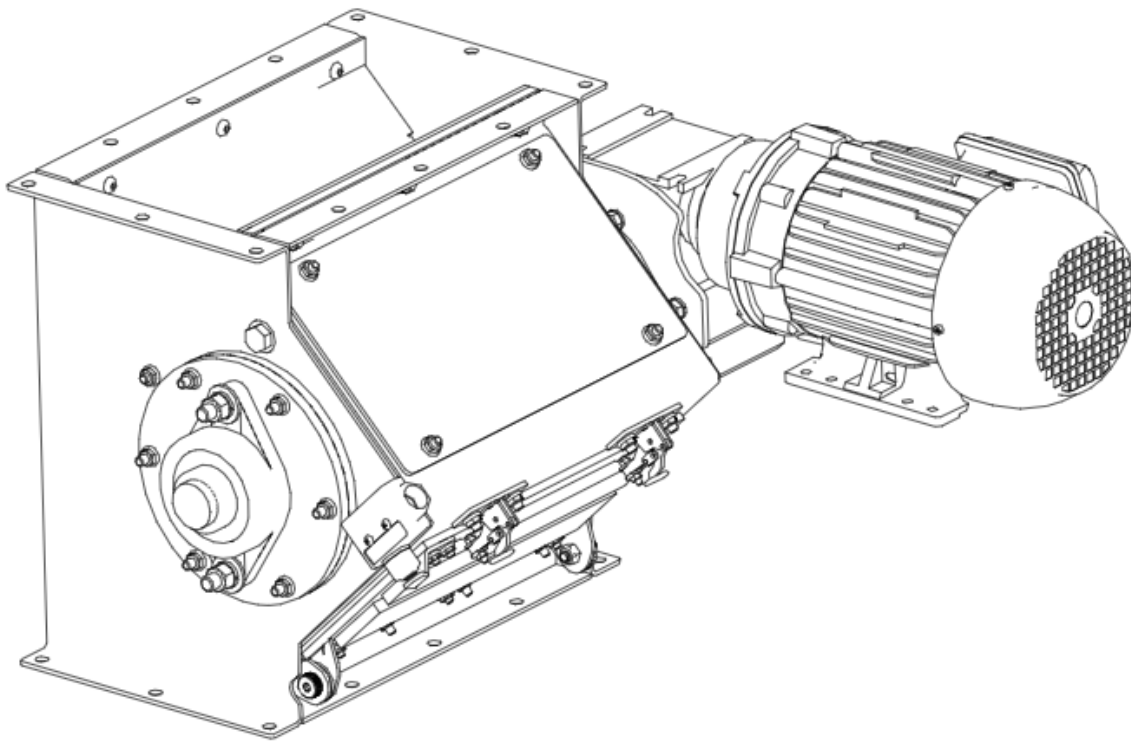




HM2014 Hammer Mill Pocket Feeder

Feed Handling Installation, Operation, and Maintenance Manual



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

Part Number: 8210-30079 R0

Revised: February 2025

Original Instructions

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1. Introduction

This manual will help you safely use and maintain the Pocket Feeder. Read and follow the manual before using. Keep the manual handy to refer to and review it with others.

1.1. Intended Use

The Pocket Feeder is intended to be a dedicated feeder for the HM2014 Hammer Mill, or used as a standalone unit for various metering applications. It is designed to provide an even feed rate and even distribution of the material across the full inlet of the downstream equipment.

1.2. Need More Help?

For help understanding this manual or for additional information, go to aggrowth.com/en-us/contact-us, scan the QR code, or contact your local AGI representative. Additional contact information is located on the back cover of this manual.



1.3. Product Label Location

The product label location is shown below. Have the serial number ready when ordering parts or requesting service or other information. Record information in the table below for easy reference.

Model Number	
Sales Order	
Job Number	
Date Received	

Figure 1. Product Label Location

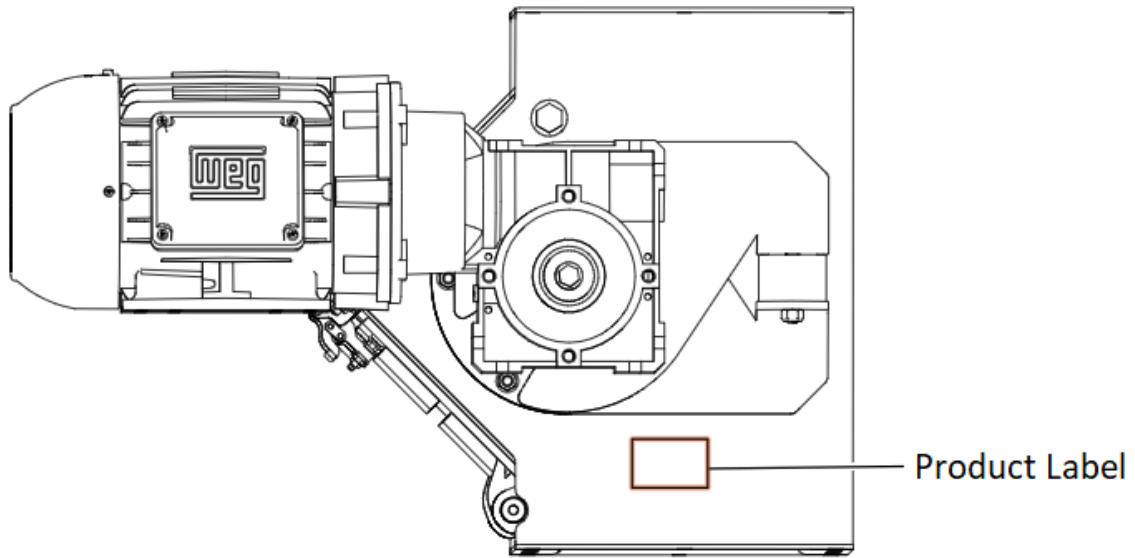




Figure 2. Product Label


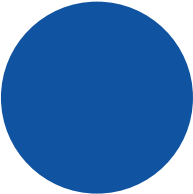

	Project Name:	
	140 PARKLAND - OAK BLUFF, MB (204) 897-6949 WWW.AGGROWTH.COM	
Cust. PO#:	Sales #	Job #
Volume #:	Part #:	
	Description:	

2. Safety

Good safety practices prevent accidents. Always take time to work safely and don't shortcut or ignore safety information. Inform others of safety hazards and how to prevent them.


2.1. About Safety Information in this Manual

Below are the definitions of the safety alert words and symbols that are used in this manual. When you see them, follow their messages to prevent injury, death, or equipment damage.

Safety Alert Symbols	Safety Alert Words
 <p>This symbol indicates a safety hazard.</p>	<p>DANGER Serious injury or death will occur.</p>
 <p>This action is required.</p>	<p>WARNING Serious injury or death could occur.</p>
 <p>This action is not allowed.</p>	<p>CAUTION Minor or moderate injury could occur.</p> <p>NOTICE Property damage may occur.</p>

2.2. Preventing Safety Hazards

Follow the information below to prevent safety hazards.



