AIR SEEDER CONVEYOR
Model:
PB-1625-AS

OPERATOR’S MANUAL
LIMITED WARRANTY

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

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

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

Written notice shall be given by registered mail, to Convey-All within seven (7) days after the defect shall have become apparent or the repairs shall have become necessary, addressed as follows:

Convey-All Industries Inc, Box 2008, 130 Canada Street
Winkler Manitoba R6W 4B7
Canada

This warranty shall expire one (1) year after the date of delivery of the new machinery.

If these conditions are fulfilled, Convey-All shall at its own cost and at its own option either repair or replace any defective parts provided that the buyer shall be responsible for all expenses incurred as a result of repairs, labor, parts, transportation or any other work, unless Convey-All has authorized such expenses in advance.

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

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

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

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

WARRANTY VOID IF NOT REGISTERED
CONVEY-ALL
AIR SEEDER CONVEYOR

WARRANTY REGISTRATION FORM & INSPECTION REPORT

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<td>City _____________________________________</td>
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<td>State/Prov, Code __________________________</td>
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I have thoroughly instructed the buyer on the above described equipment which review included the Operator’s Manual content, equipment care, adjustments, safe operation and applicable warranty policy.

Date ___________________ Dealer’s Rep. Signature ________________________

The above equipment and Operator’s Manual have been received by me and I have been thoroughly instructed as to care, adjustments, safe operation and applicable warranty policy.

Date ___________________ Owner’s Signature ______________________________

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updated 3.2015
PRODUCT INFORMATION

Always give your dealer the serial number of your conveyor when ordering parts or requesting service or other information.

The serial number for the conveyor is located on the left side, below the hopper. Please mark the number in the space provided for easy reference.

Fig 1 - Serial Number Location

Conveyor Model Number: ______________________________

Conveyor Serial Number: ______________________________

Motor Model Number: ______________________________

Motor Serial Number: ______________________________

Production Year: ______________________________
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Section 1: INTRODUCTION

Congratulations on your choice of a Convey-All Air Seeder Conveyor to complement the seed delivery system in your farming operation. This equipment has been designed and manufactured to meet the exacting standards for such equipment in the agricultural industry and will keep your seed delivery operation working at optimum efficiency.

This manual covers the Air Seeder Conveyor manufactured by Convey-All Industries Inc.

Safe, efficient and trouble free operation of your conveyor system requires that you and anyone else who will be operating or maintaining the machine, read and understand the Safety, Operation, Maintenance and Trouble Shooting information contained within this Operator’s Manual.

Use the Table of Contents as a guide to locate required information.

Keep this manual handy for frequent reference and to pass on to new operators or owners.

Call your Convey-All Industries Inc, dealer or distributor if you need assistance, information, additional/replacement copies or a digital copy of this manual.

OPERATOR ORIENTATION - The directions: left, right, as mentioned throughout this manual, are as seen from the hopper, facing the discharge spout.
Section 2: SAFETY

This Safety Alert symbol means:
ATTENTION! BECOME ALERT!
YOUR SAFETY IS INVOLVED!

Why is SAFETY important to you?

3 Big Reasons:
• Accidents Disable and Kill
• Accidents Cost
• Accidents Can Be Avoided

The Safety Alert symbol identifies important safety messages on the Convey-All Air Seeder Conveyor and in this manual. When you see this symbol, be alert to the possibility of equipment damage, personal injury or death. Follow the instructions in the safety message.

SIGNAL WORDS:

Note the use of the signal words: DANGER, WARNING and CAUTION with the safety messages. The appropriate signal word for each message has been selected using the following guide-lines.

DANGER - Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury. This signal word is to be limited to the most extreme situations typically for machine components which, for functional purposes, cannot be guarded.

WARNING - Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.

CAUTION - Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.
2.1 SAFETY ORIENTATION

YOU are responsible for the SAFE operation and maintenance of your Convey-All Air Seeder Conveyor. Ensure that you, and anyone else who will operate, maintain or work around the machine, be familiar with the safety, operating and maintenance procedures in this manual. This manual will take you step-by-step through your working day. It will alert you to all the safety practices that should be adhered to while operating the conveyor.

Remember, you are the key to safety. Good safety practices not only protect you but also the people around you. Make these practices a working part of your safety program. Be certain that everyone operating this equipment follows all the safety precautions. Most accidents can be prevented. Do not risk injury or death by ignoring good safety practices.

- Conveyor owners must give operating instructions to operators or employees before allowing them to operate the machine. Procedures must be reviewed annually thereafter, as per OSHA (Occupational Safety and Health Administration) regulation 1928.57.

- The most important safety device on this equipment is a SAFE operator. It is the operator’s responsibility to read and understand all safety and operating instructions in this manual, and to follow them.

- A person who has not read and understood all operating and safety instructions is not qualified to operate the machine. An untrained operator exposes himself and bystanders to possible serious injury or death.

- Think SAFETY! Work SAFELY!

2.2 GENERAL SAFETY

1. Read and understand the Operator’s Manual and all safety decals before operating, maintaining, adjusting or unplugging the conveyor.

