

Slide Gates

Spouts and Connections Assembly and Operation Manual

This manual applies to the following models:

SLDA-701-M-01

SLDF-701-M-01

SLMF-701-M-01

SLDB-701-M-01

SLDG-701-M-01

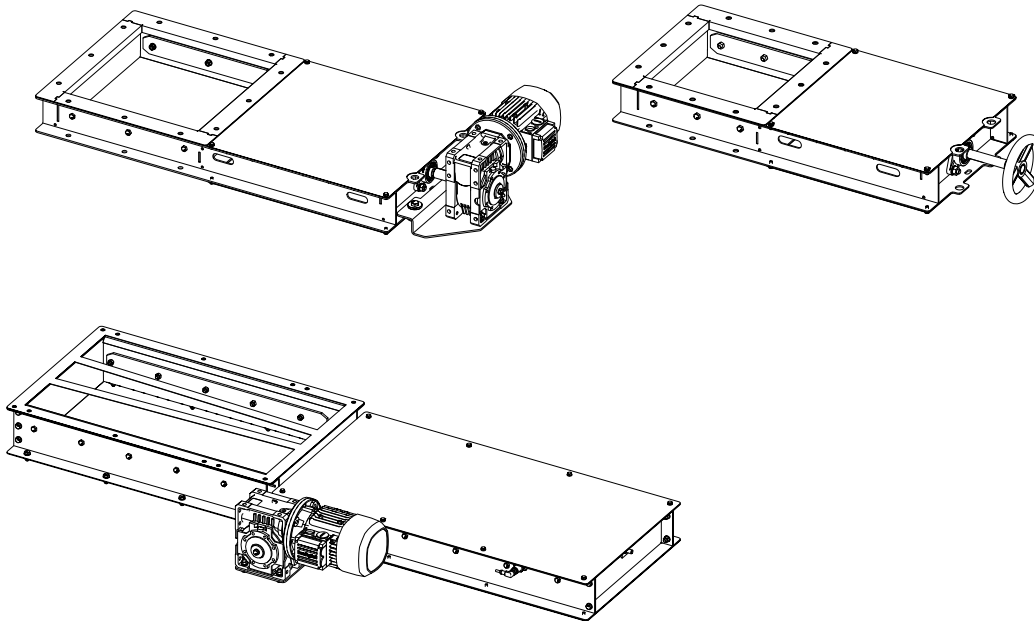
SLMG-701-M-01

SLDC-701-M-01

SLDH-701-M-01

SLMH-701-M-01

SLDD-701-M-01



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: 8210-30069 R0

Revised: September 2024

Original Instructions

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1. Introduction

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

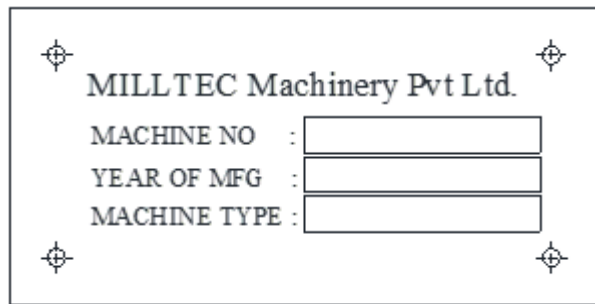
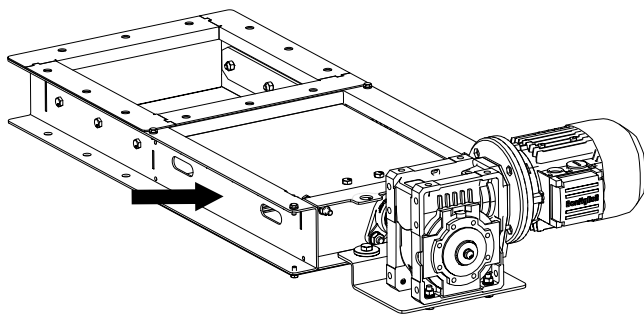
1.1. Intended Use

Slide gate is not a standalone device. It is intended to be installed on the underbin conveyor to allow regulated inflow of dry free-flowing materials.

1.2. Serial Number Location

The serial number location for your slide gate is shown in the figure 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	
Serial Number	
Date Received	



2. Safety

2.1. Safety Alert Symbol and Signal Words



This safety alert symbol indicates important safety messages in this manual. When you see this symbol, be alert to the possibility of injury or death, carefully read the message that follows, and inform others.

Signal Words: Note the use of the signal words **DANGER**, **WARNING**, **CAUTION**, and **NOTICE** with the safety messages. The appropriate signal word for each message has been selected using the definitions below as a guideline.



Indicates an imminently hazardous situation that, if not avoided, will result in serious injury or death.



Indicates a hazardous situation that, if not avoided, could result in serious injury or death.



Indicates a hazardous situation that, if not avoided, may result in minor or moderate injury.



Indicates a potentially hazardous situation that, if not avoided, may result in property damage.

2.2. General Safety Information

Read and understand all safety instructions, safety decals, and manuals and follow them when operating or maintaining the equipment.

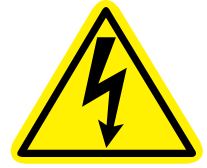
- Owners must give instructions and review the information initially and annually with all personnel before allowing them in the work area. Untrained users/operators expose themselves and bystanders to possible serious injury or death.
- Use for intended purposes only.
- Modification of the slide gate in any way without written permission from the manufacturer is not covered by the warranty.
- Follow a health and safety program for your worksite. Contact your local occupational health and safety organization for information.
- Follow applicable local codes and regulations.



