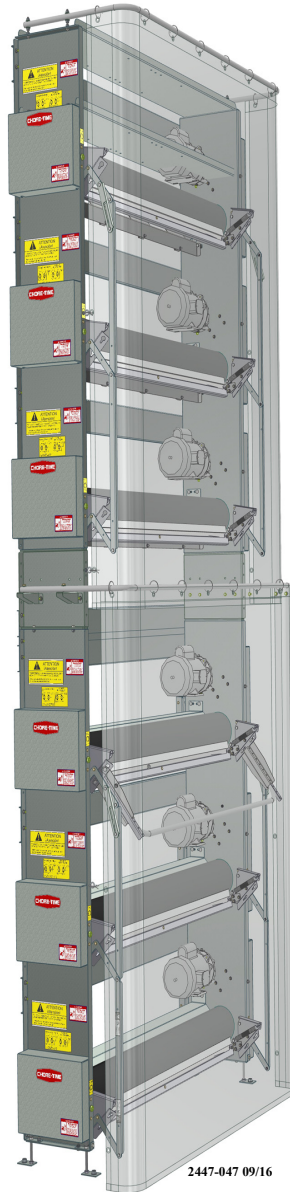




# Manure Drive Installation and Operators Instruction Manual

Installation and Operators Manual

Installation and Operators Manual



For additional parts and information, contact your nearest Chore-Time distributor or representative.  
Find your nearest distributor at: [www.choretime.com/contacts](http://www.choretime.com/contacts)

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## Limited Warranty

CTB, Inc. (“Chore-Time”) warrants new CHORE-TIME Chain Idler Parts manufactured by Chore-Time to be free from defects in material or workmanship under normal usage and conditions, for One (1) year from the date of installation by the original purchaser (“Warranty”). If such a defect is determined by Chore-Time to exist within the applicable period, Chore-Time will, at its option, (a) repair the Product or Component Part free of charge, F.O.B. the factory of manufacture or (b) replace the Product or Component Part free of charge, F.O.B. the factory of manufacture. This Warranty is not transferable, and applies only to the original purchaser of the Product.

### CONDITIONS AND LIMITATIONS

THIS WARRANTY CONSTITUTES CHORE-TIME’S ENTIRE AND SOLE WARRANTY AND CHORE-TIME EXPRESSLY DISCLAIMS ANY AND ALL OTHER WARRANTIES, INCLUDING, BUT NOT LIMITED TO, EXPRESS AND IMPLIED WARRANTIES, INCLUDING, WITHOUT LIMITATION, WARRANTIES AS TO MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSES. CHORE-TIME shall not be liable for any direct, indirect, incidental, consequential or special damages which any purchaser may suffer or claim to suffer as a result of any defect in the Product. Consequential or Special Damages as used herein include, but are not limited to, lost or damaged products or goods, costs of transportation, lost sales, lost orders, lost income, increased overhead, labor and incidental costs, and operational inefficiencies. *Some jurisdictions prohibit limitations on implied warranties and/or the exclusion or limitation of such damages, so these limitations and exclusions may not apply to you. This warranty gives the original purchaser specific legal rights. You may also have other rights based upon your specific jurisdiction.*

Compliance with federal, state and local rules which apply to the location, installation and use of the Product are the responsibility of the original purchaser, and CHORE-TIME shall not be liable for any damages which may result from non-compliance with such rules.

The following circumstances shall render this Warranty void:

- Modifications made to the Product not specifically delineated in the Product manual.
- Product not installed and/or operated in accordance with the instructions published by the CHORE-TIME.
- All components of the Product are not original equipment supplied by CHORE-TIME.
- Product was not purchased from and/or installed by a CHORE-TIME authorized distributor or certified representative.
- Product experienced malfunction or failure resulting from misuse, abuse, mismanagement, negligence, alteration, accident, or lack of proper maintenance, or from lightning strikes, electrical power surges or interruption of electricity.
- Product experienced corrosion, material deterioration and/or equipment malfunction caused by or consistent with the application of chemicals, minerals, sediments or other foreign elements.
- Product was used for any purpose other than for the care of poultry and livestock.

