







S&E GRADE 8 BOLTS		S&E GRADE 8,2 BOLTS	
			
S&E GRADE 8 & S&E GRADE 8,2 BOLTS ARE ESSENTIALLY EQUAL FOR SILO ERECTION.			
S&E GRADE 5 BOLTS		S&E GRADE 2 BOLTS	
			
ASTM A325 BOLTS		ASTM A307 BOLTS	
			
USED FOR STRUCTURAL CONNECTIONS		ALLOWED ONLY FOR ANCHOR BOLTS	
CONTACT SCAFCO ENGINEERING DEPARTMENT BEFORE SUBSTITUTING ANY BOLTS ON SILOS.			

INSTRUCTIONS

VERTICAL SEAM BEAD SEALANT:

1. PLACE 24" (610) STRIPS ALONG THE BOTTOM FLANGE OF SHEET 'A' WHERE THE TWO LOWER SHEETS WILL OVERLAP.
2. ATTACH SHEET 'C' TO SHEET 'A'.
3. RUN A CONTINUOUS STRIP OF BEAD SEALANT DOWN THE VERTICAL SEAM AND AROUND THE CORNER OF SHEET 'C'.
4. ATTACH SHEET 'B'.
5. APPLY SEALANT TO SHEET 'B' IN THE SAME MANNER AS SHEET 'C'.
6. CONTINUE THIS PROCEDURE AROUND THE BIN FOR ALL WALL SHEET ROWS, WITH THE EXCEPTION OF THE BOTTOM ROW.

* USE A DOUBLE STRIP FOR 8, 10, AND 11, GAUGE SHEETS.

(3.68, 3.23, 2.90)

ANCHORING BIN:

1. SWEEP CONCRETE TO REMOVE EXCESS DUST AND WIPE UNDER-SIDE OF BOTTOM ROW SHEET TO REMOVE DIRT AND EXCESS OIL.
2. USE CONSUAL CS-102, ALUMINIZED ROOFING ASPHALT, OR OTHER APPROVED MATERIAL FOR SEALING BASE OF BIN.
3. WITH BIN HELD ONE TO TWO INCHES (25 TO 50) ABOVE FOUNDATION, TROWEL SEALANT UNDER FLANGE. (SEE ANCHOR DETAIL)
4. IF CONCRETE IS UNEVEN PLACE EXTRA SEALANT ON TOP TO ASSURE SEAL.
5. SLOWLY LOWER BIN AND TIGHTEN ANCHOR BOLTS.
6. TROWEL SEALANT INSIDE AND OUTSIDE TO ASSURE WATER-TIGHT SEAL WITH THE FOUNDATION.

STIFFENER INSTALLATION:

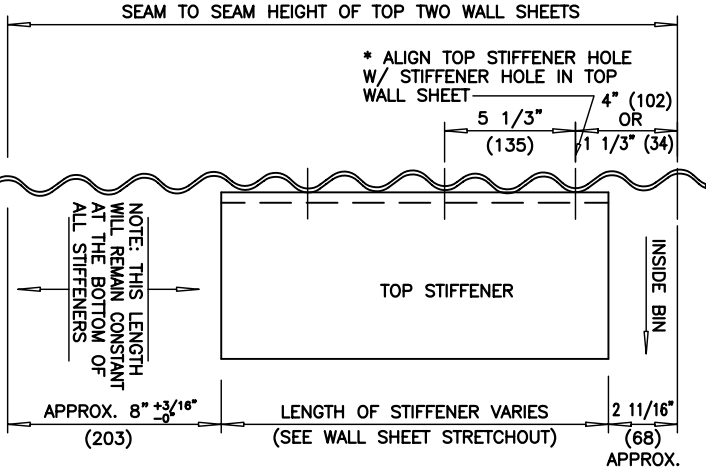
1. REFER TO WALL SHEET STRETCHOUT DRAWING FOR PROPER PLACEMENT OF STIFFENERS AND SPLICE PLATES.
2. PLACE THE TOP STIFFENER SO TOP HOLE IN THE STIFFENER IS IN LINE WITH THE TOP STIFFENER HOLE OF THE WALL SHEET.
3. DO NOT ALLOW STIFFENER TO SLIP DOWN WHILE BOLTING. FINGER TIGHTEN BOLTS, FORCE STIFFENER UPWARDS WITH DIRT PIN AS FAR AS THE BOLTS WILL ALLOW. HOLD THE STIFFENER IN POSITION AND TIGHTEN BOLTS.
4. CONTINUE THIS PROCEDURE THROUGH THE STIFFENER AND SPLICE PLATE INSTALLATION. THE GAP BETWEEN STIFFENERS SHOULD NOT EXCEED 1/4" (6). MAKE SURE STIFFENERS AND SPLICE PLATES ARE THE PROPER GAUGE AS SHOWN ON THE WALL SHEET STRETCHOUT DRAWING. ALL PARTS ARE COLOR CODED.
5. SHIM BASE PLATES AS REQUIRED TO COMPENSATE FOR UNEVEN FOUNDATION. BOTTOM FLANGE OF BIN SHOULD BE BEARING ON FOUNDATION.