2. Only trained competent persons shall operate the conveyor. An untrained operator is not qualified to operate the machine.

3. Have a first-aid kit available for use should the need arise and know how to use it.

4. Provide a fire extinguisher for use in case of an accident. Store in a highly visible place.

5. Do not allow riders.

6. Do not allow children, spectators or bystanders within hazard around the machine.

7. Wear appropriate protective gear. This list may include but is not limited to:
   - Hard Hat
   - Protective shoes with slip resistant soles
   - Eye protection
   - Heavy gloves
   - Hearing protection
   - Respirator or filter mask
   - Hi-Visibility Safety Vest

8. Review safety related items annually with all personnel who will be operating or maintaining the conveyor.
2.3 EQUIPMENT SAFETY GUIDELINES

1. Safety of the operator and bystanders is one of the main concerns in designing and developing this conveyor. However, every year many accidents occur which could have been avoided by a few seconds of thought and a more careful approach to handling equipment.

You, the operator, can avoid many accidents by observing the following precautions described in this section. To avoid personal injury or death, study these precautions and insist those working with you, or for you, follow them also.

2. In order to provide a better view, certain photographs or illustrations in this manual may show an assembly with a safety guards removed. Equipment should never be operated in this condition. Keep all guards in place. If removal becomes necessary for repairs, replace the guard prior to use.

3. Replace any safety or instruction decal that is not readable or is missing.

4. Never use alcoholic beverages or drugs which can hinder alertness or coordination while operating this equipment.

Consult your doctor about operating this machine while taking prescription medications.

5. Do not allow persons to operate this unit until they have read this manual. They should have a thorough understanding of the safety precautions.

Review the safety instructions with all users annually.

6. This equipment is dangerous to children and persons unfamiliar with its operation. The operator should be a responsible, properly trained and physically able person familiar with farm machinery and trained in this equipment’s operations.

If the elderly are assisting with farm work, their physical limitations need to be recognized and accommodated.

7. Never exceed the limits of a piece of machinery. If its ability to do a job, or to do so safely, is in question - DON’T TRY IT.

8. Do not modify the equipment in any way. Unauthorized modification result in serious injury or death and may impair the function and life of the equipment.

9. The design and configuration of this conveyor includes safety decals and equipment. They need to be clean, readable and in good condition.
2.4 SAFETY TRAINING

1. Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator or bystander.

2. Hazard control and accident prevention are dependent upon the personnel operating and maintaining the conveyor. Their awareness, concern, prudence and proper training are crucial.

3. It has been said, “The best safety feature is an informed, careful operator.” We ask you to be that kind of an operator. It is the operator’s responsibility to read and understand all safety and operating instructions in this manual and to follow them.

4. Working with unfamiliar equipment can lead to careless injuries. Read this manual before operating, to acquaint yourself with the machine. If this machine is used by any person other than yourself, or is loaned or rented, it is the machine owner’s responsibility to make certain that the operator, prior to operating:
   • Reads and understands the operator’s manuals.
   • Is instructed in safe and proper use.

5. Know your controls and how to stop the tractor, engine and conveyor quickly in an emergency. Read this manual and the one provided with your power unit.

6. Train all new personnel and review instructions frequently with existing workers. Be certain only a properly trained and physically able person will operate the machinery.

A person who has not read and understood all operating and safety instructions is not qualified to operate the machine. An untrained operator exposes himself and bystanders to possible serious injury or death.

If the elderly are assisting with farm work, their physical limitations need to be recognized and accommodated.

2.5 SAFETY DECALS

1. Keep safety decals clean and legible at all times.

2. Replace safety decals that are missing or have become illegible.

3. Replaced parts that displayed a safety decal should also display the current decal.

4. All safety decals have a part number in the lower right hand corner. Use this part number when ordering replacements.

5. Safety decals are available from your authorized distributor, dealer’s parts department or from Convey-All Industries Inc.

2.5.1 How to Install Safety Decals:

1. Be sure that the installation area is clean and dry.

2. Ensure temperature is above 50°F (10°C).

3. Determine exact position before you remove the backing paper.

4. Remove the smallest portion of the split backing paper.

5. Align the decal over the specified area and carefully press the small portion with the exposed sticky backing in place.

6. Slowly peel back the remaining paper and carefully smooth the remaining portion of the decal in place.

7. Small air pockets can be pierced with a pin and smoothed out using the piece of decal backing paper.
2.6 WORK PREPARATION

1. Never operate the tractor and conveyor until you have read and completely understand this manual, and each of the safety messages found on the safety decals placed on this unit.

2. Personal protective equipment including:
   - Hard Hat
   - Eye protection
   - Protective shoes
   - Heavy gloves
   are recommended during installation, placement, operation, adjustment, maintaining, repairing and removal of the implement.

3. Do not allow long hair, loose fitting clothing or jewelry to be around equipment.

4. PROLONGED EXPOSURE TO LOUD NOISE MAY CAUSE PERMANENT HEARING LOSS! Agricultural equipment can often be noisy enough to cause permanent, partial hearing loss. We recommend that you wear hearing protection on a full-time basis if the noise in the Operator’s position exceeds 80db.