Read and Understand the Safety Information

Before operating or maintaining:

- Follow the information in this manual and on the safety decals.
- Keep this manual in a convenient location.
- Keep the safety decals clean and legible.

Keep the Pocket Feeder in Good Condition



For safe operation and to prevent unnecessary downtime:

- Do not modify the Pocket Feeder.
- Maintain the Pocket Feeder and inspect it before using.
- Make sure all parts are in good condition and guards/covers are in place.
- Hire professional help and do not work on the Pocket Feeder if you do not have proper training, experience, and equipment/tools to perform work safely.

Adjust the Torque Arm Carefully



To prevent serious injury or death:

- Never remove the torque arm when equipment is loaded.
- Removal of the torque arm will cause the reducer to suddenly rotate.
- Secure the drive and motor before removing the torque arm.

Keep Away from Strong Magnetic Fields



The Pocket Feeder could be equipped with strong magnets.

To prevent serious injury or death.

- Stay clear! Can be harmful to pacemaker wearers and other medical implants.
- Keep tools and other metal objects away.

Lock Out Power Sources Before Maintaining or Inspecting



To prevent injury:

- Know how to shut off and lock out power before servicing, maintaining, inspecting, or cleaning.

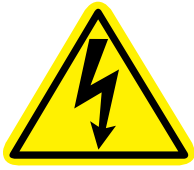
Keep Away from Rotating Parts



To prevent serious injury or death:

- Keep body, hair, and clothing away from rotating parts.

Use Electric Motors Safely



To prevent electrocution:

- Have electric motors and controls installed and serviced by a qualified electrician to meet local codes and standards.
- Replace electrical wiring and cords that are worn or are not in good condition.
- Place the main power switch in the locked position when not using the equipment or before maintaining it.
- If reset is required, disconnect all power before resetting the motor.

Use Variable Frequency Drives (VFD) Safely



VFDs contain hazardous voltage when powered and even after power is disconnected.

To prevent death or serious injury:

- Do not install or perform maintenance on the VFD unless you are a properly qualified and trained Electrician.
- Remove AC line power from the VFD before doing any service or repair and wait for all power to be safely discharged from capacitors.
- Never operate the VFD with the enclosure door open.

Use Appropriate Personal Protective Equipment (PPE)



Work Gloves

Protect hands from sharp and rough edges.



Steel-Toe Boots

Protect feet from falling debris.



Hearing Protection

Prevent hearing damage.



Safety Glasses


Protect eyes from debris.




Coveralls

Protect the skin.

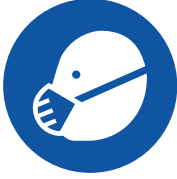
Keep appropriate Safety Equipment On Site



Fire Extinguisher
Keep for use in case of an accident. Store in a visible and accessible place.



First-Aid Kit
Keep properly-stocked and available.



Dust Mask
Prevent breathing potentially harmful dust.

2.3. Safety Decal Locations and Replacements

Read and follow all safety decals.

Know where they are located.

Replace all safety decals that are missing, damaged, or faded.

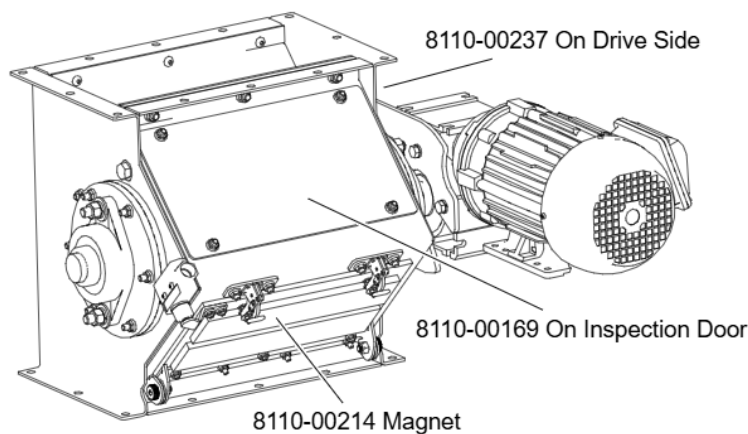
Click the [link](#), scan the QR code, or contact your local AGI representative for **free replacements**.









To replace a safety decal:

1. Make sure the area is clean, dry, and the temperature is above 50°F (10°C).
2. Decide on the position before removing the backing paper.
3. Align the decal and press the small portion with the exposed sticky backing in place.
4. Slowly peel back the remaining paper and smooth the remaining portion of the decal in place.
5. Use a pin to pierce small air pockets and smooth out using the decal backing paper.

