



03-SERIES

**2, 4, 6, & 8-ROW
CONVERSION KITS
(FROM CHAINS TO BELTS)**

OPERATOR MANUAL

THIS MANUAL TO ACCOMPANY MACHINE

PART NO. 03-OM-KIT
PRINTING DATE: JULY 2010

WARRANTY POLICY

KELLEY MANUFACTURING COMPANY (KMC) warrants that all goods sold to the original purchaser of any KMC product shall be free of any defects in material and workmanship if used under normal operating conditions. The warranty period begins on the date of purchase by the retail customer and ends twelve (12) months thereafter. KMC's sole responsibility is to repair and/or replace the defective part or parts at no cost to purchaser. This remedy is the **SOLE AND EXCLUSIVE REMEDY** of purchaser.

The purchaser must fill out and return the warranty registration form found in the front of the operator's manual. Failure to return the warranty registration form within 30 days shall result in the goods being sold "AS IS", and all warranties shall be excluded.

This warranty shall not apply to those items that are by nature worn in normal service, including but not limited to belts, springs, teeth, chains, etc. Items such as tires, tubes, and gearboxes and all other items warranted by the original manufacturer are warranted only to the extent of their individual manufacturer warranty, and KMC is not warranting any of said items. All warranty claims must be made through a KMC licensed dealer, and a warranty form request must be submitted to KMC within 30 days of failure or the warranty provision shall be unenforceable against KMC.

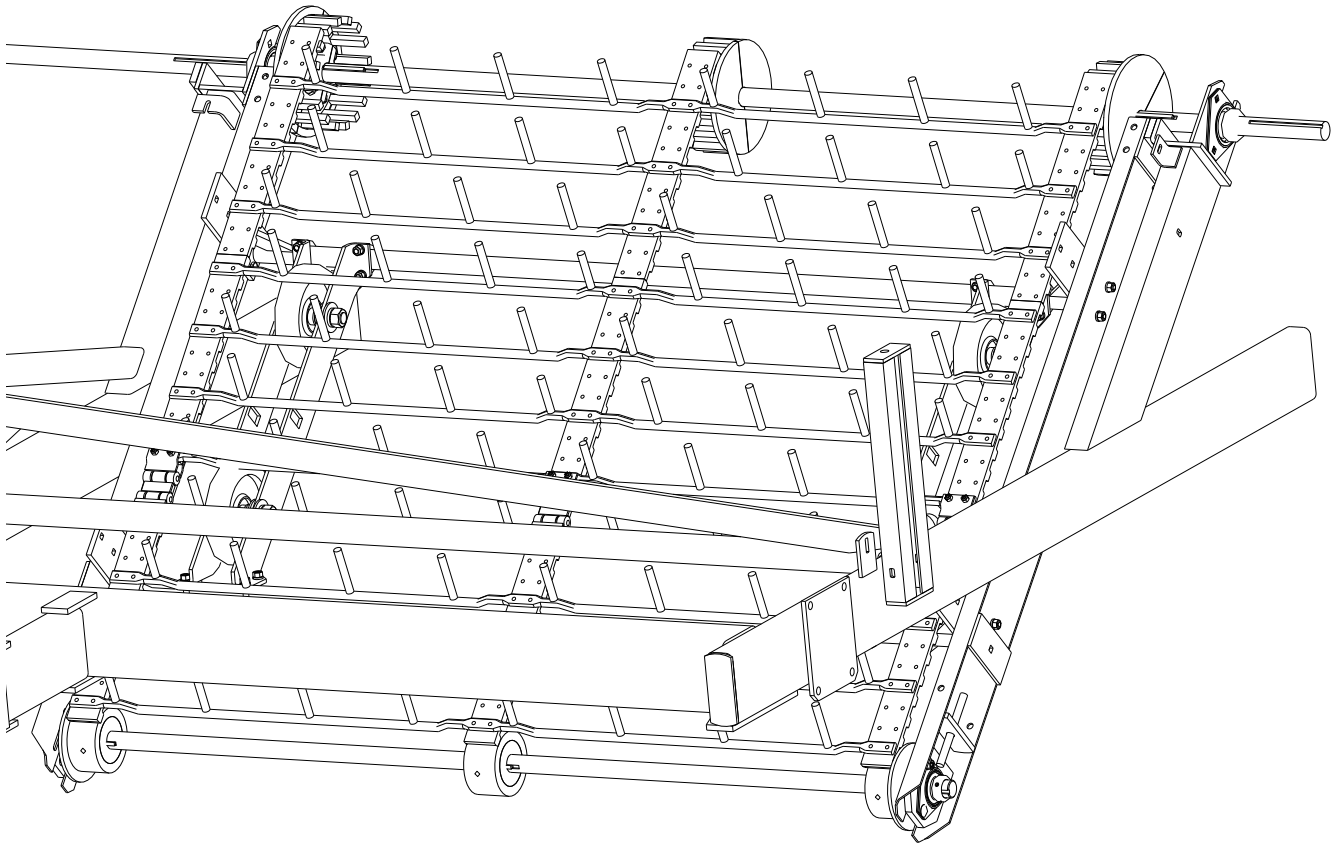
No agent or person has authority to change or add to this warranty as written.

THE ABOVE IS THE ONLY WARRANTY MADE BY KMC AND IS MADE EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED. KMC MAKES NO WARRANTY OF MERCHANTABILITY AS TO ANY GOODS MANUFACTURED BY KMC AND FURTHER, KMC DOES NOT WARRANT ANY SUCH GOODS AS SUITABLE FOR ANY PARTICULAR PURPOSE TO THE RETAIL CUSTOMER. THE SUITABILITY OF GOODS FOR ANY PURPOSE PARTICULAR TO THE CUSTOMER IS FOR THE CUSTOMER, IN HIS SOLE JUDGEMENT, TO DETERMINE. KMC FURTHER MAKES NO WARRANTIES WITH RESPECT TO ITS MANUFACTURED GOODS THAT WOULD NORMALLY BE DISCLOSED BY AN EXAMINATION. THIS IS THE FULL AND FINAL EXPRESSION OF ALL WARRANTY LIABILITY OF KMC. NO OTHER WARRANTY, EITHER EXPRESSED OR IMPLIED, SHALL BE ENFORCEABLE AGAINST KMC.

Kelley Manufacturing Co.