2.3. Electrical Equipment Safety

WARNING Power Source

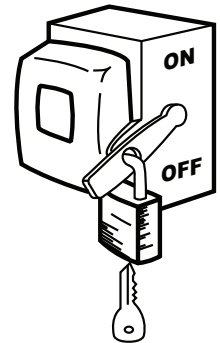
- Electrical equipment and controls shall be installed and serviced by a qualified electrician and must meet all local codes and standards.
- Locate main power disconnect switch within reach from ground level to permit ready access in case of an emergency.
- All electrical equipment must be properly grounded.
- Covers and guards must be in place and secure.
- Ensure electrical wiring and cords remain in good condition; replace if necessary.



Lockout

- Lockout power source before making adjustments, cleaning, maintaining equipment or when not in use. Ensure that all personnel are clear before turning on power to equipment

SERVICE DISCONNECT



2.4. Personal Protective Equipment

The following Personal Protective Equipment (PPE) should be worn when assembling, operating or maintaining the equipment.

- **Safety Glasses**



Wear safety glasses at all times to protect eyes from debris.

- **Steel-Toe Boots**



Wear steel-toe boots to protect feet from falling debris.

- **Coveralls**



Wear coveralls to protect skin.

- **Work Gloves**



Wear work gloves to protect your hands from sharp and rough edges.

2.5. Safety Decals

- Keep safety decals clean and legible at all times.
- Replace safety decals that are missing or have become illegible. See decal location figures that follow.
- Replaced parts must display the same decal(s) as the original part.
- Replacement safety decals are available **free of charge** from your distributor, dealer, or factory as applicable.

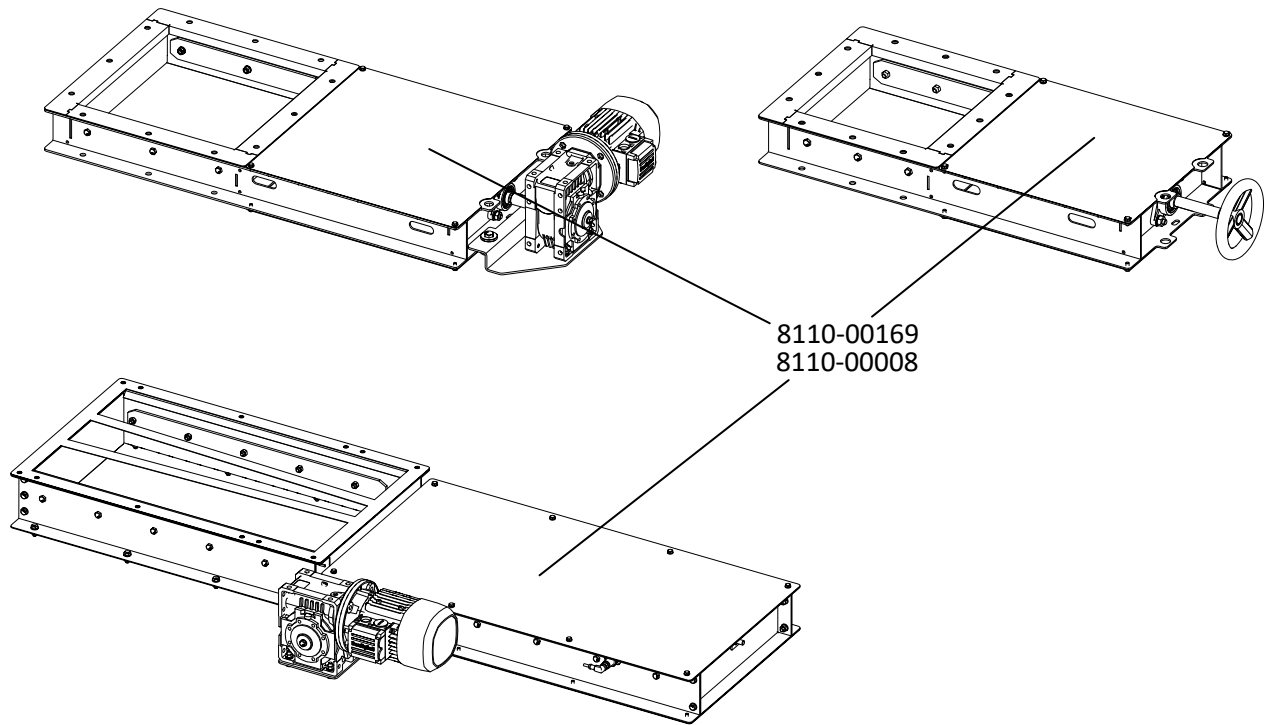
2.5.1 Decal Installation/Replacement

1. Decal area must be clean and dry, with a temperature above 50°F (10°C).
2. Decide on the exact position before you remove the backing paper.
3. Align the decal over the specified area and carefully press the small portion with the exposed sticky backing in place.
4. Slowly peel back the remaining paper and carefully smooth the remaining portion of the decal in place.
5. Small air pockets can be pierced with a pin and smoothed out using the decal backing paper.

2.5.2 Safety Decal Locations and Details

Replicas of the safety decals that are attached to the slide gate and their messages are shown in the figure(s) that follow. Safe operation and use of the slide gate requires that you familiarize yourself with the various safety decals and the areas or particular functions that the decals apply to, as well as the safety precautions that must be taken to avoid serious injury, death, or damage.