Safety Decal Locations

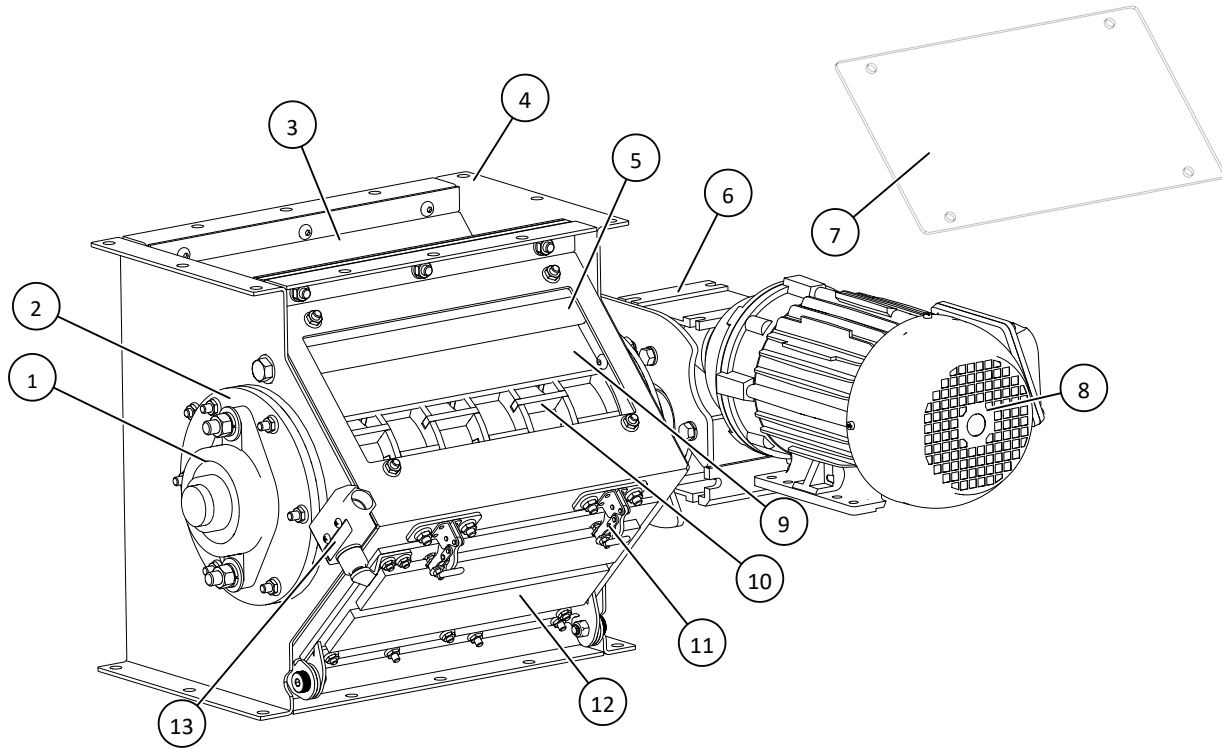


Safety Decals and Part Numbers

8110-00169	8110-00214	8110-00237
<div style="border: 1px solid black; padding: 5px;"> <div style="background-color: #FFC000; padding: 2px; text-align: center;">⚠ WARNING</div> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="border-top: 1px solid black; padding-top: 5px;"> <p style="text-align: center;">ENTANGLEMENT HAZARD</p> <p>To prevent serious injury or death:</p> <ul style="list-style-type: none"> • Keep body, hair, and clothing away from rotating parts. • Do not operate with any guard removed or modified. Keep guards in good working order. • Shut off and lock out power source before inspecting or servicing machine. </div> </div>	<div style="border: 1px solid black; padding: 5px;"> <div style="background-color: #FFC000; padding: 2px; text-align: center;">⚠ WARNING</div> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="border-top: 1px solid black; padding-top: 5px;"> <p style="text-align: center;">STRONG MAGNETIC FIELD</p> <p>To prevent serious injury or death:</p> <ul style="list-style-type: none"> • Stay clear! Can be harmful to pacemaker wearers and other medical implants. • Keep tools and other metal objects away. This magnet is strong enough to pull them out of your hand. </div> </div>	<div style="border: 1px solid black; padding: 5px;"> <div style="background-color: #FFC000; padding: 2px; text-align: center;">⚠ WARNING</div> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="border-top: 1px solid black; padding-top: 5px;"> <p style="text-align: center;">ROTATING SHAFT HAZARD</p> <p>To prevent serious injury or death:</p> <ul style="list-style-type: none"> • Keep body, hair and clothing away from rotating shafts. • Do not operate with any guard removed or modified. Keep guards in good working condition. • Shut off and remove key or lockout power source before inspection or service. </div> </div>

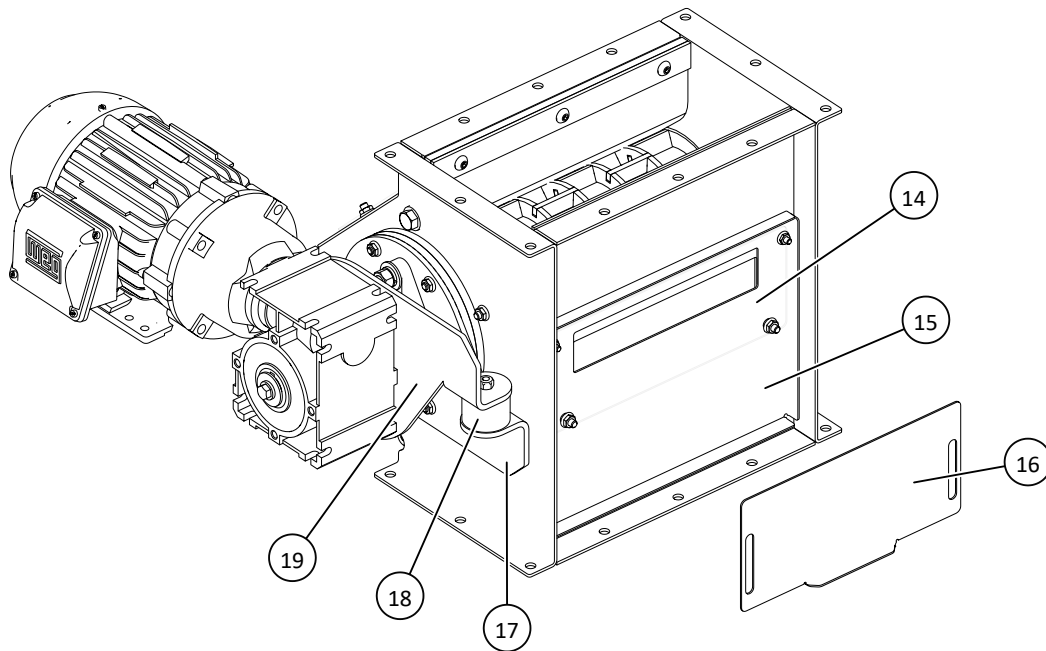
3. Features

Figure 3. Front View



Item	Description
1	Bearing
2	End Plate
3	Interior Plate
4	Body Weldment
5	Seal Retaining Bar
6	Gearbox
7	Access Door
8	Electric Motor
9	Drum Seal
10	Pocket Feeder Drum Assembly
11	Clamp
12	Magnet Plate
13	Sensor

Figure 4. Back/Side View



Item	Description
14	Mesh
15	Air Inlet Cover
16	Air Inlet Gate
17	Pocket Feeder Bearing Torque Arm
18	Vibration Damping Sandwich Mount
19	Pocket Feeder Motor Torque Arm

4. Pre-Installation

4.1. Installing Safely

Follow the information below to prevent installation safety hazards. For more detail, refer to [Section 2. – Safety on page 6](#).



Hire trained installers

Have all installation and servicing operations completed by qualified technicians.

Have all electrical connections made by a qualified electrician in accordance with applicable local codes and regulations.



Properly tighten fasteners

Always use proper tools for the job.

Tighten all fasteners according to their specifications. Do not replace or substitute bolts, nuts, or other hardware.



Lift components properly

Components can be large, heavy, and hard to handle.

Lift carefully and make sure the load is balanced.

Properly plan lift operations.

Always have two or more people complete the installation.

Use proper lifting equipment and connect to proper lifting points. Never lift with only one support point. Keep lifting equipment in good condition.

Do not stand on, under, or near any component that is not secured.

4.2. Before Unloading the Shipment

1. Check if the loads have shifted or have been damaged during transport.
2. Inspect all sides of the shipment for any visible signs of damage. Look for dents, misaligned flanges and shafts. Take photos of the damaged components on the truck.
3. If components are damaged or missing, note these on the delivery receipt and immediately report missing or damaged parts to the manufacturer and freight company.

4.3. Unload the Shipment



WARNING

Use proper unloading and lifting techniques to prevent injury or component damage.

1. Determine the appropriate area for unloading the shipment.
2. Make sure the area is clear before unloading.

3. Unload the Pocket Feeder on a solid and clean flat surface.
4. Thoroughly inspect components for any damage.
5. Compare the packing slip to the shipment and confirm all items have arrived.
6. Report missing or damaged parts to AGI or your representative. Report immediately to receive proper credit and so missing parts can be shipped quickly. Take pictures of shipments after unloading if there are any damaged parts.