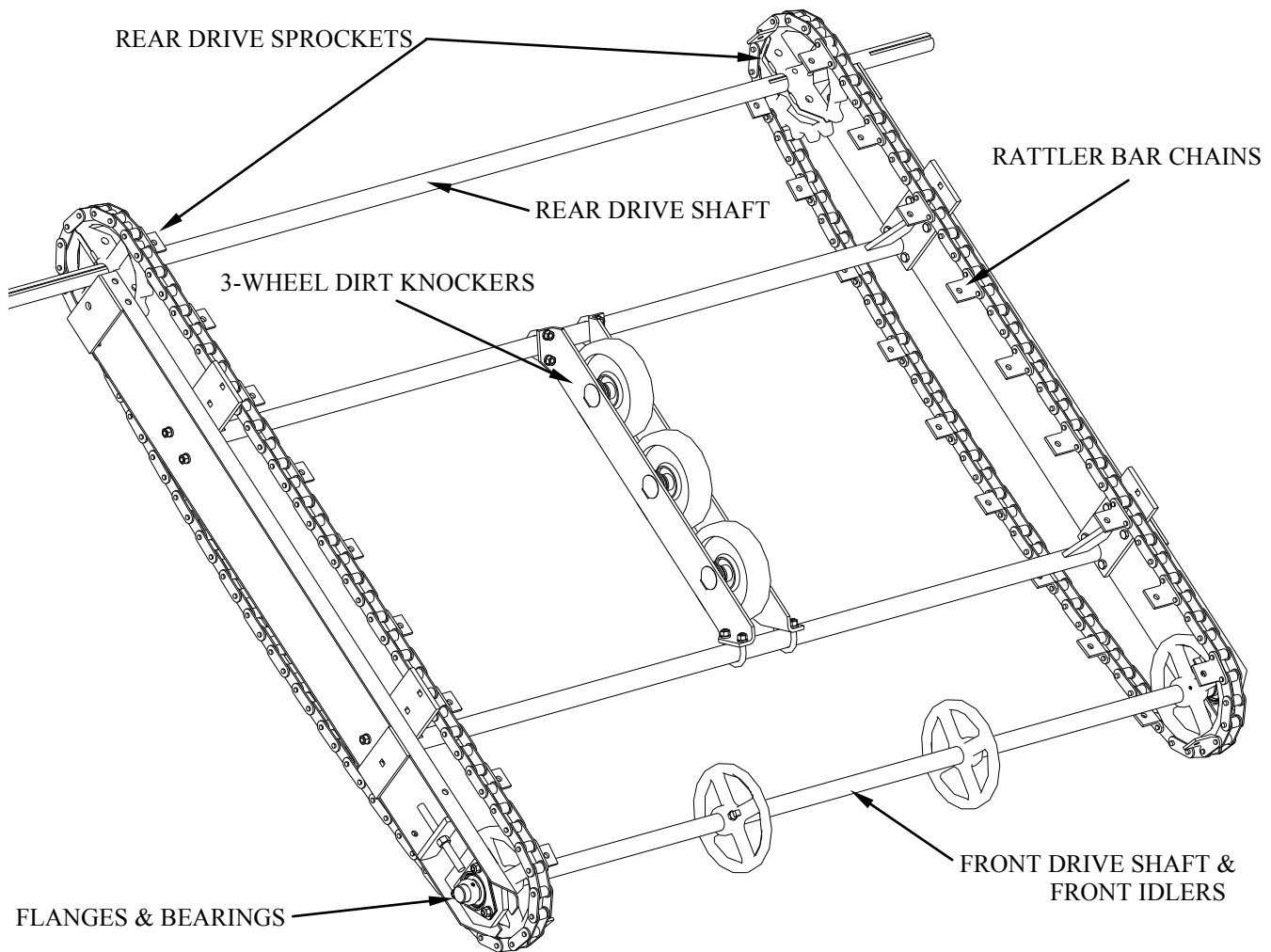
80 Vernon Drive / Zip 31794
P.O. Drawer 1467 / Zip 31793
Tifton GA

CONVERSION KITS FOR 4, 6, AND 8-ROW MACHINES



PART NUMBER	DESCRIPTION
03-081-209	UPDATE, BELT 4(30)-05
03-081-210	UPDATE, BELT 4(36-40)-05
03-081-211	UPDATE, BELT 6(30)-05
03-081-212	UPDATE, BELT 6(36-40)-05
03-081-213	UPDATE, BELT 8(30)-05
03-081-214	UPDATE, BELT 8(36-40)-05

