



SCAFCO Grain Systems Company

6200 E. Main Avenue

PO Box 11215

Spokane, WA 99211-1215, USA

Tel: 509-535-1571 • Toll Free: 1-800-224-0676 • Fax: 509-535-9130 • mail@scafco.com • www.scafco.com

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SCAFCO[®]
FLUSH FORM
AERATION SYSTEM
ASSEMBLY & INSTALLATION
INSTRUCTIONS



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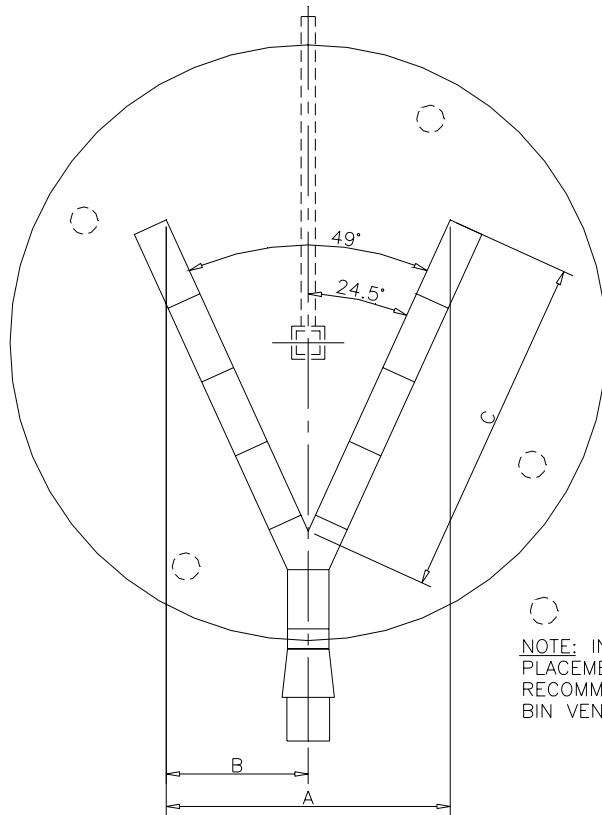


FLUSH FORM AERATION SYSTEMS ASSEMBLY & INSTALLATION PROCEDURES

1. Study assembly instructions and layout drawings carefully before proceeding.
2. Count and check all parts, including fasteners.
3. Follow all recommendations including Page 3 of Grain Bin Assembly Instructions (290025) showing required concrete reinforcing wire mesh and rebar. Note that wire mesh or rebar at sides and under flush form is tied in with grain bin foundation and slab reinforcing.
4. Assemble transition extender and Y transition for “Y” unit, or the reducer assembly and one length flush form for the straight unit.
5. Add additional flush forms as needed to complete. Lap 2” and fasten with sheet metal screws.
6. Bolt all sections together and add end dam on the end of each run of flush form.
7. Locate system within foundation concrete form.
8. All units must be level, anchored securely and protrude 2” outside foundation wall. Stake form to prevent form floating when concrete is poured.
9. Before pouring concrete, lay perforated planking in place. Planking or other covering is necessary to keep concrete out of forms and protect from damage due to pressure exerted while pouring and vibrating concrete.
10. Parallel straight units have 12 pieces of solid planks, plus necessary perforated planks. Install solid planks closest to fan end of duct. Cover balance of flush form with perforated planks. Add flashing angle and fasten to planks with self-drilling fasteners.
11. Form up slab for fan, leaving 24” spacing between it and bin slab. Spacing is recommended to reduce possibility of water entering ducts.
12. Assemble fan transition and bolt to transition extender or reducer.
13. Attach fan to fan transition.
14. Anchor fan and hook up electricity.
15. Turn on fan and watch your profits grow!

