



Cor-Lok/Cut-Lok Flooring and Grandstand Layout

Models:
48' DIAMETER

Installation Manual

PNEG-222
Version 5.0

Date: 10-11-21



PNEG-222

All information, illustrations, photos, and specifications in this manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

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NOTES

1 Safety Precautions

Topics Covered in this Chapter

- Safety Guidelines
- Cautionary Symbol Definitions
- Safety Cautions
- Safety Decals
- Safety Sign-off Sheet

Safety Guidelines

Safety guidelines are general-to-specific safety rules that must be followed at all times. This manual is written to help you understand safe operating procedures and problems that can be encountered by the operator and other personnel when using this equipment. Read and save these instructions.

As owner or operator, you are responsible for understanding the requirements, hazards, and precautions that exist and to inform others as required. Unqualified persons must stay out of the work area at all times.

Alterations must not be made to the equipment. Alterations can produce dangerous situations resulting in **SERIOUS INJURY or DEATH**.

This equipment must be installed in accordance with the current installation codes and applicable regulations, which must be carefully followed in all cases. Authorities having jurisdiction must be consulted before installations are made.

When necessary, you must consider the installation location relative to electrical, fuel and water utilities.








Personnel operating or working around equipment must read this manual. This manual must be delivered with equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

ST-0001-4

Cautionary Symbol Definitions

Cautionary symbols appear in this manual and on product decals. The symbols alert the user of potential safety hazards, prohibited activities and mandatory actions. To help you recognize this information, we use the symbols that are defined below.

Table 1-1 Description of the different cautionary symbols

Symbol	Description
	This symbol indicates an imminently hazardous situation which, if not avoided, will result in serious injury or death.
	This symbol indicates a potentially hazardous situation which, if not avoided, can result in serious injury or death.
	This symbol indicates a potentially hazardous situation which, if not avoided, can result in minor or moderate injury.
	This symbol is used to address practices not related to personal injury.
	This symbol indicates a general hazard.
	This symbol indicates a prohibited activity.
	This symbol indicates a mandatory action.

ST-0005-2

Safety Cautions

Use Personal Protective Equipment

- Use appropriate personal protective equipment:

Eye Protection



Respiratory Protection



Foot Protection



Hearing Protection



Head Protection



Fall Protection



Hand Protection



- Wear clothing appropriate to the job.
- Remove all jewelry.
- Tie long hair up and back.

ST-0004-1

Follow Safety Instructions

- Carefully read all safety messages in this manual and safety signs on your machine. Keep signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from the manufacturer.
- Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.
- If you do not understand any part of this manual or need assistance, contact your dealer.



ST-0002-1

Chapter 1: Safety Precautions

Maintain Equipment and Work Area

- Understand service procedures before doing work. Keep area clean and dry.
- Never service equipment while it is operating. Keep hands, feet, and clothing away from moving parts.
- Keep your equipment in proper working condition. Replace worn or broken parts immediately.



ST-0003-1

Prevent Roof Damage Due to Vacuum Pressure

- Roof damage can result from excessive vacuum or internal pressure from fans or other air moving systems. The manufacturer does not warrant this type of roof damage.
- Adequate ventilation or “makeup air” devices must be provided for all powered air handling systems.
- The manufacturer does not recommend the use of downward flow systems (suction).
- Severe roof damage can result from any blockage of air passages.
- Operating fans during high humidity or cold weather conditions can cause air exhaust or intake ports to freeze.



ST-0028-2

Sharp Edge Hazard

- This product has sharp edges, which can cause serious injury.
- To avoid injury, handle sharp edges with caution and always use proper protective clothing and equipment.



ST-0036-2

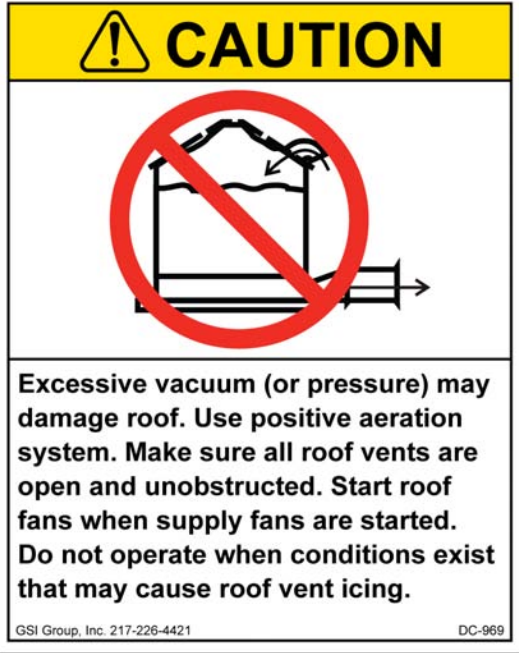
Safety Decals

The safety decals on your equipment are safety indicators which must be carefully read and understood by all personnel involved in the installation, operation, service and maintenance of the equipment.



To replace a damaged or missing decal, contact us to receive a free replacement.

GSI Decals

1004 E. Illinois Street
 Assumption, IL 62510
 Phone: 1-217-226-4421

Location	Decal No.	Decal	Description
Located next to aeration system.	DC-969		Caution Vacuum Pressure

Chapter 1: Safety Precautions

Location	Decal No.	Decal	Description
On bin door covers	DC-GBC-1A	 <p>WARNING</p> <p>Rotating flighting could kill or dismember. Flowing material could trap and suffocate. Crusted material could collapse and suffocate.</p> <p>Keep clear of all augers. DO NOT ENTER this bin!</p> <p>If you must enter the bin:</p> <ol style="list-style-type: none"> 1. Shut off and lock out all power. 2. Use a safety harness and safety line. 3. Station another person outside the bin. 4. Avoid the center of the bin. 5. Wear proper breathing equipment or respirator. <p>Failure to heed these warnings could result in serious injury or death.</p> <p><small>DC-GBC-1A</small></p>	Warning Keep Clear of Augers
On bin door covers	DC-GBC-2A	 <p>WARNING</p> <p>UNLOADING INSTRUCTIONS:</p> <ol style="list-style-type: none"> 1. Use CENTER FLOOR OUTLET ONLY until NO grain remains above this outlet. 2. Side floor outlets to be used ONLY when above condition is satisfied. 3. Lock all side floor outlets to avoid accidental premature use. 4. See manufacturers instructions for proper use of factory supplied sidedraw (wall) discharge systems. <p>Failure to heed these warnings could result in serious injury, death, structural damage or collapse of tank.</p> <p><small>DC-GBC-2A</small></p>	Warning Unload Instructions

NOTES

2 Floor Installation

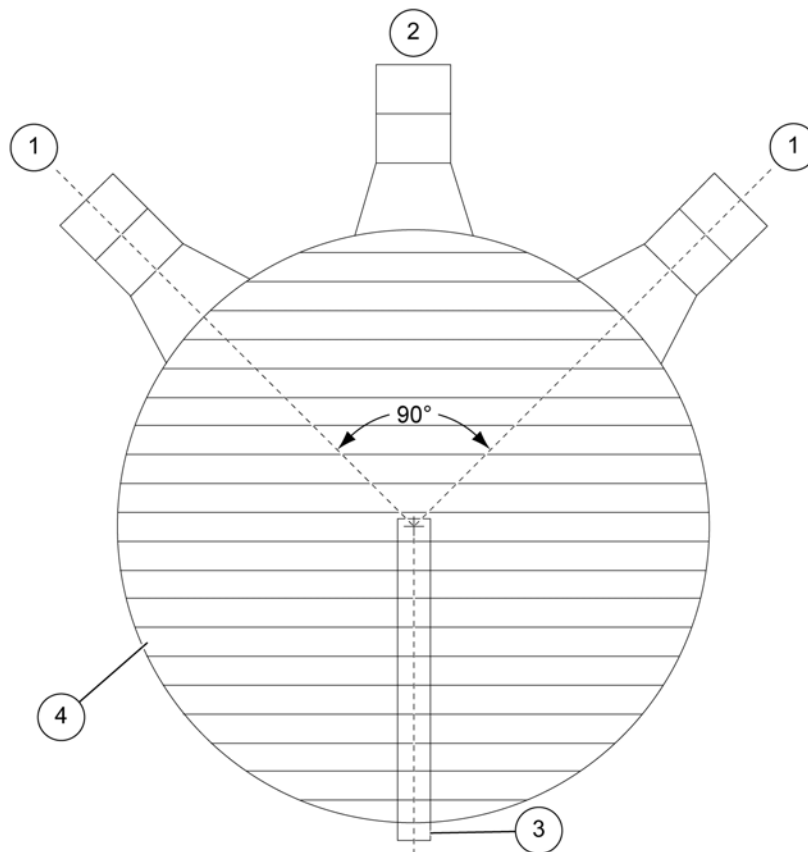
Topics Covered in this Chapter

- Fan Placement Diagram
- Full Floor Installation
- Undersplice Specifications
- Installing the Undersplice
- Installing the Undersplice and Oversplice for Small Grain Floor Planks

Fan Placement Diagram

1. For uniform air flow, place the fans (1 and 2) in relation to the unloading tube (3) as shown below.
2. Floor planks (4) should be perpendicular to the unloading tube (3).

Figure 2-1 Fan placement diagram



1	Placement with two fans	3	Auger/Unload equipment
2	Placement with one fan	4	Floor plank

Full Floor Installation

Using the GSI recommended method for full floor installation should save construction time and eliminate the problem of improper installation which could invalidate your warranty. Note the following dimensions as shown below.

- Dimension “A” is the leg-to-leg spacing along the centerline of a given plank.
- Dimension “B” is the amount of stagger between supports under adjacent planks and is half of dimension “A”.
- Dimension “C” is the distance from the center of the unload auger to the nearest row of supports and is half of dimension “B”.

Dimensions “A”, “B” and “C” are shown on the appropriate grandstand layout for wall heights under 32'. For taller bins, grandstand quantity as well as dimensions “A” and “B” are given in the grandstand layout on [2.66" Corrugation chart, page 50](#) and [4.00" Corrugation chart, page 51](#).

1. Layout centerlines of tank. Make sure one centerline (5) is in line with the direction of the flooring planks (4) while the other centerline (5) is perpendicular with the flooring planks (4).
2. From the centerline that is perpendicular to the flooring planks, measure the distance of “C” dimension and mark a chalk line (6).
3. From the line chalked (6), measure over the distance of “B” dimension and chalk another line. Repeat this procedure across the bin until reaching the wall in both directions. When completed, there should be a set of parallel lines (perpendicular to the floor planks (4)) with “B” dimension distance between each line.

Figure 2-2 Full floor installation

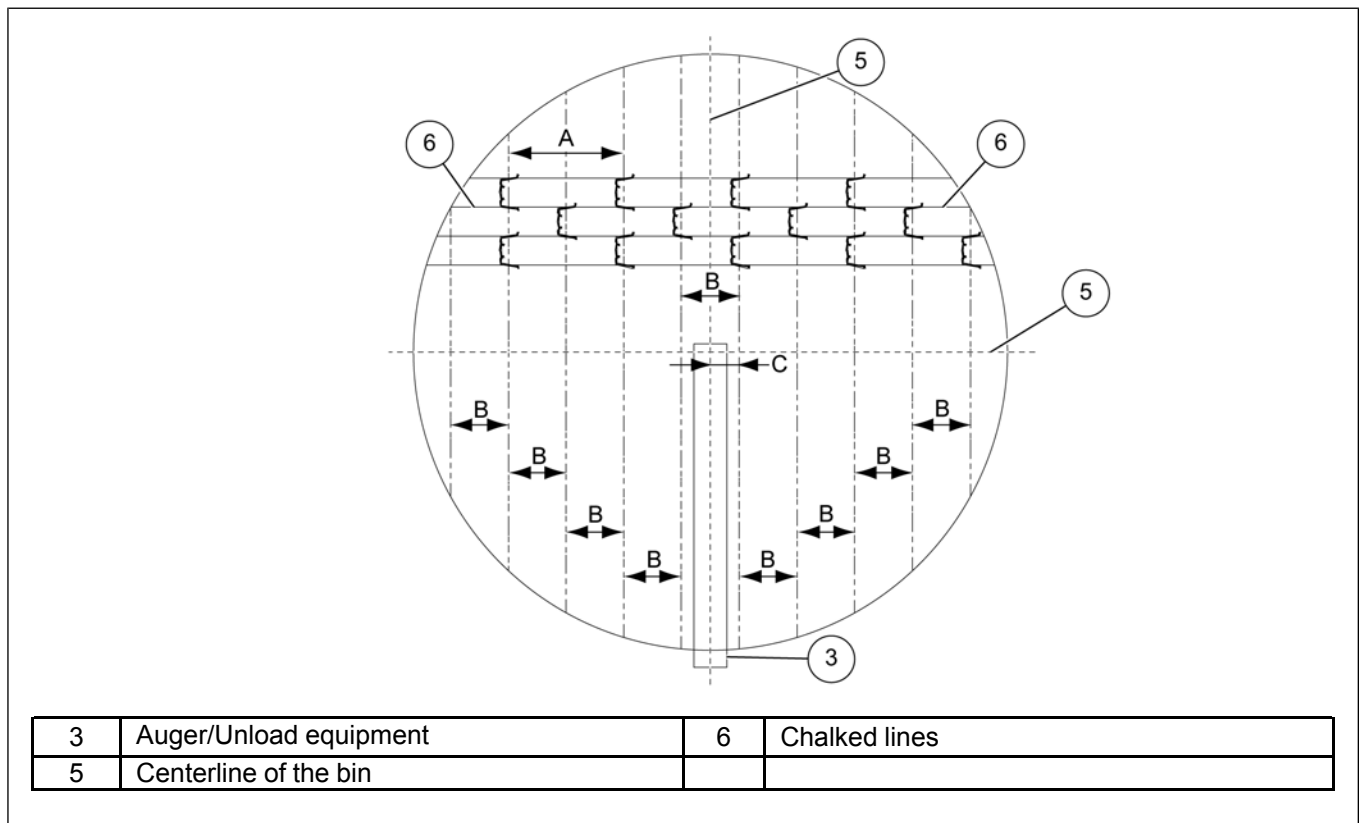
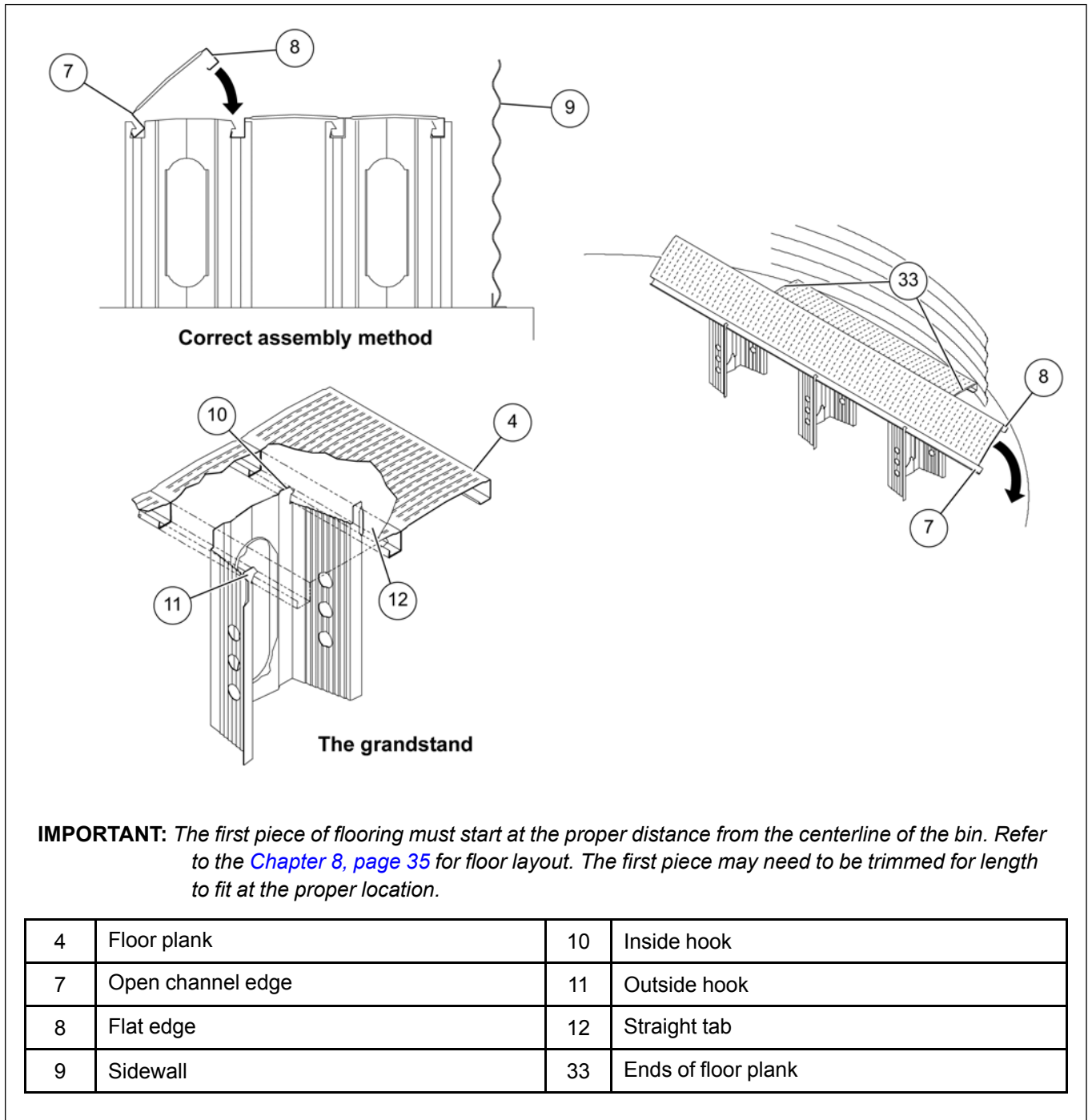


Figure 2-3 Floor plank assembly



4. Install the flooring starting at the sidewall (9) on the opposite side of the unload auger (3).
5. Floor planks (4) should be placed perpendicular to the unload auger (3) with the outside edge the correct distance from the center of the bin. Refer to the [Chapter 8, page 35](#).
6. Make sure that the flat edge (8) of the floor plank (4) is facing the sidewall (9) and the open channel edge (7) is facing towards the center of the bin.
7. Position the supports for the first/shortest floor plank (4) according to the number of bin rings and corrugation as shown in the grandstand layout charts and illustrations. (Refer to [2.66" Corrugation chart, page 50](#) and [4.00" Corrugation chart, page 51](#).)

