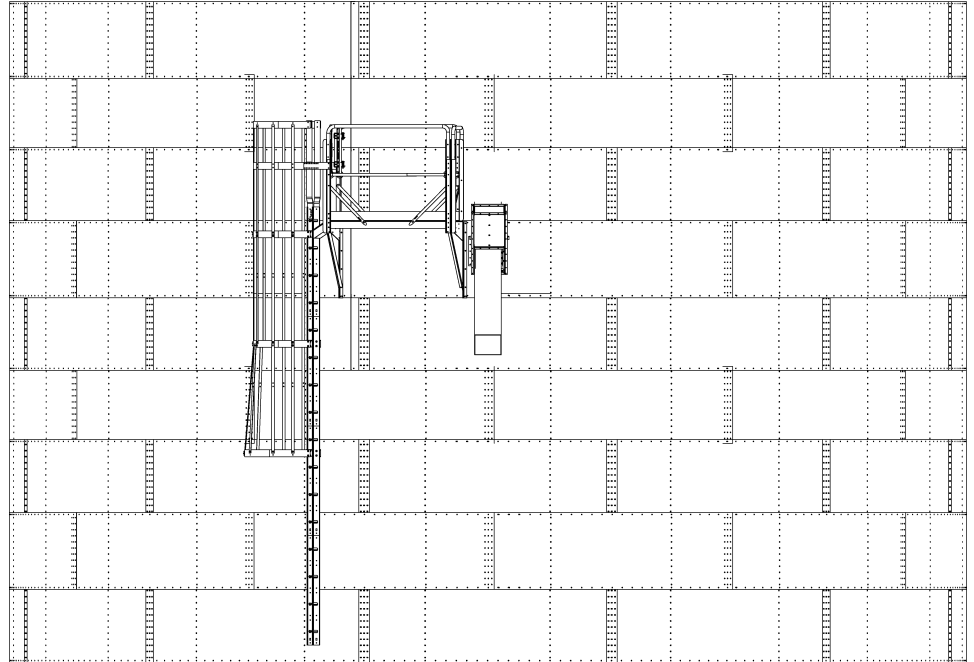




“X” Series Ladder, Cage, Platform

Assembly Instructions

PNEG-1773

Date: 11-15-10

GSI GROUP



PNEG-1773

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1. Introduction

READ THIS MANUAL carefully to learn how to properly use and install equipment. Failure to do so could result in personal injury or equipment damage.

INSPECT the shipment immediately upon arrival. The customer is responsible for ensuring that all quantities are correct. The customer should report and note any damage or shortage on the bill of lading to justify their claim to the transport company.

THIS MANUAL SHOULD BE CONSIDERED a permanent part of your equipment and should be easily accessible when needed.

This warranty provides you the assurance that the company will back its products when defects appear within the warranty period. In some circumstances, the company also provides field improvements, often without charge to the customer, even if the product is out of warranty. Should the equipment be abused, or modified to change its performance beyond the factory specifications, the warranty will become void and field improvements may be denied.

Safety Guidelines

This manual contains information that is important for you, the owner/operator, to know and understand. This information relates to protecting **personal safety** and **preventing equipment problems**. It is the responsibility of the owner/operator to inform anyone operating or working in the area of this equipment of these safety guidelines. To help you recognize this information, we use the symbols that are defined below. Please read the manual and pay attention to these sections. Failure to read this manual and its safety instructions is a misuse of the equipment and may lead to serious injury or death.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



DANGER indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.



CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.



NOTE indicates information about the equipment that you should pay special attention.

General Safety Statement

Our foremost concern is your safety and the safety of others associated with this equipment. This manual is to help you understand safe operating procedures and some problems which may be encountered by the operator and other personnel.

As owner and/or operator, you are responsible to know what requirements, hazards and precautions exist and inform all personnel associated with the equipment or in the area. Safety precautions may be required from the personnel. Avoid any alterations to the equipment, which may produce a very dangerous situation, where **SERIOUS INJURY** or **DEATH** may occur.

You should consider the location of the bin site relative to power line locations or electrical transmission equipment. Contact your local power company to review your installation plan or for information concerning required equipment clearance. Clearance of portable equipment that may be taken to the bin site should also be reviewed and considered. Any electrical control equipment in contact with the bin should be properly grounded and installed in accordance with National Electric Code provisions and other local or national codes.

This product is intended for the use of grain storage only. Any other use is a misuse of the product.



This product has sharp edges, which may cause serious injury. To avoid injury, handle sharp edges with caution and always use proper protective clothing and equipment.

Sidewall bundles or sheets must be stored in a safe manner. The safest method of storing sidewall bundles is laying horizontally with the arch of the sheet upward, like a dome. Sidewall sheets stored on edge must be secured so that they cannot fall over and cause injury. Use care when handling and moving sidewall bundles.

Personnel operating or working around equipment should read this manual. This manual must be delivered with equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

Safety Instructions

Our foremost concern is your safety and the safety of others associated with this equipment. We want to keep you as a customer. This manual is to help you understand safe operating procedures and some problems which may be encountered by the operator and other personnel.

As owner and/or operator, it is your responsibility to know what requirements, hazards and precautions exist, and to inform all personnel associated with the equipment or in the area. Safety precautions may be required from the personnel. Avoid any alterations to the equipment. Such alterations may produce a very dangerous situation where **SERIOUS INJURY** or **DEATH** may occur.

This equipment shall be installed in accordance with the current installation codes and applicable regulations which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.

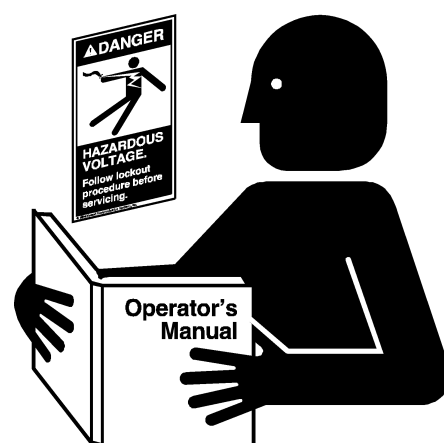
Follow Safety Instructions

Carefully read all safety messages in this manual and safety signs on your machine. Keep signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from the manufacturer.

Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.

Keep your machinery in proper working condition. Unauthorized modifications to the machine may impair the function and/or safety and affect machine life.

If you do not understand any part of this manual or need assistance, contact your dealer.



Read and Understand Manual

Practice Safe Maintenance

Understand service procedures before doing work. Keep area clean and dry.

Never lubricate, service, or adjust machine while it is in operation. Keep hands, feet and clothing away from rotating parts.

Keep all parts in good condition and properly installed. Fix damage immediately. Replace worn or broken parts. Remove any built up grease oil and debris.



Maintain Equipment and Work Area

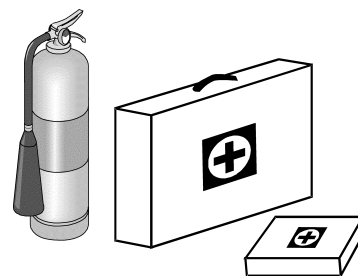
2. Safety

Prepare for Emergencies

Be prepared if fire starts.

Keep a first aid kit and fire extinguisher handy.

Keep emergency numbers for doctors, ambulance service, hospital and fire department near your telephone.



**Keep Emergency Equipment
Quickly Accessible**

Wear Protective Clothing

Wear close fitting clothing and safety equipment appropriate to the job.

Remove all jewelry.

Long hair should be tied up and back.

Safety glasses should be worn at all times to protect eyes from debris.

Wear gloves to protect your hands from sharp edges on plastic or steel parts.

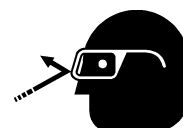
Wear steel toe boots to help protect your feet from falling debris. Tuck in any loose or dangling shoe strings.

A respirator may be needed to prevent breathing potentially toxic fumes and dust.

Wear hard hat to help protect your head.

Wear appropriate fall protection equipment when working at elevations greater than six feet (6').

Eye Protection



Gloves



Steel Toe Boots



Respirator



Hard Hat



Fall Protection



Safety Sign-Off Sheet

As a requirement of O.S.H.A., it is necessary for the employer to train the employee in the safe operating and safety procedures for this equipment. This sign-off sheet is provided for your convenience and personal record keeping. All unqualified persons are to stay out of the work area at all times. It is strongly recommended that another qualified person who knows the shut down procedure be in the area in the event of an emergency.

[illegible]

Proper Storage of Grain Bin/Silo Materials Prior to Construction

Wet storage stain (rust) will develop when closely packed bundles of galvanized material, such as sidewall and roof sheets, have moisture present. Inspect roof and sidewall bundles on arrival for any moisture. If moisture is present, it must not be allowed to remain between the sheets. Separate the sheets or panels immediately and wipe them down. Spray with a light oil or diesel fuel.

If possible, sidewall bundles, roof sheets and other closely packed galvanized materials should be stored in a dry, climate controlled building. If outdoor storage is unavoidable, the materials should be stored so that they are raised above the ground and vegetation. Any stacking and spacing materials should not be corrosive or wet. Be sure to protect materials from the weather, but permit air movement around the bundles if possible.

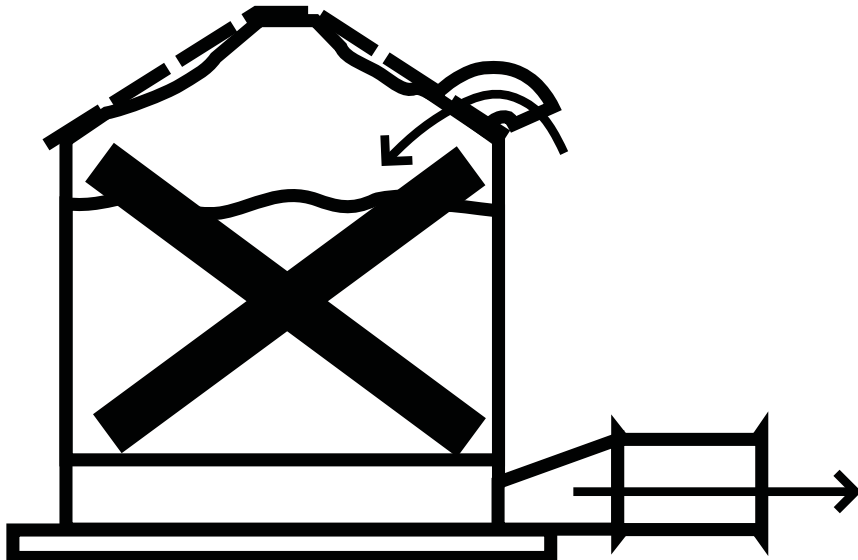
Storing roof bundles and sidewall sheets at a slight incline can also help minimize the presence of moisture. Storing the bundles with the center of the dome up (like an arch) is one option for minimizing moisture during storage. Sidewall bundles can also be stored on edge but must be secured so that they do not fall over and cause injury.

If “white rust” or “wet storage stain” occurs, contact the manufacturer immediately about ways to minimize the adverse effect upon the galvanized coating.

The manufacturer does not warrant any roof damage caused by excessive vacuum or internal pressure from fans or other air moving systems. Adequate ventilation and/or “makeup air” devices should be provided for all powered air handling systems. The manufacturer does not recommend the use of downward flow systems (suction). Severe roof damage can result from any blockage of air passages. Running fans during high humidity/cold weather conditions can cause air exhaust or intake ports to freeze.



CAUTION!



Excessive vacuum (or pressure) may damage roof. Use positive aeration system. Make sure all roof vents are open and unobstructed. Start roof fans when supply fans are started. Do not operate when conditions exist that may cause roof vent icing.

DC-969

3. Decals

ATTENTION: The decal shown below should be present on the outside of the door cover of the 2 ring, 24" porthole door cover and the roof manway cover. If a decal has been damaged or is missing in any of these locations, contact the manufacturer for a free replacement decal.

GSI Decals

1004 E. Illinois St.
Assumption, IL. 62510
Phone: 1-217-226-4421



DANGER



Rotating flighting will kill or dismember.



Flowing material will trap and suffocate.



Crusted material will collapse and suffocate.

Keep clear of all augers. DO NOT ENTER this bin!

If you must enter the bin:

- 1. Shut off and lock out all power.**
- 2. Use a safety harness and safety line.**
- 3. Station another person outside the bin.**
- 4. Avoid the center of the bin.**
- 5. Wear proper breathing equipment or respirator.**

Failure to heed these warnings will result in serious injury or death.

DC-GBC-1A

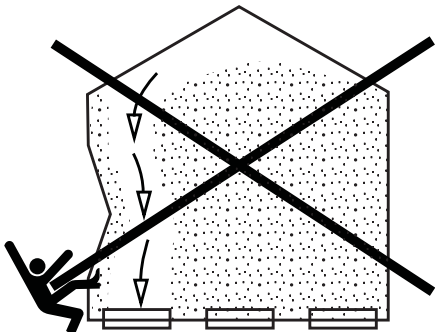
ATTENTION: The decal shown below should be present on the outside of the door cover of the 2 ring, 24" porthole door cover and the roof manway cover. If a decal has been damaged or is missing in any of these locations, contact the manufacturer for a free replacement decal.

GSI Decals

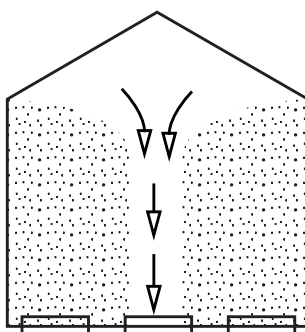
1004 E. Illinois St.
Assumption, IL. 62510
Phone: 1-217-226-4421



WARNING



DON'T



DO

UNLOADING INSTRUCTIONS:

1. Use **CENTER FLOOR OUTLET ONLY** until **NO** grain remains above this outlet.
2. Side floor outlets to be used **ONLY** when above condition is satisfied.
3. Lock all side floor outlets to avoid accidental premature use.
4. See manufacturers instructions for proper use of factory supplied sidedraw (wall) discharge systems.

**Failure to heed these warnings
could result in serious injury, death,
structural damage or collapse of tank.**

DC-GBC-2A

72'-135' Ladder Eave Platform Assembly (LDR-5193)

Ladder Eave Platform Package

1. [Figure 4A](#) shows the assembly of the platform supports. Use 5/16" hardware at all the connection points. (Platform floor will have to be attached at the same time as support angles.)

NOTE: When installing the top wind ring, do NOT use the top set of holes in the stiffener.

2. [Figure 4A](#) shows the assembly of the platform floor system. This must all be assembled at the same time using 5/16" hardware.

NOTE: Leave all hardware loose until completely assembled.

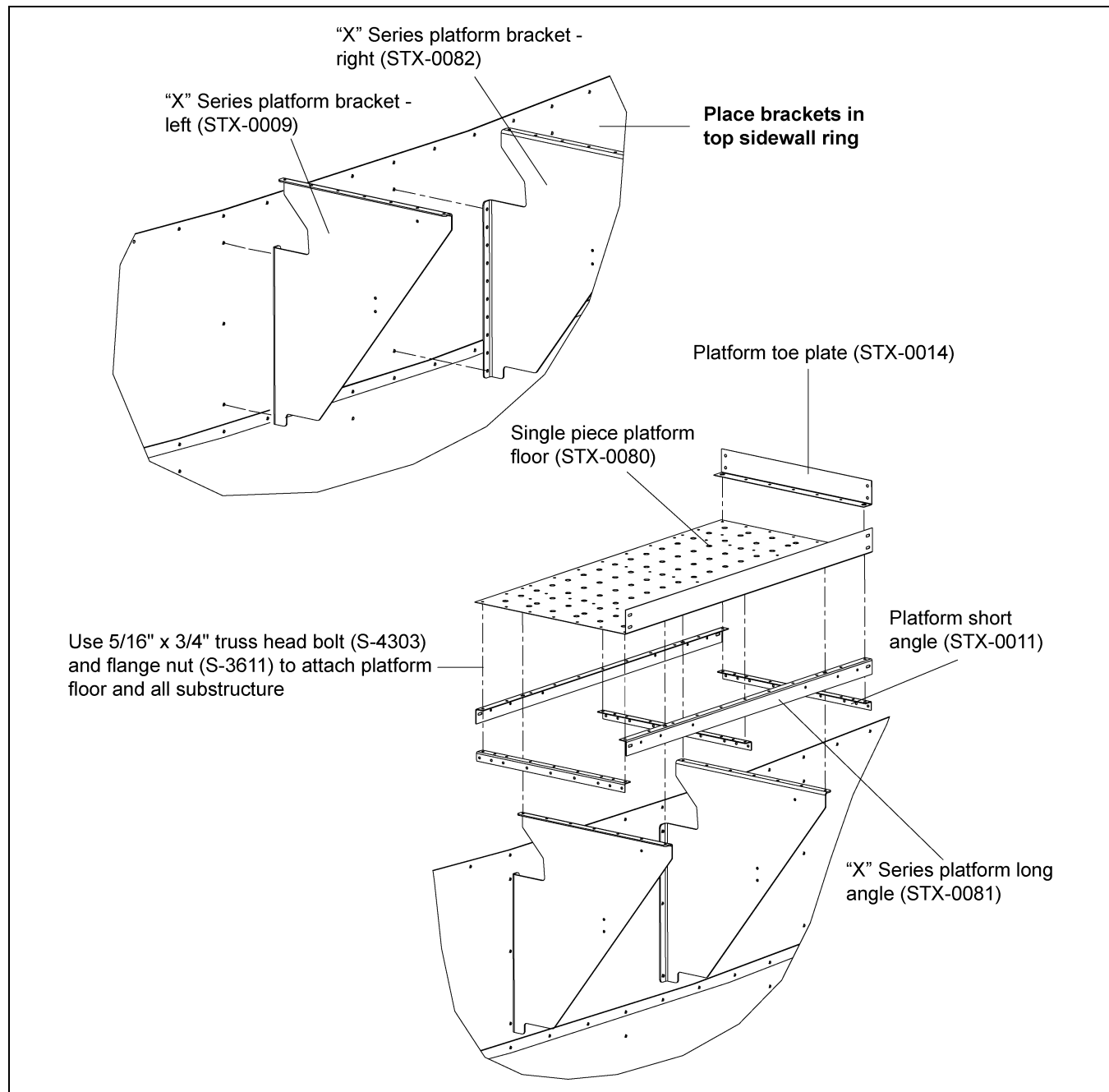


Figure 4A

Platform and Safety Cage Bar

3. [Figure 4B](#) shows the assembly of the platform post and post supports. This must all be assembled at the same time using 5/16" hardware.

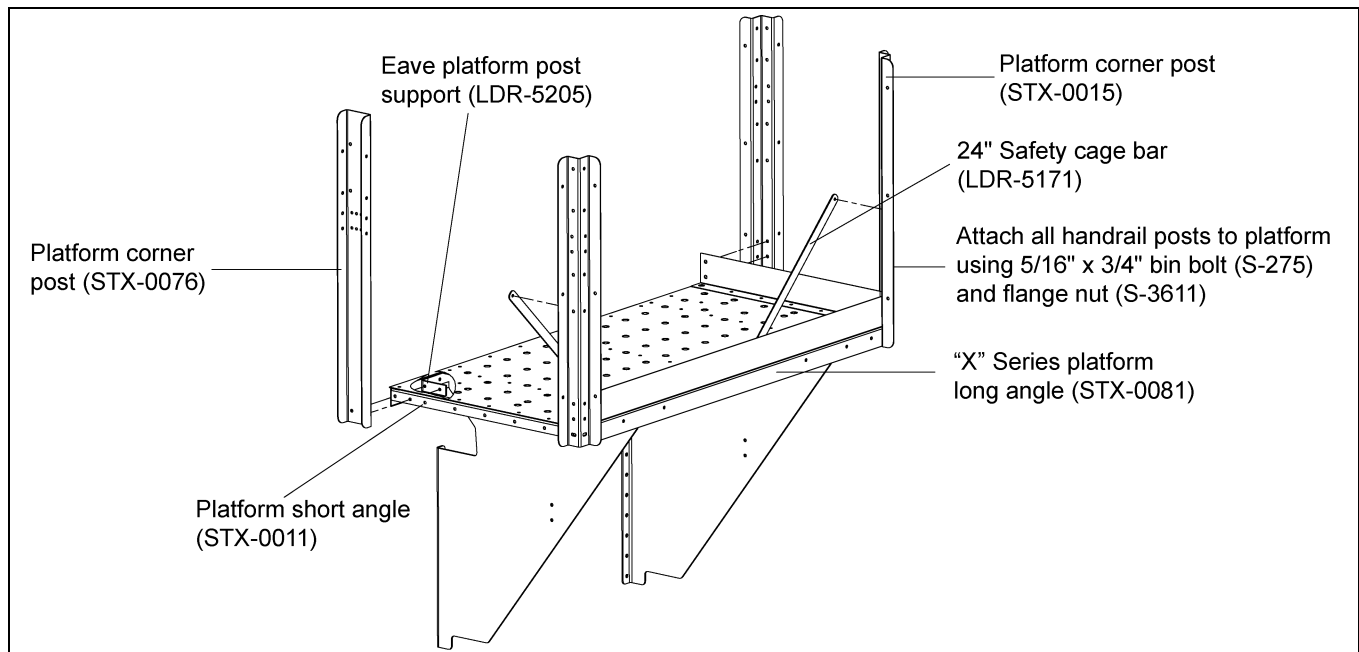


Figure 4B

Platform and Wall Brace

4. Assemble the eave platform wall braces to the platform support and sidewall using 5/16" hardware.
(See [Figure 4C](#).)

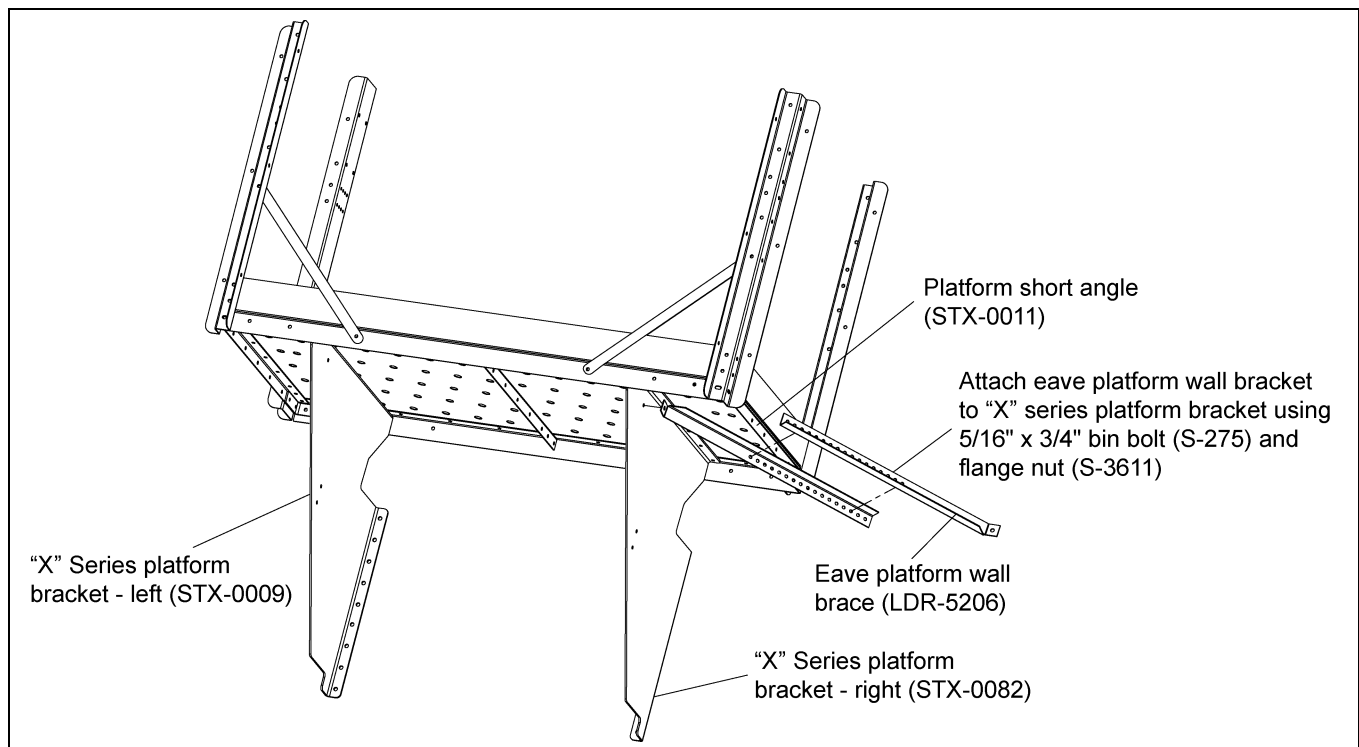


Figure 4C

4. Assembly Instructions

Platform and Handrail Package

5. [Figure 4D](#) shows the assembly of the platform handrails. These must also be attached using 5/16" hardware.

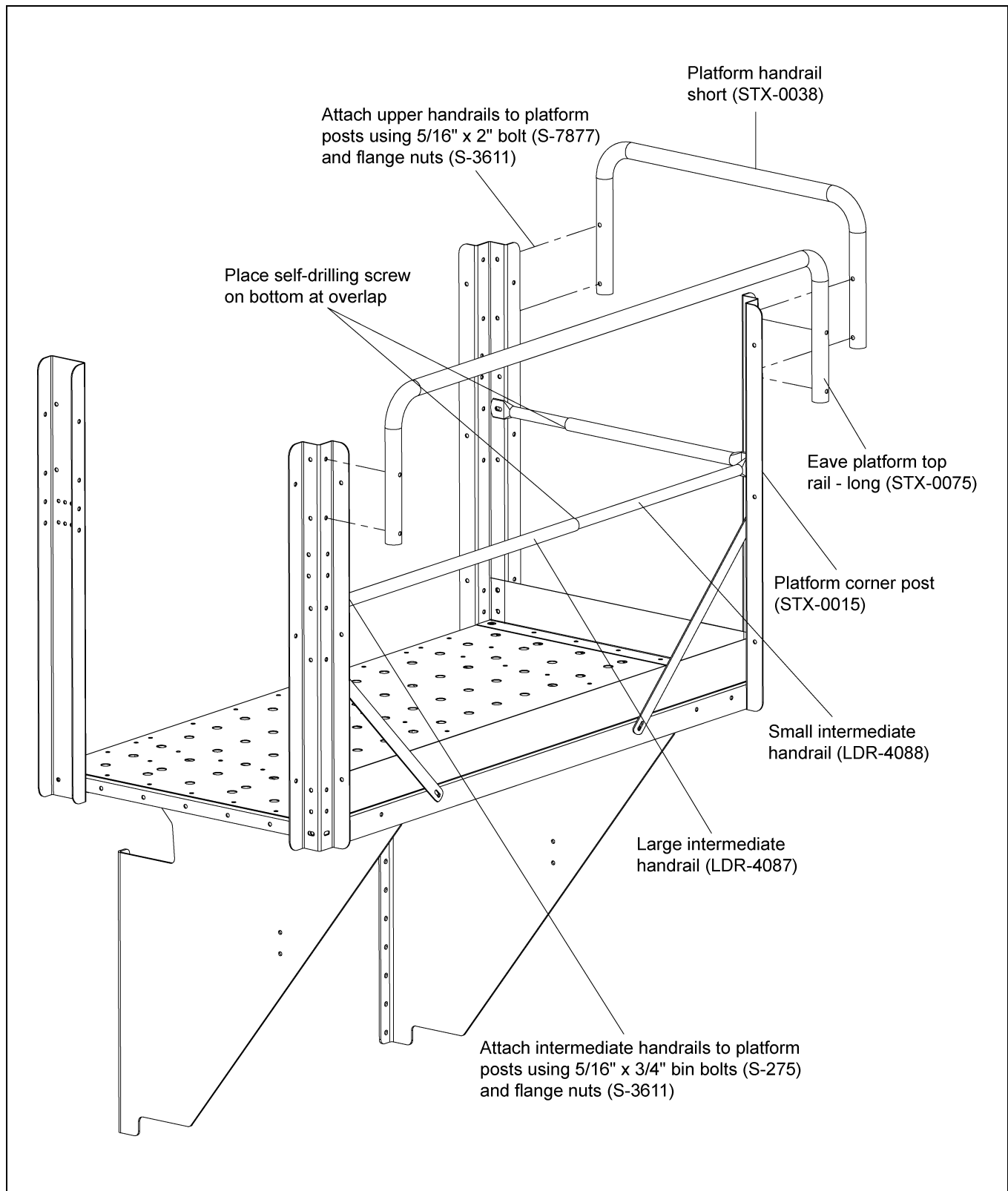


Figure 4D

Platform and Swing Gate Package

6. Attach the platform gate bracket to the gate before attaching it to the inside platform post using 5/16" hardware. (See Figure 4E.)