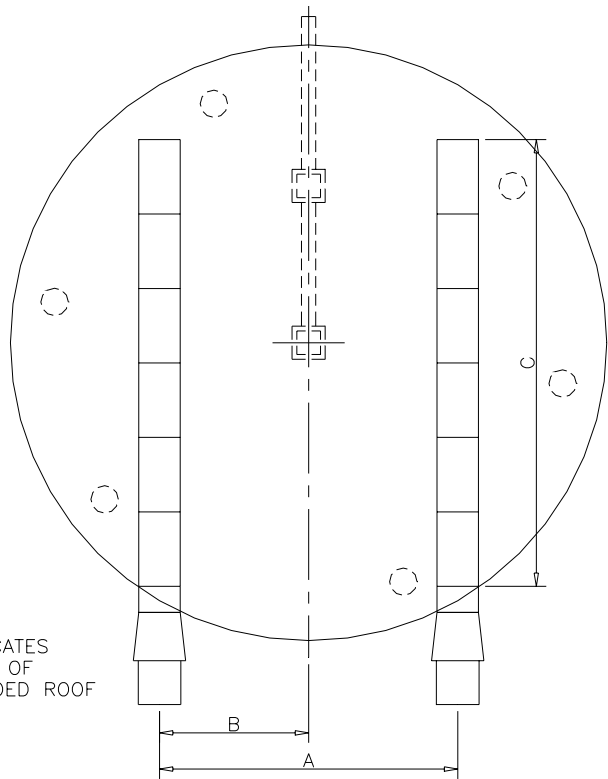
FLUSH FORM AERATION SYSTEMS

“Y” FLUSH FORM

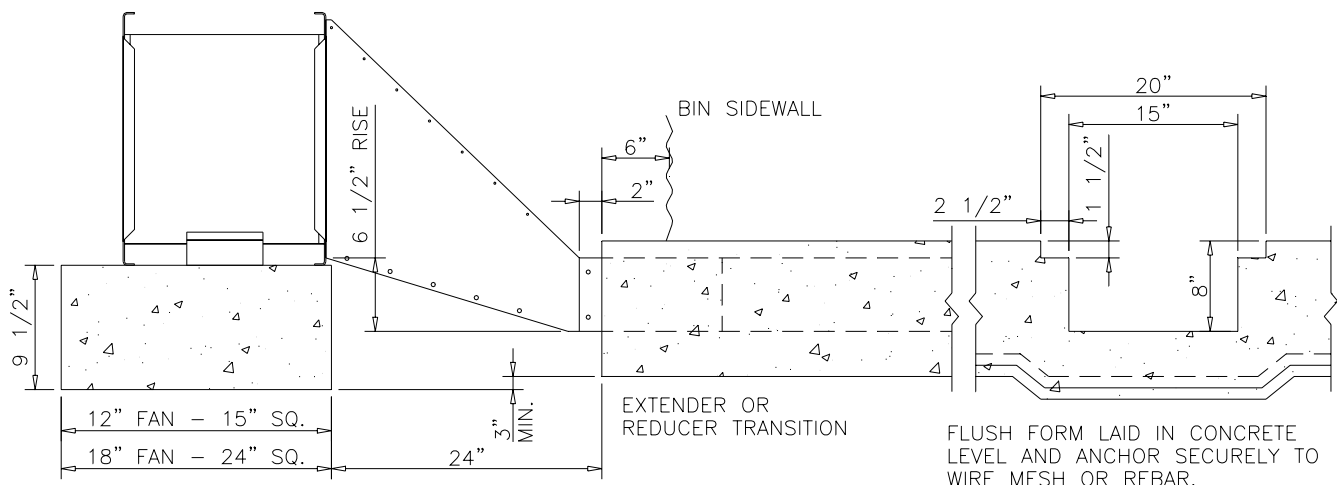


DIMENSIONS			
BIN DIA.	A	B	C
15'	6' 8"	3' 4"	8' 0"
18'	8' 4"	4' 2"	10' 0"
21'	10' 0"	5' 0"	12' 0"
24'	11' 8"	5' 10"	14' 0"
27'	15' 0"	7' 6"	18' 0"
30'	16' 7"	8' 3 1/2"	20' 0"
33'	18' 3"	9' 1 1/2"	22' 0"
36'	19' 11"	9' 11 1/2"	24' 0"
39'	21' 4"	10' 9"	26' 0"
42'	23' 2"	11' 7"	28' 0"

