auger trough

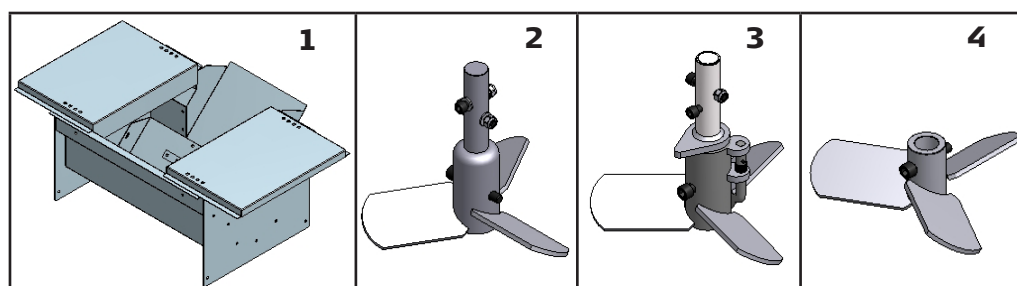
Fit propellers, propeller with pin or with pin and free wheel, to the bottom shaft of the elevator, and fit side augers, if specified, to these.

Make sure that propellers and augers are fitted on the right side, so the material is directed towards the elevator. Attach the cover above the augers and the trough cover plates.



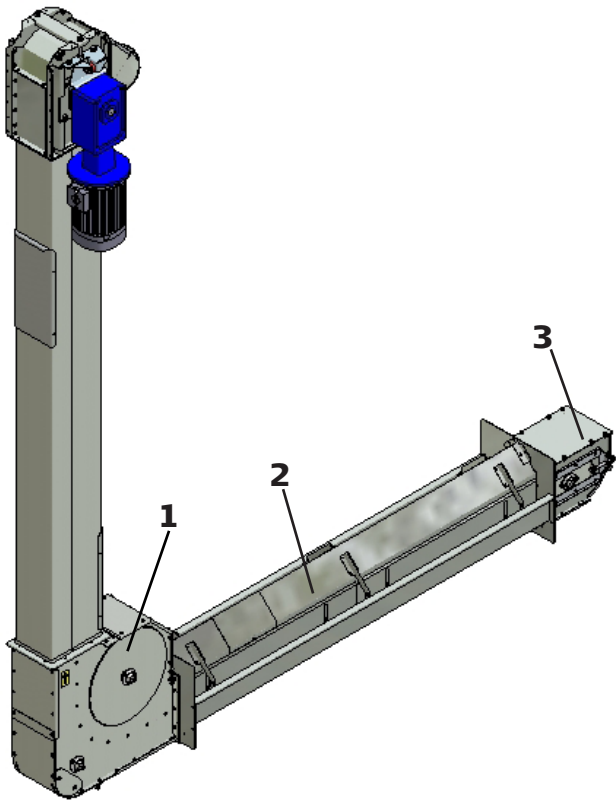
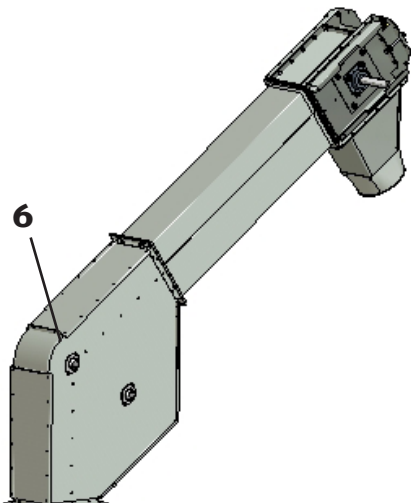
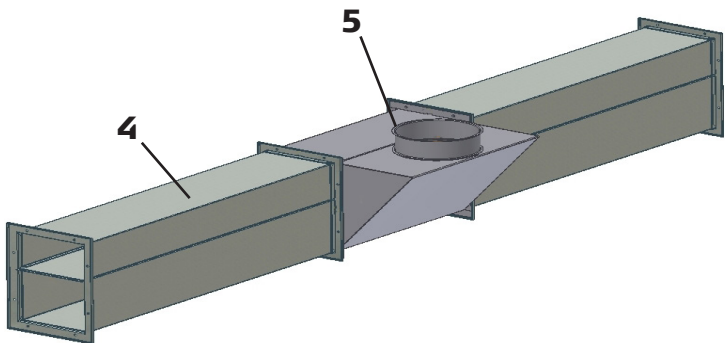
Position	Description
1	Trough under elevator 45°- 90°
2	Auger in trough RHS: Ø135-S60, d135-S90, Ø135-S125 Length: 2,0 m - 1,25 m - 1,0 m - 0,5 m
3	Auger in trough LHS: Ø135-S60, Ø135-S90, Ø135-S125 Length: 2,0 m - 1,25 m - 1,0 m - 0,5 m

1. Trough under elevator 45°- 90°.
2. Propeller with pin d135
3. Propeller with pin and free wheel d135
4. Propeller without pin



The shown propellers are RHS

Chain elevator with 55° og 90° bend



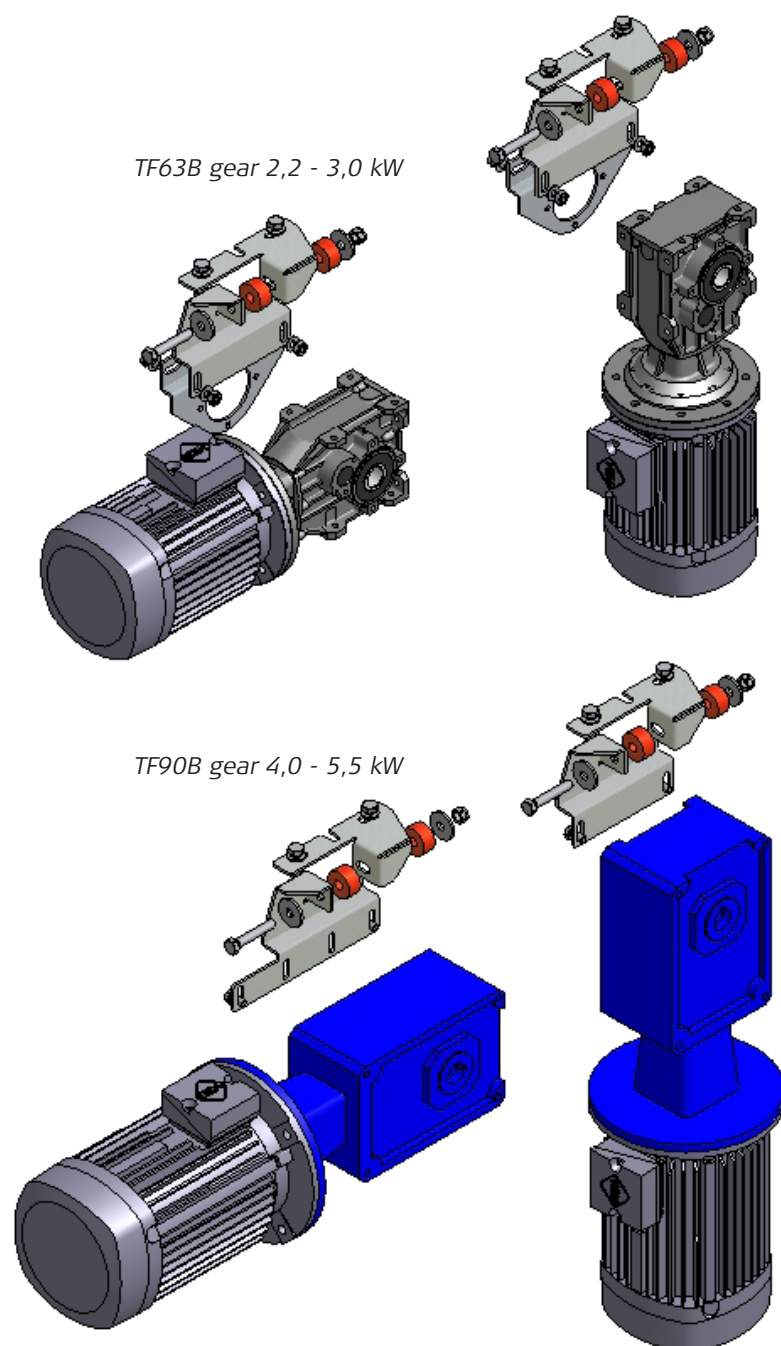
Position	Description
1	90° bend - model A
2	Inlet trough
3	Tension end
4	Extension
5	0.5 m extension with side inlet
6	Bend 55°

Gear motor assembly

Fit the motor and gear on the drive shaft (see below drawing).
The engine can be fitted in parallel or transversely on the machine.

Important!

The breather on the gear must always be fitted in the top position.

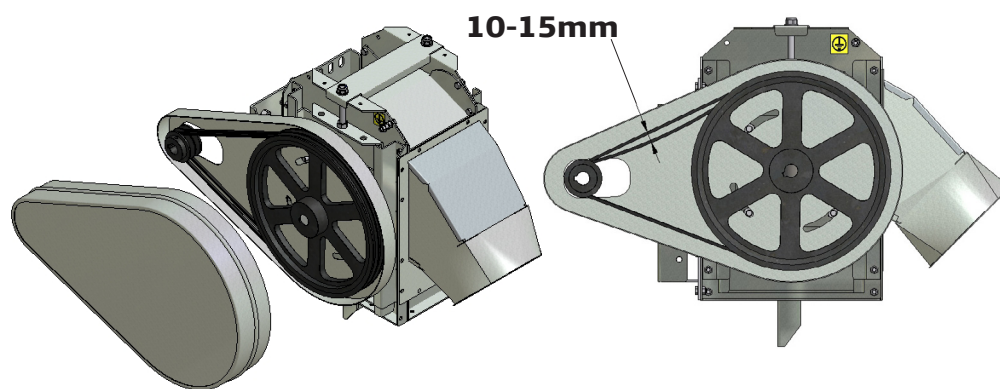


For maintenance of motor and gear: please see the attached supplier documentation.

