



**12" [305 mm]
Hopper Aeration Kit**

**3-19072
Installation Instructions**



NOTE: Metric measurements are in *italics*, millimeters and square parentheses following the English measurement.

Cut the Mounting Plate Hole in the Hopper Panel

1. **Locate the center point** of the 12" [305] hole:
Measure down from the top of the Hopper Panel, along the center line (CL). See the Chart, "Locating the Hopper Panel Center" on the back page.
2. Use **Figure 1** at right and the Mounting Plate (Item 5) as a hole template. Locate and mark the 12" circle center and nineteen (19) Bolt holes.
3. Scribe the 12" circle on the Hopper Panel.
4. Drill nineteen (19) 3/8" [9.5] diameter Bolt holes.
5. Shear out the 12" center hole along the scribe line.

Item	Dimension
CL	CenterLine (CL), Hopper Panel/12" Hole
A	12" [305] Hole CENTER/CL to:
B	Top/Bottom Plate holes, 8 1/4" [210]
C	Bottom Vent holes CL: 24 3/4" [629]
D	Plate side holes #1/#6: 6 41/64" [169]
E	Plate side holes #2/#5: 3 63/64" [101]
F	Plate side holes #3/#4: 1 21/64" [33.7]
G	Bolt holes: 9 3/8" [238]
H	(to) Weldbolt: 7" [178]
J	12" [305] Hole diameter
K	Crimp line
L	Distance to top of Hopper Panel (not to Crimp Line) See the Chart on the back page.
M	Top of Hopper Panel