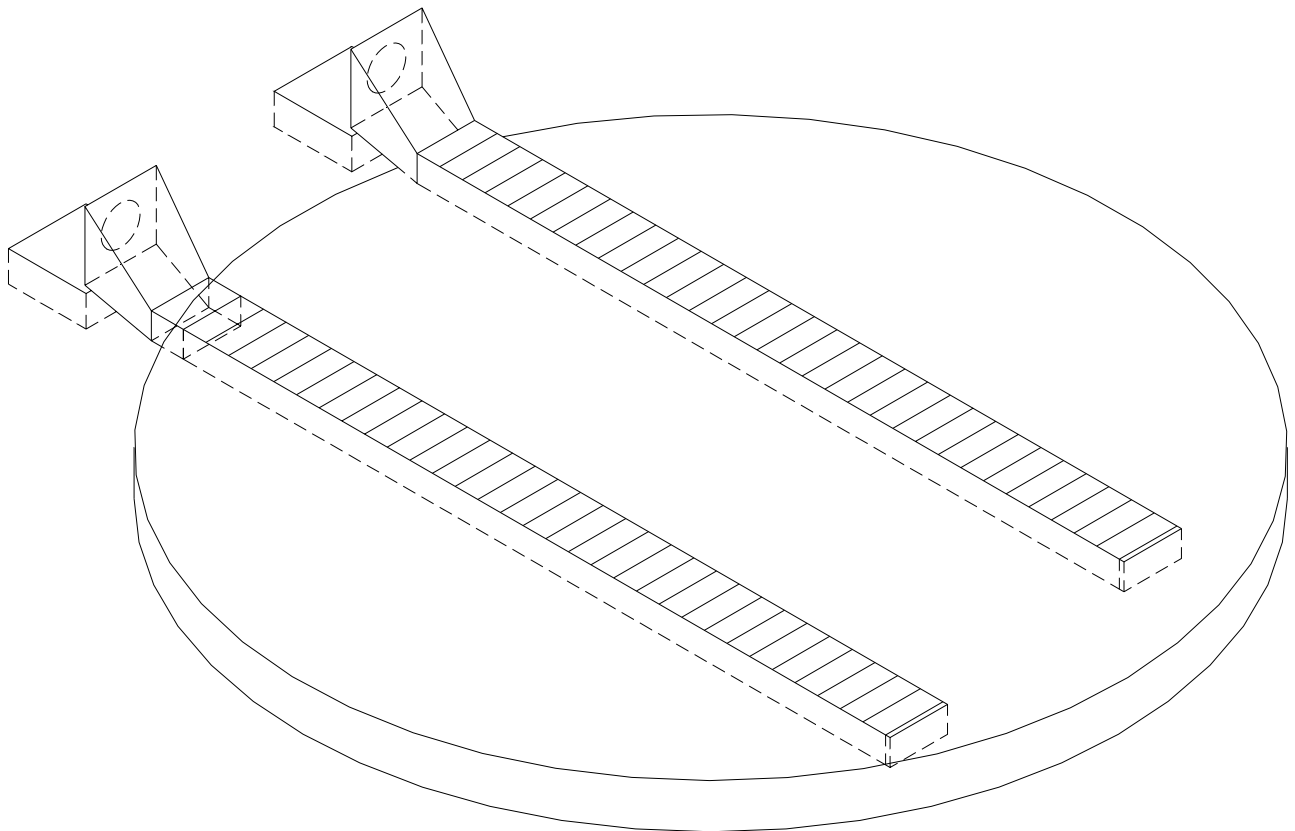
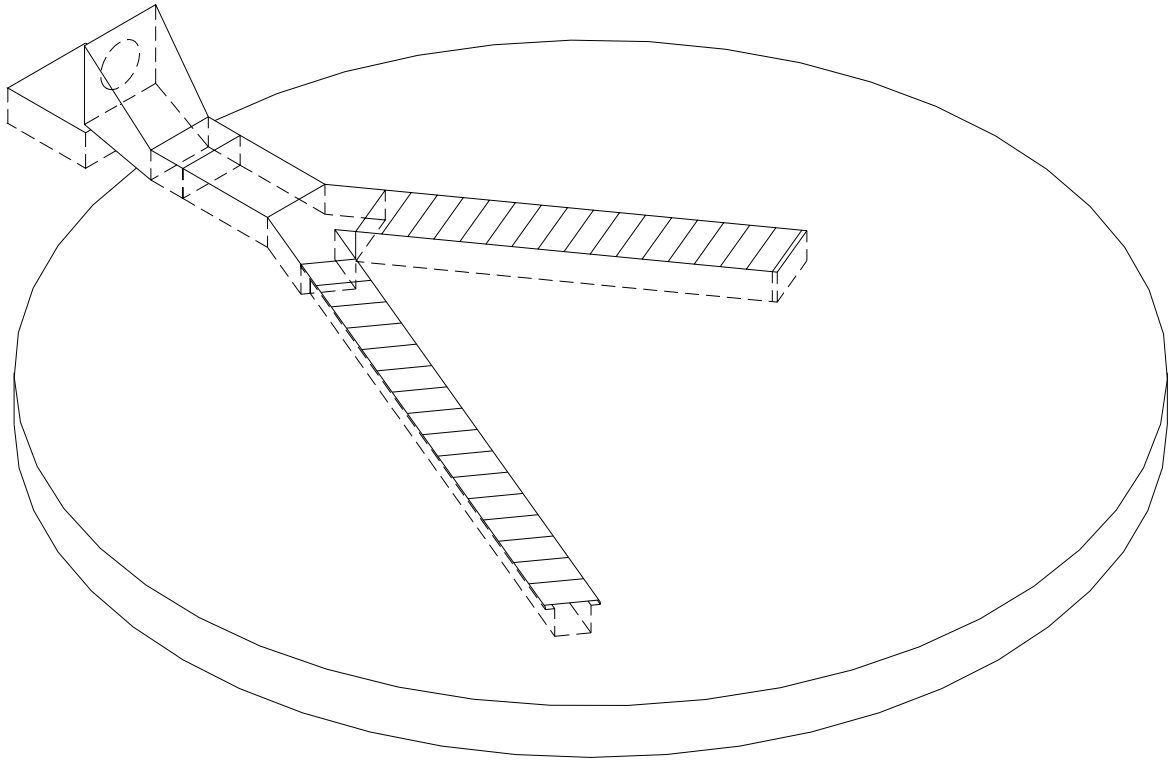
PARALLEL FLUSH FORM