Figure 1. Safety Decal Locations



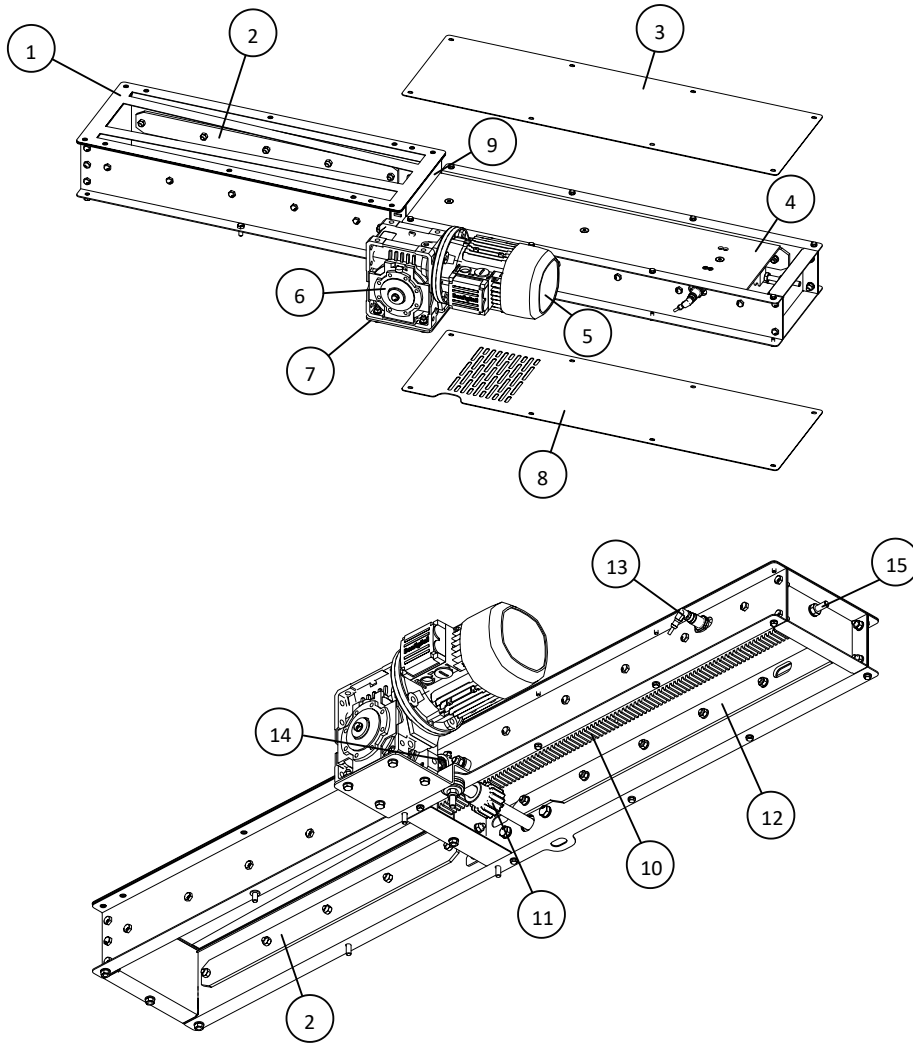
Safety Decals and Part Numbers

8110-00008	8110-00169
<p>WARNING</p> <p>To prevent serious injury or death:</p> <ul style="list-style-type: none"> • Read and understand the manual before assembling, operating, or maintaining the equipment. • Only trained personnel may assemble, operate, or maintain the equipment. • Children and untrained personnel must be kept outside of the work area. • Do not modify the equipment. Keep in good working order. • Lock out power before performing maintenance. • If the manual, guards, or decals are missing or damaged, contact factory or representative for free replacements. 	<p>WARNING</p> <p>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.

3. Features

Slide Gate with Electric Drive Operator

SLDA-701-M-01, SLDB-701-M-01, SLDC-701-M-01, SLDD-701-M-01



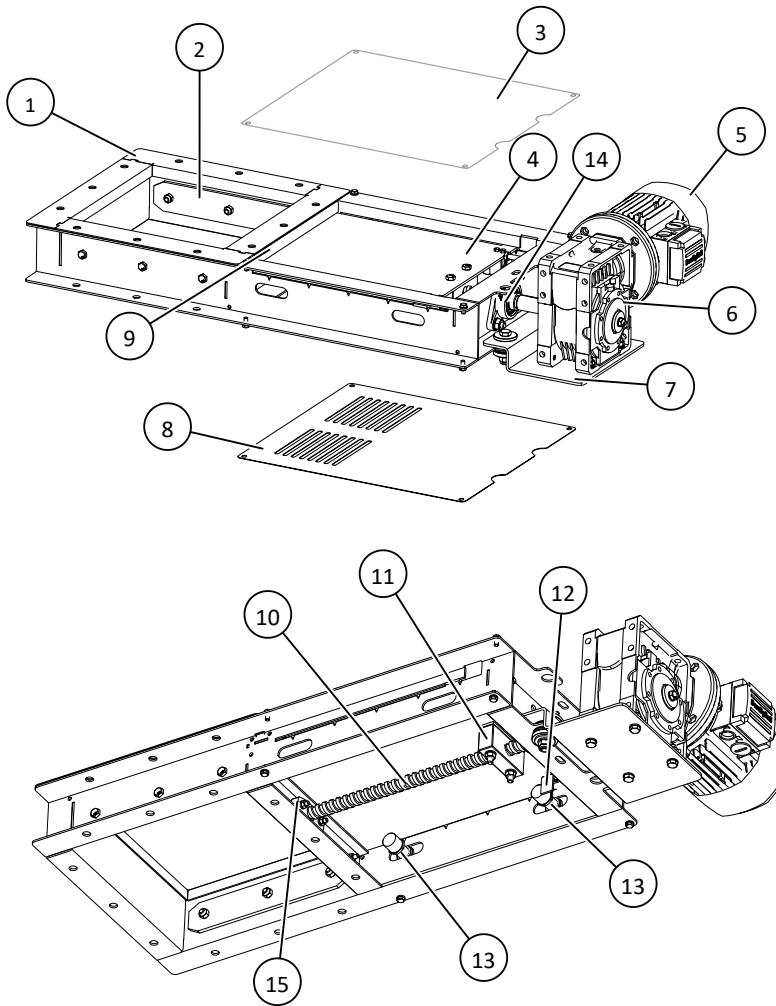
Item	Description
1	Grid Plate
2	Guide Bar (grid plate side)
3	Upper Cover
4	Slide Plate
5	Electric Motor