Chapter 2: Floor Installation

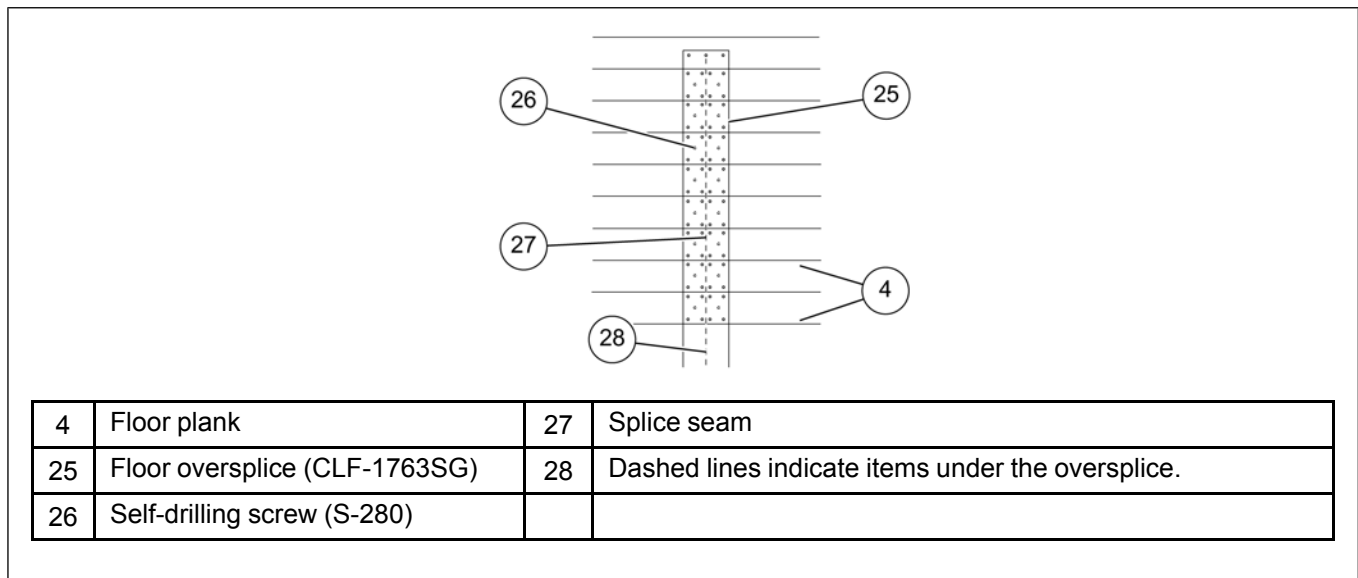
8. Attach the flashing to flooring and sidewall (9) to hold floor plank (4) in place. Refer to the [Chapter 4, page 23](#) for flashing installation.
9. Attach two flashings to the both ends (33) of first floor plank here, just to hold it in place.
NOTE: *These two flashings will need to be removed and repositioned when installing the rest of the flashing.*
10. **POSITION THE NEXT ROW OF SUPPORTS ACCORDING TO THE CHALK LINES (6)** and support layout. The straight tab (12) should “snap” under the first (previous) floor piece.
11. After the supports in the row are correctly positioned, install the next floor piece by hooking the open channel edge (7) under the outside hooks (11) of the floor supports.
12. Push down sharply on the edge of the floor piece until it snaps into the previous floor piece. Continue this process for the rest of the floor cutting planks for the center and intermediate wells as needed.
13. Refer to the [Chapter 5, page 25](#) for center well support locations.

NOTE:

- Whenever there is more than dimension “B” divided by three inches ($B/3$) of plank (4) unsupported beside the sidewall (9), there should be a support on that plank (4) or a support on each of the planks (4) adjacent to it such that no more than dimension “B” divided by three inches ($B/3$) is unsupported.
- For example: 2.66" bin with 8 rings has a “B” dimension of 22". Take $22"/3 = 7.33$ " (Round to 7"). Therefore, there should be no more than 7" of unsupported floor plank (4).

14. Some floor planks (4) will need to be spliced together. Refer to the [Figure 6-1, page 27](#), and [48'-1" Plank Lengths \(Optional\), page 34](#) for more information.
15. Install plank length “A” first, then install the corresponding plank length “B” by butting plank “B” up against plank “A”.
16. Make sure that the planks are supported by a grandstand on each side of the splice. Continue this until the floor is complete.

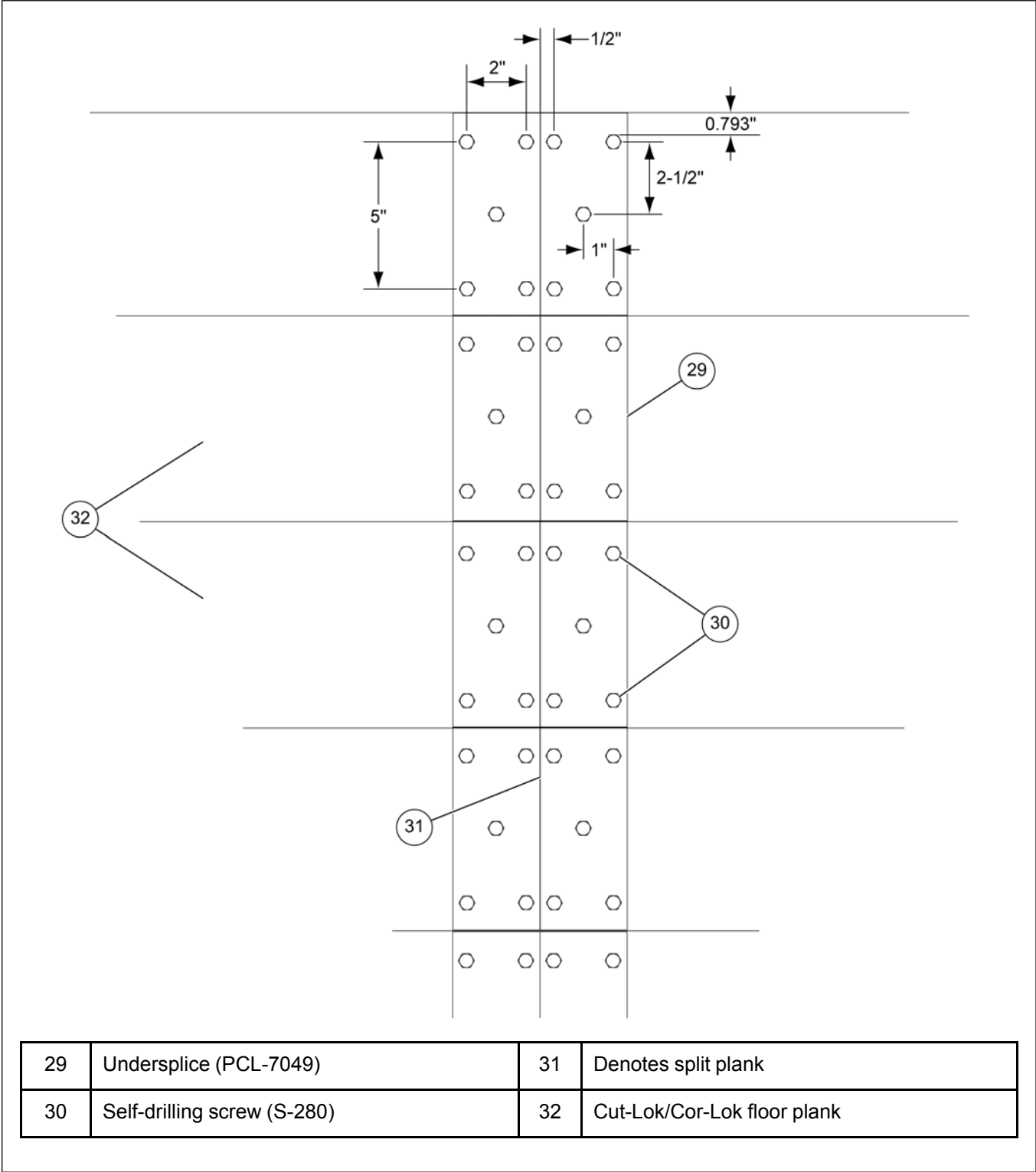
Figure 2-4 Oversplice bolt pattern for small grain floors



Undersplice Specifications

1. The undersplice should be installed underneath the planks at the split after both plank lengths have been butted together.
2. Each splice has to be installed as each row of planks are installed. Below figure shows the layout of the undersplice plates (29) and the screw pattern used to secure them.

Figure 2-5 Specifications for installing the undersplice to floor planks

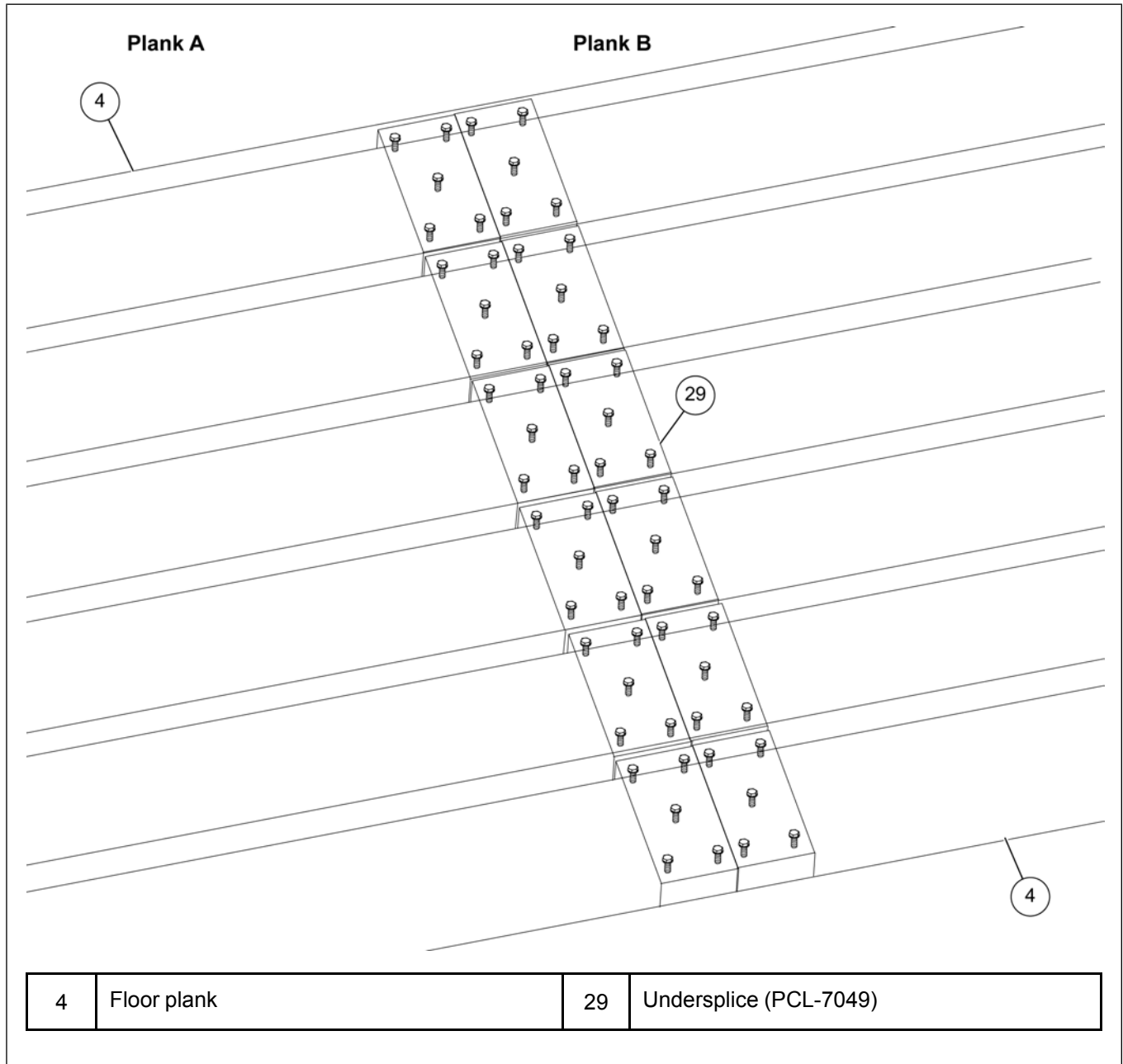


Installing the Undersplice

1. Place floor plank (4) ends together.
2. Place the undersplice (29) under the floor planks (4). Make sure the undersplice (29) extends 3" across each floor plank (4).
3. The undersplice (29) should extend 3" under each floor plank (4). The undersplice (29) should be screwed in place as shown in [Figure 2-4, page 16](#).
4. Repeat for all the plank locations requiring a splice.

NOTE: *Small grain perforated floors include an oversplice that is installed at the same time as the undersplices.*

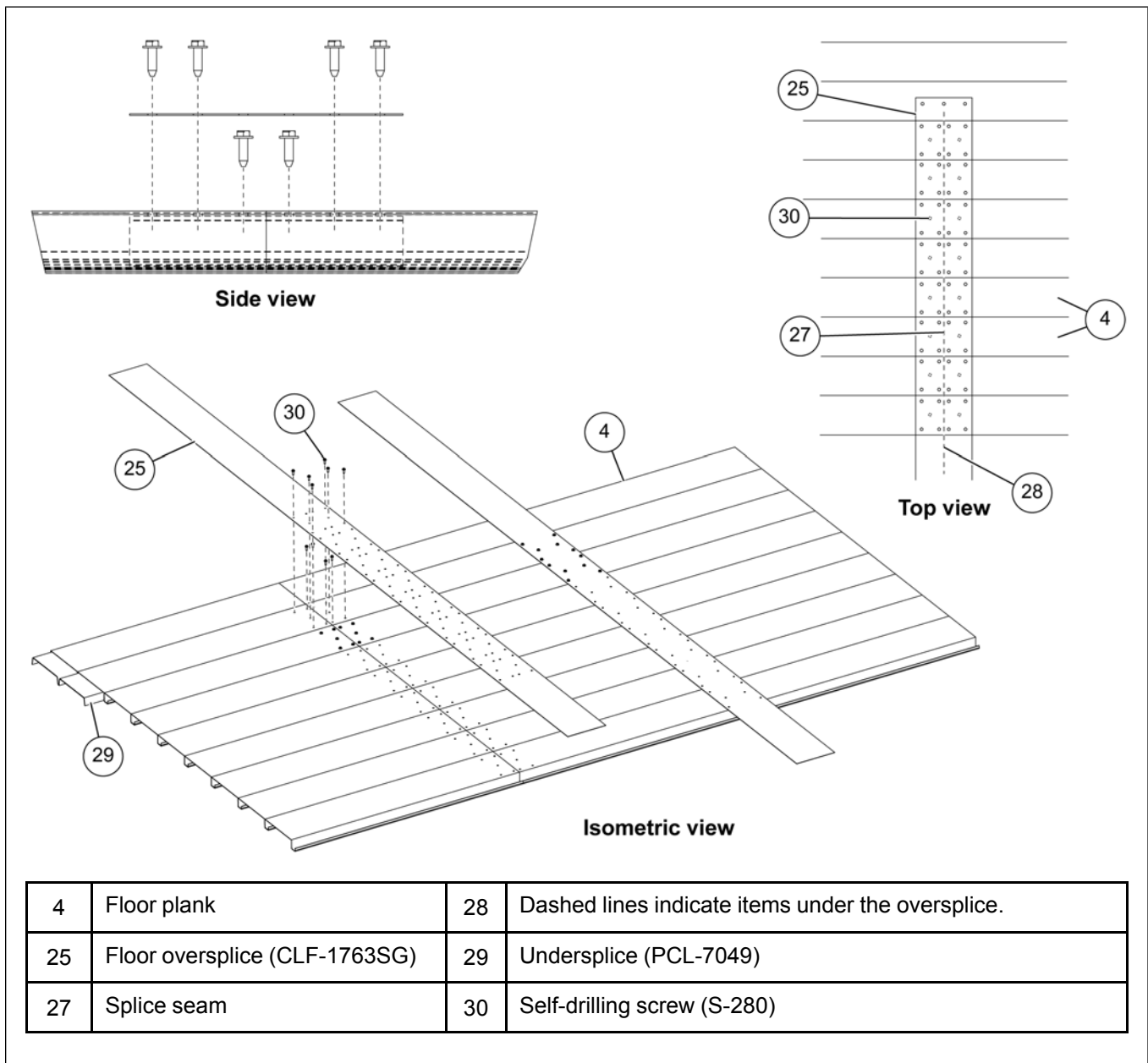
Figure 2-6 Installing the undersplice



Installing the Undersplice and Oversplice for Small Grain Floor Planks

1. Place plank ends together.
2. Place the undersplice (29) under the planks. Make sure the undersplice (29) extends 3" across each plank.
3. Install the undersplice (29) to the planks using two self-drilling screws (30) per splice to hold it in place.
4. Place the oversplice (25) over the length of the plank splice seams.
5. Install the oversplice (25) to the planks and undersplices (29) using three self-drilling screws (30) per each undersplice.

Figure 2-7 Installing the undersplice and oversplice



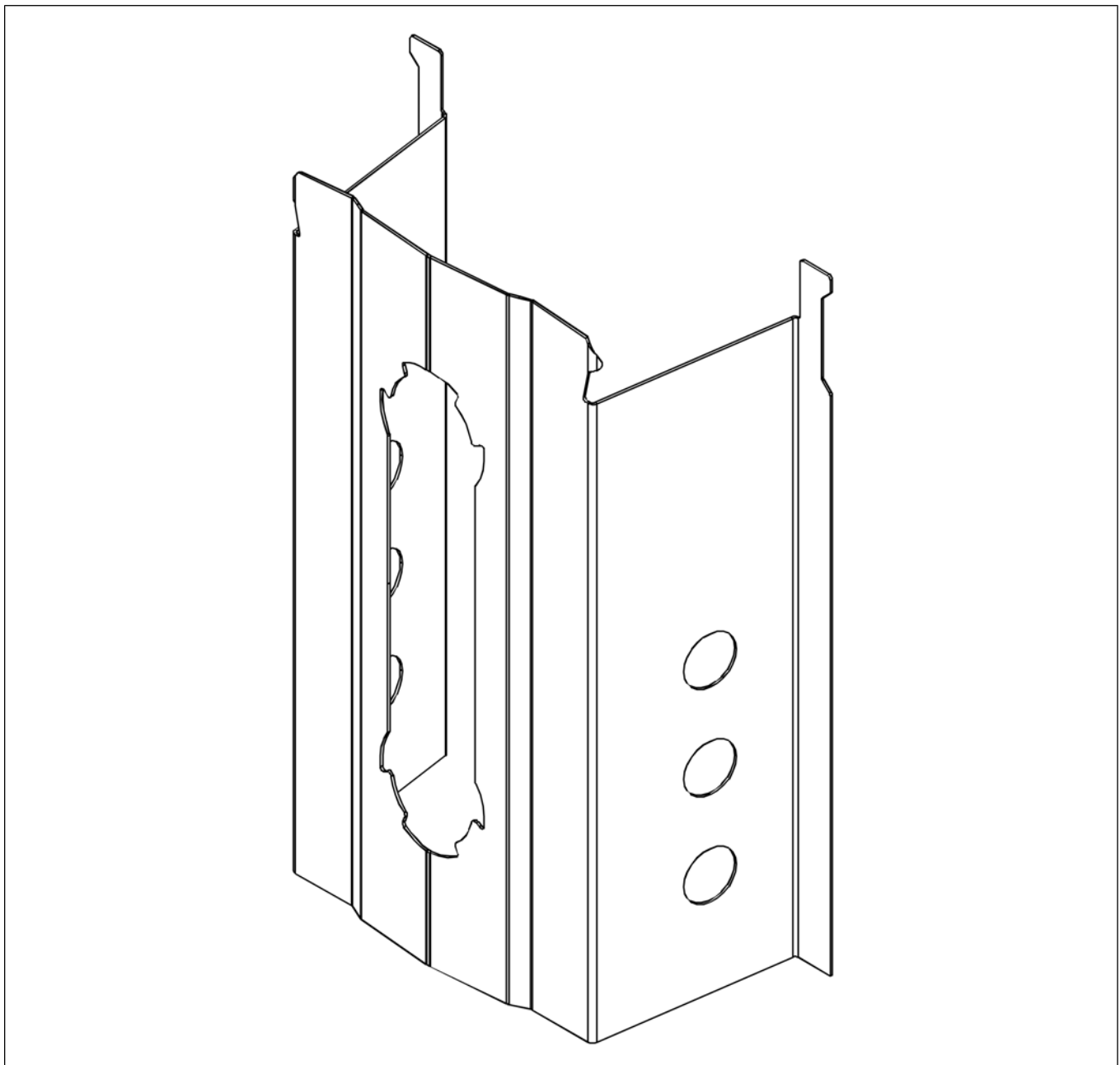
NOTES

3 20 Gauge Grandstand Identification

Table 3-1 20 gauge grandstand identification

Plenum clearance	Grandstand color code
11-7/8"	Blue
14-3/8"	White
17-3/16"	Yellow