   Noise over 85db on a long-term basis can cause severe hearing loss.

   Noise over 90db adjacent to the operator over a long-term basis may cause permanent, total hearing loss.

   **Note:**
   Hearing loss from loud noise (tractors, chain saws, radios, etc.) is cumulative over a lifetime without hope of natural recovery.

5. Clear working area of stones, branches or hidden obstacles that might be hooked or snagged, causing injury or damage.

6. Operate only in daylight or good artificial light.

7. Be sure machine is properly mounted, adjusted and in good operating condition.

8. Ensure that all safety shielding and safety decals are properly installed and in good condition.

9. Before starting, inspect the unit for any loose bolts, worn parts, cracks, leaks or frayed belts. Make the necessary repairs. Always follow the maintenance instructions.
2.7 OPERATING SAFETY

1. Be sure that anyone who will be operating the air seeder and conveyor or working on or around the unit reads and understands the operating, maintenance and safety information in this operator’s manual.

Review the manual annually.

2. Clean or replace all safety decals if they cannot be clearly read and understood.

3. Stop the tractor engine, place all controls in neutral, set park brake, remove ignition key and wait for all moving parts to stop before servicing, adjusting, repairing or unplugging the conveyor.

4. Keep all bystanders, especially children, away from the machine when running, or when carrying out maintenance work.

5. Establish a lock-out, tag-out policy for the work site. Be sure all personnel are trained in and follow all procedures. Lock-out, tag-out all power sources before servicing the unit or working around equipment.

6. Be familiar with machine hazard area. If anyone enters hazard areas, shut down machine immediately. Clear the area before restarting.

7. Keep hands, feet, hair and clothing away from all moving and/or rotating parts.

8. Do not allow riders on the conveyor when transporting.

9. Keep working area clean and free of debris to prevent slipping or tripping.

10. Stay away from overhead obstructions and power lines during operation and transporting. Electrocution can occur without direct contact.

11. Do not operate machine when any guards are removed.

12. Set park brake on the tractor and chock it’s wheels before starting.

13. Be sure that conveyor is empty before moving on its support arm.

14. Be sure hydraulic valves are closed when positioning machine or before transporting.

2.8 LOCK-OUT TAG-OUT SAFETY

1. Establish a formal Lock-Out Tag-Out program for your operation.

2. Train all operators and service personnel before allowing them to work around the unloading system.

3. Provide tags on the machine and a sign-up sheet to record tag out details.
2.9 MAINTENANCE SAFETY

1. Review the Section 4: Service and Maintenance of this Manual before working with, maintaining or operating the conveyor.

2. Follow good shop practices:
   - Keep service area clean and dry.
   - Be sure electrical outlets and tools are properly grounded.
   - Use adequate light for the job.

3. Place all controls in neutral or off, stop engine, remove ignition key and wait for all moving parts to stop before servicing, adjusting, unplugging or repairing the conveyor.

4. Before applying pressure to a hydraulic system, make sure all components are tight and that hoses and couplings are in good condition.

5. Relieve pressure from hydraulic circuit before servicing or disconnecting from tractor.

6. Keep hands, feet, hair and clothing away from all moving and/or rotating parts.

7. Replace parts with genuine factory replacements to restore your equipment to original specifications. Convey-All Industries Inc. will not be responsible for injuries or damages caused by use of unapproved parts and/or accessories.

8. Make sure there is plenty of ventilation. Never operate the engine in a closed building. The exhaust fumes may cause asphyxiation.

9. Clear the area of bystanders, especially children, when carrying out any maintenance and repairs or making any adjustments.

10. Place stands or blocks under the frame before working beneath the machine.

11. Before resuming work, install and secure all guards when maintenance work is completed.

12. Keep safety decals clean. Replace any decal that is damaged or not clearly visible.

2.10 TRANSPORT SAFETY

1. Always move air seeder with the conveyor in its cradle and locked in transport position.

2. Comply with all local laws governing safety and transporting of equipment on public roads.

3. Check that all the lights, reflectors and other lighting requirements are installed and in good working condition.

4. Do not exceed a safe travel speed. Slow down for rough terrain and when cornering.

5. Stay away from overhead power lines. Electrocution can occur without direct contact.

6. Plan your route to avoid heavy traffic.

7. Do not drink and drive.

8. Be a safe and courteous driver. Always yield to oncoming traffic in all situations, including narrow bridges, intersections, etc. Watch for traffic when operating near or crossing roadways.


2.11 STORAGE SAFETY

1. Store the conveyor on a firm, level surface.

2. Store in an area away from human activity.

3. Make certain all mechanical locks are safely and positively connected before storing.

4. Do not permit children to play on or around the stored machine.
2.12 SAFETY SYMBOL IDENTIFICATION

There are many types of safety symbols on decals placed in various locations on the conveyor. Good safety practices include being familiar with these signs, the type of warning, the area, and the particular function related to that area.