Item	Description
6	Gear Reducer
7	Motor Mount Bracket
8	Lower Cover
9	Slide Plate Cleaner
10	Rack

Item	Description
11	Pinion
12	Guide Bar (rack and pinion side)
13	Position Sensor
14	Bearing
15	Mechanical Stopper

Slide Gate with Electric Drive Operator

SLDF-701-M-01, SLDG-701-M-01, SLDH-701-M-01



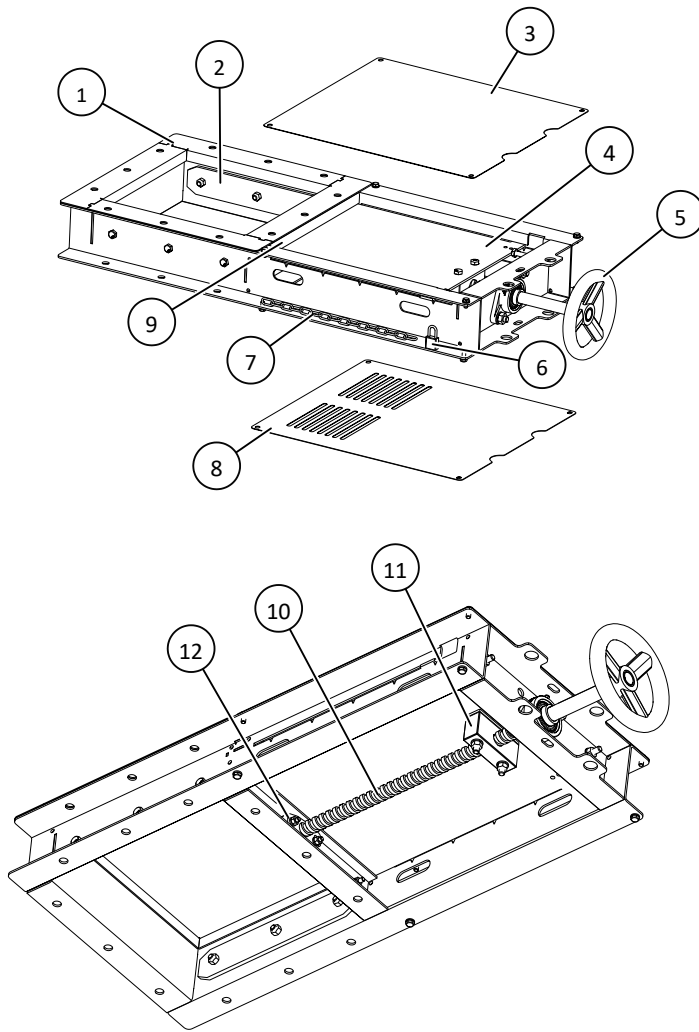
Item	Description
1	Slide Gate Housing
2	Guide Bar
3	Upper Cover
4	Slide Plate
5	Electric Motor

Item	Description
6	Gear Reducer
7	Motor Mount Bracket
8	Lower Cover
9	Slide Plate Cleaner
10	Lead Screw

Item	Description
11	Lead Screw Nut
12	Slide Gate Flange
13	Position Sensor
14	Bearing
15	Screw Support Block

Slide Gate with Manual Operator

SLMF-701-M-01, SLMG-701-M-01



Item	Description
1	Slide Gate Housing
2	Guide Bar
3	Upper Cover
4	Slide Plate

Item	Description
5	Handwheel
6	Lock
7	Chain
8	Lower Cover

Item	Description
9	Slide Plate Cleaner
10	Lead Screw
11	Lead Screw Nut
12	Screw Support Block

4. Pre-Installation

4.1. Approval Drawing

An approval drawing from AGI Milltec is provided with the slide gate. Use the approval drawing when assembling/installing as it contains specific information about component placement and locations.

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

1. Determine the appropriate area for unloading the shipment.
2. Make sure the area is clear before unloading.
3. Unload the slide gate parts on a solid and clean flat surface.

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

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

- Store motors indoors in a clean, dry, and vibration-free environment. If storing for long-term, follow the manufacturer's storage requirements.
- Do not lay bundles on the bare ground. Raise all bundles 6" to 8" off the ground on wood blocks or timbers.
- All other bundles material should be placed so that they are well sloped to promote good drainage.
- 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 all bundles dry before assembly of the slide gate.
- Start assembly as soon as possible.

4.5. Before You Begin

Before you assemble the slide gate:

- Familiarize yourself with all the sub-assemblies, components, and hardware that make up the equipment.
- Have all parts and components on hand, and arrange them for easy access.
- Separate the hardware (bolts, nuts, etc.) and lay them out into groups for easier identification during assembly.

