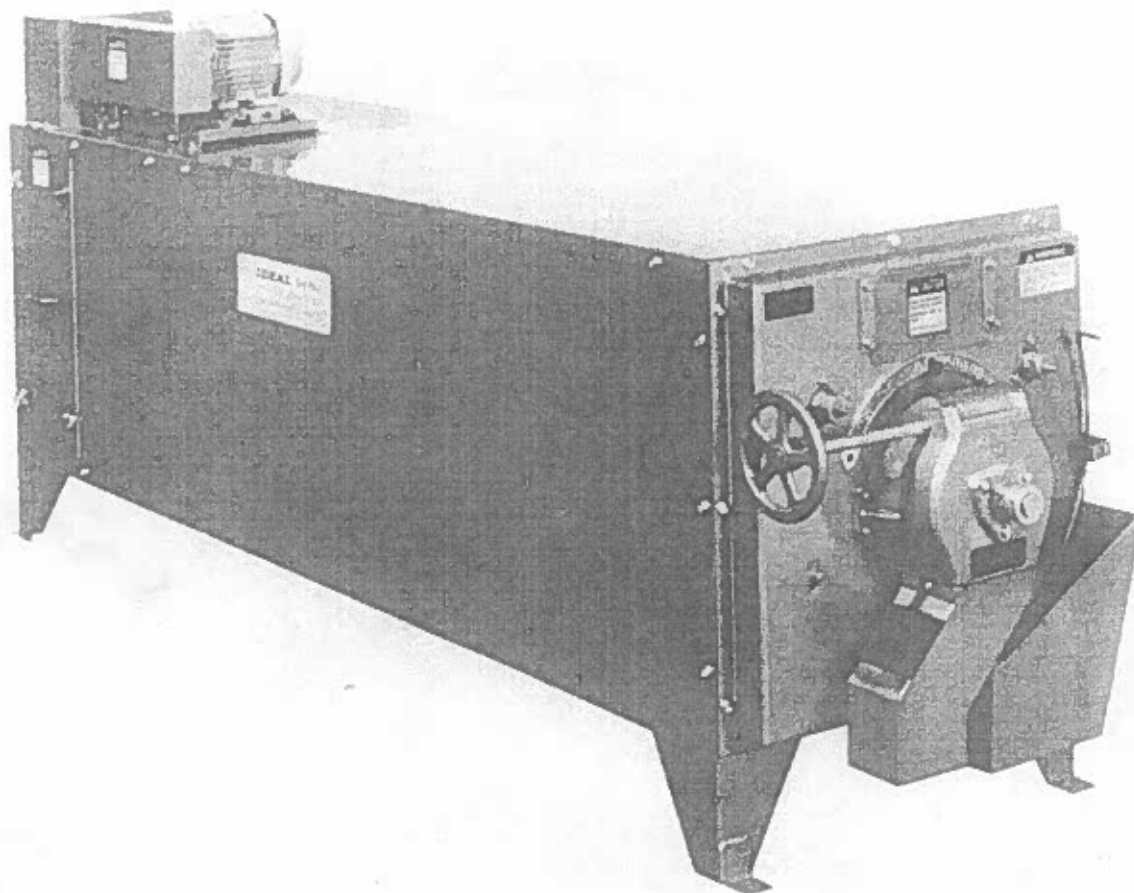


OPERATION AND REPAIR PARTS MANUAL



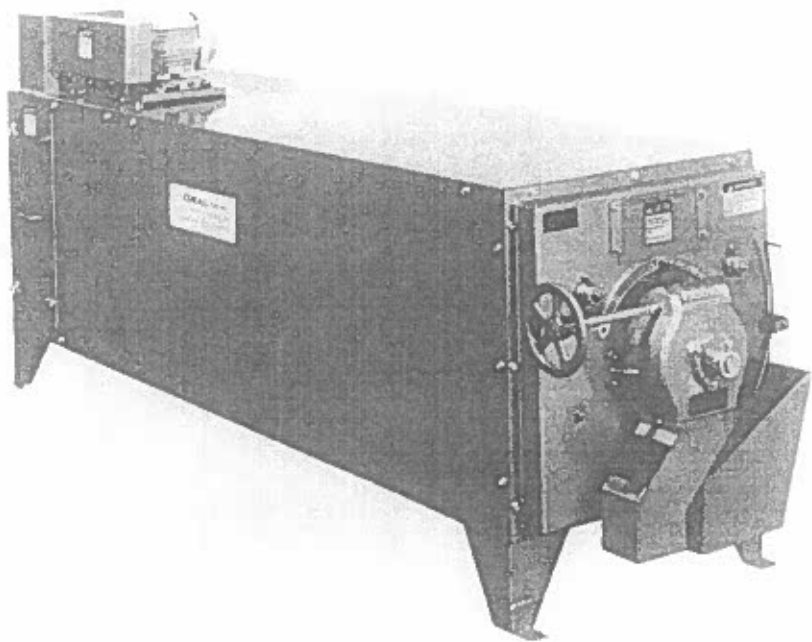
IDEAL MODEL S-1 **Self Flow Length Grader**

CRIPPEN *MANUFACTURING CO., INC.*

400 Woodside Drive - Saint Louis, MI 48880
Phone: 989/681-4323; Toll Free: 800/872-2474
Fax: 989/681-3818

MANUFACTURING AND REPAIRING OF GRAIN CLEANING MACHINES

INTRODUCTION



The Model S-1 Self Flow Length Grader is a basic, one cylinder machine which is designed to clean grain and seed and make separations by length only. The exclusive tapered indent cylinder allows product to flow through the machine for continuous running. A variety of indent cylinder sizes combined with control flexibility and the capability of combining two or more S-1 machines in various height and width combinations allows the processing of many types of product and capacities.