**CAUTION**

1. Read and understand the Operator’s Manual before operating.
2. Keep safety shields and devices in place and in good working order.
3. Make certain everyone is clear before operating or moving the machine. Keep children, visitors and unauthorized people away.
4. Keep hands, feet, hair and clothing away from moving parts.
5. Shut off and disable power source before adjusting, servicing, repairing or cleaning.
6. Disconnect power before rewinding motor overloads.
7. Be sure electric motors are grounded.
8. Support discharge and or anchor intake end to prevent overloading.
9. Empty Conveyor before moving to prevent overloading.
10. Lower Conveyor to the fully down position before moving or transporting. Use a tractor to move and transport.
11. Lower Conveyor well below level of power lines before moving or transporting. Electrocution can occur without direct contact.
13. Test operators annually.

**DANGER**

MISSING SHIELD HAZARD
Install and secure shield before operating.

**WARNING**

ROTATING PART HAZARD
To prevent serious injury or death from rotating parts:
1. Place all controls in neutral or off stop engine or motor, remove ignition key and wait for all moving parts to stop before servicing, adjusting, repairing or unplugging.
2. Install and secure all guards before operating.
3. Do not operate with rotating parts exposed.

**WARNING**

HIGH-PRESSURE FLUID HAZARD
To prevent serious injury or death:
1. Relieve pressure on system before repairing or adjusting.
2. Wear proper hand and eye protections when searching for leaks. Use wood or cardboard instead of hands.
3. Keep all components in good repair.

REMEMBER - If safety decals have been damaged, removed, become illegible or parts replaced without signage, new ones must be applied. New decals are available from your authorized dealer.

updated 3.2015
Section 3: OPERATION

![Operating Safety]

- Read and understand the Operator's Manual, and all safety decals, before using.
- Clear the area of bystanders, especially children, before starting.
- Close valves. Stop the tractor engine. Place all controls in neutral, remove ignition key and wait for all moving parts to stop before servicing, adjusting, repairing or unplugging the conveyor.
- Be familiar with machine hazard area. If anyone enters hazard areas, shut down machine immediately. Clear the area before restarting.
- Keep hands, feet, hair and clothing away from all moving and/or rotating parts.
- Do not allow riders on the conveyor when transporting.
- Stay away from overhead obstructions and power lines during operation. Electrocution can occur without direct contact.
- Do not operate machine when any guards are removed.
- Keep working area clean and free of debris to prevent slipping or tripping.
- Establish a lock-out, tag-out policy for the work site. Be sure all personnel are trained in and follow all procedures. Lock-out tag-out all power sources before servicing the unit or working around loading/unloading equipment.

The Convey-All Air Seeder Conveyor is designed to efficiently move seed. The conveyor can be used to fill or unload the air seeder. Power is provided by a hydraulic motor. Be familiar with the machine before starting.

It is the responsibility of the owner or operator to read this manual and to train all other operators before they start working with the machine. Follow all safety instructions exactly. It is everyone’s business. By following recommended procedures, a safe working environment is provided for the operator, bystanders and the area around the work site.

The design and configuration of this conveyor includes safety decals and equipment. Hazard controls and accident prevention are dependent upon the personnel operating and maintaining it. Their awareness, concern, prudence and proper training are crucial.

Many features incorporated into this machine are the result of suggestions made by customers like you. Read this manual carefully to learn how to operate the machine safely. There are instructions on how to set it, to provide maximum efficiency. By following the operating instructions, in conjunction with a good maintenance program, your conveyor will provide many years of trouble free service.
3.1 MACHINE COMPONENTS

The Air Seeder Conveyor is attached to the side of the air seeder, and can move along the side as required.

A hydraulic motor supplies power to operate the conveyor belt. The hydraulics must be provided by an external source.

These are the main components and some of the options available:

- a. Conveyor
- b. Hopper
- c. Discharge Spout
- d. Support Arm (not supplied by Convey-All)
- e. Conveyor Belt Alignment and Tension Springs
- f. Hydraulic Motor

Fig 2 - PB-1625-AS Conveyor
3.2 MACHINE BREAK-IN

There are no operational restrictions on the conveyor when used for the first time. Even though, it is recommended that the following mechanical items be checked:

**Before Starting Work:**
1. Read the conveyor operator’s manuals.
2. Run the unit for half an hour to seat the conveyor belt and flashing around the intake hopper. It is normal for rubber from the flashing to be expelled out the discharge and form a pattern on the belt.

**After Operating or Transporting for 1/2 hour:**
1. Re-torque all the bolts, fasteners and hardware.
2. Check the conveyor belt tension and alignment. Adjust as required. Refer to Section 4.3.1 and 4.3.2
3. During the conveyors first few minutes of operation, check belt alignment to ensure preset alignment and tension does not vary under loaded conditions.
4. Check the flashing seal on the intake hopper. If any seed slips under the flashing around the hopper, stop, loosen flashing mounting screws and adjust. Retighten anchor screws and try again. Repeat until no product is lost.
5. Check condition of all hydraulic lines, hoses and connections. Repair or replace any damaged system components.
6. Check that all guards are installed and working as intended.