Figure 3-1 Grandstand identification



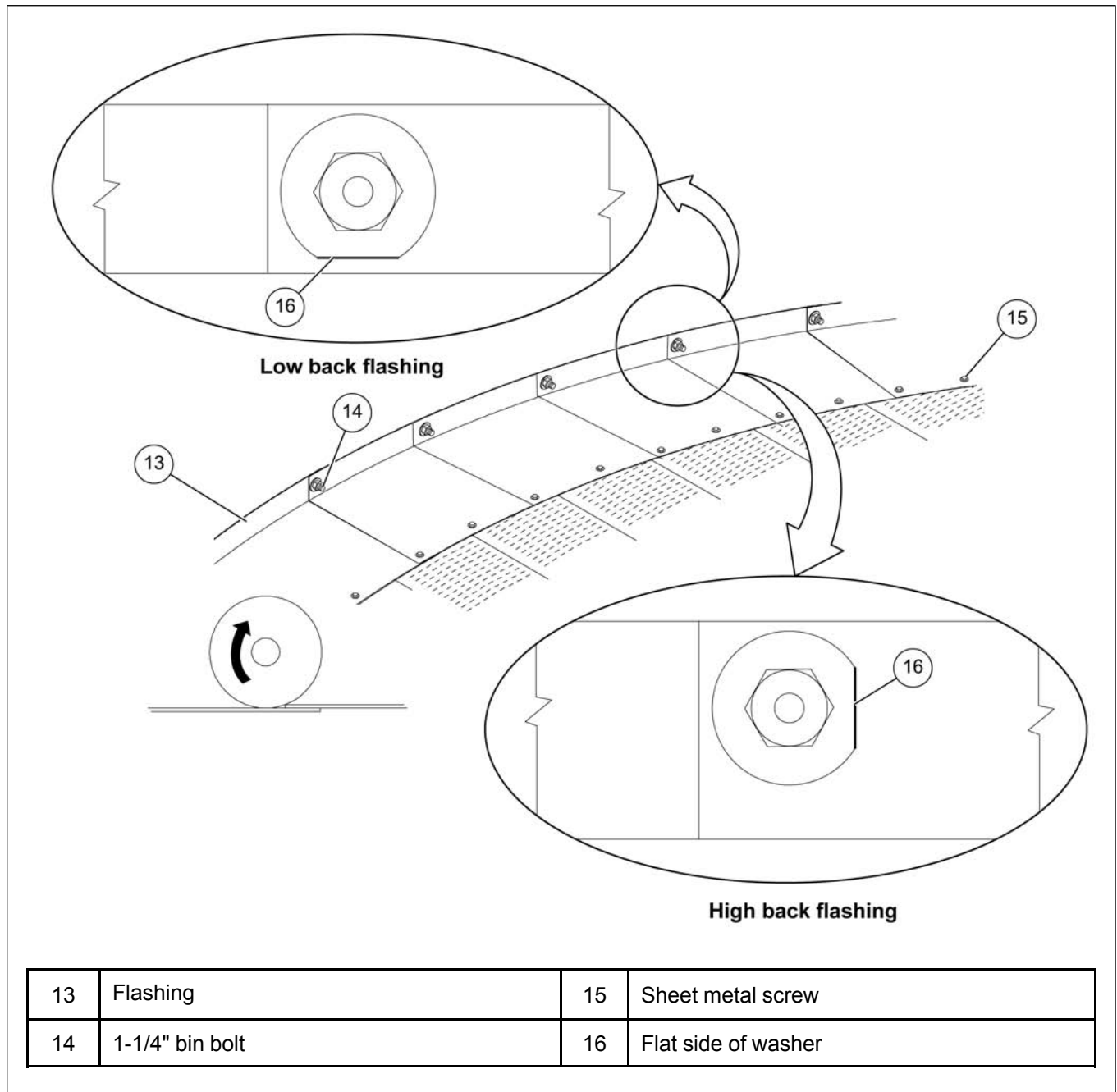
NOTES

4 Flashing Installation

1. If a bin sweep auger will be used, overlap flashing (13) so that the sweep will climb up on to the next flashing (13) section when rotating (usually clockwise).
2. This will prevent the rotating/slipping outer wheel of the sweep from catching on the flashing (13) edges.

NOTE: All GSI power sweeps and carry-in sweeps manufactured after April 2002 run clockwise.

Figure 4-1 Formed flashing installation



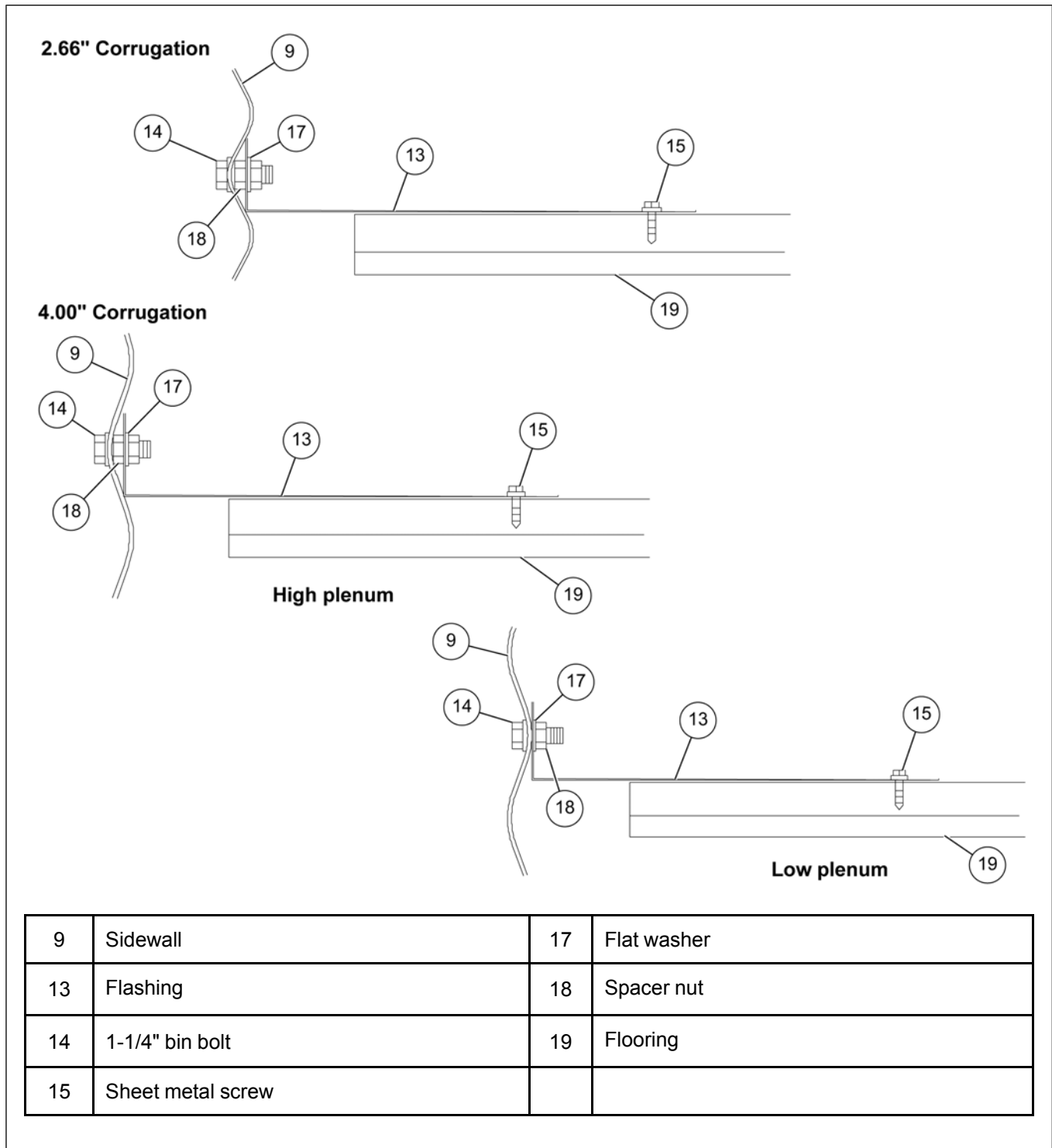
Chapter 4: Flashing Installation

- After floor (19) is in place, place 1-1/4" bin bolts (14) through the pre-punched holes in the sidewall (9). Refer the below figure to determine the correct sequence for placing the spacer nuts (18) and flat washers (17).

NOTE: Bolt (14) heads should be on the outside of the bin.

- Finger tighten the spacer nuts (18) until all flashing (13) is installed, then go back and fully tighten.
- While holding the flashing (13) flat and pushing in towards the sidewall (9), fasten the flashing (13) to the floor (19) with two sheet metal screws (15).

Figure 4-2 Corrugation details

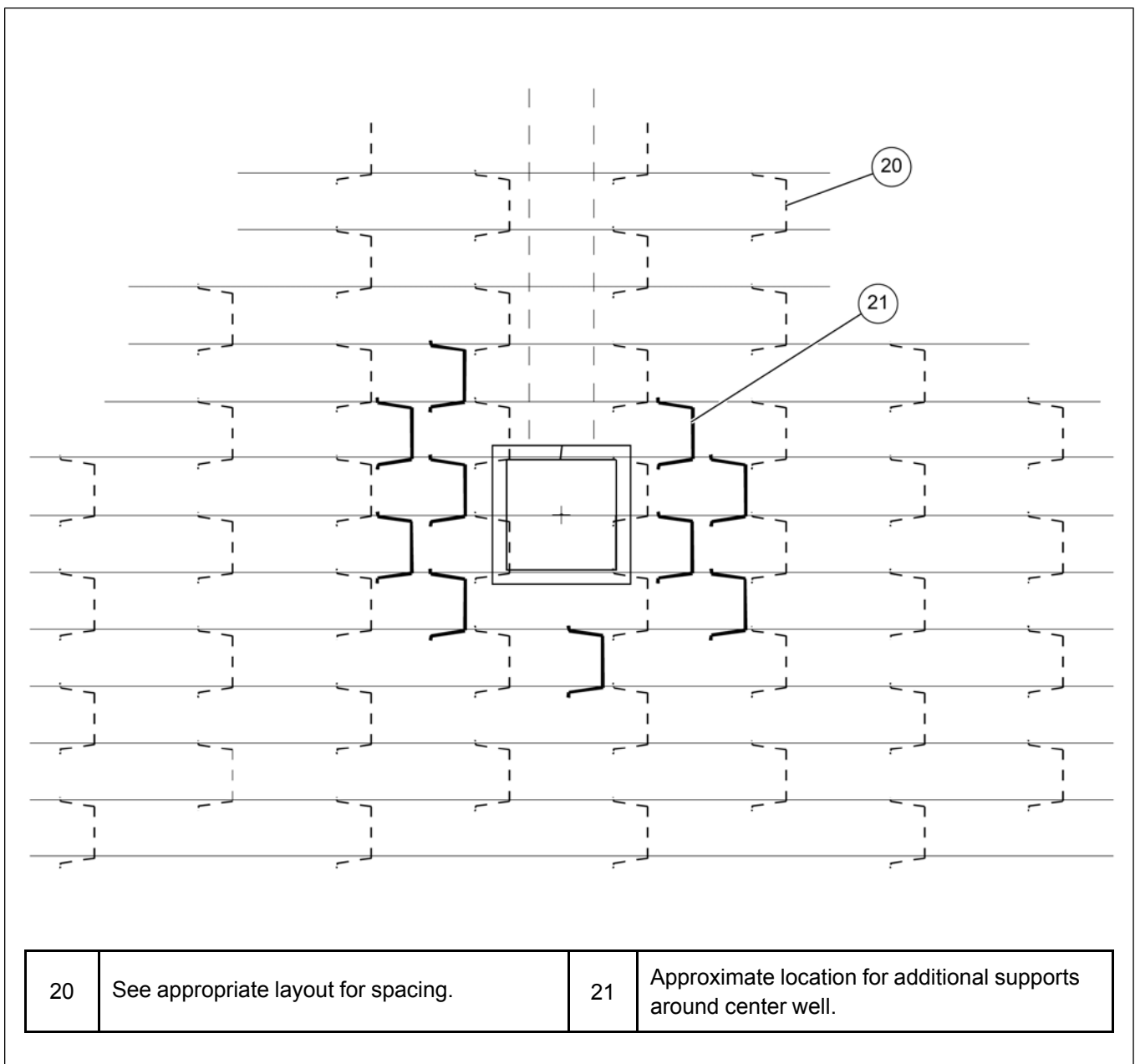


5 Grandstand Layout at Center Well for Recirculating System



Support all center wells to concrete.

Figure 5-1 Grandstand layout for recirculating system



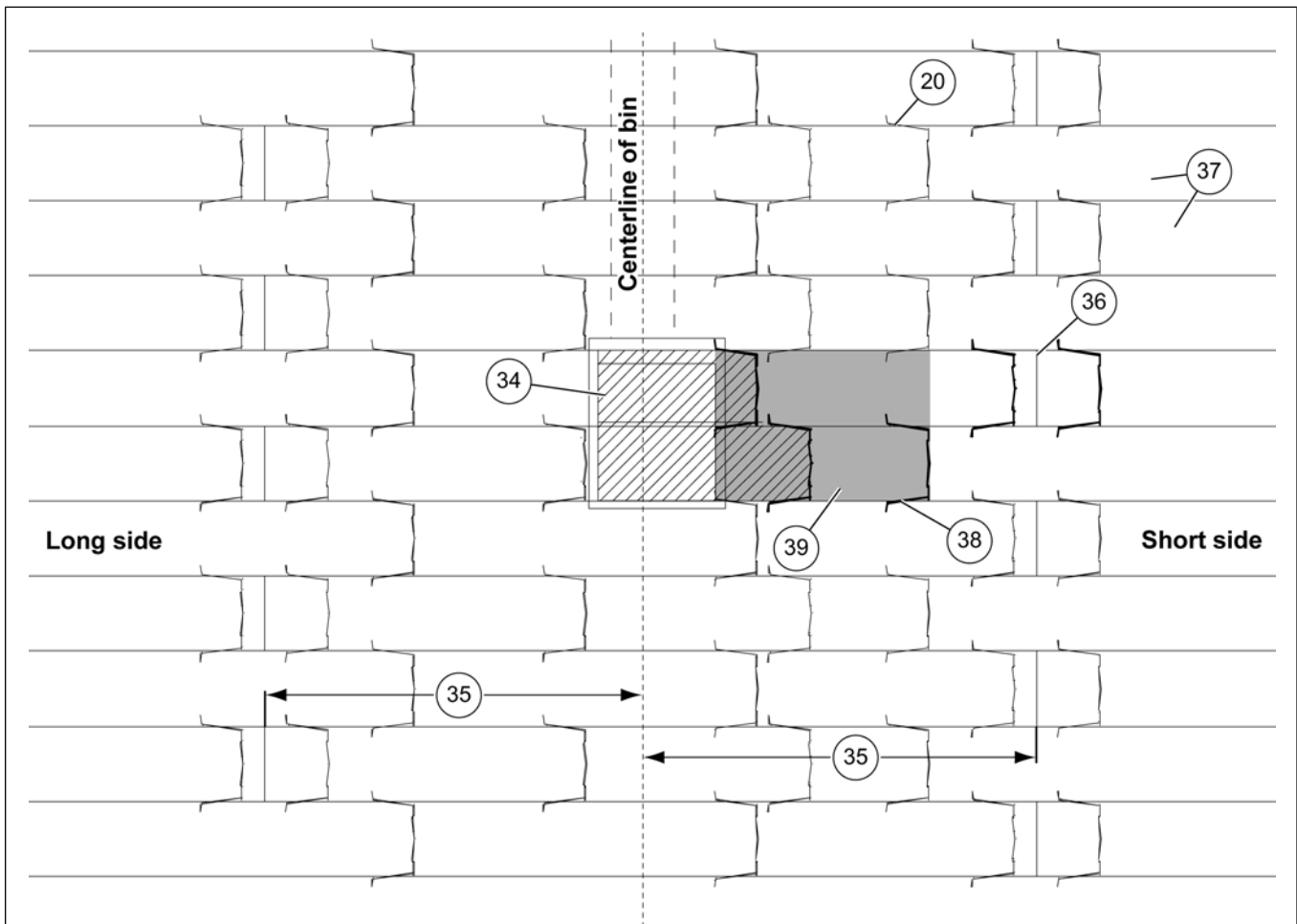
NOTES

6 Well Installation Cut Detail



Support all center wells to concrete.