Important

Do not assemble or install damaged components.

4.4. Product Storage

If storing the Pocket Feeder before installation, follow the instructions below to prevent dirt and moisture accumulation, damage, or injury. Damage to the Pocket Feeder resulting from improper storage is not covered by warranty.

- Store the Pocket Feeder in a clean, dry, and vibration-free environment. If storing for long-term, follow the electric motor manufacturer's storage requirements.
- Do not lay the Pocket Feeder on the bare ground. Elevate it 6" to 8" above the ground surface.
- Temporary storage can be provided by erecting a simple framework supporting a waterproof tarp.
- All hardware boxes should be stored inside. These are not waterproof, and will deteriorate in normal weather conditions, allowing moisture to contact the parts inside.
- Keep the Pocket Feeder dry before assembly of the Pocket Feeder.
- Secure the location to prevent unauthorized access.
- Start assembly as soon as possible.

4.5. Site Preparation

To ensure proper installation and optimum operation of the Pocket Feeder, consider the following requirements.

Downstream Equipment

The Pocket Feeder is mounted on a downstream equipment which functions as a base. The downstream equipment must be:

- level and rigid to minimize vibrations
- properly anchored to the floor or foundation

Access

Provide sufficient working space around the Pocket Feeder for routine parts change and maintenance.

5. Installation

5.1. Electrical Requirements



WARNING

A qualified electrician must do the installation. The installation must meet all local codes and standards. Improper installation can result in serious injury or damage to the equipment.

When providing power to the electric motor and VFD, make sure to:

- provide appropriate circuit breaker.
- use suitable cable size.
- properly ground the motor and VFD.



References

For important additional information:

- Contact the responsible engineer of the project or AGI.
- Refer to the documentation provided by the motor, VFD, and electrical disconnect electrical manufacturers.

5.2. Installing the Pocket Feeder

This section provides general instructions for installation of the Pocket Feeder. While details may vary depending on the application, following these instructions will ensure proper installation of the Pocket Feeder.



Preparation

Before installing the Pocket Feeder, ensure that the base meets the following requirements:

- Level in all directions
 - Rigid and uniformly supported to help prevent misalignment of the coupling and bending of the rotor shaft
-



Required Tools and Equipment

To install the Pocket Feeder, have the following available:

- Wrench set
- Socket set
- Torque wrench
- Shims
- Silicone (all bolted connections should be sealed)
- Lifting equipment – NOTE capacity must be higher than the Pocket Feeder weight.

Additional tools and equipment may be required.

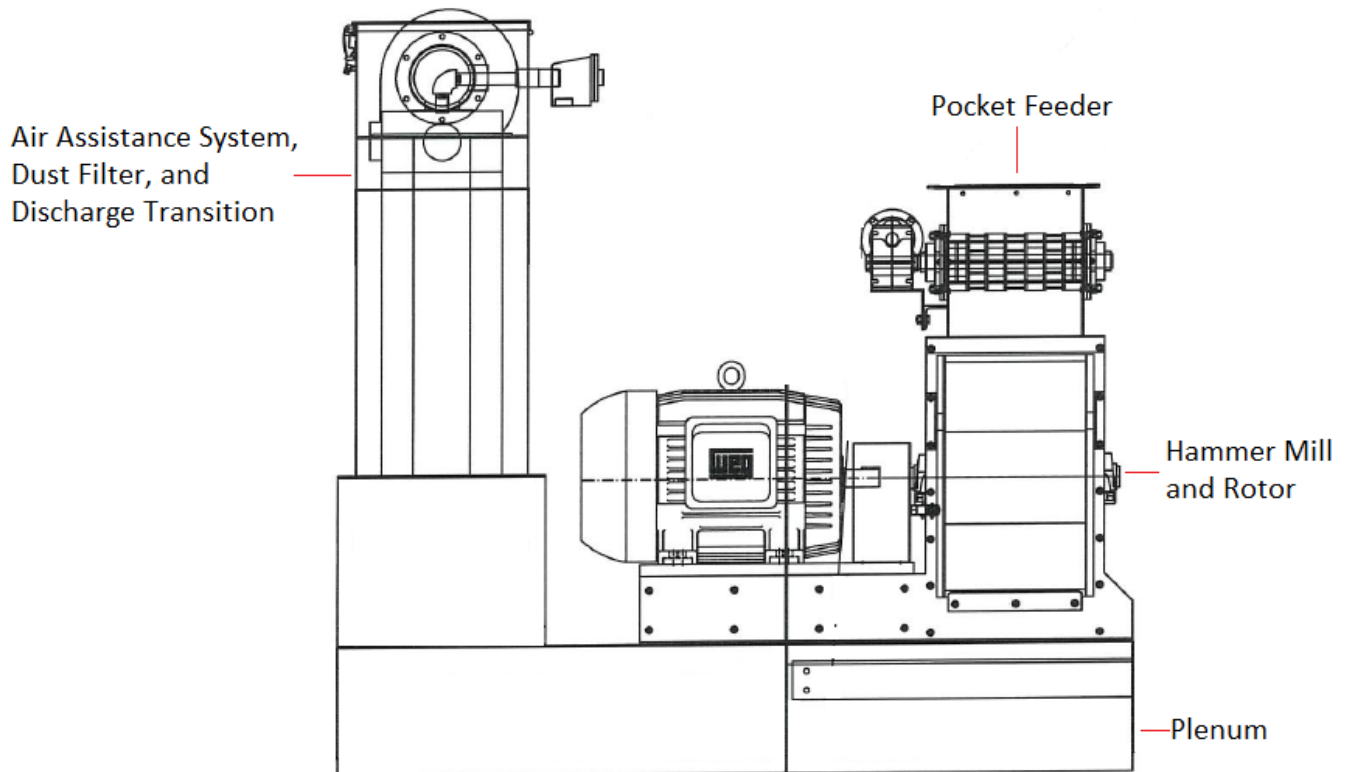
Positioning the Pocket Feeder

1. Verify that the downstream equipment where the Pocket Feeder will be placed is level, rigid, and properly connected to the foundation.
2. Lift the Pocket Feeder and guide it into place.
3. Check that the base of the Pocket Feeder is level in all directions and uniformly supported.
4. Secure the Pocket Feeder to the base using the 3/8" fasteners provided and tighten them to the recommended torque. Refer to [Section 10.2 – Bolt Torque on page 30](#).

Figure 5. Pocket Feeder Installed with Hammer Mill, Plenum, and Air Assistance System

Note

The combined configuration shown below is an example only.



6. Operation

For optimal operation, follow the safety precautions, checklists, and instructions in this section.

6.1. Operating Safely

Follow the information below to prevent operating safety hazards. For more detail, refer to [Section 2. – Safety on page 6](#).



Work Site Hazard

- Do not work alone.
- Keep the work area clean.
- Keep bystanders away.



Electrocution Hazard

- Keep away from power lines.
- Electrocution can occur without direct contact.



Entanglement Hazard

- Keep away from moving components.
- Keep guards in place.