**After Operating For 5 Hours and 10 Hours:**
Repeat steps 1 through 6 above.

Go to the normal servicing and maintenance schedule as defined in the Section 4: Service and Maintenance.

3.3 PRE-OPERATION CHECKLIST

Efficient and safe operation of the conveyor requires that each operator reads and understands the operating procedures and all related safety precautions outlined in this section. A pre-operation checklist is provided for the operator. It is important for both the personal safety and maintaining the good mechanical condition of the conveyor that this checklist is followed.

Before operating the conveyor and each time thereafter, the following areas should be checked off:

1. Service the machine as per the schedule outlined in the Section 4.2.
2. Check that all guards are installed, secured and functioning as intended. Do not operate with missing or damaged shields.
3. Check worksite. Clean up working area to prevent slipping or tripping.
4. Check that conveyor belt is properly tensioned and aligned. Ensure it is not frayed or damaged. Refer to Section 4.3.1 and 4.3.2
5. Check that discharge and intake areas are free of obstructions.

CAUTION: Upending Hazard
Anchoring or support conveyor during operation. When lower half of Conveyor empties of material, the weight balance transfers to the upper end of the machine, which can cause upending.
3.4 COMPONENTS AND CONTROLS

Before starting to work, all operators should familiarize themselves with the location and function of the components and controls.

Hydraulic Motor:
The hydraulic motor drives the conveyor belt using the discharge roller.

Hydraulic Valve Block:
The valve block in the centre of the conveyor feeds the hydraulic motor. When the conveyor is installed on the air seeder, the hydraulic hoses will need to be attached here.

Hydraulic Valves:
There is a red handle at the discharge and hopper ends. Either of them will operate the hydraulic valve to work the conveyor belt.

Hopper Feet:
There are 2 pivoting feet below the hopper end. When the conveyor is in working position, it will sit on the ground, resting on these feet.

Hopper:
The hopper has a spring loaded frame. This will allow the truck box to push the hopper edge down. This design comes with a clip on the conveyor to hold the hopper frame down when required.

All hoppers have rubber flashing to seal the junction between the belt and the sides of the hopper.
Discharge Spout:
Position the spout where the product is to be delivered.

Paddle Belt:
This conveyor belt uses large paddles to move material up the conveyor. Because of this design, the conveyor can be set at steeper angles than standard conveyor belts.

3.5 CONVEYOR PLACEMENT
The conveyor is can be positioned to move product from a truck into the air seeder. It can also be swung around to unload from the seeder into another storage bin.

3.6 STARTING CONVEYOR
1. Place conveyor into working position.
2. Lock conveyor in position, so it does not move when running.
3. Connect hydraulic hoses and open hydraulic valves from the tractor.
4. When ready, open the hydraulic valve on the conveyor to start the belt.
5. Start the flow of material and unload into conveyor’s hopper.
3.7 STOP THE CONVEYOR

1. Stop unloading. Wait for conveyor belt to empty.

2. Close the hydraulic valve on the side conveyor housing, to stop the belt.

3. Turn off tractor engine and remove ignition key.

3.7.1 Emergency Stopping:
Although it is recommended that the conveyor be emptied before stopping, in an emergency situation, stop or shut-down the power source immediately.

See to the emergency. Correct before resuming work.

3.7.2 Restarting after Emergency Stop:
When the machine is shut down inadvertently or in an emergency, the conveyor belt will still be covered with material.

Remove as much product from the conveyor’s hopper as possible, before restarting.

3.7.3 Unplugging:
In unusual moisture, crop or material conditions, the machine can plug. When unplugging, follow this procedure:

1. Close hydraulic valve, to stop the conveyor belt.

2. Place all controls in neutral or off. Stop tractor engine, and wait for all belts to stop rotating.

3. Lock-out, tag-out the controls.

4. Remove material from discharge and hopper area.

5. Reposition unit if discharge area plugs due to lack of clearance.

6. Restart unit.
3.8 OPERATING HINTS:

• Keep the hopper full for maximum capacity. Most efficient results will be obtained when flow of incoming material is directed to the top of the hopper.

• Always listen for any unusual sounds or noises. If any are heard, stop the machine and determine the source. Correct the problem before resuming work.

• Do not run the machine for long periods of time with no material on the belting. This increases the wear. Try to run only when moving material.

• Do not support discharge end directly on the storage facility.

• For better performance, use a transfer conveyor or drive over conveyor, to move product from the storage facility or truck to conveyor hopper.

• The hopper is designed with flashing to seal the junction of the belt with the sides of the hopper. It must be kept in good condition to prevent the material from “leaking” out of the hopper. Replace flashing if “leakage” occurs.

• Belt Speed:
  The best results are obtained when the drive is set to provide a belt speed of 600 ft./min.

  Count the number of belt revolutions per unit time to determine belt speed. Use the connector splice as a reference when counting belt revolutions.