Consult your sales literature or contact your local sales representative to help you with any cleaning, grading or separating problems. Our Seed Laboratory offers a sample testing service at no obligation or price to you. Send grain and seed samples or written inquiries to:

CRIPPEN MANUFACTURING COMPANY INC.
400 Woodside Drive, Saint Louis, MI 48880

Or call (800) 872-2474

USE OF MANUAL

This manual has been prepared especially for use in familiarizing owners and operators with the operation and maintenance of the IDEAL SELF FLOW LENGTH GRADER, Model S-1. In some instances, the information contained in this manual has been generalized since certain specific information can be determined only by actual experience. For thorough understanding, optimum operation and proper maintenance of the IDEAL S-1, please give all the information in this manual your careful consideration.

The right hand and left hand sides of the machine are determined by viewing the machine from the discharge (front) end. As a further aid to orientation, drawings in this manual are designated by direction arrows or captions as to their position.

MECHANICAL SPECIFICATIONS

Overall Height (with motor)	42"
Overall Height (without motor)	35-1/4"
Overall Length	107"
Overall Width (with motor)	27"
Overall Width (without motor)	27"
Length on Floor (base)	92-3/4"
Width on Floor (base)	27"
Width of Inlet Hopper Opening	3-1/4"
Length of Inlet Hopper Opening	7-1/2"
Length of Complete Cylinder	87-5/8"
Power Required	3/4 H.P.
Shipping Weight	Approx. 800 lbs.

INSTALLATION

Machine should be set on a level foundation which is free from as much floor vibration as possible. Adequate clearance around machine should be provided to allow access for service and maintenance. Ideally, one end of the machine should have enough clearance to allow cylinder replacement.

A suitable connection must be provided at the feed hopper to connect to the 3¼" x 7½" opening. The machine operates most efficiently if the product is choke-fed to assure a constant infeed volume and flow.

If a motor is supplied with your machine, refer to the packing list or motor nameplate to identify power requirements.

Electrical installation should be done by a qualified electrician, strictly following or exceeding local safety codes. A lockable power switch is recommended to prevent accidental start up during maintenance.

CAUTION

Check rotation of motor pulley after making electrical connections. Viewing motor from pulley end, motor should rotate clockwise. If not, reverse the electrical connections to the motor.

The S-1 machine has been completely pre-lubricated before being shipped from the factory. See Maintenance Section for operational lubrication.

OPERATION

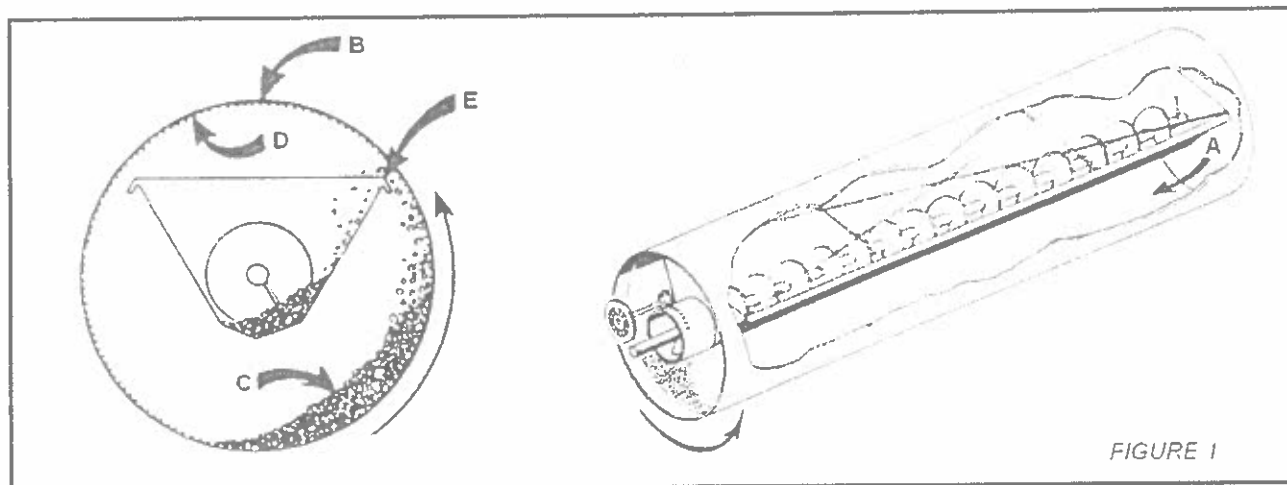


FIGURE 1

SEQUENCE OF OPERATION

Product is choke-fed into feed hopper and is discharged into the rear of the cylinder at (A, Figure 1). The counter-clockwise rotating action and the tapered construction of cylinder (B) cause the movement of product along the inside bottom of cylinder toward the front (discharge) end.

The retarder (6, Figure 2) dams up product at the discharge end of the cylinder until a wall is built up of product (C) for the entire length of the cylinder.

Thousands of indent pockets (D) in the rotating cylinder pick up the smaller particles such as grain or seeds and are carried over the separating edge (E). Gravity forces the small particles to fall into the trough where a rotating auger moves them to the discharge opening.

Larger particles such as weeds and longer seeds which cannot be lifted are built up at the retarder where they flow over the retarder and are discharged.

The location of the separating edge, the indent size, the speed of the cylinder and the height of the retarder are all factors in determining maximum separating or cleaning performance.

OPERATING CONTROLS

TROUGH CONTROL – Handwheel (1, Figure 2) is moved clockwise to lower the separating edge of the trough and counterclockwise to raise the edge. Position of trough is locked with Lockscrew (2, Figure 2). As a further aid to the location of the separating edge, pointer (3, Figure 2) is aligned with the edge and increments on decal can be used to record changes in settings.

INSPECTION PORT – Inspection Cover (4, Figure 2) can be pivoted to observe the position of the trough and separating action during operation.

RETARDER CONTROL – Retarder control rod (5, Figure 2) adjusts the position of the retarder (6, Figure 2) and is locked into position with wing nut and eye bolt (7, Figure 2). An increasing amount of product is held in the cylinder as the retarder is raised. When retarder is fully lowered, it is in the cleanout position and allows product to flow freely out of the cylinder.

FEED HOPPER SHUT-OFF SLIDE – Product flow may be shut off and regulated by the shut-off slide (19, Figure 6), located at the rear of the machine. A thumbscrew has been provided to lock the slide in various positions.