Figure 6-1 Well installation plank cut detail for 48' split floor



20	See appropriate layout for grandstand spacing.	37	Use floor sections cut from long pieces for well installation on this side of the well as shown. (Must be cut to fit.)
34	Cut these pieces for well installation.	38	Additional grandstands
35	3' distance from the center of the bin to splice location	39	Add entire cut pieces back in here with additional grandstands per plank as shown.
36	Plank splice location		

NOTES

7 Bundle and Plank Layouts

Topics Covered in this Chapter

- 48' Split Floor Bundle Layout
- 48' Split Floor Plank Layout
- 48'-1" Plank Lengths (Optional)

48' Split Floor Bundle Layout

Figure 7-1 48' Split floor bundle layout

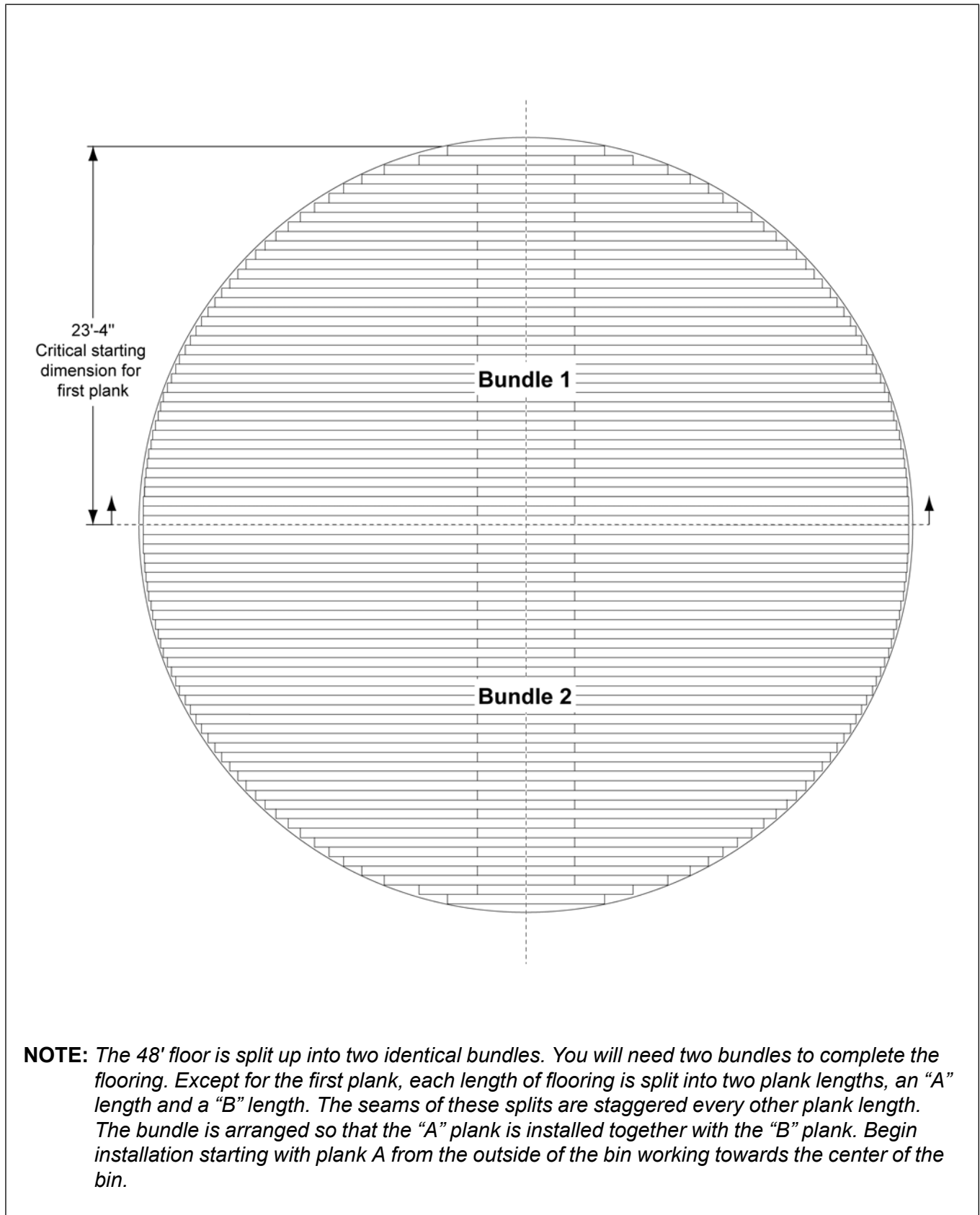


Table 7-1 48' Split plank floor bundle layout chart

Plank Bundle Layout by Plank Number				Plank Bundle Layout by Plank Length			
Stack 1	Stack 2	Stack 3	Stack 4	Stack 1	Stack 2	Stack 3	Stack 4
7A	5A	3A		121"	99"	69"	
8B	6B	4B	2B	131"	110"	86"	43"
7B	5B	3B	1	193"	171"	141"	116"
8A	6A	4A	2A	203"	182"	158"	115"
15A	13A	11A	9A	183"	171"	157"	140"
16B	14B	12B	10B	185"	177"	164"	149"
15B	13B	11B	9B	255"	243"	229"	212"
16A	14A	12A	10A	257"	249"	236"	221"
23A	21A	19A	17A	220"	212"	204"	194"
24B	22B	20B	18B	223"	216"	208"	199"
23B	21B	19B	17B	292"	284"	276"	266"
24A	22A	20A	18A	295"	288"	280"	271"
31A	29A	27A	25A	240"	236"	232"	226"
32B	30B	28B	26B	241"	238"	234"	229"
31B	29B	27B	25B	312"	308"	304"	298"
32A	30A	28A	26A	313"	310"	306"	301"
39A	37A	35A	33A	247"	246"	245"	243"
40B	38B	36B	34B	247"	247"	246"	244"
39B	37B	35B	33B	319"	318"	317"	315"
40A	38A	36A	34A	319"	319"	318"	316"

NOTE:

1. Charts are arranged to mimic the bundles as if you were standing at the end of the bundle where all the plank edges are butted flush together.
2. The 48' floor requires two identical bundles to complete the floor.
3. Plank banding and sub-banding are separated by gray areas in tables.

48' Split Floor Plank Layout

Figure 7-2 48' Split floor plank layout

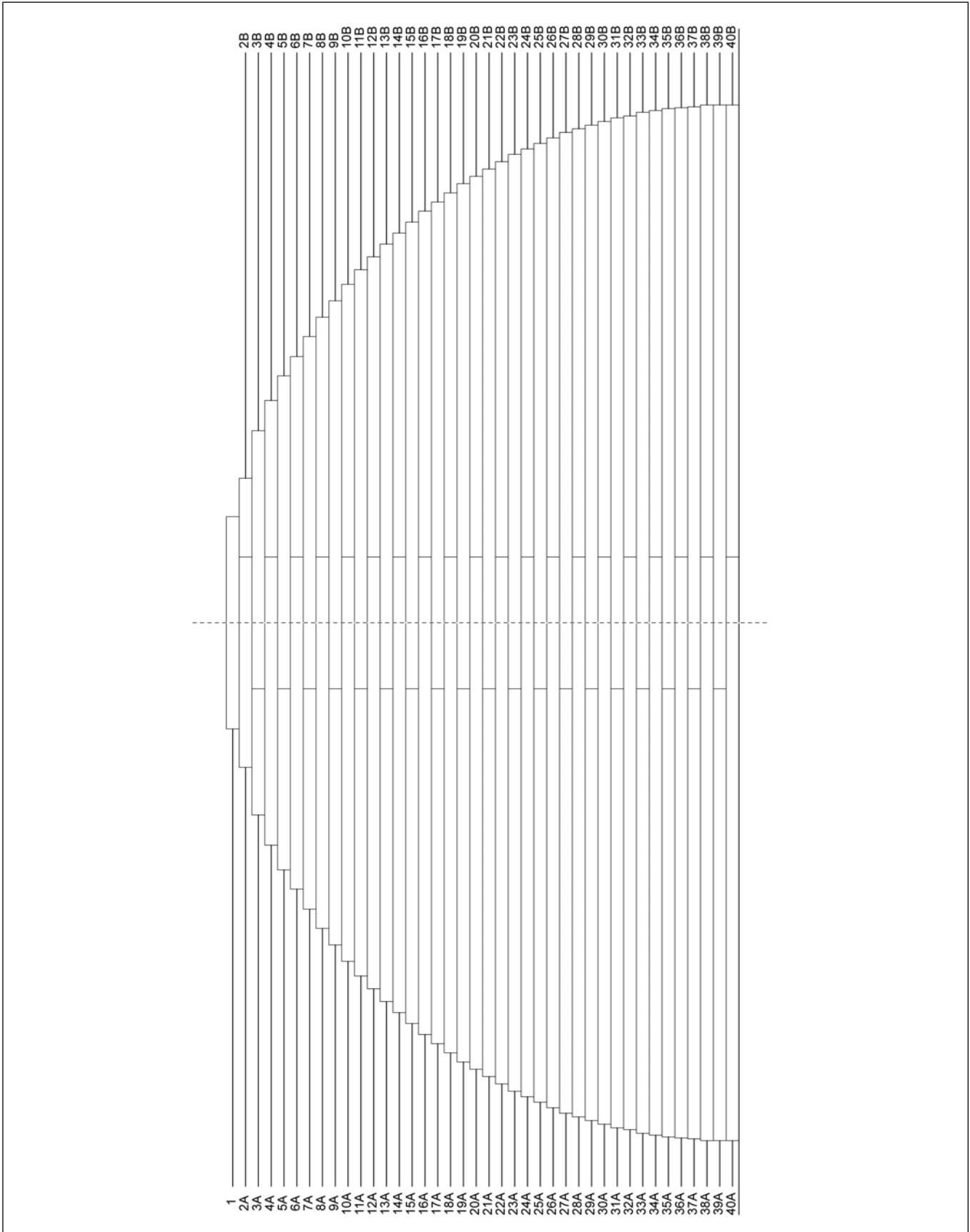


Table 7-2 48' Split floor plank layout chart

Plank #	Plank Length	In Inch	In Metric	Plank #	Plank Length	In Inch	In Metric
1	9'-8"	116	294.64				
2A	9'-7"	115	292.1	2B	3'-7"	43	109.22
3A	5'-9"	69	175.26	3B	11'-9"	141	358.14
4A	13' - 1-1/2"	157-1/2	400.05	4B	7' - 1-1/2"	85-1/2	217.17
5A	8'-3"	99	251.46	5B	14'-3"	171	434.34
6A	15' - 1-1/2"	181-1/2	461.01	6B	9' - 1-1/2"	109-1/2	278.13
7A	10'-1/2"	120-1/2	306.07	7B	16'-1/2"	192-1/2	488.95
8A	16'-11"	203	515.62	8B	10'-11"	131	332.74
9A	11'-8"	140	355.6	9B	17'-8"	212	538.48
10A	18'-5"	221	561.34	10B	12'-5"	149	378.46
11A	13'-11"	157	396.46	11B	19'-11"	229	581.40
12A	19'-8"	236	599.44	12B	13'-8"	164	416.56
13A	14'-3"	171	434.34	13B	20'-3"	243	617.22
14A	20'-9"	249	632.46	14B	14'-9"	177	449.58
15A	15'-3"	183	464.82	15B	21'-3"	255	647.7
16A	21' - 4-1/2"	256-1/2	651.51	16B	15' - 4-1/2"	184-1/2	468.63
17A	16'-2"	194	492.76	17B	22'-2"	266	675.64
18A	22'-7"	271	688.34	18B	16'-7"	199	505.46
19A	17'-0"	204	518.16	19B	23'-0"	276	701.04
20A	23'-4"	280	711.2	20B	17'-4"	208	528.32
21A	17'-8"	212	538.48	21B	23'-8"	284	721.36
22A	24'-0"	288	731.52	22B	18'-0"	216	548.64
23A	18'-4"	220	558.8	23B	24'-4"	292	741.68
24A	24'-7"	295	749.3	24B	18'-7"	223	566.42
25A	18'-10"	226	574.04	25B	24'-10"	298	756.92
26A	25'-1"	301	764.54	26B	19'-1"	229	581.66
27A	19'-4"	232	589.28	27B	25'-4"	304	772.16
28A	25'-6"	306	777.24	28B	19'-6"	234	594.36
29A	19'-8"	236	599.44	29B	25'-8"	308	782.32
30A	25'-10"	310	787.4	30B	19'-10"	238	604.52
31A	20'-0"	240	609.6	31B	26'-0"	312	792.48
32A	26'-1"	313	795.02	32B	20'-1"	241	612.14
33A	20'-3"	243	617.22	33B	26'-3"	315	800.1
34A	26'-4"	316	802.64	34B	20'-4"	244	619.76
35A	20'-5"	245	622.3	35B	26'-5"	317	805.18
36A	26' - 5-1/2"	317-1/2	806.45	36B	20' - 5-1/2"	245-1/2	623.57
37A	20'-6"	246	624.84	37B	26'-6"	318	807.72
38A	26'-7"	319	810.26	38B	20'-7"	247	627.38
39A	20'-7"	247	627.38	39B	26'-7"	319	810.26
40A	26'-7"	319	810.26	40B	20'-7"	247	627.38

48'-1" Plank Lengths (Optional)

The following plank lengths start at the sidewall and work towards the center of the bin. Refer to the grandstand layout on [2.66" Corrugation chart, page 50](#) and [4.00" Corrugation chart, page 51](#) for floor drawing.

1st Plank (A)		
Plank #	Plank Length	In Inch
1	9'-8"	116"
2	13'-12"	158"
3	17'-6"	210"
4	20'-3"	243"
5	22'-6"	270"
6	24'-3"	291"

1st Plank (A)		
Plank #	Plank Length	In Inch
7A	14'-1"	169"
8A	14'-11"	179"
9A	15'-8"	188"
10A	16'-5"	197"
11A	17'-1'	205"
12A	17'-8"	212"
13A	18'-3"	219"
14A	18'-9"	225"
15A	19'-3"	231"
16A	19'-9"	237"
17A	20'-2"	242"
18A	20'-7"	247"
19A	21'-0"	252"
20A	21'-4"	256"
21A	21'-8"	260"
22A	22'-0"	264"
23A	22'-4"	268"
24A	22'-7"	271"
25A	22'-10"	274"
26A	23'-1"	277"
27A	23'-4"	280"
28A	23'-6"	282"
29A	23'-8"	284"
30A	23'-10"	286"
31A	24'-0"	288"
32A	24'-1"	289"
33A	24'-3"	291"
34A	24'-4"	292"
35A	24'-5"	293"
36A	24' – 5-1/2"	293-1/2"
37A	24'-6"	294"
38A	24'-7"	295"
39A	24'-7"	295"
40A	24'-7"	295"

2nd Plank (B)		
Plank #	Plank Length	In Inch
7B	12'-0"	144"
8B	12'-11"	155"
9B	13'-8"	164"
10B	14'-5"	173"
11B	15'-1'	181"
12B	15'-8"	188"
13B	16'-3"	195"
14B	16'-9"	201"
15B	17'-3"	207"
16B	17'-9"	213"
17B	18'-2"	218"
18B	18'-7"	223"
19B	19'-0"	228"
20B	19'-4"	232"
21B	19'-8"	236"
22B	20'-0"	240"
23B	20'-4"	244"
24B	20'-7"	247"
25B	20'-10"	250"
26B	21'-1"	253"
27B	21'-4"	256"
28B	21'-6"	258"
29B	21'-8"	260"
30B	21'-10"	262"
31B	22'-0"	264"
32B	22'-1"	265"
33B	22'-3"	267"
34B	22'-4"	268"
35B	22'-5"	269"
36B	22' – 5-1/2"	269-1/2"
37B	22'-6"	270"
38B	22'-7"	271"
39B	22'-7"	271"
40B	22'-7"	271"

8 48' Grandstand Layout for Recirculating System

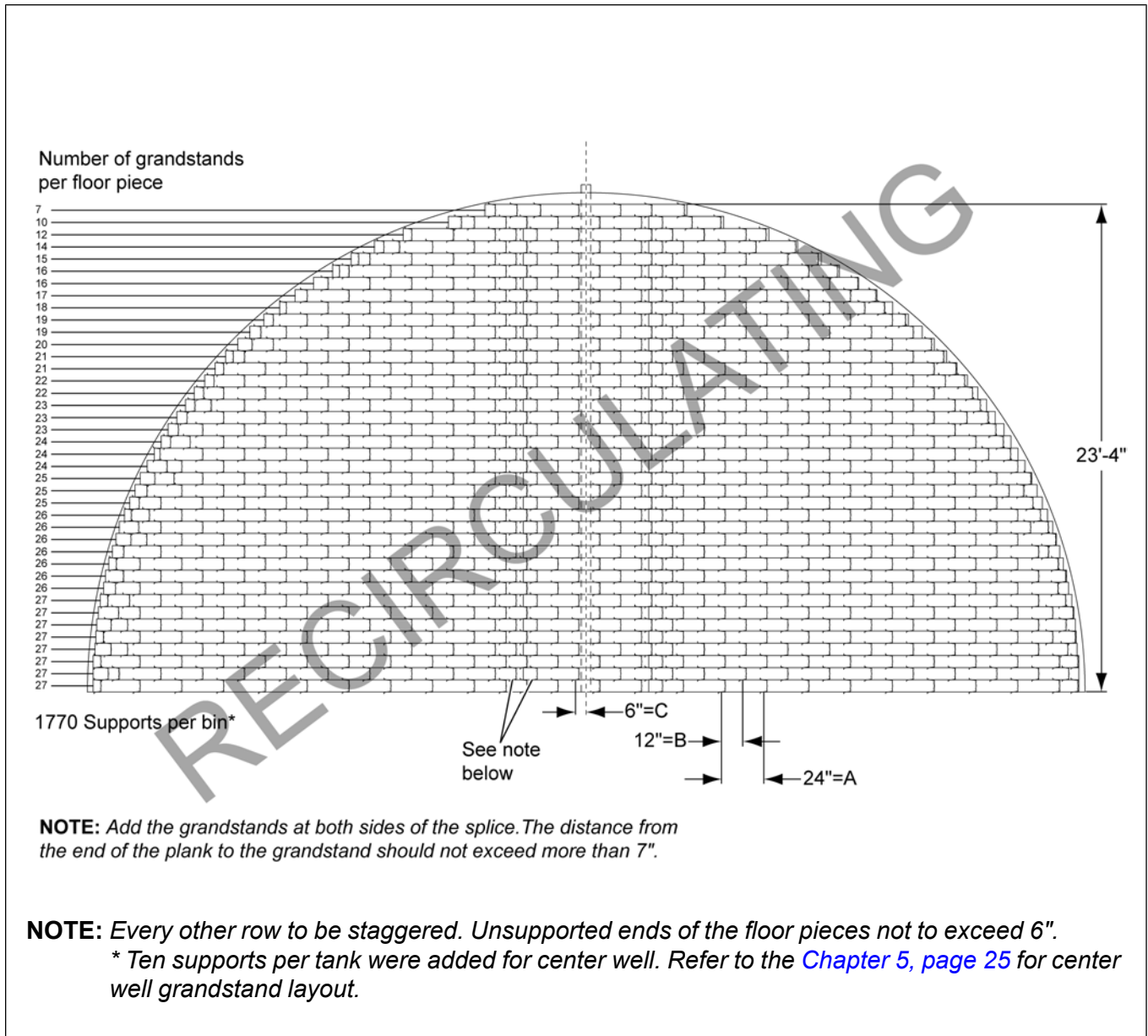
2.66" Bins 8 Rings Maximum and 4.00" Bins 6 Rings Maximum



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 8-1 2.66" bins 8 rings maximum and 4.00" bins 6 rings maximum



NOTES

9 Cor-Lok/Cut-Lok and Grandstand Layouts (33' Max. Wall Height)

Topics Covered in this Chapter

- 2.66" Bins 5 Rings and 4.00" Bins 4 Rings
- 2.66" Bins 6 Rings
- 2.66" Bins 7 Rings and 4.00" Bins 5 Rings
- 2.66" Bins 8 Rings and 4.00" Bins 6 Rings
- 2.66" Bins 9 Rings
- 4.00" Bins 7 Rings
- 2.66" Bins 10 Rings
- 2.66" Bins 11 Rings and 4.00" Bins 8 Rings
- 2.66" Bins 12 Rings
- 4.00" Bins 9 Rings