  Contact your dealer or the factory for the appropriate drive components to give the recommended belt speed.

• Belt Tension:
  There may be a rapid decrease in belt tension during the first few hours of operation until the belt has worn in.

  The correct operating tension is the lowest tension at which the belt will not slip under peak load conditions.

Fig 12 - Air Seeder with Conveyor
3.9 TRANSPORTATION

Transporting Safety

- Read and understand ALL the information in the Operator’s Manual regarding procedures and SAFETY when moving or transporting the conveyor.

- Check with local authorities regarding conveyor transport on public roads. Obey all applicable laws and regulations.

- Close all hydraulic valves.

- Do not allow riders on the conveyor when transporting.

- Lower conveyor into its cradle for transporting.

- Stay away from overhead obstructions and power lines when transporting. Electrocution can occur without direct contact.

Convey-All conveyors are designed to be easily and conveniently transported over longer distances. When the job is complete and its time to transport the unit to a new location, follow this procedure:

1. Ensure the conveyor belt is empty of product.

2. Return the conveyor housing to lay along side the seeder. Discharge spout should face backwards.

3. Lock conveyor into transport position.

![Fig 13 - Transporting Hazard Area](image)
3.10 STORAGE

After the season’s use, the conveyor should be thoroughly inspected and prepared for storage.

Repair or replace any worn or damaged components to prevent any unnecessary down time at the start of next season. To have a long, trouble free life, this procedure should be followed when preparing the unit for storage:

1. Remove all residual material from the hopper and from inside the conveyor housing.
2. Inspect all moving or rotating parts to see if anything has become entangled in them. Remove the entangled material.
3. Wash the entire machine thoroughly using a water hose or pressure washer to remove all dirt, mud, debris or residue.
4. Inspect all hydraulic hoses, fittings, lines, couplers and valves. Tighten any loose fittings. Replace any hose that is badly cut, nicked or abraded or is separating from the crimped end of the fitting.
5. Touch up all paint nicks and scratches to prevent rusting.
6. Select an area that is dry, level and free of debris.

Storage Safety

- Store the unit in an area away from human activity.
- Do not permit children to play on or around the stored machine.
- Lower conveyor to its cradle for storage.
- If required, make sure the unit is solidly blocked up.
- Make certain all mechanical locks are safely and positively connected before storing.
Section 4: SERVICE AND MAINTENANCE

Servicing Safety

- Review the Operator’s Manual and all safety items before working with, maintaining or operating the conveyor.
- Close valves. Place all controls in neutral and stop tractor engine. Wait for all moving parts to stop before servicing, adjusting, repairing or unplugging.
- Follow good shop practices:
  - Keep service area clean and dry.
  - Be sure electrical outlets and tools are properly grounded.
  - Use adequate light for the job at hand.
- Before applying pressure to a hydraulic system, make sure all components are tight and that hoses and couplings are in good condition.
- Relieve pressure from hydraulic circuit before servicing or disconnecting from tractor.
- Keep hands, feet, hair and clothing away from all moving and/or rotating parts.
- Clear the area of bystanders, especially children, when carrying out any maintenance and repairs or making any adjustments.
- Before resuming work, install and secure all guards when maintenance work is completed.
- Keep safety decals clean. Replace any decal that is damaged or not clearly visible.

By following the operating instructions, in conjunction with a good maintenance program, your conveyor will provide many years of trouble free service.

4.1 FLUIDS AND LUBRICANTS

Grease:
Use an SAE multipurpose high temperature grease with extreme pressure (EP) performance. Also acceptable, SAE multipurpose lithium based grease.

Storing Lubricants:
Your machine can operate at top efficiency only if clean lubricants are used. Use clean containers to handle all lubricants. Store them in an area protected from dust, moisture and other contaminants.
4.1.1 Greasing:
Use the Maintenance Checklist provided to keep a record of all scheduled maintenance.

1. Use a hand-held grease gun for all greasing.

2. Wipe grease fitting with a clean cloth before greasing, to avoid injecting dirt and grit.

3. All bearings are sealed and greasable. They require minimal grease.

   Recommended greasing is 1 small stroke every 2 weeks. Be careful not to over grease as this may push the seal out.

4. Replace and repair broken fittings immediately.

5. If fittings will not take grease, remove and clean thoroughly. Also clean lubricant passageway. Replace fitting if necessary.

4.2 SERVICING INTERVALS

The conveyor belt alignment is preset to run true under a condition of no load. It is important to check alignment and make adjustments, if required, during the initial few minutes of loaded operation.

Check bearings for wear daily.

The periods recommended below are based on normal operating conditions. Severe or unusual conditions may require more frequent lubrication and oil changes.

4.2.1 After 10 Hours or Daily:
1. Grease hopper roller bearings.

2. Grease discharge roller bearings.
4.2.2 After 50 Hours or Weekly:
3. Check the conveyor belt tension.
   Refer to Section 4.3.1

   **Note:**
   A properly tensioned belt will not slip when in operation.

4. Check conveyor belt alignment.
   Refer to Section 4.3.2

5. Check the condition of the rubber hopper flashing.
   Be sure it seals the hopper to prevent leaking. Replace if there are gaps, or excessive wear.