Fitting the motor and pulley drive

- Start by screwing on the motor stand and then fit the internal pulley guard.
- Fit the small pulley on the motor shaft and tighten with a screw.
- Fit the motor loosely on the stand with 4 bolts without tightening it, screw the clip bolt and tension bolt on the motor stand, and then fit the large pulley on the drive station shaft and tighten it with a screw (remember the Woodruff wedge).
- Offset the motor in the slotted holes of the support, until the pulley sheaves are parallel. Tighten the motor bolts.
- Move the motor stand towards the conveyor by loosening the tension bolt, and fit the pulleys. Tighten the pulleys with the tension bolt and the clip bolt.
- Finally fit the external pulley guard.

The belt tensioning is correct when the belt deflection is 10-15 mm (see drawing).



Important!

The belt needs retightening after the first 24 hours, and then according to the maintenance schedule.

NOTE!

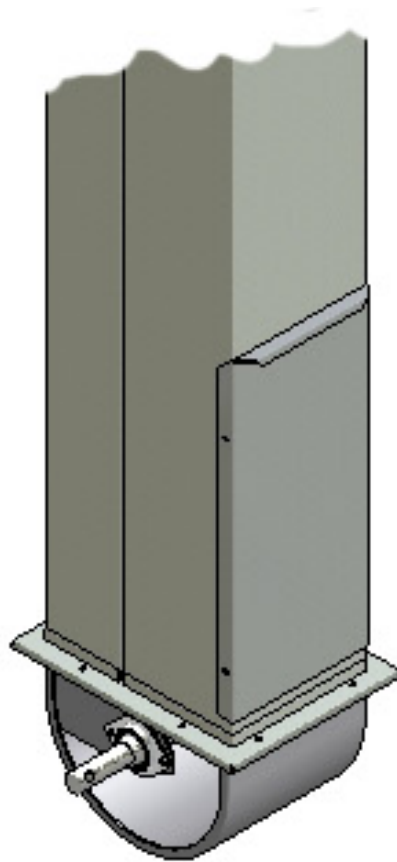
Do not use tools to force the pulleys onto the sheaves.

Elevator extensions

Fit the elevator extensions with inspection doors to the elevator boot /pivot inlet in a way that provides sufficient space for later assembly of the chain, as this has to be done through the extension/inlet trough opening/access door.

Fit the extensions as shown on the drawing (if available).

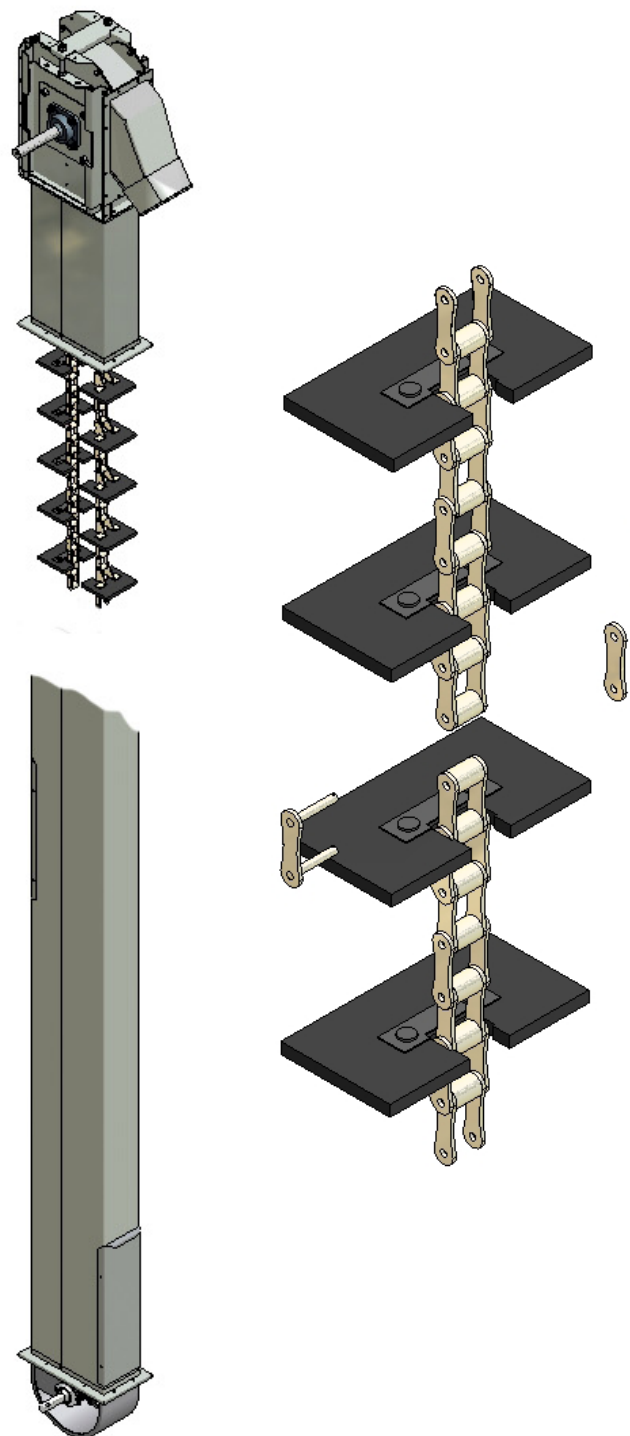
The elevator must be constantly secured during the fitting – see section “Height attachment”.



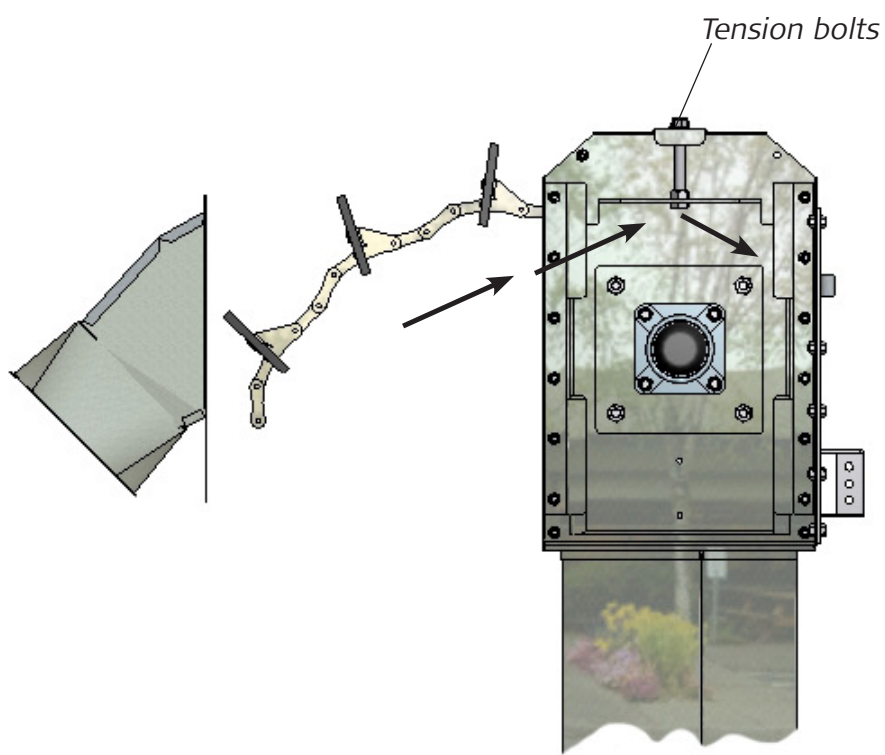
Elevator chain

The conveyor chain is equipped with rubber slats, and the chain must be fitted in the elevator, before the elevator head with extension is hoisted (see drawing).

When the elevator top section with the chain has been lowered into the bottom part, assemble the chain with the enclosed belt lacers.

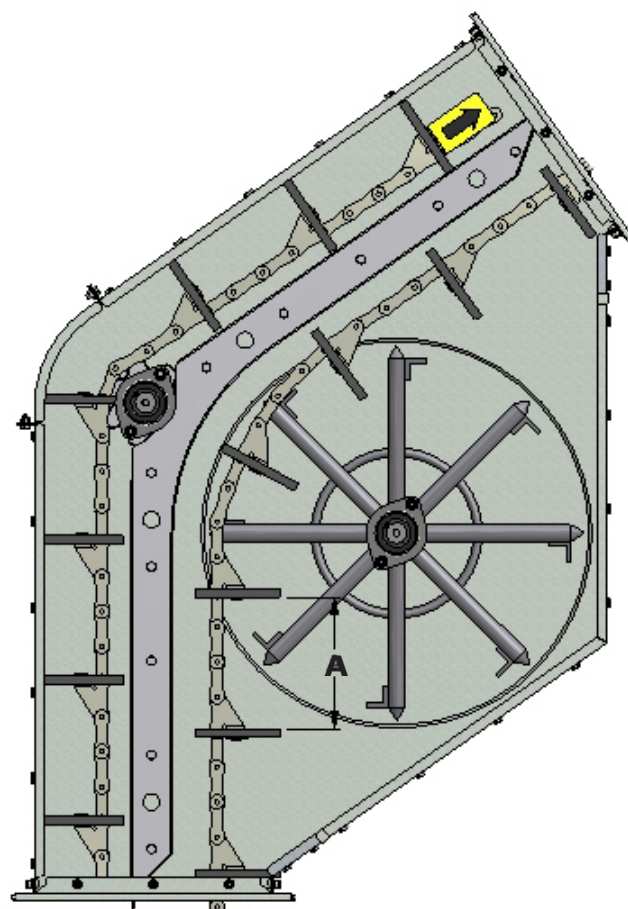
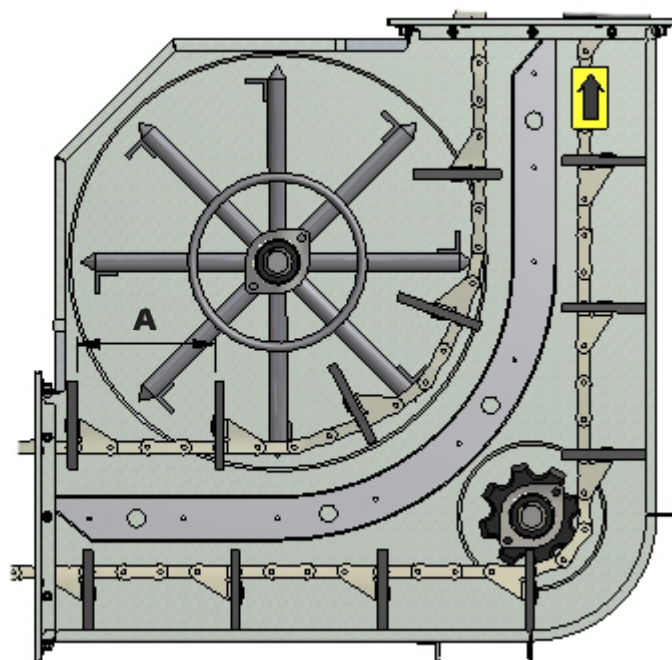