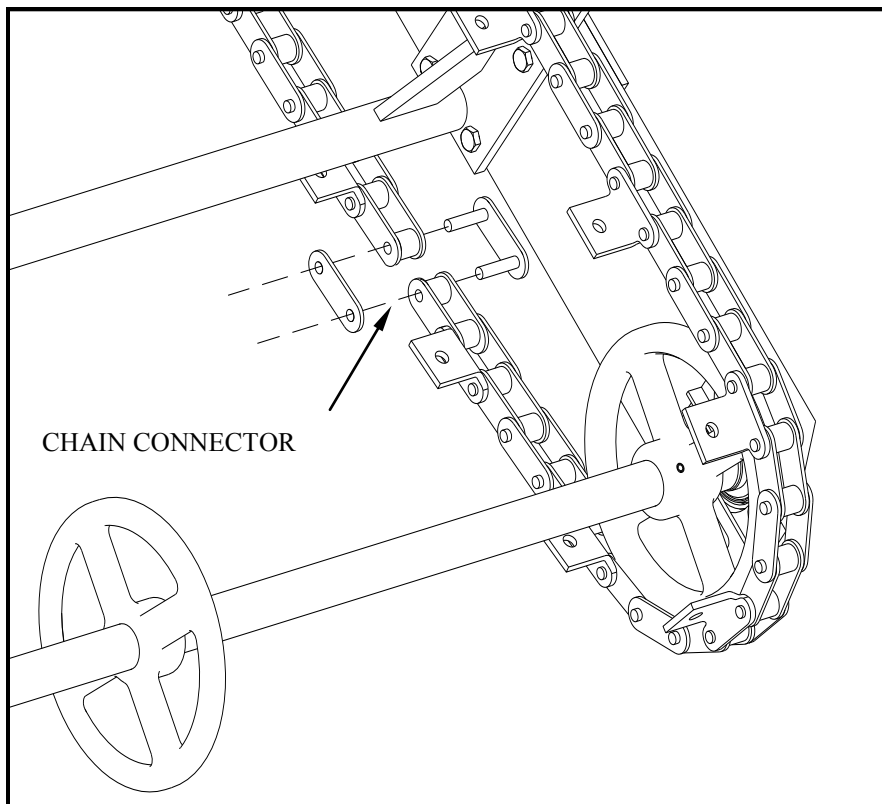
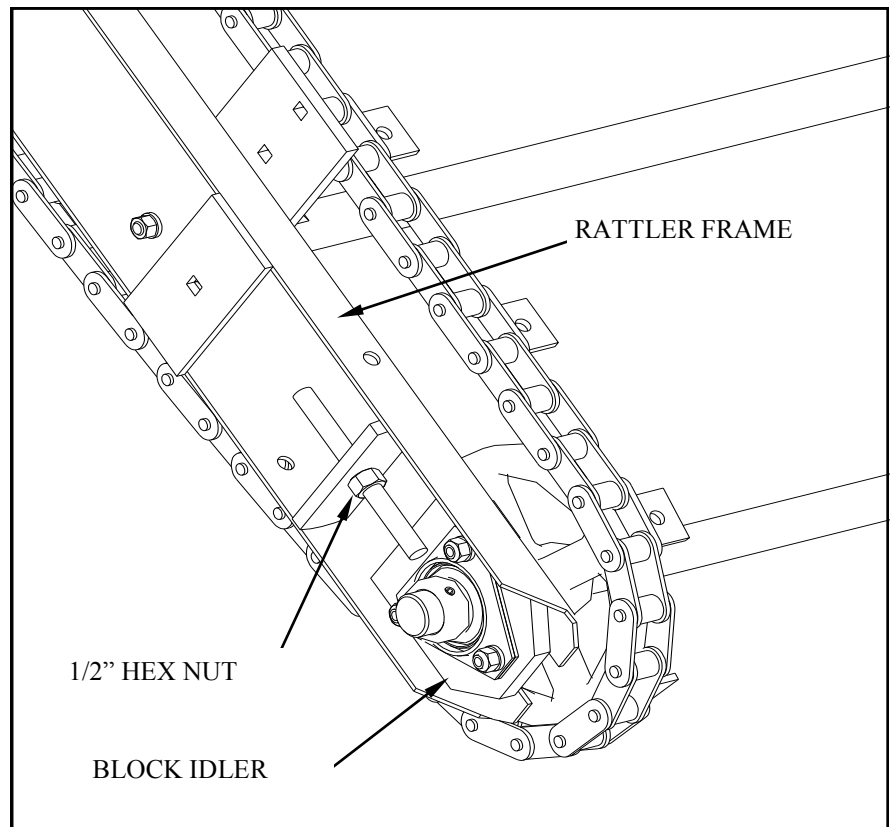
RATTLER FRAME WITH CHAINS (Bars removed for clarity)



INSTRUCTIONS FOR REMOVING CHAINS CONVEYORS

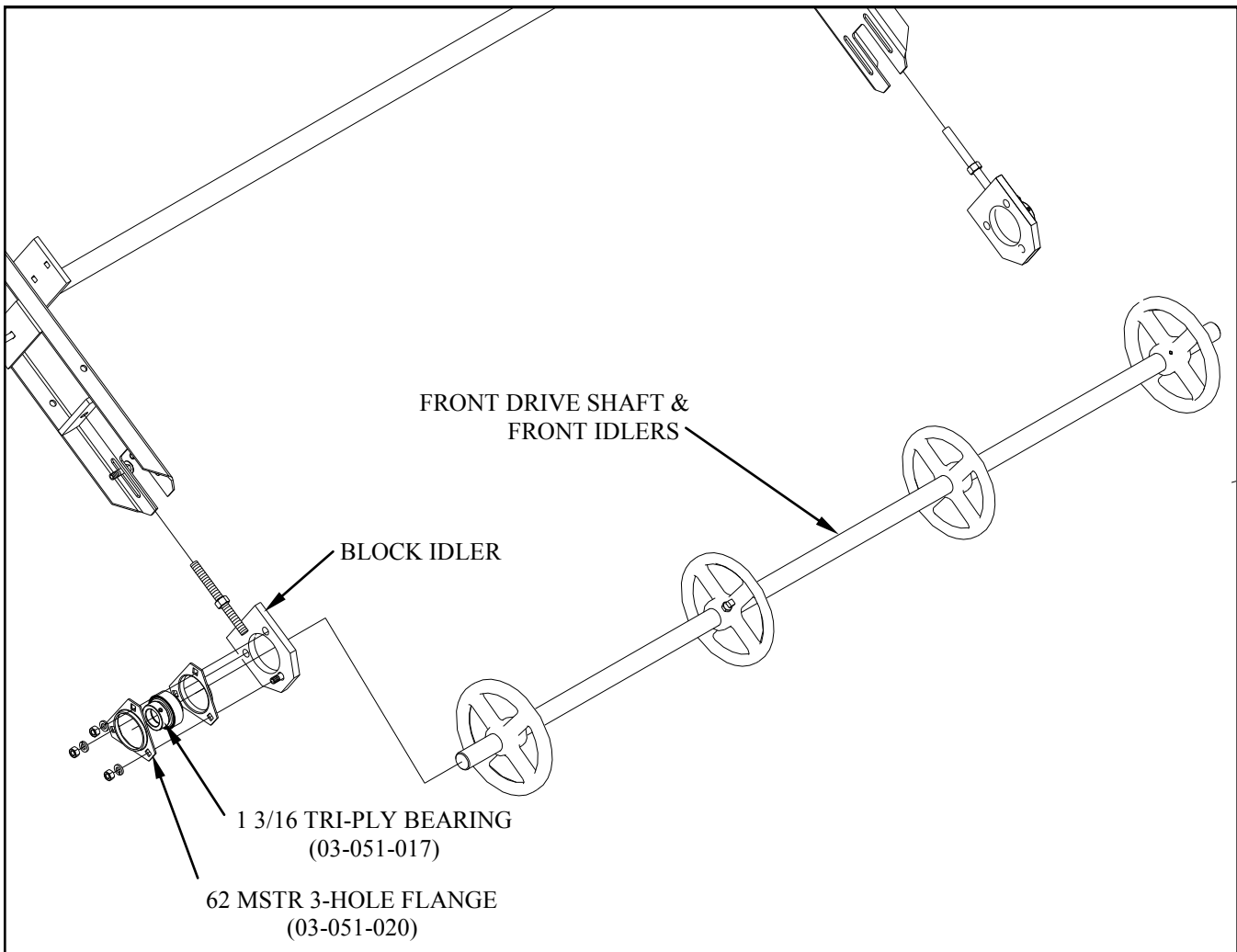
HOW TO REMOVE CHAINS AND BARS

First loosen the 1/2" hex nut on the block idler on both sides of the rattler frame to help loosen the conveyor chains.