   If any seed slips under the flashing around the hopper, loosen flashing mounting screws and adjust. Retighten screws and try again. Repeat until no product is lost.

6. Check the hydraulic motor’s Lovejoy coupler for wear.

4.2.3 After 200 hours or Annually:
7. Wash the machine
4.3 MAINTENANCE

By following a careful service and maintenance program for your machine, you will enjoy many years of trouble-free service.

WARNING: Rotating Part Hazard
Close hydraulic valves before working on belt.

4.3.1 Conveyor Belt Tension
The tension of the belt should be checked weekly, or more often if required, to be sure that it does not slip. To maintain the belt, follow this procedure:

Tension bolt components:
- a. Lock nuts
- b. Tension spring
- c. Hopper roller spring tension bolt

Use the hopper roller spring tension bolts to set the tension of the belt.

Tighten tension bolt until spring measures 3-3/4 inches (95mm).

Note:
A properly tensioned conveyor belt should not slip on its rollers during operation.
4.3.2 Conveyor Belt Alignment:
The belt is properly aligned when it runs in the centre of the rollers on both ends of the conveyor.

As with tensioning, the alignment should be checked weekly, or as required.

![Warning: Rotating Part Hazard](image)
Close hydraulic valves before working on belt.

1. Rotate the conveyor belt a half revolution when the belt is new and check the drive and hopper rollers.

   **Note:**
   If belt is out of alignment, it will move to the loose side. Tighten loose side or loosen tight side.

2. Tighten or loosen the tensioning bolt by a 1/4 turn to 2 turns.

3. Measure the distance from the bolt mount to the edge of the housing. They should be equal.

4. Run a couple of revolutions and check again.

5. Tighten the tension bolt lock nut.

Check frequently during the first few minutes of operation. Then, several times during the first 10 hours.

The belt normally seats itself during the first 10 hours of operation and can be checked weekly after that.
4.3.3 Conveyor Belt Replacement:

WARNING: Rotating Part Hazard
Turn off engine. Close hydraulic valves, and wait for belts to stop moving.

1. Remove one of the panels, on top, in the middle of the conveyor housing.

2. Rotate the belt until the lacing is positioned at the open panel.

3. Move the tension bolt to its loosest position. See Figure 29

4. Pull all the slack to the Alligator lacing area.

5. Place a board under the belt, and sit on top of the open panel sides. Now, the belt lacing can be easily worked on.

6. Remove the lacing pin and open the belt.

7. Attach one end of the replacement belt to the end of the existing belt which is heading towards the discharge spout.

Be careful to match the direction the paddles face of the new belt, to the existing belt.

8. Pull the end of the old belt which is coming from the direction of the hopper. The new belt will follow and be threaded into place.

9. Disconnect the old belt.

10. Connect the ends of the new belt together.

11. Loosen the discharge roller mounts. Pull the mounts all the way forward in their slotted bolt holes. Tighten the bolts.

12. Set the belt tension. Refer to Section 4.3.1

13. Check and set the belt alignment. Refer to Section 4.3.2

14. Place and bolt the panel into place.
4.4 SERVICE RECORD

See Section 4.3 for details of maintenance. The Servicing Intervals section is only a guide under good conditions. Under extreme, or unusual circumstances adjust service timing accordingly.

Copy this page to continue record.

<table>
<thead>
<tr>
<th>Maintenance</th>
<th>Hours</th>
</tr>
</thead>
<tbody>
<tr>
<td>Serviced By</td>
<td></td>
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</table>

<table>
<thead>
<tr>
<th>10 Hours or Daily</th>
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</thead>
<tbody>
<tr>
<td>Grease Hopper Roller Bearings</td>
</tr>
<tr>
<td>Grease Discharge Roller Bearings</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>50 Hours, or Weekly</th>
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<tbody>
<tr>
<td>Check Conveyor Belt Tension</td>
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<tr>
<td>Check Conveyor Belt Alignment</td>
</tr>
<tr>
<td>Check Hopper Flashing</td>
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<tr>
<td>Check Hopper Brush</td>
</tr>
<tr>
<td>Check Hydraulic Drive Lovejoy Coupler</td>
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</table>

<table>
<thead>
<tr>
<th>200 Hours or Annually</th>
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</thead>
<tbody>
<tr>
<td>Wash Machine</td>
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</table>

4.5 ORDERING PARTS

Always give the Model Number and Serial Number when ordering parts.

To get your parts promptly the following information will be required:
- The part name and number
- Your Name, Address, Town, Province/State, Country
- Complete information for shipping

Confirm all phoned in orders in writing. If Purchase Orders are required please note the number on the written order.

Unless claims for shortages or errors are made immediately upon receipt of goods, they will not be considered.

Inspect all goods received immediately upon receipt. When damaged goods are received, insist that a full description of the damage is made with the carrier against the freight bill. If this is insisted upon, full damage can be collected from the transport company.