The Warranty and Extended Warranty may only be modified in writing by an officer of CHORE-TIME. CHORE-TIME shall have no obligation or responsibility for any representations or warranties made by or on behalf of any distributor, dealer, agent or certified representative.

Effective: **April, 2014**

## Safety

### DANGER: Electrical Hazard

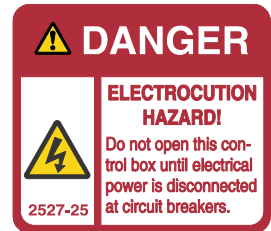
Disconnect electrical power before inspecting or servicing equipment unless maintenance instructions specifically state otherwise.

Ground all electrical equipment for safety.

All electrical wiring must be done by a qualified electrician in accordance with local and national electric codes.

Ground all non-current carrying metal parts to guard against electrical shock.

With the exception of motor overload protection, electrical disconnects and over current protection are not supplied with the equipment.



### Decal Descriptions

#### DANGER: Moving Parts

Disconnect electrical power before working on system, equipment may start automatically. Otherwise personal injury will result.

Severe personal injury will result if the equipment is operated without covers properly installed.





# Introduction

The Manure Drive is designed to attach to the end of a Cage System and drive the Belts for Manure removal.

## Features:

- One Bolt per side to easily adjust Belt tracking and Pinch.
- Linkages and Levers allow engaging/disengaging of multiple scrapers on different Tiers.
- Uses individual, spring loaded Snub Scrapers for each Snub Roller to keep Rollers clean and improve Tracking.
- Scrapers track along w/their respective Rollers.
- Main Scraper is made from UHMW plastic, and is replaceable toollessly and easily cleaned.
- Pinch Indicator facilitates achieving an even pinch on both sides.
- Hard stops prevent over-tightening of Shafts.
- Levers are adjustable and removable.