If this is not possible, due to lack of space, insert the chain through the elevator head outlet (see drawing below), insert the complete chain down the channel. Then insert half of the chain into the return channel, so the chain is evenly distributed in both channels. Block the chain with a rope or wire, and pull one end of the chain around the bottom sprocket and lift it up to the inspection door. Check the chain length (loosen the tensions bolts on the elevator head). If the chain needs shortening, it can be disassembled with a thin chisel. Assemble the chain – use only new clips in the connector links. Tighten the chains with the bolts on the elevator heads with a few mm play at the lower sprocket.



Important!

When fitting and tightening the chain on machines with inclinations, always keep the same distance between the slats (pos. A), and always fit one slat for each four chain links (as on drawings below).



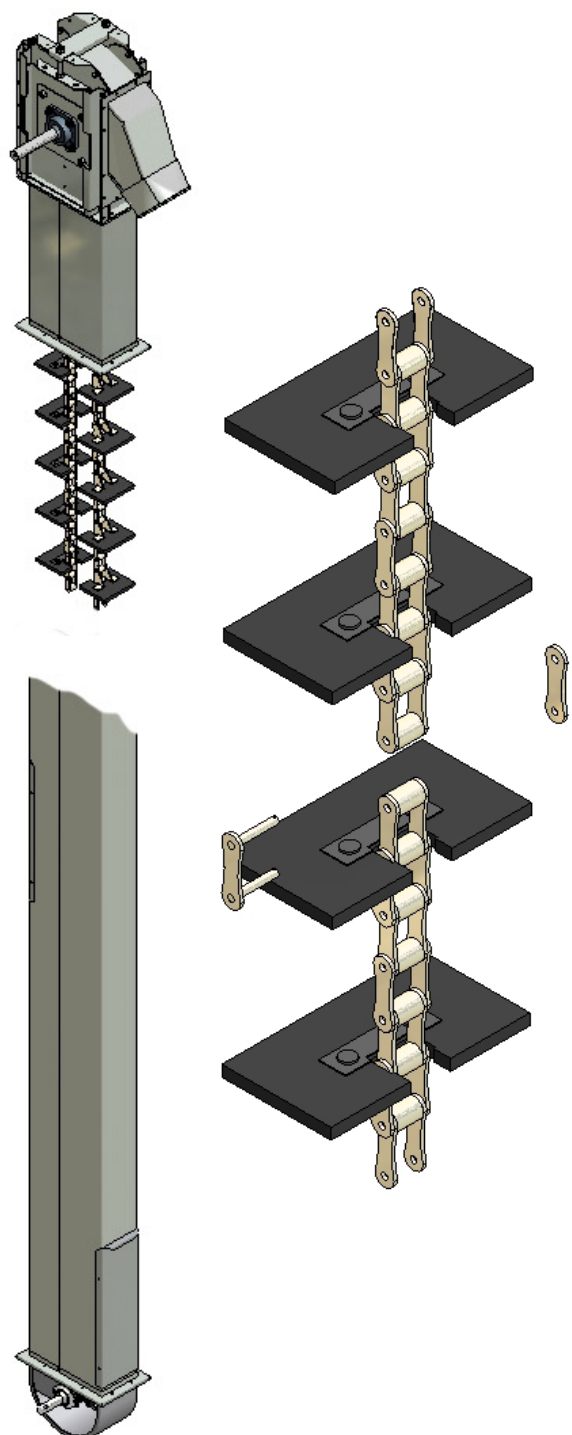
Elevator assembly

Always use correct and approved SWL-lifting equipment for the elevator assembly. Read the section "Upon receipt" before starting the assembly work.

Before lifting the elevator, the chain must be locked, e.g. with a rope or wire.

Unlock the chain before assembly.

Assemble the chain with the chain connector, when the elevator top and bottom part have been fitted (see drawing).



Important!

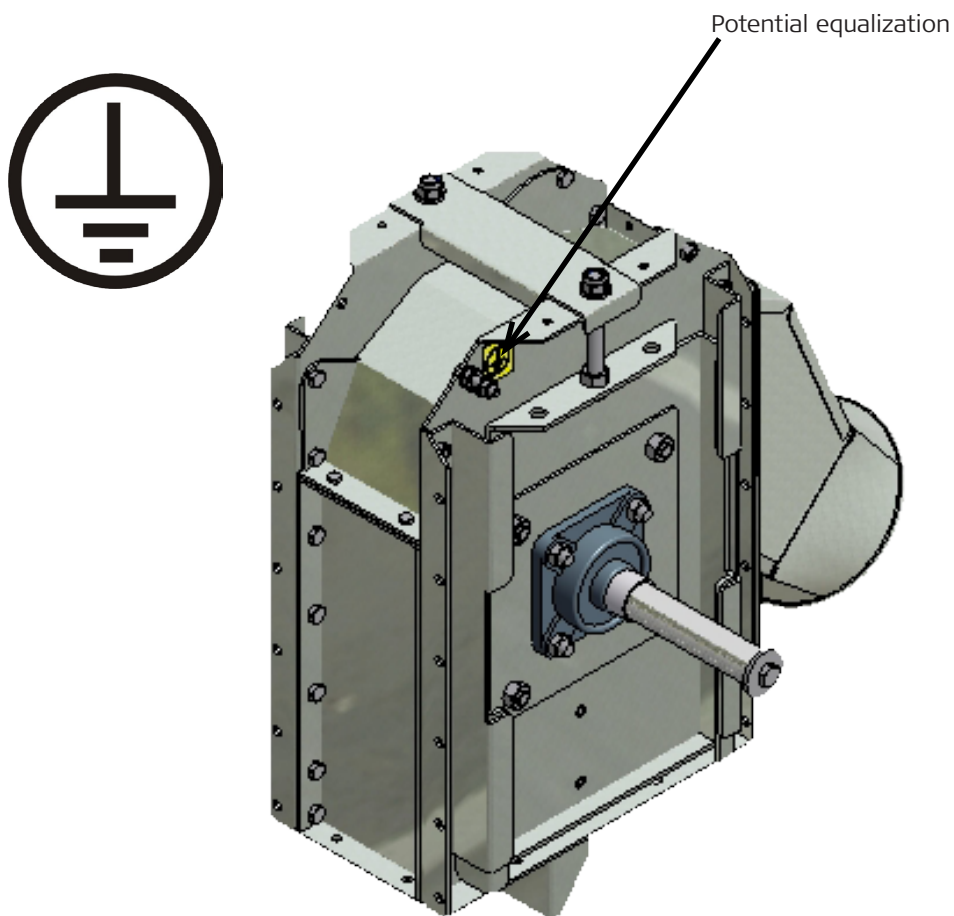
Remember to fit all inspection doors after assembly.

Potential equalization

The potential equalization must be carried out according to the current regulations.

A label on the elevator head indicates the correct point of the potential equalization. The equalization is important to secure that the machine is metalically connected.