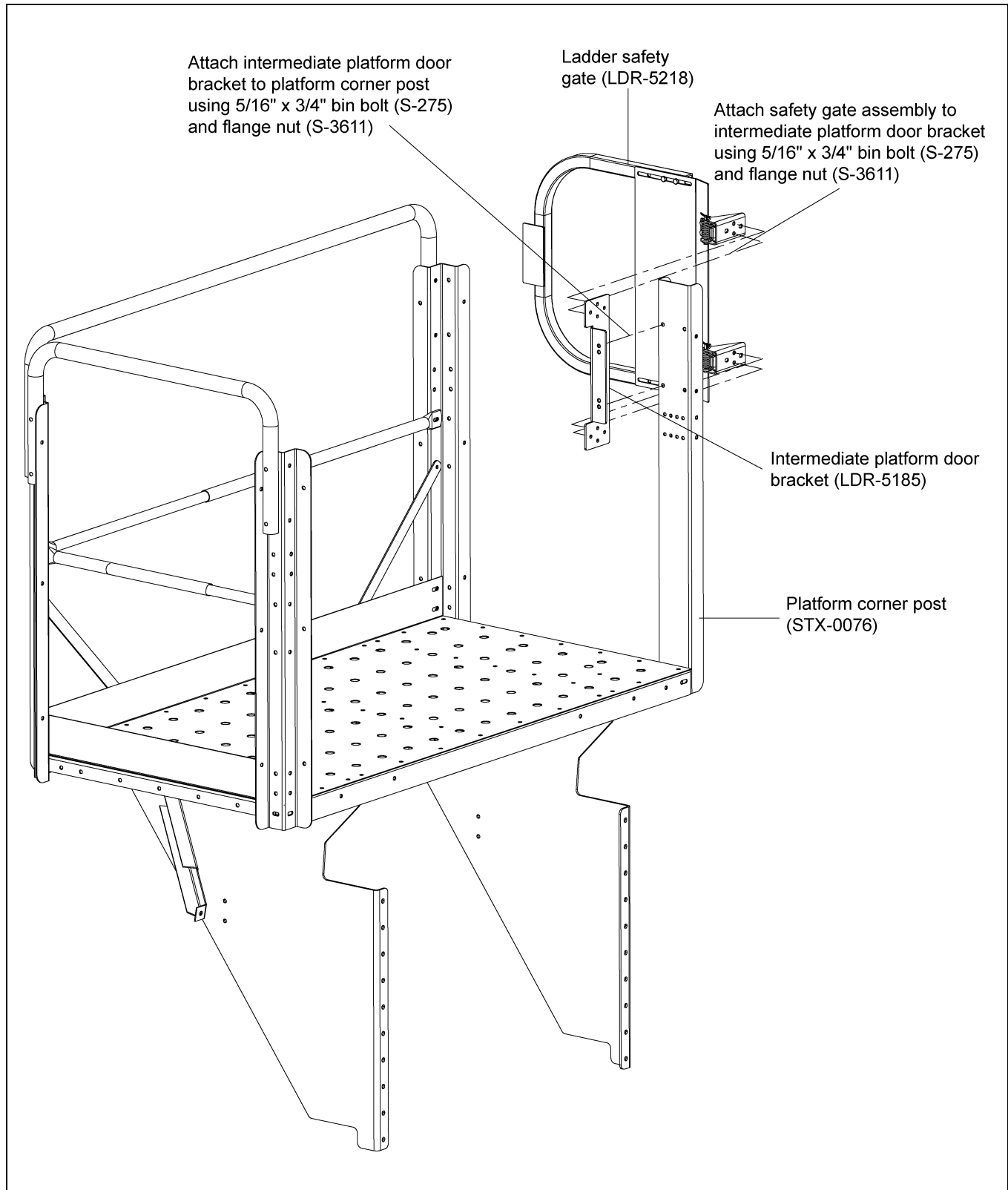


Figure 4E

4. Assembly Instructions

Platform Ladder Bracket Package - Left Hand Side Assembly

7. Attach the wall angle to the sidewall sheet using the hole 9-3/8" from the stiffener hole pattern with 3/8" hardware. Assemble the wall bracket to the wall angle with 3/8" hardware and tighten.

(See Figure 4F.)

Attach left and right intermediate platform ladder bracket to the wall bracket and platform support with 5/16" hardware.

NOTE: Do not force the wall bracket in or out.

Assemble the ladder and ladder brackets to the wall bracket using 5/16" hardware. The top ladder rung must be level with the platform floor.

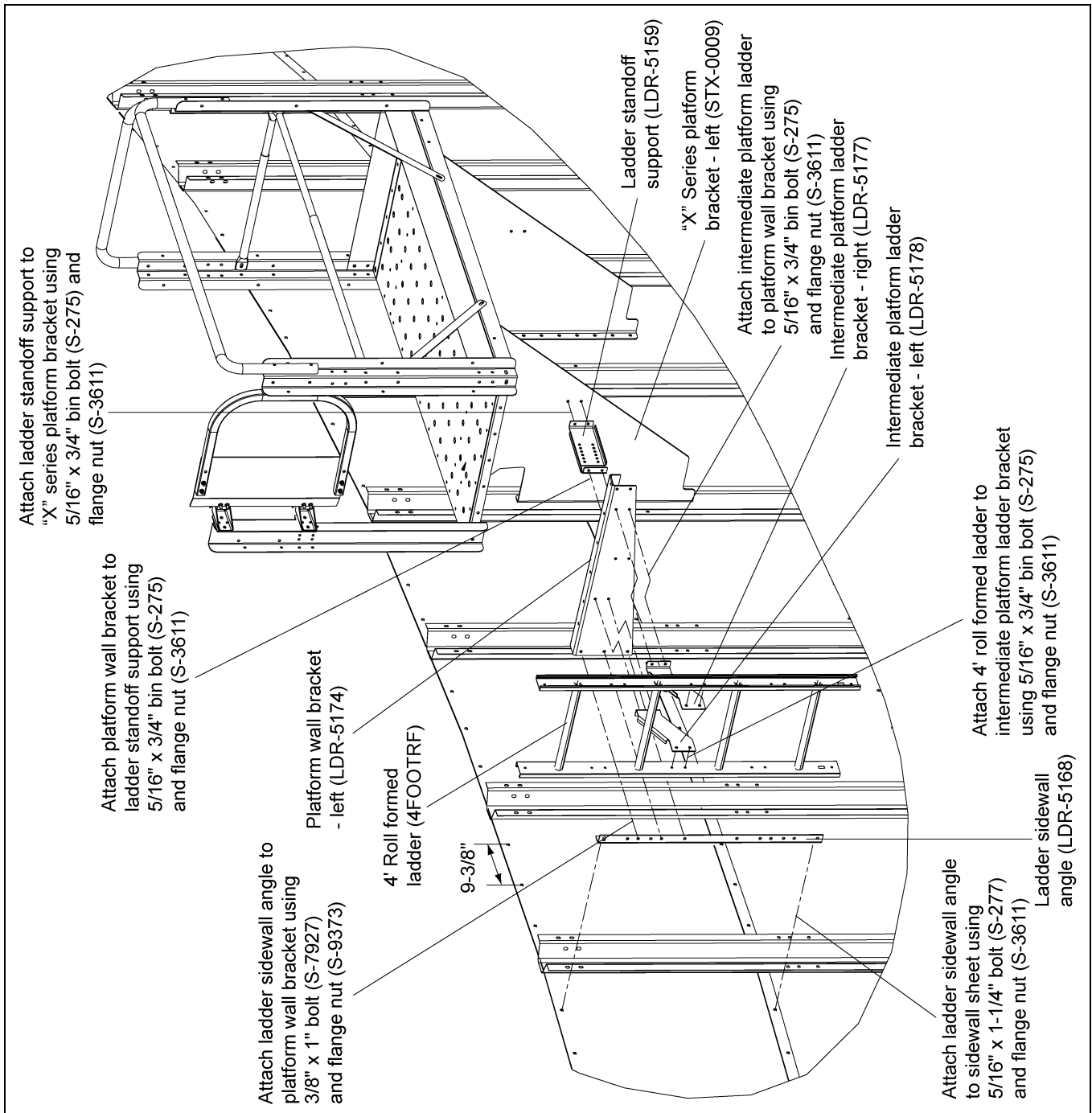


Figure 4F

Platform Ladder Bracket Package - Right Hand Side Assembly

8. Attach the wall angle to the sidewall sheet using the hole 9-3/8" from the stiffener hole pattern with 3/8" hardware. Assemble the wall bracket to the wall angle with 3/8" hardware and tighten.

(See Figure 4G.)

Attach left and right intermediate platform ladder bracket to the wall bracket and platform support with 5/16" hardware.

NOTE: Do not force the wall bracket in or out.

Assemble the ladder and ladder brackets to the wall bracket using 5/16" hardware. The top ladder rung must be level with the platform floor.

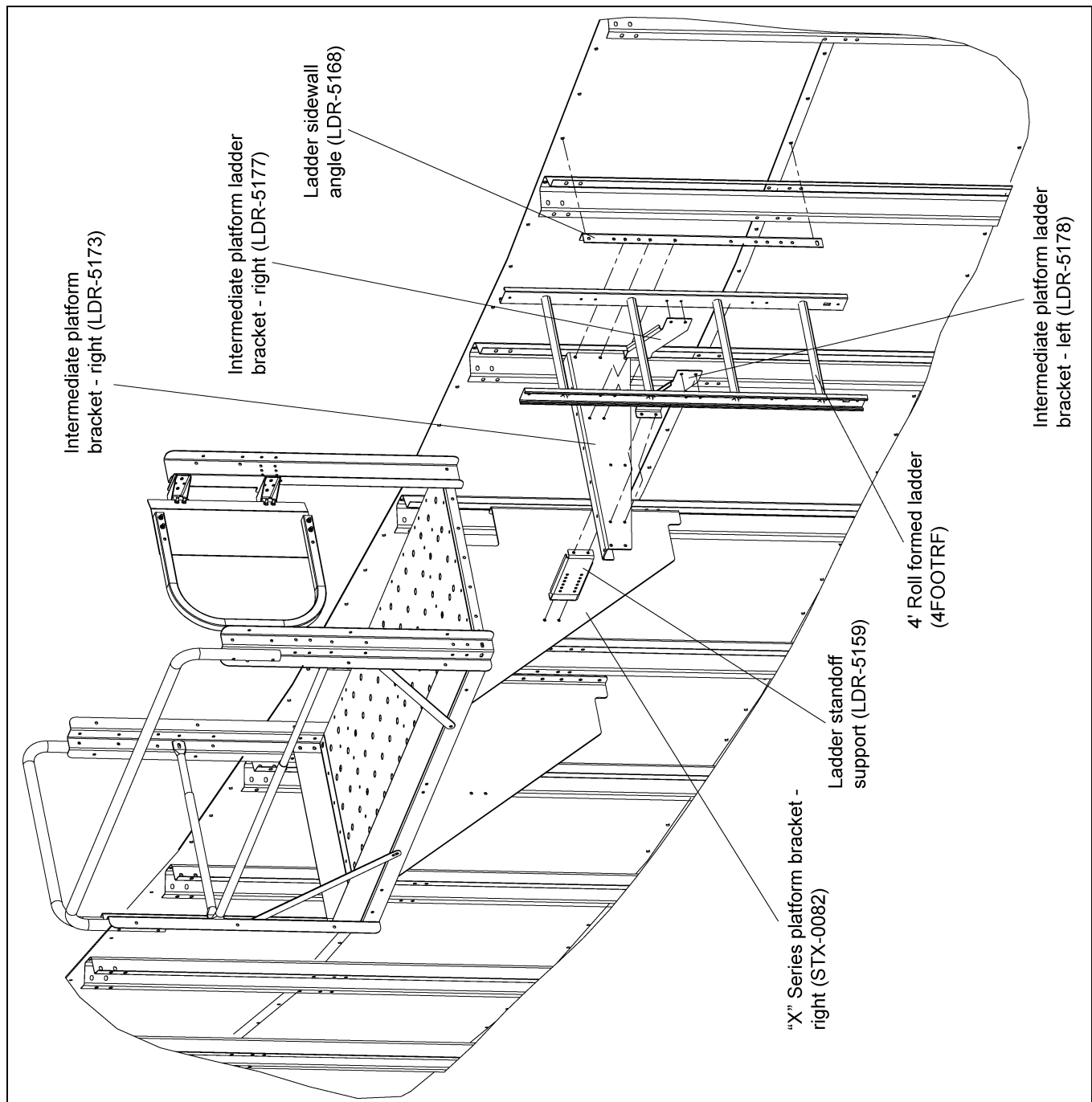


Figure 4G

4. Assembly Instructions

Platform and Safety Cage Package

- Attach the ladder flare to the ladder using 5/16" hardware. You must drill the bottom hole through the ladder and use 5/16" hardware. (See Figure 4H.)
- Attach the narrow safety cage bracket, cage hoops and cage splice brackets to the ladder flares and platform posts. This must all be assembled at the same time using 5/16" hardware.

NOTE: *Be sure the ladder flares are vertical and parallel to the platform posts by adjusting the splice brackets. The ladder will NOT be square to the platform due to the radius of the bin. The side closest to the bin wall will be closer to the platform.*

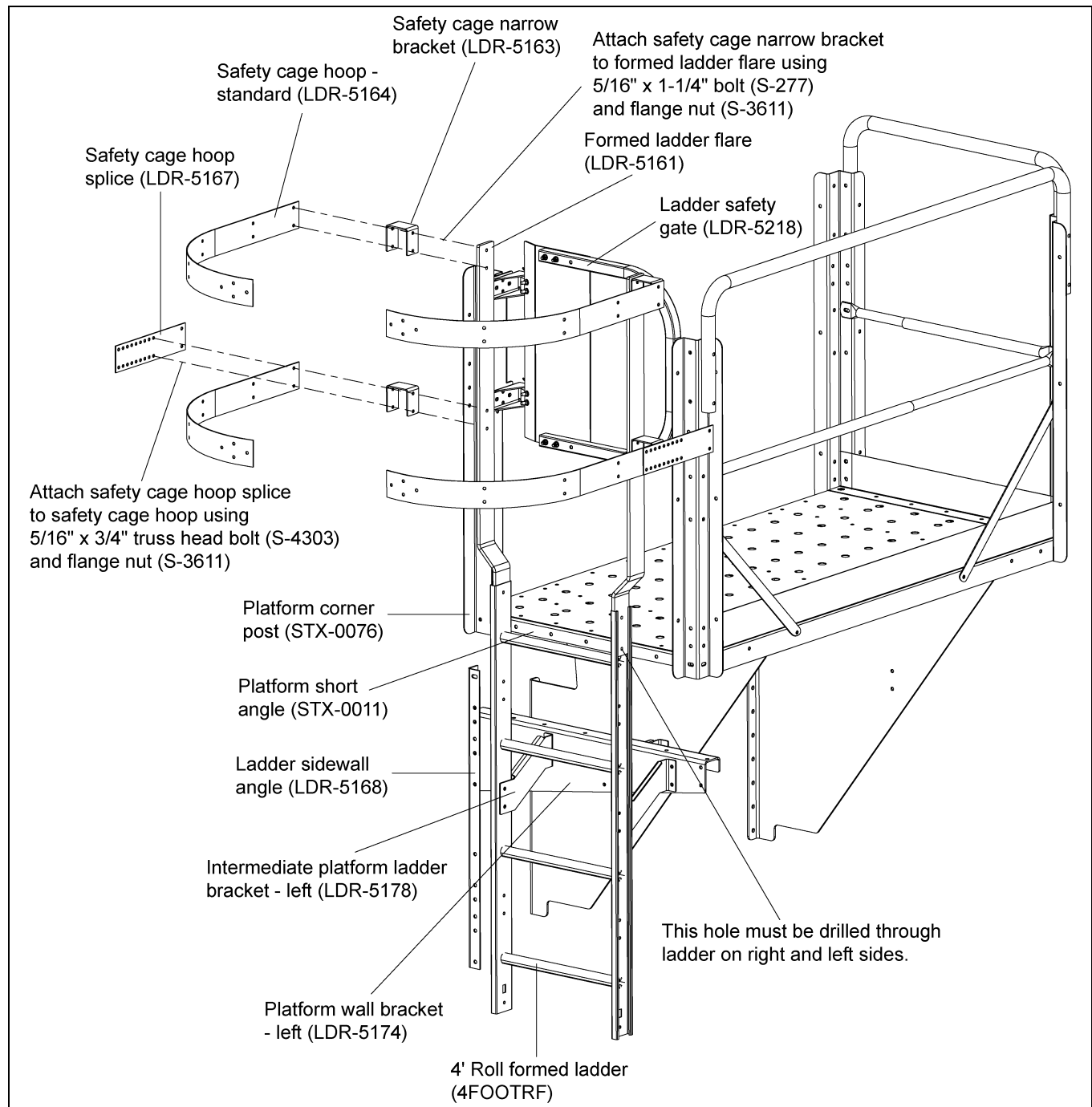


Figure 4H

Platform and Safety Cage Splice Bracket

11. Attach the cage splice bracket to the post and cage splice using 5/16" hardware. (See Figure 4I.)

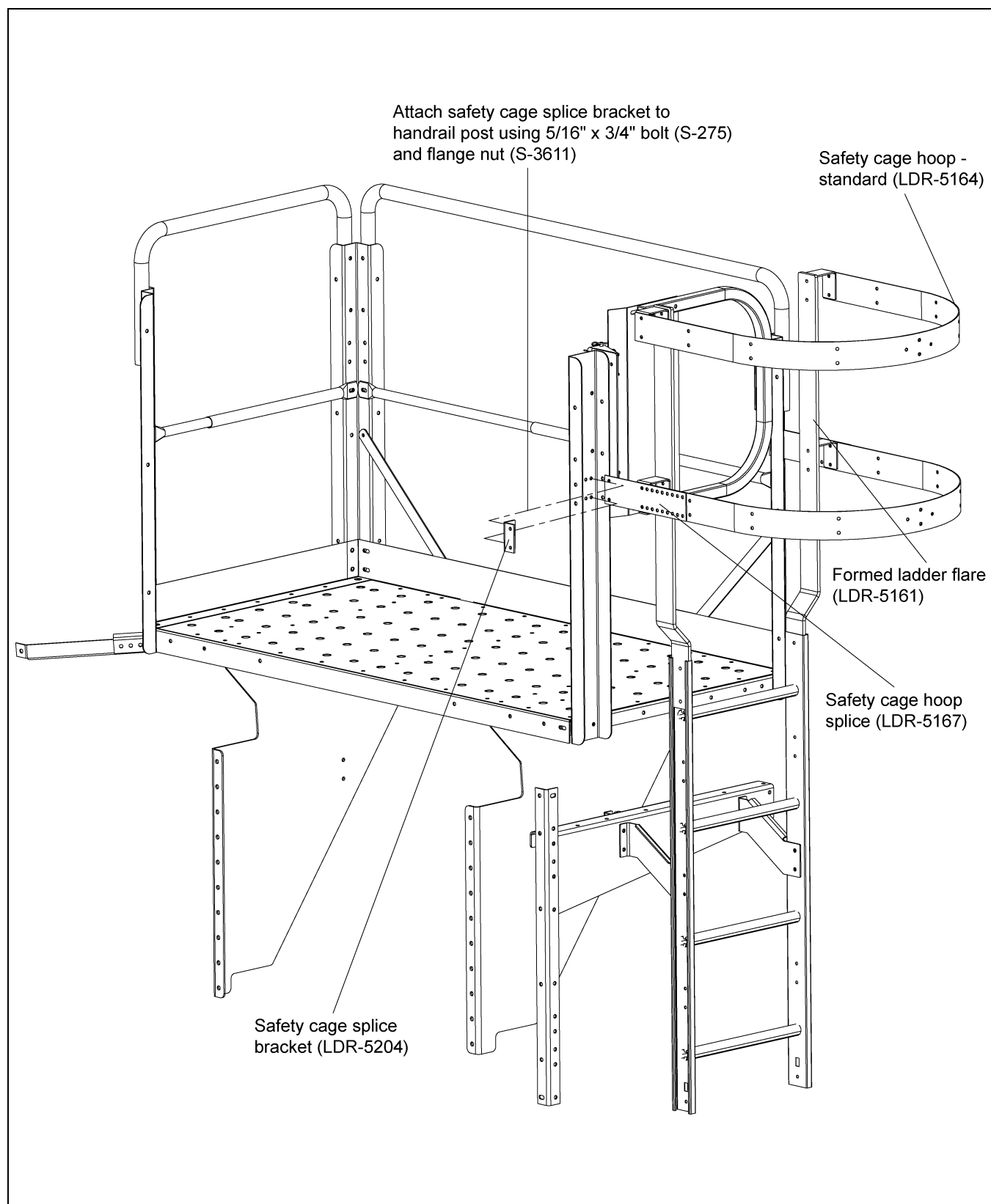


Figure 4I

4. Assembly Instructions

Platform Inside Post Bracket

12. Attach the post bracket to the inside post and bottom stair post using 5/16" hardware. (See Figure 4J.)

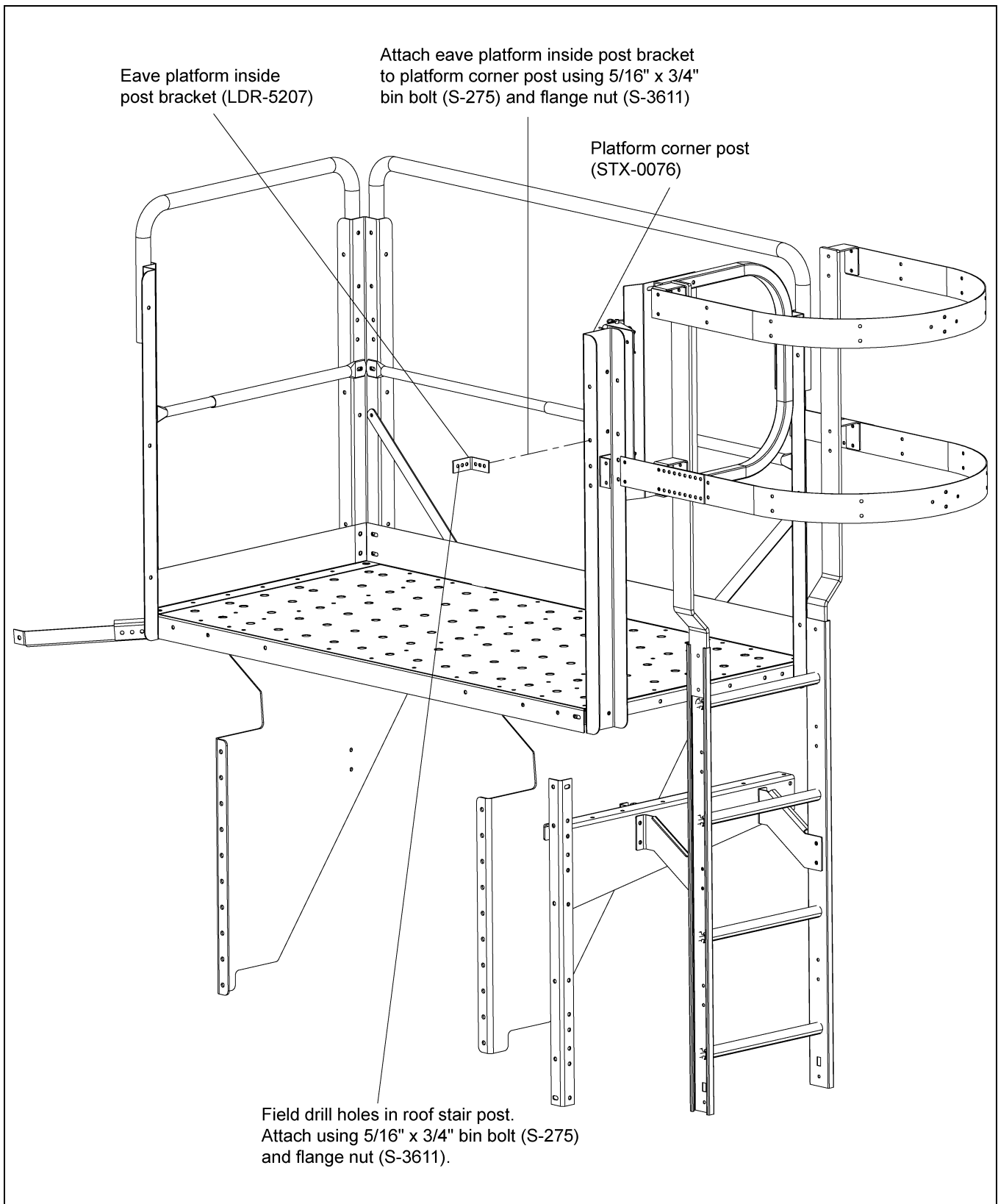


Figure 4J

Ladder Only Eave Platform Package w/ Manway Guard (LDR-5303)

1. Attach ladder/eave platform handrail bracket (LDR-5304) and ladder/eave platform kickplate splice plate (LDR-5305) to eave handrail post (STX-0076) using 5/16" hardware. LDR-5207 will not be used in this package. *(See Figure 4K below and Figure 4L on Page 24.)*

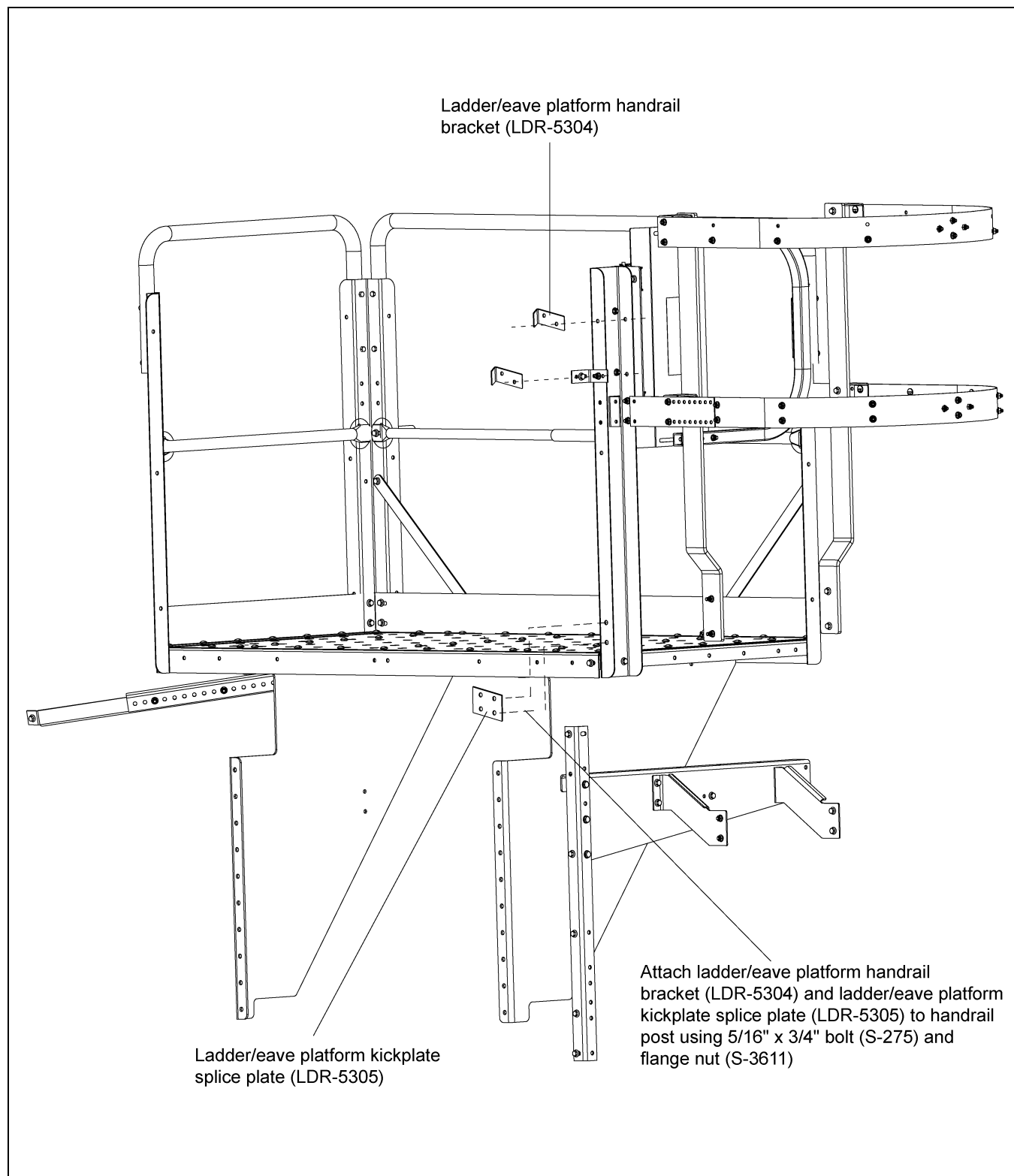


Figure 4K

Ladder Only Eave Platform Package w/ Manway Guard (LDR-5303) (Continued)

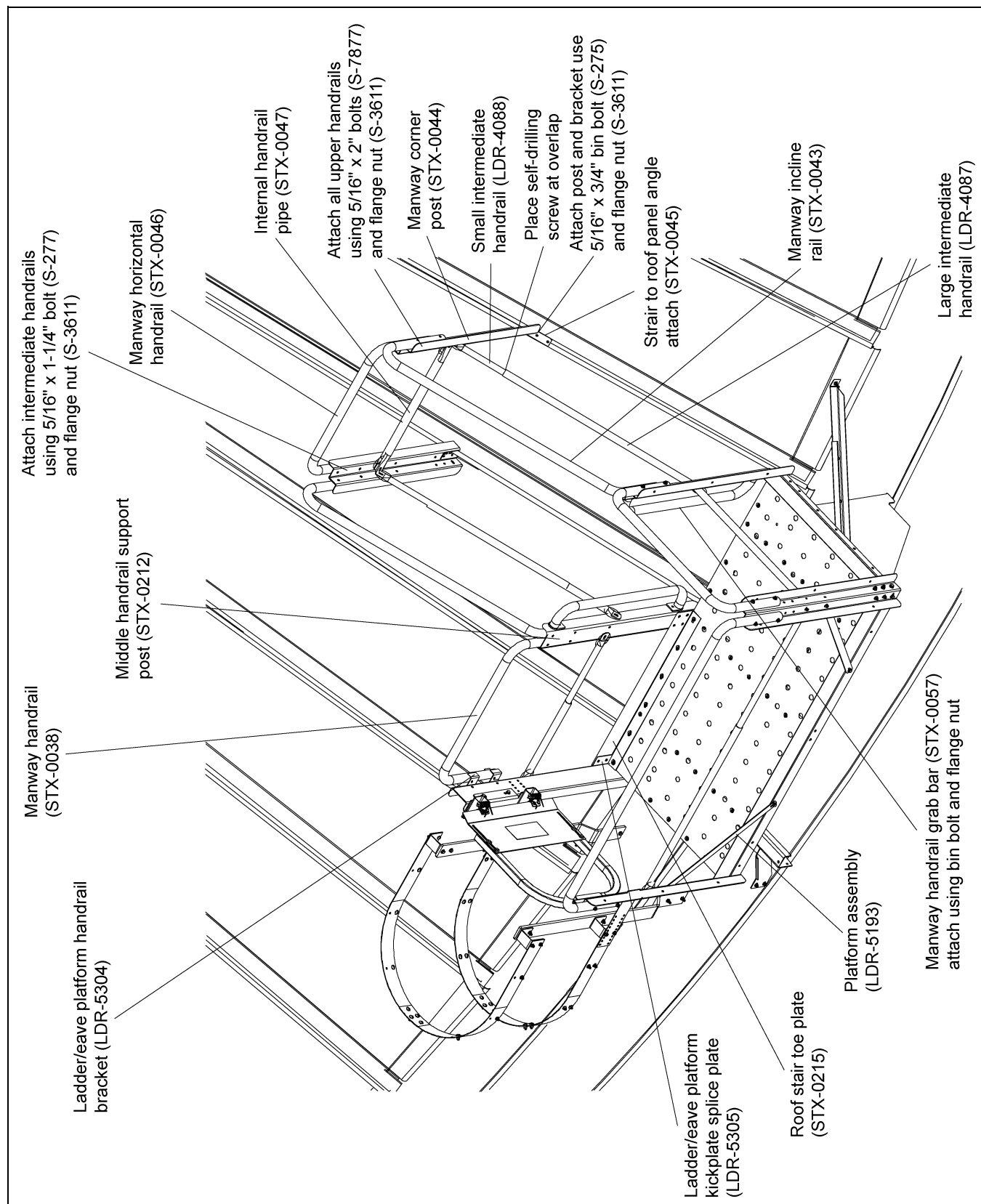


Figure 4L

42'-60' Bins Ladder Eave Platform (LDR-5208)

Ladder Eave Platform Package

1. [Figure 4M below](#) and [Figure 4N on Page 26](#) shows the assembly of the platform supports. Use 5/16" hardware at all the connection points. (Platform floor will have to be attached at the same time as support angles.)

