

# INSTRUCTIONS

## REPAIR PARTS LIST

WF25, WF40, WF60,  
WF80, WF100

### READ ALL DIRECTIONS CAREFULLY BEFORE BEGINNING INSTALLATION

#### ASSEMBLY INSTRUCTIONS

Before attempting assembly, refer to the Parts Diagram on the reverse side.

1. Begin by locating Ref. No. 1, trough base. Insert Ref. No. 2, feed axle into the recess at the center of the trough. Drill four (4) holes through the fiberglass trough base, using the feed axle as a guide and a 1/4-in. drill bit. (NOTE: Masonry type drill bits are preferred for fiberglass because high speed steel bits rapidly become dull).

Remove the axle and clean out any residue. Fasten the plate of the feed axle to the trough with the four (4) flat-head bolts, nuts, and washers provided, Ref. Nos. 23, 21, & 22. **Check that the axle is perpendicular to the trough.**

2. Next place the feed wheel washer, Ref. No. 24 and the feed wheel, Ref. No. 3, on the feed axle. The feed wheel should turn freely on the feed axle. If it does not, check for excess galvanizing residues and remove if necessary.
3. Put the trough divider cage, Ref. No. 4, on the trough and force it over the trough lip as far as possible. Now drill one 5/16-in. hole through the trough, using the trough divider cage as a guide. Insert one of the cage bolts, Ref. No. 25, in the hole with the head to the OUTSIDE of the feed trough. Install a flanged cage nut, Ref. No. 26 and hand tighten. Repeat this procedure for the remaining holes, checking each time that the cage is down as far as possible. Now tighten the bolts by holding the nuts and turning the heads. **DO NOT OVERTIGHTEN THE BOLTS ON THE FIBERGLASS;** tighten only until snug. Overtightening can damage the fiberglass.
4. After the cage is installed, drop the hopper bottom, Ref. No. 5, into place. The step in the hopper sidewall should rest on the upper hoop of the cage.
5. Now install the feed sweep, Ref. No. 16, over the axle and the feed wheel. Slide the sweep down the axle until it just clears the hopper and tighten the set screws, Ref. No. 32. Rotate the wheel to be certain the sweep does not rub. For proper operation, all four arms of the sweep should clear the hopper no more than about 1/8-in. Adjust as necessary.
6. After installing the feed sweep, place a 5/16 x 3-in. bolt with a 5/16-in. washer, Ref. Nos. 33 & 35, into the pre-punched hole in Axle, Ref. No. 2. Secure bolt using another 5/16-in. washer with a 5/16-in. hex nut, Ref. Nos. 35 & 34 (See Figure 3). Tighten nut.

**Note:** The bolt in the axle will allow the feeder to operate with minimal clearance between the Feeder Cone Assembly, Ref. No. 8 and the Feed Sweep, Ref. No. 16, and acts as a lower safety stop during adjustment of the Feeder Cone Assembly.

7. Now slip the axle cover assembly, Ref. No. 7, inside the axle tube as far as possible. Slide the cone assembly, Ref. No. 8, over the axle until the spool settles between the fingers on the cover assembly. Swivel the spool until it is aligned with the adjustor hole in the hopper with the flats toward the adjustor plate. The cone assembly cables have been factory adjusted for equal tension. If they are not of equal tension, remove the cone assembly and adjust the eye-bolts beneath the cone.
8. Fasten the hopper bottom, Ref. No. 5, to the cage, Ref. No. 4 (See Figure 2) using the four tie-downs, Ref. No. 31. Locate each tie-down directly above a cage upright. The leg of each tie-down should grip the upper lip of the cage. Space the tie-downs from one another around the hopper at 90 degrees by skipping two uprights between each tie-down. Use (4) 1/4-in bolts, Ref. No. 27, with rubber backed washers, Ref. No. 28, with the rubber against the fiberglass, under the bolt heads inside the hopper. Use a lock-washer, Ref. No. 30, and a nut, Ref. No. 29 on the outside.
9. Bolt together shell - with cone adjust holes, Ref. No. 12, using 2 bolts, flat washers, lock washers, and nuts, Ref. No. 40, 37, 39, & 38. Be sure to leave the bolts as loose as possible.
10. Lift the shell onto the hopper bottom. The 1-3/8-in hole or notch in the side of the hopper top should align with the one in the hopper bottom. Gradually work the edge of the hopper top over the hopper bottom until the entire lip is started. Again, check to see that the holes are aligned and push the top down until the first corrugation is just above the hopper bottom. If everything is done properly, you should now be able to slide the long end of the cone adjust bracket, Ref. No. 11, into the aligned holes. Turn the bracket so the small holes line up with the holes in the sheet metal.