6.2. Pre-Operating Checks

Check the following before initial use and occasionally afterwards.

General

- all fasteners are tight (nuts, bolts, etc)
- safety decals in place and legible
- guards in place and good condition

Pocket Feeder

- intake and discharge areas are free of obstructions
- no entanglement present on the rotating parts
- pockets are empty
- no cracked welds or chips on the painted surfaces

Safety devices

- door safety switches are functioning properly

Power supply and wiring

- power supply matches with the machine's requirements
- all electrical wiring and connections are securely fastened

Drive components

- coupling and shafts are aligned
- bearings are greased and lubricated
- shaft cover plates are installed
- torque arm and vibration dumping mount are in good condition and properly fastened

6.3. Using the Pocket Feeder

This section is intended as a general guide only as the operation of the Pocket Feeder may vary depending on your operation and system requirements.



Preparation

For efficient and safe operation, confirm the following before starting:

- The operator received proper training in the Pocket Feeder operation, safety features, and lockout/tagout procedures. A person who has not read and understood all operating and safety instructions is not qualified to operate the machine.
 - Maintenance has been performed and is up to date.
 - Visual inspection of the entire unit.
 - The magnet is clean and securely fastened.
 - All inspection doors and air dumpers are properly fastened.
 - Check for any unusual sounds. Investigate anything immediately.
 - Check the operation of the safety switch.
 - Check the torque arm and rubber connector for loose bolts and cracked rubber.
 - Check that all safety labels are in place and readable. If not, replace them. Refer to [Section 2.3 – Safety Decal Locations and Replacements on page 9](#).
-



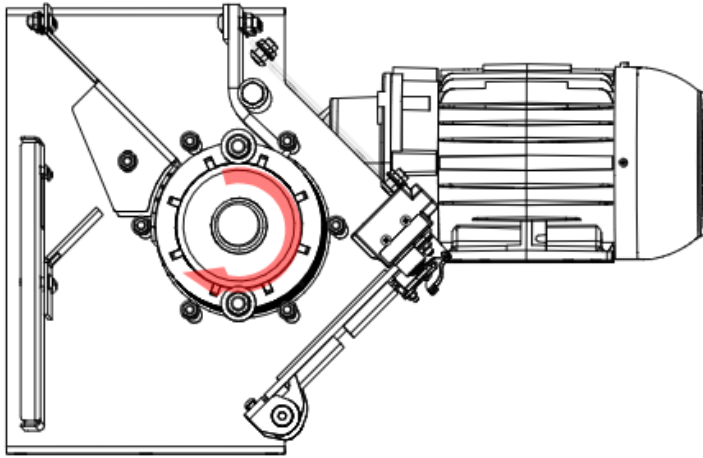
Equipment Settings

To maximize capacity and attain the proper product transfer, make sure to implement the following. Refer to [Section 7.2 – Maintenance Procedures on page 21](#) for more details.

- Correct rotor speed/material flow rate.
 - Correct airflow settings
 - Ensure tight clearance between drum and interior plate. Refer to [Section 7.2 – Maintenance Procedures on page 21](#) (Check the Clearance Between Drum and Interior Plate).
-

When using the Pocket Feeder for the first time

1. Complete all pre-operation checks.
2. Check that the drum rotation is correct.



3. Bump start or run the Pocket Feeder for 3–4 seconds and stop it. During the run, check that the feeder shaft spins/works correctly without any noise or restrictions.
 - If the bump start was good, start the Pocket Feeder for 30 seconds and listen for any unusual noises. If the Pocket Feeder runs smoothly, it is ready for use.

Normal Operation

1. Visually inspect the Pocket Feeder before every use.
2. Keep the magnet clean. Clear all the debris every 8 hours. Based on the amount of debris accumulated at every shift (8 hours) adjust magnet cleaning cycle accordingly.
3. Adjust the air inlet for better material flow.

Note

- Good air intake and flow improves the Pocket Feeder and Hammer Mill's performance.
- Adjustments to air can be done before or during operation.

Shutdown

1. Stop the flow of material above the Pocket Feeder. See [Clearing Objects on page 19](#).
2. Run the Hammer Mill until the Pocket Feeder is empty.
3. Turn off the Pocket Feeder.
4. Turn off the Hammer Mill.
5. Lock out/ tag out both the Hammer Mill and Pocket Feeder.

Clearing Objects



CAUTION

- Before clearing objects it is recommended to empty a surge hopper bin above the Pocket Feeder.
 - Failure to remove product from the surge bin will flood the Pocket Feeder and Hammer Mill chamber. The bin will empty uncontrollably.
1. Lock out/tag out power of the Pocket Feeder, Hammer Mill, and Dust Filter.
 2. Open the inspection door and magnet plate and remove the air dumper from the Pocket Feeder.

Note

If access is limited, remove the interior plate and rubber seal.

3. Check for any foreign objects and remove them.
4. After clearing any objects, clean any residual product from the Pocket Feeder.
5. Reinstall and adjust all internal parts of the Pocket Feeder.
6. Close the inspection door and magnet plate and reinstall air dumper on the Pocket Feeder

Extended Shutdown

1. Empty the surge hopper above the Pocket Feeder.
2. Empty the Pocket Feeder.
3. Open the magnet cover and clean out all debris.
4. Visually inspect all internal components. Adjust, or replace if necessary.
5. Visually inspect all exterior components. Repair or replace them if necessary.
6. Visually inspect the motor, drive, and toque arm components
7. Change drive gear oil if necessary and/or due.
8. Purge bearings with fresh grease.

Note

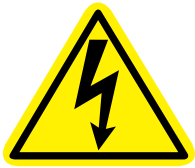
Purge bearings when the rotor is in motion.

7. Maintenance

Proper maintenance will improve safety, efficiency, and will keep the Pocket Feeder operating reliably. All equipment must be locked out and tagged out prior to performing maintenance.

7.1. Maintaining Safely

Follow the information below to prevent maintenance safety hazards. For more detail, refer to [Section 2. – Safety on page 6.](#)



Electrocution Hazard

Do not service or maintain electrical components unless you are an authorized electrician.



Entanglement Hazard

Lock out power before maintaining or servicing.

Replace covers, doors, and guards after maintaining.