5. Installation

5.1. Installation Safety

⚠ WARNING

- Do not take chances with safety. The components can be large, heavy, and hard to handle. Always use the proper tools, rated lifting equipment, and lifting points for the job.
- Do not stand on, under, or near any component that is not secured.
- Always have two or more people assembling the slide gate.
- Make sure you have sufficient lighting for the work area.
- Tighten all fasteners according to their specifications. Do not replace or substitute bolts, nuts, or other hardware that is of lesser quality than the hardware supplied by the manufacturer.
- Install the equipment in accordance with applicable local codes and regulations.
- Install the position sensors by following the manufacturer's instructions and ensuring all requirements are met.
- All installation and servicing operations are to be carried out by qualified technicians.
- All electrical connections shall be made by a qualified electrician and must meet the applicable local codes and regulations.
- When testing the slide gate, be aware of moving components and avoid all potential pinch points.

5.2. Lifting and Moving

- Inspect all slings and lifting equipment prior to each lift.
- Extreme care must be taken to prevent damage when moving assembled equipment or components.
- Consider unusually heavy items such as drives and gates when choosing support points due to loading balance and its shifting effects.
- Create a barrier using tape or rope to prevent bystanders from entering the work area.
- Determine the lifting points. Lift using at least two support points. Consider the weight of the component in relation to load balance and its bending effect.

5.3. Gate Installation

This section provides general instructions for installation of slide gates. Details may vary depending on the application.

Important

Slide gate mounting flange and other mating flanges should be checked for bends, warping, dirt, and damage. Flanges must be clean, flat, and square with all attached equipment before tightening any bolts.

Install the slide gate according to the following steps to ensure smooth operation and accurate movement of the slide plate. When installed properly, the slide gate should move smoothly from fully open to fully closed position with no binding.

Note

Sealant can also be applied before placing the slide gate into position. If this method is preferred, use care not to disturb the sealant during lifting and positioning procedures.

1. Using the appropriate slings (attached to the four lift points) raise the slide gate assembly and move into position for installation.
2. Install flange bolts and nuts in four corners of the slide gate flange (near the lifting points) and the mounting flange of the equipment to be connected.
3. Hand-tighten four flange bolts, keeping a square alignment between the flanges. Leave a small gap between flange mating surfaces for sealant.
4. Apply a small bead of silicone sealant to one flange of each connection.
5. Install all remaining fasteners. Carefully draw all flange connections together evenly keeping flanges square and straight with one another. Snug all fasteners in a cross-pattern sequence and in several stages to minimize distortion. Tighten all bolts (in sequence) to the recommended torque.
6. After the slide gate is fully installed and connected, operate the slide gate from fully open to fully closed. If the gate has position sensors, check for proper operation with gate in both open and closed commanded positions. Refer to [Section 7.6 – Position Sensor Maintenance on page 19](#) as required.
7. Install covers as necessary.

6. Operation

For optimal operation, follow these safety precautions, checklists, and instructions.

6.1. Operation Safety

- ⚠ WARNING**
- Read and understand the operation of the system for which the slide gate is installed.
 - Keep away from rotating and moving parts.
 - Always operate with guards, covers, and shields in place.
 - Have another trained person nearby who can shut down the equipment in case of accident.
 - Keep the work area clear of bystanders.
 - Ensure maintenance has been performed and is up to date.

6.2. Pre-Start Inspection Checklist

Before using the slide gate for the first time, check and verify the following:

1. Visually inspect the slide gate, see [Section 7.3 – Visually Inspect the Equipment on page 19](#).
2. Check tightness of all bolts/nuts, fasteners, and hardware (re-torque if necessary).
3. **For Slide Gate with Electric Drive Operator:** Ensure the slide gate is properly grounded in accordance with the local codes.

6.3. Start-up and Break-in

1. Test functionality of the slide gate before running the products. If any unusual noises occur, disconnect and lock out the power.
2. After equipment is known to be operating normally, engage full-flow of product through the system.
3. Monitor for proper slide gate function and no product leakage. If no problems, the slide gate can be used in normal operation. If problems are encountered, refer to [Section 8. – Troubleshooting on page 24](#) for more information.

6.4. Operation

This section does not cover specific operation of the slide gate, as operation may depend on the system in which the slide gate is integrated into.

Below are some general guidelines to keep in mind when operating the slide gate.

- Read and understand the operation of the system for which the slide gate is installed.
- Familiarize with the method of slide gate operation.
- Monitor equipment regularly during normal operation.
- Perform scheduled maintenance as required.

6.5. Shutdown

When operation has been completed:

1. Once the slide gate is clear of products, lock out the power source.
2. Clean out any remaining products from the slide gate with a vacuum or sweep out.
3. Clean the entire work area.

6.6. Extended Shutdown

After the season's use, the slide gate should be thoroughly inspected and prepared for extended shutdown. Repair or replace any worn or damaged components and perform maintenance as described in the Maintenance Section to prevent any unnecessary downtime at the start of the next season.

1. Stop the flow of the products from the upstream equipment.
2. Remove all residual material inside the slide gate.
3. Inspect all moving parts to see if anything has become entangled in them. Remove any entangled material.
4. Check the gate guides, slide plate, and corners for residue and blow all dust out the slide gate with compressed air.
5. Inspect the slide gate for cracks, tightness of fittings and fasteners. Have required repairs performed to replace worn or damaged components.
6. Check the gate guides for loosened bolts.
7. Touch up all paint nicks and scratches to prevent rusting.
8. Ensure the slide gate inlet and outlet flanges are securely connected to the mating components.
9. Ensure the covers are closed to protect the slide gate from the weather.

7. Maintenance

Proper maintenance will improve safety, efficiency, and will keep the slide gate operating reliably.