## Getting Familiar with the Drives

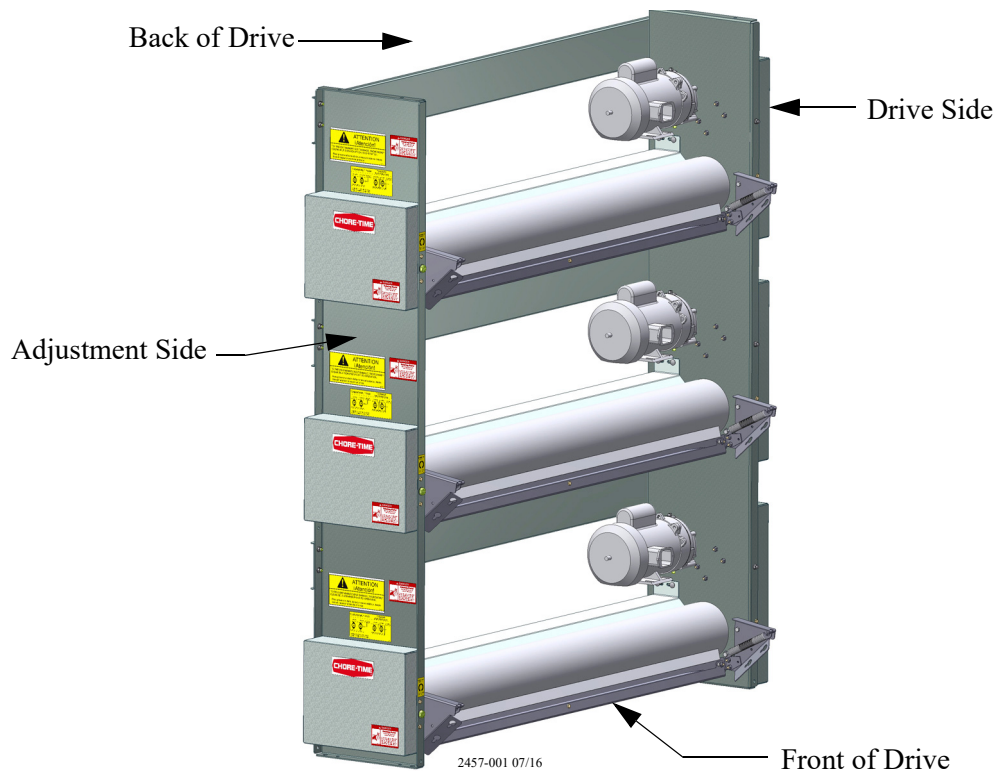
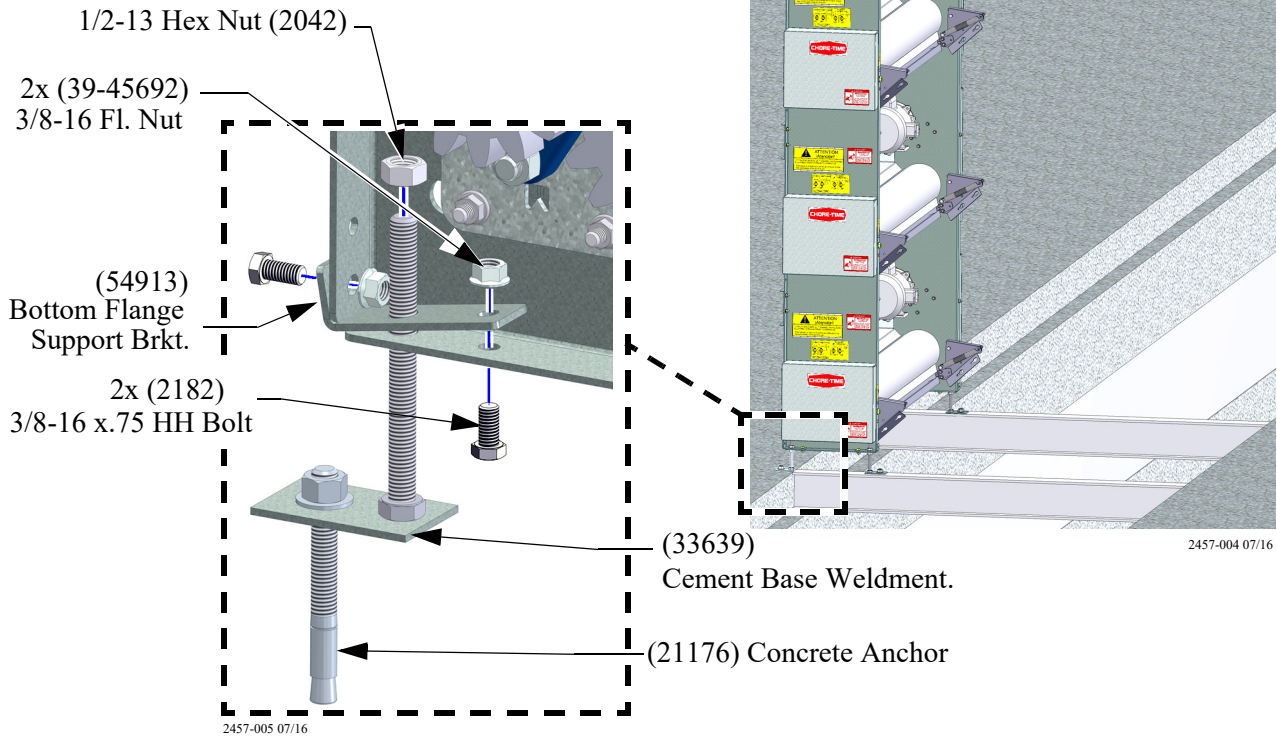


Figure 1. Getting Familiar with Drives

# Installation

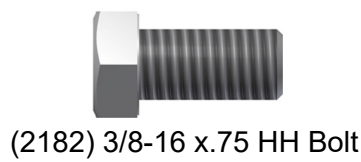
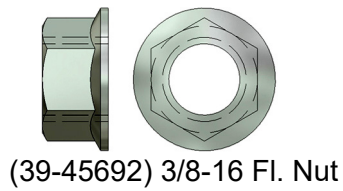
## Attaching Feet to Bottom Drives

For Drive Placement, see **Figure 3.** on page 7.



**Figure 2.**Attaching Feet to Bottom Drive

Note: Hardware is Full Scale and comes in (48058) Drive and Idler Assembly Kit.