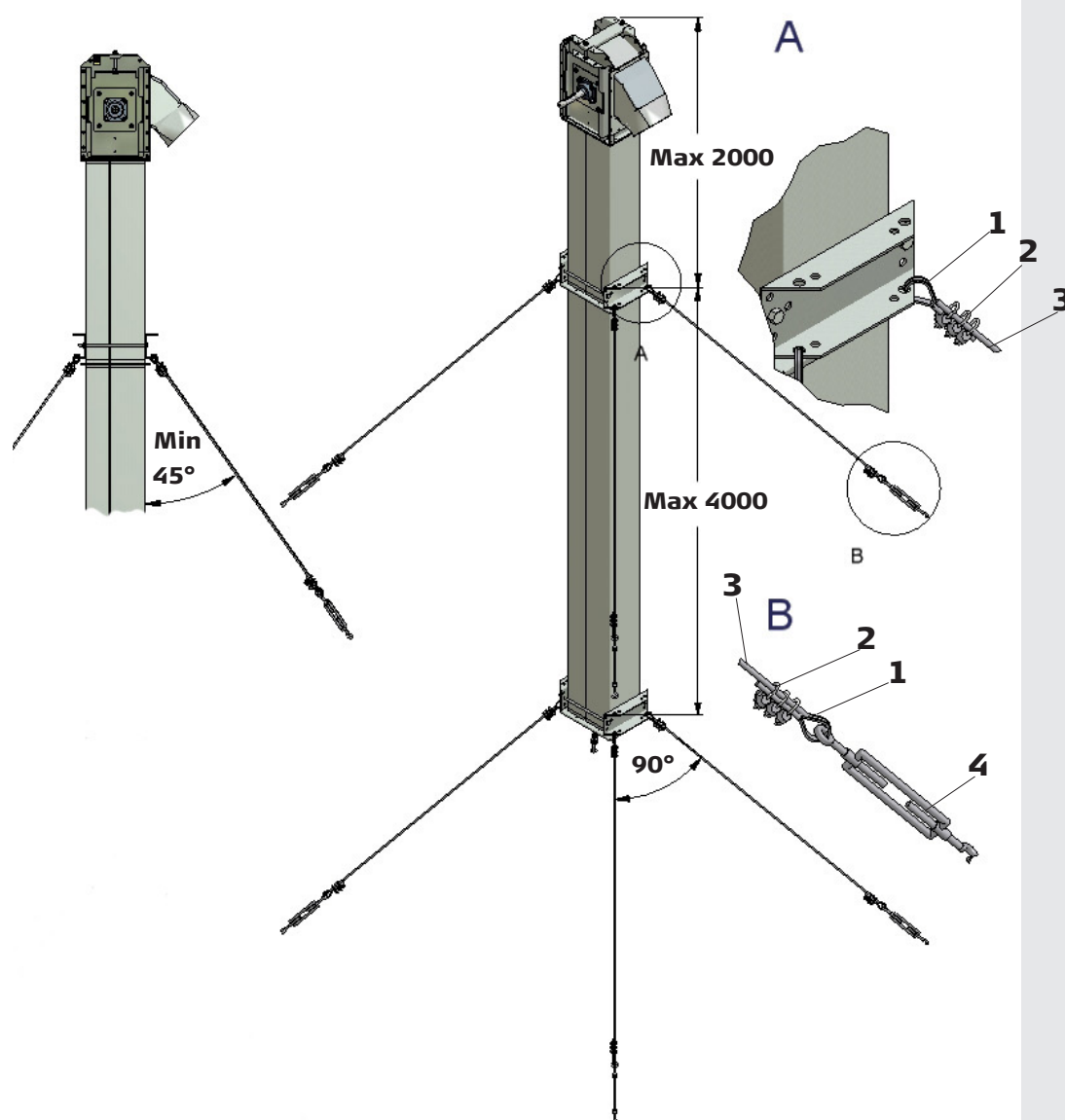
The label indicates the potential equalization point for the chain elevator.



Attachment

In order to obtain the maximum stability, it is important to stabilize the elevator vertical position. There must be a distance of maximum 2.0 m from the elevator head to the top attachment, and 4 m between the following fixation points.

The angle between the wires and the elevator must be max. 45°, and 90° between the wires (see below drawings).

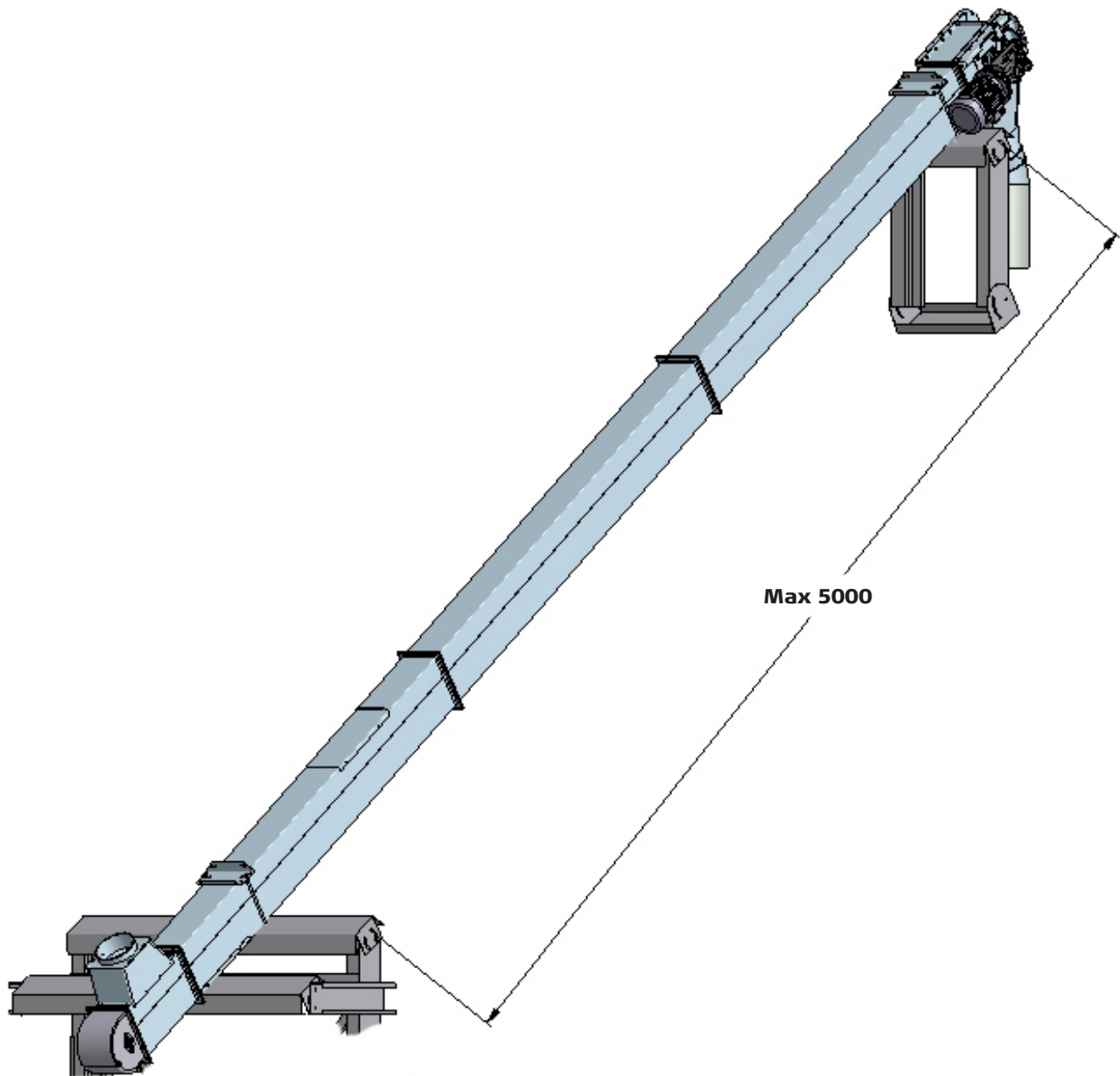


Pos.	Description	T20	Kg.	T40	Kg.
1	Wire thimble for 8mm wire	92112	0,032	92112	0,032
2	Wire rope clips for 8mm wire	92113	0,032	92113	0,032
3	Wire 8mm (weight per m.)	92114	0,194	92114	0,194
4	Wire idler for 8mm wire	92115	0,400	92115	0,400

Support of increasing elevator

It's important that the elevator is fixed to ensure stability.

Max. distance between the support points is 5 meters.



Starting up

Before starting to work with the chain elevator, please check that:

- All inspection doors are fitted
- No work is carried out on/near the machine.
- The motor rotation direction is correct.
- All bolts are correctly fitted and tightened.
- The chain is correctly fitted and adjusted.
- The attachment and stability of the chain elevator is correct.
- Check after start that no joints are leaking.
- If fitted, check for correct tension of the pulley.

Elevator stops – faultfinding

In case of stops, check first whether the elevator is able to start again, when the relay has cooled. If this is possible, the fault is either caused by low adjustment of the relay or lack of motor capacity. Check if the motor is correctly connected by the electrician.

If the elevator is still not able to start without being emptied of material, check whether the return tube (downward passage) on the conveyor is filled with material in the first section (open the inspection door). In this case the fault is due to blockage of the elevator drain (drain tubes too small or insufficient slope) or caused by stops further along in the transport system.

Maintenance

Please see the maintenance summary and the attached supplier documentation for cleaning- and maintenance intervals.

Warning!

- During cleaning and maintenance work, the electric supply for the chain elevator must be disconnected and secured against accidental reconnection.
- After repair and maintenance the inspection doors and shields must be refitted before the work is continued.

Always use original parts only

In case that original parts are not used, the warranty becomes void, and JEMA AGRO A/S can no longer be held liable for the EU Declaration of conformity.

Gear motor

Check the gear as described in the attached supplier documentation.

Important!

Check that the breather is fitted in the top position on the gear.

Motor

Bearing noise from the motor: please see the attached supplier documentation.

Motor inspection: please see the attached supplier documentation.

Retorque the motor as indicated in the maintenance summary. Please see the assembly guidance for instructions.

Pulley kit

Check the belt tension intervals as indicated in the maintenance summary.

Check for cracks on the side of the belts. Replace if necessary.

Note!

Do not mix old and new belts

Elevator chain

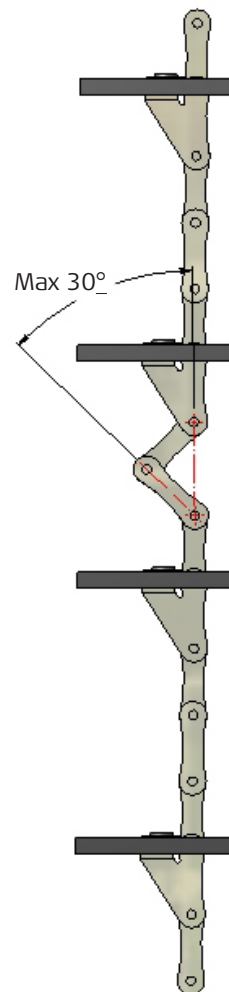
Check that the chain tension is correct.

Tighten the belt by using the 12 mm bolts on the top of the elevator head.

See drawing for correct procedure.

IMPORTANT! When tightening the chain, loosen the torque arm.

See inspection intervals in the maintenance summary.



Rubber slats

Defective or worn rubber slats must be replaced. See the maintenance summary.

Bearings.