7.1. Maintenance Safety

⚠ WARNING

- Keep components in good condition. Follow the maintenance procedures.
- Ensure the service area is clean, dry, and has sufficient lighting.
- Do not modify any components without written authorization from the manufacturer. Modification can be dangerous and result in serious injuries.
- Shut down and lock out power before maintaining equipment.
- After maintenance is complete, replace all guards, service doors, and/or covers.
- Use only genuine AGI Milltec replacement parts or equivalent. Use of unauthorized parts will void warranty. If in doubt, contact AGI Milltec or your local dealer.



7.2. Maintenance Schedule

Follow the Maintenance Schedule below. Keep good records of the hours the slide gate has been operated and the maintenance performed.

Daily:
Check equipment for proper operation during and after startup up. If a problem is encountered, repair the problem before continuing normal operations. Refer to Section 8. – Troubleshooting on page 24 as necessary.
Monthly:
Refer to Section 7.3 – Visually Inspect the Equipment on page 19. Refer to Section 7.8 – Lubricating the Bearing on page 22.
Quarterly:
Refer to Section 7.4 – Cleaning the Slide Gate on page 19.
Annually:
Section 7.5 – Inspecting the Wiring, Controls, and Electric Motor on page 19.
As needed:
Refer to Section 7.6 – Position Sensor Maintenance on page 19. Refer to Section 7.7 – Adjusting the Mechanical Stopper on page 21. Refer to Section 7.9 – Gear Drive Maintenance on page 22.

7.3. Visually Inspect the Equipment

Before inspection, ensure that the upstream equipment connected to the slide gate is clear of any product.

1. Examine the slide gate for damage or unusual wear.
2. Check that the slide gate inlet is free of obstruction. Remove obstructions as necessary.
3. Check slide gate assembly for dirt, debris, or other obstructions that may restrict slide plate movement. Clean and remove obstructions as necessary.
4. Check slide gate assembly for missing, loose, or worn hardware. Replace or tighten hardware as required.
5. Check that all components of the slide gate assembly are properly aligned and tightly secured. Realign parts and tighten hardware as necessary.
6. Check that the two position sensors are not damaged and are tightly secured. Replace sensor if damaged. If sensor is loose or has been replaced, verify proper sensor-to-magnetic target air gap and tighten sensors. Refer to [Section 7.6 – Position Sensor Maintenance on page 19](#), as required.
7. Check that all slide gate safety decals are in place and legible. Replace decals as required.

7.4. Cleaning the Slide Gate

1. Ensure that the upstream equipment is completely empty.
2. Open the cover. Use compressed air or vacuum to remove any buildup under it.
3. Use compressed air to blow out any material, dirt, or debris left on the top of the gate components, as well as in the gaps between slide plate guides.

7.5. Inspecting the Wiring, Controls, and Electric Motor

- Check electric motor, external components, and wiring connections for damage. Repair as necessary.
- Check for frayed/exposed wiring. Replace wiring as necessary.
- Ensure all electrical connections are secure. Tighten and secure wiring connections as required.
- Ensure the strain reliefs retain wiring firmly and are properly attached to the slide gate's body.
- Replace damaged and defective components.
- Follow the electric motor manufacturer's instructions for routine maintenance.