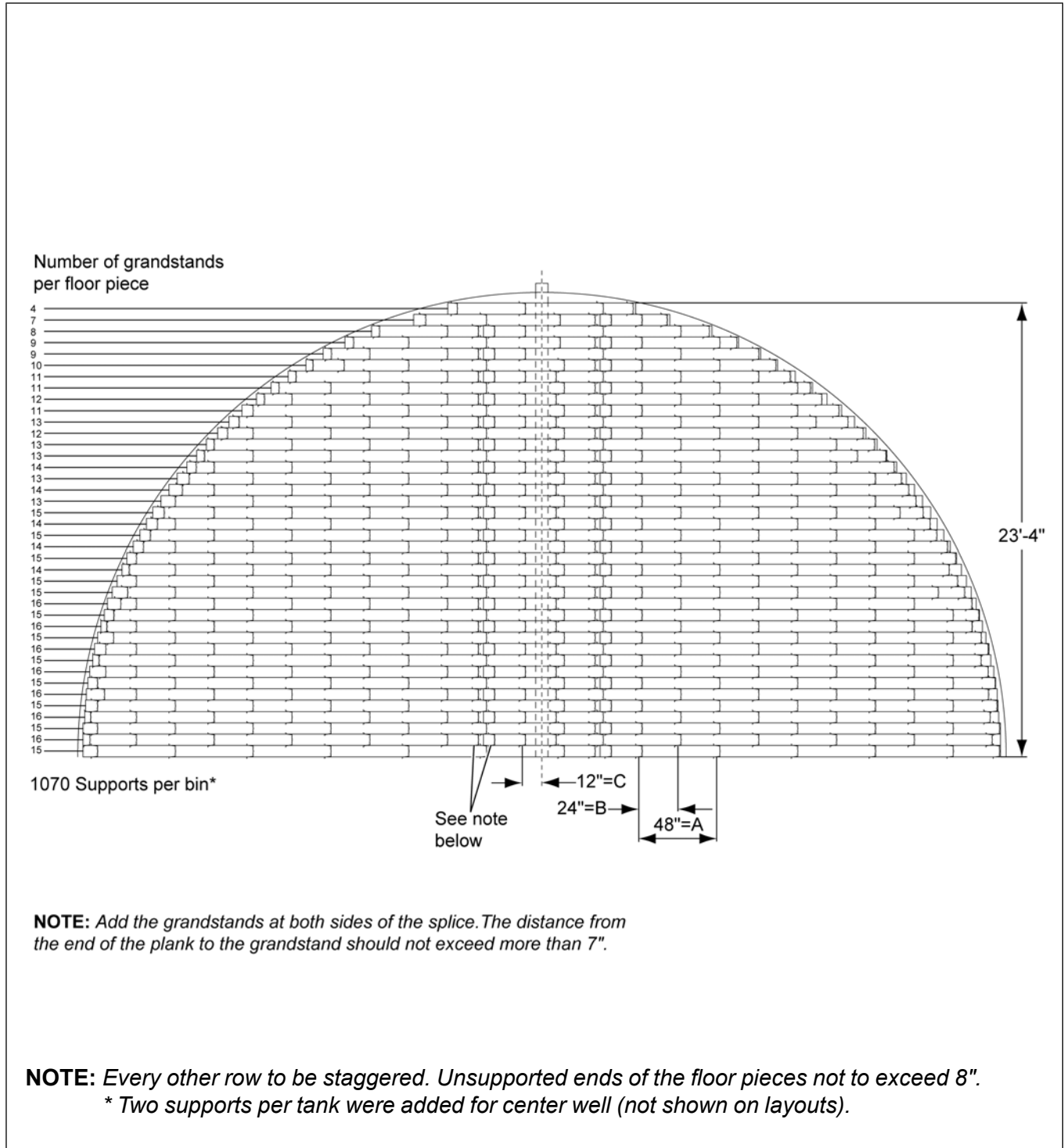
2.66" Bins 5 Rings and 4.00" Bins 4 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-1 2.66" bins 5 rings and 4.00" bins 4 rings



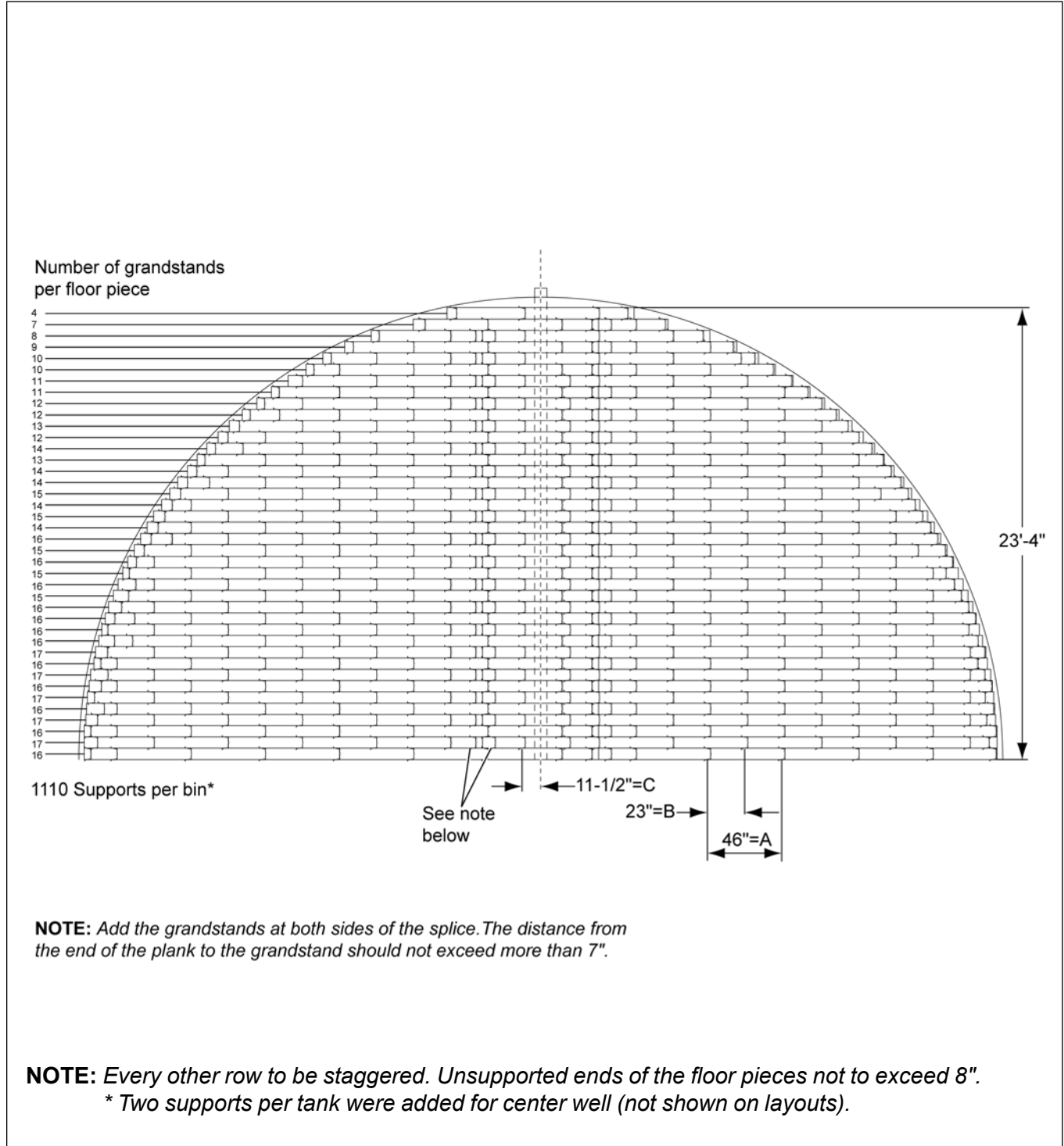
2.66" Bins 6 Rings



Support all center wells to concrete.

IMPORTANT: *The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.*

Figure 9-2 2.66" bins 6 rings



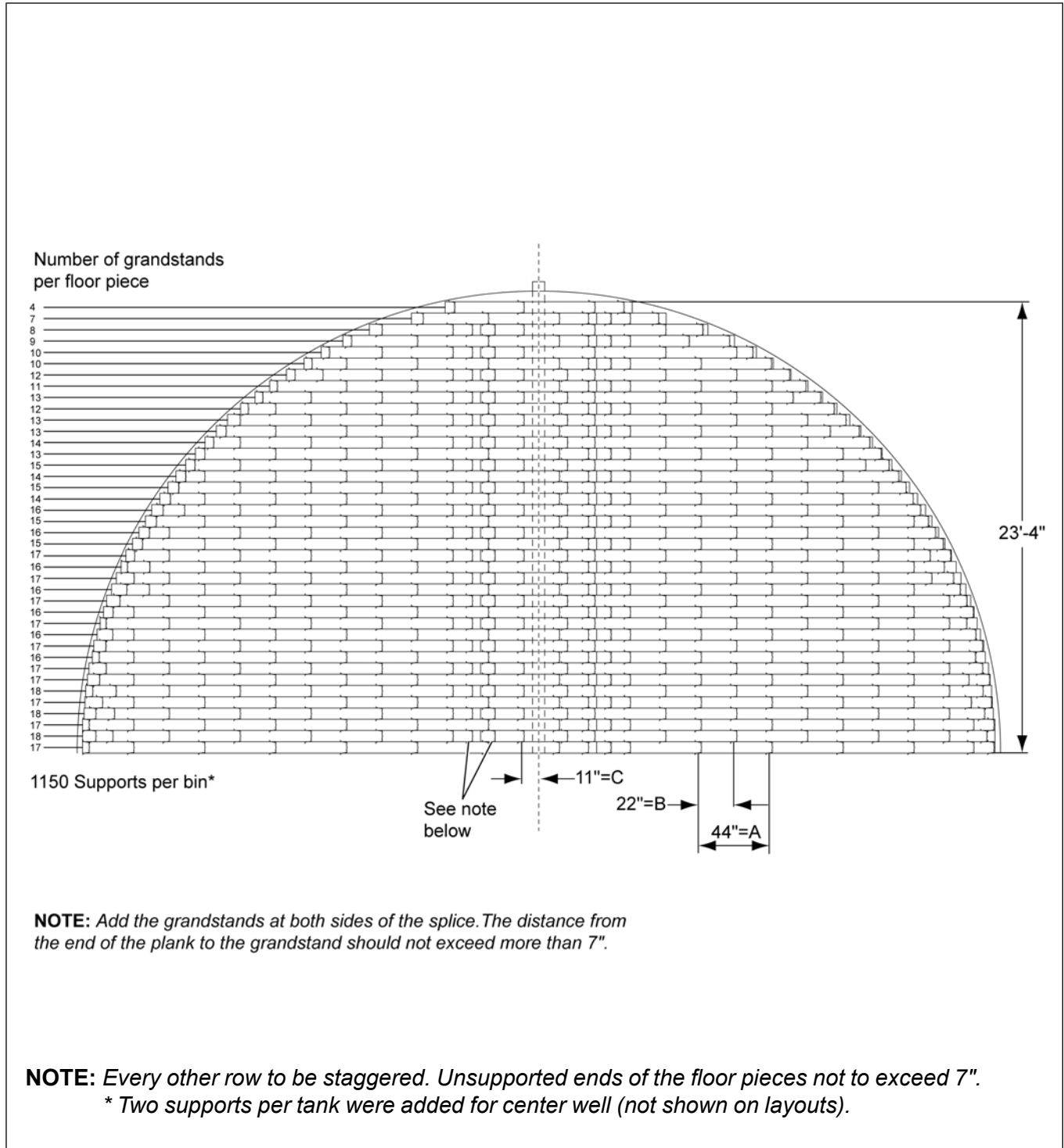
2.66" Bins 7 Rings and 4.00" Bins 5 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-3 2.66" bins 7 rings and 4.00" bins 5 rings



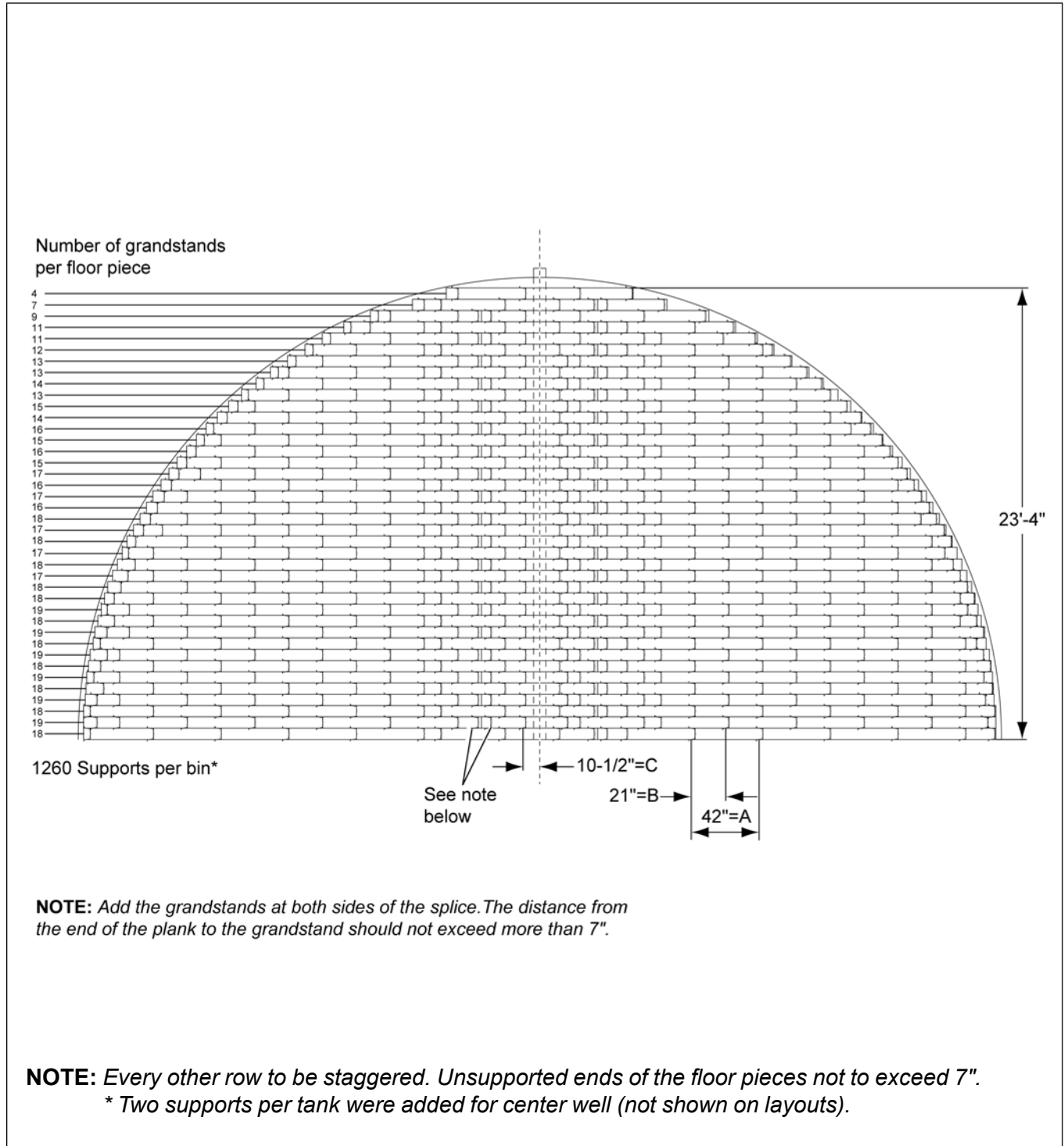
2.66" Bins 8 Rings and 4.00" Bins 6 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-4 2.66" bins 8 rings and 4.00" bins 6 rings



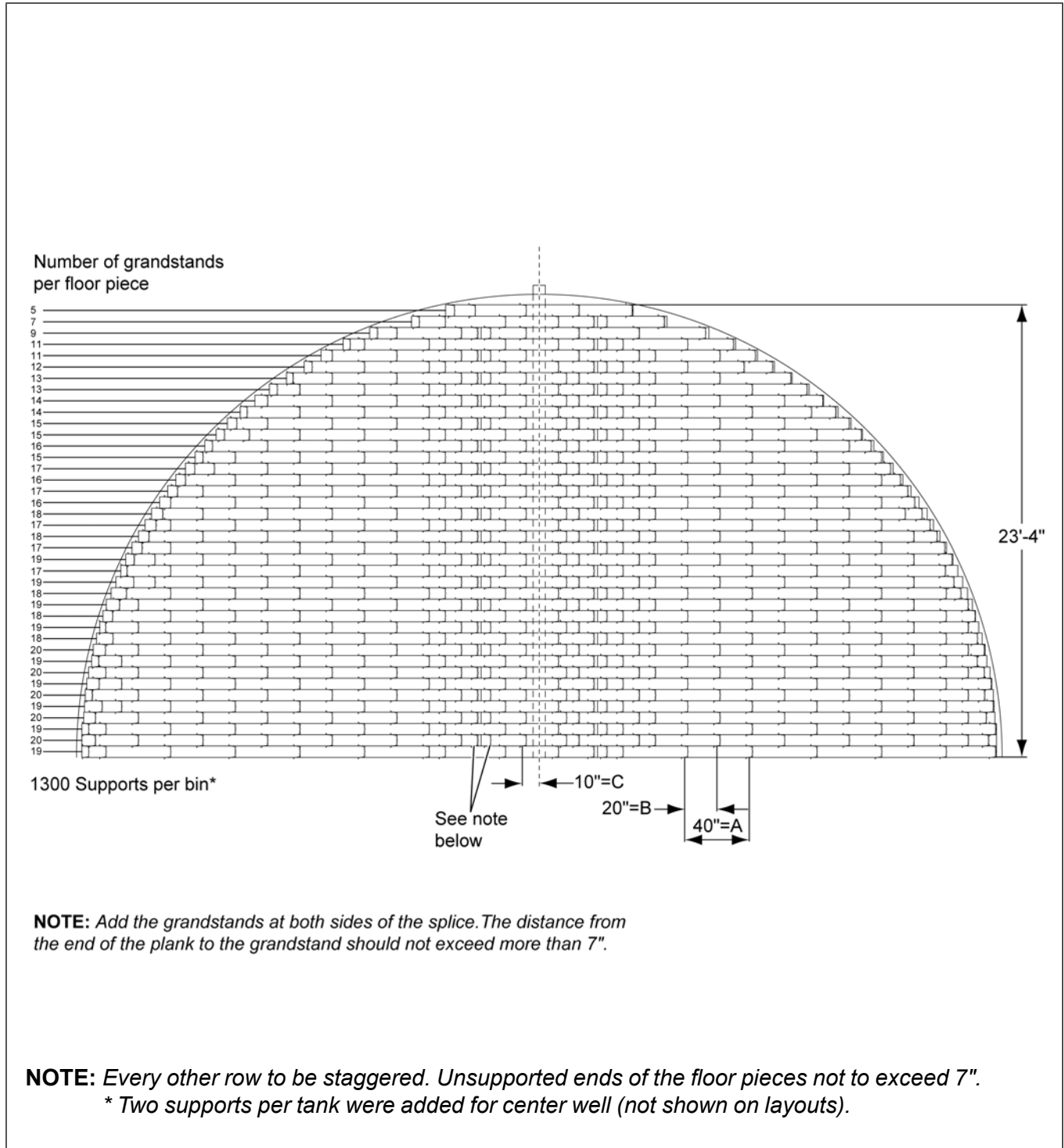
2.66" Bins 9 Rings



Support all center wells to concrete.