Check the bearings for wear/play, and lubricate as described in the maintenance summary.

Check for wear/play by lifting up the shaft and check manually.

Make sure that there is no water in the pit, as this will damage the bearings in the elevator boot section.

Lubrication of bearings

Important!

Always keep the lubrication intervals as stated in the maintenance schedule.

It is extremely important to use the correct amount of grease, as too much will damage the sealing of the bearing, which will result in leaks and subsequent overheating of the bearing.

Check the amount of grease per grease gun stroke.

Elevator head

Lubricate the 2 bearings in the elevator head with 3.0 g grease as described in the maintenance summary.

Elevator boot

Check, and if necessary, change the two bearings in the elevator boot after 8000 hrs of operation.

Leaks

Any leaks must be repaired immediately.

Nose and vibrations

Stop the chain elevator immediately and identify the problem.

Disposal



The methods of disposal must comply with the current local regulations

Warning!

The electric supply to the motor must be disconnected during the disassembly.

Disassemble the elevator on the floor, if space allows, following the reverse order of the assembly procedure.

If the chain elevator is disassembled at the premises, start by removing the motor. For elevators with pulley drive, the pulley must be removed first, then the motor, the large pulley sheave and finally the guard.

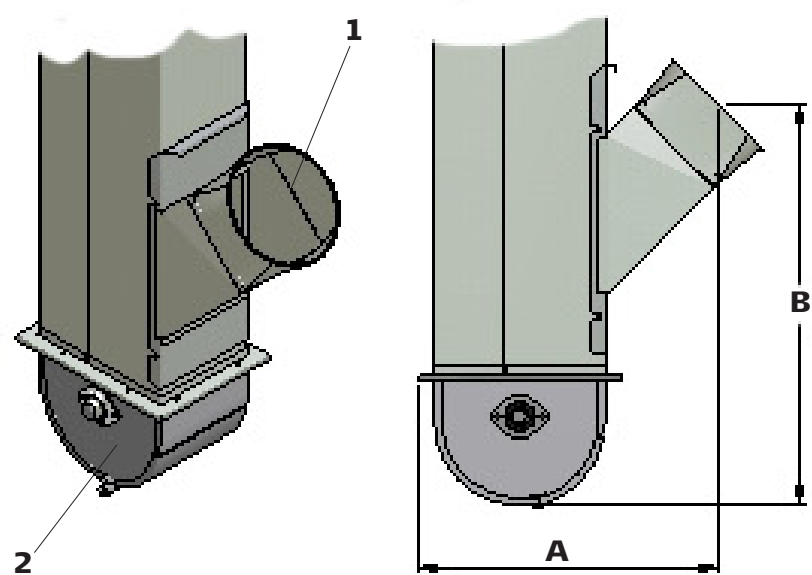
The easiest way to remove the chain is to dismantle the connector joint at the bottom of the elevator and then pull out the chain through the bottom inspection door. Screw off the motor stand and the elevator head. Finally remove all extensions.

The chain elevator contains various materials that can be reused. All metal parts should be delivered to a recycle industry.

Options/accessories

A range of various options/accessories is available for the chain elevator, if required.

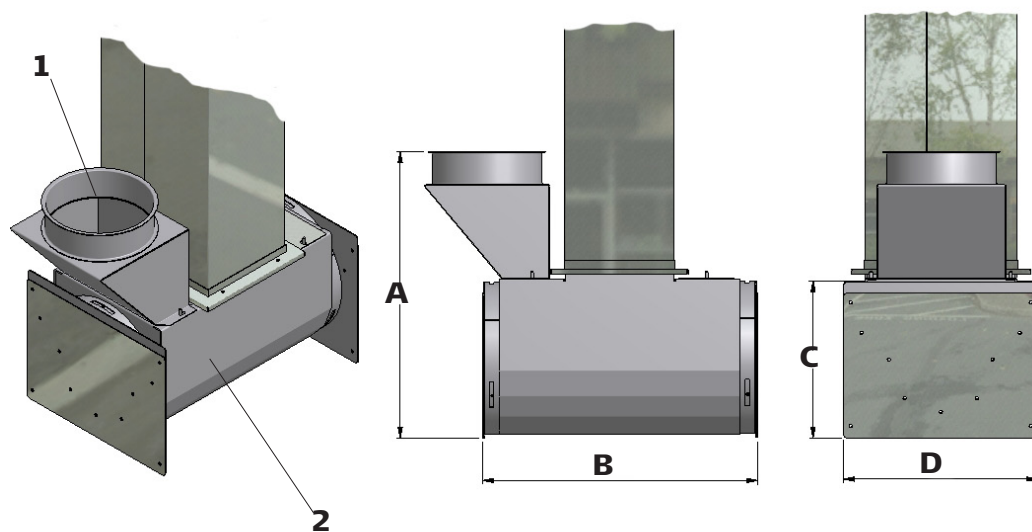
Inspection door with inlet



Pos.	T20	T40
A	425	475
B	580	650

Pos.	Description	T20	Kg.	T40	Kg.
1	Inspection door with inlet 45° OK160/d200	51467	2,000	52467	3,000
2	Elevator boot, closed	51231	7,000	52231	8,000

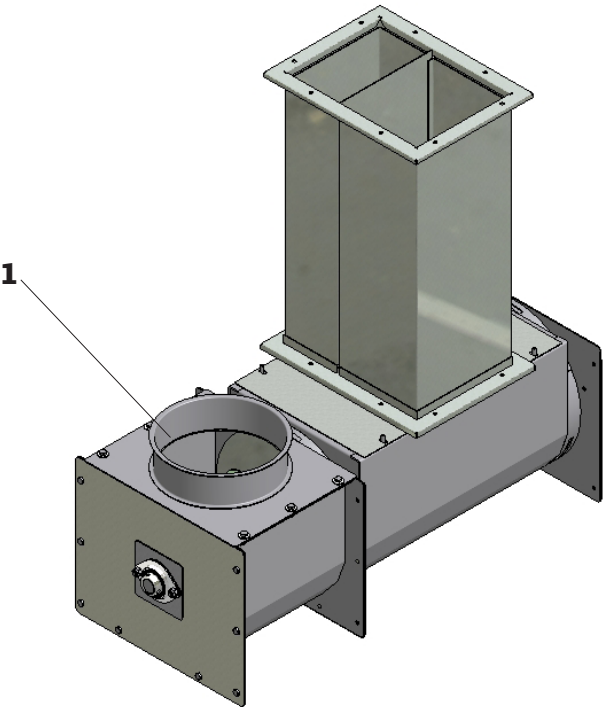
Inlet piece for flex-elevator boot section



Pos.	T20	T40
A	500	500
B	500	500
C	265	265
D	355	355

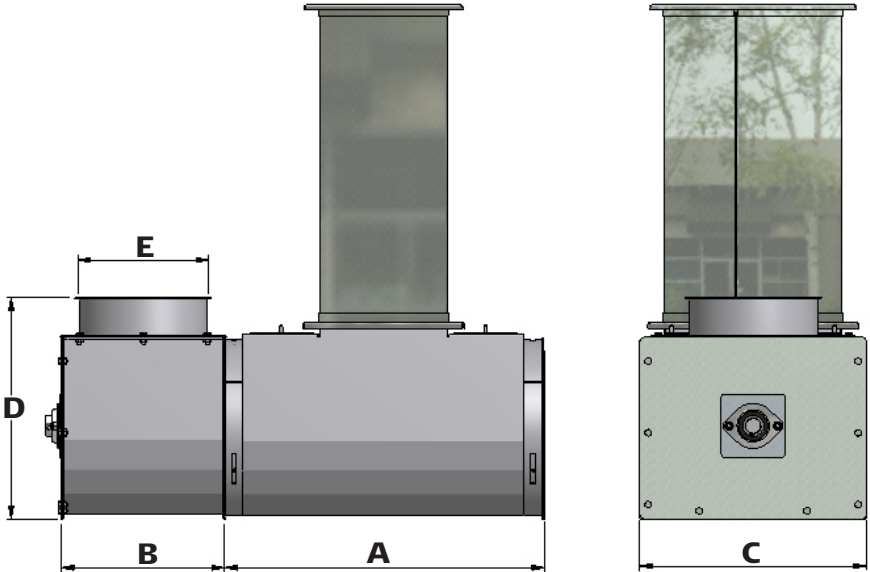
Pos.	Description	T20	Kg.	T40	Kg.
1	Inlet piece, flex-elevator boot section OK160/d200	51303	2,000	52303	4,000
2	Flex-elevator boot	51312	22,000	52312	22,000

Inlet d.200 Flex-boot section, one-way

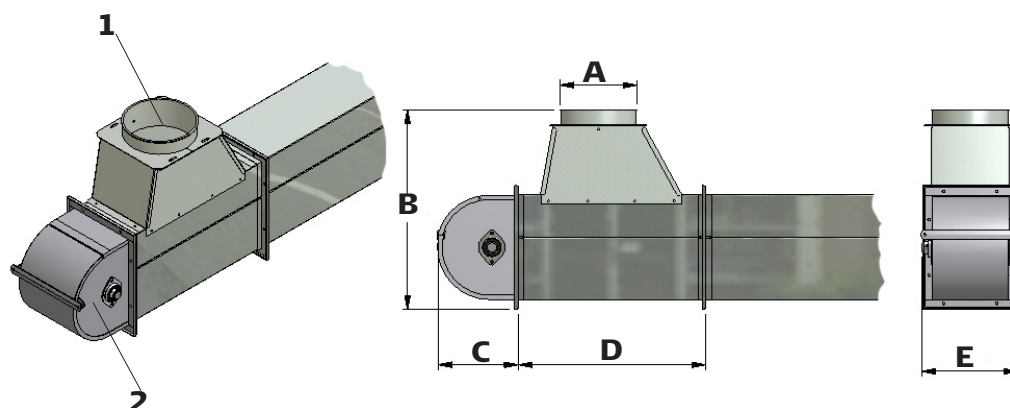


Pos.	Description	RHS	Kg.	LHS	Kg.
1	Inlet diam.200, one-way for flex-boot section T40	52320	15,000	52321	15,000