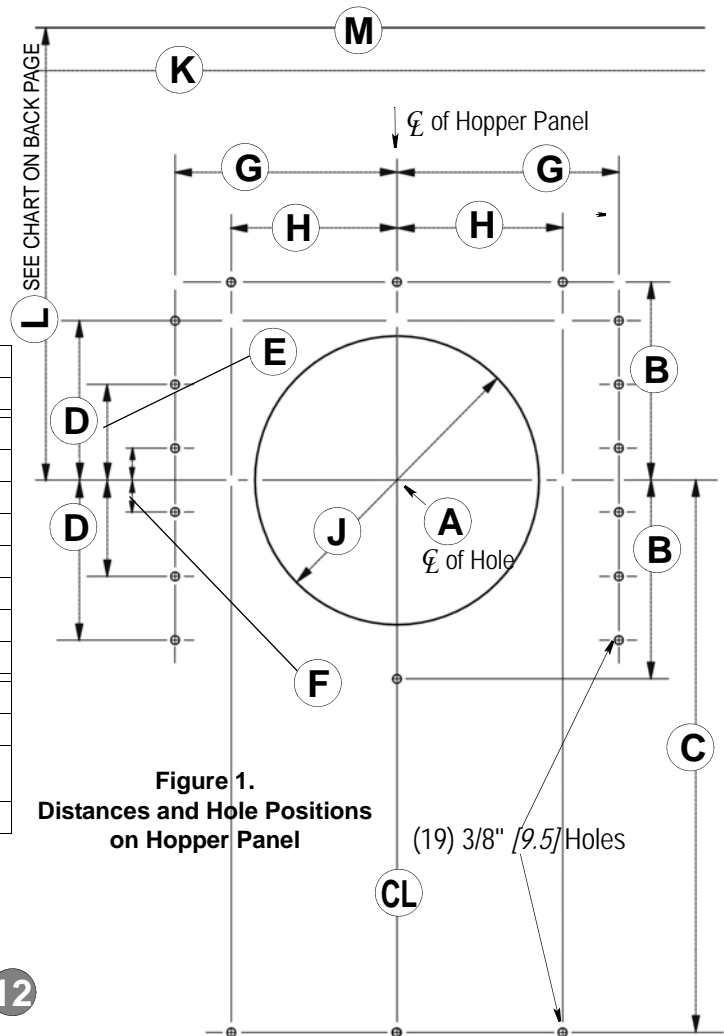


Figure 1.
Distances and Hole Positions
on Hopper Panel

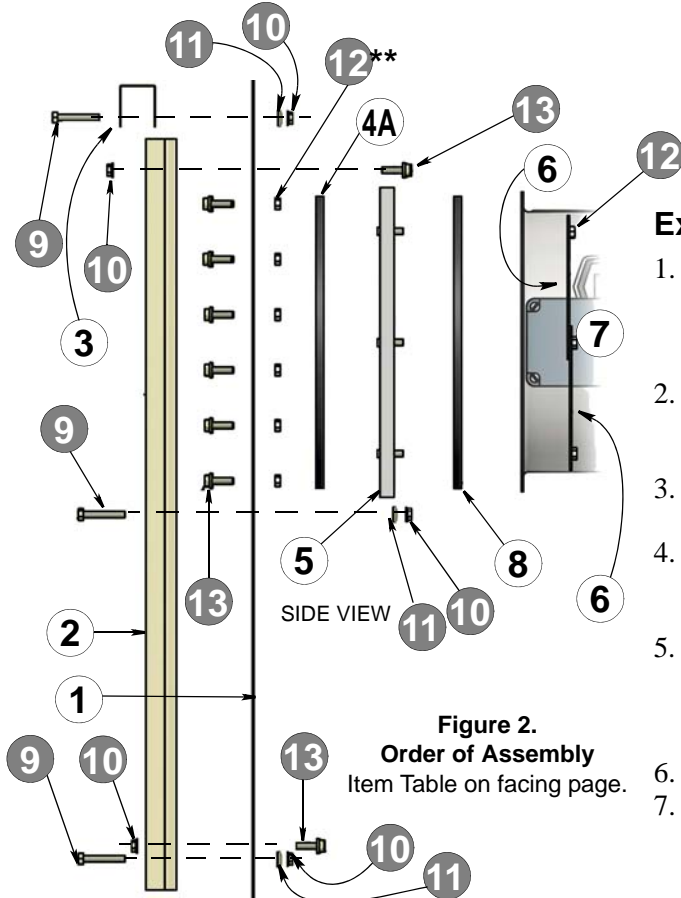


Figure 2.
Order of Assembly
Item Table on facing page.

Exterior Connections and Sealing

1. Cut two (2) pieces of adhesive 3/8" x 1" Pres-Stik Seal each at 44" [1118]. Form one piece into a circular gasket (Item 4A). Press around the cut 12" hole on the Hopper Panel exterior. Butt ends of the strip; trim excess.
2. Insert twelve (12) 5/16 x 1" Bin Seal Bolts (Item 13), heads **inside**, through the twelve (12) holes drilled in the Hopper Panel for Mounting Plate sides (dimension G above).
3. Outside the Hopper Panel, place a Hex Nut (Item 12**) onto each Bolt.
4. Align the Mounting Plate (Item 5), side flanges out, over the center hole and side Bolts. Secure with (12) Hex Nuts (Item 12). Tighten the Nuts evenly.
5. Form and press the second 44" Pres-Stik strip to form a circular seal (Item 4B) inside the six (6) Weldbolts (Item 14) around the Mounting Plate center hole. Butt ends of the strip; trim excess.
6. Position the Fan housing flange over the seal.
7. On top of the Fan flange (**Figure 4**), connect two (2) Mounting Straps (Item 6) over a *center Weldbolt. Spread Straps so end holes align over Weldbolts above and below. Repeat with a pair of Straps on the other side.
8. Secure the Weldbolt-Fan-Strap connection with six (6) Hex Nuts (Item 12). See **Figure 4**.