# Wheel Feeder

## Assembly Diagram and Parts List

Figure 1

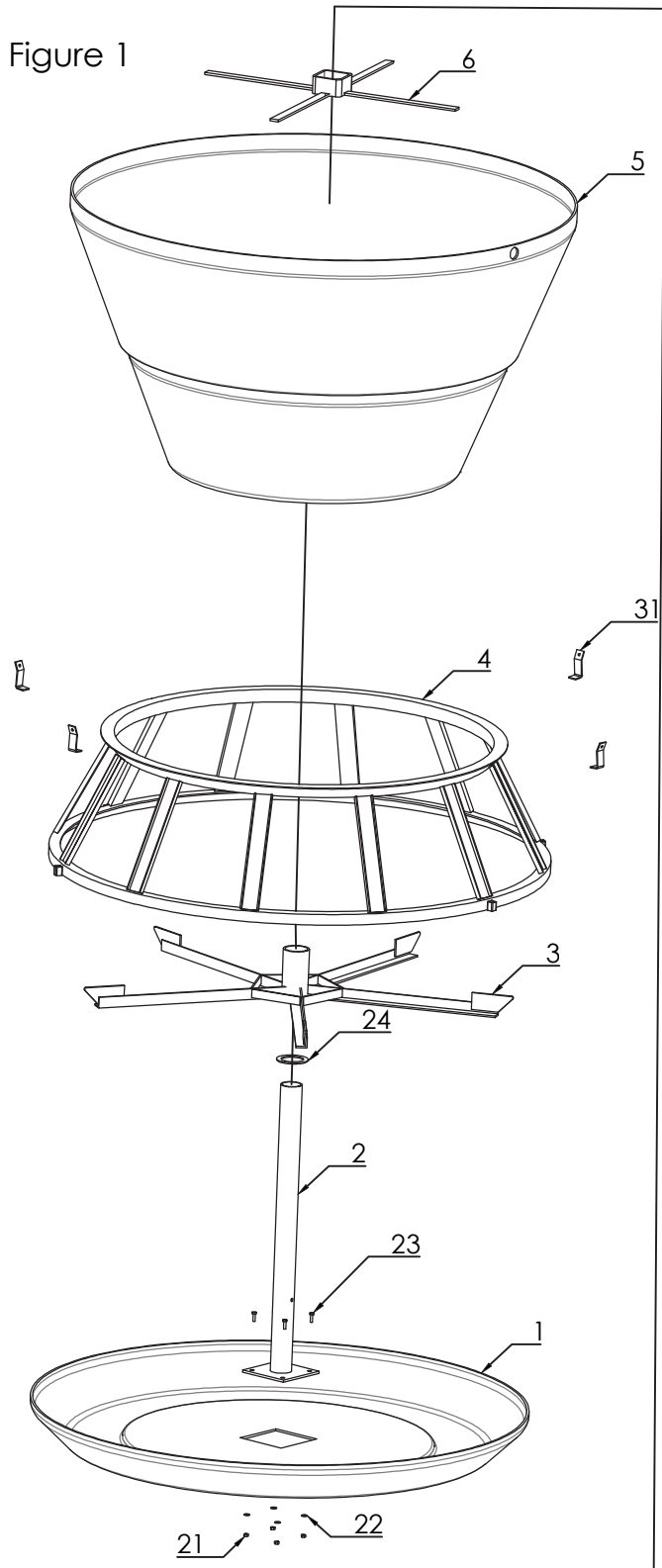
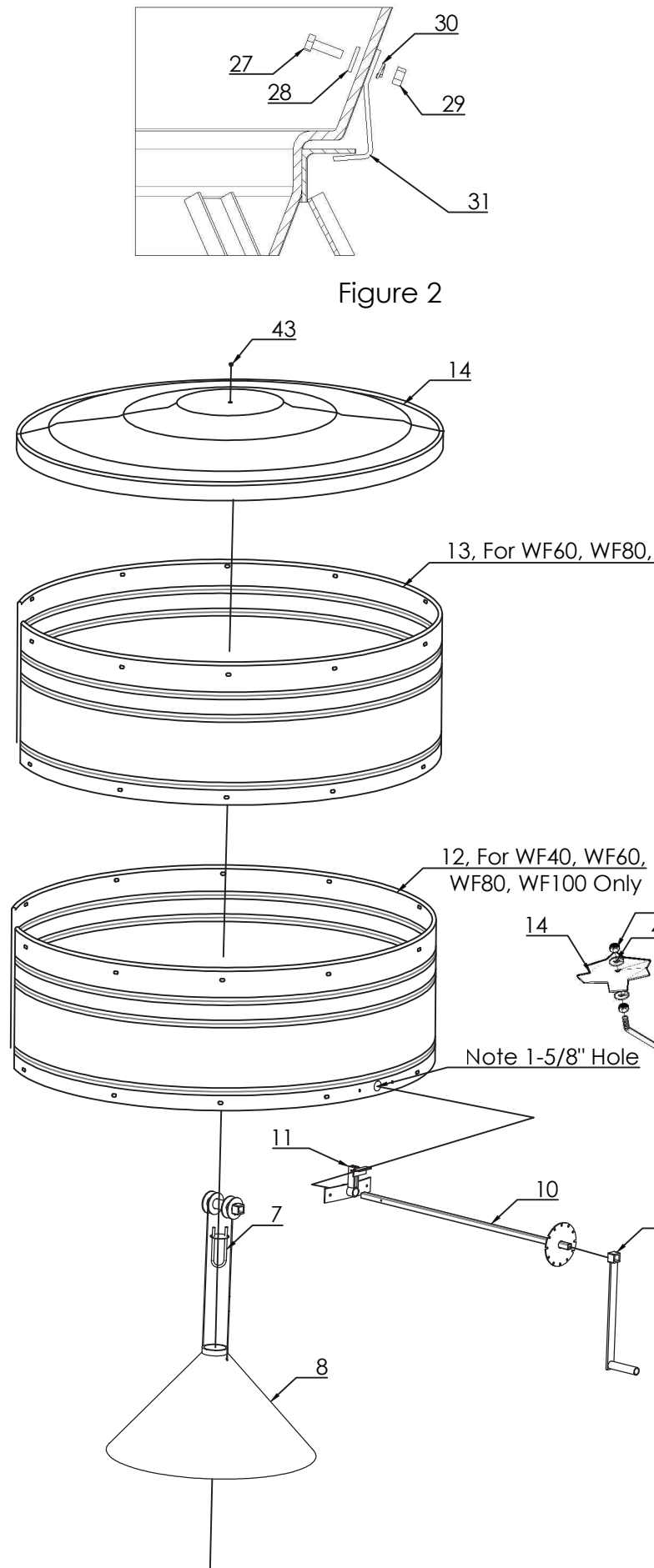