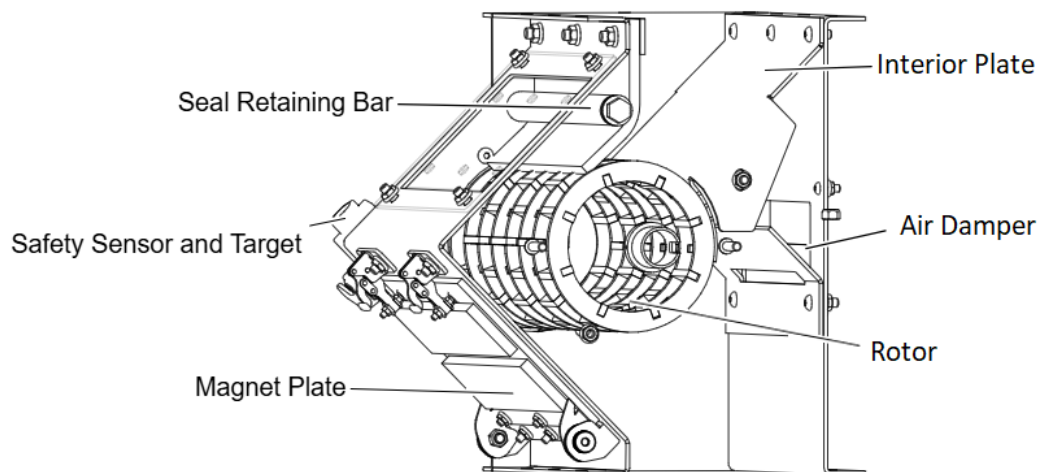
7.2. Maintenance Procedures



WARNING

- Lock out/tag out all equipment before maintenance is performed.
- The Air Assist system (dust filter) on the Hammer Mill must be off prior to performing any work.
- Remove anything that falls into the Hammer Mill chamber. Remove immediately.

Follow the maintenance procedures below. Keep records of the hours the Pocket Feeder has been operated and the maintenance performed.



Inspect the Exterior of the Pocket Feeder

Frequency: Monthly

Procedure:

1. Remove buildup from the exterior of the Pocket Feeder.
2. Remove buildup from the bearing and shaft guard slots to avoid thermal failure and allow adequate airflow.
3. Check the Pocket Feeder housing for wear or damage.
4. Check for any missing or loose hardware.
5. Check the sensor for loose hardware and correct activation. Adjust if required.
6. Check the bearings. Keep clean and lubricated.
7. Check the torque arm assembly.
8. Check the drive and motor.
9. Check magnet hinge and latching mechanism.

Check the Electrical Wiring and Connections



WARNING

- Follow lock out/ tag out procedures before performing electrical work.
- Have a qualified electrician replace any worn electrical wiring.

Frequency: Monthly

Procedure:

1. Check for frayed/exposed wiring. Replace wiring if required.
2. Check all wiring connections. Tighten and secure wiring connections as required.
3. Check function of safety switch.

Inspect the Electric Motor

Frequency: Monthly

Procedure:

1. Remove dust accumulation from the motor frame surface and cooling fins.
2. Clean the air inlet and outlet openings.
3. Check the cooling fan condition.
4. Check the exterior of the electric motor for damage.
5. Check the condition of the seals. Replace if required.
6. Check that mounting bolts are tightened to proper torque. Refer to [Section 10.2 – Bolt Torque on page 30](#) for fastener torque specifications.
7. Check the cable passages, cable gland seals, and seals inside the terminal box. Replace if required.
8. Follow electric motor's manufacturer documentation for bearing lubrication.
9. Check for unusual noise and vibration.

Inspect the Rotor

Frequency: Monthly

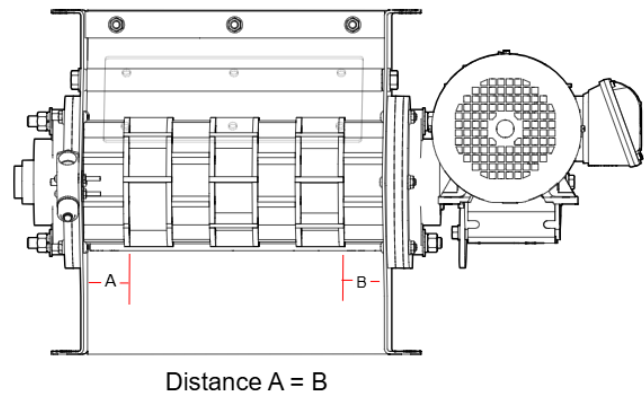
Procedure:

1. Check alignment. Check the rotor is straight and centered.

Note

Distances A and B must be equal to ensure the drum location is correct.

2. Check for wear.
3. Check for missing or loose hardware.
4. Clean any dirt or debris build up.

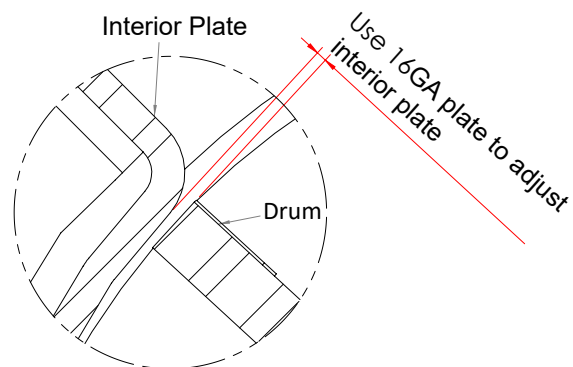


Check the Clearance Between Drum and Interior Plate

Frequency: Monthly

Procedure:

1. Check gap between drum and interior plate. Required gap is 0.06".
2. Ensure motor is not in contact with the interior plate.

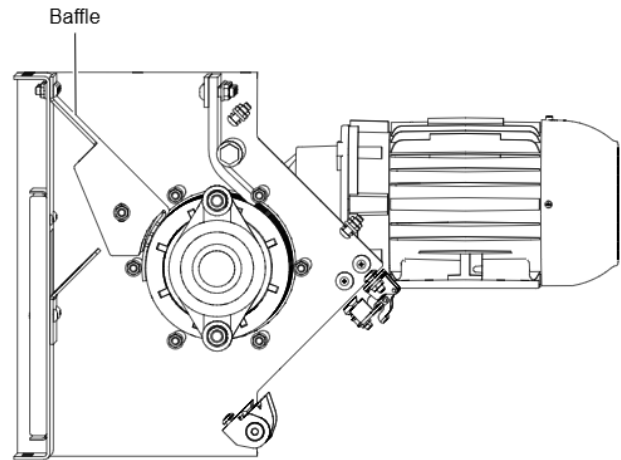


Inspect the Baffle

Frequency: Monthly

Procedure:

1. Check alignment.
2. Check for wear and cracks.
3. Check for missing or loose hardware.
4. Clean any dirt or debris build up.

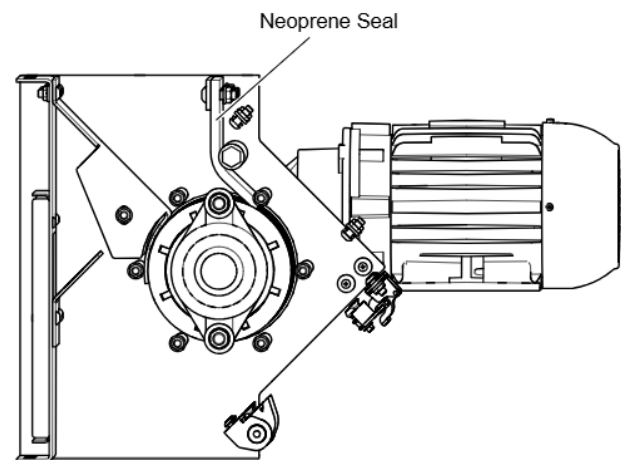


Inspect the Seal

Frequency: Weekly

Procedure:

1. Remove the inspection door.
2. Check the neoprene seal for wear and damaged surfaces.
3. Check for proper alignment and contact with the Pocket Feeder drum.
4. Check for missing or loose hardware.