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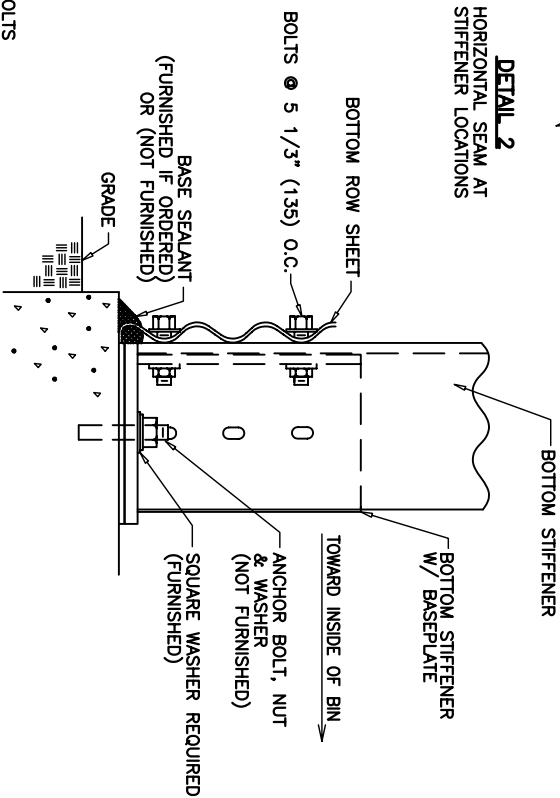
INTERNALLY STIFFENED BINS OR SILOS INSTALLATION & SEALANT DETAILS