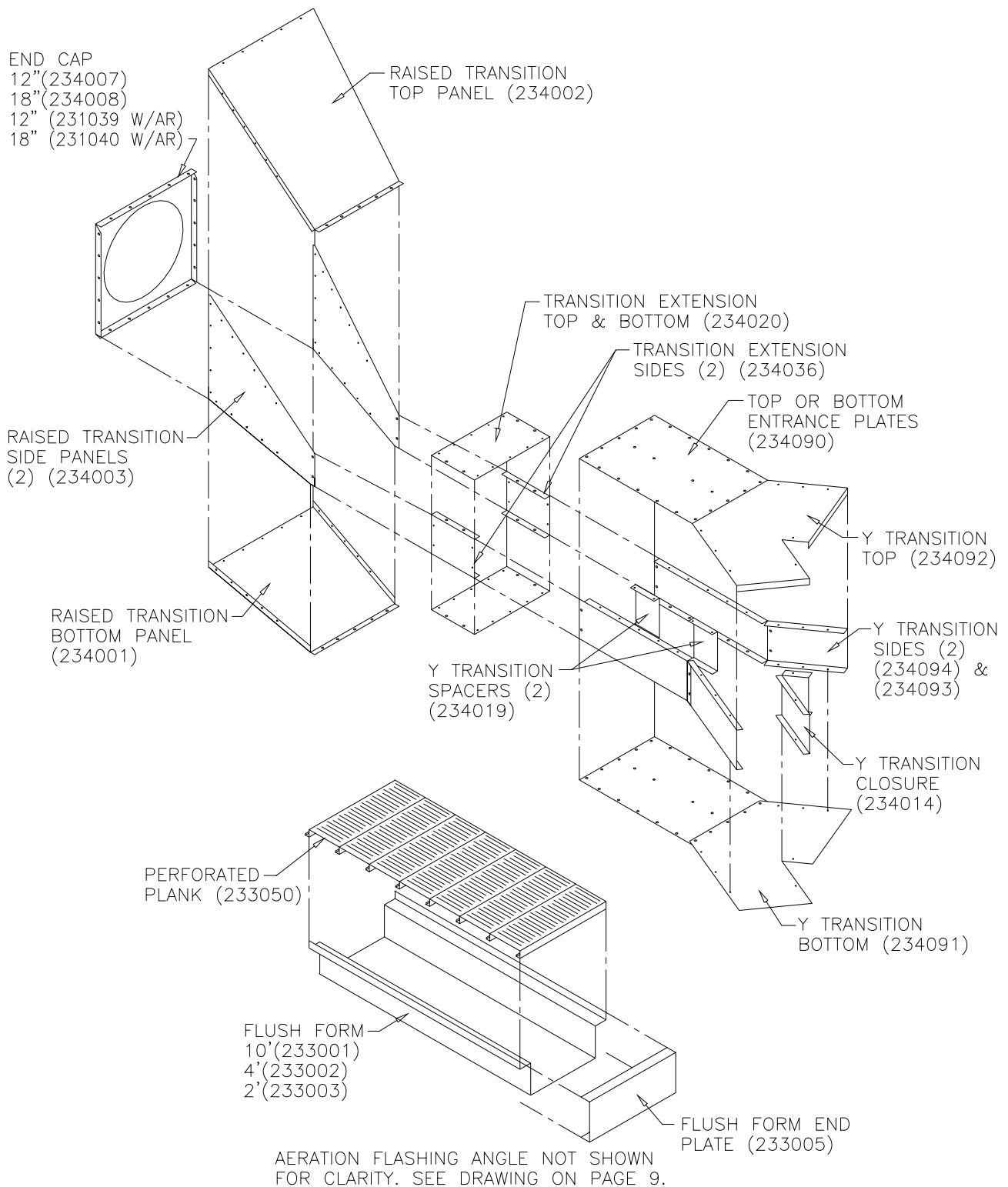
DIMENSIONS			
BIN DIA.	A	B	C
18'	9' 0"	4' 6"	12' 4"
21'	10' 6"	5' 3"	15' 9"
24'	12' 0"	6' 0"	17' 0"
27'	13' 6"	6' 9"	20' 0"
30'	15' 0"	7' 6"	24' 0"
33'	16' 0"	8' 0"	26' 0"
36'	18' 0"	9' 0"	28' 0"
39'	19' 0"	9' 9"	30' 0"
42'	21' 0"	10' 6"	32' 0"
48'	24' 0"	12' 0"	40' 0"