FIGURE 2 – Operating Controls

RECOMMENDED CYLINDER ROTATION SPEED

The following chart lists various types of indent cylinders and the range of speeds which are best suited for separation or cleaning. Further adjustment is made with control settings.

CYLINDER INDENT SIZE	CYLINDER R.P.M.
#8 to #23	45 to 52
#26	42 to 46
#28 to #30	40 to 45

To increase the speed of the cylinder, lower the motor base by adjusting turnbuckle (21, Figure 4), thus increasing the pitch diameter of the motor sheave (25, Figure 4). Decreasing the speed is accomplished by raising the motor base with the adjustable turnbuckle which decreases the pitch diameter of the motor sheave. When an adjustable sheave is used, stop machine and adjust motor sheave for correct cylinder speed.

INITIAL START-UP

1. Loosen lockscrew on handwheel shaft and turn handwheel until top of trough is in a horizontal position. Check position through inspection port and note pointer setting. Setting should be about $3\frac{1}{2}$ or 4. Secure with lockscrew.
2. Loosen wing nut on retarder control handle and raise handle until approximately 3" of discharge opening are left. Lock retarder position with wing nut.
3. Check to see that shut-off slide is fully into feed hopper.
4. Supply an adequate volume of product to the feed hopper to allow continuous choke-feeding.
5. Start machine and when cylinder is rotating at recommended speed, open shut-off slide to desired position and lock with thumbscrew.
6. Allow machine to run a few minutes until product is distributed along the bottom of the cylinder and against retarder.

WARNING

MACHINE MUST NOT BE STOPPED UNTIL EMPTY OF PRODUCT BECAUSE START-UP UNDER FULL LOAD COULD DAMAGE DRIVE PARTS.

MAINTENANCE

To assure continued satisfactory operation of the S-1 Machine, it will be necessary to perform the periodic maintenance described in this section. The recommended service intervals are based on forty hours per week of machine running time. If running time is more than forty hours per week, maintenance should be scheduled accordingly.

WARNING

DO NOT PERFORM ANY MAINTENANCE ON THE MACHINE WHILE IT IS RUNNING. ALWAYS BE SURE POWER SWITCH IS TURNED OFF AND IF POSSIBLE, LOCKED IN AN OFF POSITION.

OPERATIONAL CHECKS

The preceding starting sequence describes the general start-up procedure applicable to all grain products used in the S-1 Machine. The actual control settings can be determined by experience only and it is recommended that the operator maintain a record of control settings for various products as an aid for future operations.

When the machine is shipped from the factory, all separating cylinders are coated with a rust inhibitor. After the machine has been in operation for four or five hours, the inner surfaces of the cylinder will become smoothly polished which changes the operating characteristics. Therefore, it will probably be necessary to readjust control settings to obtain maximum results.

CONTROL ADJUSTMENTS

After the machine has been running with product for a few minutes, sample small grain by inserting a small hand scoop into the opening of the discharge head and large grain which is discharging over the retarder.

If too much large grain is being lifted into trough, move pointer to a higher number thereby raising the leading or separating edge of the trough. If the output of small grain is too small, lower leading edge of the trough by using a smaller setting. Ideally, the height of the separation edge should be set so that small grain is lifted just over the edge before dropping into the trough. Secure trough with lockscrew.

When short material is present in long material being discharged over the retarder it is necessary to raise the retarder slightly. When long material is being carried into the trough, the retarder could be set too high and should be lowered slightly.

NOTE: When changing control settings, wait a few minutes to observe effects of control changes.

The S-1 Machine may be used for grading or cleaning. For a grading operation, clean or aspirated grain which is supplied to the feed hopper is separated more efficiently.

STOPPING AND CLEANOUT

1. Shut off product supply at inlet hopper by moving shut-off slide to the fully in position.
2. Move trough to the dump position (pointer in "D" position on calibration decal).
3. Push retarder control handle down to allow maximum retarder opening.
4. Run machine a few minutes until machine empties and then shut off power to the drive motor.
5. Clean out by hand any foreign material that might be held or imbedded in the retarder. This material might cause undue wear to the cylinder or retarder.

SCHEDULED MAINTENANCE

Grain and dust accumulations should be cleaned from the area daily or at the end of each shift. Excessive accumulations of dirt, especially on shafts, bearings and controls can lead to operational difficulties.

Foreign material such as pieces of metal, glass, etc., which have accumulated behind the retarder should be removed daily or at the end of each shift. See Step 5 of Stopping and cleanout.

After the first week of operation, check setscrews on all bearings, sprockets and pulleys for tightness. Inspect the entire machine for loose bolts or nuts and tighten if necessary. Recheck tightness occasionally.

LUBRICATION

The S-1 Machine has been prelubricated before leaving the factory. For moderate temperature operation, use only a high quality, medium pressure bearing grease for all bearings. For sub-zero temperature operation, use light pressure grease for all bearings.

Sealmaster® bearings should be lubricated according to the manufacturer's recommendations. A general rule would be to lubricate these bearings with 4 to 5 shots of good quality grease from a hand gun at least every 200 hours of running time and more often when machine is running in extremely dirty conditions or high temperature.

Bronze bearing should be lubricated with bearing grease every forty hours of running time.

Lubricate roller chain with a good grade commercial chain lubricant or with SAE 10W oil. Brush a liberal amount on the chain to assure adequate lubrication of all internal chain pivot points. Chain may be lubricated without removing the machine side cover by pivoting cover (17, Figure 4) and working through the access hole.

Friction Rollers (29, Figure 5) which have needle type bearings should be greased every 40 hours of running time.

Apply light oil to all control pivot points periodically.

SERVICE

Your local Ideal distributor is trained to service this machine and assist you with any service, operation or adjustment problems that you may have.

CYLINDER REPLACEMENT, SHAFT ADJUSTMENT

When replacing the indent cylinder, enough clearance must be provided to re-move the cylinder straight out of one end of the machine.

The placement of the shafts in the cylinder is critical. Position the plain end of the shaft exactly $8\frac{1}{16}$ " from the ends of the cylinder as shown in Figure 3. Tighten all setscrews securely.