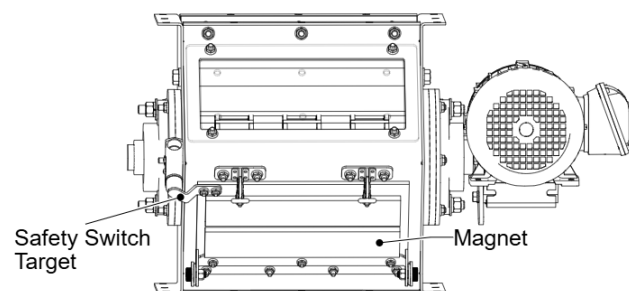


Inspect the Magnet

Frequency: Monthly

Procedure:

1. Check the latching mechanism.
2. Check the hinges.
3. Check for missing or loose hardware.
4. Check the safety switch and switch target.
5. Check the magnet for wear marks.
6. Check seal between magnet and Pocket Feeder body.

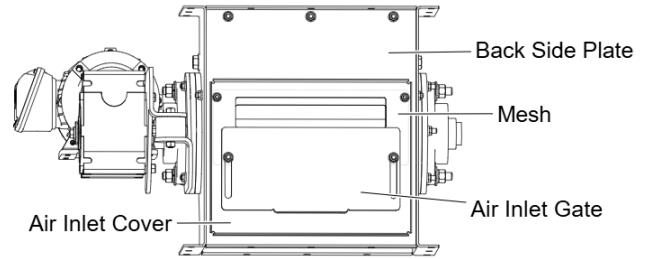


Inspect the Air Inlet

Frequency: Monthly

Procedure:

1. Check for any missing or loose hardware.
2. Check the air system for proper function. All parts should move freely. Adjust positions as needed.
3. Check and clean the mesh.

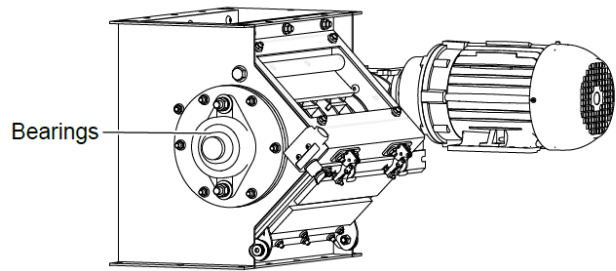


Inspect the Bearings

Frequency: Monthly

Procedure:

1. Check for loose and missing hardware.
2. Keep the bearings clean.
3. Keep the bearings lubricated. Follow manufacturer’s recommendations.
4. Check the bearings set screws. Torque if loose.

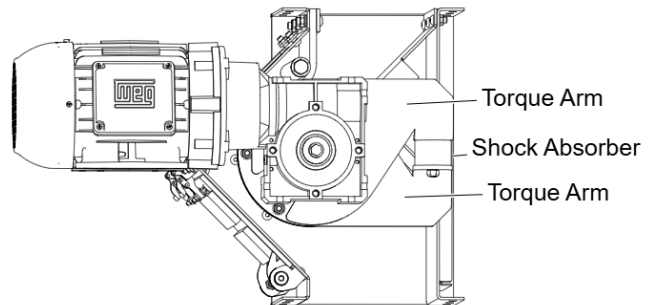


Inspect the Drive

Frequency: Monthly

Procedure:

1. Check the oil level and for oil leaks.
2. Check for any loose or missing hardware.
3. Check if the drive bearings are loose. Adjust them and tighten the set screws if necessary.
4. Check the motor/drive coupler. If worn, replace. Replace every 6 months.
5. Check the torque arm and torque arm hardware including shock absorber. Replace and repair immediately if worn or damaged.
6. Check drive air breather (if equipped). Clean if necessary.



8. Troubleshooting

The following section covers some causes and solutions to some of the problems that may be encountered. For further assistance, please contact AGI or your representative and have this manual and the serial number ready.



WARNING

Shut down and lock out all power sources before diagnosing any of the causes or attempting any of the solutions below.

Problem: **Uneven feed pattern**

Cause

Improper interior plate adjustment or damaged seal.

Solution

Adjust interior plate. Check neoprene seal, if damaged or worn, replace it.

Problem: **Pocket Feeder is not feeding the Hammermill.**

Cause

Feeder drive is not working even though the motor is running.
Rotor remains stationary even when the gear motor is running.

Solution

Check motor coupler. Adjust or replace.
Check drive keystick. Adjust or replace it.

Problem: **Product leaks through the magnet flange.**

Cause

Improper magnet latch adjustment, broken latch, or buildup between magnet flange and housing flange.

Solution

Clean area between the magnet flange and housing flange. Adjust magnet latches. If they are broken, replace them. Replace gasket between the magnet plate and Pocket Feeder body.

Problem: **Motor is not working.**

Cause

The Pocket Feeder is not feeding the Hammer Mill.

Solution

Check breaker, reset it. Check wire connections at the motor and the breaker. Replace motor.

Problem: Oil spills around the Pocket Feeder.

Cause**Solution**

Drive is leaking oil.

Check drive air breather: clean it or replace it. Replace oil seals.

Problem: Poor Pocket Feeder Performance

Cause**Solution**

Rotor vibration
.

Check shaft straightness. Check bearings. Grease them or replace them. Check rotor alignment. Check bearings bolted connections. Check drive torque arm and vibration dumping mount. Check gear drive bearings and oil level. Check housing for cracks and or loose bolted connections. Repair or replace housing. Check inside for any foreign object.

9. Parts List

Item Number	Description	Part Number	Assembly Quantity
1	Nord Flexbloc Size 63 20:1 Ratio	NO1SI63-140TC-107-088	1
2	WEG W22 Electric Motor	MI.5-M-575-TC-TEFC	1 *
3	Interior Plate	HMPF-2014-118	1
4	Drum Seal	HMPF-2014-116	1
5	Body Weldment	HMPF-2014-108, HMPF-2014-109, HMPF-2014-110, HMPF-2014-111, HMPF-2014-115	1
6	Welded in Bolts	BOLTBH031X150	12
7	¼" UNC Flange Nut GR5	NUTFLANGE025	2
8	Round Bar Weldment	HMPF-2014-119	1
9	½" x 1" UNC Flange Bolt	BOL TFL0S0X100	2
10	Vibration Damping Sandwich Mount	9213K640	1
11	Pocket Feeder Bearing Torque Arm	HMPF-2014-TQARM-B	1
12	Pocket Feeder Motor Torque Arm	HMPF-2014-TQARM-M	1
13	Air Inlet Gate	HMPF-2014-124	1
14	Access Door	HMPF-2014-114	1
15	Mesh 1/8" Square	HMPF-2014-127	1
16	Magnet HM Feeder 6" x 12"	MAG-PL-6X12	1 **
17	Spacer Flange	HMPF-2014-112	2
18	Air Inlet Cover	HMPF-2014-123	1
19	5/16" Flange Hex Nut GRS	NUTFLANGE031	12
20	Pocket Feeder Drum Assembly 8"	HMPF-2014-03	1
21	Switch Honeywell BZE6-2RN	INSBZE6-2RN	1
22	Clamps Jergens 702280,	CLA-JE-70280	2
23	5/16" Flange Nut GR5	NUTFLANGE031	2
24	Button head bolt 5/16"x.75"	BOLTBH031X075	2
25	½" UNC Hex Nut GR5	NUTHEX0S0	4
26	½" Lock Washer	WASHLOCK050	4