Figure 2



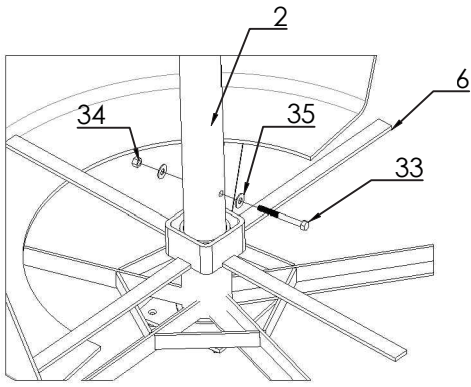


Figure 3

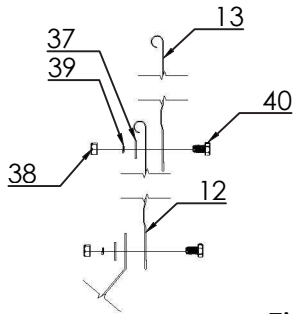


Figure 4

WF100 Only

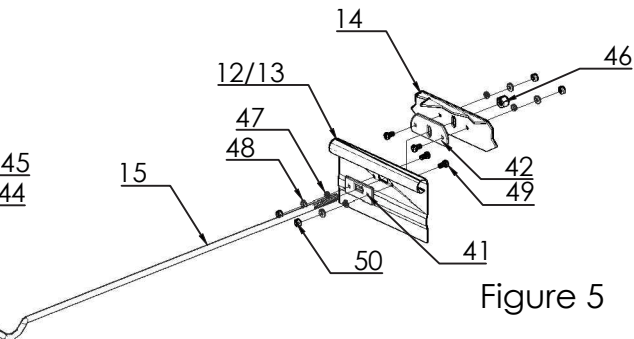


Figure 5

45  
44

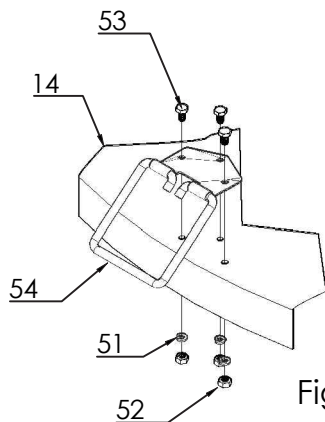


Figure 6

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Ref. No.	Item Number	Description	Qty				
			WF25	WF40	WF60	WF80	WF100
<b>Individual Parts</b>							
1	KF-010003	Trough, Fiberglass	1	1	1	1	1
2	KF-010008	Axle	1	1	1	1	1
3	KF-010006	Feed Wheel	1	1	1	1	1
4	KF-010005	Trough Divider Cage	1	1	1	1	1
5	KF-010001	Hopper Bottom, Fiberglass	1	1	1	1	1
6	KF-010007	Feed Sweep	1	1	1	1	1
7	KF-010020	Axle Cover Assembly	1	1	1	1	1
8	KF-010004	Cone Assembly	1	1	1	1	1
9	KF-010011	Cone Adjust Handle	1	1	1	1	1
10	KF-010009	Cone Adjust Rod	1	1	1	1	1
11	KF-010010	Cone Adjust Bracket	1	1	1	1	1
12	F60G94	Shell - With Cone Adjust Holes	0	1	1	1	1
13	F60G95	Shell - W/O Cone Adjust Holes	0	0	1	2	3
14	F60B12	Wheel Feeder Cover	1	1	1	1	1
15	F60B26	Cover Rods	2	2	2	2	2
16	988-1014	Step Side Rail	0	0	2	2	2
17	F60G96	Step Rung, 14-1/2" C2C	0	0	1	1	1
18	F60G97	Reinforcement Plate	0	0	1	1	1
19	988-1013	Ladder Side Rail	0	0	0	2	4
20	F60G83	Ladder Rung, 16" C2C	0	0	0	3	6
<b>KF-010016 Wheel Feeder Base Hardware Bag</b>			<b>1</b>	<b>1</b>	<b>1</b>	<b>1</b>	<b>1</b>
21	RFN-1101	Nut, 1/4" Hex SS	4	4	4	4	4
22	RFW-1201	Washer, 1/4" Flat SS	4	4	4	4	4
23	RFB-1351	Bolt, 1/4" x 7/8" HHCS	4	4	4	4	4
24	RFW-9700	Feeder Wheel Washer, 2-1/2" Flat	1	1	1	1	1
25	RFB-2050	Bolt, 5/16" x 7/8" HHCS	12	12	12	12	12
26	RFN-2300	Nut, 5/16" Hex Flange	12	12	12	12	12
27	RFB-1400	Bolt, 1/4" x 1" HHCS	6	6	6	6	6
28	RFW-3150	Washer, Neoprene Backed 3/8"	6	6	6	6	6
29	RFN-1100	Nut, 1/4" Hex	6	6	6	6	6
30	RFW-1300	Washer, 1/4" Lock	6	6	6	6	6
31	SF-010064	Hopper Tiedown Brackets	4	4	4	4	4
32	RFB-1100	Bolt, 1/4"-28 x 1/2" HHCS	2	2	2	2	2