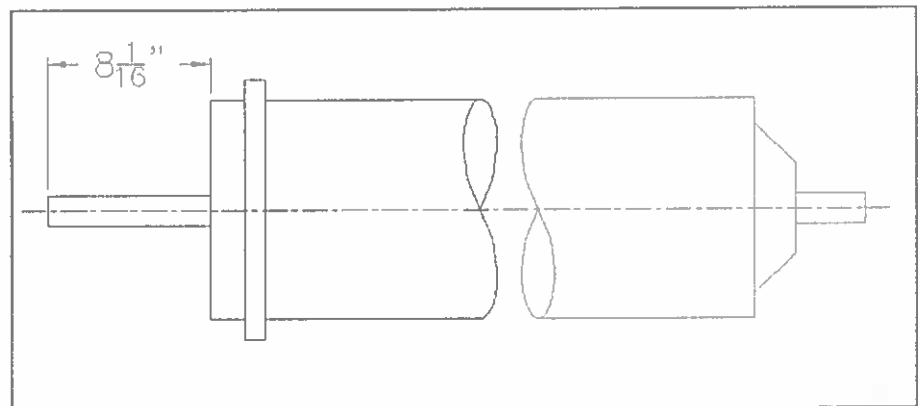


FIGURE 3 – Shaft Location

REPAIR PARTS

The following pages illustrate and list all repair parts for the Ideal S-1 Self Flow Length Grader. Common hardware items such as nuts, bolts, washers, etc., are not listed. It is advisable to obtain these items from your local source.

PARTS ORDERING INFORMATION

1. Order repair parts from your local Ideal distributor or the home office:

Crippen Manufacturing Company Inc.
400 Woodside Drive
St. Louis, MI 48880
Phone: (800) 872-2474

2. Always specify the model and serial number of the machine when ordering replacement parts. This information is shown on the machine serial plate which is located on the front end plate.

3. Please furnish the part number, description and quantity desired for each part ordered as shown in the following list. Do not show the item number.
4. Specify any special shipping instructions.

CYLINDER ORDERING INFORMATION

When ordering cylinders, please specify INDENT SIZE in addition to part number, description and quantity desired. For ease of installation, it is recommended that a new cylinder be purchased complete with end and ring because these parts are difficult to install correctly in the field. The intake cone assembly or ring sprocket should be ordered separately if required.

PARTS LIST

FRAME, COVERS AND DRIVE (FIGURE 4)

Item	Part No.	Description	Qty	Item	Part No.	Description	Qty
1	3W676	Guard, Main Drive.	1	14		Top Cover, Front.	1
2	567	Side Cover, Right Hand.	1	15		Motor, 1 HP (Specify)	1
3	568	Angle, Frame Top RH.	1	16	3W461	Top Brace, Frame	2
4	3W458	Leg Weldment, LH	2	17		Cover, Inspection.	1
5	3W457	End Weldment, Frame Rear	1	18		Reducer Sheave	1
6		Decal, Company Identification	2	19	A308	Reducer	1
7	570	Angle, Frame Bottom RH	1	20		Sprocket.	1
8	3W459	Leg Weldment, RH	2	21		Reducer Motor Plate.	1
9	3W460	End Weldment, Frame Front.	1	22		Belt.	1
10	A350	Frame Assembly (Includes Items 3,4,5,7,8,9,11,13 & 16).	1	23		Top Cover, Rear.	1
11	571	Angle, frame bottom LH	1	24	644	Bearing Plate Support.	1
12		Side Cover, Left Hand	1	25		Sheave, Motor (Specify).	1
13	569	Angle, Frame Top LH	1	26	643	Bearing Plate	1
				27	143-T	Motor Mount.	1