IMPORTANT: *The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.*

Figure 9-5 2.66" bins 9 rings



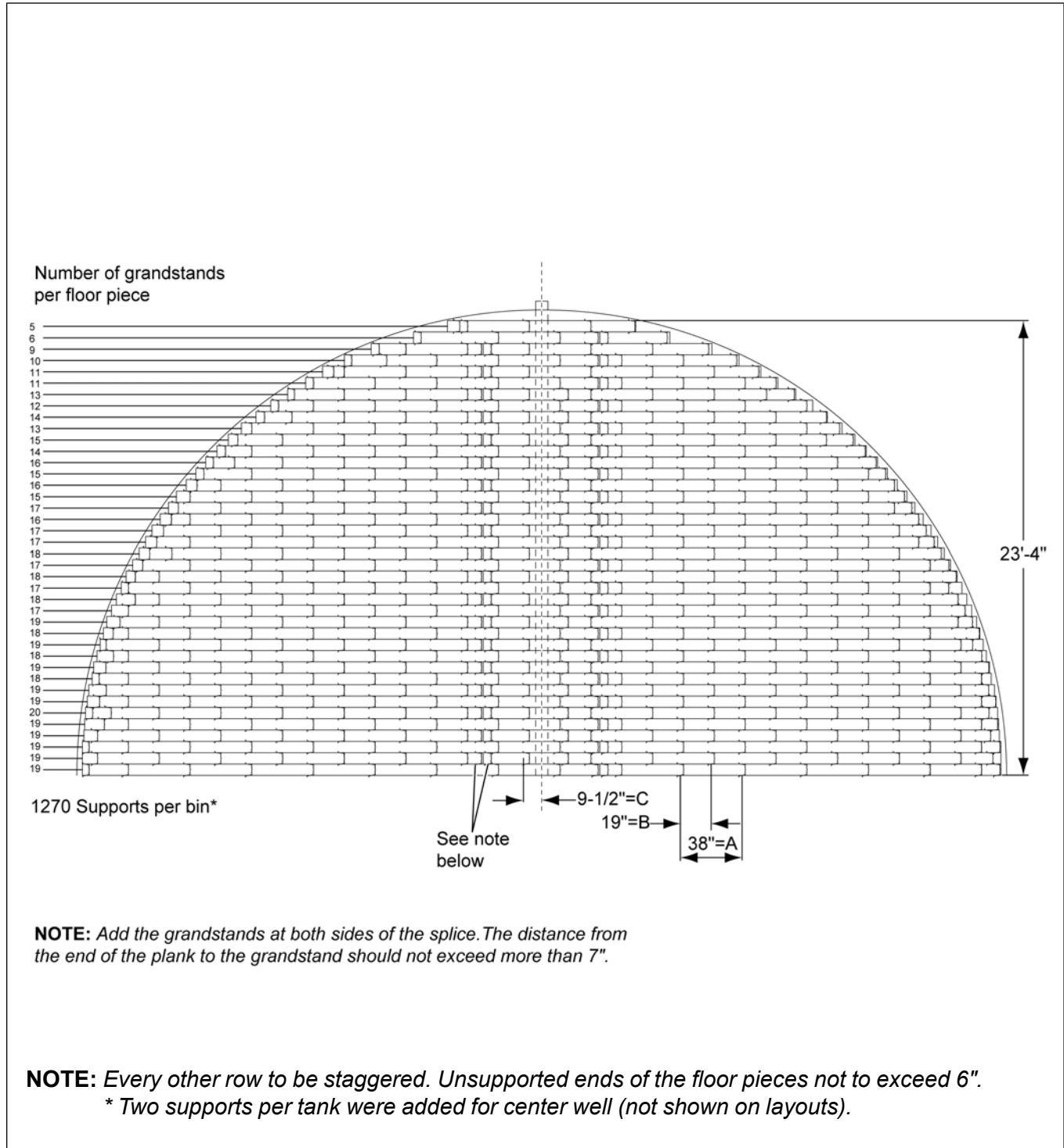
4.00" Bins 7 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-6 4.00" bins 7 rings



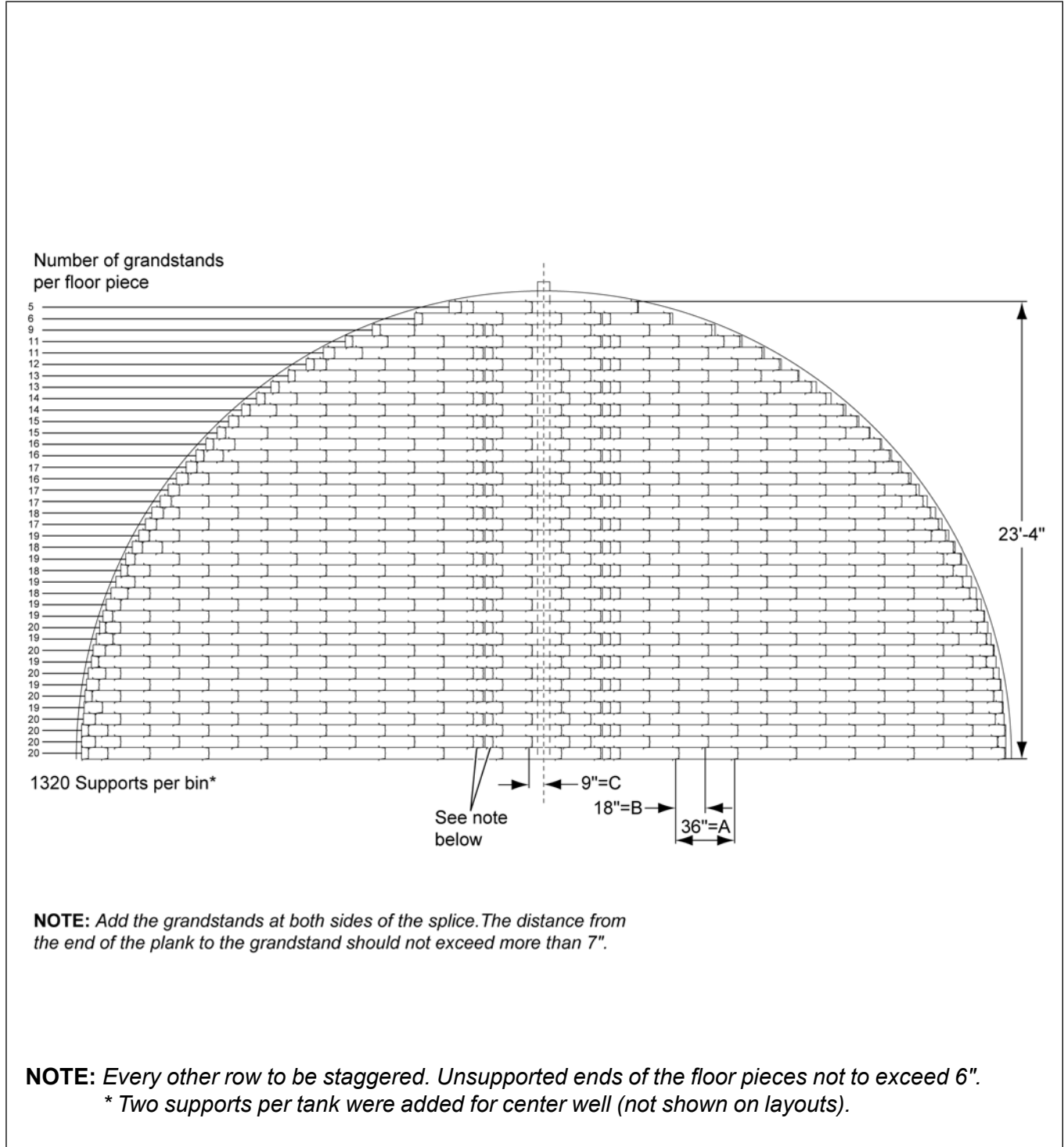
2.66" Bins 10 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-7 2.66" bins 10 rings



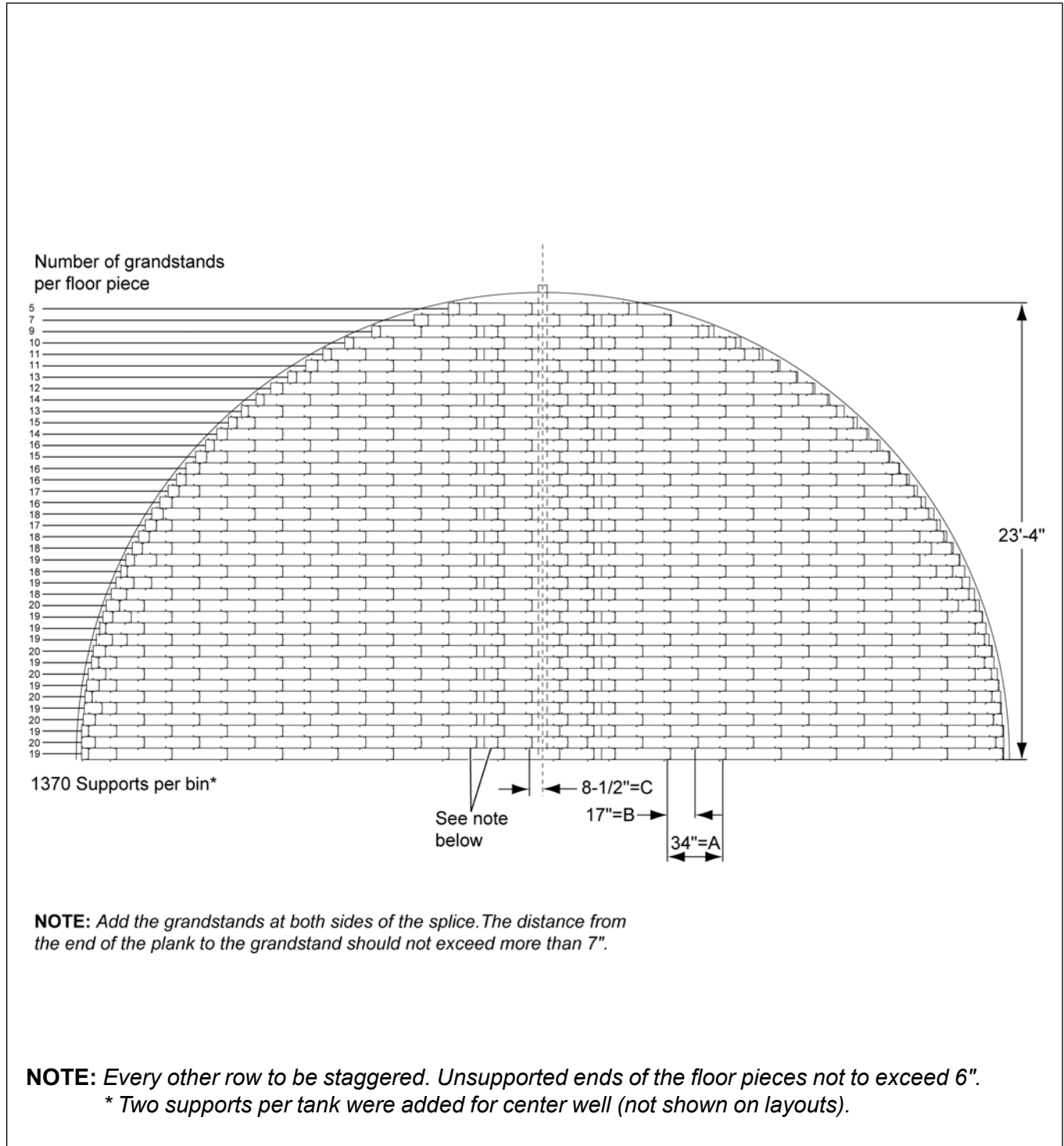
2.66" Bins 11 Rings and 4.00" Bins 8 Rings



Support all center wells to concrete.

IMPORTANT: *The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.*

Figure 9-8 2.66" bins 11 rings and 4.00" bins 8 rings



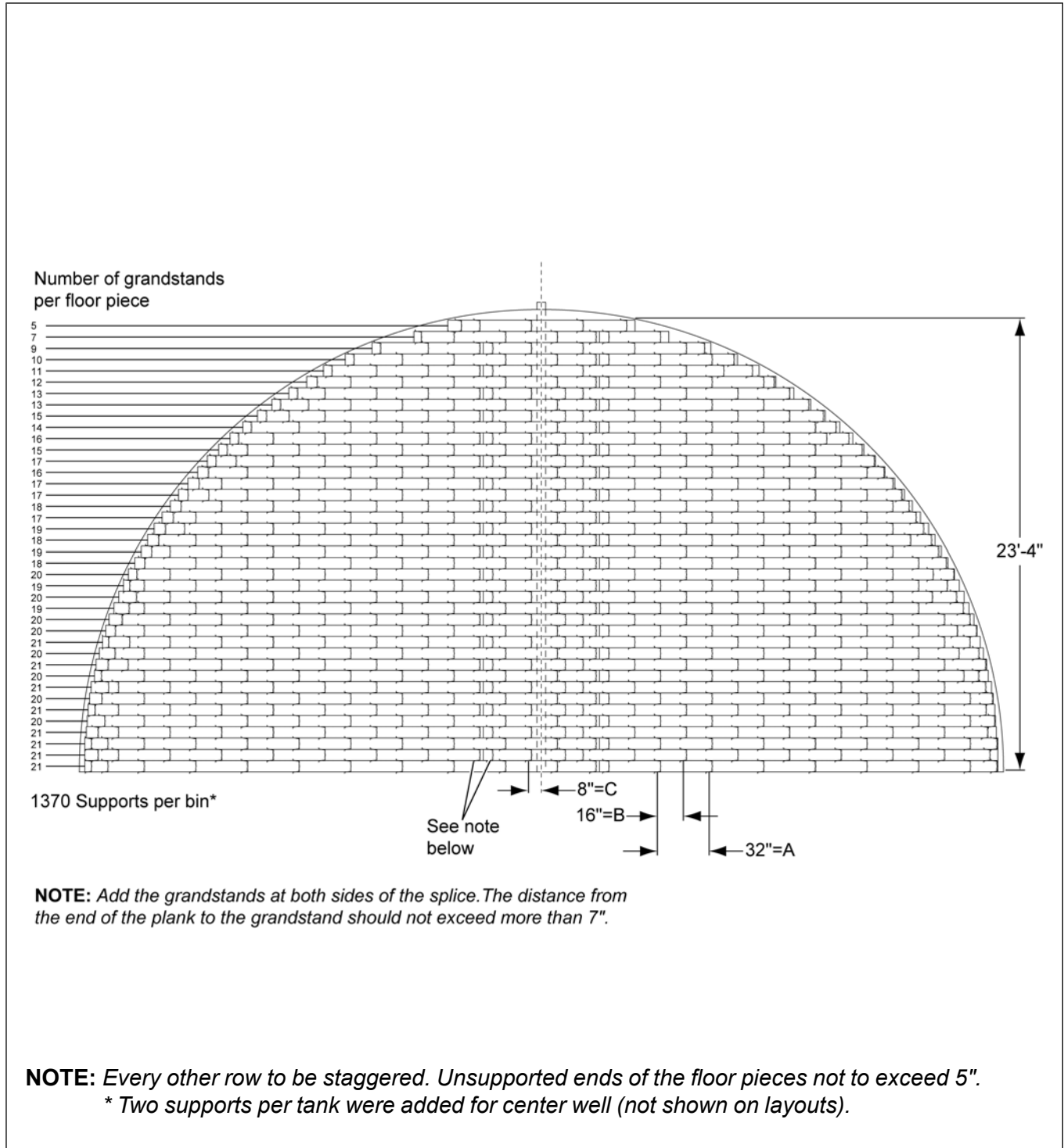
2.66" Bins 12 Rings



Support all center wells to concrete.

IMPORTANT: The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.

Figure 9-9 2.66" bins 12 rings



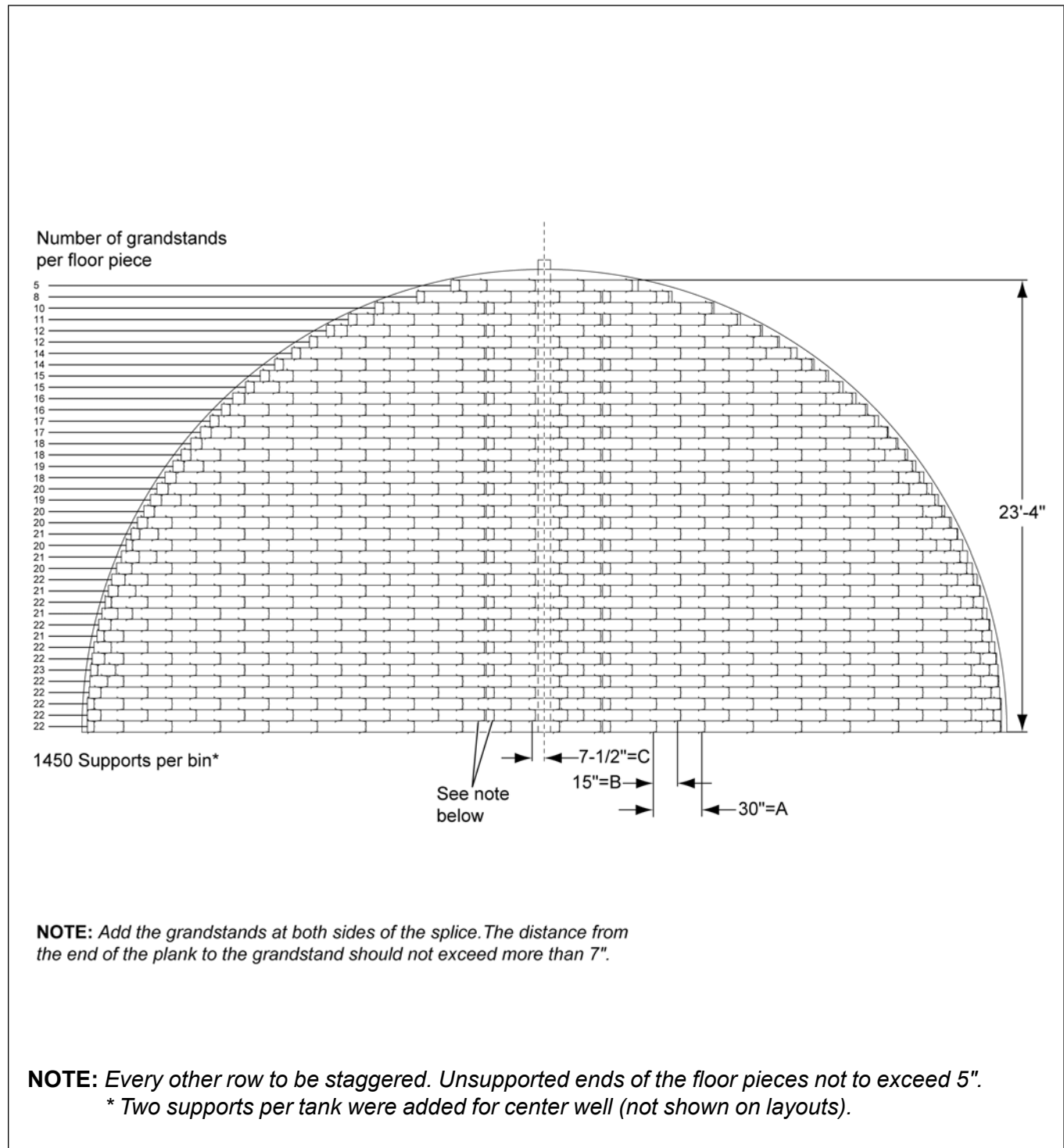
4.00" Bins 9 Rings



Support all center wells to concrete.