# Placement of the Drive Unit

Use the dimensions shown below to assure that the Drive unit is square with the Row Centerline.

Place the Drive Unit with the Front of the Drive unit 1/3 of the width of the Conveyor away from the Edge of the Conveyor Belt as shown.

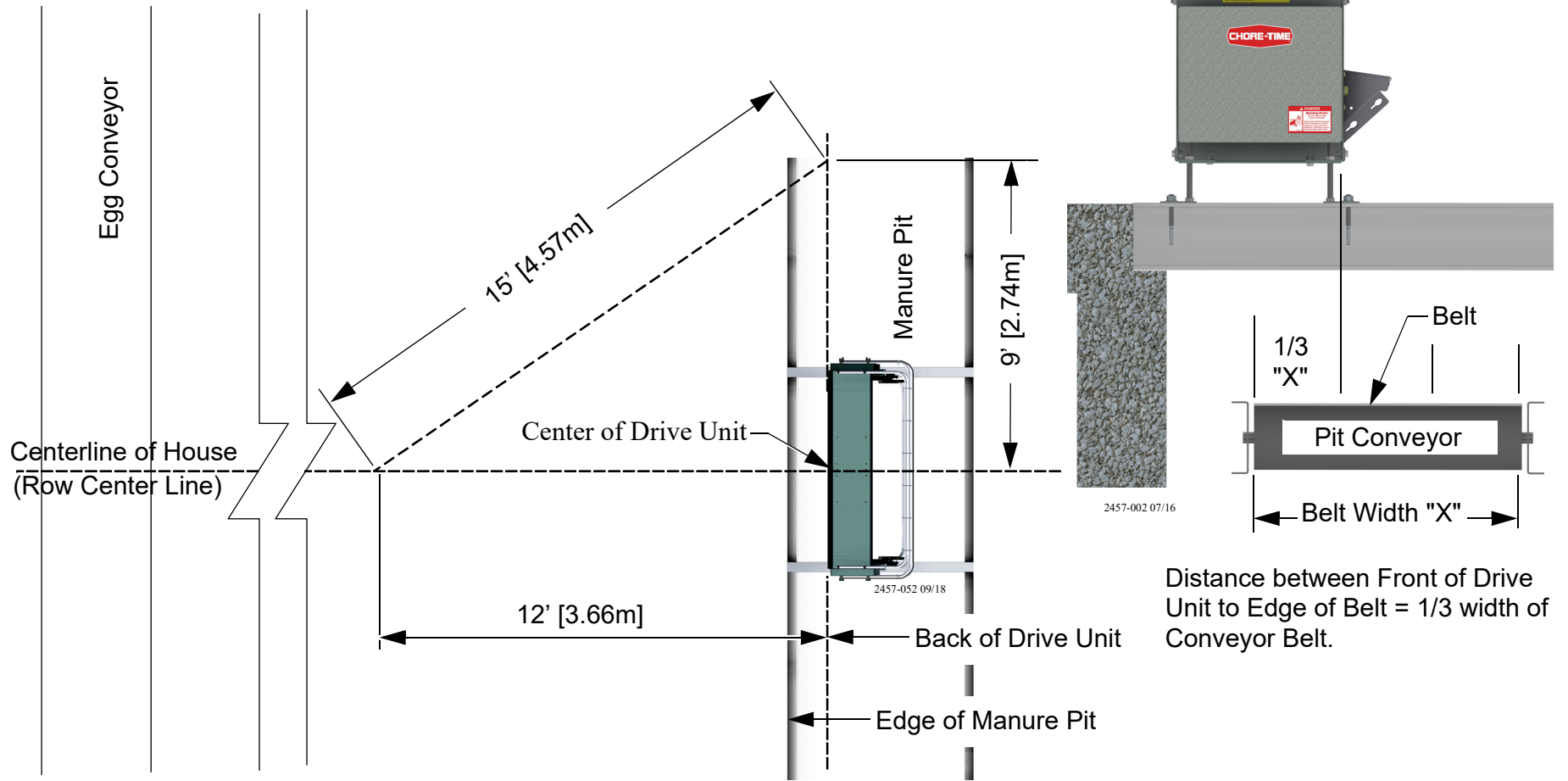
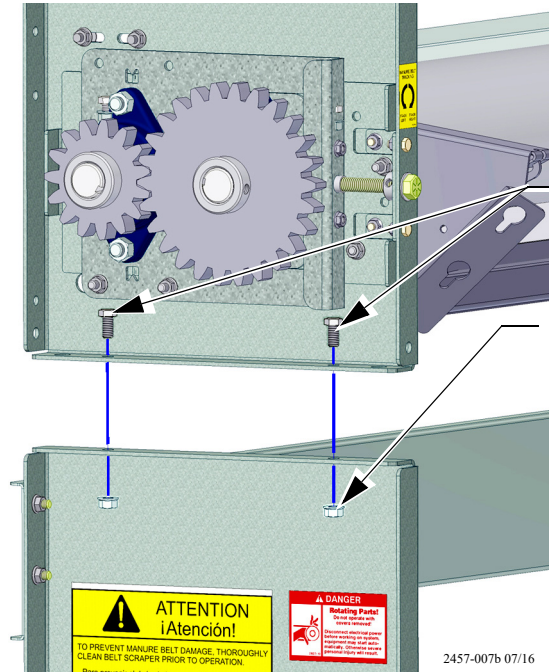
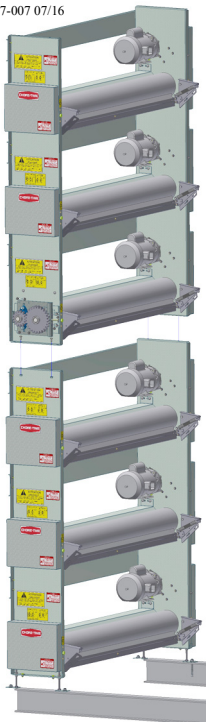