NOTE: When installing the top wind ring, do NOT use the top set of holes in the stiffener.

NOTE: Leave all hardware loose until completely assembled.

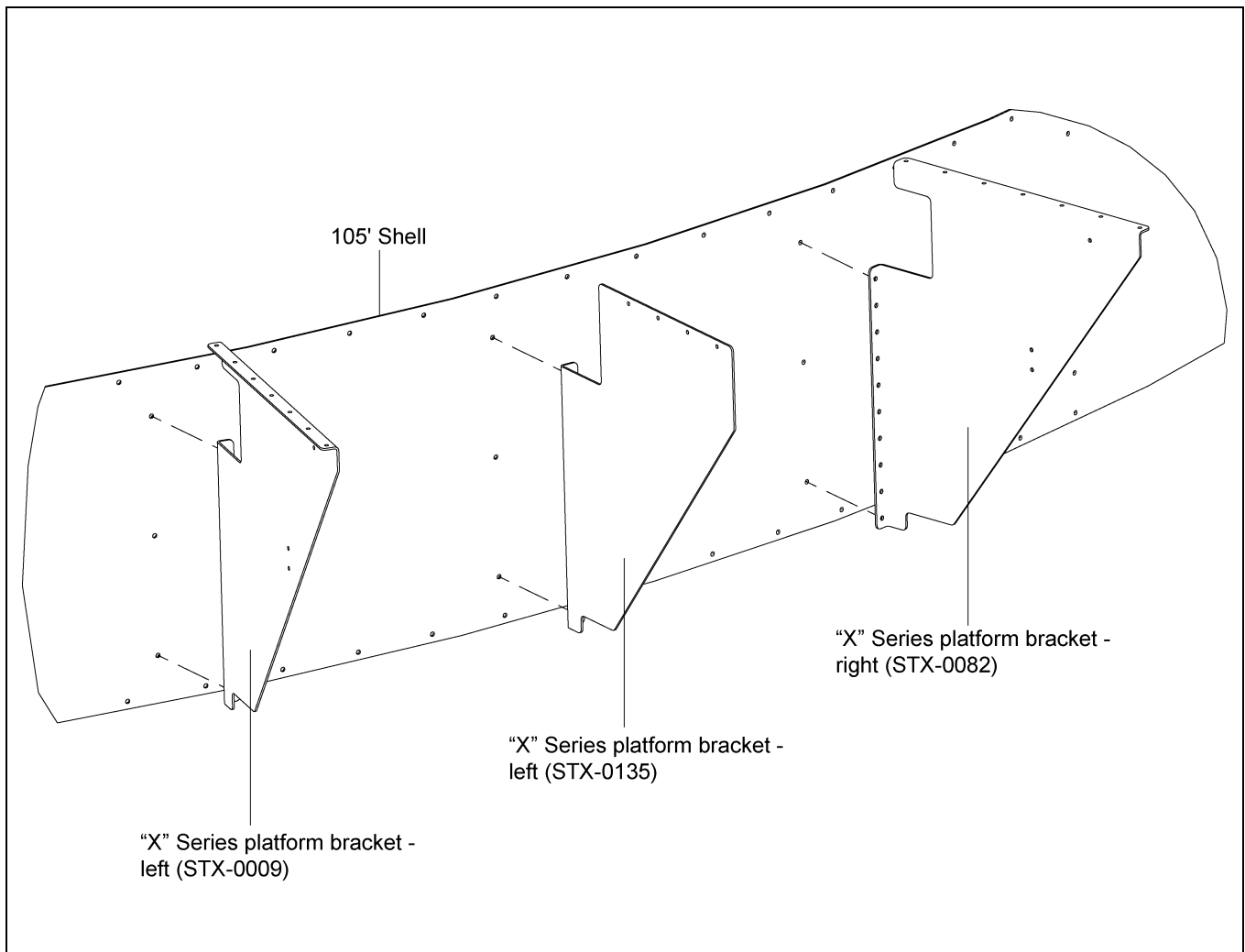


Figure 4M

4. Assembly Instructions

Ladder Eave Platform Package (Continued)

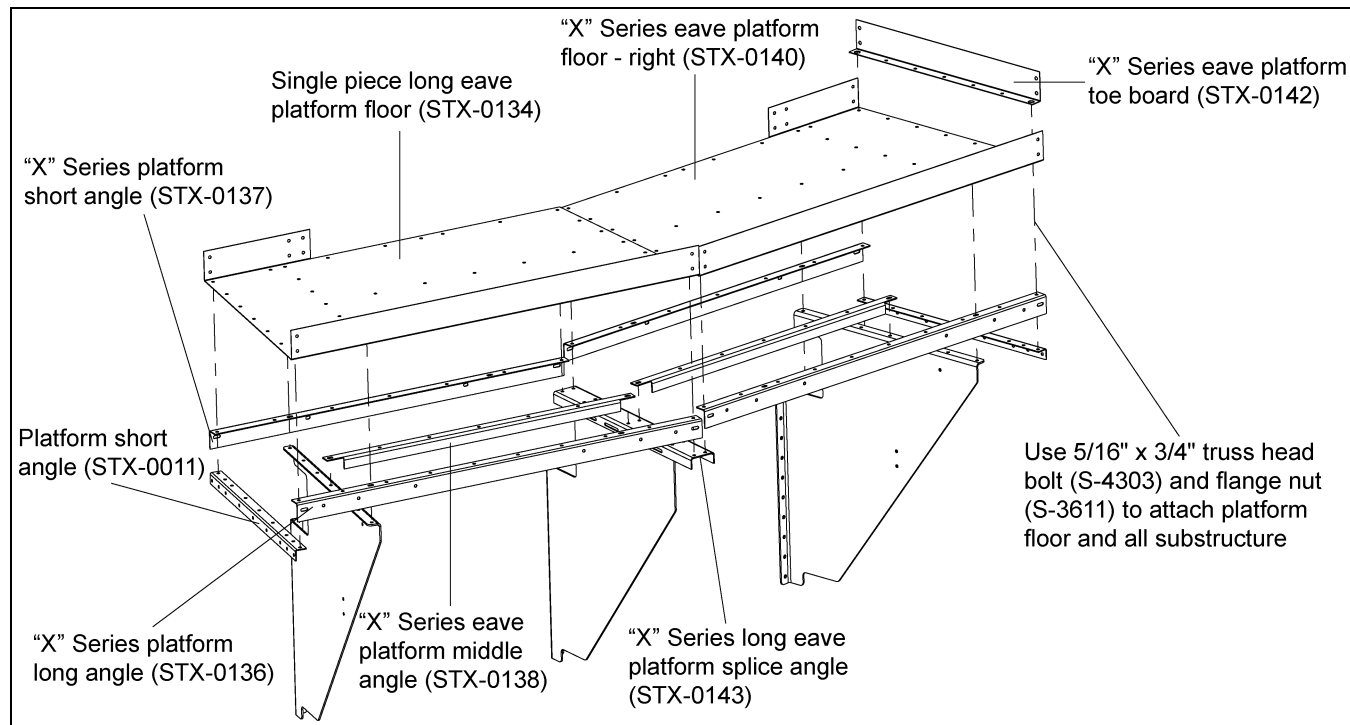


Figure 4N

Platform and Safety Cage Bar

2. [Figure 4O](#) shows the assembly of the platform post. This must all be assembled at the same time using 5/16" hardware. **NOTE:** 24" Safety cage bars are mounted to the inside of the post and the outside of the platform long angle.

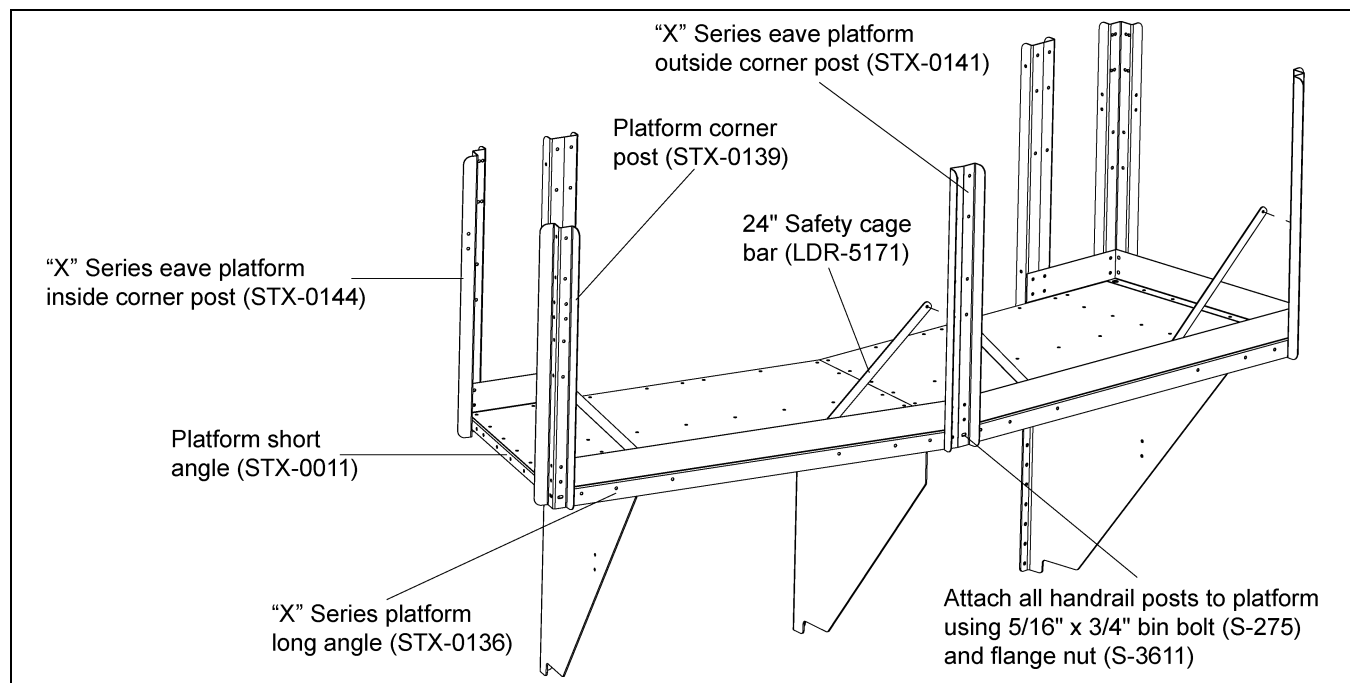


Figure 4O

Platform and Handrail Package

3. **Figure 4P** shows the assembly of the platform handrails. These must also be attached using 5/16" hardware.

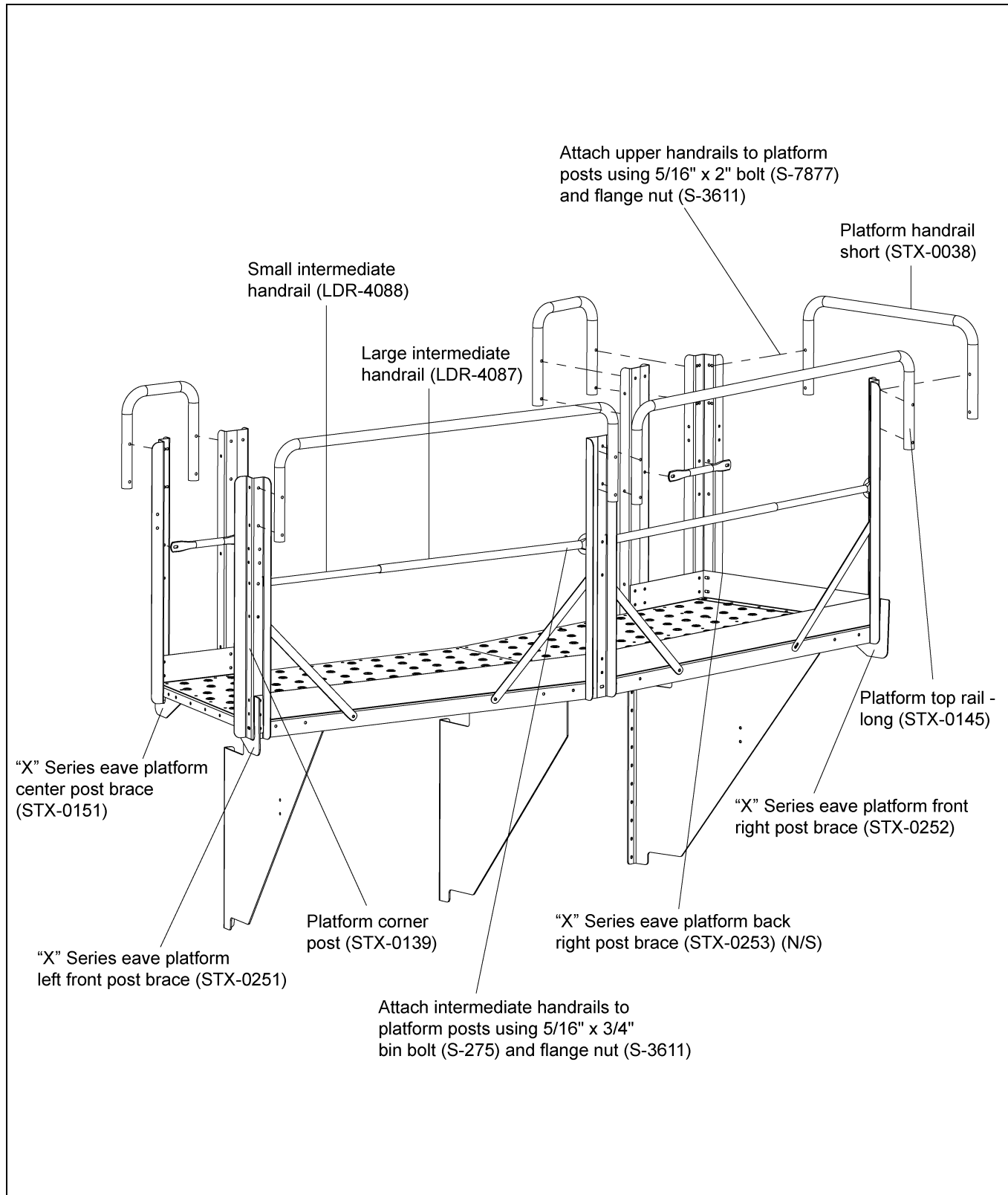


Figure 4P

4. Assembly Instructions

Platform and Swing Gate Package

4. Attach the platform gate bracket to the gate before attaching it to the inside platform post using 5/16" hardware. (See Figure 4Q.)

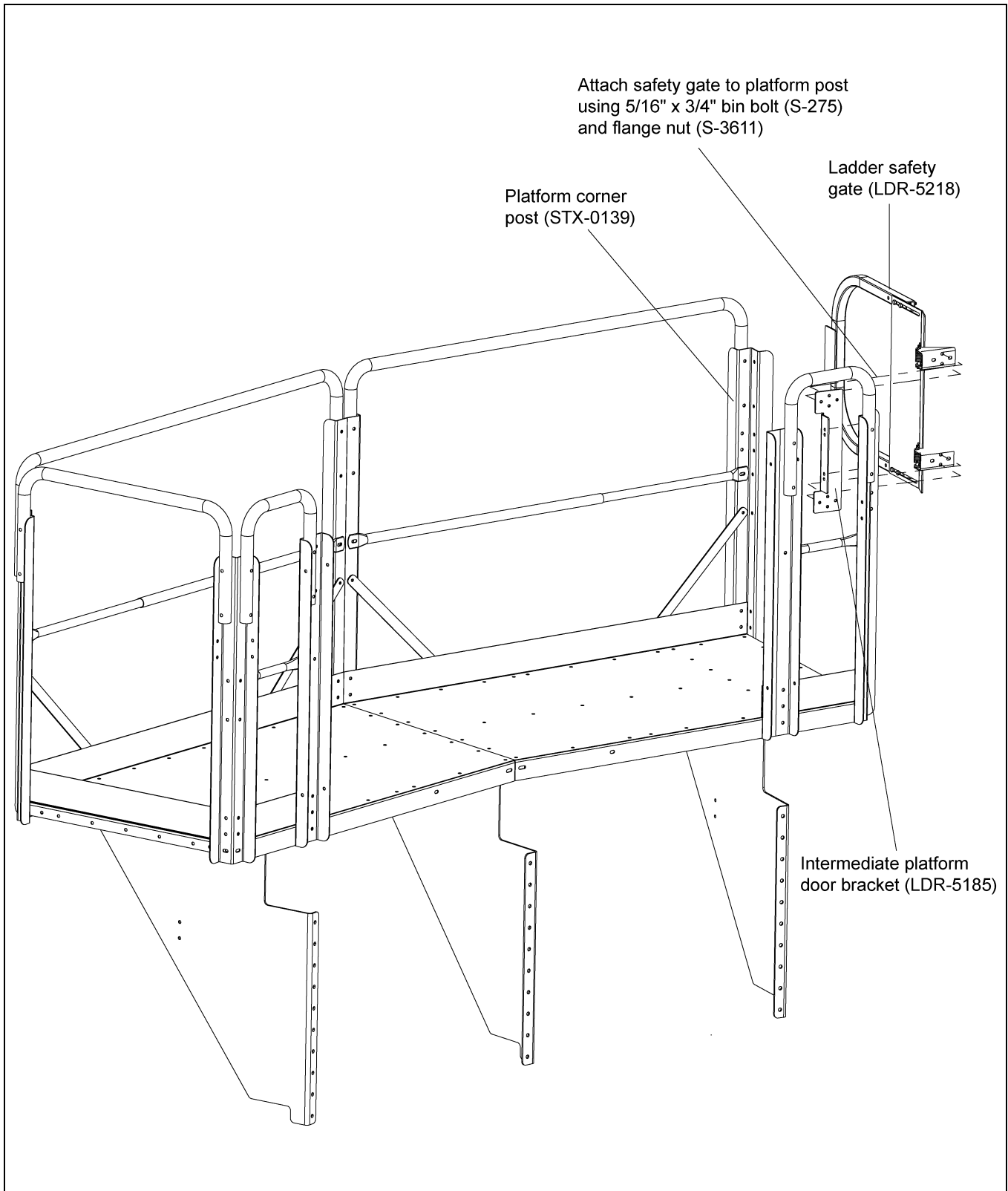


Figure 4Q

Platform Ladder Bracket Package

5. Attach the wall angle to the sidewall sheet using the hole 9-3/8" from the stiffener hole pattern with 3/8" hardware. Assemble the wall bracket to the wall angle with 3/8" hardware and tighten.
(See Figure 4R.)

Attach left and right intermediate platform ladder bracket to the wall bracket and platform support with 5/16" hardware.

NOTE: Do not force the wall bracket in or out.

Assemble the ladder and ladder brackets to the wall bracket using 5/16" hardware. The top ladder rung must be level with the platform floor.

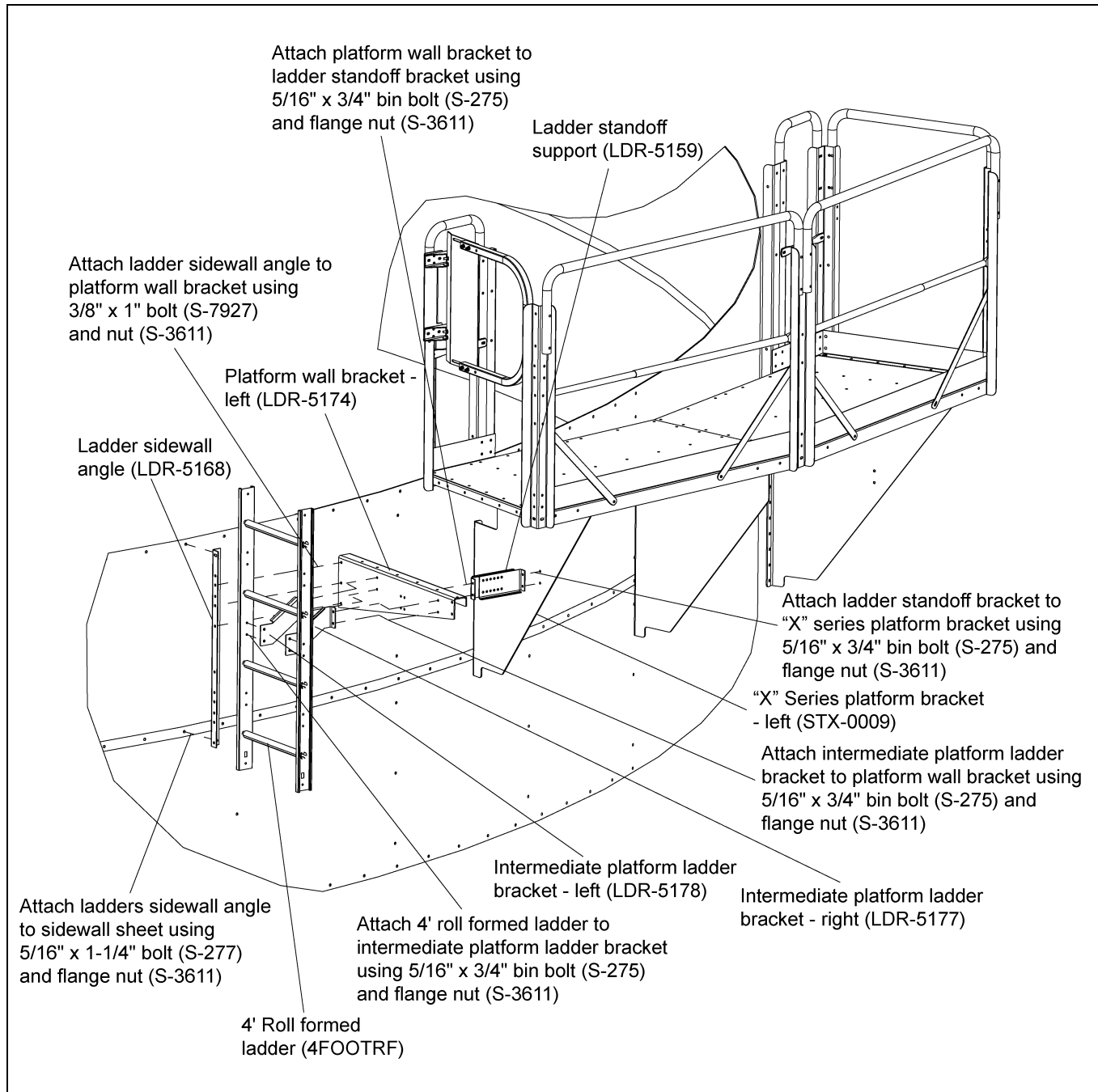


Figure 4R

4. Assembly Instructions

Platform and Safety Cage Package

6. Attach the ladder flare to the ladder using 5/16" hardware. You must drill the bottom hole through the ladder and use 5/16" hardware. (See Figure 4S.)
7. Attach the narrow safety cage bracket, cage hoops and cage splice brackets to the ladder flares and platform posts. This must all be assembled at the same time using 5/16" hardware.