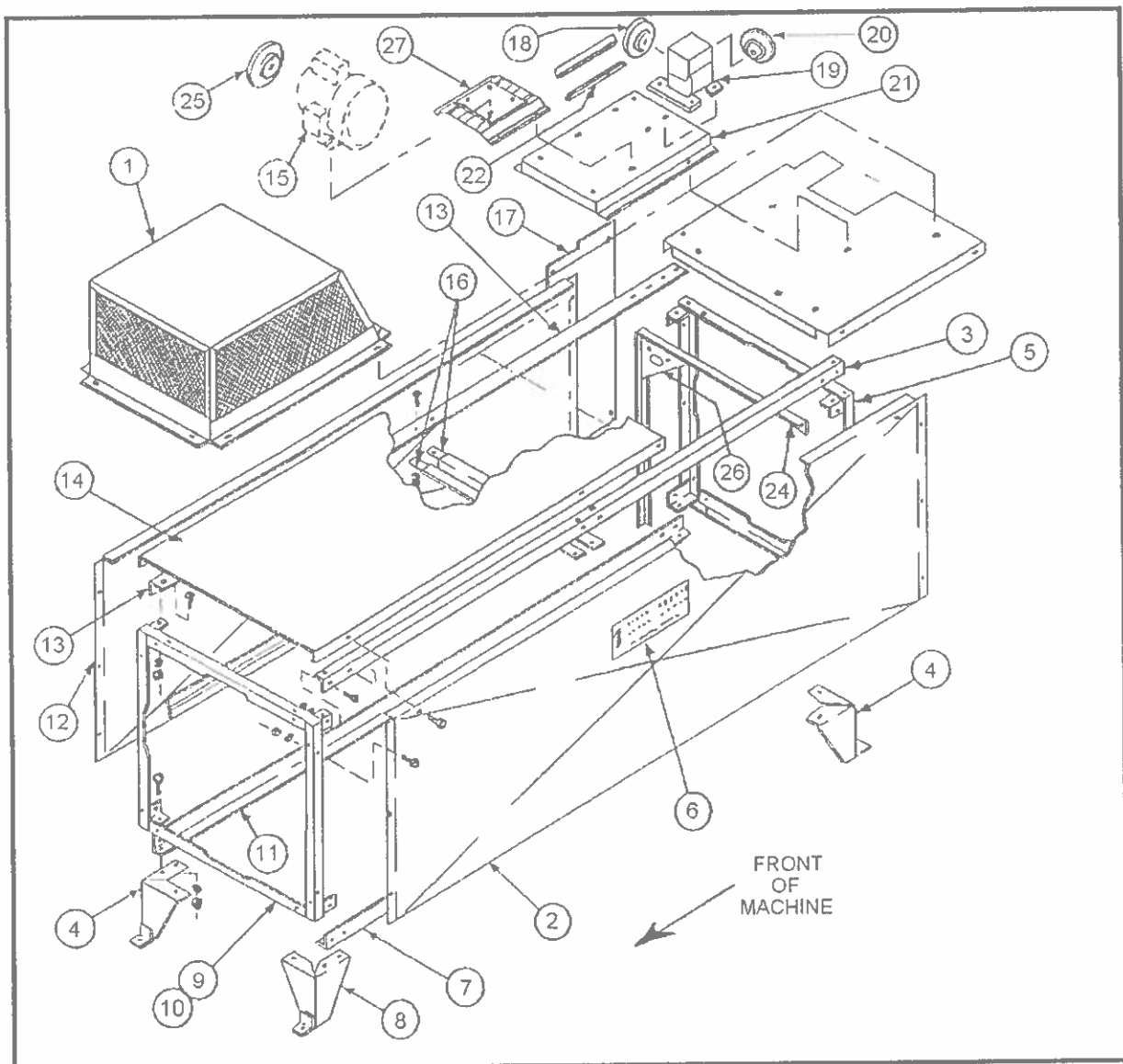


FIGURE 4 – Frame, Covers & Drive

PARTS LIST

CYLINDER AND FRONT END PARTS (FIGURE 5)

Item	Part No.	Description	Qty	Item	Part No.	Description	Qty
1	3W403	Seal, Wool Band.	1	18	C67	Worm Gear.	1
2	3W375	Retarder Blade.	1	19		Wing Nut	1
3	3W406	Guide, Retarder	1	20	C96	Cover, Inspection	1
4	581	Deflector, Corn Machine Only	1	21	C69	Dial, Calibration	1
5	W5001-0	Cylinder - Only (Specify).	1	22		Serial Plate.	1
6	C1	Cylinder Ring - Only.	1	23	582	End Plate, Front	1
7	A201	Cylinder Ass'y, (Incl. Items 5 & 6, Fig 5; Item 2, Fig 6).	1	24	3W370	Rack, Trough Adjustment	1
8	3W363	Support, Retarder Control Rod.	1	25	3W466	Conveyor.	1
9	406	Retarder Control Rod	1	26	3W467	Trough Weldment	1
10	3W462	Spout, Large Grain.	1	27	A206	Trough Assembly	1
11	3W463	Spout, Small Grain.	1	28	C11	Housing, Wood Bearing	1
12	C12	Bearing Holder.	1	29	102	Wood Bearing	1
13	A335	Bearing, Bronze	1	30	A113	Wood Bearing Assembly (Incl. Item 29 & 30)	1
14	487	Shaft, Trough Setting	1	31	C39	Blade, Leveling.	5
15	C84	Handwheel.	1	32	C12	Bearing Holder.	1
16	468	Set Collar, 3/4"	2	33	C36	Bracket, Roller Assembly	2
17	A342	Discharge Head Assembly.	1	34	A332	Friction Roller Assembly.	2