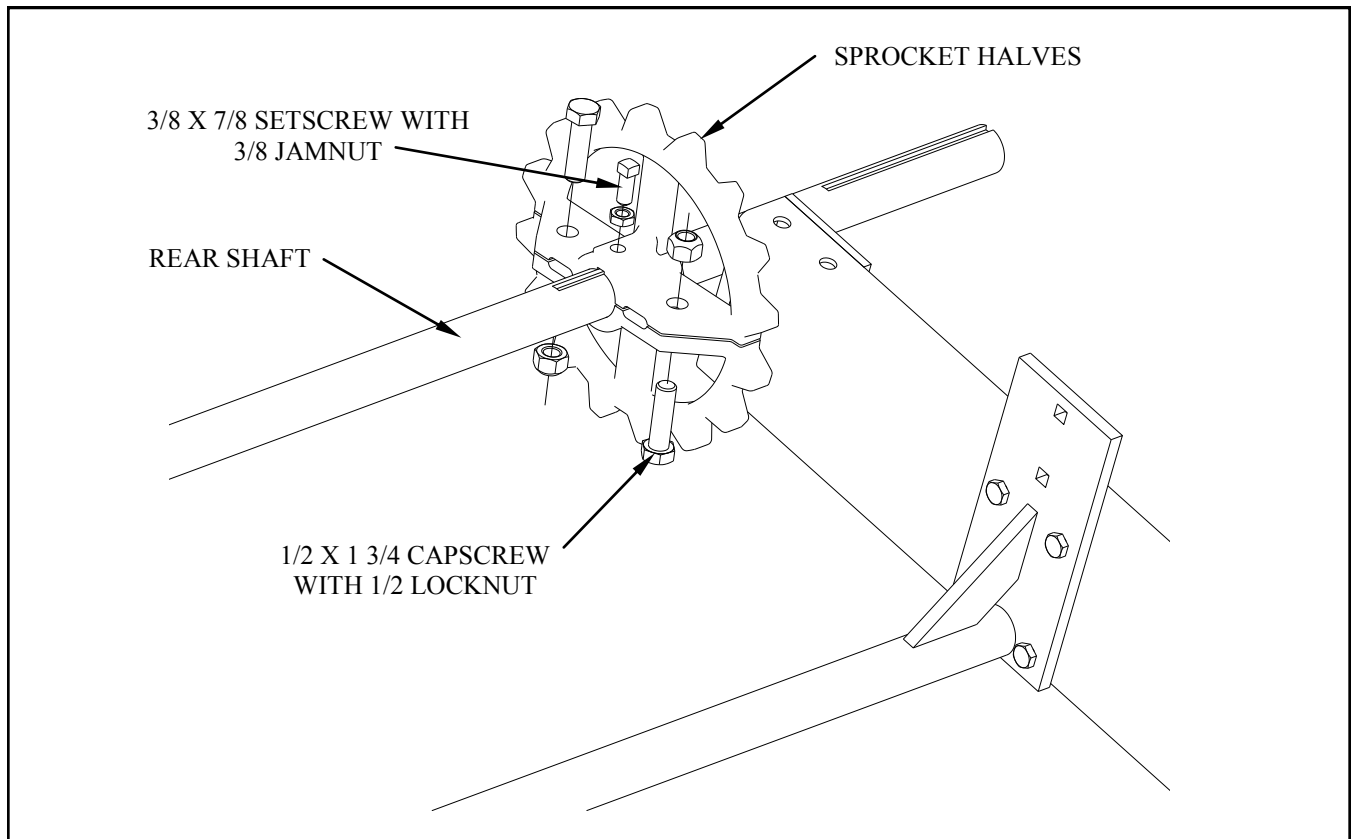
Next remove the chain connector from both sides of chain conveyor. It may become necessary to remove some of the bars in order to get to the connector.