IMPORTANT: *The first piece of flooring must start at the proper distance from the center of the bin.
The first few pieces may have to be trimmed to fit correctly.*

Figure 9-10 4.00" bins 9 rings



NOTES

10 20 Gauge Floor Support Requirements

Topics Covered in this Chapter

- 2.66" Corrugation Grandstand Chart
- 4.00" Corrugation Grandstand Chart

2.66" Corrugation Grandstand Chart

Table 10-1 Narrow/2.66" corrugation - 20 gauge grandstand floor support chart

Full floor supports required for plank type flooring 2.66" corrugation (* Based upon 13-1/2" or taller floor heights)																				
Dia.	12'	15'	18'	21'	24'	27'	30'	33'	36'	39'	42'	45'	48'	54'	60'	72'	75'	78'	90'	105'
Rings																				
3	57/27 62																			
4	54/27 62	58/29 80	54/27 120																	
5	54/27 62	58/29 80	54/27 120	52/26 160	56/28 205	54/27 249	54/27 304	50/25 390	50/25 470	50/25 576										
6	54/27 62	54/27 88	54/27 120	52/26 160	52/26 215	48/24 275	48/24 347	50/25 390	48/24 487	48/24 586	48/24 695	48/24 806	48/24 909	44/22 1196	44/22 1430					
7	54/27 62	52/26 96	48/24 138	50/25 168	48/24 225	48/24 275	48/24 347	46/23 425	44/22 523	46/23 606	44/22 735	44/22 836	44/22 933	42/21 1236	42/21 1477					
8	48/24 70	48/24 100	48/24 144	46/23 182	46/23 230	46/23 300	44/22 363	44/22 435	44/22 523	44/22 624	42/21 750	42/21 866	42/21 977	40/20 1296	40/20 1544					
9	48/24 70	48/24 100	42/21 144	42/21 190	42/21 243	44/22 303	42/21 387	42/21 465	40/20 565	40/20 656	40/20 790	40/20 906	40/20 1019	38/19 1346	36/18 1697					
10	42/21 75	42/21 110	42/21 144	42/21 190	42/21 250	42/21 309	40/20 397	40/20 479	38/19 597	38/19 716	38/19 820	36/18 986	36/18 1109	34/17 1486	34/17 1779					
11	42/21 75	42/21 110	42/21 144	40/20 190	40/20 265	38/19 319	36/18 417	36/18 525	36/18 620	34/17 746	34/17 900	32/16 1036	32/16 1163	30/15 1566	30/15 1883					
12	38/19 80	40/20 115	40/20 154	40/20 202	38/19 280	38/19 345	36/18 441	34/17 550	34/17 659	34/17 786	32/16 950	32/16 1096	32/16 1230	30/15 1660	30/15 1993	26/13 3300	26/13 3580	26/13 3870	24/12 5520	22/11 8110
13	38/19 80	38/19 120	38/19 166	36/18 220	36/18 290	36/18 360	34/17 470	32/16 600	32/16 710	30/15 880	30/15 1010	30/15 1160	28/14 1390	28/14 1760	26/13 2300	24/12 3540	24/12 3840	24/12 4150	22/11 5960	20/10 8820
14	34/17 90	34/17 130	34/17 180	34/17 230	34/17 300	34/17 380	32/16 500	30/15 630	30/15 750	28/14 930	28/14 1070	26/13 1310	26/13 1480	24/12 1870	24/12 2460	22/11 3820	22/11 4410	22/11 4480	20/10 6480	18/9 9680
15	32/16 95	32/16 140	32/16 190	32/16 250	32/16 320	32/16 400	30/15 520	28/14 670	28/14 790	26/13 990	26/13 1140	24/12 1400	24/12 1590	24/12 2000	22/11 2650	22/11 3200	20/10 4500	20/10 4870	18/9 7120	18/9 9680
16	30/15 100	30/15 150	30/15 205	30/15 260	28/14 360	28/14 450	28/14 550	26/13 670	26/13 840	24/12 1060	24/12 1220	24/12 1400	22/11 1710	22/11 2160	20/10 2880	20/10 4150	20/10 4500	18/9 5340	18/9 7120	16/8 10760
17	28/14 106	28/14 160	28/14 215	26/13 290	26/13 380	26/13 480	26/13 590	24/12 710	24/12 900	22/11 1060	22/11 1320	22/11 1510	20/10 1860	20/10 2350	20/10 2880	18/9 4550	18/9 4950	18/9 5340	16/8 7910	16/8 10760
18	26/13 110	26/13 170	24/12 240	24/12 310	24/12 400	24/12 510	24/12 630	24/12 760	22/11 900	22/11 1140	22/11 1320	20/10 1640	20/10 1860	18/9 2570	18/9 3170	16/8 5060	16/8 5500	16/8 5940	16/8 7910	14/7 12150
19	24/12 180	24/12 240	22/11 340	22/11 440	22/11 550	22/11 680	22/11 820	22/11 970	20/10 1140	20/10 1430	20/10 1640	18/9 2040	18/9 2570	16/8 3520	16/8 4500	16/8 5060	16/8 5500	16/8 5940	14/7 8920	14/7 12150
20	22/11 190	22/11 260	22/11 340	22/11 440	22/11 550	20/10 740	20/10 890	20/10 1060	20/10 1240	20/10 1430	18/9 1800	18/9 2040	16/8 2860	16/8 3520	16/8 4500	14/7 5710	14/7 6200	14/7 6710	12/6 8920	12/6 13990
21				20/10 370	20/10 470	20/10 740	20/10 890	20/10 1060	20/10 1240	18/9 1570	18/9 1800	16/8 2270	16/8 2860	14/7 3970	14/7 5710	14/7 6200	14/7 6710	14/7 7140	12/6 10280	12/6 13990
22				18/9 400	18/9 520	18/9 660	18/9 810	18/9 970	18/9 1160	16/8 1360	16/8 1570	16/8 2000	16/8 2270	14/7 2860	14/7 3970	12/6 6580	12/6 7140	12/6 7730	12/6 10280	
23				18/9 400	18/9 520	16/8 730	16/8 900	16/8 1080	16/8 1290	16/8 1510	16/8 1740	16/8 2000	16/8 2270	14/7 3230	14/7 3970	12/6 6580	12/6 7140	12/6 7730		
24				16/8 450	16/8 580	16/8 730	16/8 900	16/8 1080	16/8 1290	16/8 1510	16/8 1740	16/8 2000	14/7 2560	14/7 3230	12/6 4570	12/6 6580	12/6 7140			
25				14/7 500	14/7 650	14/7 820	14/7 1010	14/7 1220	14/7 1450	14/7 1700	14/7 1960	14/7 2260	14/7 2560	12/6 3230	12/6 4570					
26								14/7 820	14/7 1010	14/7 1220	14/7 1450	14/7 1700	14/7 1960	12/6 2560	12/6 3230					
27								12/6 950	12/6 1160	12/6 1410	12/6 1670	12/6 1960	12/6 2260	12/6 2600	12/6 2950					
28								12/6 950	12/6 1160	12/6 1410	12/6 1670	12/6 1960	12/6 2260	12/6 2600	12/6 2950					
29								12/6 950	12/6 1160	12/6 1410	12/6 1670	12/6 1960								

* For Aeration Systems recessed in the concrete, add one ring for proper spacing.

When using FL-3102-3 or FL-3102-6 (3", 6") Grandstands, increase the listed quantities by 33% (Standard quantity x 1.33).

Quantities of Grandstands are minimum required for installation - Due to varying conditions and construction techniques at floor and wall penetrations, additional supports may need to be ordered.

How to read the chart: For example, a 12' diameter bin with 7 rings would have spacing of 54/27 (the top numbers). Meaning A=54" and B=27". The number of supports needed would be 62, (the bottom number).

4.00" Corrugation Grandstand Chart

Table 10-2 Wide/4.00" corrugation - 20 gauge grandstand floor support chart

Full floor supports required for plank type flooring 4.00" corrugation (* Based upon 13-1/2" or taller floor heights)																					
Dia.	12'	15'	18'	21'	24'	27'	30'	33'	36'	39'	42'	45'	48'	54'	60'	72'	75'	78'	90'	105'	
Rings	Support spacing support quantity																				
3	54/27 62	58/29 80	54/27 120	52/26 150	56/28 202	54/27 249	50/25 333	50/25 390	50/25 470	50/25 576	46/23 695	52/26 735	48/24 869								
4	54/27 62	54/27 88	54/27 120	52/26 160	52/26 214	48/24 275	50/25 333	50/25 390	50/25 470	50/25 576	46/23 695	48/24 775	48/24 869	46/23 1156	44/22 1430						
5	54/27 62	52/26 96	48/24 138	50/25 168	48/24 224	48/24 275	48/24 347	46/23 425	44/22 523	46/23 606	46/23 695	44/22 836	44/22 933	42/21 1236	42/21 1477						
6	48/24 70	48/24 100	48/24 138	46/23 182	46/23 230	44/22 303	44/22 363	44/22 435	44/22 523	42/21 656	42/21 751	42/21 866	42/21 977	40/20 1296	38/19 1650						
7	42/21 75	42/21 110	42/21 144	42/21 190	42/21 249	42/21 309	42/21 387	40/20 480	40/20 565	40/20 686	38/19 821	38/19 946	38/19 1057	36/18 1416	34/17 1779						
8	42/21 75	42/21 110	42/21 144	42/21 190	40/20 265	40/20 319	38/19 417	36/18 525	36/18 620	36/18 746	34/17 900	34/17 1036	34/17 1163	32/16 1566	32/16 1883	28/15 3550	18 Gauge Cor-Lok or Cut-Lok if diameter and number of rings are in shaded area.				
9	38/19 80	40/20 115	38/19 166	38/19 220	38/19 277	36/18 355	34/17 471	34/17 555	32/16 695	32/16 830	32/16 951	30/15 1156	30/15 1303	30/15 1660	28/14 2160	28/15 3550	24/12 3850	24/12 4160	24/12 5970	20/10 8820	
10	36/18 90	34/17 130	34/17 180	34/17 230	34/17 300	34/17 380	32/16 500	32/16 600	30/15 750	28/14 930	30/15 1010	28/14 1230	28/14 1390	26/13 1870	24/12 2460	22/11 3820	22/11 4150	22/11 4480	20/10 6480	18/9 9680	
11	32/16 95	30/15 150	32/16 190	32/16 250	32/16 320	32/16 400	30/15 520	30/15 650	28/14 790	26/13 990	26/13 1140	24/12 1400	24/12 1590	24/12 2000	22/11 2650	20/10 4150	20/10 4500	20/10 4870	18/9 7120	16/8 10760	
12	28/14 100	28/14 160	28/14 210	28/14 280	28/14 360	28/14 450	28/14 550	28/14 670	26/13 840	24/12 1060	24/12 1220	22/11 1510	22/11 1710	20/10 2350	20/10 2880	18/9 4550	18/9 4950	18/9 5340	16/8 7910	16/8 10760	
13	26/13 110	26/13 170	26/13 220	26/13 290	24/12 400	24/12 510	24/12 630	24/12 760	24/12 900	22/11 1140	22/11 1320	20/10 1640	20/10 1860	18/9 2570	18/9 3170	16/8 5060	16/8 5500	16/8 5940	16/8 7910	14/7 12150	
14			22/11 260	22/11 340	22/11 440	22/11 550	22/11 680	22/11 820	20/10 1060	20/10 1240	20/10 1430	18/9 1800	18/9 2040	16/8 2860	16/8 3520	16/8 5060	16/8 5500	16/8 5940	14/7 8920	14/7 12150	
15				20/10 370	20/10 480	20/10 600	20/10 740	20/10 890	20/10 1060	18/9 1360	18/9 1570	18/9 1800	16/8 2270	16/8 2860	16/8 3520	14/7 5710	14/7 6200	14/7 6710	14/7 8920	12/6 13990	
16				18/9 400	18/9 520	18/9 660	18/9 810	18/9 970	18/9 1160	18/9 1360	18/9 1570	16/8 2000	16/8 2270	16/8 2860	14/7 3970	12/6 6580	12/6 7140	12/6 7730	12/6 10280		
17					16/8 580	16/8 730	16/8 900	16/8 1080	16/8 1290	16/8 1510	16/8 1750	16/8 2000	16/8 2270	14/7 3230	14/7 3970	12/6 6580	12/6 7140	12/6 7730			
18					16/8 580	16/8 730	16/8 900	16/8 1080	16/8 1290	16/8 1510	16/8 1750	16/8 2000	14/7 2560	14/7 3230	12/6 4570	Support spacing support quantity					
19							14/7 820	14/7 1010	14/7 1220	14/7 1450	14/7 1700	14/7 1970	14/7 2260	12/6 3720	12/6 4570						
20							12/6 950	12/6 1160	12/6 1410	12/6 1670	12/6 1960	12/6 2270	12/6 2600	12/6 2950	12/6 3720						
21							12/6 950	12/6 1160	12/6 1410	12/6 1670	12/6 1960	12/6 2270	12/6 2600	12/6 2950							

* For Aeration Systems recessed in the concrete, add one ring for proper spacing.

When using FL-3102-3 or FL-3102-6 (3", 6") Grandstands, increase the listed quantities by 33% (Standard quantity x 1.33).

Quantities of Grandstands are minimum required for installation - Due to varying conditions and construction techniques at floor and wall penetrations, additional supports may need to be ordered.

Floor styles in order of increasing strength are 18 gauge Cor-Lok, Cut-Lok and Dura-Lok.

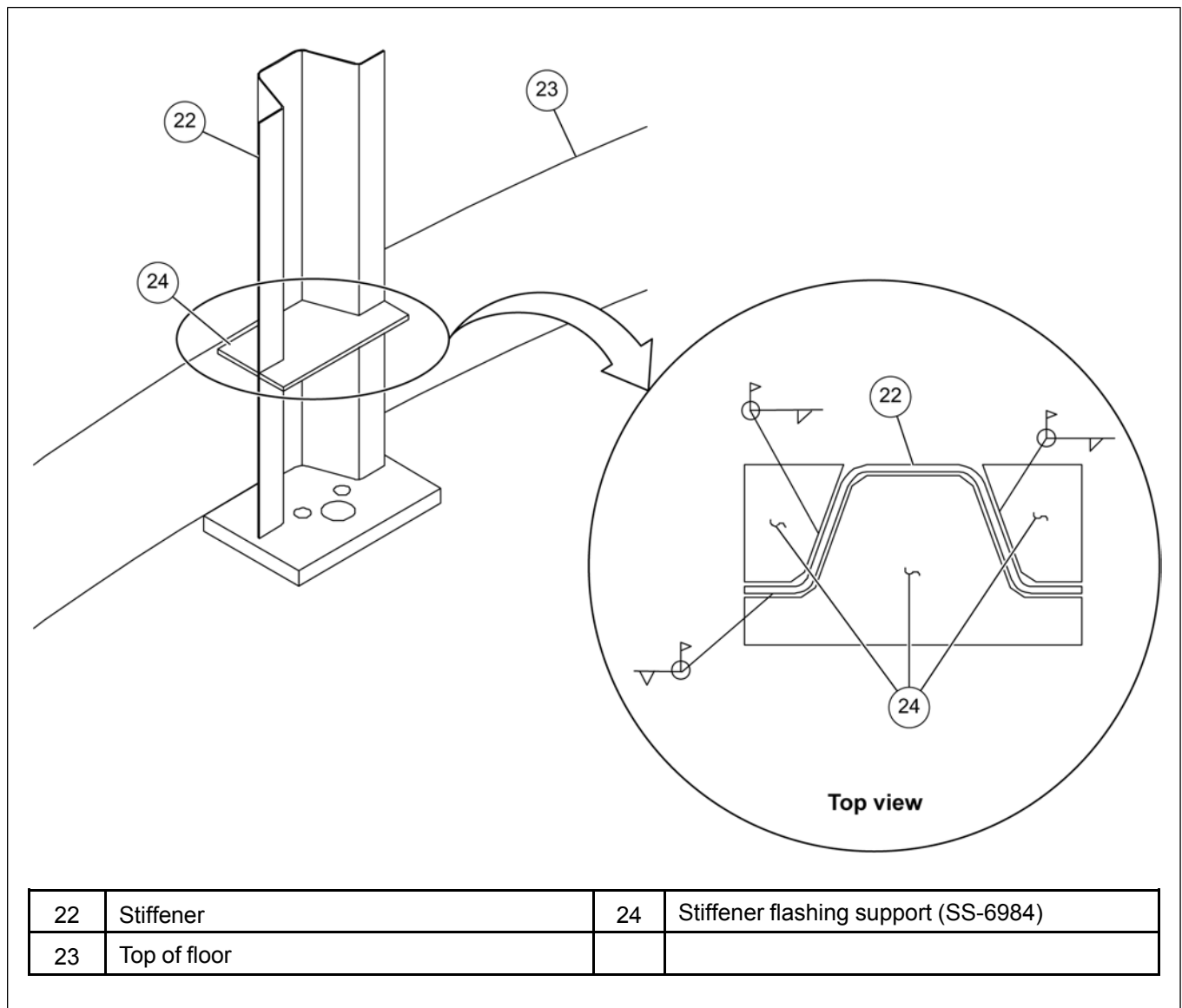
How to read the chart: For example, a 12' diameter bin with 5 rings would have spacing of 54/27 (the top numbers). Meaning A=54" and B=27". The number of supports needed would be 62, (the bottom number).

NOTES

11 Installing the Stiffener Flashing Support

1. Install the floor and support system, cutting the floor to go around the internal stiffeners as required.
2. Break the stiffener flashing support (24) into its three components.
3. Lay the stiffener flashing supports (24) on top of the flooring (23) and weld the flashing supports (24) to the stiffener (22) as close as possible. Fasten the flashing to the wall, flashing support (24) and floor. Seal all spaces by welding or caulking.
4. Paint all welds with good quality zinc rich paint.
5. Stiffener flashing supports (24) must be ordered separately from the standard floor and flashing.

Figure 11-1 Internal universal stiffeners



NOTES

12 Installing the Air Flow Supports

1. Determine the spacing and quantity of air flow supports required from the [Table 12-1, page 57](#). Make sure that the correct supports have been ordered for use with the proper depth of plank (either 1-1/8" or 1-3/8" deep).
2. Mark the center of the bin.
3. Install the discharge auger.
4. Mark the spacing lines parallel to the discharge auger.
5. Start on the side of the bin opposite from the discharge auger and place the first two rows of supports on the spacing lines.

NOTE: *The air flow supports are installed at an angle in an overlapping pattern, so the ends will overlap. Refer to the [Figure 12-2, page 58](#) for floor layouts.*

6. Install the channel lock flooring on the first two rows of supports and secure in place with sidewall flashing.
7. Finish placing supports on the spacing lines and installing the floor planks.
 - a. Single supports are used next to the sidewall and at the ends of split floor planks in order to maintain the floor manufacturer's recommended minimum distance from the end of a plank to a support.
 - b. Double supports are used at the sump and along the sides of the discharge auger for spacing of 16" or less and for recirculating bin equipment.
 - c. Full supports may have to be overlapped or angled to provide support at walls and to maintain spacing and flashing requirements.

