

Rotary Valves

Metering Equipment Installation and Operation Manual

This manual applies to:

Micro Rotary Valve

Standard Rotary Valve

High-Capacity Rotary Valve







Read this manual first and follow the instructions and safety precautions to prevent serious injury, death, or property damage. Keep manual for future reference. Part Number: 8210-30039 R0 Revised: November 2024 Original Instructions

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1. Introduction

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

Intended Use

The rotary valve is intended for use as described throughout this manual and as specified on the approval drawing. Use in any other way is considered contrary to the intended use and is not covered by the warranty.

Need More Help?

For help understanding this manual or for additional information, click the link, scan the QR code, or contact your local AGI representative. Additional contact information is located on the back cover of this manual.



2. Safety

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

About Safety Information in this Manual

Safety alert words and symbols are used in this manual. When you see them, follow their messages to prevent injury, death, or equipment damage. The table below explains what they mean.

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

Preventing Safety Hazards

Follow the information below to prevent safety hazards.





• Hire professional help and do not work on the rotary valve if you do not have proper training, experience, and equipment/tools to perform work safely.

Lock-out Power Sources Before Maintaining or Inspecting



To prevent injury:

• Know how to shut-off and lockout 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.



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.

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WARNING ENTANGLEMENT HAZARD

To prevent serious injury or death:

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





Item	Description	ltem	Description
1	Gear Reducer	6	Bearing Cover
2	Inlet	7	Rotary Valve Shaft (hex end)
3	Rotor	8	Inspection Panel
4	Plug Sensor	9	Bearing
5	Electric Motor	<u> </u>	

4. Installation

Installing Safely

Follow the information below to prevent installation safety hazards. For more detail, refer to Section 2. – Safety on page 5.



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.

Installation Drawing

An installation drawing from AGI is provided with the rotary valve. Use the installation drawing when assembling/installing as it contains specific information about component placement and locations.

Check the Shipment

Unload the rotary valve parts at the assembly site and compare the packing slip to the shipment contents. Ensure that all items have arrived and that none are damaged. Take pictures of shipments prior to, or just after, unloading if there are any damages.

Report missing or damaged parts immediately to ensure that proper credit is received from AGI or your representative, and to ensure that any missing parts can be shipped quickly to avoid holding up the assembly process.

Important

Do not assemble or install damaged components.

Product Storage

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

- Store the rotary valve 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 rotary valve 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 rotary valve dry before assembly of the rotary valve.
- Secure the location to prevent unauthorized access.
- Start assembly as soon as possible.

Installing the Rotary Valve

This section provides general instructions for installation of the rotary valve. While details may vary depending on the application, following these instructions will help ensure an efficient and trouble-free installation process.

- 1. Check that the rotary valve mounting flanges and all mating flanges are free from bends, warping, dirt, and damage.
- 2. Lift the rotary valve and guide it into place. Align all flanges and install flange bolts and nuts to four corners of each flange connection.
- 3. Install all remaining fasteners.
 - a. Gradually tighten the bolts following the crosspattern sequence indicated below to minimize distortion.
 - b. Tighten all bolts to the recommended torque. Refer to Section – Bolt Torque on page 22.





4. Remove the pipe plug installed in the gearbox's vent hole and replace it with the vent plug or breather. Refer to the gear reducer manufacturer's documentation for more information.

Note

For shipment, a pipe plug is installed in the vent hole. The appropriate vent plug is packed separately.



5. Operation

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

Operating Safely

Follow the information below to prevent operating safety hazards. For more detail, refer to Section 2. – Safety on page 5.



Entanglement Hazard

Keep away from moving components. Keep guards in place.

Pre-Operating Checks

Check the following before initial use and then regularly as specified in the maintenance procedures.

General

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

Valve

- intake and discharge areas are free of obstructions
- no entanglement present on the moving or rotating parts
- no crack weld or chips on the painted surfaces
- inspection panel is securely fastened

Drive components

- shafts are aligned
- bearings are greased and lubricated
- shaft cover plates are installed

Safety devices

 interlocks and safety controls are functioning properly

Power supply and wiring

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

Using the Rotary Valve

This section is intended as a general guide only as the operation of the rotary valve may vary depending on your operation requirements.

When using the rotary valve for the first time:

- 1. Verify the rotary valve is connected to the control system.
- 2. Bump start or run valve for 2-3 seconds. Check for proper valve rotation and verify correct direction of flow.
- 3. Operate the equipment while empty up to one hour, continuously checking for misalignment of drive and unusual sounds. If any of these problems occur, refer to Section 7. Troubleshooting on page 19.
- 4. For valves equipped with VFDs, check that the protection settings are correctly configured.

Normal Operation

Monitor equipment for proper operation and product flow. Be aware of unusual sounds. If any are heard, determine the source and stop the rotary valve. Lock out the power and correct the problem before resuming work.

Clearing Obstructions

- 1. Lock out/tag out all power.
- 2. Remove the inspection panel.
- 3. Remove obstructions and product from the equipment.

Note

Utilize the hex nut welded to the rotor shaft as a means to rotate it and gain access to the valve's interior and clear any obstructions.