Pos.	T40
A	500
B	280
C	355
D	350
E	Ø200



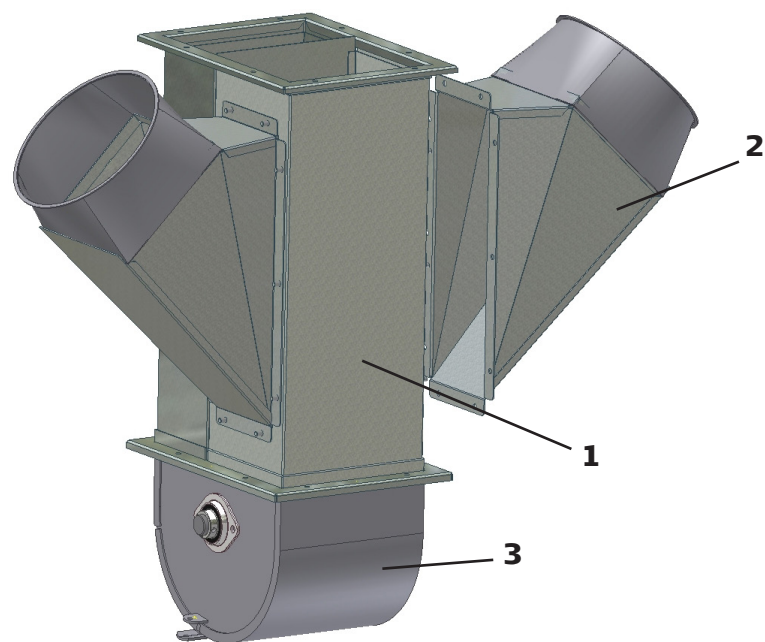
Extensions with pivot inlet



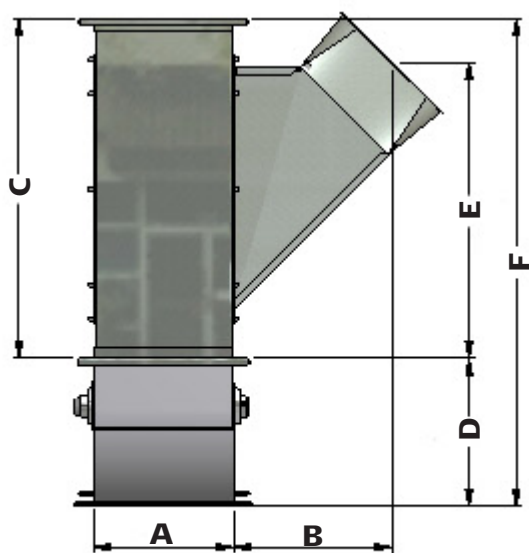
Pos.	T20	T40
A	160	200
B	535	535
C	215	215
D	500	500
E	175	240

Pos.	Description	T20	Kg.	T40	Kg.
1	0.5 m with pivot inlet OK160/d200	51246	9,000	52246	12,000
2	Elevator boot section, closed	51231	7,000	52231	8,000

Extensions 0.5 m with 45° inlet



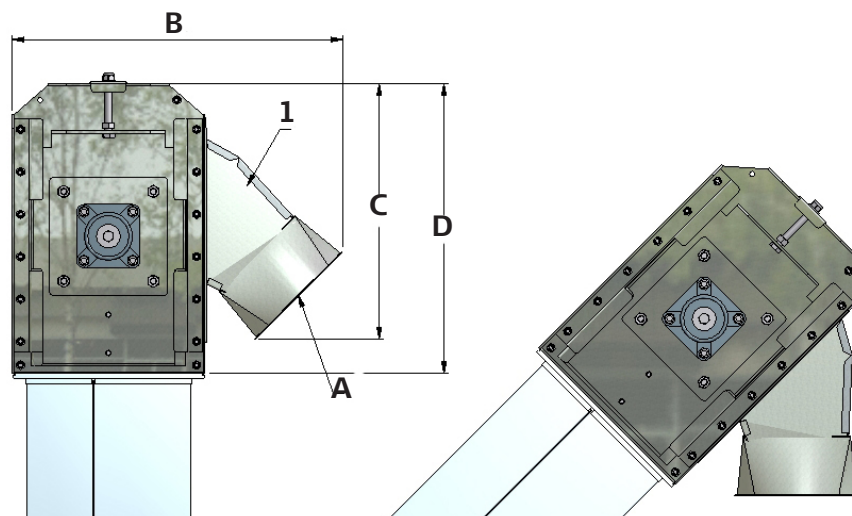
Pos.	Description	T20	Kg.	T40	Kg.
1	Extension 0.5 m with 45° indløb - inlet – RHS or LHS d200	51249	9,000	52249	11,000
2	Inlet 45°, d200 for 0.5 m extension	51250	3,000	51250	3,000
3	Closed elevator boot section	51231	7,000	52231	8,000



Pos.	T20	T40
A	175	240
B	250	250
C	500	500
D	215	215
E	450	450
F	665	665

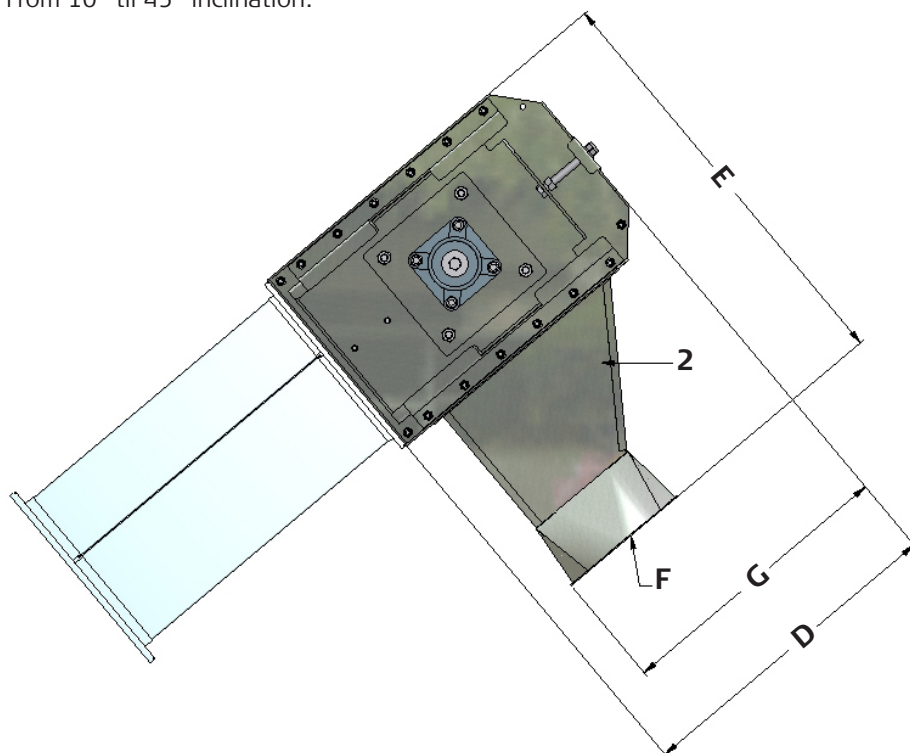
Outlet for elevator head

From 90° til 45° inclination:



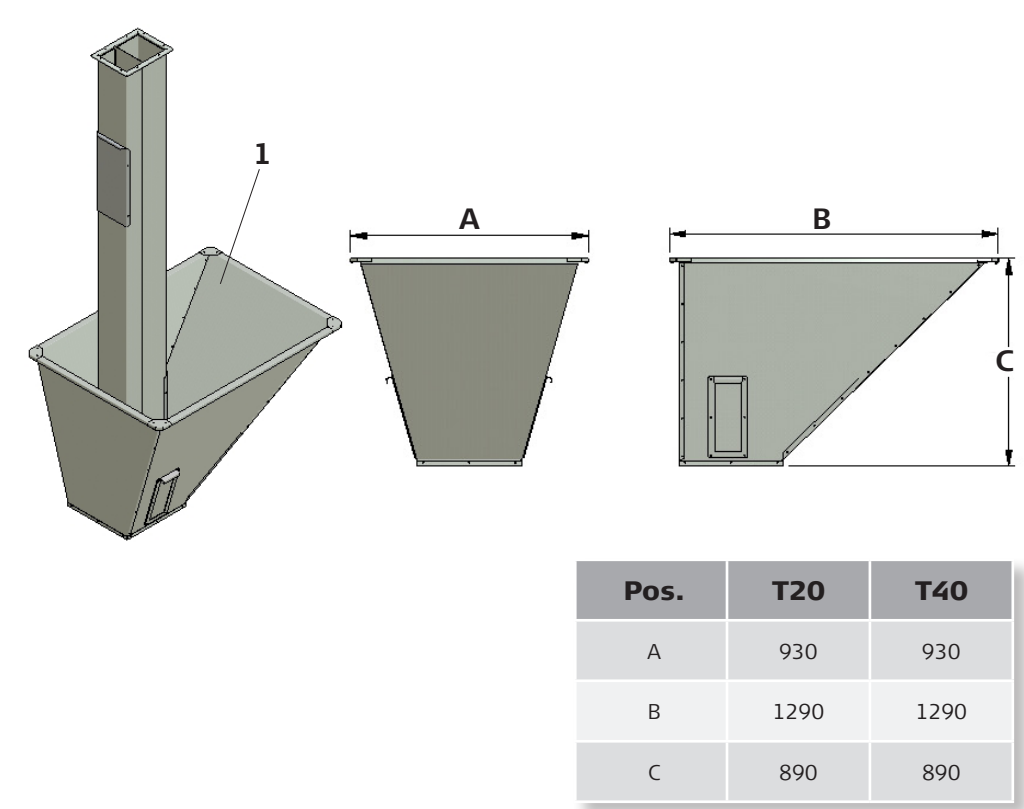
Pos.	Description	T20	Kg.	T40	Kg.
1	Outlet for drive station	51571	2,500	52110	3,000
2	Outlet trough for drive-/tension station 90°	44247	4,500	45247	5,000