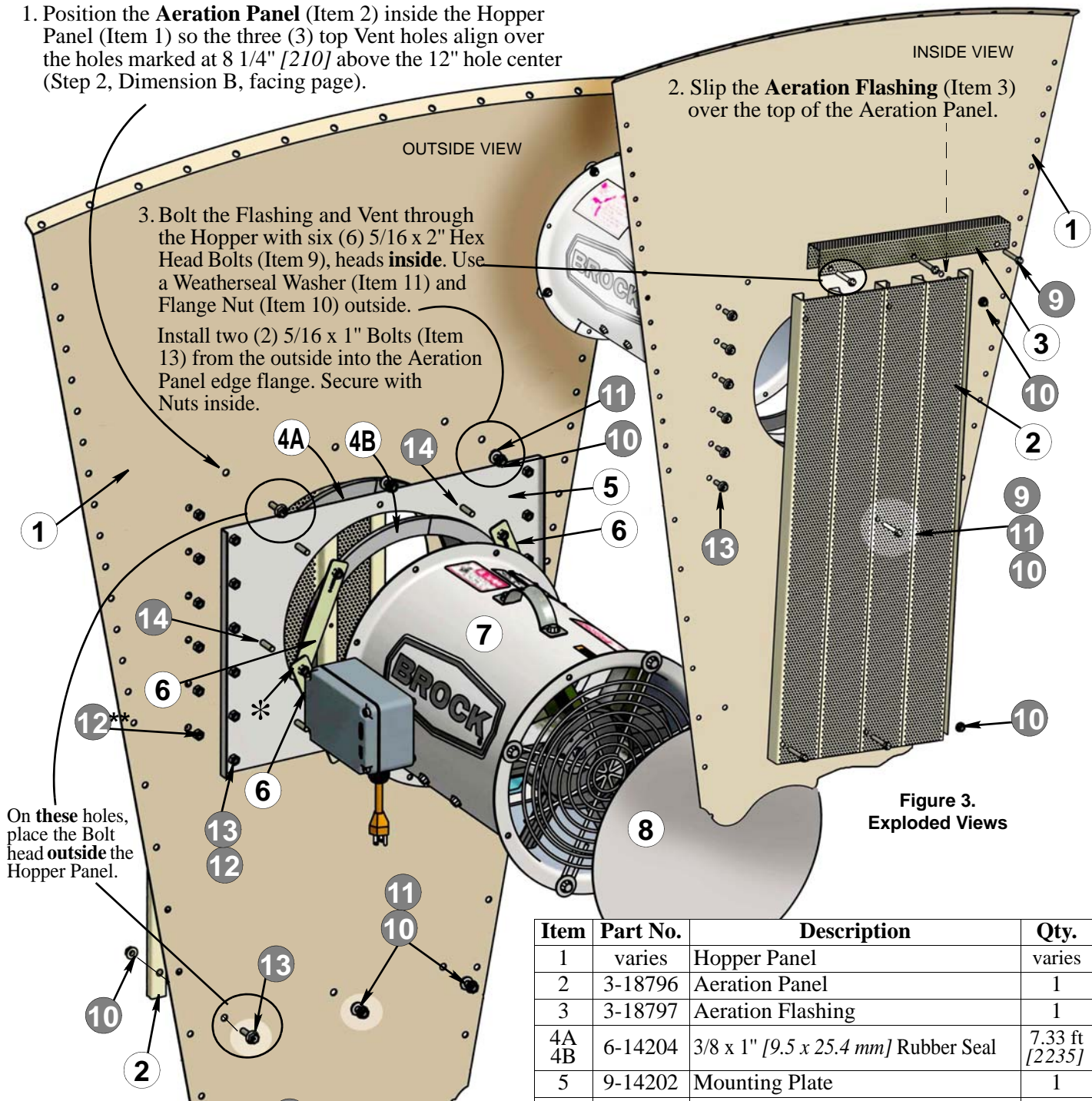
Interior Aeration Panel Assembly

1. Position the **Aeration Panel** (Item 2) inside the Hopper Panel (Item 1) so the three (3) top Vent holes align over the holes marked at 8 1/4" [210] above the 12" hole center (Step 2, Dimension B, facing page).

2. Slip the **Aeration Flashing** (Item 3) over the top of the Aeration Panel.

3. Bolt the Flashing and Vent through the Hopper with six (6) 5/16 x 2" Hex Head Bolts (Item 9), heads **inside**. Use a Weatherseal Washer (Item 11) and Flange Nut (Item 10) outside.