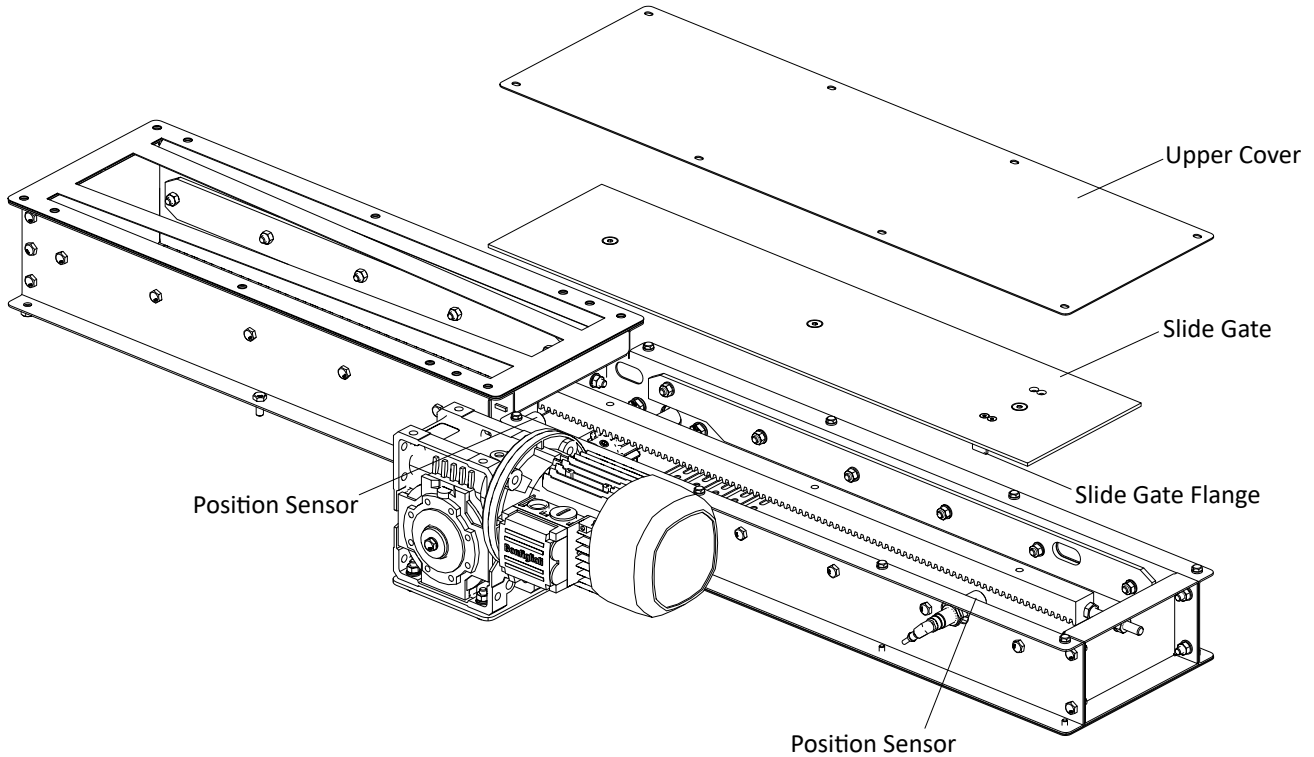
7.6. Position Sensor Maintenance

- Check position sensors for damage. Replace defective or damaged sensors as required and perform the air-gap adjustment procedure.
- Check that sensors are attached tightly and that they do not screw in or out by hand. If a loose sensor is found, perform the following air-gap adjustment procedure.
- Check that slide gate flange is tightly secured.
- Check for loose or damaged wiring or connectors at sensors. Secure or repair as required.

Position Sensor Air-Gap Adjustment

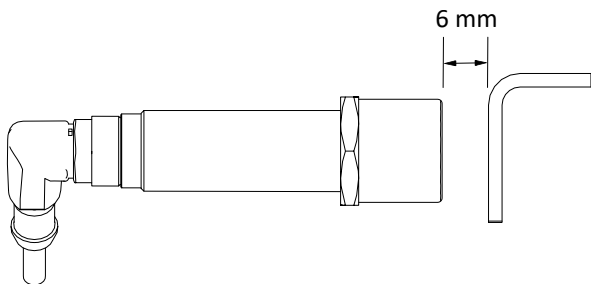
1. Operate gate until slide gate flange is in front of sensor to be adjusted (fully open or fully closed position).

Figure 2. Typical Sensor and Slide Gate Flange Locations



2. Lock out slide gate power.
3. Check that slide gate flange is tightly secured and properly aligned with sensor. Sensor should be at center of the slide gate flange.
4. Measure air-gap between slide gate flange and tip of sensor. Air-gap specification is 6 mm.

Figure 3. Typical Position Sensor Air Gap Specification



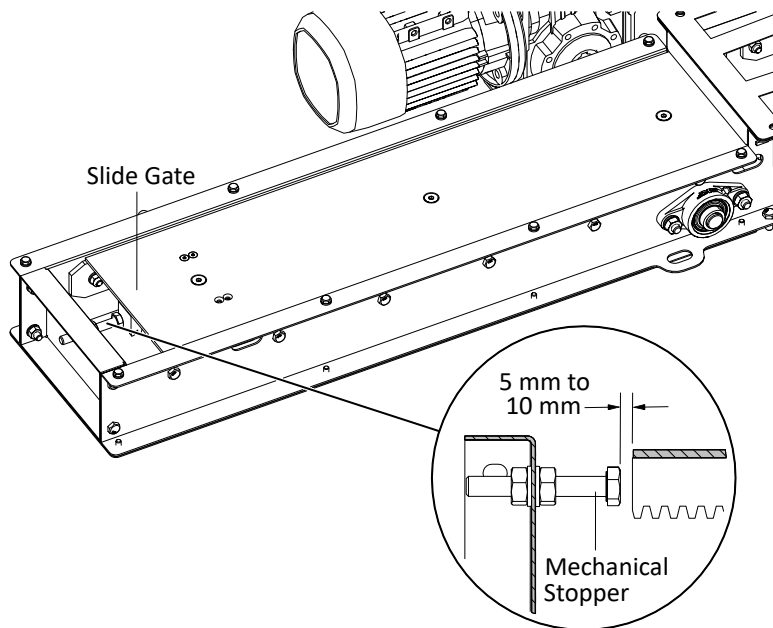
5. Loosen and rotate sensor jam-nuts and adjust to the specified air-gap as required.
6. While keeping the sensor body in position, tightly snug the jam-nuts to prevent sensor movement.
7. After securing the sensor, recheck air-gap. Readjust as necessary.
8. Tighten one sensor jam nut to 12-22 lb-ft (20-30 Nm).

9. Remove lock out and restore slide gate power.
10. Operate slide gate and verify proper function and control.

7.7. Adjusting the Mechanical Stopper

1. Operate gate until slide gate is in fully open position.
2. Lock out slide gate power.
3. Measure air-gap between the front edge of the slide gate and tip of mechanical stopper. Air-gap specification is 5 mm to 10 mm.