From 10° til 45° inclination:



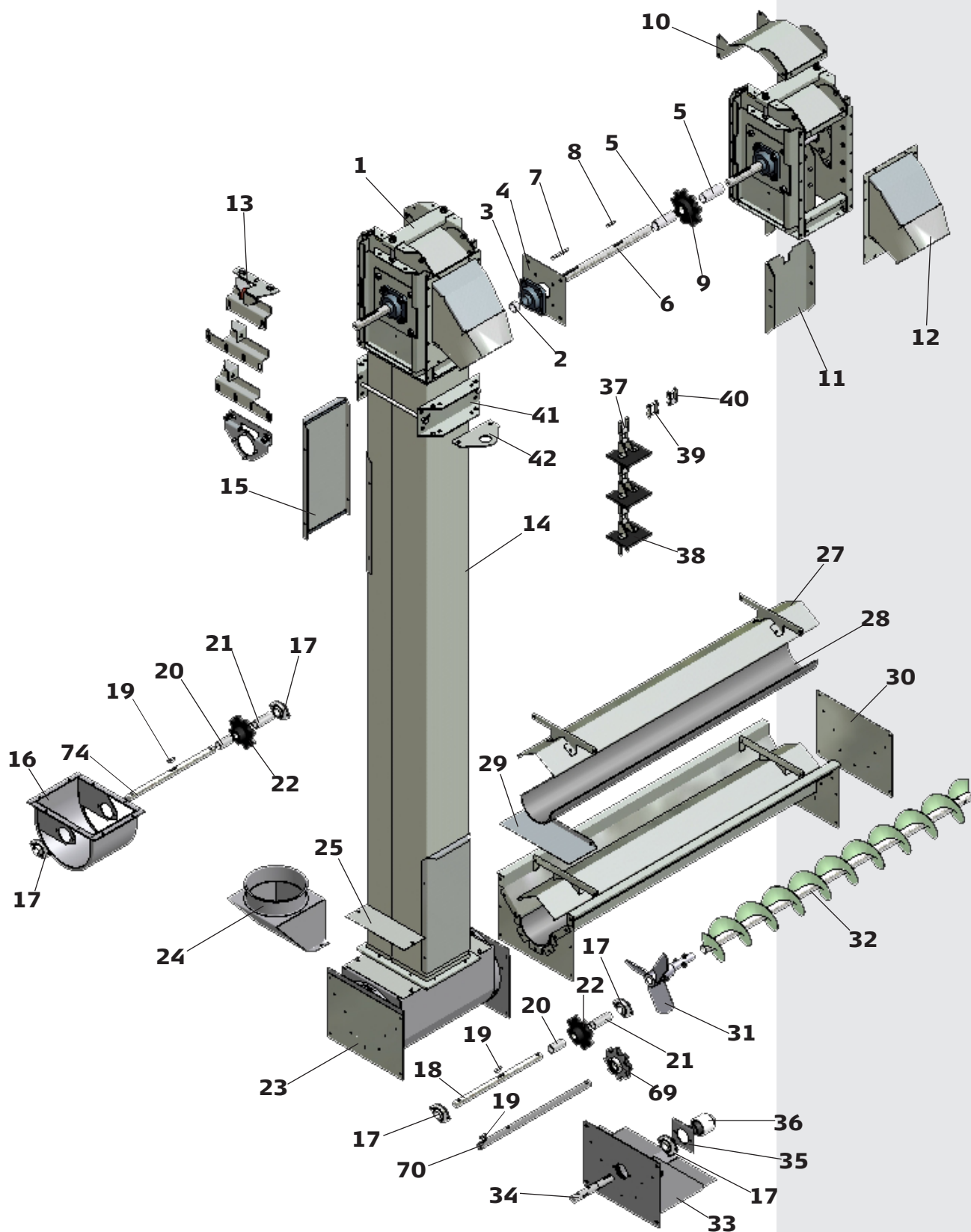
Pos.	T20	T40
A	OK160	Ø200
B	540	565
C	450	440
D	500	500
E	650	650
F	Ø200	Ø200
G	440	440