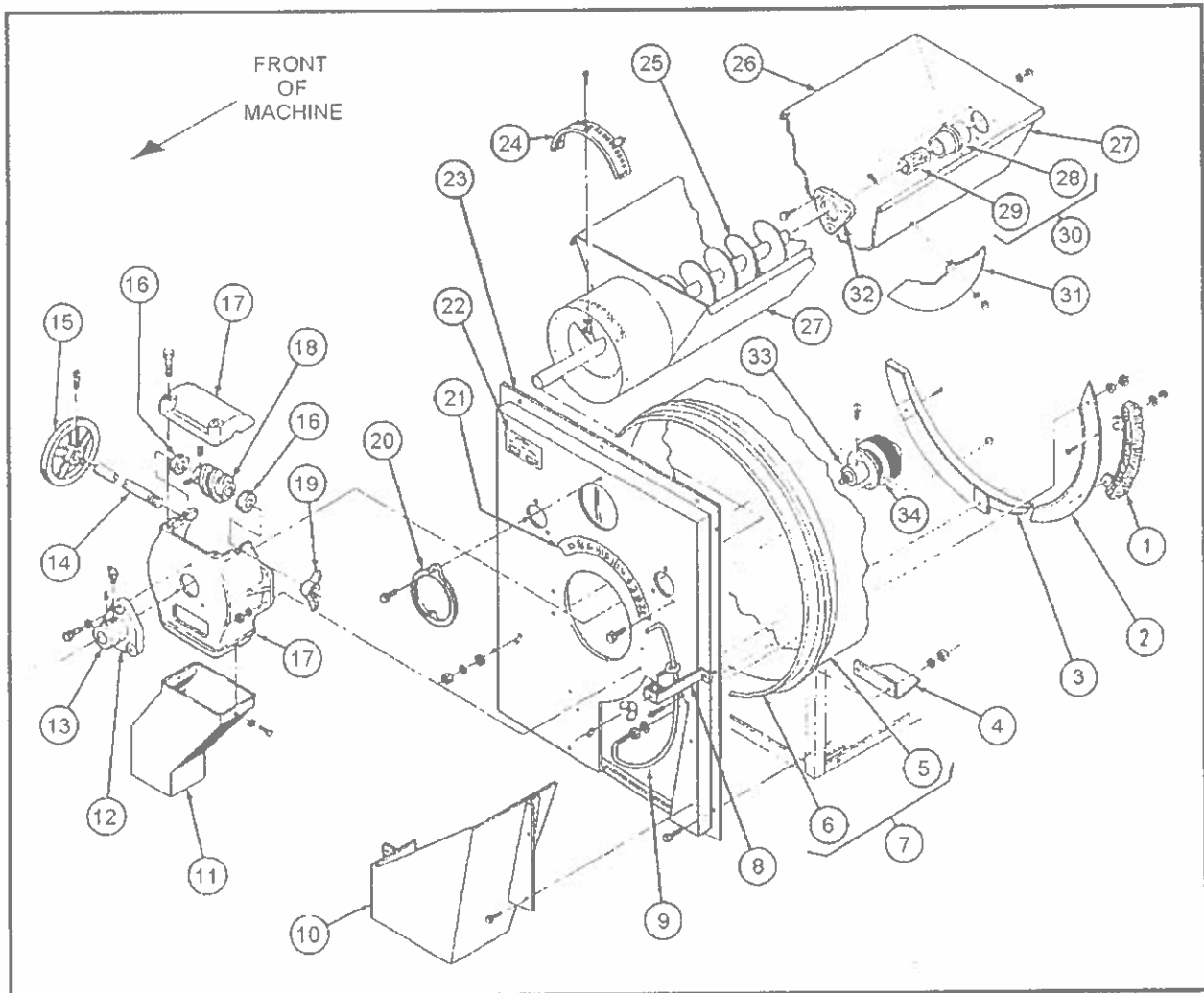


FIGURE 5 – Cylinder & Front End Parts

PARTS LIST

CYLINDER AND REAR END PARTS (FIGURE 6)

Item	Part No.	Description	Qty	Item	Part No.	Description	Qty
1	W5001-0	Cylinder - Only (Specify)	1	12	#5	Bolts 5/16-18 x 1 3/4	3
2	423	Cylinder End - Only	1	13	A506	Bearing Assembly	1
3	A201	Cylinder Ass'y, (Incl. Items 1 & 2, Fig 6; Item 6, Fig 5).	1	14	C18	Intake Casting	1
4	581	Conveyor	1	15	500	Felt Washers	1
5	C5-4	Cone	1	16	465	Set Collar, 1-5/16"	1
6	A7009	Chain, Roller 5/8, 112P.	1	17	3W468	Feed Hopper	1
7		Grease Fitting 1/8" x 45°	1	18	584	Shut-off Slide	1
8		Coupling, Pipe 1/8"	1	19	336	Wool Seal	1
9		Pipe Nipple, 1/8" x 4"	1	20	585	End Plate, Rear	1
10	P1	Taper Lock 1-5/16	1	21		Decal, Direction of Rotation	1
11	3W115	Locking Plate	1	22	7010-76	Sprocket, 76T, 5/8P	1

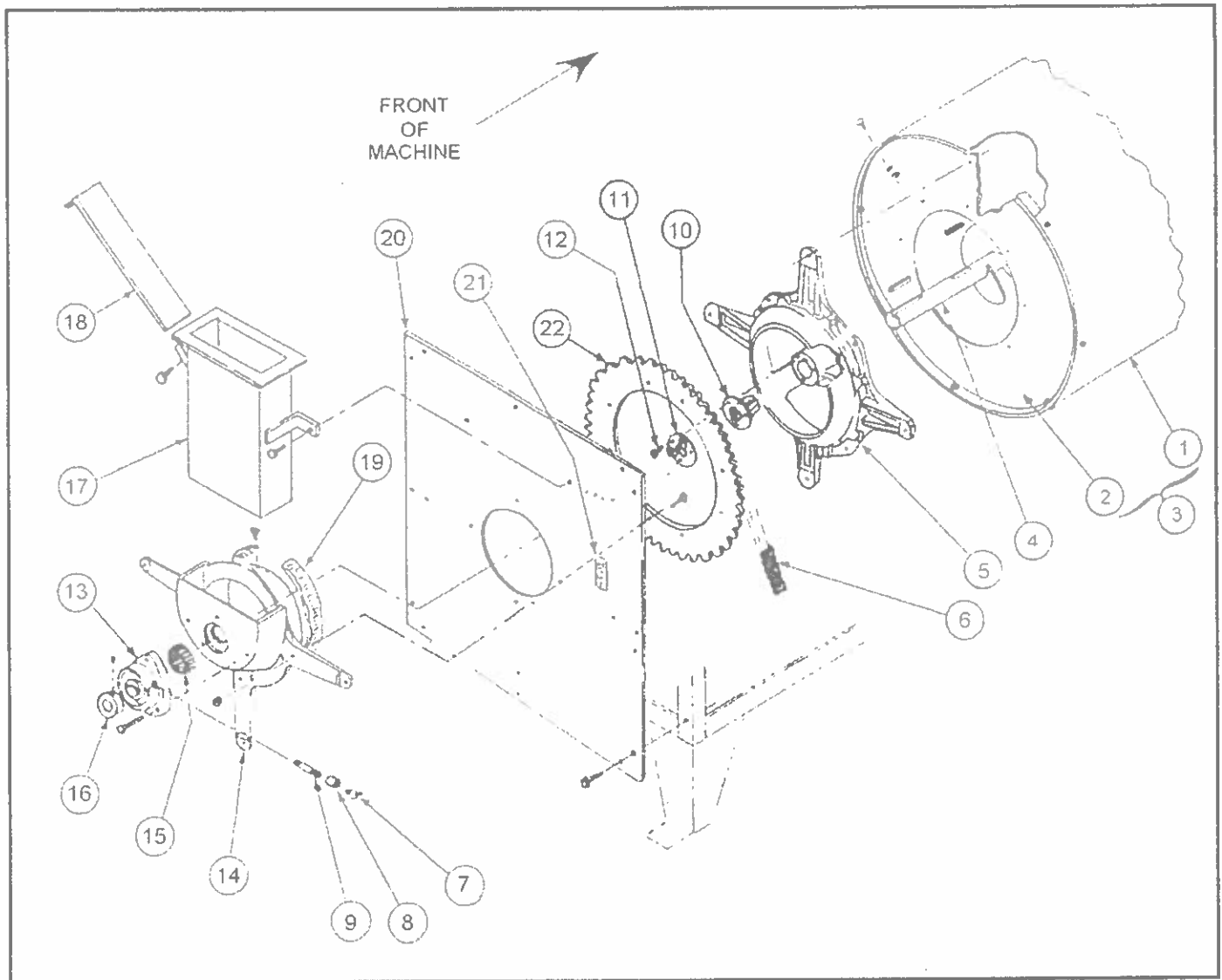


Figure 6 – Cylinder & Rear End Parts

WARRANTY

The following does not supersede or alter the policy stated in the General Conditions of Sale of Crippen Manufacturing Company, Inc. Rather it is extracted from that policy as a guide for this manual.