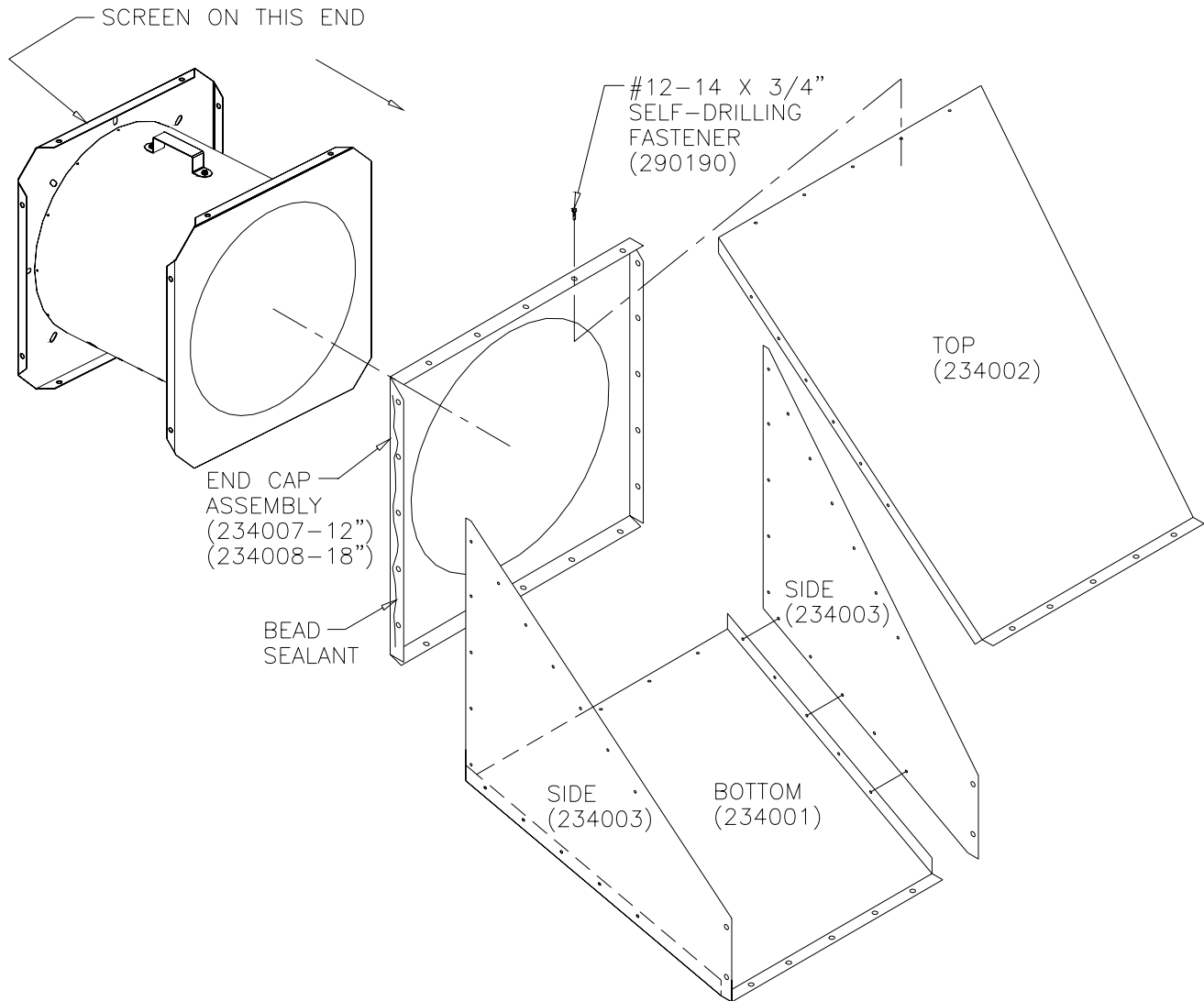
**TYPICAL “Y” & STRAIGHT
PARALLEL AERATION SYSTEMS**



TYPICAL STRAIGHT PARALLEL & “Y” SYSTEM ASSEMBLY

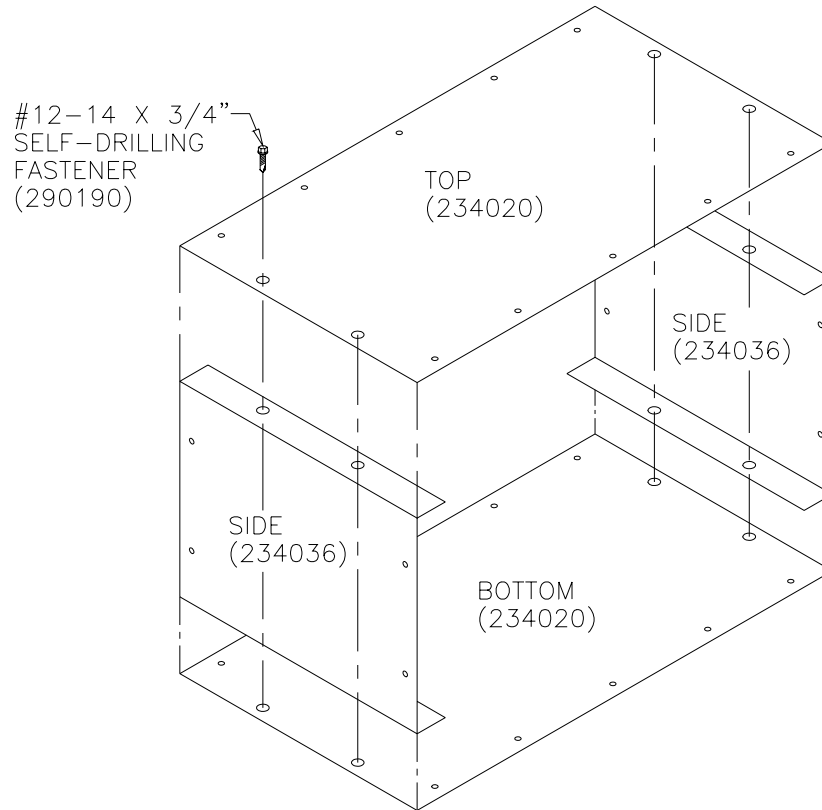


RAISED FAN TRANSITION ASSEMBLY

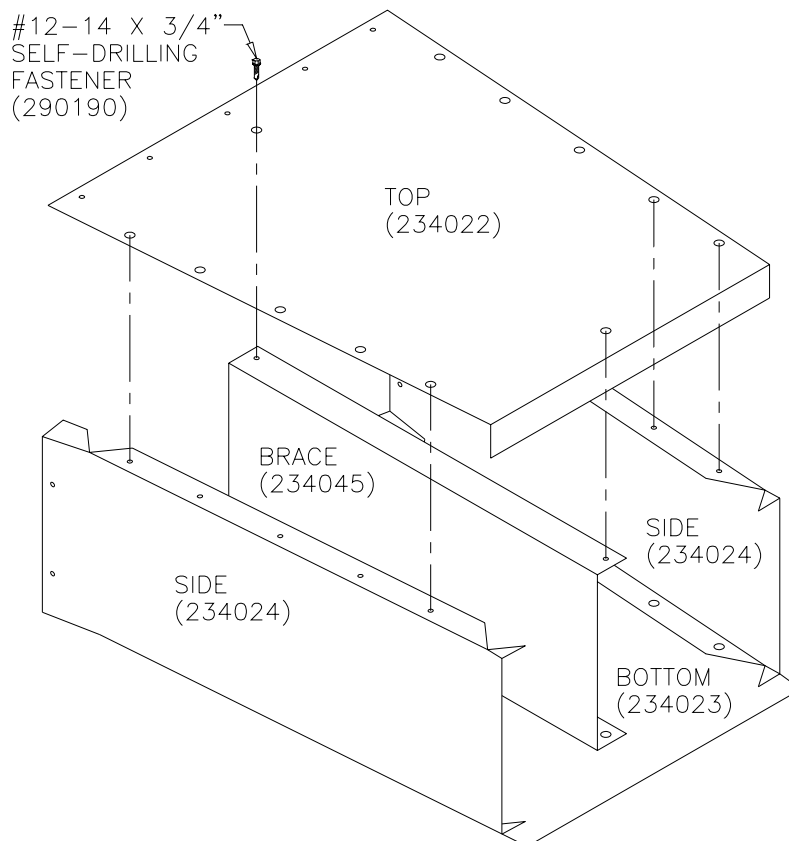


NOTE: To attach fan to transition – drill pilot holes lining up with fan flange holes and attach with #12-14 x 3/4" self-drilling fasteners.

