

# **Addendum Sheet For Galvanized Cone Assembly**

**(For cone panel # FP442)**



## Step 1

Assemble the discharge cone by following steps A thru C below.

### Step A

Assemble the four cone sections together using two - 1/4"-20 x 3/4" bolts (# MH8061) and nuts (# MH8055) per seam at this time. **One edge of each cone panel is marked with the part number (FP442). Each seam of the assembled cone must either have two edges with the part number marking or two edges with no marking.** Install the bolts into the two holes near the center of each seam. Apply the cone support straps and bolts to the holes nearest the narrow end of the cone. All bolts shall be installed from with the head of the bolts to the inside of the finished cone. **Make sure that all cone seams have the lapping of panels the same and that each seam has either two edges with part number or two edges with no marking.** The holes at the widest end of the cone shall remain empty at this time.



### Step B

Form the flat cone sections into a cone by joining flange #1 and flange #8 and using three 1/4"-20 x 3/4" bolts (# MH8061) and nuts (# MH8055), bolt the two flanges together. Again make sure that the lapping of panels is the same as all other cone seams. As in Step #A install the bolt closest to the narrow end of the cone and apply a cone support strap to the outside of the cone panels.



### Step C

With the formed cone on a flat surface (large diameter up) place the guard screen into the cone (bolt loops up). Align the bolt loops on the guard screen with the bolt holes in the cone and fasten the guard screen in place using  $\frac{1}{4}$ "-20 x  $\frac{3}{4}$ " bolts (# MH8061) and nuts (# MH8055) with the bolt heads against the guard screen and the nuts on the outside of the cone assembly. Ensure that the bolt loops on the guard screen are all the way onto the bolts prior to tightening (approximately 80 – 85 in. lbs.) the bolts fully.



**Continue on with the assembly instructions IS10031, Step 17.**