Figure 3. Drive Unit Placement

# Setting the Middle Tier Drives

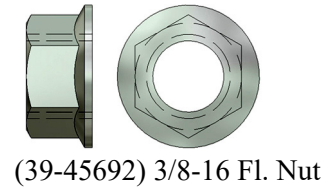
## Tiers without Walkways

2457-007 07/16

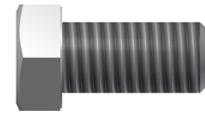


(2182) 3/8-16 x 3/4 HH Bolt

(39-45692) 3/8-16 Fl. Nut



(39-45692) 3/8-16 Fl. Nut



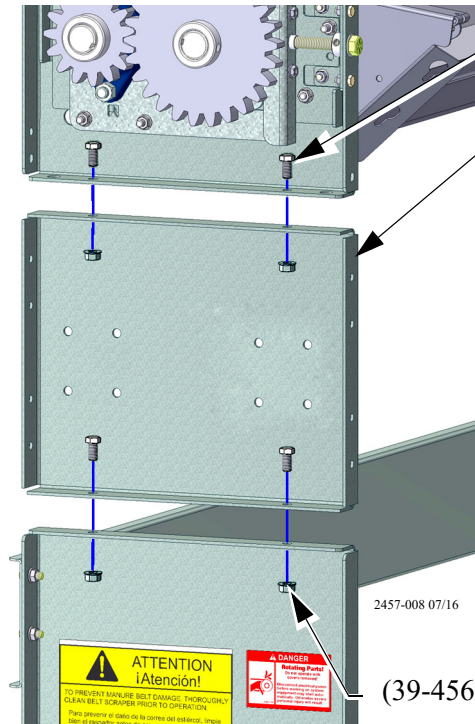
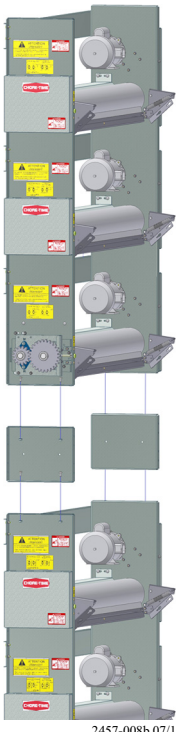
(2182) 3/8-16 x .75 HH Bolt

Figure 4.Middle Tier Drives

## Walkway Tiers

### Filler Panels

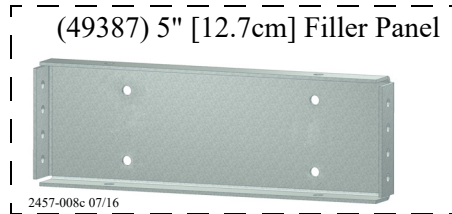
Tiers with Walkways require a Filler Panel. There are two sizes of Filler Panels: 12" [30.5 cm] and 5" [12.7cm]. Install Filler Panels as shown in **Figure 5.** below.