NOTE: *Be sure the ladder flares are vertical and parallel to the platform posts by adjusting the splice brackets. The ladder will NOT be square to the platform due to the radius of the bin. The side closest to the bin wall will be closer to the platform.*

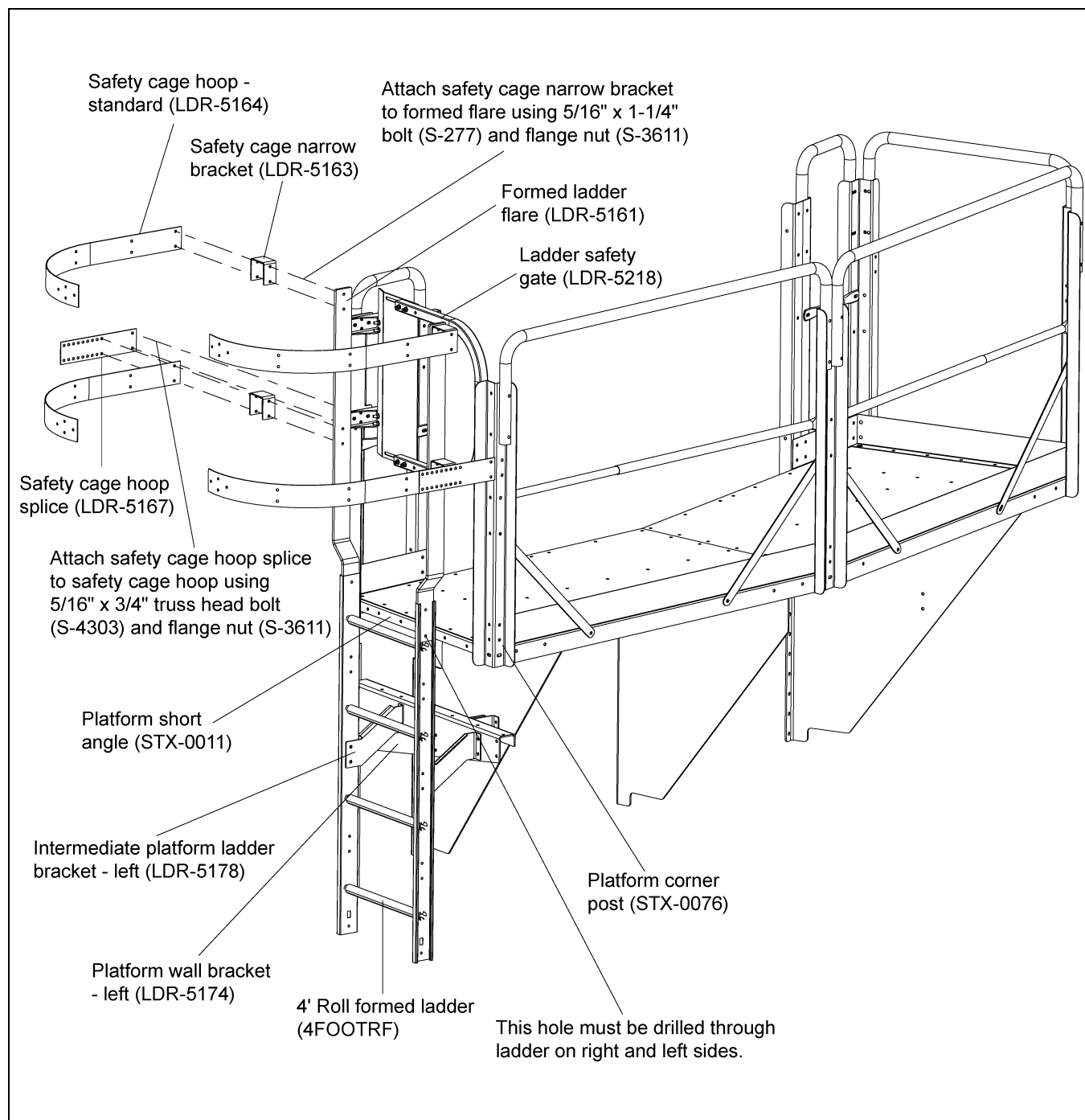


Figure 4S

Safety Cage and Ladder Assembly

Ladder and Safety Cage Layout

Item	10 Rings	11 Rings	12 Rings	13 Rings	14 Rings	15 Rings	16 Rings	17 Rings	18 Rings	19 Rings	20 Rings	21 Rings	22 Rings	23 Rings	24 Rings	25 Rings	26 Rings	27 Rings	28 Rings	29 Rings	30 Rings	31 Rings	32 Rings	33 Rings	34 Rings	35 Rings	36 Rings	37 Rings								
A Platform Located above Ring:	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1								
4' Ladder Section	7	8	4	5	5	5	6	7	7	7	7	7	8	5	6	7	7	8	7	7	7	7	7	8	5	5	6	7								
Safety Cage 4' Section	5	6	2	3	3	3	4	4	4	4	5	5	6	3	4	4	5	6	5	5	5	5	5	6	3	3	4	4								
Bell Safety Cage - 2'	0	1	1	0	0	0	1	0	0	0	0	0	1	0	1	0	0	1	0	0	0	0	0	1	0	0	1	0								
Bell Safety Cage - 3'	1	0	0	0	0	0	0	0	0	0	1	1	0	1	0	0	1	0	1	1	1	1	1	0	1	1	0	0								
Bell Safety Cage - 4'	0	0	0	1	1	1	0	1	1	1	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	1								
Eave Platform Package	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1								
Dimension A	327"	359"	167"	231"	231"	231"	263"	295"	295"	295"	327"	327"	359"	231"	263"	295"	327"	359"	327"	327"	327"	327"	327"	359"	231"	231"	263"	295"								
B Platform Located below Ring:			5	7	7	7	8	9	9	9	10	10	11	7	8	9	10	11	10	10	10	10	10	11	7	7	8	9								
4' Ladder Section			5	5	5	6	6	6	7	7	7	8	8	6	6	6	6	6	6	6	7	7	8	8	5	6	6	6								
Safety Cage 4' Section			3	2	3	4	4	4	4	5	5	6	6	3	3	3	3	3	3	3	5	5	6	6	3	3	3	3								
Safety Cage 3' Section			0	0	0	0	0	0	0	0	0	0	0	1	1	1	1	1	1	1	0	0	0	0	0	1	1	1								
Bell Safety Cage - 2'			0	0	0	1	1	1	0	0	0	1	1	1	1	1	1	1	1	1	0	0	1	1	0	1	1	1								
Bell Safety Cage - 3'			1	0	1	0	0	0	0	1	1	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0	0	0								
Bell Safety Cage - 4'			0	1	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0								
Intermediate Platform Package			1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1								
Dimension B			224"	192"	224"	256"	256"	256"	288"	320"	320"	352"	352"	256"	256"	256"	256"	256"	256"	256"	320"	320"	352"	352"	224"	256"	256"	256"								
C Platform Located below Ring:														15	16	17	18	19	18	18	20	20	21	22	14	15	16	17								
4' Ladder Section														6	6	6	6	6	7	8	7	8	8	8	7	7	7	7								
Safety Cage 4' Section														3	3	3	3	3	5	6	5	6	6	6	5	5	5	5								
Safety Cage 3' Section														1	1	1	1	1	0	0	0	0	0	0	0	0	0	0								
Bell Safety Cage - 2'														1	1	1	1	1	0	1	0	1	1	1	0	0	0	0								
Bell Safety Cage - 3'														0	0	0	0	0	1	0	1	0	0	0	1	1	1	1								
Intermediate Platform Package														1	1	1	1	1	1	1	1	1	1	1	1	1	1	1								
Dimension C														256"	256"	256"	256"	256"	320"	352"	320"	352"	352"	352"	320"	320"	320"	320"								
D Platform Located below Ring:																									24	25	26	27								
4' Ladder Section																									7	7	7	7								
Safety Cage 4' Section																									5	5	5	5								
Bell Safety Cage - 3'																									1	1	1	1								
Intermediate Platform Package																									1	1	1	1								
Dimension D																									320"	320"	320"	320"								
NOTE: See Pages 32 and 33 for A, B, C and D layouts.																																				

NOTE: See Pages 32 and 33 for A, B, C and D layouts.

2.66" Commercial Ladder Offset and Platform Layout

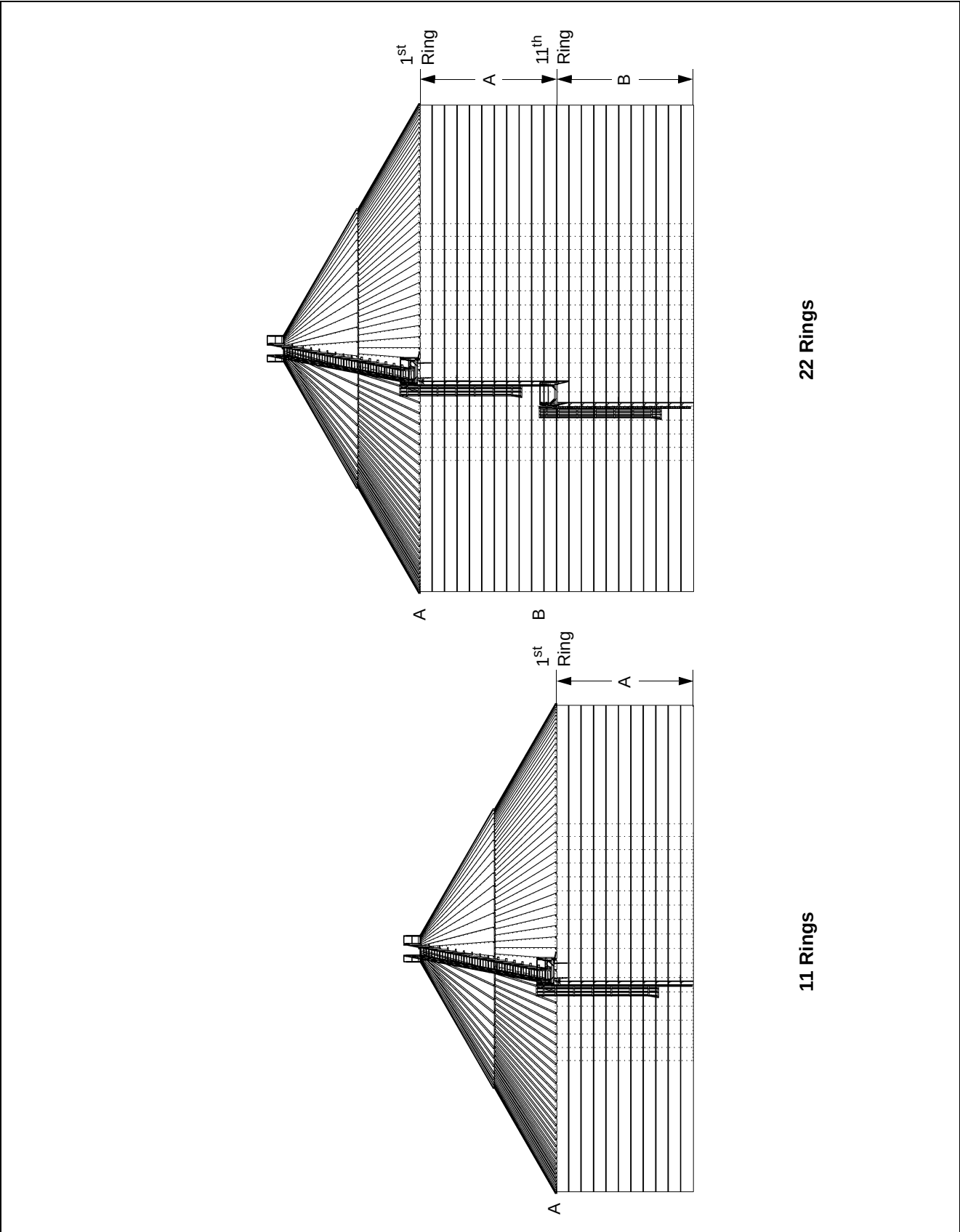
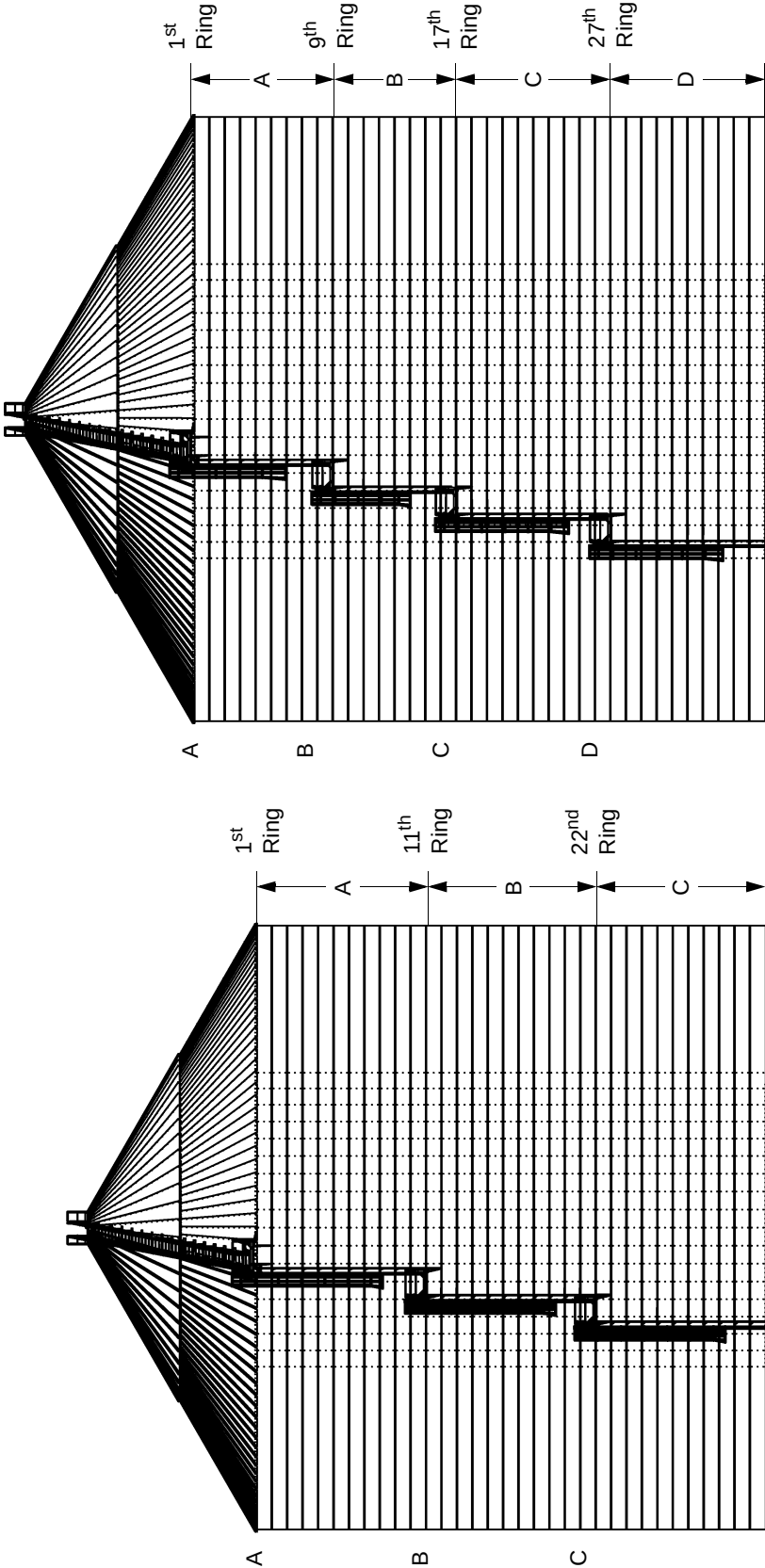


Figure 4T



37 Rings

33 Rings

Figure 4U

4. Assembly Instructions

NOTE: See table on Page 31 for correct ladder and safety cage layout.

1. Assemble the wall bracket to the wall angle using 3/8" hardware. (See Figure 4W on Page 35.)

NOTE: The wall angle must be assembled on top of the previous wall angle to provide a flat surface to mount the wall bracket.

2. Assemble the wall braces to the wall bracket and the horizontal sidewall seam using 5/16" hardware.

IMPORTANT: Use a hole in the horizontal seam and two (2) holes in the wall braces that allows the wall bracket to be aligned with the above wall bracket. If they are NOT aligned, the ladder will not be straight.

3. Attach the next ladder section to the upper section using the splice plates and 5/16" hardware. (See Figure 4V.)

Assemble the ladder standoff brackets to the ladder and wall bracket using the ladder standoff wedges and 5/16" hardware. (See Figure 4W on Page 35.)

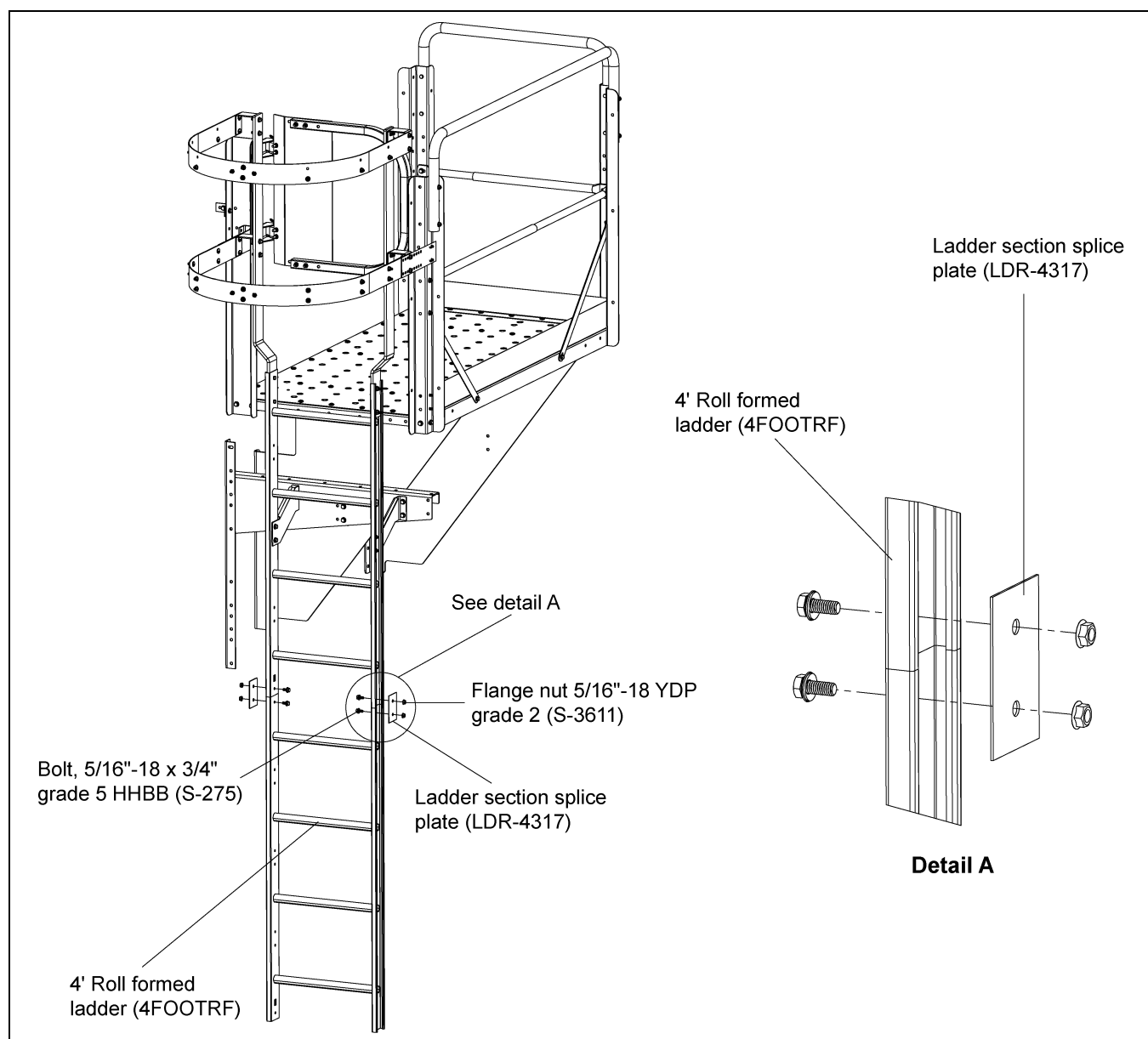


Figure 4V

Left Hand Side Ladder Assembly

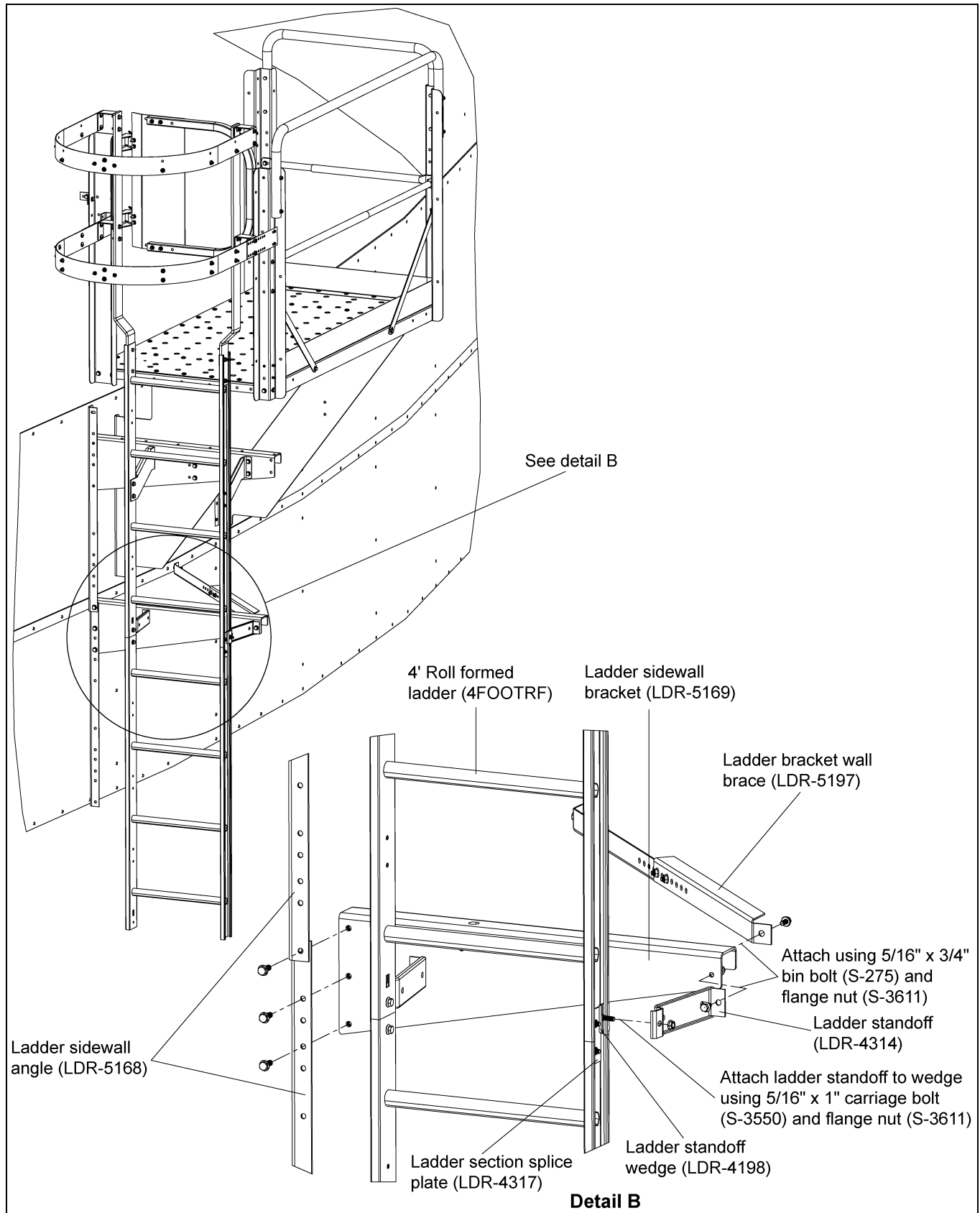


Figure 4W

4. Assembly Instructions

Right Hand Side Ladder Assembly

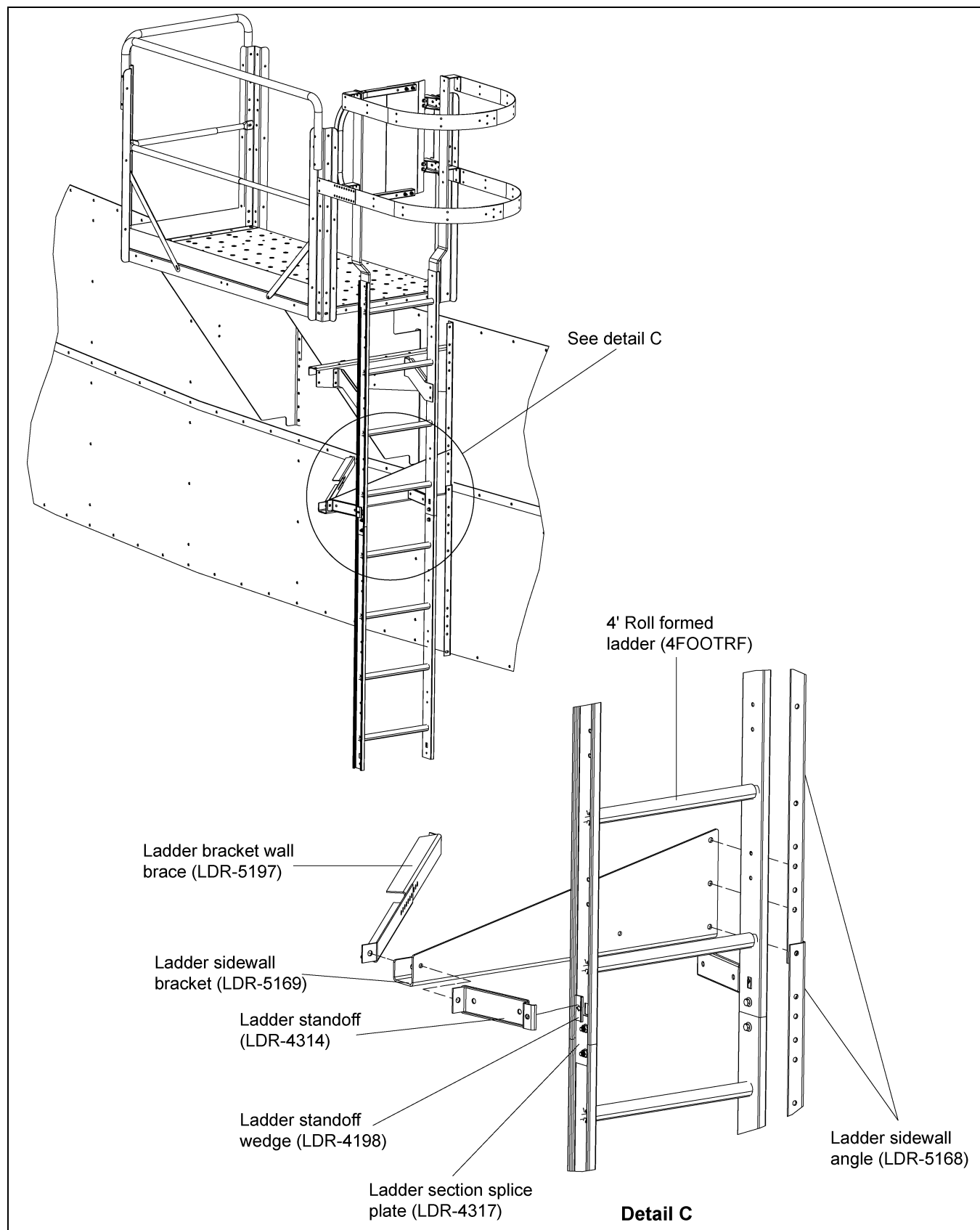


Figure 4X

4. Assemble the safety cage rail spacer, standard safety cage hoops and cage bars to the ladder using 5/16" hardware. (See Figure 4Y.)
5. Assemble the safety cage rail spacer, bell safety cage hoops and cage bars to the ladder using 5/16" hardware. (See Figure 4Y.)