Figure 4. Mechanical Stopper Position



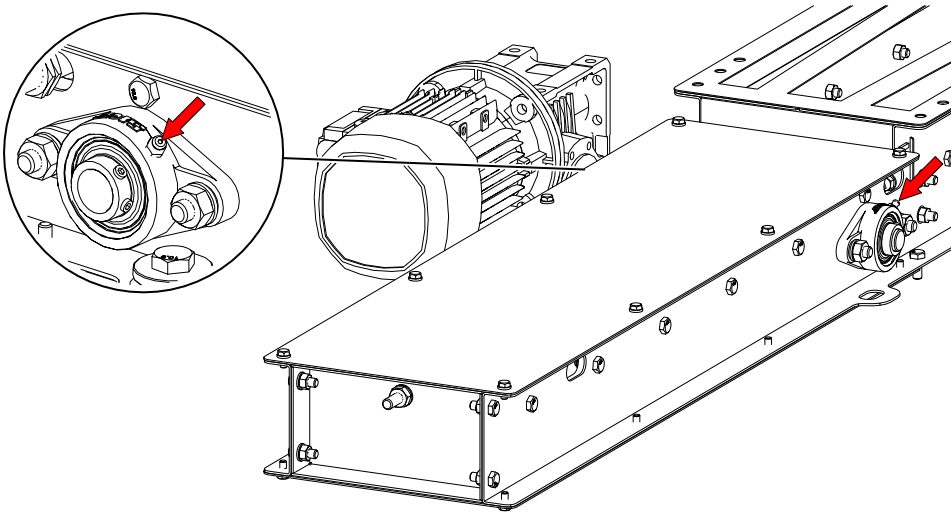
4. Loosen the jam-nuts and adjust to the specified air-gap as required.
5. Tightly snug the jam-nuts to prevent mechanical stopper movement.
6. After securing the stopper, recheck air-gap. Readjust as necessary.
7. Remove lock out and restore slide gate power.
8. Operate slide gate and verify proper function and control.

7.8. Lubricating the Bearing

Note

The lubrication frequency of a bearing is dependant upon speed, load, and working environment. Determine the lubrication frequency that suits your specific operating conditions.

1. Locate the lubrication points.
2. Apply grease at each lubrication point until a small amount of grease is forced out of the bearing ends. Use the grease specified in the manufacturer's documentation.



7.9. Gear Drive Maintenance

Check the following regularly:

- Check the exterior of the gear drive unit and attached components for damage. Replace damaged components as required.
- Check gear drive seals for leakage. Replace seals as required. Refer to gear drive manufacturer's documentation.
- Check the gear drive's breather vent for obstructions and clogging. Clean or replace breather vent as required.

NOTICE

Restricted breather vent may cause drive seal leakage and premature seal failure.

Inspect breather vent regularly. Clean or replace vent as required.

Note

The gear motor is pre-lubricated and does not require routine oil draining and refilling. Refer to the manufacturer's documentation for detailed guidelines.

7.10. Replacement Parts

Ordering Replacement Parts

Call 1(800) 425-8431. Provide the following information.

- Equipment to repair sales order number.
- Part number and paint color, when applicable. Refer to the installation drawing (if this slide gate came with an installation drawing), packing list, or invoice.
- Priority level of the order.
- Your name, complete mailing address, and phone number.



The image is a promotional graphic for AGI MILLTEC. On the left is a circular logo divided into eight segments, each representing a different stage of the mill's process: PARBOILING & DRYING, PROCESSING, COLOR SORTING, BLENDING, PACKING, HANDLING, CLEANING, and STORAGE. The center of the logo features the text "AGI MILLTEC". To the right of the logo is the AGI logo, which consists of a green telephone handset icon and the letters "AGI" in a bold, green, sans-serif font. Below the AGI logo, the text "CALL US @ TOLL FREE NO:" is written in black. Underneath this, two phone numbers are listed in a large, bold, blue font: "1800 102 8431" and "1800 425 8431". At the bottom of the graphic, the text "FOR ALL SUPPORT SERVICES" is written in a bold, red font.

AGI

CALL US @ TOLL FREE NO:

1800 102 8431
1800 425 8431

FOR ALL SUPPORT SERVICES

8. Troubleshooting

Find causes and solutions to common problems that can be encountered.

Troubleshooting

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

The following section covers some causes and solutions to some of the problems that may be encountered.

If there is a problem that is difficult to solve, even after having read through this section, please contact your representative or AGI. Have this manual and the serial number available.

Problem	Cause	Solution
Excessive noise when operating the slide gate	Worn slide plate guides.	Replace slide plate guides.
	Loose hardware.	Tighten loose hardware.
	Damaged lead screw.	Check lead screw for any mechanical damage. Replace if required.
Slide gate is not opening or closing	Worn slide plate guides.	Replace slide plate guides.
	Misaligned, warped, or loose slide plate guides.	Adjust slide plate guides. Tighten the bolts.
	Damaged slide plate.	Check for slide plate deformations. Replace if required.
	Lead screw disconnected from the slide plate.	Check connection. Replace damaged/missing hardware.
Slide gate is not consistently opening to the same point	Dirt buildup or blockage.	Check for any dirt buildup or obstruction that may be restricting the slide gate movement.
Material leaking around the slide plate	Worn slide plate guides.	Replace slide plate guides.
	Loose slide plate guides.	Adjust slide plate guides. Tighten the bolts.



9. Appendix

9.1. Bolt Torque

Table 1 provides the correct torque values for various bolts. The bolt diameter is measured to the outside of the threads. When tightening all bolts, tighten the nut on the bolt to the torque specified in the table, unless otherwise specified. Do not replace or substitute bolts, nuts, or other hardware that is of lesser strength than the hardware supplied by the manufacturer.

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

Table 1. Metric Bolt Torque






Bolt Diameter				
	(N·m)	(ft·lb)	(N·m)	(ft·lb)
M3	0.5	0.4	1.8	1.3
M4	3	2.2	4.5	3.3
M5	6	4	9	7
M6	10	7	15	11
M8	25	18	35	26
M10	50	37	70	52
M12	90	66	125	92
M14	140	103	200	148
M16	225	166	310	229
M20	435	321	610	450
M24	750	553	1050	774
M30	1495	1103	2100	1550
M36	2600	1917	3675	2710

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