HOW TO REMOVE FRONT DRIVE SHAFT AND FRONT IDLERS



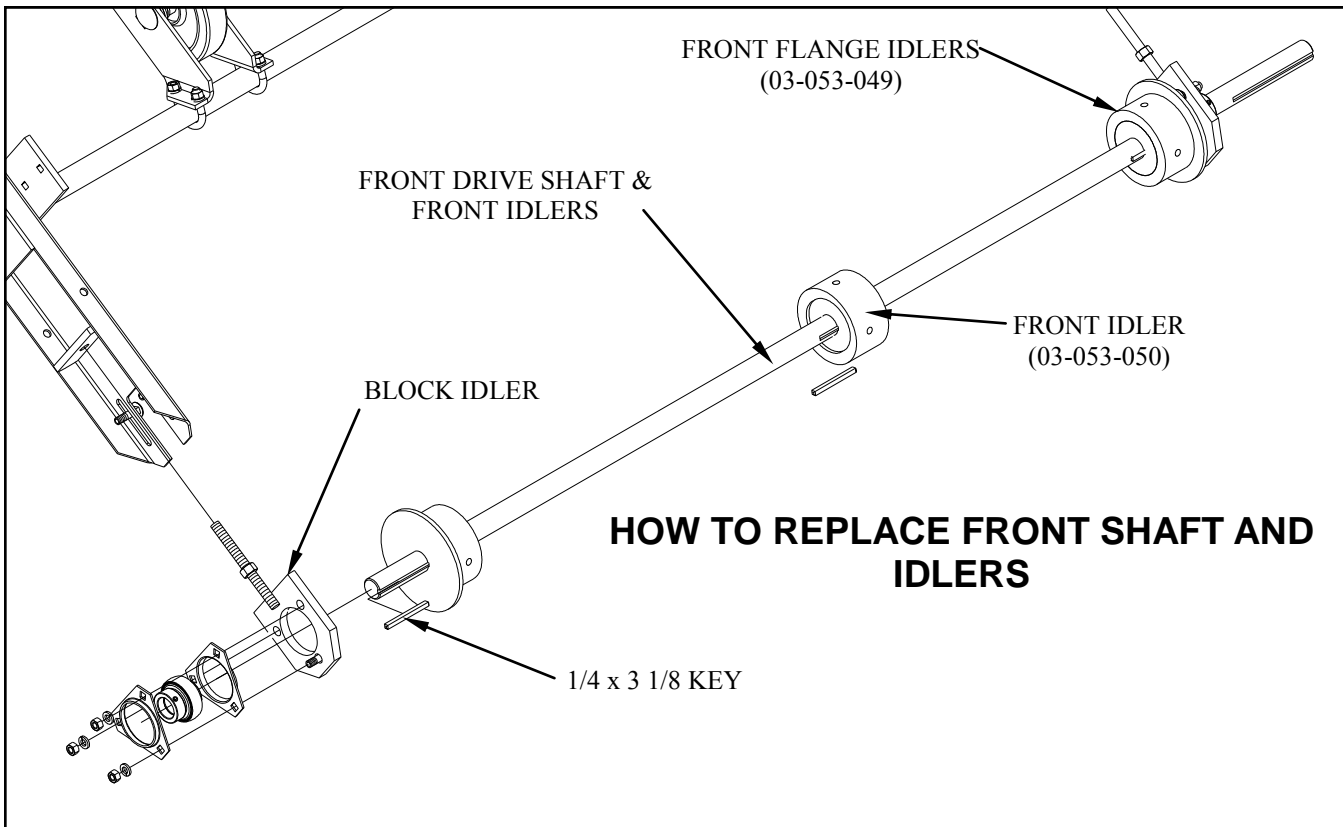
It will be necessary to remove the front drive shaft and the front idlers completely. To do this you must first remove the (2) carriage bolts that are holding the block idler to both sides of the rattler frame. The lower bolt helps hold the flanges and bearings to the block idler. New flanges and bearing are provided in the conversion kit.

HOW TO REMOVE REAR SHAFT AND SPROCKETS



On the rear shaft you will need to remove 2 sets of sprocket halves. Loosen 3/8 x 7/8 set-screw over keyway. Remove the 1/2 x 1 3/4 capscrows and locknuts to remove the sprocket halves completely.

INSTRUCTIONS FOR ASSEMBLING BELT CONVEYORS



Now place front flange idlers and center front idler on front shaft as shown in the drawing above. Assemble 3 hole flanges around bearing to block idler, with collar of bearing facing outward. Now slide bearing and idler onto the shaft and slide into place on the rattler side frames.



When shaft is in the correct location tighten the setscrew in collar to lock bearing to shaft.





Place 1/4 x 3 1/8 key in shaft and slide front flange idler onto the key. This may require using a hammer to position part into place. Once part is in the correct position tighten the setscrews over the key and one on the shaft with the proper size allen wrench as shown below. Screw in set-screw tightly to score key or shaft, then back off a half a turn. Seat down tight on shaft making sure setscrews cut into shaft. Torque to 27 ft lbs. Leave approximately 3/16" between edge of belt and idler.

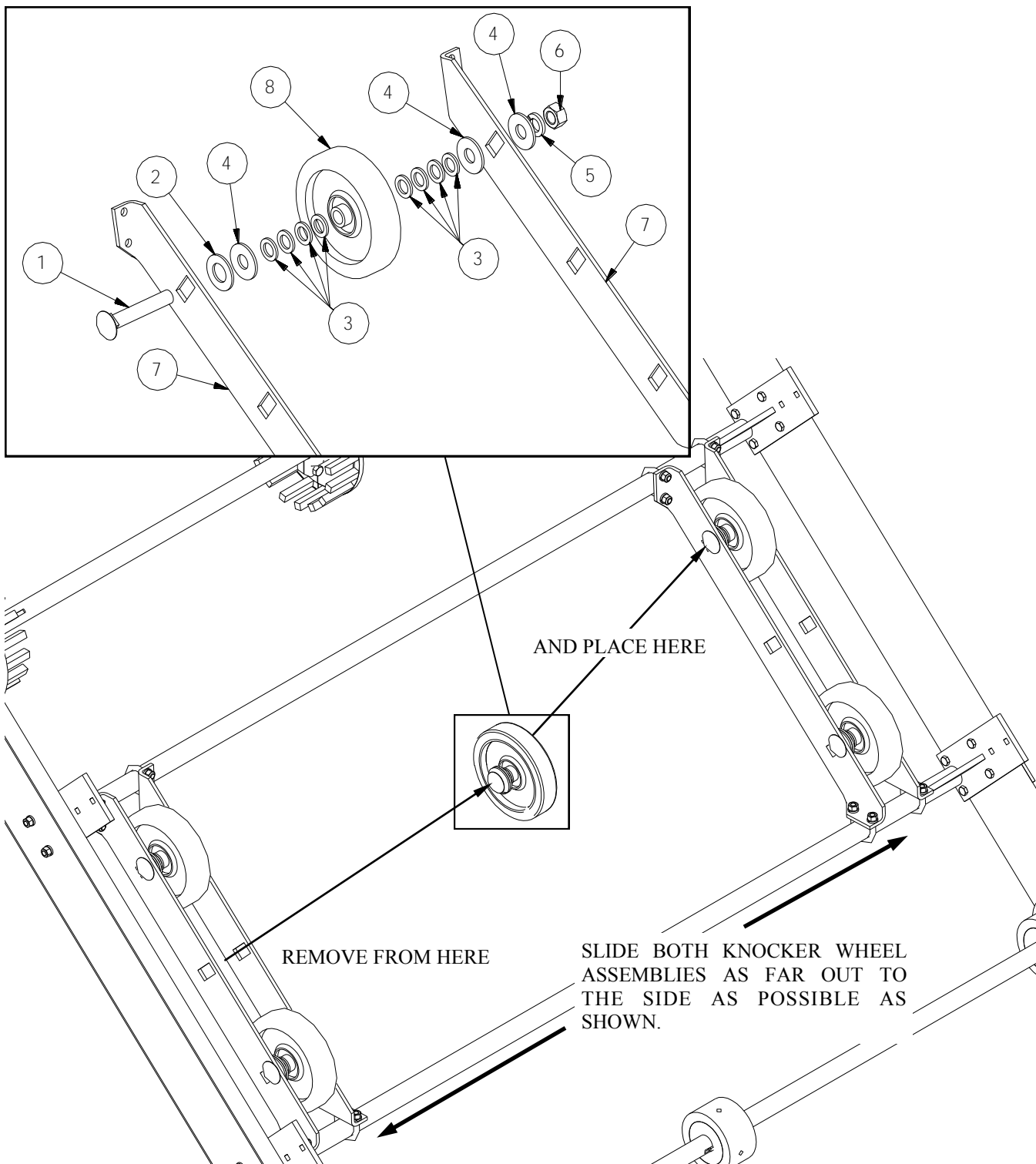
→ ← 3/16" between belt and idler

Next measure your belt conveyor to figure the approximate location for the center idler. Put key in key way in shaft and slide your idler to the correct dimension. Then tighten your setscrews and lock to shaft.