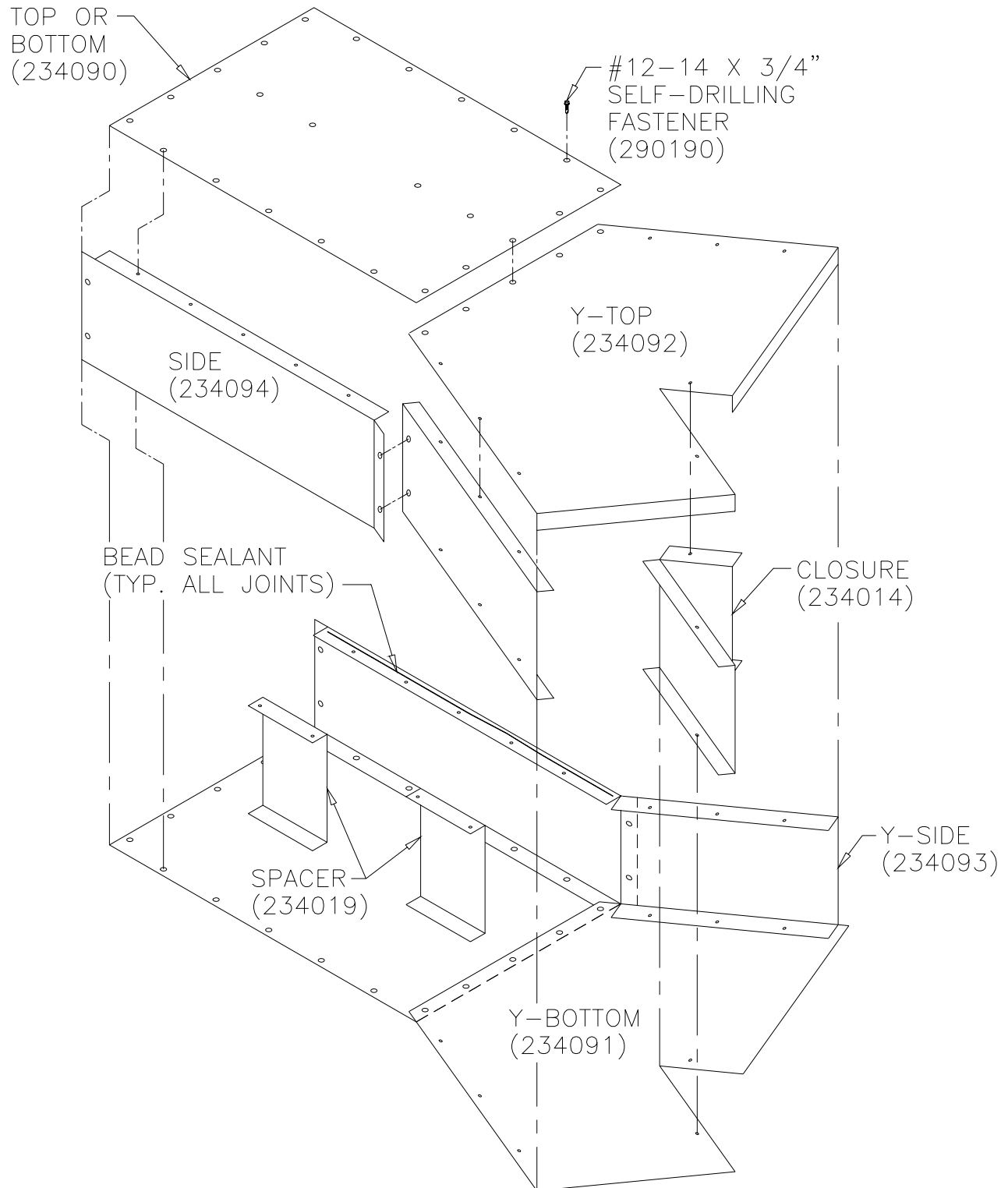
TRANSITION EXTENSION ASSEMBLY



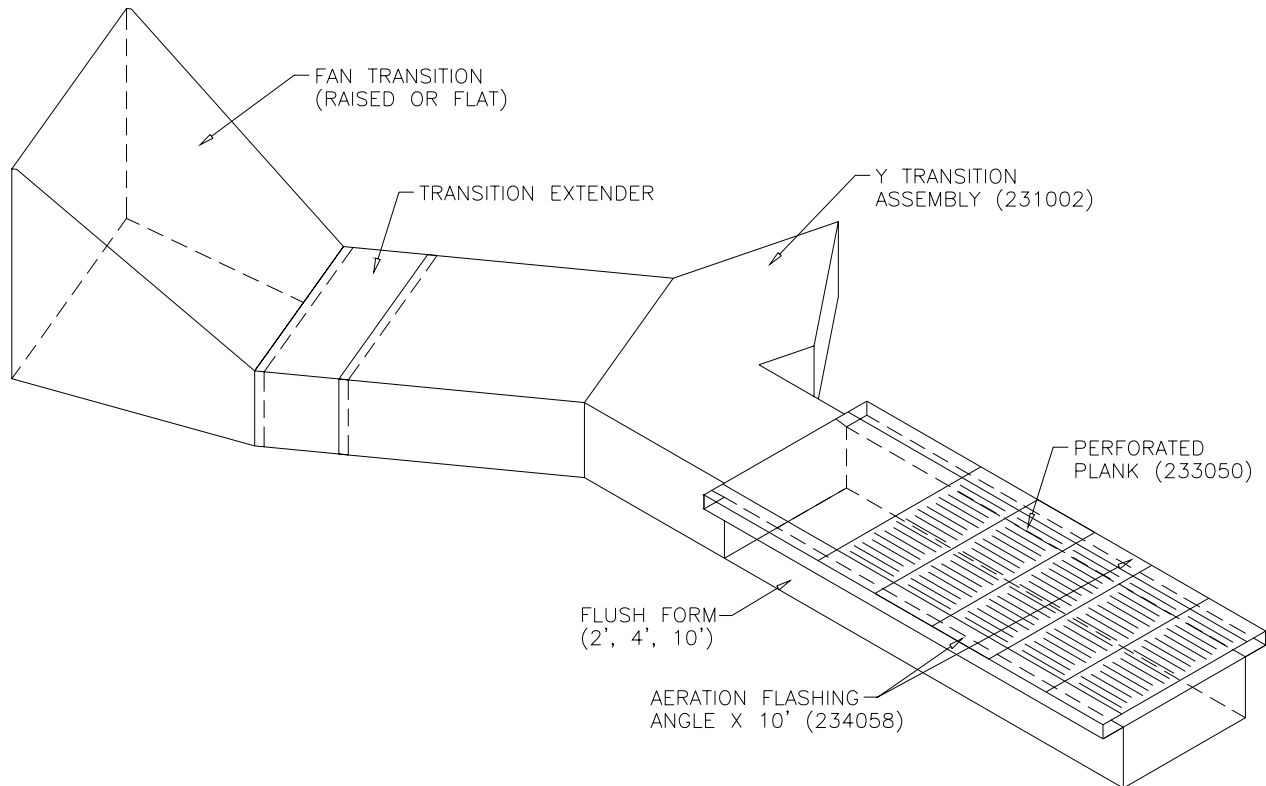