33	RFB-2300	Bolt, 5/16" x 3" Hex	1	1	1	1	1
34	RFN-2100	Nut, 5/16" Hex	1	1	1	1	1
35	RFW-2000	Washer, 5/16" Flat	2	2	2	2	2
36	RFN-1300	Nut, 1/4" Hex Flange	2	2	2	2	2
<b>WFS-HDWE Wheel Feeder Shell Hardware Bag</b>			<b>0</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>
37	OF120	Washer, 5/16" ID x 3/4" OD, Zn	0	34	68	102	136
38	OF55	Nut, 1/4-20 Hex Nut, Zn	0	17	34	51	68
39	OF113	Washer, 1/4" Lock, Zn	0	17	34	51	68
40	OF408	Bolt, 1/4"-20 x 1" Hex, GR5, Zn	0	17	34	51	68
<b>WFC-HDWE Wheel Feeder Cover Hardware Bag</b>			<b>1</b>	<b>1</b>	<b>1</b>	<b>1</b>	<b>1</b>
41	F60B39	Shell Reinforcing Plate	2	2	2	2	2
42	M60A32	Cover Rod Reinforcing Plate	2	2	2	2	2
43	85F30	D3161 Hole Plug	1	1	1	1	1
44	OF128	Washer, 3/8" Flat, Zn	4	4	4	4	4
45	OF167	Nut, 3/8"-16 Hex, Zn	4	4	4	4	4
46	OF458	Nut, 3/8"-16 Nylock Hex, Zn	2	2	2	2	2
47	OF118	Washer, 3/16" Flat, Zn	8	8	8	8	8
48	OF112	Washer, 3/16" Lock, Zn	8	8	8	8	8
49	OF214	Screw, 10-24 x 1/2" Slotted Round, Zn	8	8	8	8	8
50	OF53	Nut, 10-14 Hex, Zn	8	8	8	8	8
51	OF113	Washer, 1/4" Lock, Zn	3	3	3	3	3
52	OF55	Nut, 1/4"-20 Hex, Zn	3	3	3	3	3
53	OF143	Bolt, 1/4"-20 x 1/2" Hex, Zn	3	3	3	3	3
54	F60C85	Handle	1	1	1	1	1
55	F60C84	Cover Latch	1	1	1	1	1
56	OF22	Bolt, 5/16"-18 x 1" Phillips Truss, Zn	1	1	1	1	1
57	OF120	Washer, 5/16" Flat, Zn	1	1	1	1	1
58	OF114	Washer, 5/16" Lock, Zn	1	1	1	1	1
59	OF59	Nut, 5/16"-18 Hex, Zn	1	1	1	1	1
ISHWF Installation Guide			1	1	1	1	1
<b>Step and Ladder Hardware in separate bag within WFC-HDWE</b>							
60	907-9050	Bolt, 5/16"-18 x 1-3/4" Carriage, Zn	14	14	14	14	14
61	OF59	Nut, 5/16"-18 Hex, Zn	14	14	14	14	14
62	OF114	Washer, 5/16" Lock, Zn	14	14	14	14	14
63	OF181	Bolt, 1/4"-20 x 1-1/2" Hex, Zn	8	8	8	8	8
64	OF113	Washer, 1/4" Lock, Zn	8	8	8	8	8
65	OF55	Nut, 1/4"-20 Hex, Zn	8	8	8	8	8
66	OF120	Washer, 5/16" Flat, Zn	22	22	22	22	22