Figure 12-1 Methods of support placement

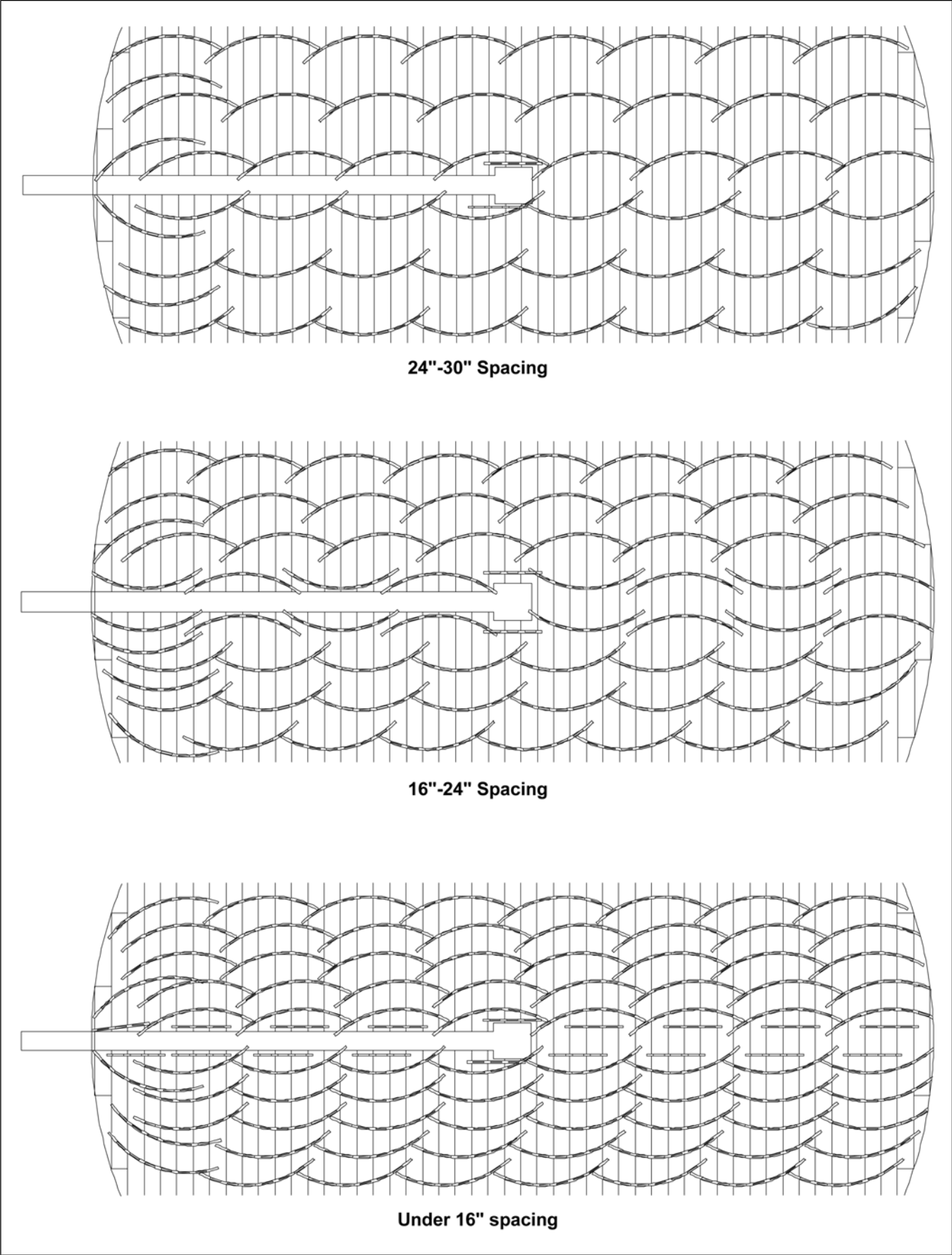


Table 12-1 * Installation, spacing and quantities of air flow supports under channel lock floors

Bin diameter - Number of supports																
Grain depth at sidewall	Spacing	18' diameter			21' diameter			24' diameter			27' diameter			30' diameter		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	34	2	8	48	2	10	60	2	12	84	2	14	88	2	14
24'	26"	36	2	8	56	2	10	74	2	12	92	2	14	104	2	14
27'	24"	44	2	8	62	2	10	76	2	12	92	2	14	112	2	14
32'	20"	54	2	10	64	2	12	84	2	14	106	2	16	130	2	18
40'	16"	58	10	14	80	12	16	104	14	18	128	16	20	160	18	22
48'	13"	72	10	16	98	12	20	126	14	22	158	16	24	190	18	28
53'	12"	76	10	18	106	12	22	140	14	24	172	16	28	210	18	30
68'	10"	86	10	22	116	12	26	156	14	28	212	16	32	250	18	36
16'	24" and 12"	68	10	8	82	12	10	104	14	12	120	16	14	140	18	14

(for grain flow)

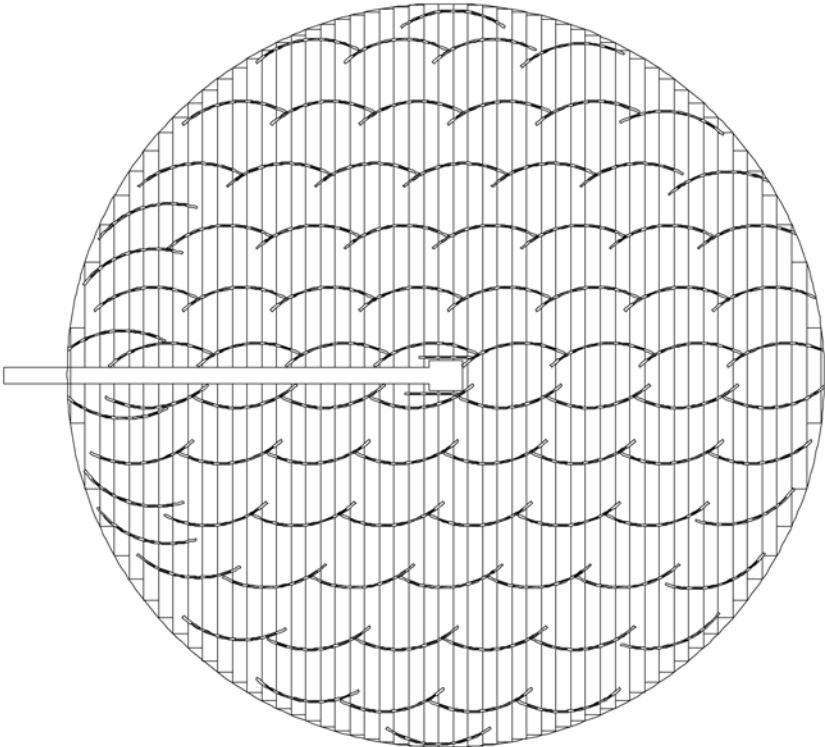
Bin diameter - Number of supports																
Grain depth at sidewall	Spacing	33' diameter			36' diameter			42' diameter			48' diameter			60' diameter		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	116	2	16	136	2	18	172	2	20	Use 24" spacing			Use 24" spacing		
24'	26"	124	2	16	144	2	18	200	2	20	Use 24" spacing			Use 24" spacing		
27'	24"	136	2	16	154	2	18	212	2	20	274	2	22	422	2	30
32'	20"	150	2	20	184	2	22	242	2	26	326	2	28	498	2	36
40'	16"	192	20	24	234	22	28	314	24	32	410	28	36	620	34	46
48'	13"	238	20	30	278	22	34	368	24	38	488	28	44	762	34	56
53'	12"	262	20	34	306	22	36	416	24	42	534	28	48	838	34	60
68'	10"	296	20	40	356	22	44	478	24	50	652	28	58	1024	34	72
16'	24" and 12"	168	20	16	188	20	18	264	24	20	350	28	20	N/A	N/A	N/A

(for grain flow)

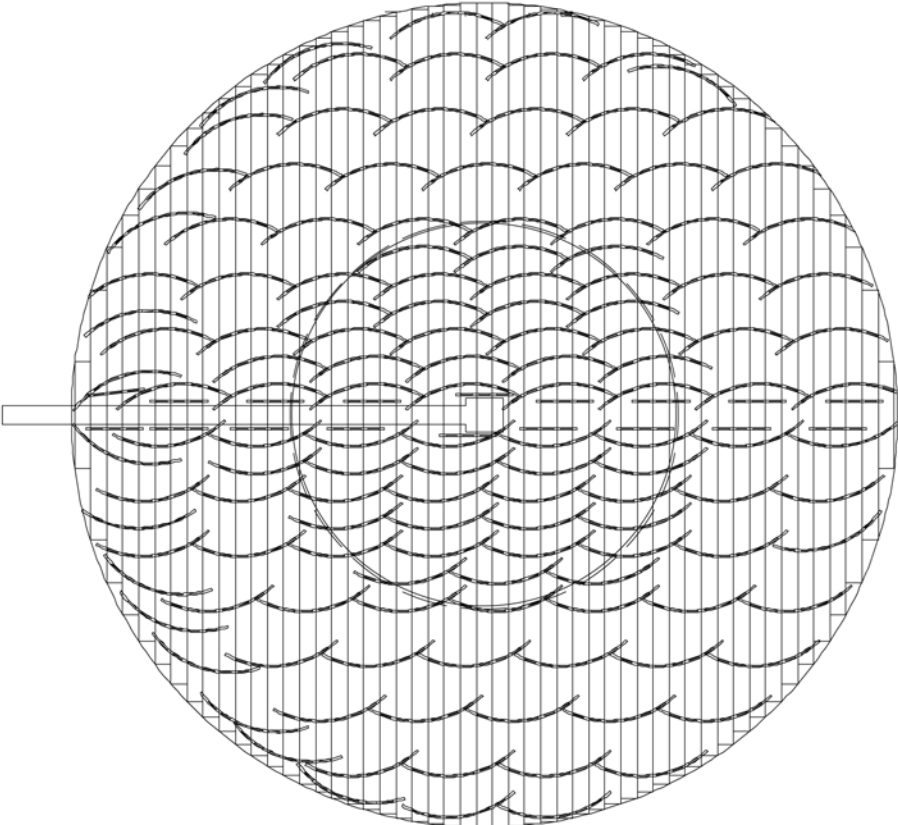
NOTE:

1. Use a maximum spacing of 16" for perforated corrugated flooring.
2. The number of supports listed is based on the maximum peaked capacity of each bin.
3. Use extra single supports for the split floors.
4. Extra supports are required for grain recirculating equipment. Use the manufacturer's recommendation for the number and spacing of extra supports.
 - For grain flows, air flow supports are doubled in a 14' diameter in the center of the floor.
5. Contact a representative for air flow supports required for larger bins and deeper grain depths.
6. * Increase the number of supports by 5% when used with 6-3/4" wide MFS floor planks.

Figure 12-2 Floor layouts



Example showing 30" spacing



Example showing 24" spacing with supports doubled (12" spacing) in the center of recirculating equipment.

Chapter 12: Installing the Air Flow Supports

Table 12-2 Installation, spacing and quantities of air flow supports under channel lock floors york and chief bins

Bin diameter - Number of supports																
Grain depth at sidewall	Spacing	15'-6"			18'-7"			21'-8"			24'-9"			27'-10"		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	26	2	8	36	2	8	50	2	10	64	2	12	80	2	14
24'	26"	30	2	8	42	2	8	56	2	10	74	2	12	92	2	14
27'	24"	32	2	8	44	2	8	60	2	10	78	2	12	98	2	14
32'	20"	38	2	10	52	2	10	72	2	12	92	2	14	116	2	16
40'	16"	46	10	14	64	12	14	86	14	16	114	14	18	142	16	20
48'	13"	54	10	16	78	12	16	106	14	20	136	14	22	172	16	24
53'	12"	58	10	18	84	12	18	114	14	22	148	14	24	184	16	28
68'	10"	70	10	22	98	12	22	134	14	26	174	14	28	220	16	32
16'	24" and 12"	60	10	8	72	12	8	88	14	10	106	14	12	126	16	14

(for grain flow)

Bin diameter - Number of supports																
Grain depth at sidewall	Spacing	31'			34'			37'-1"			40'-3"			43'-4"		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	98	2	14	116	2	16	136	2	18	160	2	20	182	2	22
24'	26"	112	2	14	132	2	16	154	2	18	182	2	20	208	2	22
27'	24"	120	2	14	142	2	16	166	2	18	196	2	20	224	2	22
32'	20"	140	2	18	168	2	20	198	2	22	232	2	26	260	2	26
40'	16"	174	18	22	208	20	24	244	22	28	286	24	32	330	26	32
48'	13"	210	18	28	252	20	30	298	22	34	350	24	38	402	26	38
53'	12"	228	18	30	272	20	34	316	22	36	378	24	42	434	26	42
68'	10"	270	18	36	324	20	40	384	22	44	450	24	50	520	26	50
16'	24" and 12"	148	18	14	170	20	16	194	22	18	224	24	20	252	26	22

(for grain flow)

Bin diameter - Number of supports										
Grain depth at sidewall	Spacing	49'-6"			55'-8"			61'-10"		
		Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	24"	288	2	28	362	2	32	444	2	36
24'	20"	346	2	28	436	2	32	536	2	36
27'	20"	346	2	28	436	2	32	536	2	36
32'	20"	346	2	28	436	2	32	536	2	36
40'	16"	428	28	36	540	32	42	664	36	46
48'	13"	524	28	44	660	32	52	812	36	56
53'	12"	566	28	48	714	32	54	878	36	60
68'	10"	676	28	58	852	32	68	1050	36	72

(for grain flow)

Chapter 12: Installing the Air Flow Supports

Table 12-3 Installation, spacing and quantities of air flow supports under channel lock floors behlen bins

Bin diameter - Number of supports													
Grain depth at sidewall	Spacing	16'-5"			19'-8"			22'-11"			26'-3"		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	30	2	8	42	2	10	56	2	12	70	2	14
24'	26"	32	2	8	46	2	10	64	2	12	80	2	14
27'	24"	36	2	8	50	2	10	68	2	12	86	2	14
32'	20"	42	2	10	60	2	12	80	2	14	102	2	16
40'	16"	50	10	14	72	12	16	98	14	18	124	16	20
48'	13"	60	10	16	88	12	20	118	14	22	152	16	24
53'	12"	66	10	18	94	12	22	126	14	24	164	16	28
68'	10"	78	10	22	110	12	26	150	14	28	194	16	32
16'	24" and 12"	64	10	8	78	12	10	96	14	12	114	16	14

(for grain flow)

Bin diameter - Number of supports													
Grain depth at sidewall	Spacing	29'-6"			36'-1"			42'-8"			49'-3"		
		Full	Double	Single	Full	Double	Single	Full	Double	Single	Full	Double	Single
18'	30"	90	2	14	130	2	18	178	2	20	286*	2	28
24'	26"	102	2	14	148	2	18	202	2	20	286*	2	28
27'	24"	108	2	14	160	2	18	218	2	20	344**	2	28
32'	20"	128	2	18	188	2	22	260	2	26	344	2	28
40'	16"	158	18	22	232	22	28	320	24	32	426	28	36
48'	13"	192	18	28	282	22	34	390	24	38	520	28	44
53'	12"	206	18	30	306	22	36	422	24	42	562	28	48
68'	10"	246	18	36	364	22	44	504	24	50	670	28	58
16'	24" and 12"	136	18	14	188	22	18	246	24	20	N/A	N/A	N/A

(for grain flow)

* Use 24" spacing

** Use 20" spacing

Limited Warranty — N.A. Grain Products

The GSI Group, LLC. (“GSI”) warrants products which it manufactures, to be free of defects in materials and workmanship under normal usage and conditions for a period of 12 months from the date of shipment (or, if shipped by vessel, 14 months from the date of arrival at the port of discharge). If, in GSI’s sole judgment, a product is found to have a defect in materials and/or workmanship, GSI will, at its own option and expense, repair or replace the product or refund the purchase price. This Limited Warranty is subject to extension and other terms as set forth below.

Warranty Enhancements: The warranty period for the following products is enhanced as shown below and is in lieu of (and not in addition to) the above stated warranty period. (Warranty Period is from date of shipment.)

	Product	Warranty Period
Storage	Grain Bin Structural Design • Sidewall, roof, doors, platforms and walkarounds • Flooring (when installed using GSI specified floor support system for that floor) • Hopper tanks (BFT, GHT, NCHT, and FCHT)	5 Years
Conditioning	Dryer Structural Design – (Tower, Portable and TopDry) • Includes (frame, portable dryer screens, ladders, access doors and platforms)	5 Years
	All other Dryer parts including: • Electrical (controls, sensors, switches and internal wiring)	2 Years
	All Non-PTO Driven Centrifugal and Axial Fans	3 Years
	Bullseye Controllers	2 Years
Material Handling	Bucket Elevators Structural Design	5 Years
	Towers Structural Design	5 Years
	Catwalks Structural Design	5 Years
	Accessories (stairs, ladders and platforms) Structural Design	5 Years

Conditions and Limitations:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH HEREIN; SPECIFICALLY, GSI DISCLAIMS ANY AND ALL OTHER WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) ANY PRODUCT MANUFACTURED OR SOLD BY GSI, OR (II) ANY ADVICE, INSTRUCTION, RECOMMENDATION OR SUGGESTION PROVIDED BY AN AGENT, REPRESENTATIVE OR EMPLOYEE OF GSI REGARDING OR RELATED TO THE CONFIGURATION, INSTALLATION, LAYOUT, SUITABILITY FOR A PARTICULAR PURPOSE, OR DESIGN OF SUCH PRODUCTS.

The sole and exclusive remedy for any claimant is set forth in this Limited Warranty and shall not exceed the amount paid for the product purchased. This Warranty only covers the value of the warranted parts and equipment, and does not cover labor charges for removing or installing defective parts, shipping charges with respect to such parts, any applicable sales or other taxes, or any other charges or expenses not specified in this Warranty. GSI shall not be liable for any other direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. Expenses incurred by or on behalf of a claimant without prior written authorization from the GSI warranty department shall not be reimbursed. This warranty is not transferable and applies only to the original end-user. GSI shall have no obligation or responsibility for any representations or warranties made by or on behalf of any dealer, agent or distributor. Prior to installation, the end-user bears all responsibility to comply with federal, state and local codes which apply to the location and installation of the products.

This Limited Warranty extends solely to products sold by GSI and does not cover any parts, components or materials used in conjunction with the product, that are not sold by GSI. GSI assumes no responsibility for claims resulting from construction defects, unauthorized modifications, corrosion or other cosmetic issues caused by storage, application or environmental conditions. Modifications to products not specifically delineated in the manual accompanying the product at initial sale will void all warranties. This Limited Warranty shall not extend to products or parts which have been damaged by negligent use, misuse, alteration, accident or which have been improperly/inadequately maintained.

Notice Procedure:

In order to make a valid warranty claim a written notice of the claim must be submitted, using the RMA form, within 60 days of discovery of a warrantable nonconformance. The RMA form is found on the OneGSI portal.

Service Parts:

GSI warrants, subject to all other conditions described in this Warranty, Service Parts which it manufactures for a period of 12 months from the date of purchase unless specified in Enhancements above.

(Limited Warranty - N.A. Grain Products_ revised 01 October 2020)

This equipment shall be installed in accordance with the current installation codes and applicable regulations which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.



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