BY	DATE	DRAWING NO.:	REV.
DRAWN	SMB	16SEP94	H
CHECKED			
APPROVED	JT	28SEP98	12/27/01

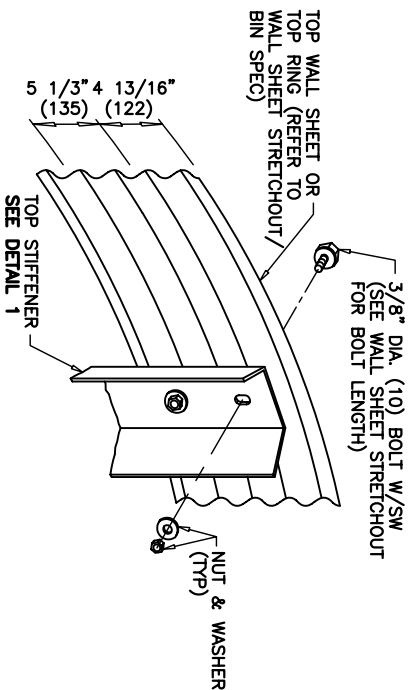
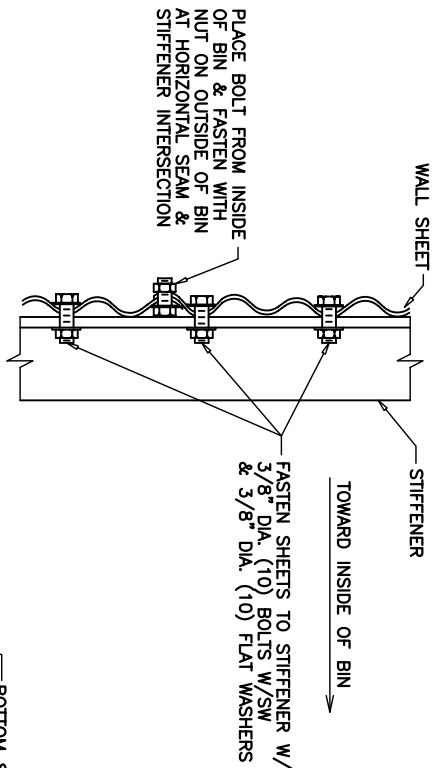


DETAIL 1
* EXCEPT FOR 48, 54, 60, 72, 78, 90 & 105 DIA. BINS
SEE ROOF ERECTION FOR PARTICULAR BIN

ANCHOR DETAIL FOR STIFFENED TANKS



DETAIL 2 HORIZONTAL SEAM AT STIFFENER LOCATIONS

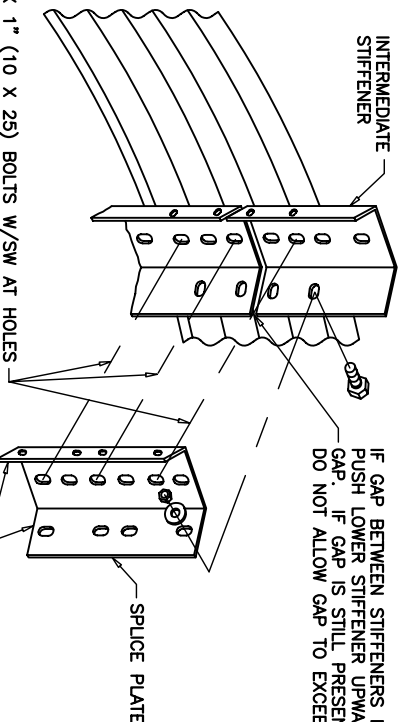


IF GAP BETWEEN STIFFENERS IS PRESENT, PUSH LOWER STIFFENER UPWARDS TO CLOSE GAP. IF GAP IS STILL PRESENT, DO NOT ALLOW GAP TO EXCEED 1/4" (6).

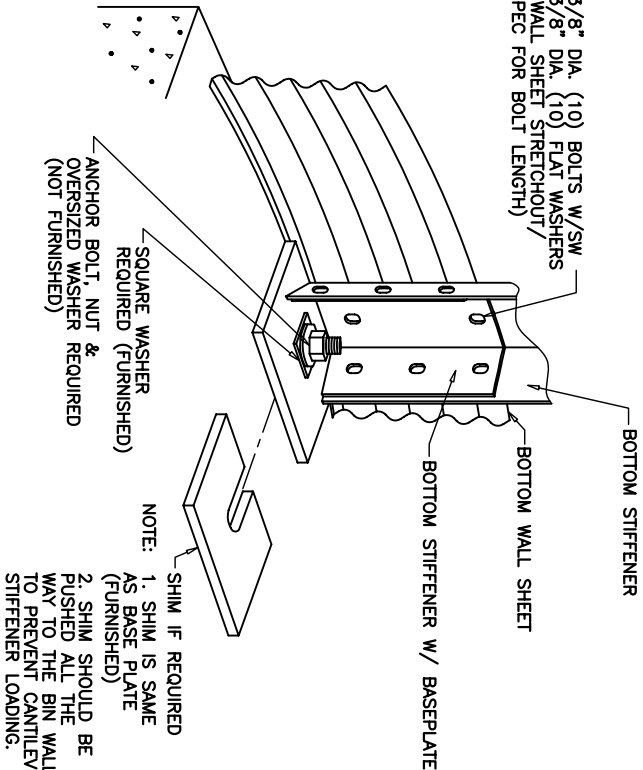
(3) 3/8" X 1" (10 X 25) BOLTS W/SW AT HOLES INDICATED ON ALL SPLICE PLATES. EXCEPT FOR 7 GA. & HEAVIER USE 3/8" X 1 1/4" (10 X 32) BOLT W/SW. ALSO (3) 3/8" DIA. (10) FLAT WASHERS REQUIRED.