EQUIPMENT WARRANTY:

The equipment is warranted to the Purchaser to perform within the limits specified in the contract. If performance is not as warranted, the Purchaser must notify the Company in writing within 30 days from its first use, stating wherein performance is not warranted. A reasonable time shall be allowed the Company to remedy the alleged defect, and the Purchaser will render all necessary and friendly assistance. In the event installation of the equipment was completed by the Purchaser, the Company's obligation under its performance warranty shall be limited to furnishing replacement equipment or modifying existing equipment F O B point of shipment.

Any repairs or modifications not specifically authorized by the Company in writing shall not be the responsibility of the Company.

The Company will repair or replace with a similar part any equipment or part thereof of its own manufacture which proves defective in workmanship or material within one year of date of shipment. This Warranty is null and void, and the Company shall in no way be liable if any part or parts not manufactured or supplied by the Company are used in the equipment, or if the equipment is not installed and operated in accordance with the contract. All cost, other than repair or replacement of the defective equipment, are the responsibility of the Purchaser.

In the event the equipment cannot be made to operate by the Purchaser or Company within the limits specified in the contract, the Purchaser may remove and return such of the equipment as is of Company manufacture, freight prepaid, and in accordance with the "Returned Goods" section below. The Company will issue credit for the returned equipment, although credit shall be limited to the purchase price thereof, less installation, dismantling charges, freight and taxes, and less a reasonable deduction for the Purchaser's use of said equipment.

The warranty does not cover products, services, accessories, parts, or attachments not manufactured or supplied by the Company except to the extent of the warranty given by the actual manufacturer or supplier.

RETURNED GOODS:

Before any equipment is returned, the Purchaser must receive the Company's written authorization. Freight shall be prepaid by the Purchaser.

Authorized returns of new and unused equipment shall be subject to a charge of 15% of the net selling price in addition to whatever restocking charges are necessary to restore the material to saleable condition. Requests received for return of equipment later than 30 days after system start-up shall not be considered.

INSTRUCTIONS FOR CHANGING CYLINDERS

SINGLE AND MODULAR LENGTH GRADERS

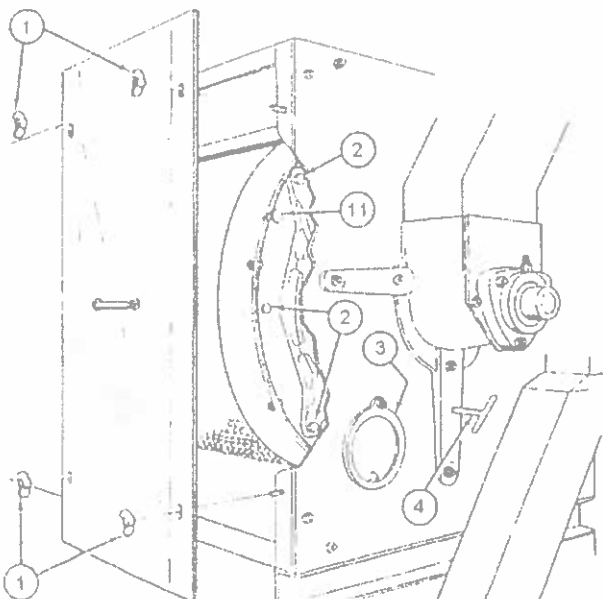
QUICK CHANGE UNITS

CYLINDER REMOVAL

IMPORTANT

Always disconnect power to the machine before attempting any service procedure to prevent accidental start-up and personal injury.

1. Hand rotate cylinder and remove eight bolts (2) that hold end plate to cylinder mounting flange of cylinder at the intake end of the machine. *Note* – Bolts may be removed through the access cover (3) if desired or unscrew four wing nuts (1) and remove rear side panel.
2. Screw support screw (4) in until hand tight against sprocket.
3. Remove discharge spouting.
4. Remove set collars (7) from the drive shaft and conveyor shaft on the discharge end of the machine.
5. Detach discharge head (9) from end plate by removing four hex head bolts.
6. Detach trough adjustment rack (10) from trough assembly by removing five screws.
7. Remove twelve hex head bolts that hold end plate (8) onto frame and lift off end plate.
8. Cylinder can now be removed from machine by sliding and lifting it out of the discharge end.

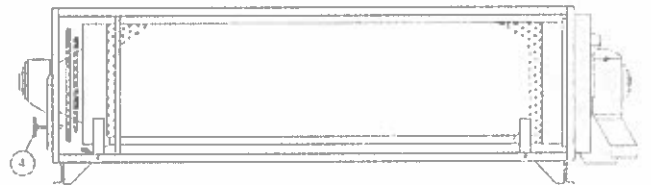
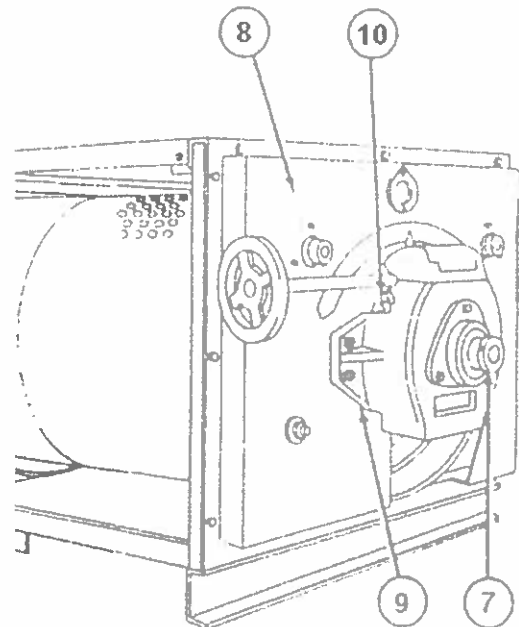


CYLINDER INSTALLATION

Installing cylinders is essentially the reverse of removal procedure listed above. However, when the cylinder is slid into the machine, the cylinder must be rotated until the two alignment holes in the cylinder mounting flange line up with alignment pins (11) which are welded to the cylinder end plate. Sight through the discharge end of the cylinder to align pins to holes.