No responsibility is assumed for delay or damage to merchandise while in transit. Dealers responsibility ceases upon delivery or pickup of shipment from or to the transportation company. Any freight damage claims must be made with the transportation company, not with the dealer.
## Section 5: TROUBLE SHOOTING

In this section, many of the problems, causes and solutions which may be encountered, are listed.

If problems are confronted which are difficult to solve, even after having read through this section, please contact your authorized dealer, distributor or Convey-All Industries Inc. Before you call, please have this Operator's Manual and the unit's serial number ready.

<table>
<thead>
<tr>
<th>Problem</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conveyor belt doesn’t turn or is slipping</td>
<td>Hopper flashing may be stuck to belt, because it is running dry and rubber is heating up</td>
<td>Turn off unit! Manually peel flashing up and off hopper. Then run dry product through to create barrier between flashing and belt</td>
</tr>
<tr>
<td></td>
<td>Conveyor belt loose</td>
<td>Tighten and align</td>
</tr>
<tr>
<td></td>
<td>Conveyor belt loose because it has stretched</td>
<td>Shorten belt</td>
</tr>
<tr>
<td></td>
<td>Conveyor belt frozen to housing from operating in high humidity conditions in extreme cold</td>
<td>Remove conveyor from area of high humidity and continue to run empty so the belt dries prior to freezing</td>
</tr>
<tr>
<td></td>
<td>Seized bearing</td>
<td>Check all bearings, Replace any that are rough or seized</td>
</tr>
<tr>
<td></td>
<td>Conveyor belt or roller is jammed</td>
<td>Check for sticks, stones, other objects jammed in belt drive area and remove</td>
</tr>
<tr>
<td>Conveyor belt won’t align</td>
<td>Roller lagging may be worn</td>
<td>Replace roller or have it re-lagged</td>
</tr>
<tr>
<td></td>
<td>Belt not aligned</td>
<td>Align and adjust tension</td>
</tr>
<tr>
<td>Product leakage</td>
<td>Product may be getting under the belt at the hopper, travelling up inside the belt and leaking off delivery end</td>
<td>Replace hopper flashing</td>
</tr>
<tr>
<td>Low capacity</td>
<td>Conveyor belt not tight enough</td>
<td>Tighten conveyor belt</td>
</tr>
<tr>
<td>No hydraulic flow</td>
<td>Hydraulic valve closed or plugged</td>
<td>Open hydraulic valve or replace it</td>
</tr>
</tbody>
</table>
Section 6: SIGN-OFF FORM

Convey-All follows the general Safety Standards specified by the American Society of Agricultural Engineers (ASAE), and the Occupational Safety and Health Administration (OSHA). Anyone who will be operating and/or maintaining the unit must read and clearly understand all Safety, Operating and Maintenance information presented in this manual.

Do not operate, or allow anyone else to operate, this equipment until this document has been read. Review this information annually, before the season start-up.

Make periodic reviews of SAFETY and OPERATION a standard practice for all of your equipment.

The following Sign-Off Form is provided for your record keeping. Use it to show that all personnel who will be working with the equipment have read and understand the provided information. They also have been instructed in the operation of the equipment. Copy this page to continue the record.

<table>
<thead>
<tr>
<th>DATE</th>
<th>EMPLOYEE’S SIGNATURE</th>
<th>EMPLOYER’S SIGNATURE</th>
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Section 7: REFERENCE

For information not included here, or for a digital copy of this manual, please call your dealer or Convey-All Industries Inc. directly for assistance (1-800-418-9461).

7.1 BOLT TORQUE

The tables shown below give correct torque values for various bolts and capscrews. Tighten all bolts to the torques specified in chart unless otherwise noted. Check tightness of bolts periodically, using bolt torque chart as a guide. Replace hardware with the same strength bolt.

<table>
<thead>
<tr>
<th>ENGLISH TORQUE SPECIFICATIONS</th>
<th>METRIC TORQUE SPECIFICATIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Bolt Diameter “A”</strong></td>
<td><strong>Bolt Diameter “A”</strong></td>
</tr>
<tr>
<td></td>
<td><strong>SAE 2</strong></td>
</tr>
<tr>
<td></td>
<td>(N.m) (lb-ft)</td>
</tr>
<tr>
<td>1/4”</td>
<td>8</td>
</tr>
<tr>
<td>5/16”</td>
<td>13</td>
</tr>
<tr>
<td>3/8”</td>
<td>27</td>
</tr>
<tr>
<td>7/16”</td>
<td>41</td>
</tr>
<tr>
<td>1/2”</td>
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<td>3/4”</td>
<td>225</td>
</tr>
<tr>
<td>7/8”</td>
<td>230</td>
</tr>
<tr>
<td>1”</td>
<td>345</td>
</tr>
</tbody>
</table>

Table 1 - English Torque

Table 2 - Metric Torque

Torque figures indicated above are valid for non-greased or non-oiled threads and heads unless otherwise specified. Therefore, do not grease or oil bolts or capscrews unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

* Torque value for bolts and capscrews are identified by their head markings.