Item Number	Description	Part Number	Assembly Quantity
27	½" Flat Washer	WASHFLAT050	4
28	2B Flange BRG - 108 Light Duty Ball - SS	BEAF2BSC108	2
29	3/8" Thick Flange	HMPF-2014-113	2
30	2 x ½" UNC x 1.75 Hex Bolt	BOLTHEX050X175	4
31	Interior Plate	HM PF-2014-126	1
32	Magnet Attachment Hinge Plate Assembly	HMPF-2014-125	1
33	¼" Flange Nut	NUTFLANGE025	2
34	¼" x 0.75" Countersink Bolt	BOL TCS025X075	2
35	Magnet Hinge Assembly	HMPF-2014-121, HMPF-2014-122	1
36	¼" Flange Nut	NUTFLANGE025	7
37	¼" x 0.75" Countersink Bolt	BOLTCS025X075	3
38	¼" x 0.7511 Button Head Bolt	BOLTBH025X075	4
39	3/8" Shoulder Screw	91259A435	2
40	3/8" Hex Nut	NUTHEX038	2
41	Plate Washer	HMPF-2014-117	1

* Motor voltage may vary.

** Some field work required.

10. Appendix

10.1. Specifications

- Mild Steel Construction - Painted Finish
- 1.5 hp Direct Shaft Mounted Drive - 575V TEFC Motor (in most cases)
- Integrated Hinged Plate Magnet and Air Intake

Note

Motor voltage may change based on customer electrical system.





10.2. Bolt Torque

Refer to the table below for the correct torque values for various hardware. Tighten all bolts to the torque specified, unless otherwise noted. Check tightness periodically, using the values in the table as a guide. Replace the hardware with the same strength bolt, contact AGI if you are unsure.

Table 1. Recommended Bolt Torque

Size	Dry or Lubricated	Threads per inch (Course/ Fine)	Area of Bolt (sq in.)		Recommended Torque (ft-lb)							
					Grade 2		Grade 5		Grade 8		8.8 S/S	
					Coarse	Fine	Coarse	Fine	Coarse	Fine	Coarse	Fine
1/4"	Dry	20/28	0.0318	0.0364	5.5	6.3	8	10	12	14	6.3	7.8
	Lubricated				6.3	4.7	6.3	7.2	9	10	-	-
5/16"	Dry	18/24	0.0524	0.058	11	12	17	19	24	27	11	11.8
	Lubricated				8	9	13	14	18	20	-	-
3/8"	Dry	16/24	0.0775	0.0878	20	23	30	35	45	50	20	22
	Lubricated				15	17	23	25	35	35	-	-
7/16"	Dry	14/20	0.1063	0.1187	32	36	50	55	70	80	31	33
	Lubricated				24	27	35	40	50	80	-	-
1/2"	Dry	13/20	0.1419	0.1599	50	55	75	85	110	120	43	45
	Lubricated				35	40	55	65	80	90	-	-
9/16"	Dry	12/18	0.182	0.203	70	80	110	120	150	170	57	63
	Lubricated				55	60	80	90	110	130	-	-
5/8"	Dry	11/18	0.226	0.256	100	110	150	170	210	240	93	104
	Lubricated				75	85	110	130	160	180	-	-
3/4"	Dry	10/16	0.334	0.373	175	200	260	300	380	420	128	124
	Lubricated				130	140	200	220	280	310	-	-
7/8"	Dry	9/14	0.462	0.508	170	180	430	470	600	670	194	193
	Lubricated				125	140	320	350	180	180	-	-
1"	Dry	8/14	0.606	0.679	250	280	640	720	910	1020	287	289
	Lubricated				190	210	480	540	680	760	-	-
1-1/8"	Dry	7/12	0.763	0.856	350	400	790	890	1290	1440	288	290
	Lubricated				270	300	590	670	970	1080	-	-
1-1/4"	Dry	7/12	0.989	1.073	500	550	1120	1240	1820	2010	289	291
	Lubricated				380	420	840	930	1360	1510	-	-

Table 1 Recommended Bolt Torque (continued)

Size	Dry or Lubricated	Threads per inch (Course/Fine)	Area of Bolt (sq in.)		Recommended Torque (ft-lb)							
					 Grade 2		 Grade 5		 Grade 8		 8.8 S/S	
					Coarse	Fine	Coarse	Fine	Coarse	Fine	Coarse	Fine
1-1/2"	Dry	6/12	1.405	1.581	870	960	1950	2200	3160	3560	-	-
	Lubricated				650	730	1460	1640	2370	2670	-	-

Note

Torque figures in table are valid unless otherwise specified.
 Only Lubricate bolts or cap screws as directed.
 When using locking hardware, increase torque values by 5%.

11. AGI Warranty

Ag Growth International Inc. warrants that the goods and/or services being supplied (the “Goods”) will be free from defects in materials and workmanship under normal conditions, use, service, and maintenance, for a period of twelve (12) months from the date of first operation of the Goods, but in no event more than eighteen (18) months from the date of delivery of the Goods to the end-user (the “Warranty Term”). If the Goods are being used for rental purposes, the Warranty Term for the subject Goods shall be limited to 90 days.

Subject to AGI’s sole discretion, if the Goods, or a component thereof, are found to have a default in materials and/or workmanship within the Warranty Term, AGI will, at its own option and expense, repair or replace the subject Goods or refund the purchase price for the applicable Goods. Any warranty related expenses incurred on behalf of or by the end-user without the prior written consent of AGI shall be the sole responsibility of the end-user. Expenses relating to travel, customs or import duties and tariffs, equipment rental, and any costs associated with accessing the Goods are the sole responsibility of the customer. Warranty shall be void in the event that the Goods are returned or disposed of without the written consent of AGI.

The customer shall not assert a claim that the Goods are defective unless the customer gives written notice to AGI of such defect within forty-eight (48) hours of discovering such defect. In the event of a warranty claim, the customer must complete any and all information required by AGI in order to properly assess or investigate the claim. AGI shall be given a reasonable opportunity to inspect and test the Goods in question. Failure by the customer to notify AGI of such claim within 48 hours shall operate as a waiver of any and all such claims by the customer.

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