Install two (2) 5/16 x 1" Bolts (Item 13) from the outside into the Aeration Panel edge flange. Secure with Nuts inside.



On these holes, place the Bolt head **outside** the Hopper Panel.

Figure 3. Exploded Views

Item	Part No.	Description	Qty.
1	varies	Hopper Panel	varies
2	3-18796	Aeration Panel	1
3	3-18797	Aeration Flashing	1
4A 4B	6-14204	3/8 x 1" [9.5 x 25.4 mm] Rubber Seal	7.33 ft [2235]
5	9-14202	Mounting Plate	1
6	9-14205	Strap, Aeration Fan Mounting	4
7	AX12	Fan 12" [305]	1
8	9-14229	Fan Cover Plate	1
9	39-37484	5/16 x 2" Hex Head Bolt Gr. 5	5
10	39-20152	5/16" Flange Nut	7
11	39-20155	Weatherseal Washer	5
12		5/16" Hex Nut	
12**	39-20020	Mounting Plate side holes require 2 Nuts; one is behind the Plate.	32
13	39-20073	5/16 x 1" Bin Seal Bolt Gr. 8.2	15
14		Weldbolt 3/8"	6

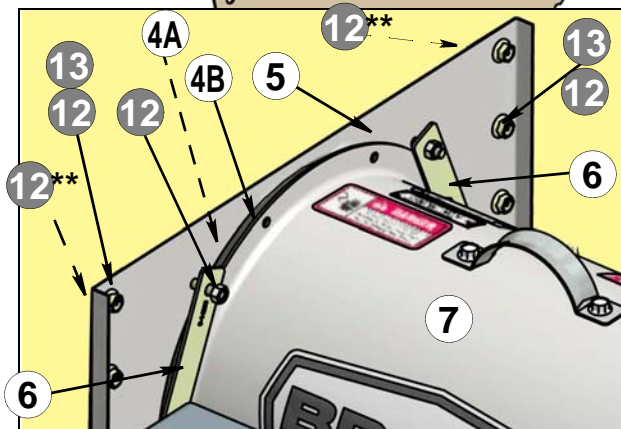


Figure 4. Gasket and Strap Detail

Locating the Hopper Panel Center

Hopper Panel				(L)	Distance From Top Edge to CenterLine	Top Edge Crimp (included)
Bin Dia.	Hopper Angle	Hopper Panel Part No.	Hopper Collar Diameter			
9' [2 743]	60°	3-37455	16" [406]		31.670" [804.4]	1.250" [31.8]
9' [2 743]	60°	3-37456	25" [635]		31.670" [804.4]	1.250" [31.8]
9' [2 743]	45°	3-37458	16" [406]		15.575" [395.6]	1.125" [28.6]
12' [3 658]	60°	3-37457	25" [635]		50.334" [1 278.4]	1.000" [25.4]
12' [3 658]	45°	3-37459	16" [406]		27.946" [709.8]	1.031" [26.2]
15' [4 572]	45°	3-37461	16" [406]		28.178" [715.7]	1.125" [28.6]
15' [4 572]	45°	3-37462	25" [635]		28.178" [715.7]	1.125" [28.6]
The following Hopper Panels have no crimp . If already installed, the top edge may be obscured behind the Upper Hopper Panel. To locate the top edge, measure upward from the center of the top Bolt holes.						DISTANCE from CenterLine of Holes
15' [4 572]	60°	3-37464	16" [406]		31.562" [801.6]	1.000" [25.4]
18' [5 486] 21' [6 401]	45°	3-37465	16" [406]		35.964" [913.5]	1.375" [34.9]
18' [5 486] 21' [6 401]	45°	3-37466	25" [635]		35.964" [913.5]	1.375" [34.9]



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All specifications subject to change without notice.

The BROCK® standard one-year Warranty for Accessory Items applies to this Part.

Changes this issue:

Mounting Straps (9-14205) were reissued for this installation.

Changes last issue:

Mounting Straps (9-14205) were discontinued. Some hardware quantities changed.