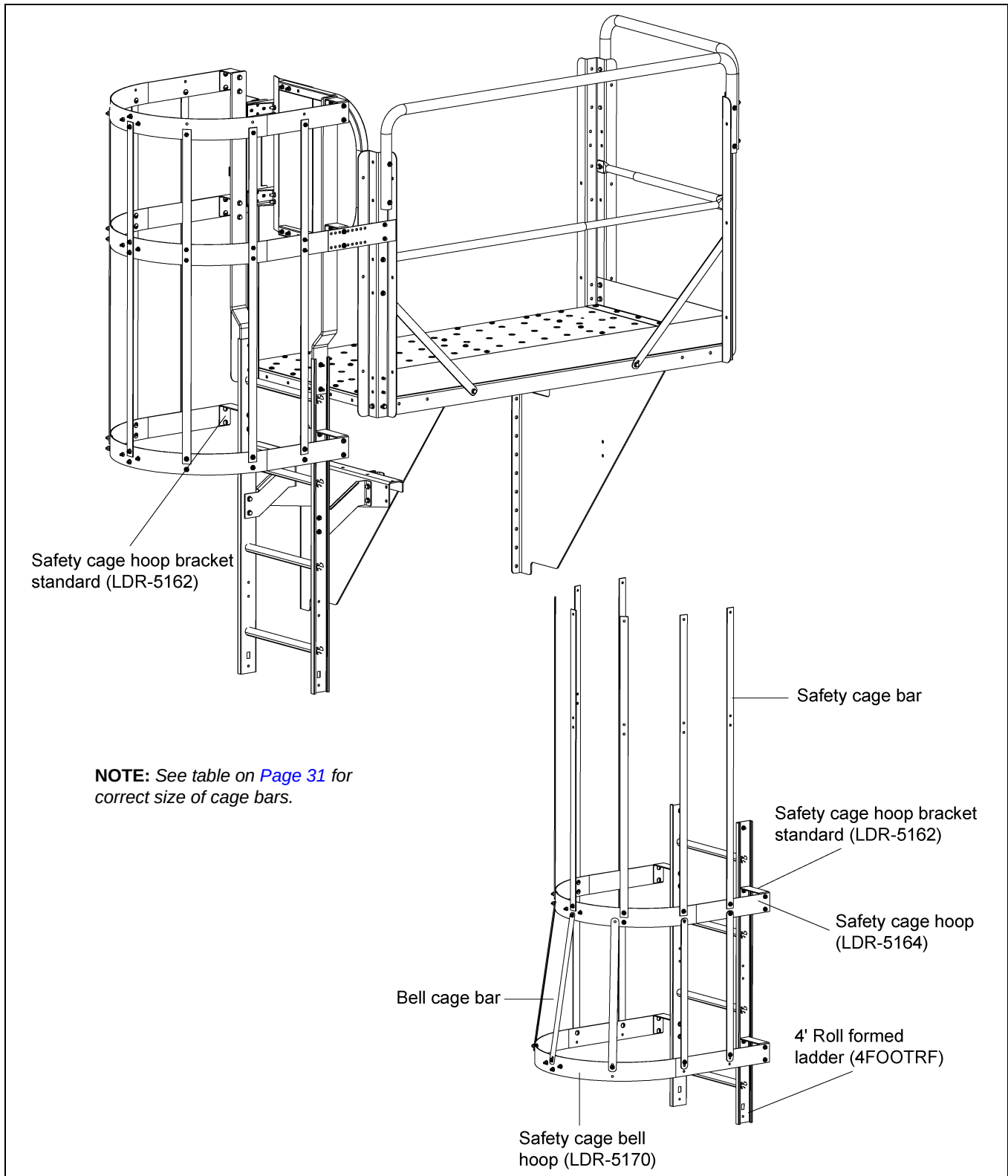


Figure 4Y

4. Assembly Instructions

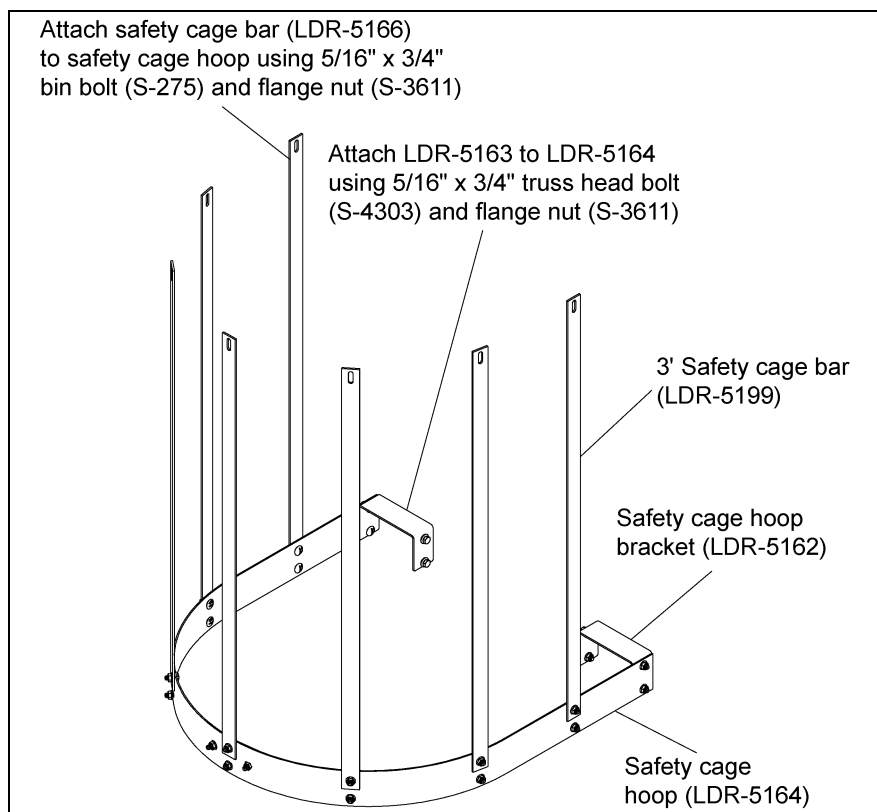


Figure 4Z 3' Ladder Safety Cage Section

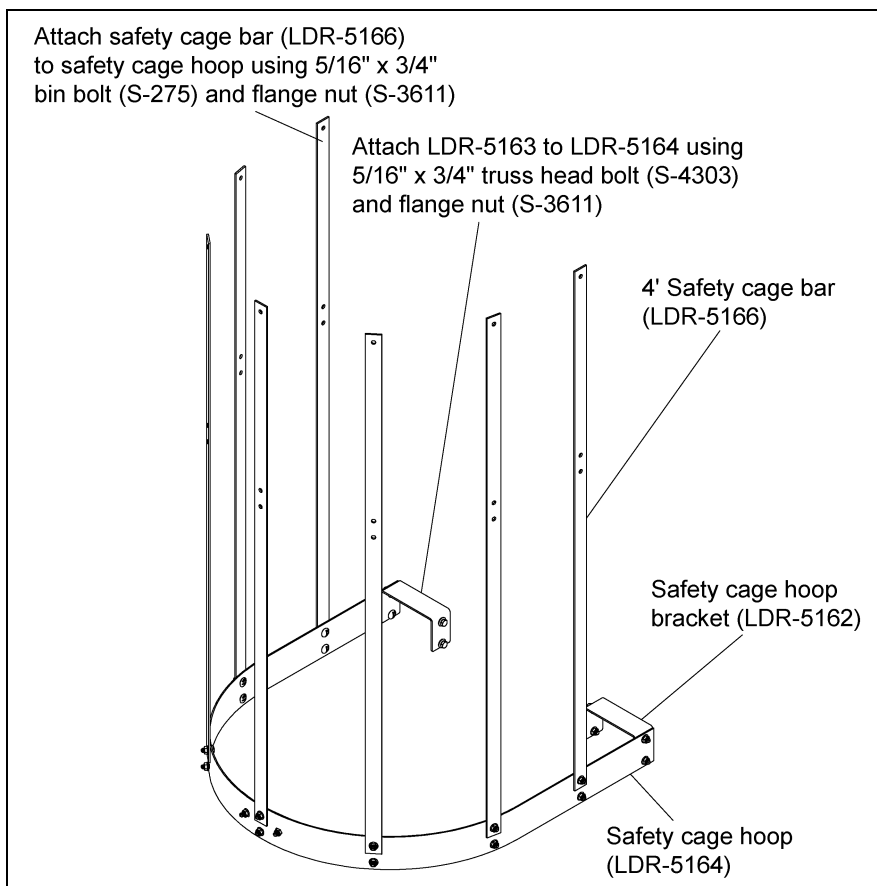


Figure 4AA 4' Ladder Safety Cage Section

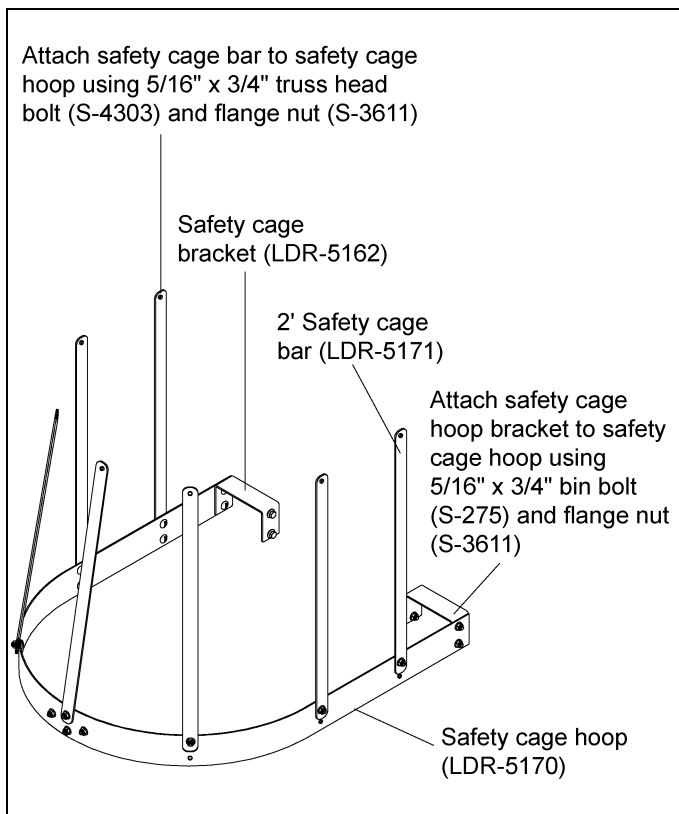


Figure 4AB 2' Ladder Safety Bell Cage

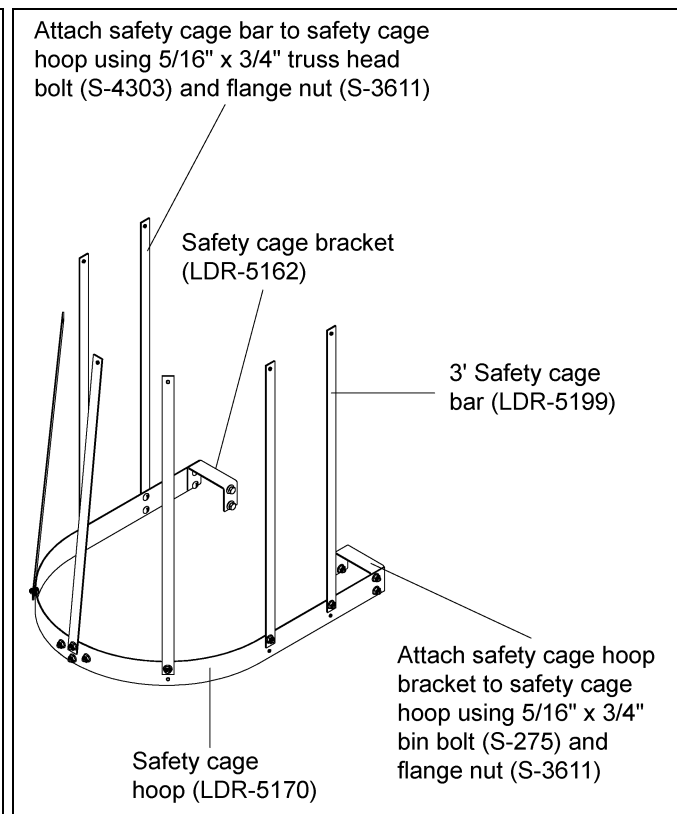


Figure 4AC 3' Ladder Safety Bell Cage

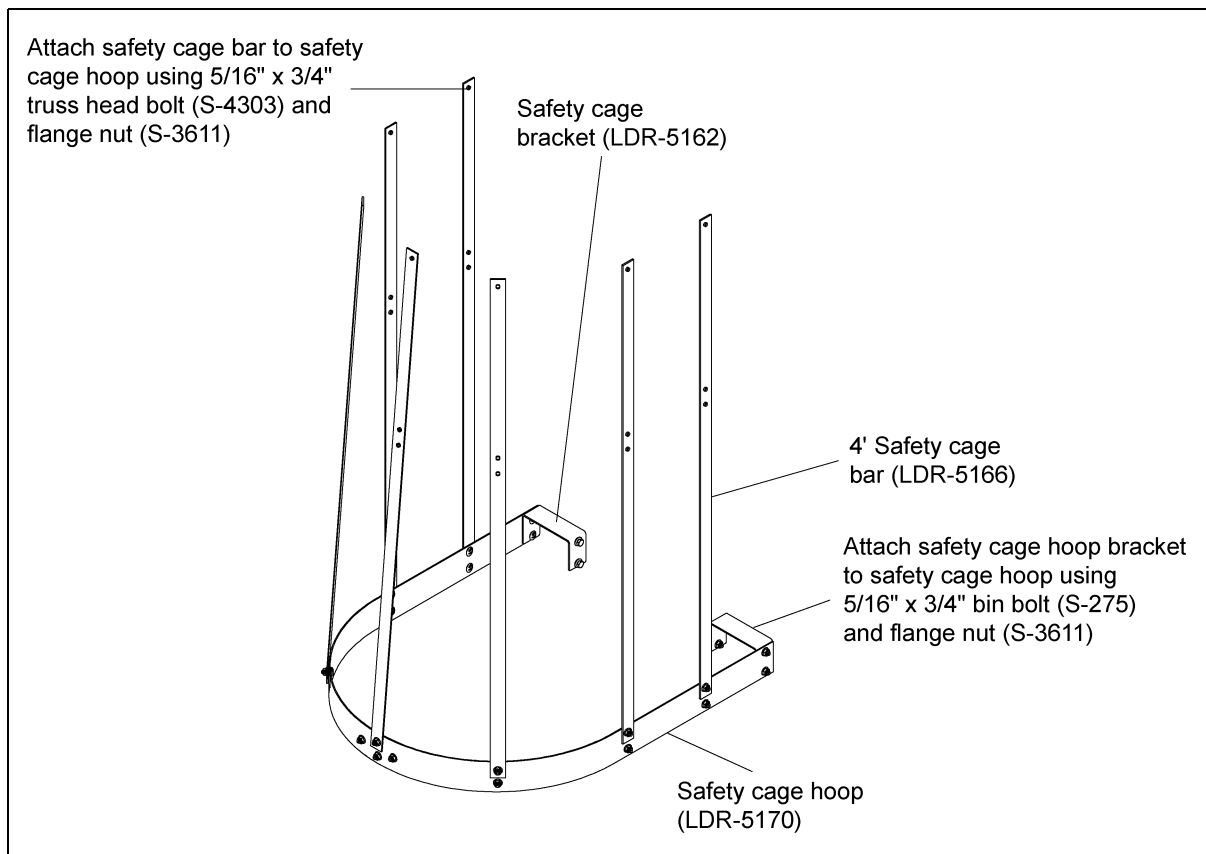


Figure 4AD 4' Ladder Safety Bell Cage

4. Assembly Instructions

6. The last ladder section at each intermediate platform and at the bottom may need to be cut off for proper fit. (See Figure 4AE.)
7. Anchor the last ladder section to the intermediate platform using the ladder base and 5/16" hardware. You must drill the platform floor to attach the ladder base to the platform. (See Figure 4AE.)

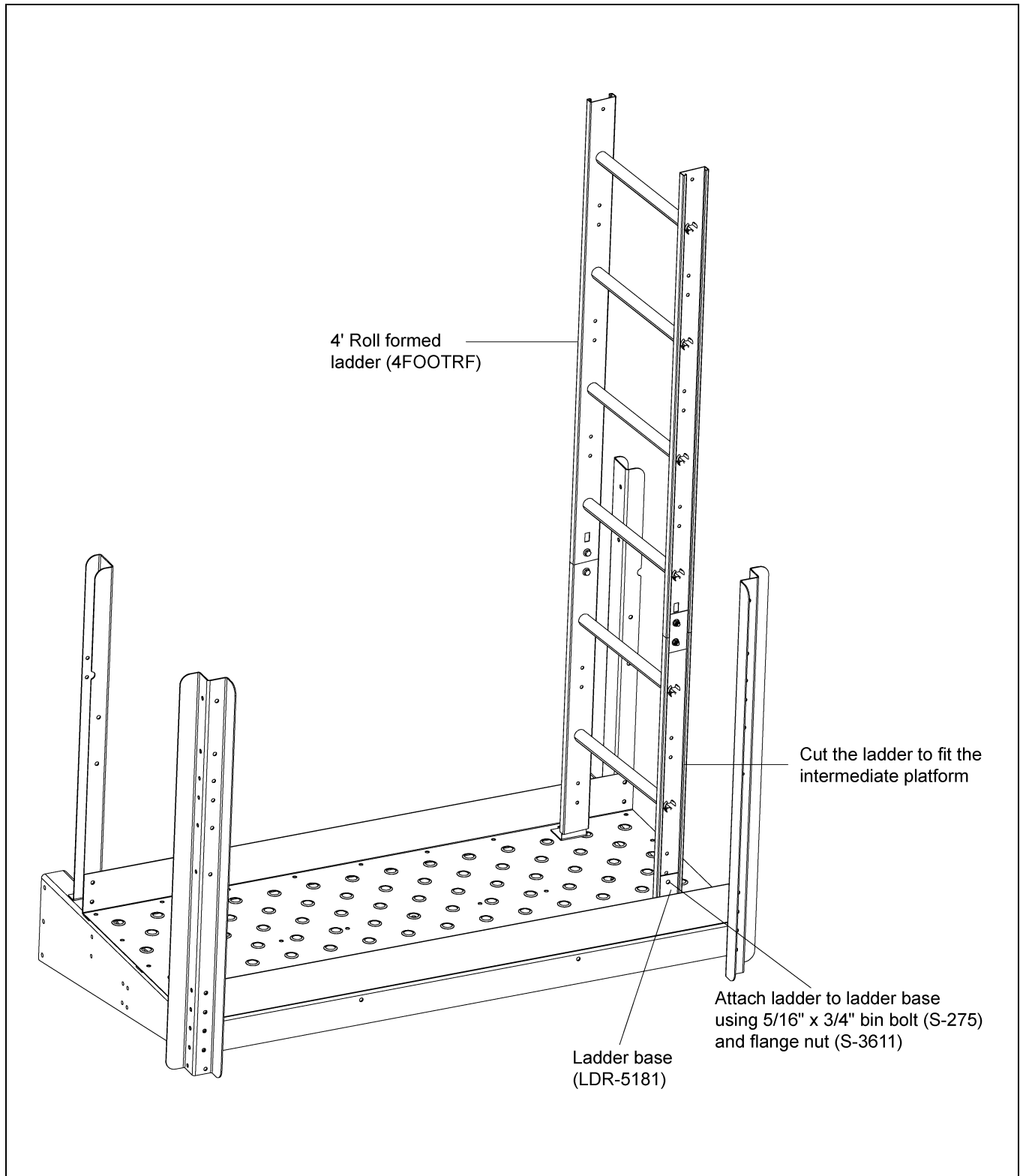


Figure 4AE

“X” Series Ladder Intermediate Platform Package (LDR-5196)

Platform Package

1. Attach the wall angle to the sidewall sheet with 3/8" hardware. Assemble the left and right intermediate platform brackets to the wall angles with 3/8" hardware. (See Figure 4AF.)

NOTE: Leave all hardware loose until completely assembled.

Assemble the platform to the front and back angles and platform brackets using the 5/16" truss bolts. Using 5/16" hardware, assemble the posts.

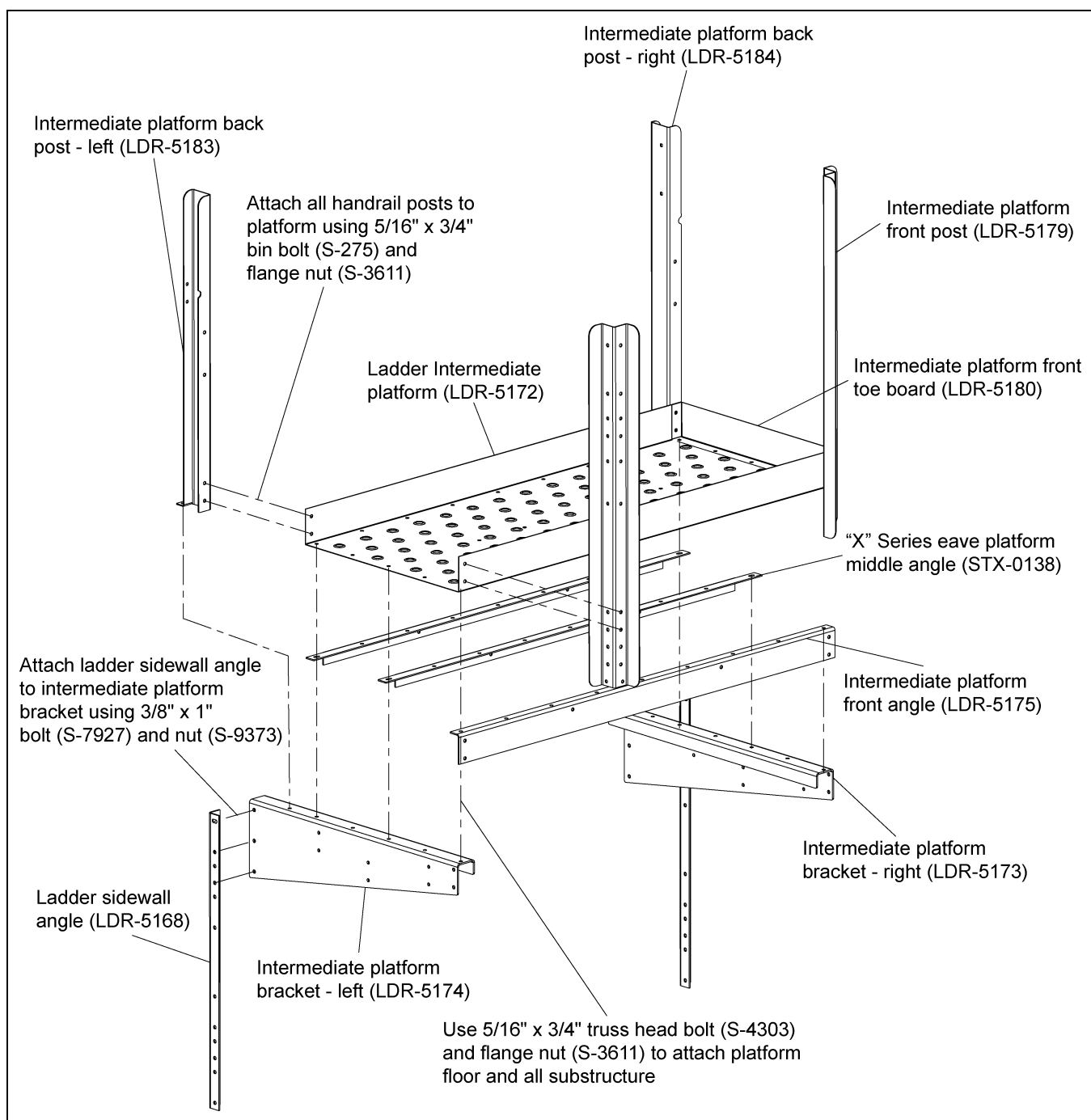


Figure 4AF

4. Assembly Instructions

Platform Package (Continued)

2. Assemble the platform wall brace to the intermediate platform front posts and wall angles with 5/16" hardware. (See Figure 4AG.)

Attach the platform gate bracket to the gate before attaching it to the platform back post using 5/16" hardware.

Assemble the top and intermediate handrails to the post using 5/16" hardware.

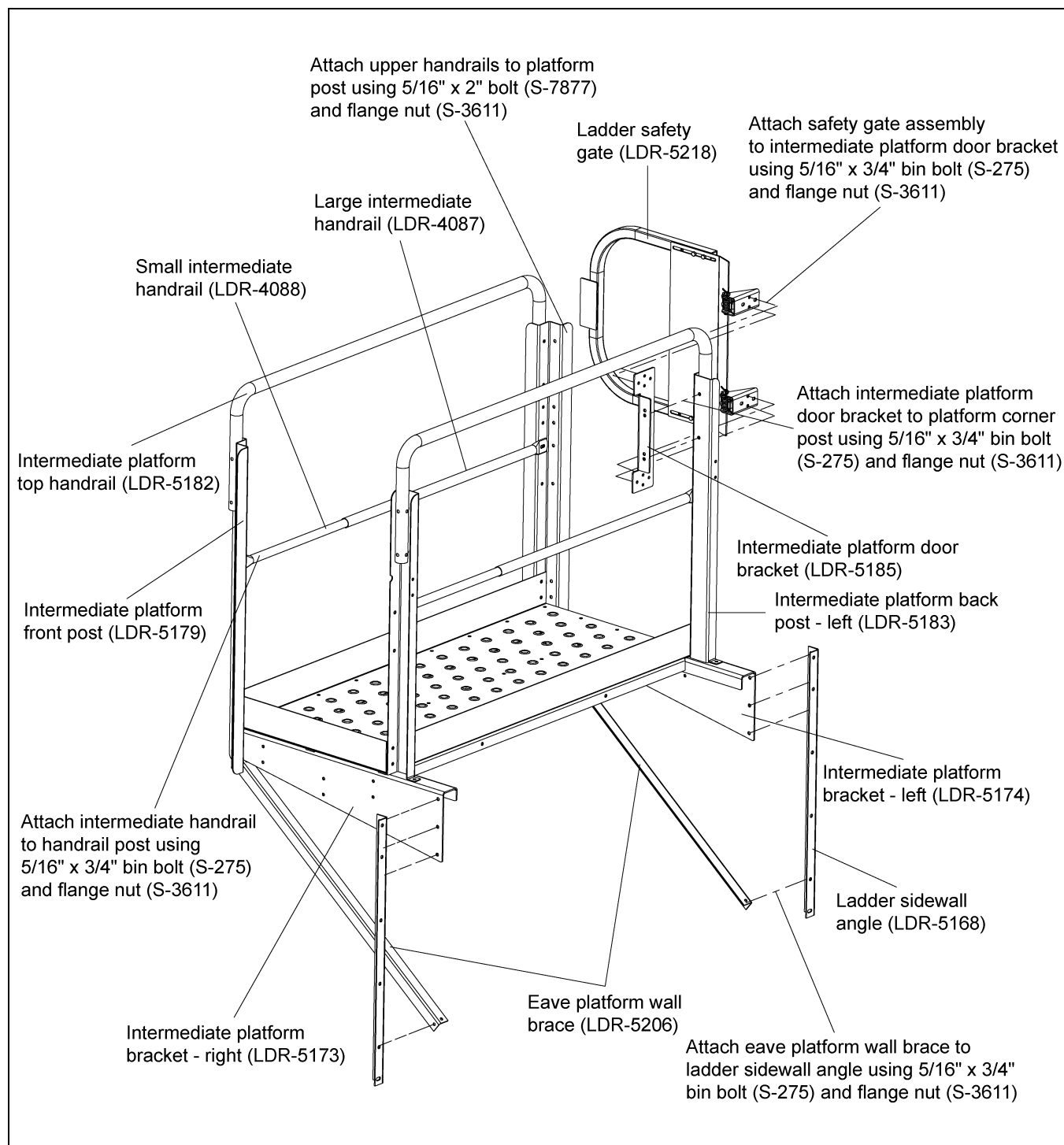


Figure 4AG

Platform and Safety Cage Bar Package

3. Assemble the safety cage bars (knee brace) to the posts and front and back angles using 5/16" hardware. (See Figure 4AH.)

NOTE: Be sure the intermediate platform is level before tightening hardware.

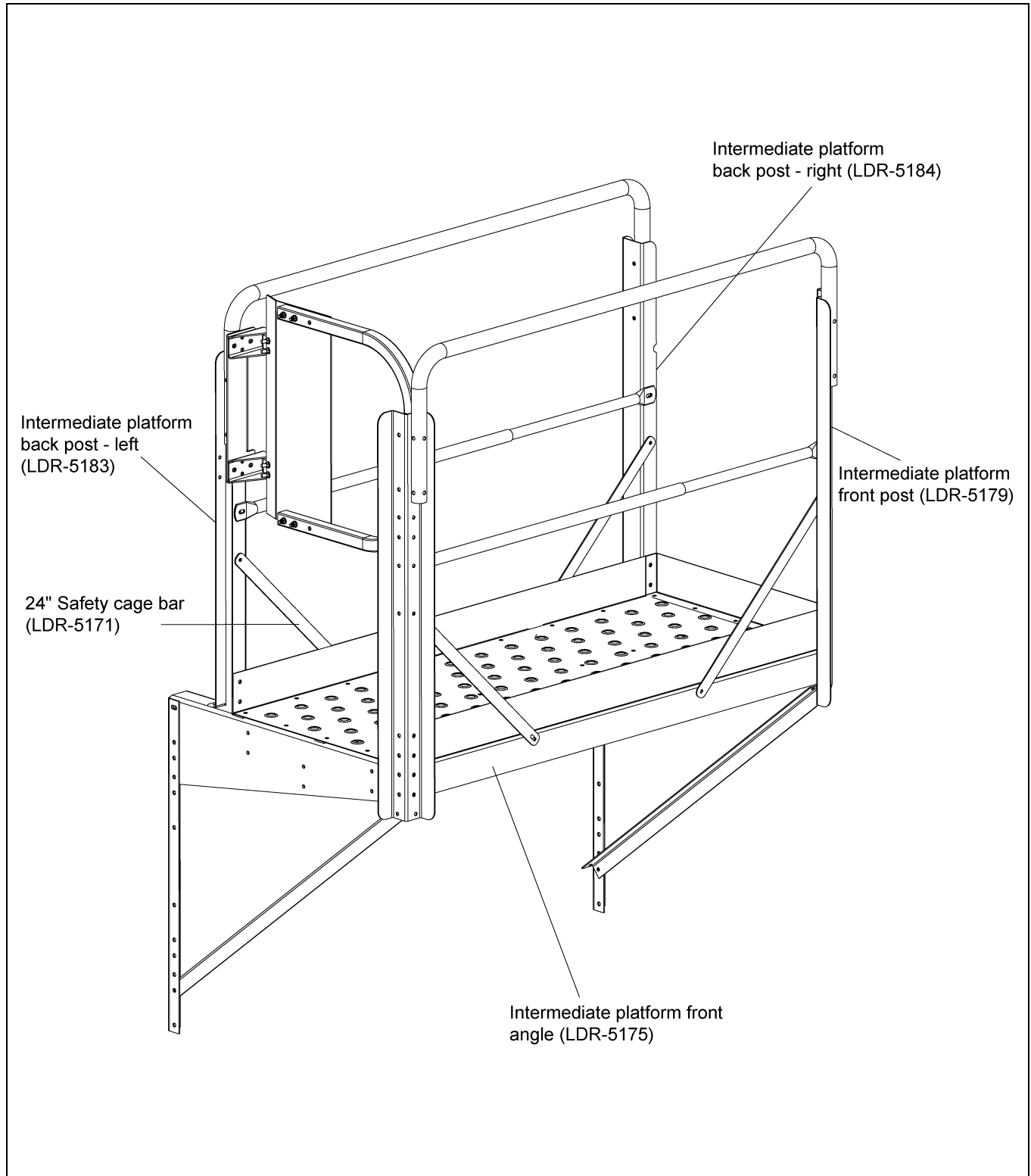


Figure 4AH

4. Assembly Instructions

Platform and Ladder Cage Package

4. Assemble the ladder and ladder brackets to the intermediate platform bracket using 5/16" hardware. The top ladder rung must be level with the platform floor. (See Figure 4AI.)