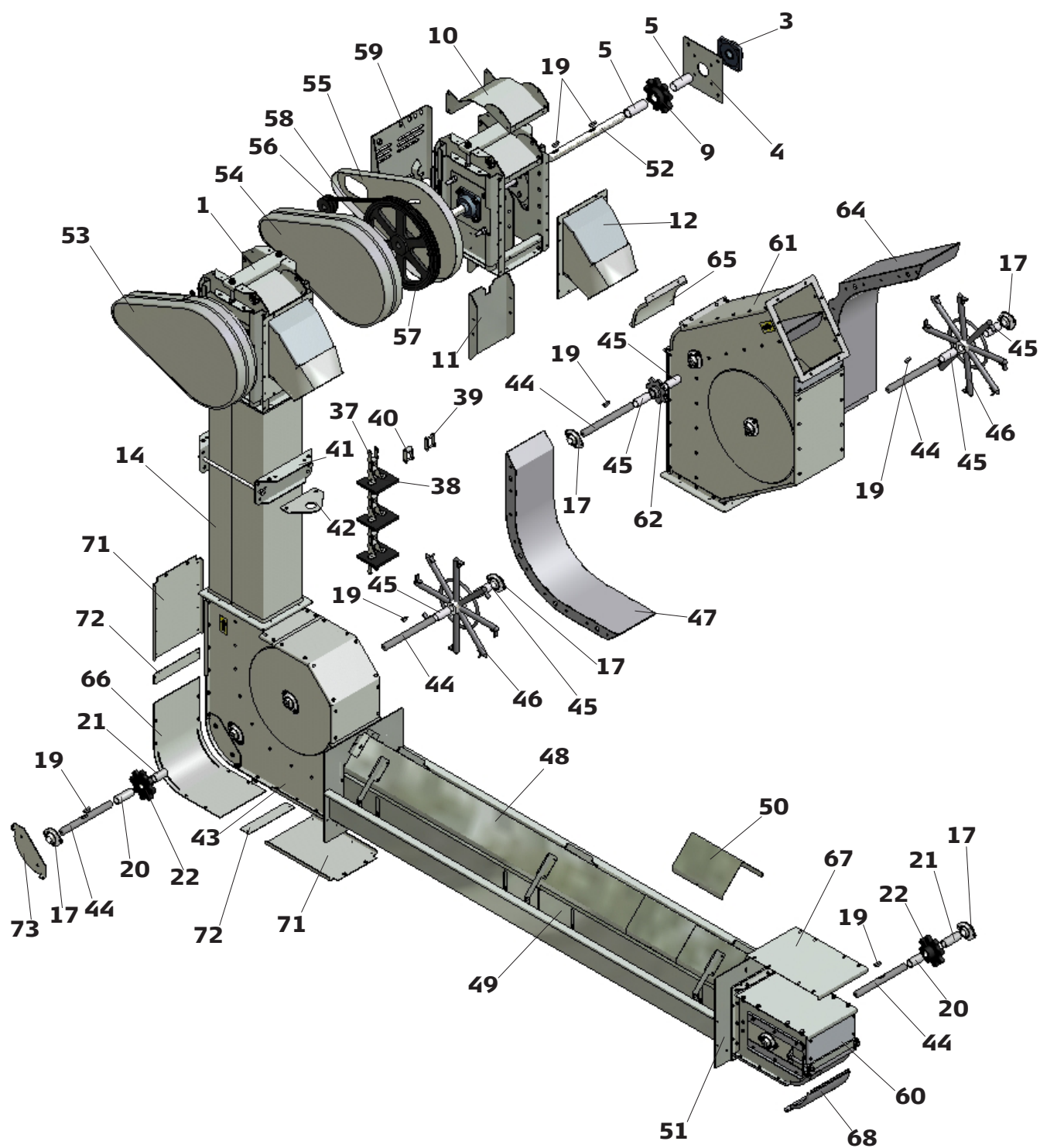
Hopper for elevator



Pos.	Description	T20	Kg.	T40	Kg.
1	Hopper for elevator	00082	35,000	00082	35,000

Parts T20/T40





Parts list T20/T40

Pos.	Description	T20	Kg.	T40	Kg.
1	Drive station without chain for pinion gear motor 2.2-5.5 kW, RHS	51583	36,00	52483	39,00
	Drive station without chain for pinion gear motor 2.2-5.5 kW, LHS	51585	36,00	52485	39,00
	Drive station without chain for pulley drive	51577	36,00	52116	39,00
2	Spacer bush d30 for drive station with pinion gear motor	51581	0,03	51581	0,03
3	Bearing UCF 206, 30 mm	85130	1,20	85130	1,20
4	Bearing plate for elevator head	51066	0,80	51066	0,80
5	Spacer bush for elevator head	20017	0,08	40017	0,13
6	Shaft d30 for elevator head with gear motor	51580	2,00	52120	2,40
7	Feather key 8x7x80 mm	87066	0,04	87066	0,04
8	Feather key 8x7x40 mm	87065	0,07	87065	0,07
9	Sprocket 9 Z for elevator head d30	83026	1,80	83026	1,80
10	Cover plate for elevator head	51564	1,70	52105	2,25
11	Adjustable intermediate plate for elevator head	51570	1,70	52108	2,20
12	Outlet for drive section d150/d200	51576	2,40	52110	2,60
	Outlet for drive section OK160	51571	2,40		
13	Torque arm for gear motor TF90B/TF63B, fitted parallel/crosswise of the extension	81319	5,00	81319	5,00
14	Extension 2.5 m with door, without chain galv.	51012	35,00	52012	37,00
	Extension 2.5 m without chain galv.	51021	35,00	52021	37,00
	Extension 2.0 m without chain galv.	51022	28,00	52022	32,00
	Extension 1.0 m without chain galv	51024	14,00	52024	16,00
	Extension 0.5 m without chain galv	51025	7,00	52025	8,00
	Extension 0.25 m without chain galv	51026	3,00	52026	5,00
	Extension 0.125 m without chain galv	51027	2,00	52027	3,00
15	Inspection cover for extension	20013	1,00	40013	1,40
16	Elevator boot d135 without chain.	51142	7,00	52142	8,00
17	Bearing with flange UCF/PFL 205, 25 mm	85100	0,30	85100	0,30
18	Shaft for elevator boot	40037	1,50	40037	1,50
19	Feather key 8x7x30mm	87079	0,02	87079	0,02
20	Bush for elevator boot, short d26 x 25/d26 x 58	20038	0,02	40038	0,06
21	Bush for elevator boot, long d26 x 48/d26 x 78	20039	0,05	40039	0,08
22	Sprocket wheel, 8 teeth dia. 25	20036	1,10	20036	1,10
23	Flex-elevator boot without chain galv.	51312	20,00	52312	20,70
24	Inlet piece for Flex-elevator boot d160/d200 galv.	51303	2,00	52303	4,00
25	Cover plate for Flex-elevator boot	51314	0,40	52314	0,30
26	Trough 2.0 with cover d135 without auger galv.	51290	26,00	51290	26,00
	Trough 1.25 with cover d135 without auger galv.	51291	17,00	51291	17,00
	Trough 1.0 with cover d135 without auger galv.	51292	14,00	51292	14,00
	Trough 0.5 with cover d135 without auger galv.	51293	8,00	51293	8,00
27	Cover 2.0 m for trough d135 galv.	51387	6,80	51387	6,80
	Cover 1.25 m for trough d135 galv.	51388	4,50	51388	4,50
	Cover 1.0 m for trough d135 galv.	51389	3,50	51389	3,50
	Cover 0.5 m for trough d135 galv.	51390	1,80	51390	1,80
28	PVC 2.0 m for trough d135	91062	3,12	91062	3,12

Pos.	Description	T20	Kg.	T40	Kg.
28	PVC 1.25 m for trough d135	91064	1,95	91064	1,95
	PVC 1.0 m for trough d135	91065	1,56	91065	1,56
	PVC 0.5 m for trough d135	91066	0,78	91066	0,78
29	Cover plate for auger trough at flex boot, galv.	20309	0,60	20309	0,60
30	End plate for auger trough/flex-elevator boot/trough under elevator	20070	1,11	20070	1,11
31	Propeller with pin, RHS d135 mm	20053	2,00	20053	2,00
	Propeller with pin, LHS d135 mm	20041	2,00	20041	2,00
	Propeller with pin and free travel, RHS d135 mm	20054	3,00	20054	3,00
	Propeller with pin and free travel, LHS d135 mm	20042	3,00	20042	3,00
	Propeller without pin, RHS d135 mm	20052	1,00	20052	1,00
	Propeller without pin, LHS d135 mm	20040	1,00	20040	1,00
32	Auger 0.5 m RHS, without trough d135-S125	94036	2,00	94036	2,00
	Auger 0.5 m RHS, without trough d135-S60	94124	2,00	94124	2,00
	Auger 0.5 m RHS without trough d135-S90	94116	2,00	94116	2,00
	Auger 0.5 m LHS without trough d135-S125	94016	2,00	94016	2,00
	Auger 0.5 m LHS without trough d135-S60	94129	2,00	94129	2,00
	Auger 0.5 m LHS without trough d135-S90	94106	2,00	84106	2,00
	Auger 1.0 RHS without trough d135-S125	94035	3,00	94035	3,00
	Auger 1.0 RHS without trough d135-S60	94123	3,00	94123	3,00
	Auger 1.0 m RHS without trough d135-S90	94115	3,00	94115	3,00
	Auger 1.0 m LHS without trough d135-S125	94015	3,00	94015	3,00
	Auger 1.0 m LHS without trough d135-S60	94128	3,00	94128	3,00
	Auger 1.0 m LHS without trough d135-S90	94105	2,00	94105	2,00
	Auger 1.25 m RHS without trough d135-S125	94034	4,00	94034	4,00
	Auger 1.25 m RHS without trough d135-S60	94122	4,00	94122	4,00
	Auger 1.25 m RHS without trough d135-S90	94114	4,00	94114	4,00
	Auger 1.25 m LHS without trough d135-S125	94014	4,00	94014	4,00
	Auger 1.25 m LHS without trough d135-S60	94127	4,00	94127	4,00
	Auger 1.25 m LHS without rough d135-S90	94104	3,00	94104	3,00
	Auger 2.0 m RHS without trough d135-S125	94032	7,00	94032	7,00
	Auger 2.0 m RHS without trough d135-S60	94121	7,00	94121	7,00
	Auger 2.0 m LHS without trough d135-S125	94012	7,00	94012	7,00
	Auger 2.0 m LHS without trough d135-S60	94126	7,00	94126	7,00
	Auger 2.0 m LHS without trough d135-S90	94102	4,00	94102	4,00
	Auger 2.0 m RHS without trough d135-S90	94112	7,00	94112	7,00
33	Console for gear motor, 2.2 kW	20223	16,50	20223	16,50
34	Transfer shaft for console and gear motor	20140	0,75	20140	0,75
35	Reinforcement plate	20181	0,20	20181	0,20
36	Clutch kpl. w28 d25/d25	87184	0,75	87184	0,75
	Plastic part sintex clutch w28	87181	0,80	87181	0,80
	Steel part sintex clutch w28 d25	87182	0,35	87182	0,35
37	Chain runn. m. kpl	20028	2,00	40028	4,00
38	Rubber flap with plate and bolt	20171	0,10	40171	0,19
39	Connector link for straight chain incl.55	87102	0,10	87102	0,10
40	Connector link for offset chain incl.55	87103	0,10	87103	0,10
41	Mounting support	00081	3,00	00081	3,00
42	Hoist hook bracket for mounting support	00083	1,00	00083	1,00

Pos.	Description	T20	Kg.	T40	Kg.
43	Bend 90° with sprocket	51060	37,00	52060	42,50
44	Shaft for tension end / bend	20230	0,70	40230	1,00
45	Spacer bush d30 x 32,5/d30 x 66	44060-6	0,03	40008	0,07
46	Return flow wheel for 45° - 90° bend	83006	5,00	83006	5,00
47	Intermediate section, welded, for 90° bend	51059	7,26	52059	9,26
48	Inlet trough 2.0 m with return channel and inspection door without chain	44014	48,00	45014	52,00
	Inlet trough 1.25 m with return channel without chain	44011	32,00	45011	34,00
	Inlet trough 1.0 m with return channel without chain	44012	24,00	45012	26,00
	Inlet trough 0.5 m with return channel without chain	44013	12,00	45013	13,00
49	Adjustment plate 1.0 m for return flow channel	44173	2,25	44173	2,25
	Adjustment plate 1.25 m for return flow channel	44172	2,80	44172	2,80
	Adjustment plate 0.5 m for return flow channel	44174	1,10	44174	1,10
50	Inspection door for return flow channel	44170	0,85	45070	0,85
51	Transition flange inlet trough/extension	44008	2,00	45008	2,00
52	Shaft for elevator head d30	20016	1,70	40016	2,00
53	Pulley kit 2-grooves d24	52111	18,00	52111	18,00
	Pulley kit 2- grooves d28	52112	20,00	52112	20,00
	Pulley kit 3- grooves d28	52113	25,00	52113	25,00
	Pulley kit 4- grooves d38	52114	28,00	52114	28,00
54	External guard for elevator head	51070	3,20	51070	3,20
55	Internal guard for elevator head	51069	2,00	51069	2,00
56	V-belt sheave A71 2 gr. d24	82081	0,70	82081	0,70
	V-belt sheave A71 2 gr. d28	82113	0,60	82113	0,60
	V-belt sheave A71 3 gr. d28	82177	1,00	82177	1,00
	V-belt sheave A71 4 gr. d38	82179	1,00	82179	1,00
57	V-belt sheave A355 2 gr. d30	82131	8,50	82131	8,50
	V-belt sheave A355 3 gr. d30	82193	10,80	82193	10,80
	V-belt sheave A355 4 gr. d30	82235	15,00	82235	15,00
58	Pulley AX 54 - 1372 mm	84254	0,15	84254	0,15
	Pulley AX 56 - 1452 mm	84256	0,15	84256	0,15
59	Motor stand, large	51068	3,50	51068	3,50
60	Tension section kpl	44095	12,61	45095	13,77
61	Bend 55° with sprocket	51030	35,20	52030	40,00
62	Sprocket 7 Z welded kpl d25	20034	0,73	20034	0,73
64	Middle section welded for 55° bend	51032	8,46	52032	10,77
65	Cover plate for bend 55°	51030-3	0,38	52030-3	0,54
66	Cover plate for bend 90°	51060-6	2,45	52060-6	3,38
67	Cover plate for tension section	44088	1,14	45088	1,53
68	Inspection door for tension section	20005	0,53	40005	0,74
69	Sprocket wheel, 8 teeth with bearing dia. 25	83037	0,75	83037	0,75
70	Shaft for flex-elevator boot with bracket	51315	1,84	52315	1,96
71	Shroud, large for 90° bend	51060-8	1,59	52060-8	2,12
72	Assembling plate for 45-90° bend	51060-9	0,13	52060-9	0,20
73	Wearing plate for 45° bend	52060-7	0,41	52060-7	0,41
74	Shaft for elevator boot	20037	1,20	40037	1,50

When ordering spare parts, please state elevator type (T20/T40) and part no.

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