CAUTION

After all parts are installed and nuts and bolts are tightened, unscrew SUPPORT SCREW (4) far enough to allow cylinder to rotate freely.



INSTRUCTIONS FOR CHANGING CYLINDERS

SINGLE AND MODULAR LENGTH GRADERS

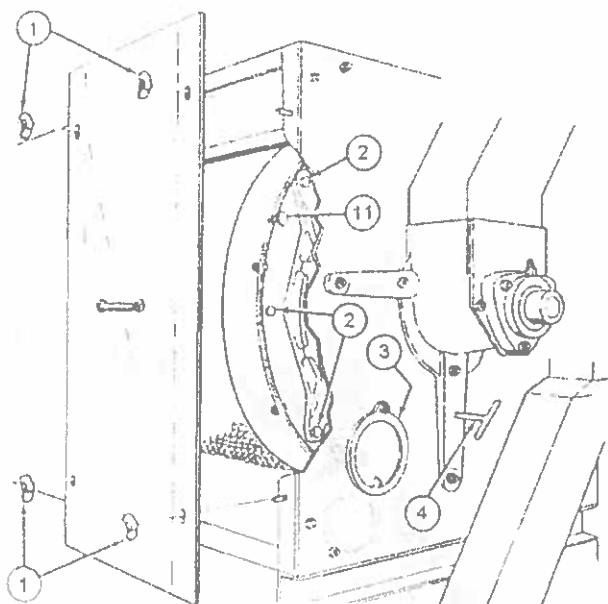
QUICK CHANGE UNITS

CYLINDER REMOVAL

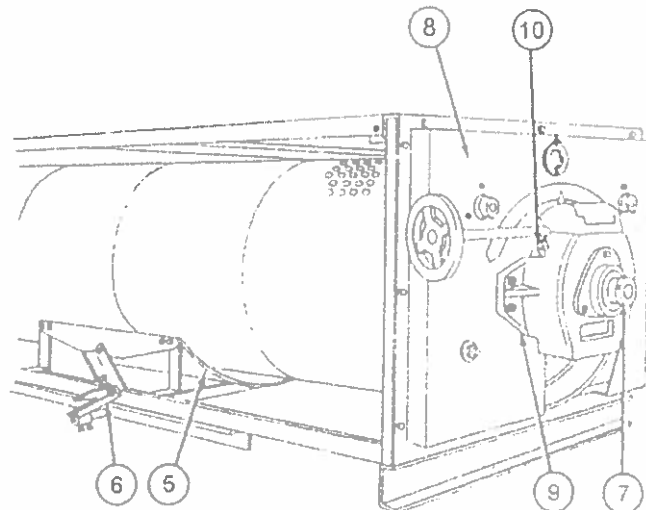
IMPORTANT

Always disconnect power to the machine before attempting any service procedure to prevent accidental start-up and personal injury.

1. Unscrew four wing nuts (1) and remove rear side panel.
2. Hand rotate cylinder and remove eight bolts (2) that hold end plate to cylinder mounting flange of cylinder at the intake end of the machine. *Note* - Bolts may be removed through the access cover (3) if desired.
3. Screw support screw (4) in until hand tight against sprocket.
4. Raise cradle (5) into support position under cylinder by depressing and pushing inward foot pedal (6) until it is locked in place. If cradle does not support cylinder properly, adjust height of adjustment screw on pedal.
5. Remove discharge spouting (not shown).
6. Remove set collars (7) from the drive shaft and conveyor shaft on the discharge end of the machine.
7. Detach discharge head (9) from end plate by removing four hex head bolts.
8. Detach trough adjustment rack (10) from trough assembly by removing five screws.
9. Remove twelve hex head bolts that hold end plate (8) onto frame and lift off end plate.



10. Cylinder can now be removed from machine by sliding and lifting it out of the discharge end.



CYLINDER INSTALLATION

Installing cylinders is essentially the reverse of removal procedure listed above. However, when the cylinder is slid into the machine over the cradle assembly (5), the cylinder must be rotated until the two alignment holes in the cylinder mounting flange line up with alignment pins (11) which are welded to the cylinder end plate. Sight through the discharge end of the cylinder to align pins to holes.

CAUTION

After all parts are installed and nuts and bolts are tightened, RELEASE CRADLE ASSEMBLY (5) and CHECK SUPPORT SCREW (4) to see that it is screwed out far enough to allow cylinder to rotate freely.

IDEAL S-1

INSTRUCTIONS ON REPLACING CYLINDER

1. Remove left side and top covers (left and right determined facing discharge end of machine).
2. Remove chain between drive shaft sprocket and cylinder ring sprocket.
3. Remove bearing on intake end of conveyor.
4. Remove bearing on drive shaft on discharge end of machine.
5. Remove sprocket on trough setting shaft.
6. Place support under cylinder on intake end – 2 x 4 or similar object.
7. Remove discharge casting from end plate on discharge end of machine.
8. Remove trough setting segment from trough neck.
9. Remove discharge end plate and retarder bracket, cylinder can now be removed from machine.
10. Loosen (3) set screws on cylinder intake cone casting and remove conveyor and trough.
11. Remove intake cone and ring sprocket from old cylinder and install same on new cylinder.
12. Install conveyor and trough into new cylinder setting shaft to dimension specified on instruction sheet, tighten (3) set screws and lock nuts, cylinder is now ready to put back into machine. (Instruction sheet – Page 5, figure 3.)

NOTE: Handle cylinder carefully.
 DO NOT DROP OR BUMP!