USE (4) 3/8" X 1" (10 X 25) BOLTS W/SW IN EACH FLANGE FOR ALL SPLICE PLATES. ALSO (8) 3/8" DIA. (10) FLAT WASHER REQUIRED.

USE 11 BOLTS AT EACH SPLICE (SEE WALL SHEET STRETCHOUT FOR LENGTH)



USE 3/8" DIA. (10) BOLTS W/SW AND 3/8" DIA. (10) FLAT WASHERS (SEE WALL SHEET STRETCHOUT/BIN SPEC FOR BOLT LENGTH)

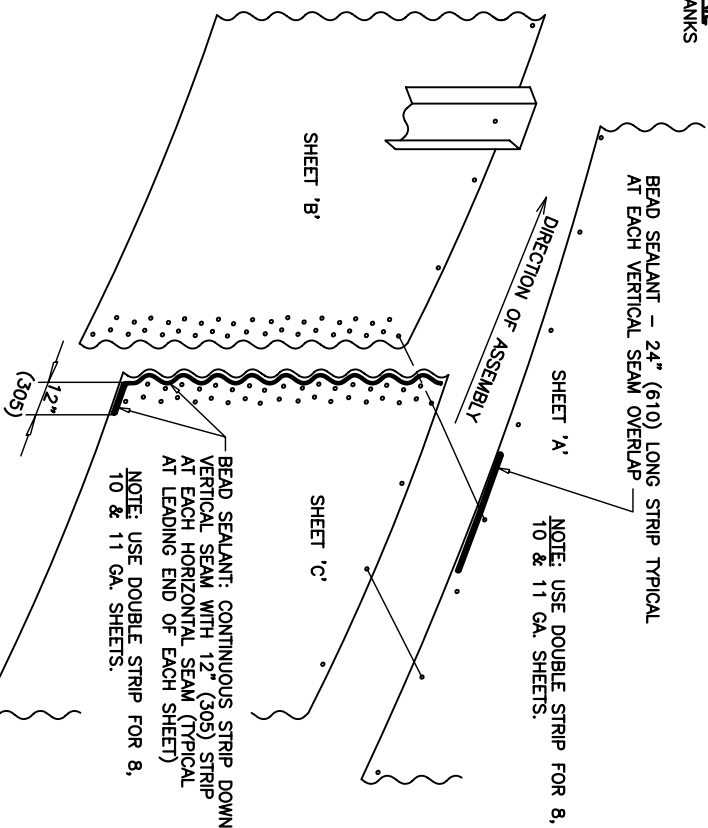


BEAD SEALANT - 4" (100) STRIP LAY BESIDE CONTINUOUS STRIP SEALANT - CONTINUOUS STRIP

BEAD SEALANT - 6" (150) STRIP FOLDED IN HALF AND LAYED OVER CONTINUOUS STRIP TO ASSURE SEAL AT LAP JOINT

VERTICAL SEAM SEALANT DETAIL BOTTOM ROW

(VIEWED FROM INSIDE BIN)



VERTICAL SEAM SEALANT DETAIL TOP ROWS

(VIEWED FROM INSIDE BIN)

NOTE: REFER TO WALL SHEET STRETCHOUT / BIN SPEC FOR SPECIFIC DETAILS OF ORDERED BIN.