WARNING! Shearing and Entanglement Hazard

Do not use hand to remove obstructions and product.

- 4. Reinstall the inspection panel.
- 5. Restart the equipment and verify proper operation.

Extended Shutdown

If the equipment is planned not to be used for a long period of time, the rotary valve should be thoroughly inspected and prepared for the extended shutdown.

- 1. Remove the inspection panel.
- 2. Make sure that the rotary valve is empty.
- 3. Inspect all components for damage or wear. Replace components as required.
- 4. Lubricate and protect all bearings according to the bearing manufacturer's instructions.
- 5. Use a cover to protect the motor from dust, dirt, and moisture.
- 6. Coat all exposed metal surfaces with rust preventative.
- 7. Reinstall the inspection panel.

6. Maintenance

Proper maintenance will improve safety, efficiency, and will keep the rotary valve operating reliably.

Maintaining Safely

Follow the information below to prevent maintenance safety hazards. For more detail, refer to Section 2. – Safety on page 5.



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.

Maintenance Procedures

Follow the maintenance procedures below. Keep records of the hours the rotary valve has been operated and the maintenance performed.

Check the Electrical Wiring and Connections

Frequency: Weekly during usage

Procedure:

- 1. Check for frayed/exposed wiring. Replace wiring as necessary.
- 2. Check all wiring connections. Tighten and secure wiring connections as required.

Clean the Exterior of the Rotary Valve

Frequency: Monthly during usage

Procedure:

- 1. Use a vacuum to remove any buildup from the exterior of the valve assembly.
- 2. Remove any buildup from the control wiring, electric motor, gear reducer, and plug sensor.

Clean the Interior of the Rotary Valve

Frequency: Monthly during usage

Procedure:

- 1. Remove the inspection panel.
- 2. Remove any buildup from the metering valve and internal surfaces using either a brush or a scraper.

Note

Utilize the hex nut welded to the rotor shaft as a means to rotate it and access all rotor cups during cleaning.

- 3. Use a vacuum to remove any material left on the inside of the valve.
- 4. Dispose of the collected waste according to local regulations.





Lubricate the Bearings

Frequency: Every six months, based on 8 hours of operation per day

Note

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

Required: Use the grease specified in the bearing manufacturer's documentation.

Procedure:

- 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.

Note

It is recommended to lubricate bearings while they are in motion when possible.



WARNING! Shearing and Entanglement Hazard

Exercise caution when applying lubricant to the bearings while they are in motion. Follow safety procedures to avoid contact with the moving parts.

Inspect the Electric Motor

Frequency: Start of every operation season

Procedure:

- 1. Remove dust accumulation from the motor frame surface and cooling fins.
- 2. Check the exterior of the electric motor for damage.
- 3. Check that mounting bolts are tightened to proper torque. Refer to Section Bolt Torque on page 22 for fastener torque specifications.
- 4. Follow manufacturer specific instructions for routine maintenance of electric motor.





Gear Reducer Maintenance

Frequency: Every six months

Procedure:

- 1. Check the exterior of the gear reducer for damage.
- Check the oil level. If oil level is low, add proper lubrication through the filler plug until it comes out the level plug.

Note

Use Mobil Glygoyle 460 polyglycol lubricant or compatible polyglycol lubricants.

NOTICE — Do not overfill or underfill with oil, or mix different oils to avoid component damage.

3. Check for proper oil level after filling.

Note

Oil should rise to the bottom edge of level hole.

- 4. Check the gear reducer seals for leakage. Replace seals as required. Refer to gear reducer manufacturer's documentation.
- 5. Check the gear reducer's breather vent for obstructions and clogging.

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

6. Clean or replace the breather vent as needed.



Change the Gear Reducer Oil

Frequency: As needed

Note

The gearbox is factory filled with Mobil Glygoyle 460 polyglycol lubricant. Change the synthetic lubricant only when performing maintenance that requires gearbox disassembly.

Required: Use Mobil Glygoyle 460 polyglycol lubricant or compatible polyglycol lubricants.

Procedure:

- 1. Drain the oil completely. Clean the drain plug and reinstall it.
- Refill the gear reducer with Mobil Glygoyle 460 polyglycol lubricant or compatible polyglycol lubricants. Refer to the table below for the gearbox oil capacities.

Oil Capacities (ounces)

Mounting Position	Gearbox Size		
	826	830	
Worm Over	40	56	

3. Check for proper oil level after refilling.

Note

Oil should rise to the bottom edge of level hole.



7. 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 ready.



WARNING! Risk of injury

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

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 available.

Problem: Rotor catches, binds, or has abnormal noise during operation.			
Cause	Solution		
Debris or obstruction in the valve.	Clean valve or remove obstruction.		
Feed rate is above specification.	Calibrate metering unit.		
Excessive product buildup.	Reduce moisture in upstream product.		
Dry or seized bearing.	Lubricate or replace bearing as required.		

Problem: Valve has excessive product caking or buildup.			
Cause	Solution		
Too much moisture in product.	Reduce moisture in upstream product.		
Improper rotor rotation.	Check for improper rotation. Reverse direction of electric motor. Contact an authorized electrician as required.		