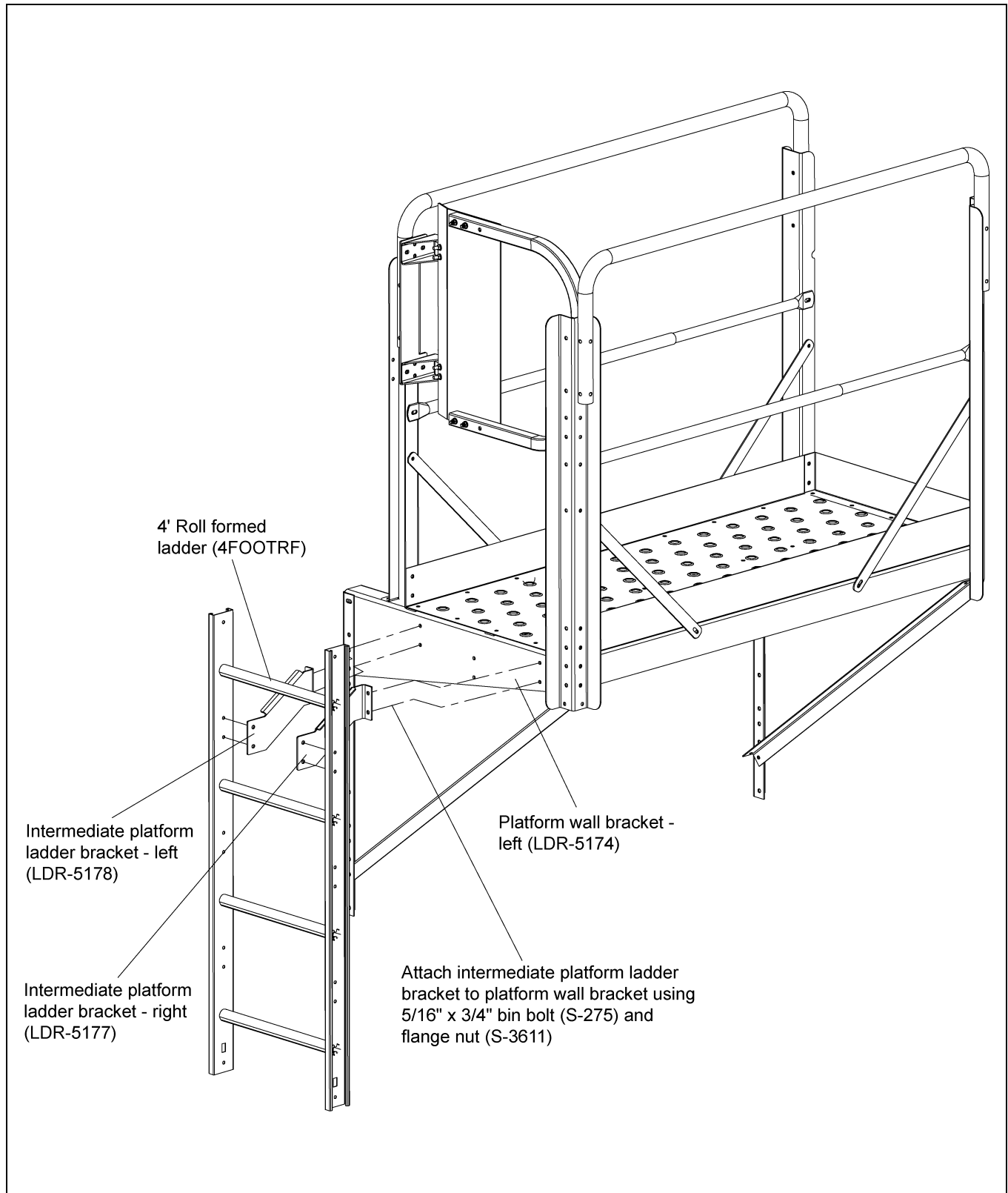


Figure 4AI

Platform and Cage Package

5. Attach the ladder flare to the ladder using 5/16" hardware. You must drill the bottom hole through the ladder and use 5/16" hardware. (See Figure 4AJ.)

Attach the narrow safety cage bracket, cage hoops and cage splice brackets to the ladder flares and platform posts. This must all be assembled at the same time using 5/16" hardware.

NOTE: *Be sure the ladder flares are vertical and parallel to the platform posts by adjusting the splice brackets. The ladder should be square to the platform.*

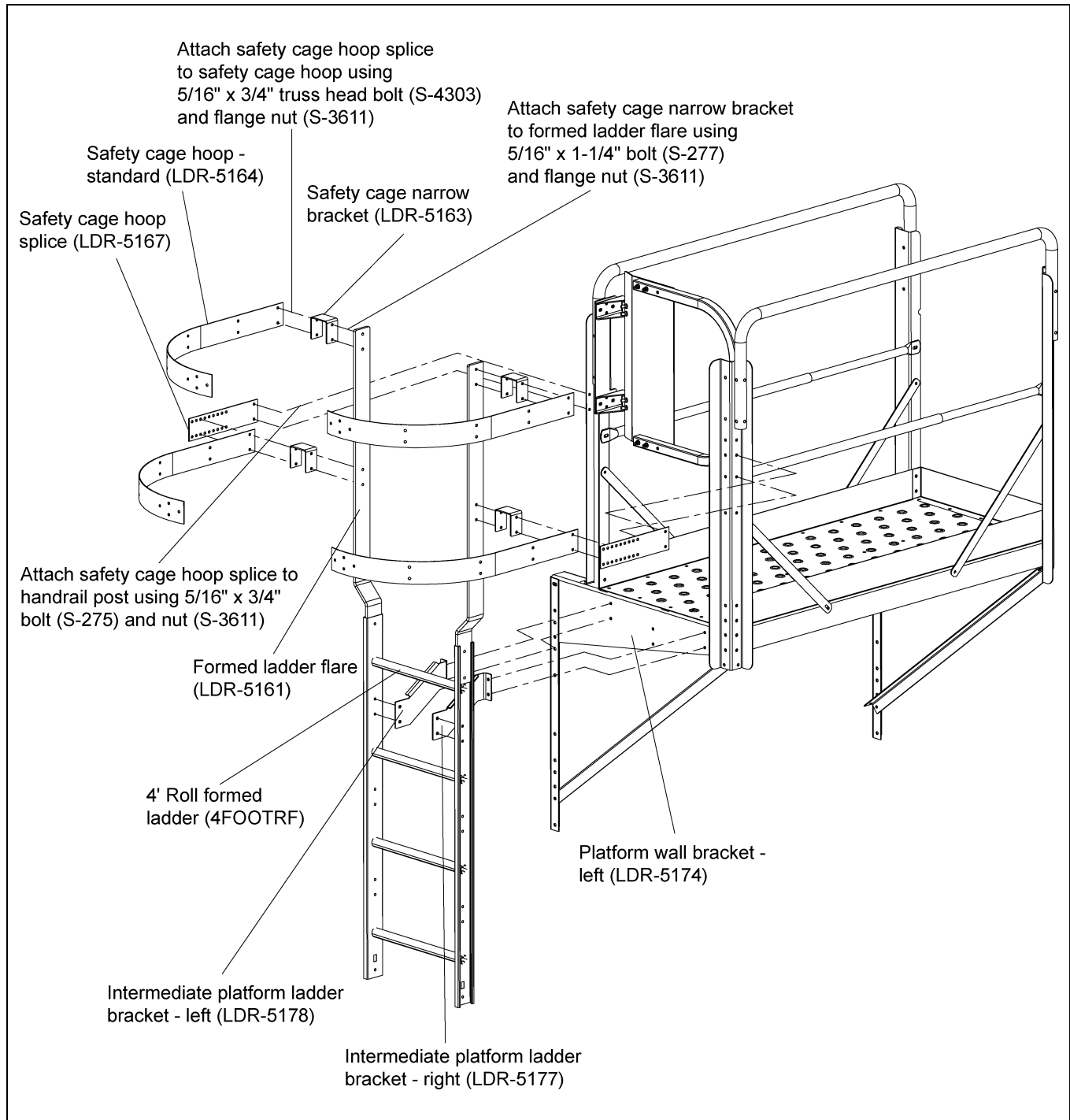


Figure 4AJ

Platform and Cage Package (Continued)

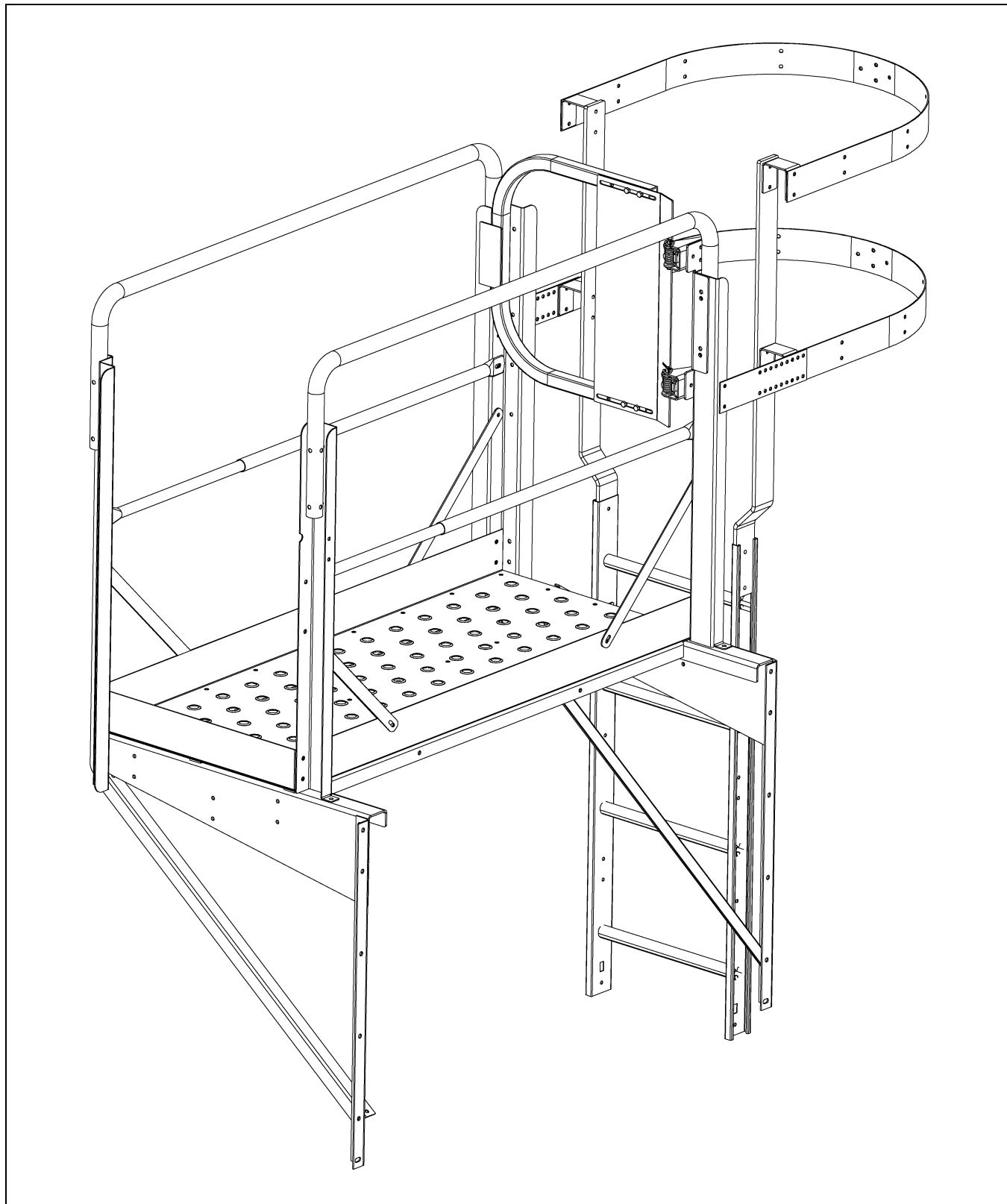


Figure 4AK

NOTE: *See Pages 34-39 for ladder and cage assembly.*

“X” Series Sidedraw Ladder Platform Package (LDR-5301-X)

Platform Package

1. Attach the wall angle to the sidewall sheet with 3/8" hardware. Assemble the left and right intermediate platform brackets to the wall angles with 3/8" hardware. [\(See Figure 4AL.\)](#)

NOTE: Leave all hardware loose until completely assembled.

Assemble the platform to the front and back angles and platform brackets using the 5/16" truss bolts. Using 5/16" hardware, assemble ladder sidewall angle to intermediate platform bracket.

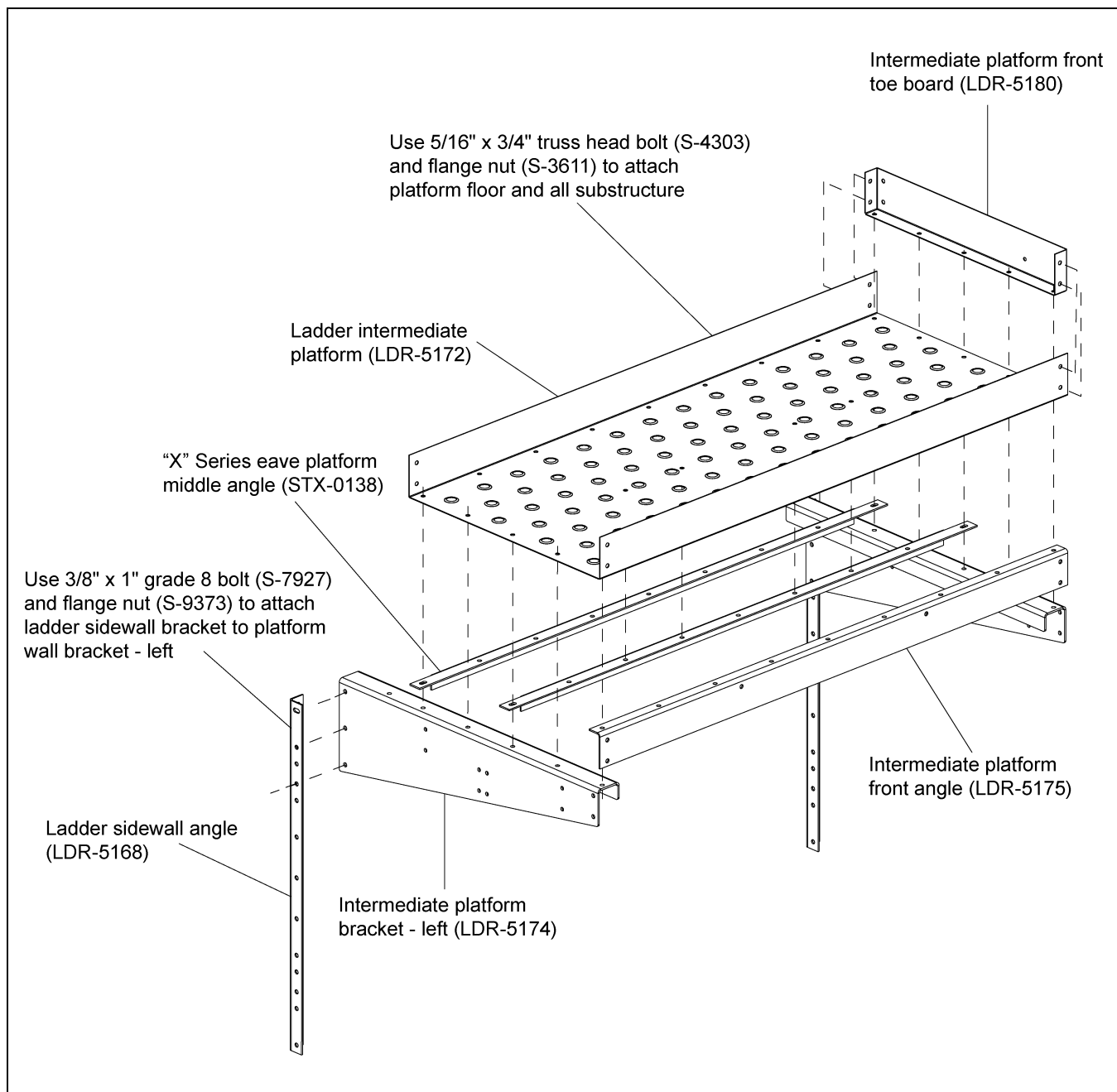


Figure 4AL

4. Assembly Instructions

Platform and Safety Cage Bar Package

2. Assemble platform post and 24" safety cage bar to platform with 5/16" hardware. Attach eave platform wall brace to platform handrail post with 5/16" hardware. (See Figure 4AM.)

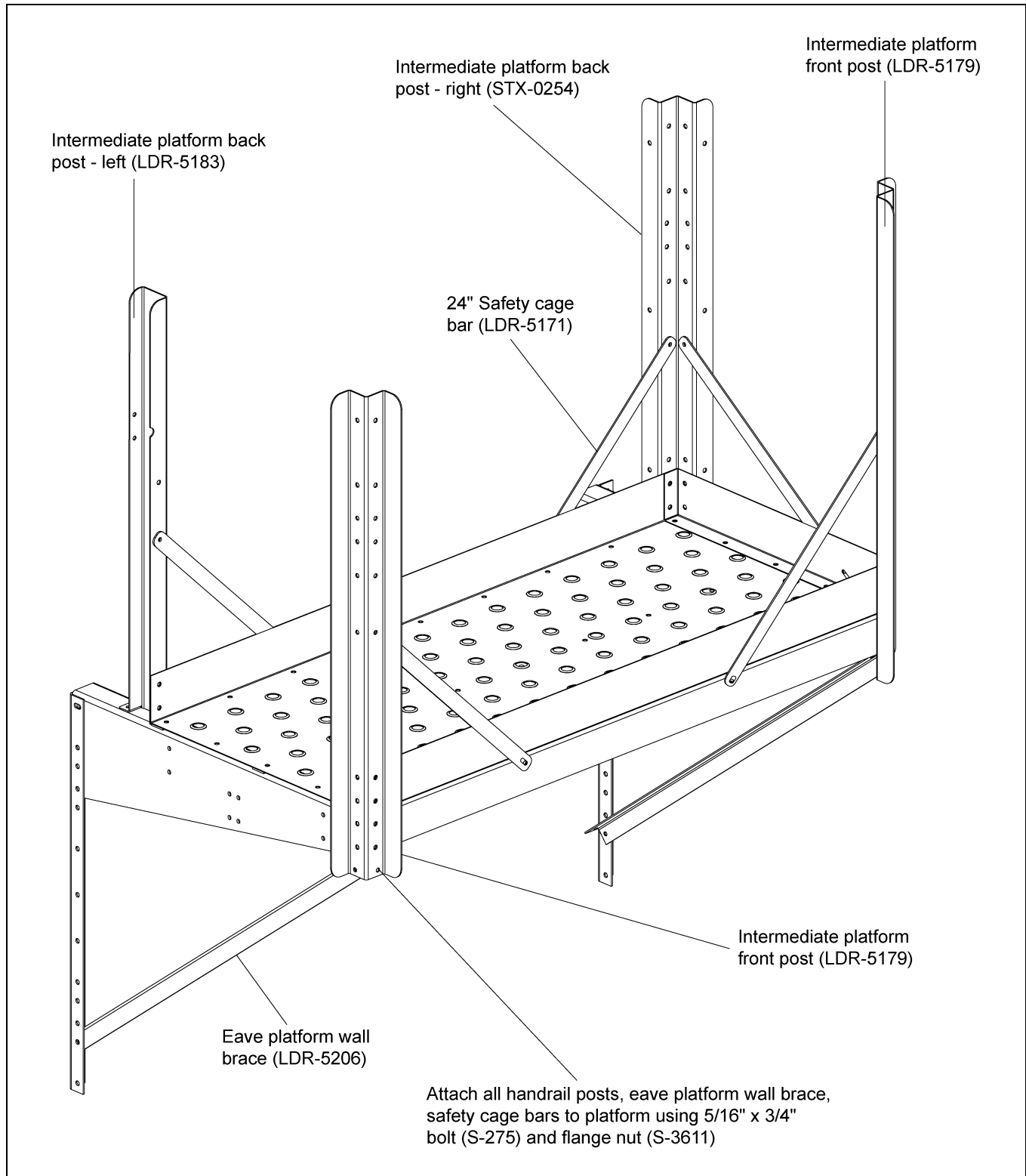


Figure 4AM

Platform and Handrail Package

3. Assemble top and intermediate handrails to the post using 5/16" hardware. *(See Figure 4AN.)*

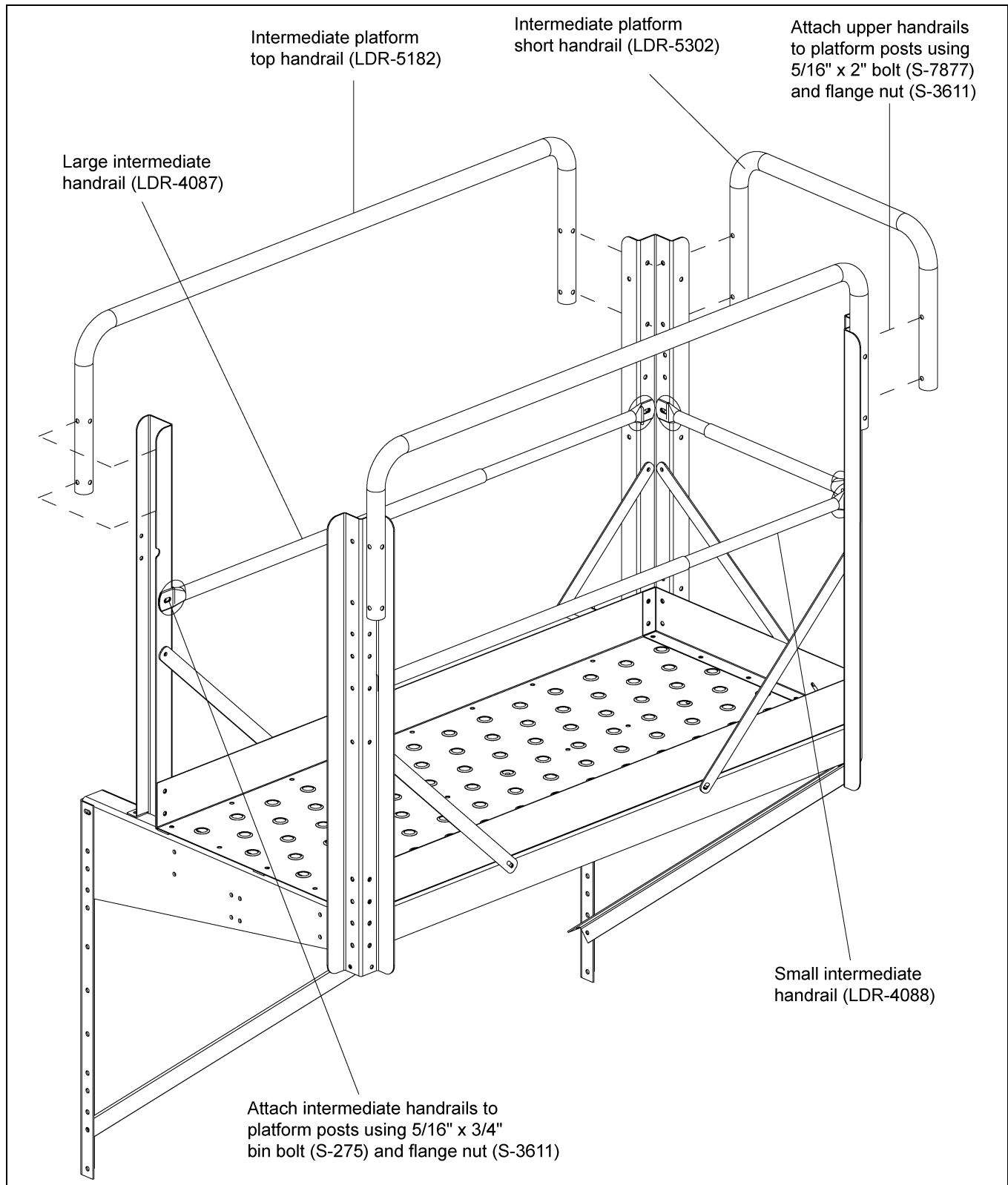


Figure 4AN

4. Assembly Instructions

Platform and Swing Gate Package

4. Assemble the platform gate bracket to the gate before attaching it to the platform back post using 5/16" hardware. (See Figure 4AO.)

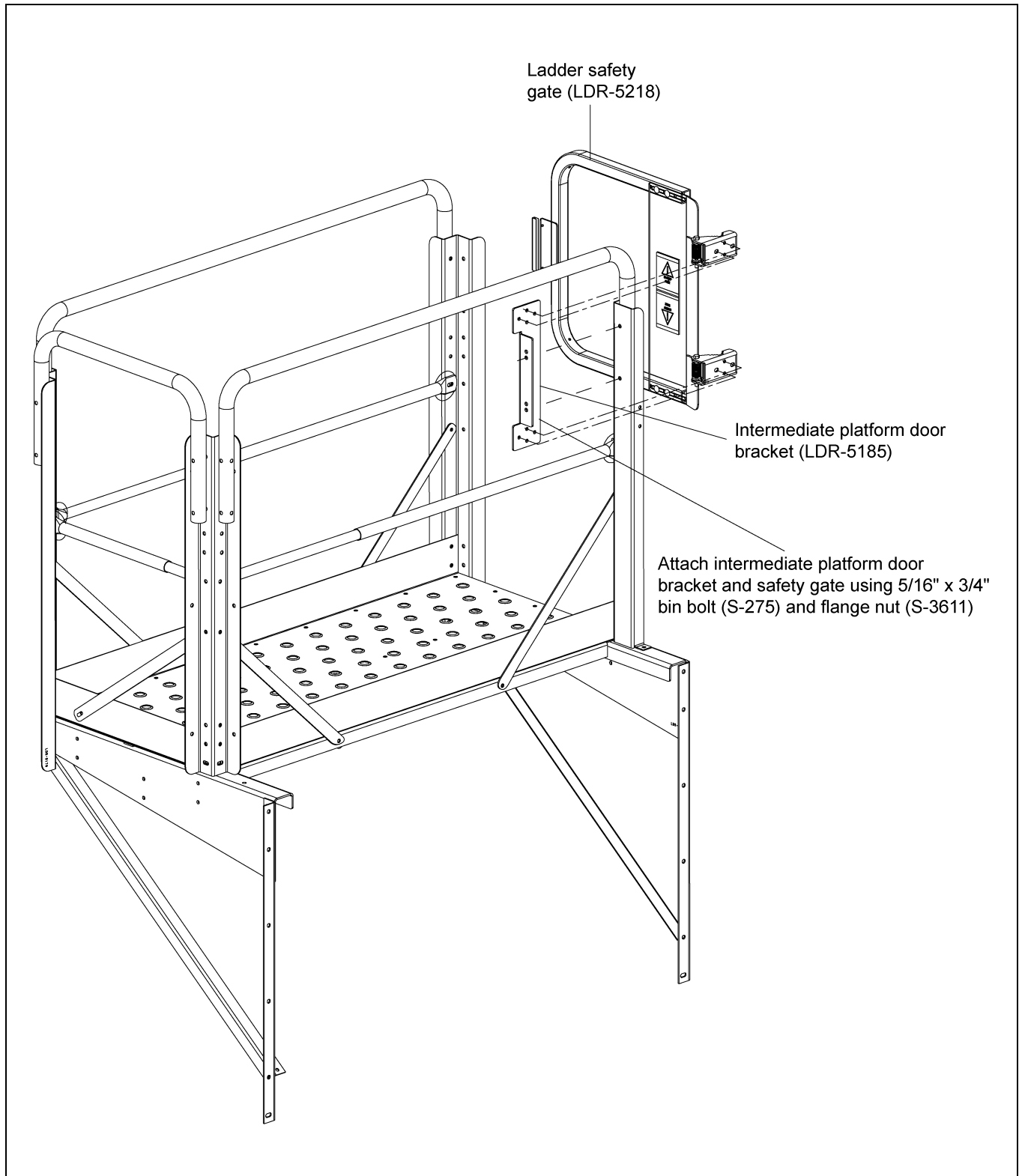


Figure 4AO

Platform and Safety Cage Package

5. Attach the ladder flare to the ladder using 5/16" hardware. You must drill the bottom hole through the ladder and use 5/16" hardware. (See Figure 4AP.)

Attach the narrow safety cage bracket, cage hoops and cage splice brackets to the ladder flares and platform posts. This must all be assembled at the same time using 5/16" hardware.