(2182) 3/8-16 x 3/4 HH Bolt  
Typical 4 places

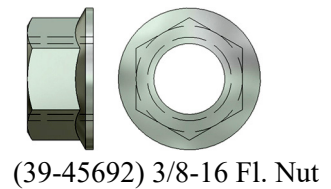
(48403) 12" [30.5cm] Filler Panel

(49387) 5" [12.7cm] Filler Panel

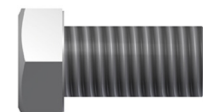


2457-008c 07/16

Hardware: Full Scale



(39-45692) 3/8-16 Fl. Nut



(2182) 3/8-16 x .75 HH Bolt

Figure 5.Filler Panels



### Cross Braces (without walkway)

For non-walkway tiers, remove the Cross Brace from the top of the bottom most Drive Unit and move to new location straddling the two Drive Units. Re-attach with existing hardware.

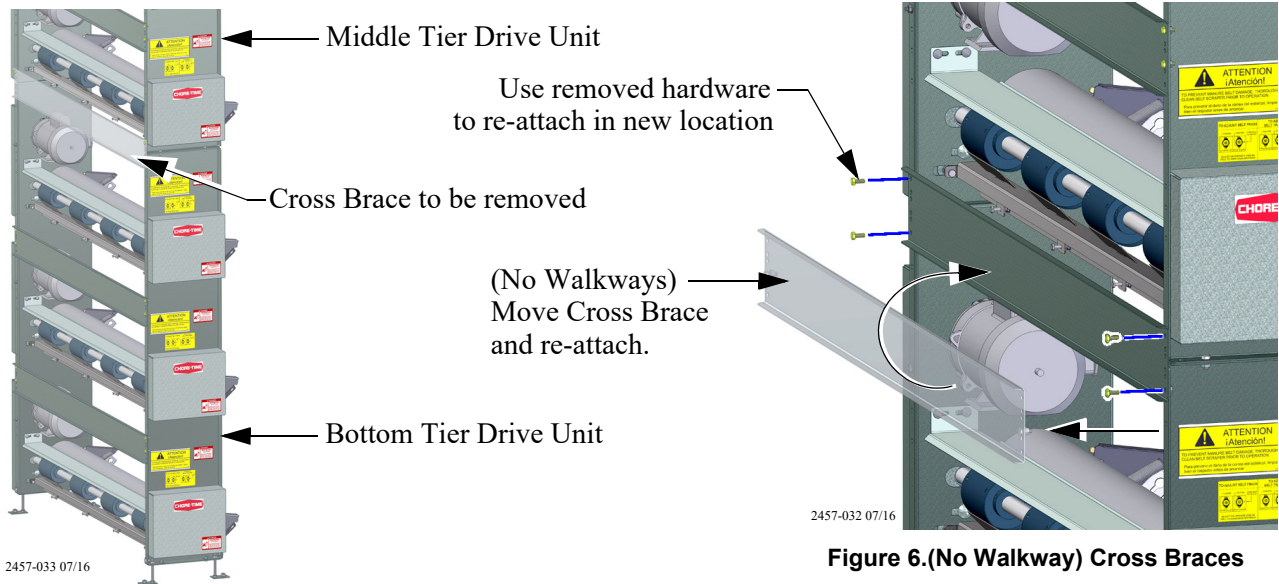
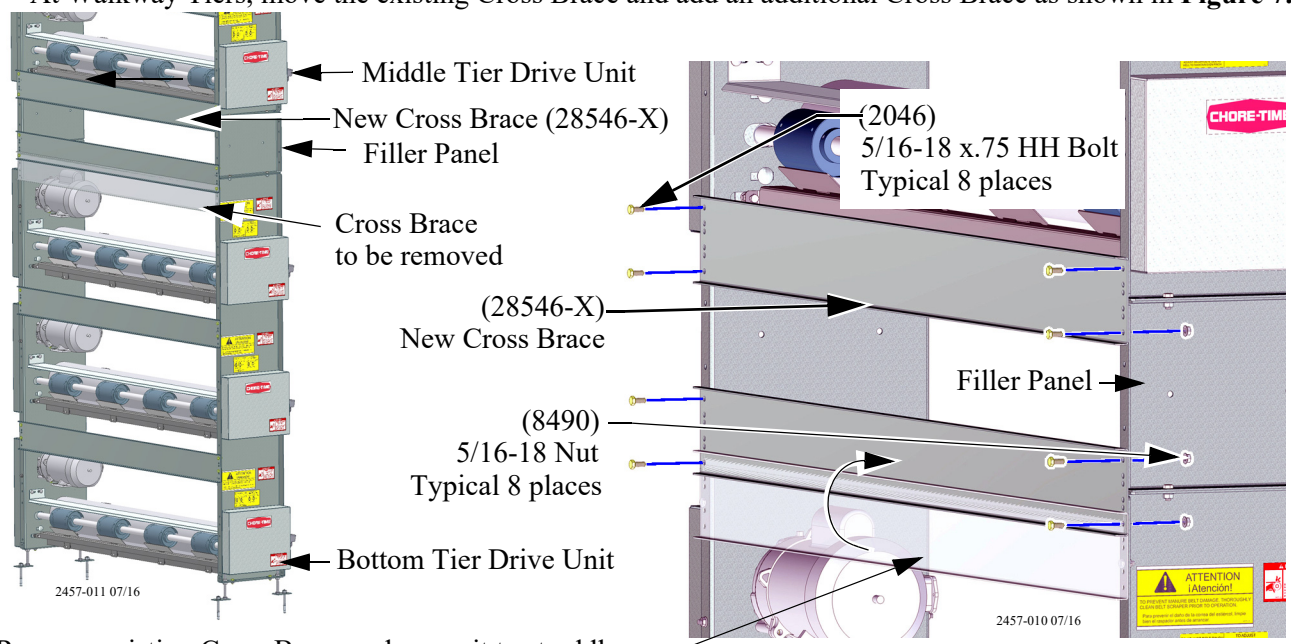