Problem: Product bridges or does not move through valve properly.			
Cause	Solution		
Too much moisture in product.	Reduce moisture in upstream product.		
Worn rotor or excessive housing- to-rotor clearance.	Check rotor and housing for proper clearances. Contact AGI for more information.		

Problem: Valve motor is inoperative.			
Cause	Solution		
Motor not receiving full supply voltage.	Check for proper supply voltage. Repair as necessary. Contact an authorized electrician as required.		
Motor may be damaged or defective.	Motor windings may be shorted. Repair or replace motor as required.		

Problem: Motor runs, gear reducer inoperative.			
Cause	Solution		
Loose or damaged coupler.	Inspect coupler for alignment and tightness. Realign and tighten coupler as required. If coupler shows signs of damage, replace coupler.		
Gear reducer may be damaged or defective.	Replace gear reducer as required.		

Problem: Gear reducer overheats.			
Cause	Solution		
Lack of lubrication in the gear reducer.	Fill gear reducer lubrication to proper level.		

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8. Specifications

Dimensions



Valve	Inlet Dimension (L _i x W _i)	Outlet Dimension (L _o x W _o)	Valve Height (H)	
Standard Rotary Valve	22-1/4" x 22"	22-1/4" x 19-1/4"	13-7/8"	
Micro Rotary Valve	22-1/4" x 22"	22-1/4" x 19-1/4"	14"	
Volumetric Rotary Valve	22-1/4" x 22-1/4"	22-1/4" x 19-1/4"	14-3/4"	

Capacities

Valve	Motor Size (hp)	Gearbox Ratio	Minimum		Maximum	
			ft³/h	m³/h	ft³/h	m³/h
Micro Rotary Valve	2	40:1	54	1.53	480	13.59
Standard Rotary Valve	2	20:1	168	4.76	1572	44.51
High-Capacity Rotary Valve	3	20:1	480	13.59	4500	127.43

9. Appendix

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.

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

Recommended Bolt Torque

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%.

10. 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 enduser. 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.

THIS IS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY AGI WITH RESPECT TO THE GOODS AND IS IN LIEU OF AND EXCLUDES ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, ARISING BY OPERATION OF LAW OR OTHERWISE, INCLUDING WITHOUT LIMITATION, MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE WHETHER OR NOT THE PURPOSE OR USE HAS BEEN DISCLOSED TO SELLER IN SPECIFICATIONS, DRAWINGS, OR OTHERWISE, AND WHETHER OR NOT AGI'S GOODS ARE SPECIFICALLY DESIGNED AND/OR MANUFACTURED BY AGI FOR BUYER'S USE OR PURPOSE.

This limited warranty extends solely to Goods manufactured by AGI and does not cover any third-party parts, components, or materials. To the extent permitted by the manufacturer, AGI will pass on applicable warranties on third-party parts, components or materials to the end-user. This warranty does not extend to any losses or damages due to misuse, use of a kind and/or to a degree not reasonably expected to be made of the Goods, any use of the Goods which is not an intended use as specified in AGI's published product literature or otherwise specified by AGI in writing, accident, acts of God, abuse, neglect, normal wear and tear (including corrosion and cosmetic issues), any equipment attached to or used in conjunction with the Goods, any field modifications or substitutions to original Goods, component damage incurred during shipping and handling, unauthorized modification or alteration, used beyond rated capacity, or improper installation, maintenance or application.

THE SOLE AND EXCLUSIVE REMEDY FOR ANY CLAIM HEREUNDER SHALL BE LIMITED TO REPAIR, REPLACEMENT, OR REFUND OF THE PURCHASE PRICE. AGI SHALL NOT BE LIABLE FOR DAMAGES CAUSED BY DELAY IN PERFORMANCE AND IN NOT EVENT, REGARDLESS OF THE FORM OF THE CLAIM OR CAUSE OF ACTION (WHETHER BASED IN CONTRACT, INFRINGEMENT, NEGLIGENCE, STRICT LIABILITY, OTHER TORT OR OTHERWISE), SHALL AGI'S LIABILITY TO BUYER AND/OR ITS CUSTOMERS EXCEED THE PURCHASE PRICE OF THE GOODS. BUYER AGREED THAT IN NO EVENT SHALL AGI'S LIABILITY TO BUYER AND/OR ITS CUSTOMERS EXCEED THE TERM "CONSEQUENTIAL DAMAGES" SHALL INCLUDE, BUT NOT BE LIMITED TO, LOSS OF ANTICIPATED PROFITS, LOSS OF USE, LOSS OF REVENUE, FAILURE TO MEET GOVERNMENT AND/OR ADMINISTRATIVE REQUIREMENTS, CLEAN UP COSTS, COST OF CAPITAL AND DAMAGE OR LOSS TO OTHER GOODS, PROPERTY OR EQUIPMENT.

THIS WARRANTY IS NON-TRANSFERABLE AND APPLIES ONLY TO THE ORIGINAL END-USER AND SHALL BE CONSIDERED VOID IF NOT REGISTERED WITHIN 30 DAYS OF RECEIPT OF THE GOODS BY THE ORIGINAL END USER.

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