NOTE: *Be sure the ladder flares are vertical and parallel to the platform posts by adjusting the splice brackets. The ladder should be square to the platform.*

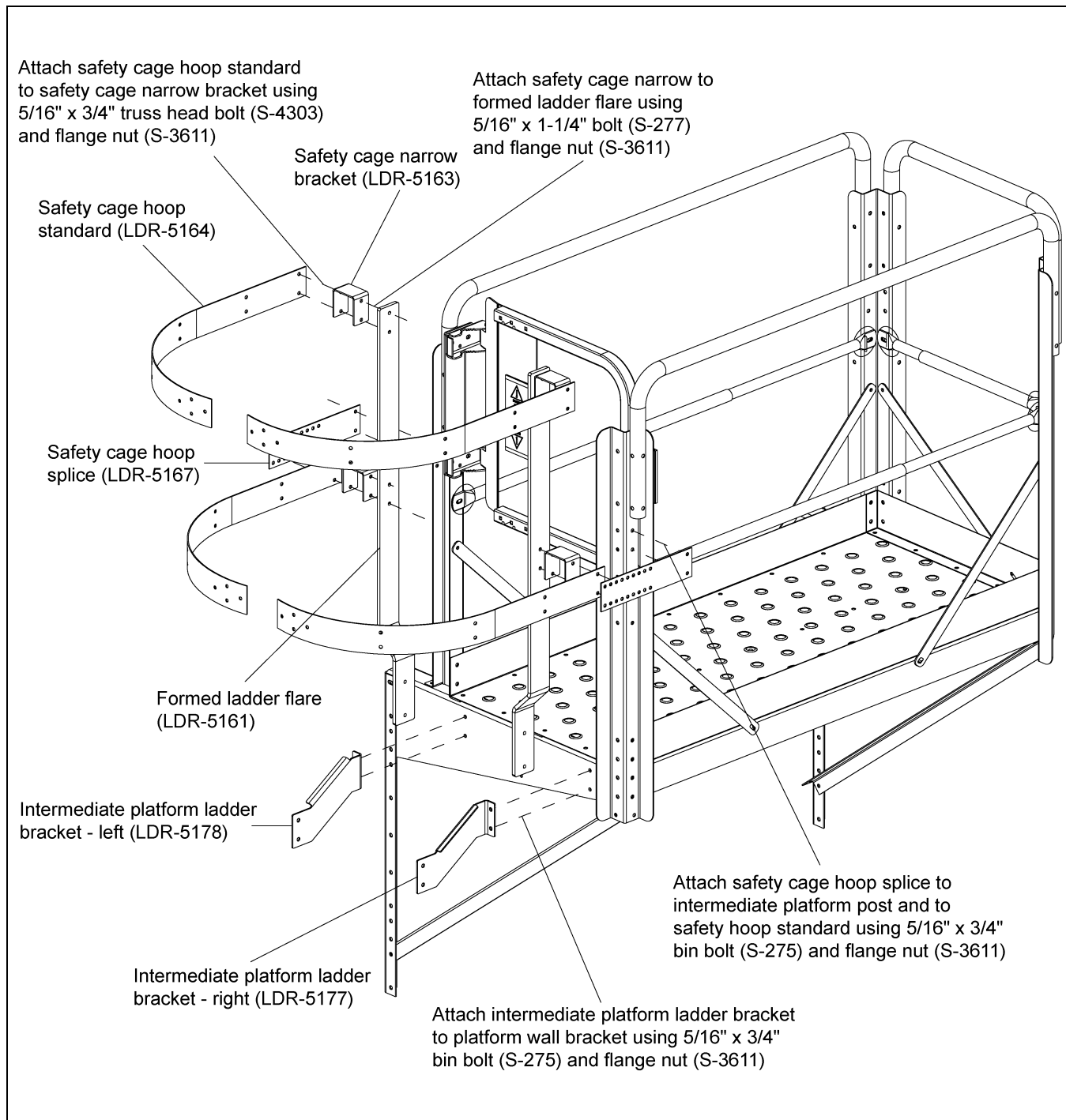


Figure 4AP

4. Assembly Instructions

Platform Ladder Bracket Package

6. Assemble the ladder to ladder brackets using 5/16" hardware. The top ladder rung must be level with the platform floor. (See Figure 4AQ below and Figure 4AR on Page 53.)

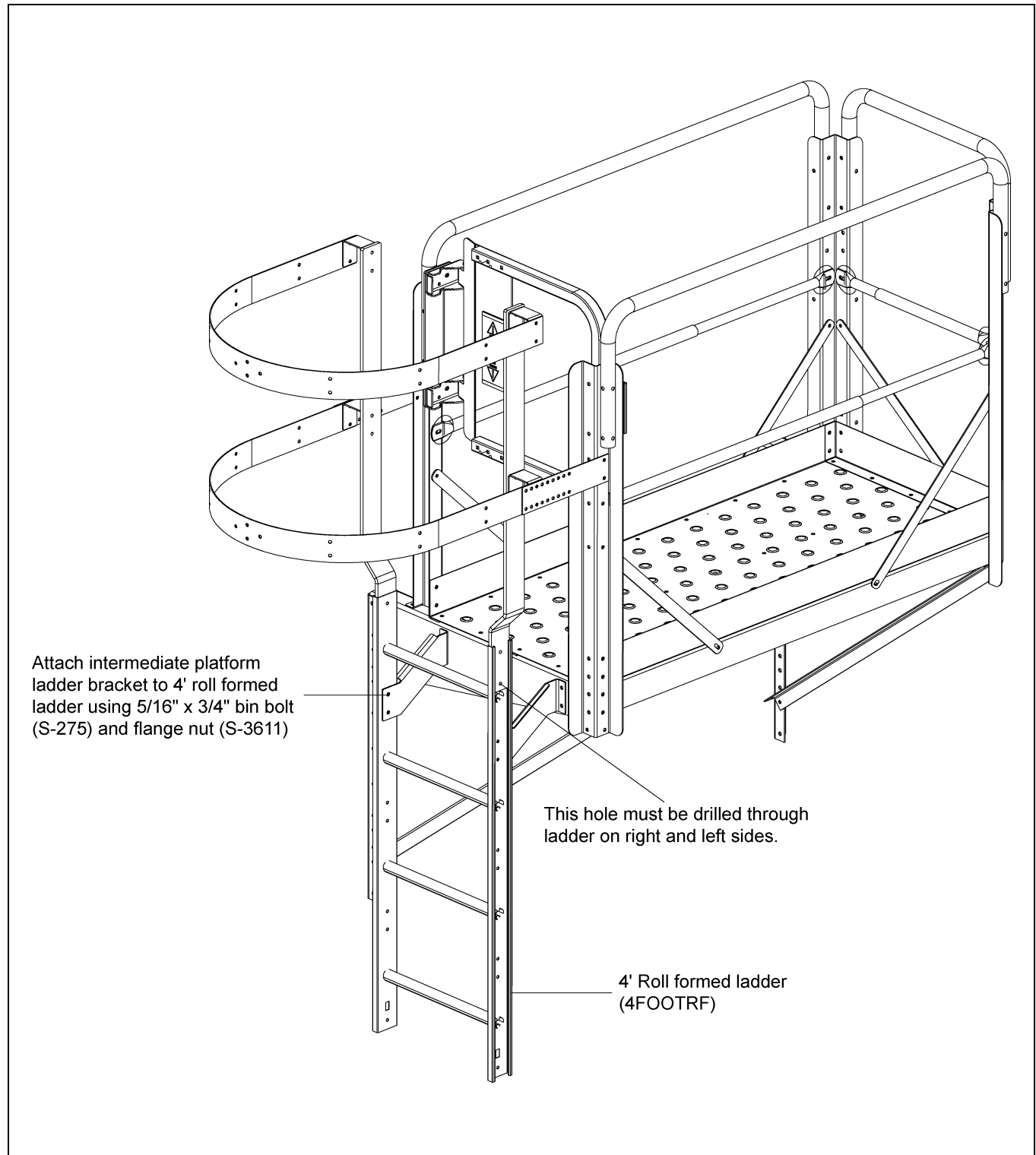
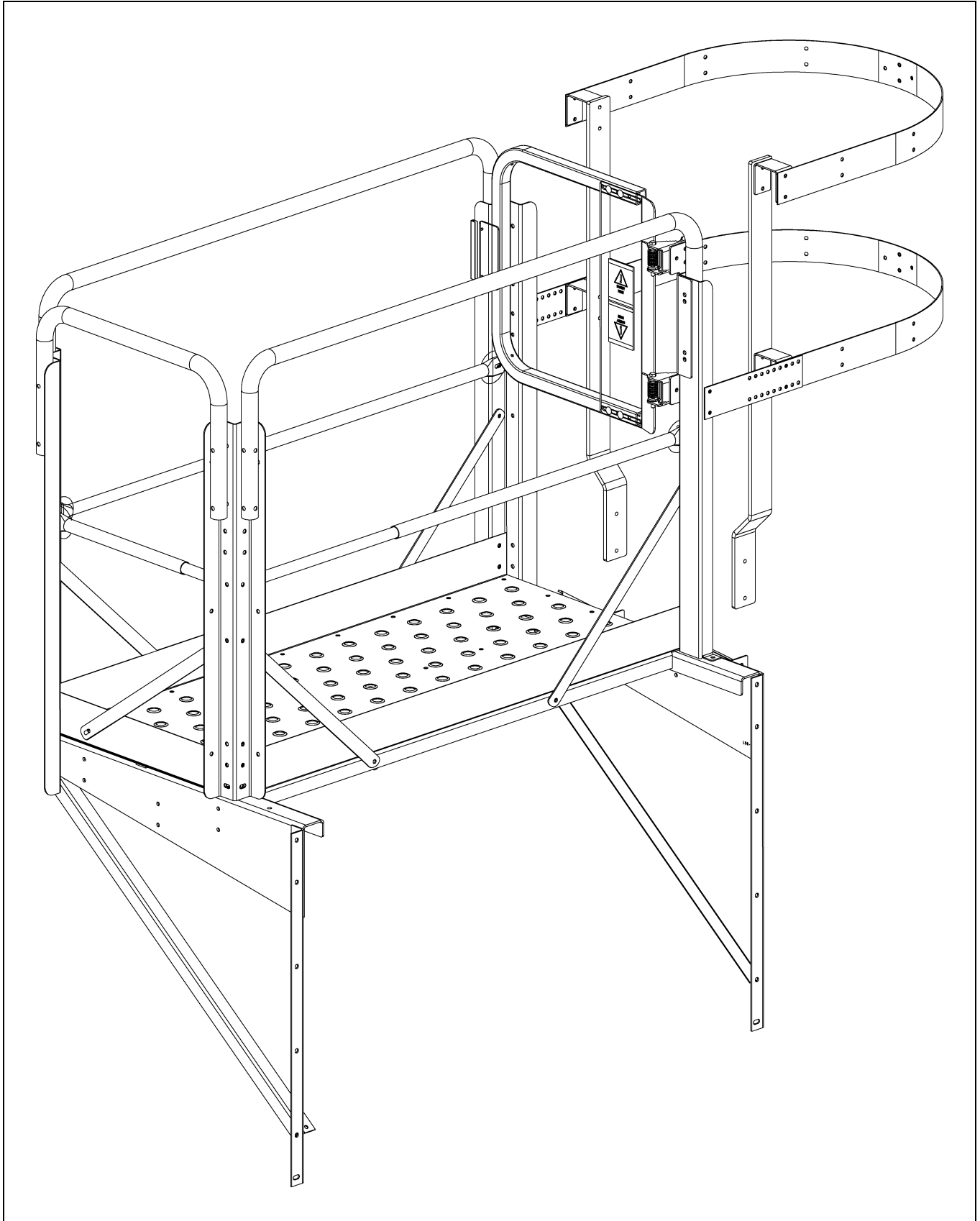


Figure 4AQ

NOTE: See Pages 34-39 for ladder assembly instructions.

Platform Ladder Bracket Package (Continued)**Figure 4AR**

4. Assembly Instructions

- Platform placed at the bottom of the ring in which sidedraw placed. [Figure 4AS](#) shows placement of 7 ring ladder package platform with sidedraw in 7th ring. (See [Figure 4AS.](#))

NOTE: *Shown for placement purposes only. Ladder mounting parts not shown.*
[See Pages 34-39](#) for ladder assembly instructions.

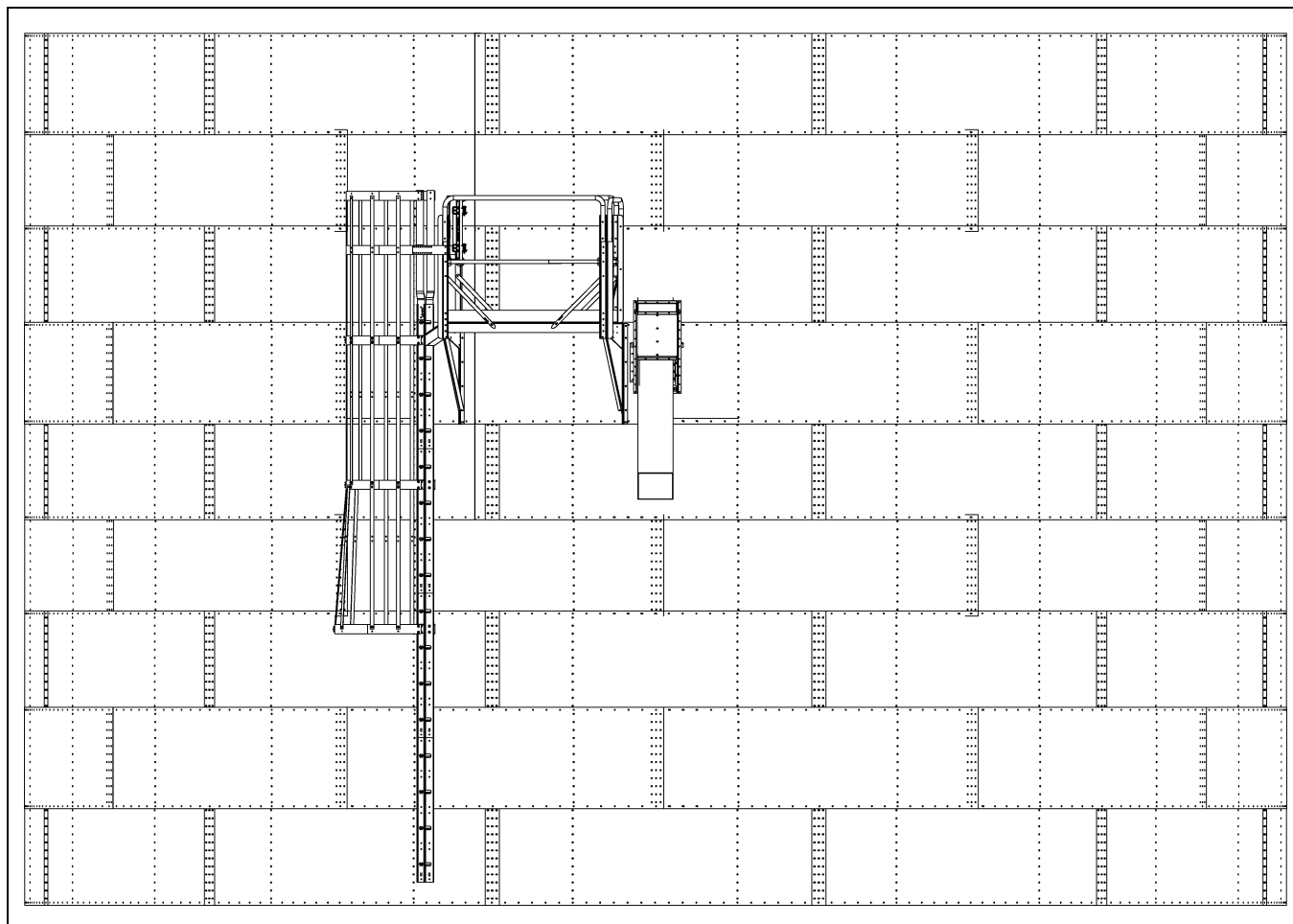
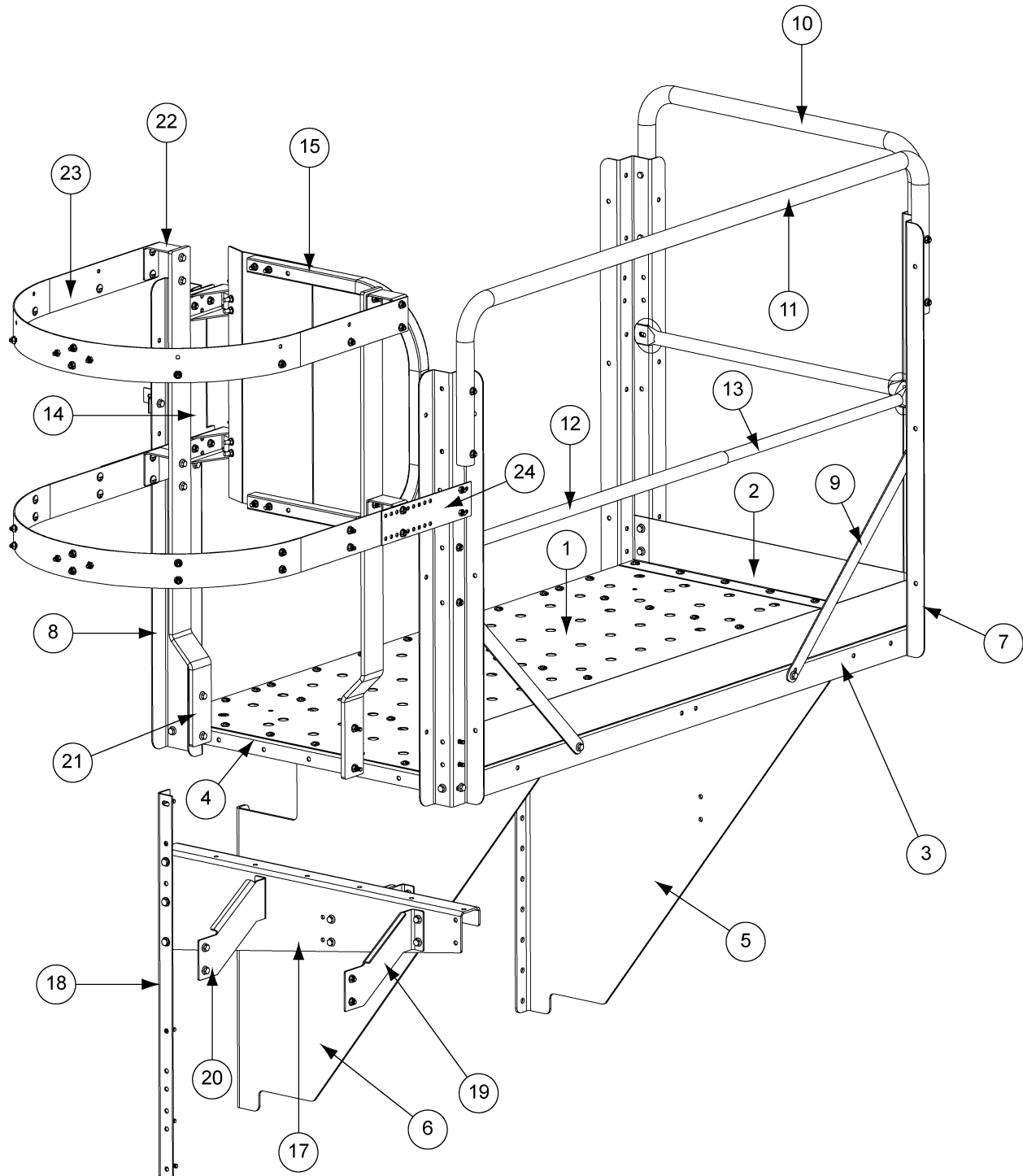


Figure 4AS

1. 72'-135' Ladder Eave Platform Assembly (LDR-5193)
2. 42'-60' Bins Ladder Eave Platform (LDR-5208)
3. "X" Series Ladder Intermediate Platform Package (LDR-5196)
4. "X" Series Sidedraw Ladder Platform Package (LDR-5301)

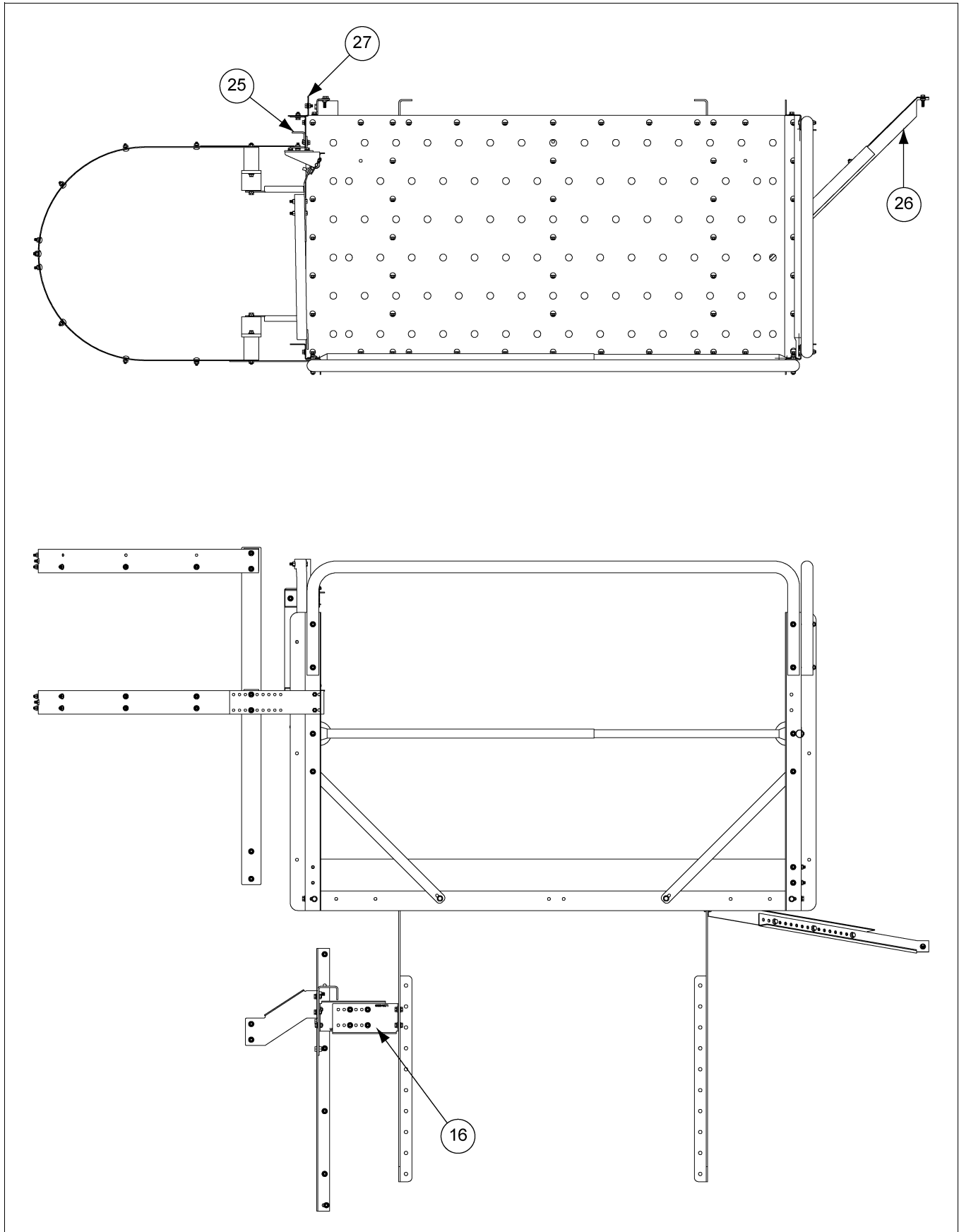
72'-135' Ladder Eave Platform Assembly (LDR-5193)



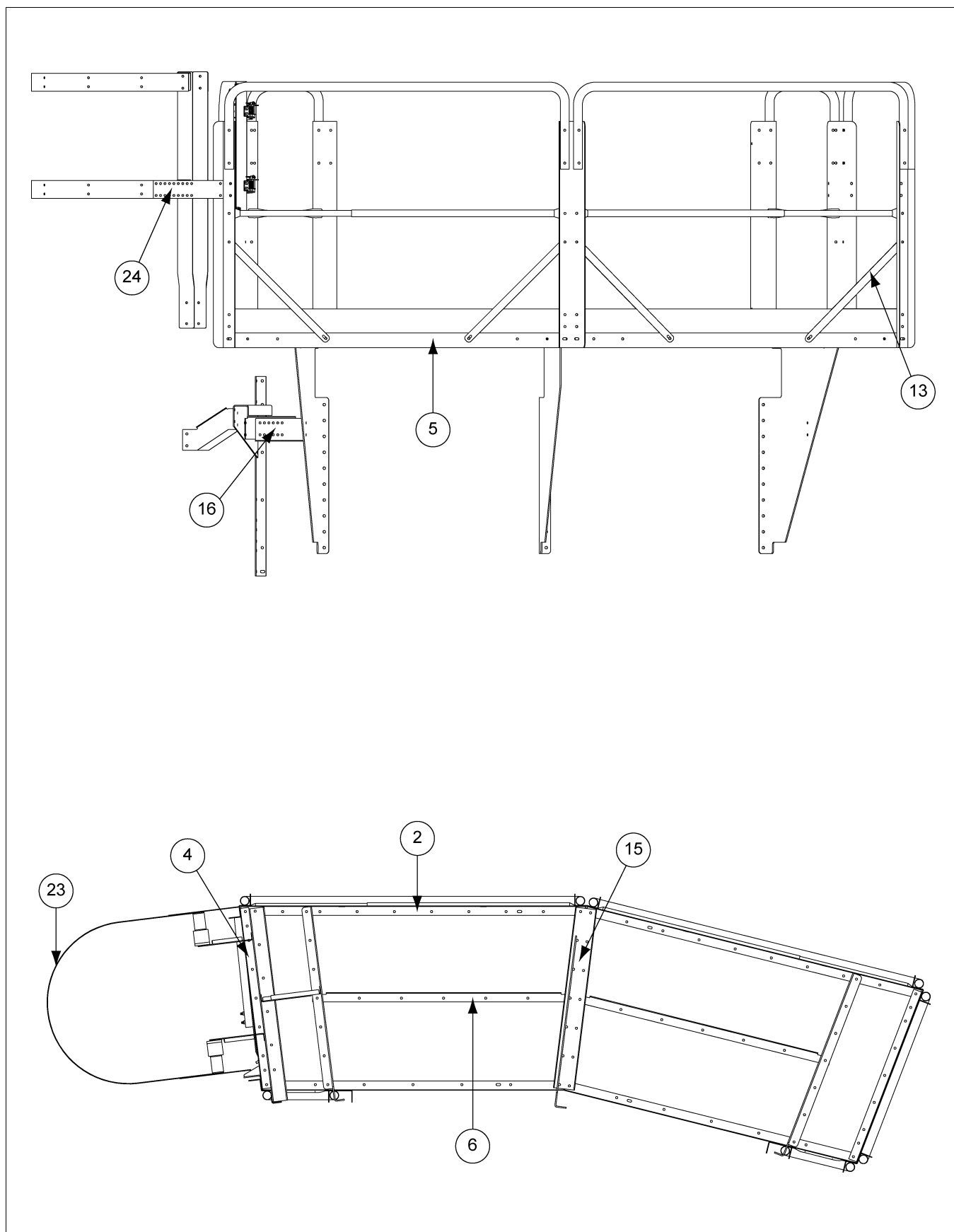
72'-135' Ladder Eave Platform Assembly (LDR-5193) Parts List

Ref #	Part #	Description	Qty
1	STX-0080	Single Piece Platform Floor	1
2	STX-0014	Platform Toe Plate	1
3	STX-0081	"X" Series Platform Long Angle	2
4	STX-0011	Platform Short Angle	3
5	STX-0082	"X" Series Platform Bracket - Right	1
6	STX-0009	"X" Series Platform Bracket - Left	1
7	STX-0015	Platform Corner Post	3
8	STX-0076	Platform Corner Post	1
9	LDR-5171	24" Safety Cage Bar	2
10	STX-0038	Platform Handrail Short	1
11	STX-0075	Eave Platform Top Rail - Long	1
12	LDR-4087	Large Intermediate Handrail	2
13	LDR-4088	Small Intermediate Handrail	2
14	LDR-5185	Intermediate Platform Door Bracket	1
15	LDR-5218	Ladder Safety Gate	1
16	LDR-5159	Ladder Standoff Support	2
17	LDR-5174	Platform Wall Bracket - Left	1
18	LDR-5168	Ladder Sidewall Angle	1
19	LDR-5177	Intermediate Platform Ladder Bracket - Right	1
20	LDR-5178	Intermediate Platform Ladder Bracket - Left	1
21	LDR-5161	Formed Ladder Flare	2
22	LDR-5163	Safety Cage Narrow Bracket	4
23	LDR-5164	Safety Cage Hoop - Standard	4
24	LDR-5167	Safety Cage Hoop Splice	2
25	LDR-5204	Safety Cage Splice Bracket	1
26	LDR-5206	Eave Platform Wall Brace	2
27	LDR-5207	Eave Platform Inside Post Bracket	1
N/S	LDR-5173	Intermediate Platform Bracket - Right	1
N/S	LDR-5205	Eave Platform Post Support	1