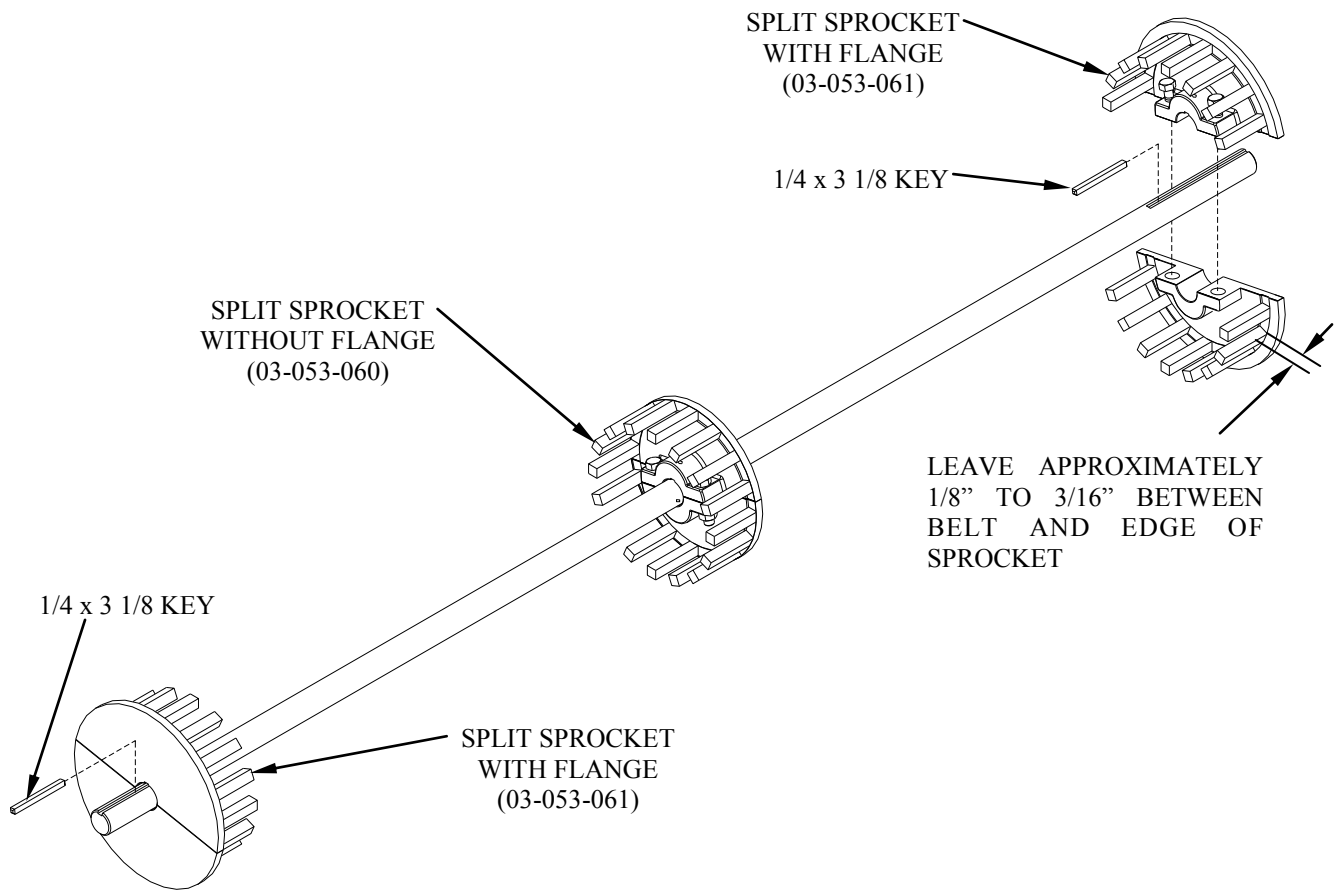
HOW TO ASSEMBLE KNOCKER WHEEL TO USE WITH BELT CONVEYOR

On your machine you will have a three wheel knocker assembly mounted in the center of the rattler frame. With your kit comes enough items to build (2) two knocker wheel assemblies. In order to do this you must remove the middle wheel from the existing 3 knocker wheel assembly and use it to make the other knocker wheel assembly. Please refer the drawing on the following page for further instructions.