TRANSITION REDUCER ASSEMBLY



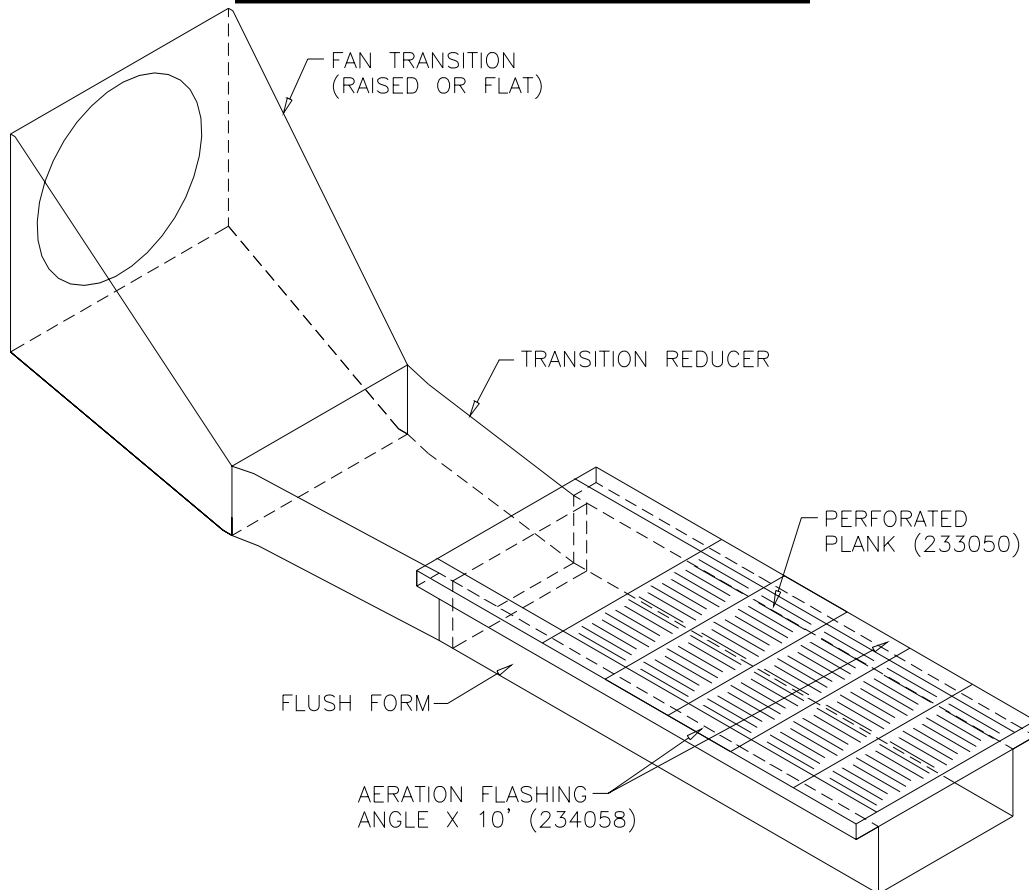
"Y" TRANSITION ASSEMBLY



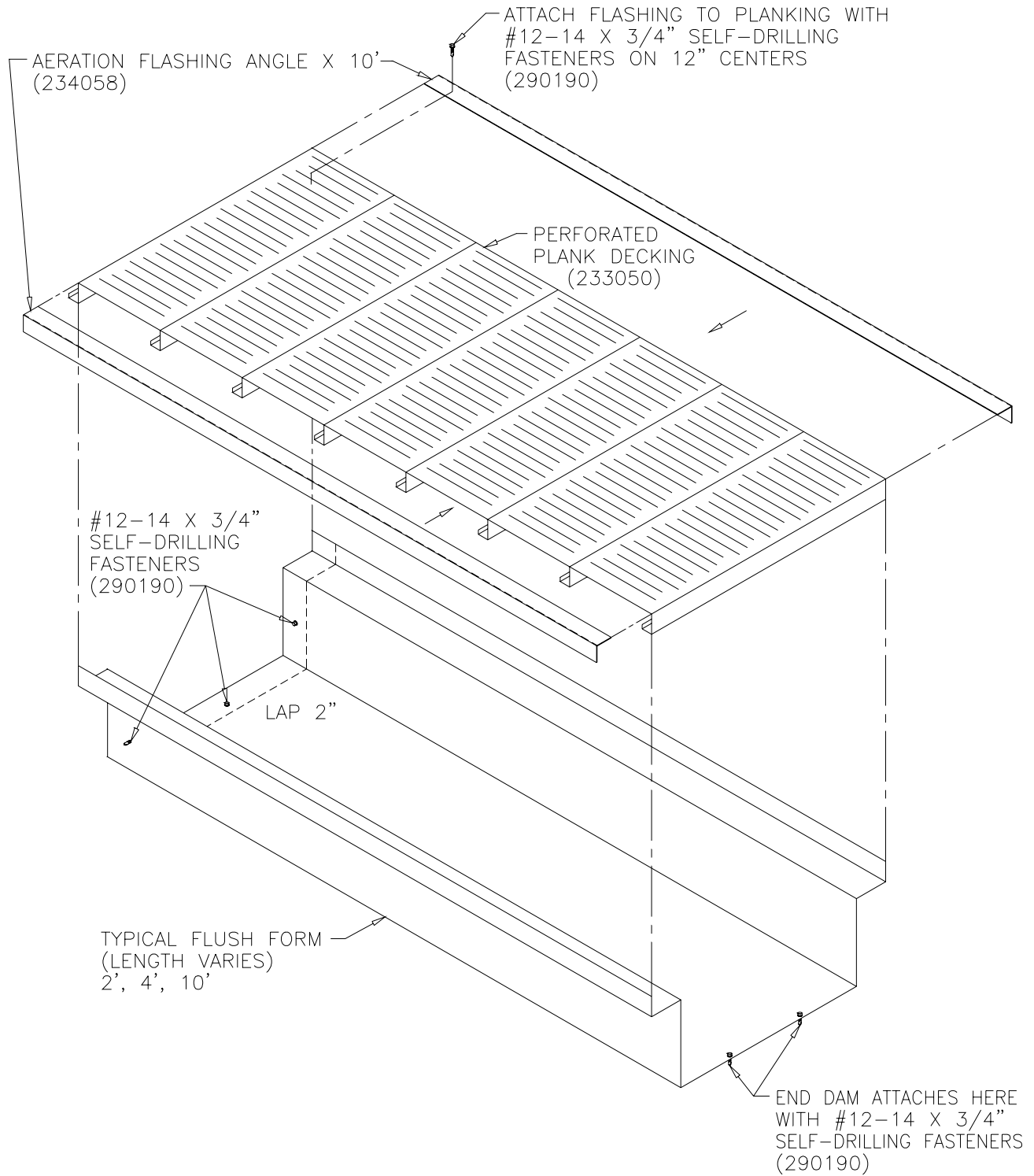
“Y” SYSTEM ASSEMBLY



STRAIGHT SYSTEM ASSEMBLY



FORM & DECK ASSEMBLY





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