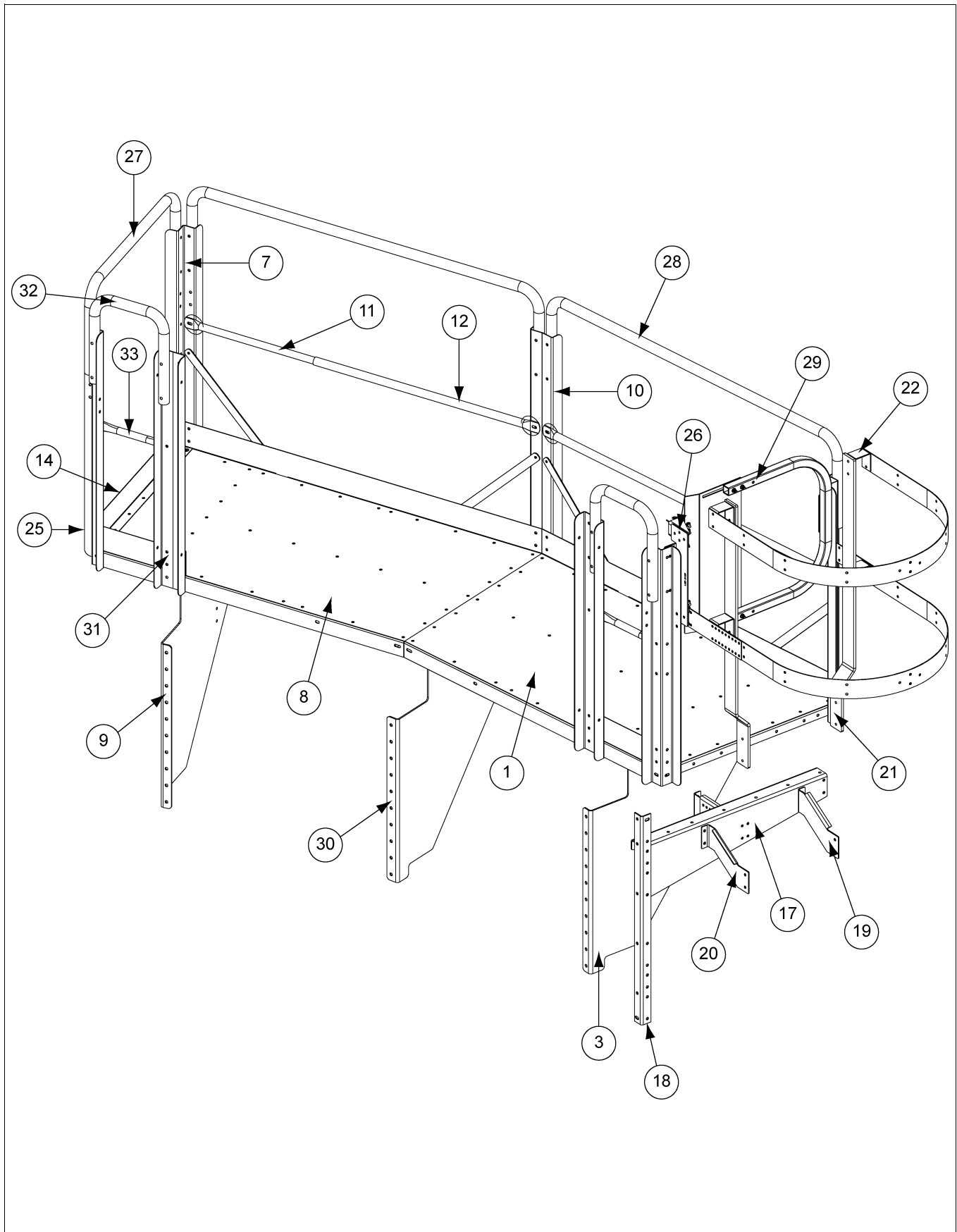
72'-135' Ladder Eave Platform Assembly (LDR-5193) (Continued)



42'-60' Bins Ladder Eave Platform (LDR-5208)



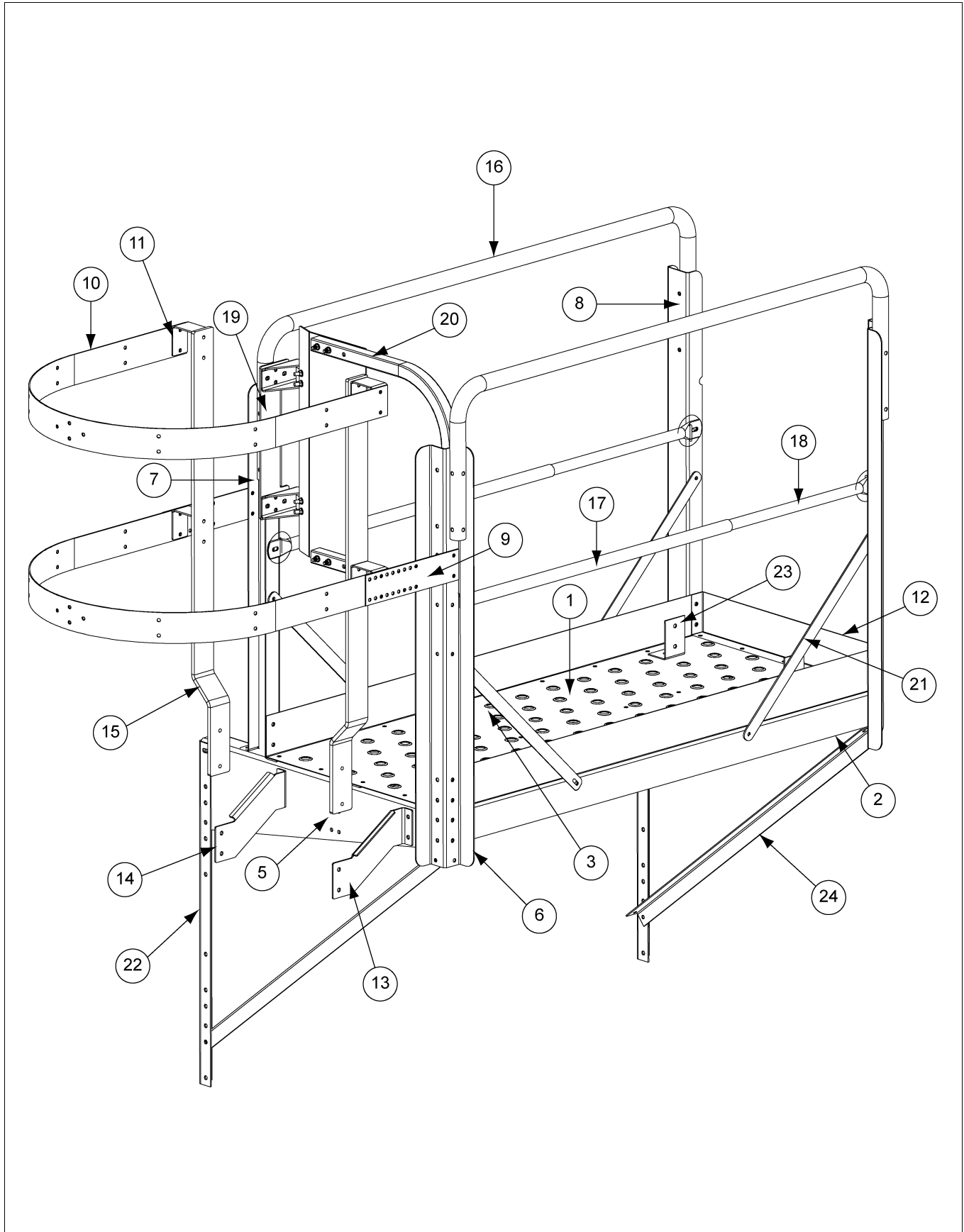
42'-60' Bins Ladder Eave Platform (LDR-5208) (Continued)



42'-60' Bins Ladder Eave Platform (LDR-5208) Parts List

Ref #	Part #	Description	Qty
1	STX-0134	Single Piece Long Eave Platform Floor	1
2	STX-0136	"X" Series Platform Long Angle	2
3	STX-0009	"X" Series Platform Bracket - Left	1
4	STX-0011	Platform Short Angle	2
5	STX-0137	"X" Series Platform Short Angle	2
6	STX-0138	"X" Series Eave Platform Middle Angle	2
7	STX-0139	Platform Corner Post	2
8	STX-0140	"X" Series Eave Platform Floor - Right	1
9	STX-0082	"X" Series Platform Bracket - Right	1
10	STX-0141	"X" Series Eave Platform Outside Center Post	1
11	LDR-4088	Small Intermediate Handrail	2
12	LDR-4087	Large Intermediate Handrail	2
13	LDR-5171	24" Safety Cage Bar	4
14	STX-0142	"X" Series Eave Platform Toe Board	1
15	STX-0143	"X" Series Long Eave Platform Splice Angle	1
16	LDR-5159	Ladder Standoff Support	2
17	LDR-5174	Platform Wall Bracket - Left	1
18	LDR-5168	Ladder Sidewall Angle	1
19	LDR-5177	Intermediate Platform Ladder Bracket - Right	1
20	LDR-5178	Intermediate Platform Ladder Bracket - Left	1
21	LDR-5161	Formed Ladder Flare	2
22	LDR-5163	Safety Cage Narrow Bracket	4
23	LDR-5164	Safety Cage Hoop - Standard	4
24	LDR-5167	Safety Cage Hoop Splice	2
25	STX-0144	"X" Series Eave Platform Inside Corner Post	2
26	LDR-5185	Intermediate Platform Door Bracket	1
27	STX-0038	Platform Handrail Short	1
28	STX-0145	"X" Series Eave Platform Top Rail - Long	2
29	LDR-5218	Ladder Safety Gate	1
30	STX-0135	"X" Series Platform Bracket - Left	1
31	STX-0146	"X" Series Eave Platform Inside Center Post	2
32	STX-0147	"X" Series Eave Platform Inside Top Rail	2
33	STX-0148	"X" Series Eave Platform Inside Intermediate Rail	2

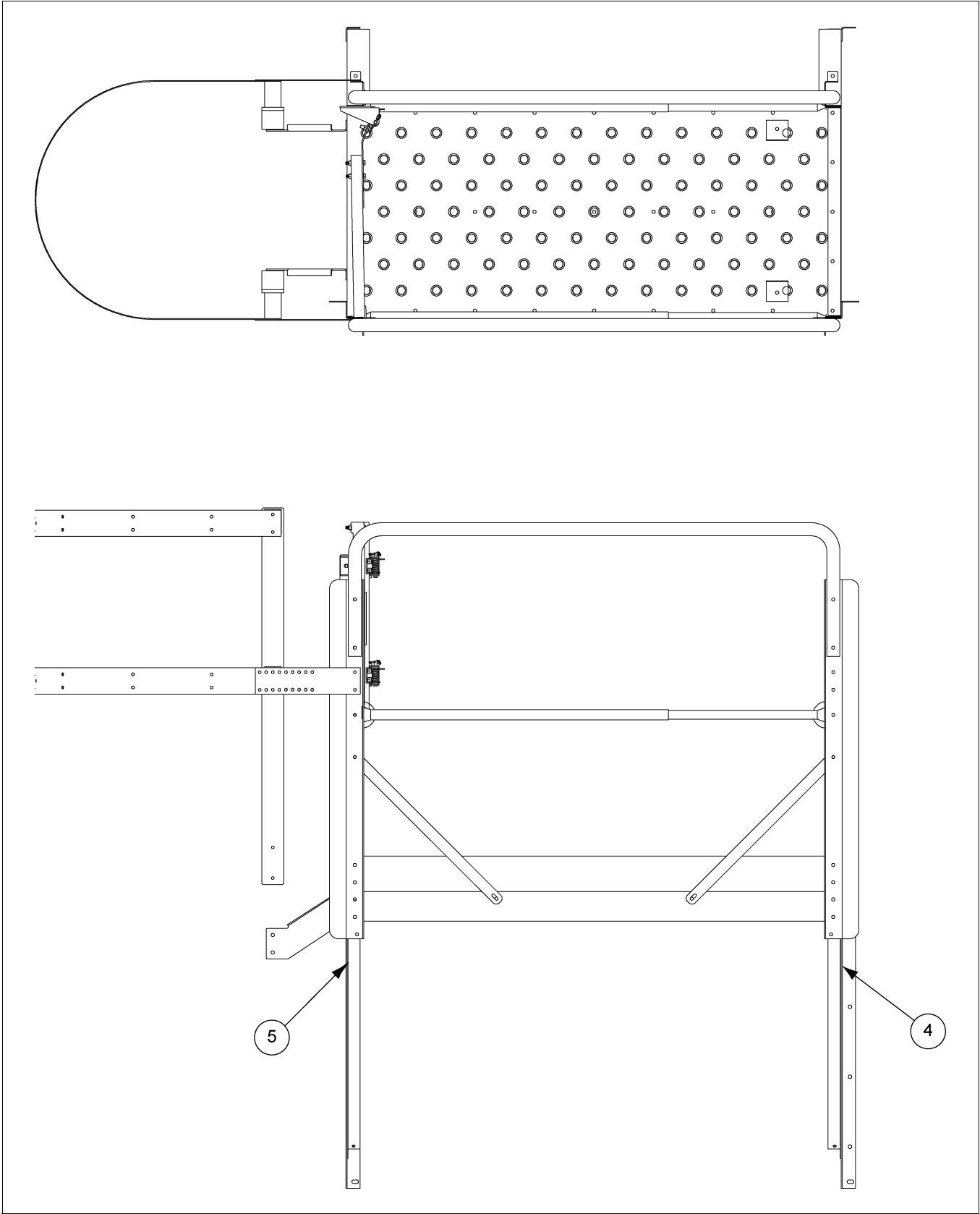
"X" Series Ladder Intermediate Platform Package (LDR-5196)



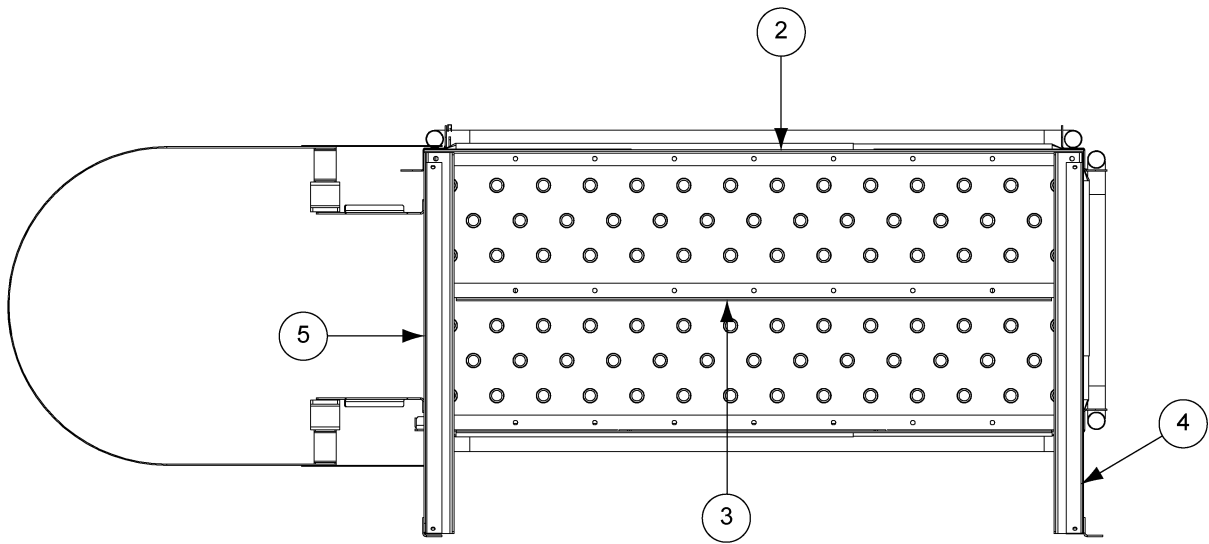
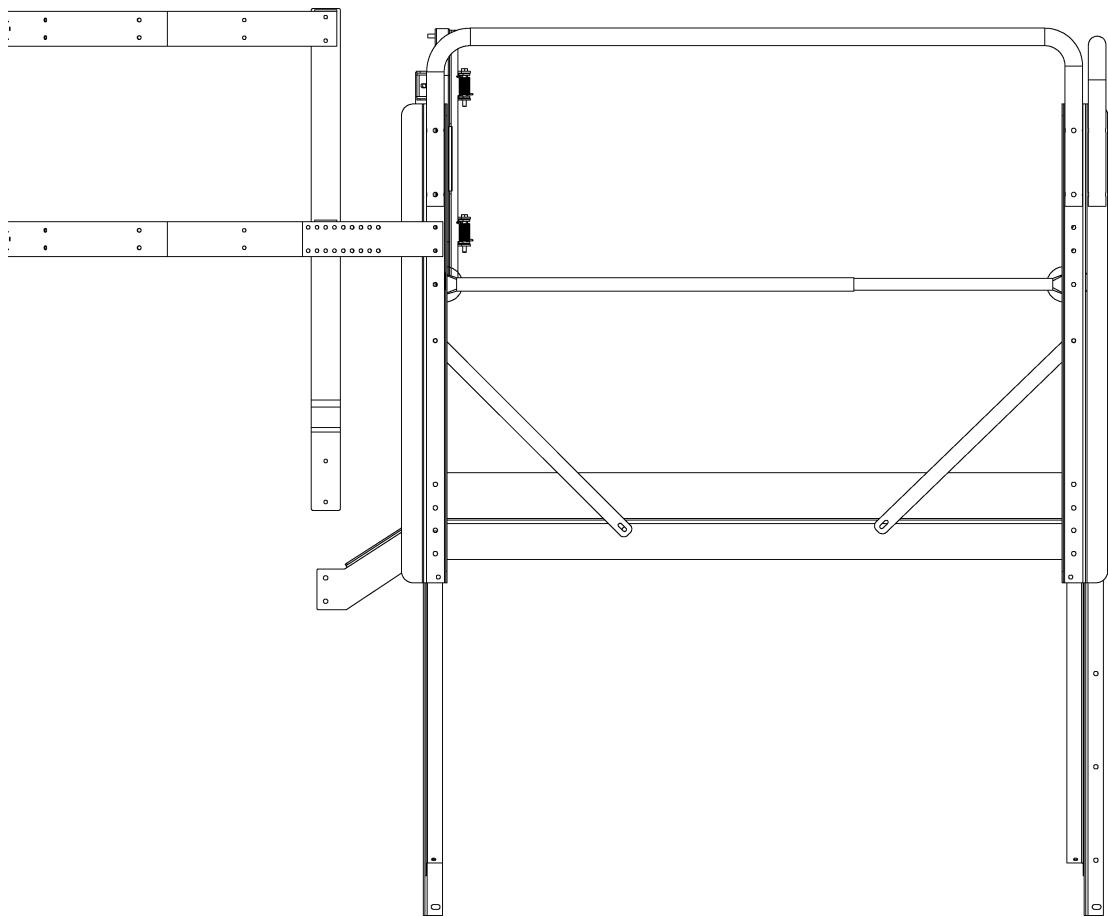
"X" Series Ladder Intermediate Platform Package (LDR-5196) Parts List

Ref #	Part #	Description	Qty
1	LDR-5172	Ladder Intermediate Platform	1
2	LDR-5175	Intermediate Platform Front Angle	1
3	STX-0138	"X" Series Eave Platform Middle Angle	2
4	LDR-5173	Intermediate Platform Bracket - Right	1
5	LDR-5174	Platform Wall Bracket - Left	1
6	LDR-5179	Intermediate Platform Front Post	2
7	LDR-5183	Intermediate Platform Back Post - Left	1
8	LDR-5184	Intermediate Platform Back Post - Right	1
9	LDR-5167	Safety Cage Hoop Splice	2
10	LDR-5164	Safety Cage Hoop - Standard	4
11	LDR-5163	Safety Cage Narrow Bracket	4
12	LDR-5180	Intermediate Platform Toe Board	1
13	LDR-5177	Intermediate Platform Ladder Bracket - Right	1
14	LDR-5178	Intermediate Platform Ladder Bracket - Left	1
15	LDR-5161	Formed Ladder Flare	2
16	LDR-5182	Intermediate Platform Handrail	2
17	LDR-4087	Large Intermediate Handrail	2
18	LDR-4088	Small Intermediate Handrail	2
19	LDR-5185	Intermediate Platform Door Bracket	1
20	LDR-5218	Ladder Safety Gate	1
21	LDR-5171	24" Safety Cage Bar	4
22	LDR-5168	Ladder Sidewall Angle	2
23	LDR-5181	Intermediate Platform Ladder Base	2
24	LDR-5200	Intermediate Platform Wall Brace	2

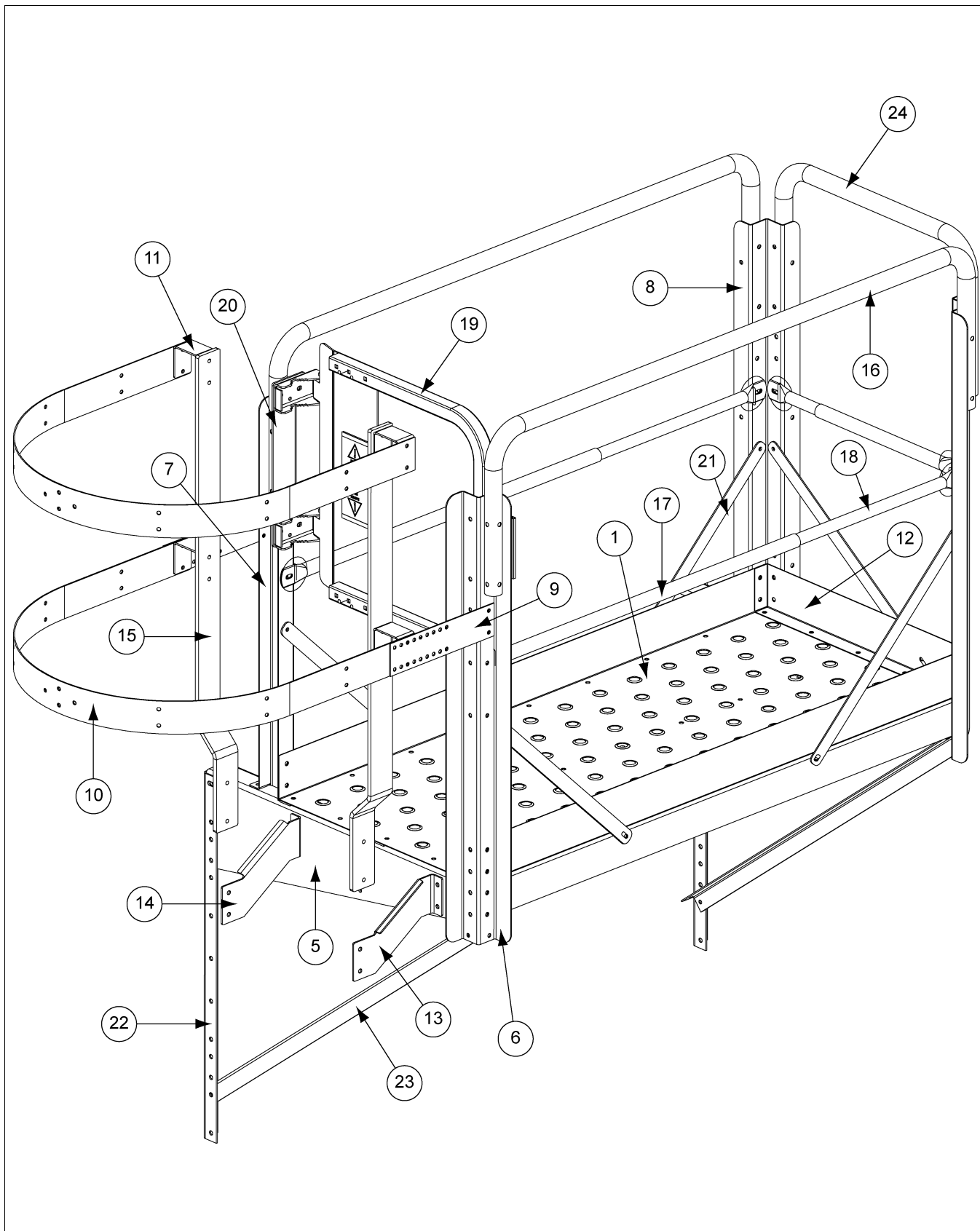
“X” Series Ladder Intermediate Platform Package (LDR-5196)
(Continued)



“X” Series Sidedraw Ladder Platform Package (LDR-5301)



“X” Series Sidedraw Ladder Platform Package (LDR-5301) **(Continued)**



"X" Series Sidedraw Ladder Platform Package (LDR-5301) Parts List

Ref #	Part #	Description	Qty
1	LDR-5172	Ladder Intermediate Platform	1
2	LDR-5175	Intermediate Platform Front Angle	1
3	LDR-5176	Intermediate Platform Back Angle	2
4	LDR-5173	Intermediate Platform Bracket - Right	1
5	LDR-5174	Platform Wall Bracket - Left	1
6	LDR-5179	Intermediate Platform Front Post	2
7	LDR-5183	Intermediate Platform Back Post - Left	1
8	STX-0254	Platform Corner Post	1
9	LDR-5167	Safety Cage Hoop Splice	2
10	LDR-5164	Safety Cage Hoop - Standard	4
11	LDR-5163	Safety Cage Narrow Bracket	4
12	LDR-5180	Intermediate Platform Toe Board	1
13	LDR-5177	Intermediate Platform Ladder Bracket - Right	1
14	LDR-5178	Intermediate Platform Ladder Bracket - Left	1
15	LDR-5161	Formed Ladder Flare	2
16	LDR-5182	Intermediate Platform Handrail	2
17	LDR-4087	Large Intermediate Handrail	3
18	LDR-4088	Small Intermediate Handrail	3
19	LDR-5218	Ladder Safety Gate	1
20	LDR-5185	Intermediate Platform Door Bracket	1
21	LDR-5171	24" Safety Cage Bar	5
22	LDR-5168	Ladder Sidewall Angle	2
23	LDR-5200	Intermediate Platform Wall Brace	2
24	LDR-5302	Platform Handrail Short	1

NOTES

GSI Group, LLC Limited Warranty

The GSI Group, LLC ("GSI") warrants products which it manufactures to be free of defects in materials and workmanship under normal usage and conditions for a period of 12 months after sale to the original end-user or if a foreign sale, 14 months from arrival at port of discharge, whichever is earlier. The end-user's sole remedy (and GSI's only obligation) is to repair or replace, at GSI's option and expense, products that in GSI's judgment, contain a material defect in materials or workmanship. Expenses incurred by or on behalf of the end-user without prior written authorization from the GSI Warranty Group shall be the sole responsibility of the end-user.

Warranty Extensions:

The Limited Warranty period is extended for the following products:

	Product	Warranty Period	
AP Fans and Flooring	Performer Series Direct Drive Fan Motor	3 Years	* Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 25% 5 to 7 years - end-user pays 50% 7 to 10 years - end-user pays 75%
	All Fiberglass Housings	Lifetime	
	All Fiberglass Propellers	Lifetime	
Cumberland Feeding/Watering Systems	Feeder System Pan Assemblies	5 Years **	** Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 50%
	Feed Tubes (1-3/4" and 2.00")	10 Years *	
	Centerless Augers	10 Years *	
	Watering Nipples	10 Years *	
Grain Systems	Grain Bin Structural Design	5 Years	† Motors, burner components and moving parts not included. Portable dryer screens included. Tower dryer screens not included.
Grain Systems Farm Fans Zimmerman	Portable and Tower Dryers	2 Years	
	Portable and Tower Dryer Frames and Internal Infrastructure †	5 Years	

GSI further warrants that the portable and tower dryer frame and basket, excluding all auger and auger drive components, shall be free from defects in materials for a period of time beginning on the twelfth (12th) month from the date of purchase and continuing until the sixtieth (60th) month from the date of purchase (extended warranty period). During the extended warranty period, GSI will replace the frame or basket components that prove to be defective under normal conditions of use without charge, excluding the labor, transportation, and/or shipping costs incurred in the performance of this extended warranty.

Conditions and Limitations:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH ABOVE. SPECIFICALLY, GSI MAKES NO FURTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) PRODUCT MANUFACTURED OR SOLD BY GSI OR (II) ANY ADVICE, INSTRUCTION, RECOMMENDATION OR SUGGESTION PROVIDED BY AN AGENT, REPRESENTATIVE OR EMPLOYEE OF GSI REGARDING OR RELATED TO THE CONFIGURATION, INSTALLATION, LAYOUT, SUITABILITY FOR A PARTICULAR PURPOSE, OR DESIGN OF SUCH PRODUCTS.

GSI shall not be liable for any direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. The sole and exclusive remedy is set forth in the Limited Warranty, which shall not exceed the amount paid for the product purchased. This warranty is not transferable and applies only to the original end-user. GSI shall have no obligation or responsibility for any representations or warranties made by or on behalf of any dealer, agent or distributor.

GSI assumes no responsibility for claims resulting from construction defects or unauthorized modifications to products which it manufactured. Modifications to products not specifically delineated in the manual accompanying the equipment at initial sale will void the Limited Warranty.

This Limited Warranty shall not extend to products or parts which have been damaged by negligent use, misuse, alteration, accident or which have been improperly/inadequately maintained. This Limited Warranty extends solely to products manufactured by GSI.

Prior to installation, the end-user has the responsibility to comply with federal, state and local codes which apply to the location and installation of products manufactured or sold by GSI.

This equipment shall be installed in accordance with the current installation codes and applicable regulations which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.

G S I G R O U P



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