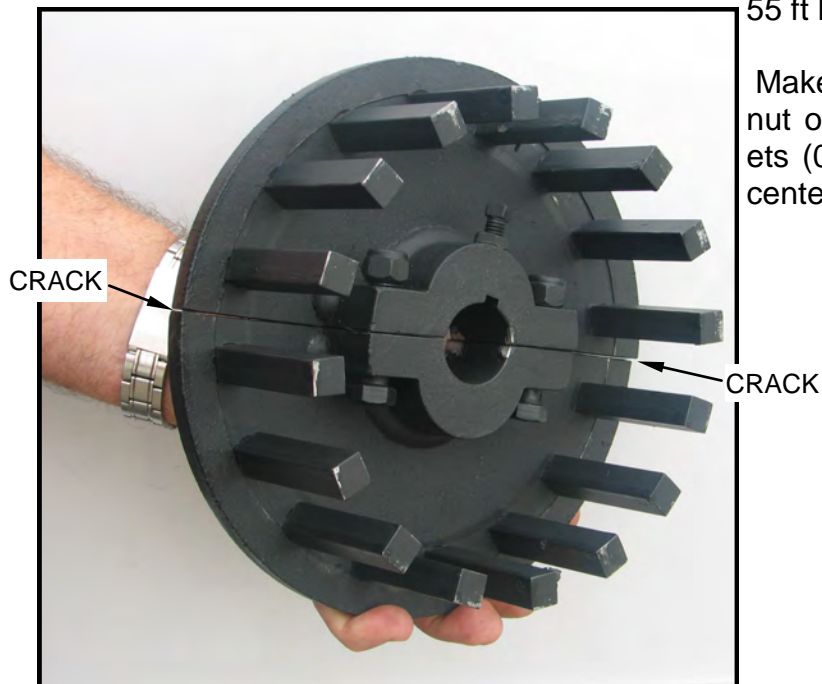


ITEM	PART NO.	SERIAL NO OR YR	DESCRIPTION	QTY
1	52-050448		CARRIAGE SCREW, 3/4 X 4 1/2	1
2	62-020050		FLATWASHER, 1 SAE	1
3	03-050-028		WASHER, 1 1/4 X 3/4	8
4	62-010300		FLATWASHER, 3/4 PLT	3
5	66-010350		LOCKWASHER, 3/4 PLT	1
6	68-010350		HEX NUT, 3/4 PLT	1
7	03-023-464		BRACKET, DIRT KNOCKER	2
8	03-050-111		WHEEL, 7 X 1 1/2 KNOCKER	1

HOW TO ASSEMBLE REAR SPROCKETS TO REAR SHAFT

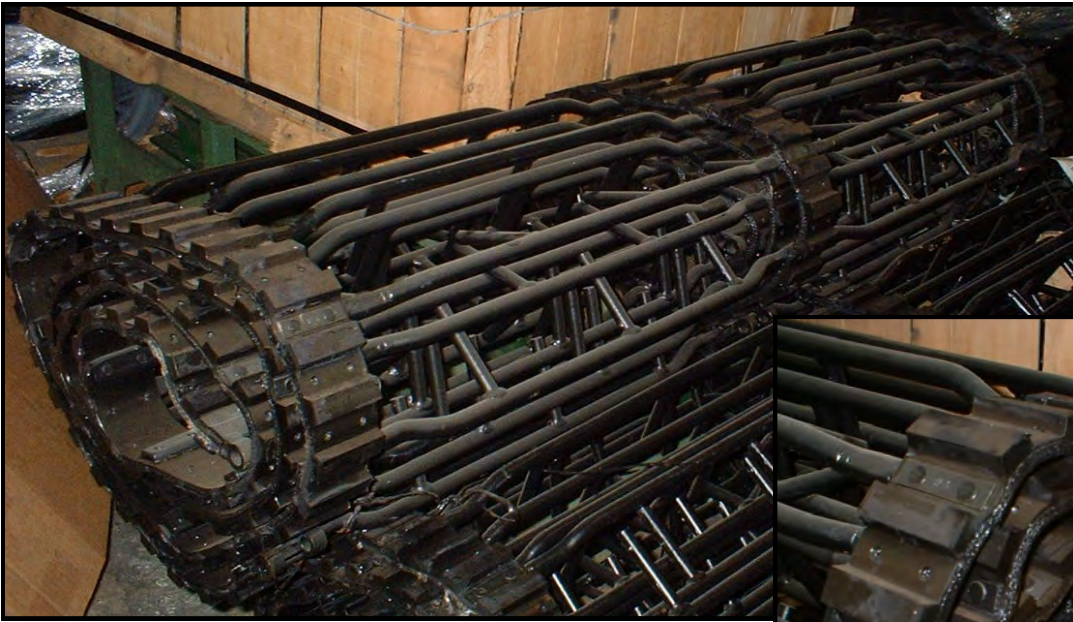


These sprocket assemblies come in pairs to make sure they perform better on the shaft. So it will be necessary for you to untighten the hardware on the sprockets in order to mount them on the shaft. A key is also used to help keep the two outside sprockets (03-053-061) in place. No key is required for the center sprocket (03-053-060). Tighten up bolts together when assembling them on the shaft. Rotate back and forth between front and rear bolts to help insure the sprocket leave equal amount of crack between the split sprockets. Torque to 55 ft lbs.



Make sure to tighten setscrew and jam-nut over the keys on the outside sprockets (03-053-061) and on the shaft on the center sprocket (03-053-060).

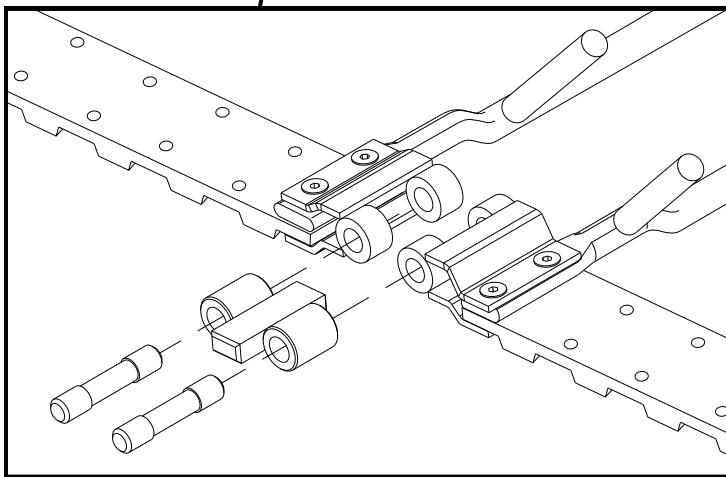
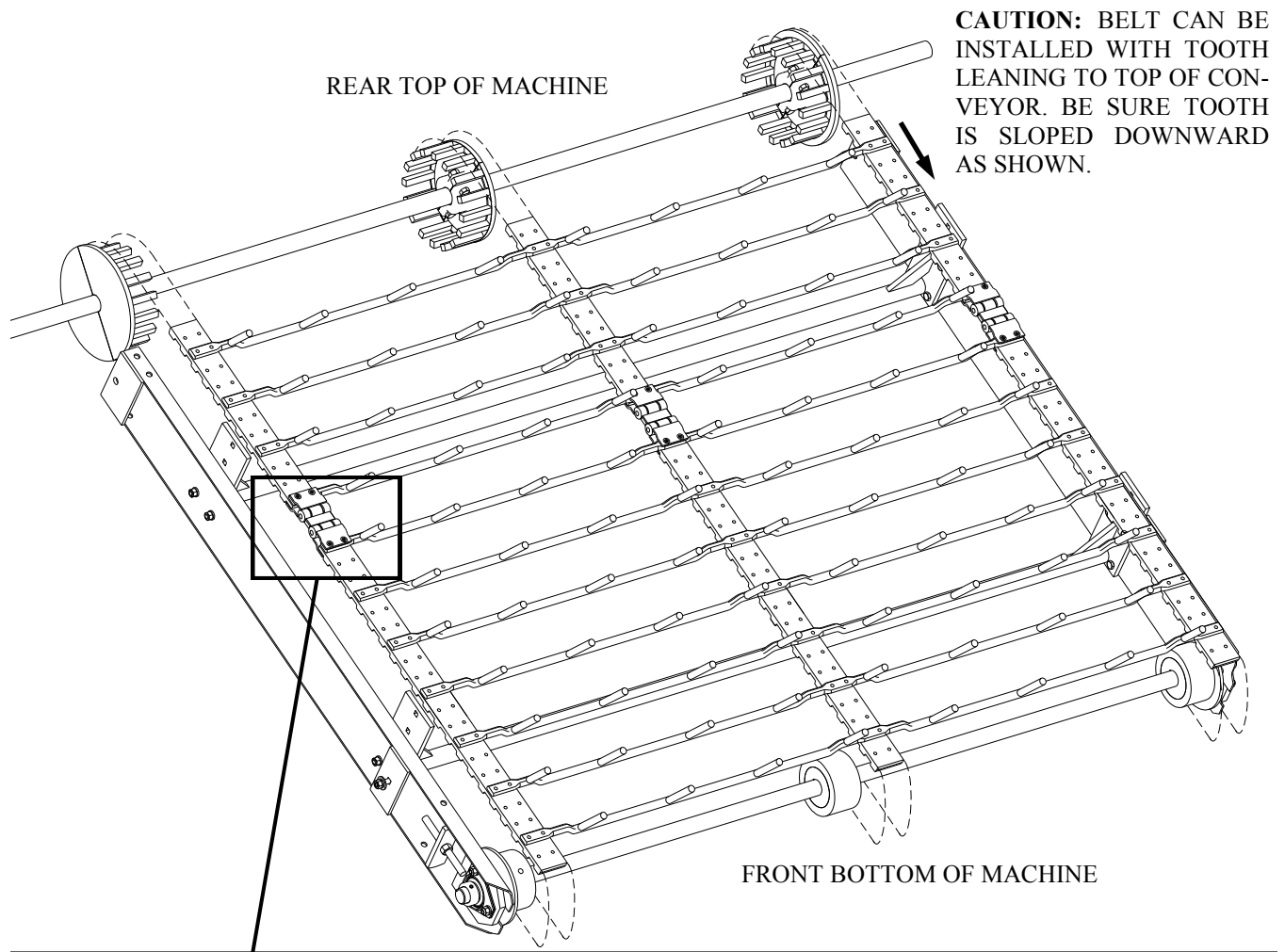
HOW TO ASSEMBLE CONVEYOR BELT ON RATTLER FRAME



This conveyor belt comes assembled with bars. The connector link and pins come in a small cardboard box attached to one end of the rolled up conveyor belt as shown in the above pictures

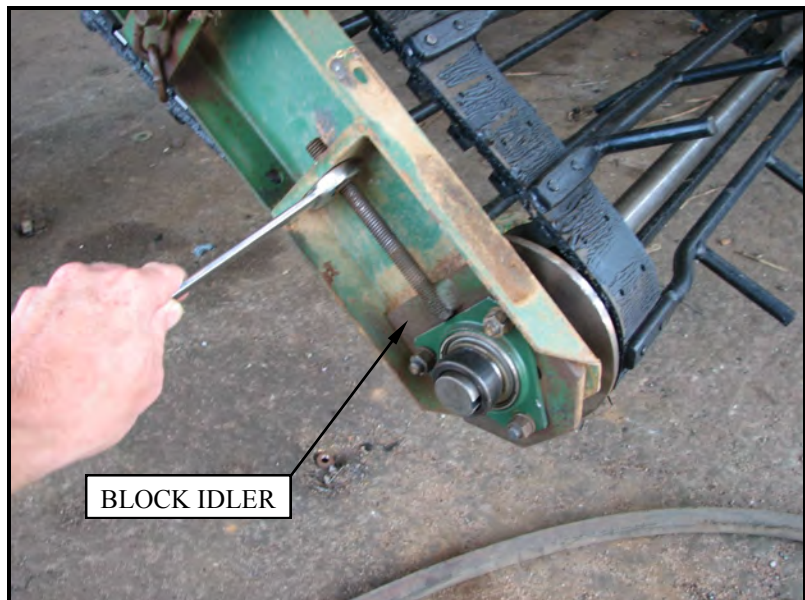


Roll out belt flat on ground. Using a hoist, lift conveyor over the rattler frame and lower it down on to the rear sprockets and front idlers. Make sure that the block idler is loose enough to help you attach the belt together.



It will be easier to connect belt beneath the rattler frame using the connecting link and the pins as shown in drawings. The center sprocket and idlers may require some adjustment to make sure the belt is running over them correctly.

Once the belt is in place and all the adjustment have be made, tighten belt by screwing locknut to force the block idler downward as shown in the picture.



Run belt loose. **DO NOT** over tighten. Leave same amount of droop on each side, 3 1/2" below rattler frame between knocker wheel locations.

The following is a list of serial numbers issued to our machines at the beginning of each year. To determine when a unit was made, find the range within which the particular serial number falls. It would have been produced between January 1 to December 31 of that year.

YEAR	SERIAL NUMBERS
1985	27986-29695
1986	29696-31095
1987	31096-33234
1988	33235-35548
1989	35549-38496
1990	38497-41771
1991	41772-44466
1992	44467-47001
1993	47002-48750
1994	48751-51549
1995	51551-54262
1996	54263-56661
1997	56662-59465
1998	59466-62097
1999	62098-63986
2000	63987-65692
2001	65693-67340
2002	67341-68699
2003	68700-70482
2004	70483-72646
2005	72647-74866
2006	74867-76368
2007	76369-77883
2008	77884-79891
2009	79892-80944
2010	80945-81775
2011	81776-83453
2012	83454-85092
2013	85093-86418
2014	86419-



DEPENDABLE EQUIPMENT FOR PROGRESSIVE FARMING

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MADE IN AMERICA

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