Figure 6.(No Walkway) Cross Braces

### Cross Braces (with walkway)

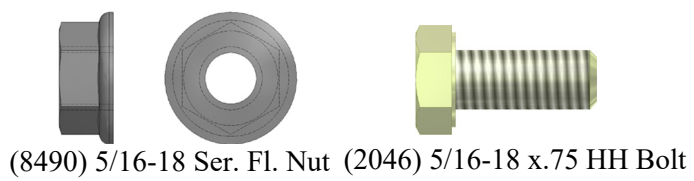
At Walkway Tiers, move the existing Cross Brace and add an additional Cross Brace as shown in Figure 7.



Remove existing Cross Brace and move it to straddle Filler Panel and Drive Unit for Walkway Tiers

Note: 12" Filler Panels Shown. Assembly the same for 5" Filler Panels.

Figure 7.Cross Braces (with Walkway)



### Top Panel

Install a Top Panel and Top Curtain Rod (48606-X) as shown. The Top Curtain Rods are shorter than the walkway Curtain Rods.

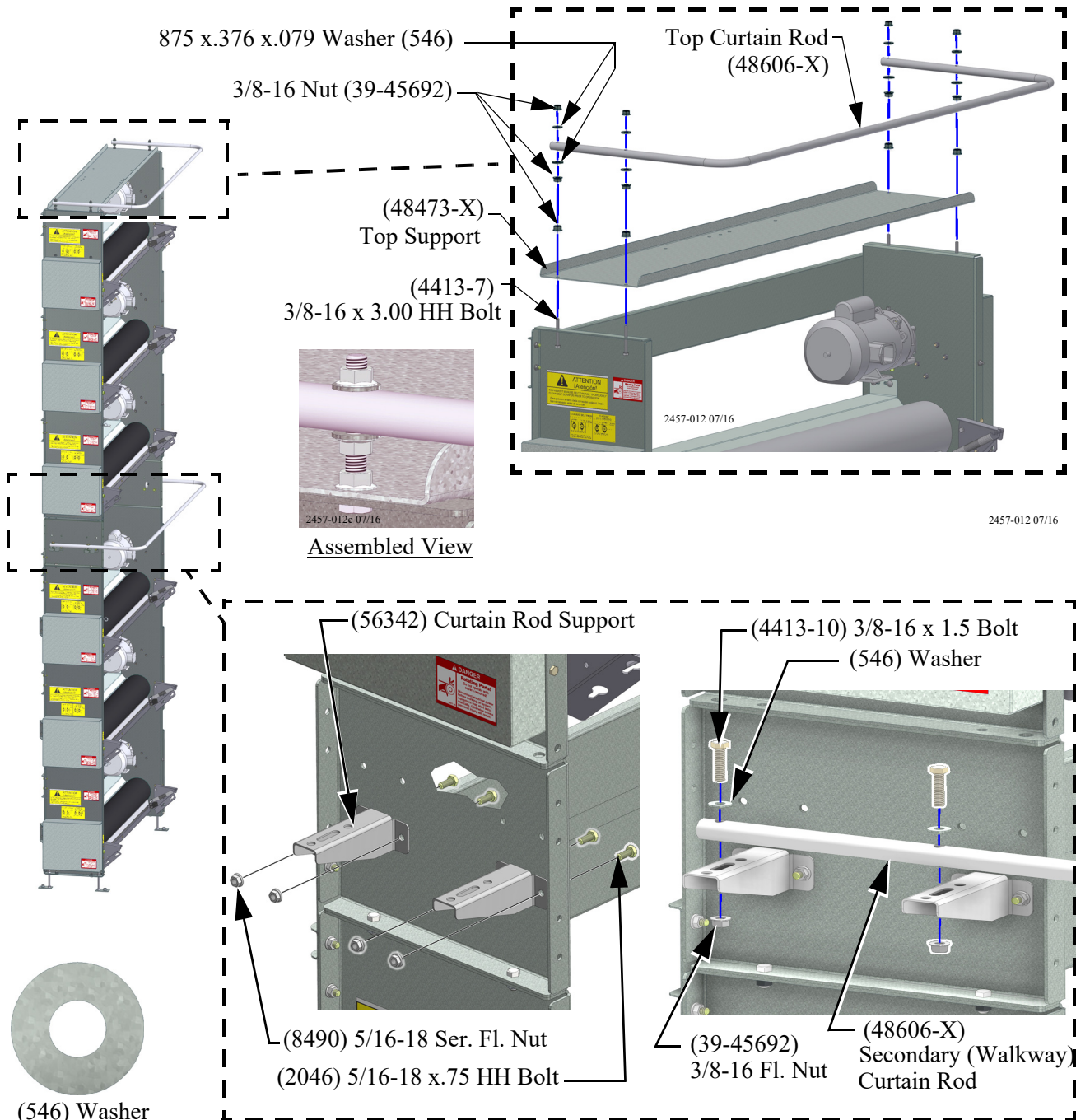
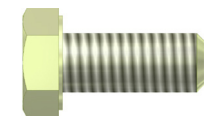


Figure 8. Top Panel and Curtain Rods



(2046) 5/16-18 x.75 HH Bolt



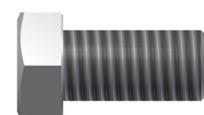
(8490) 5/16-18 Ser. Fl. Nut



(39-45692) 3/8-16 Fl. Nut



(4413-10) 3/8-16 x 1.5 Bolt



(2182) 3/8-16 x.75 HH Bolt



(4413-7) 3/8-16 x 3.0 Bolt



## Attaching to the Cage Assembly

1. Use Drive Rails (48963-X) to attach the Drive Units to the Cage Assembly as shown.

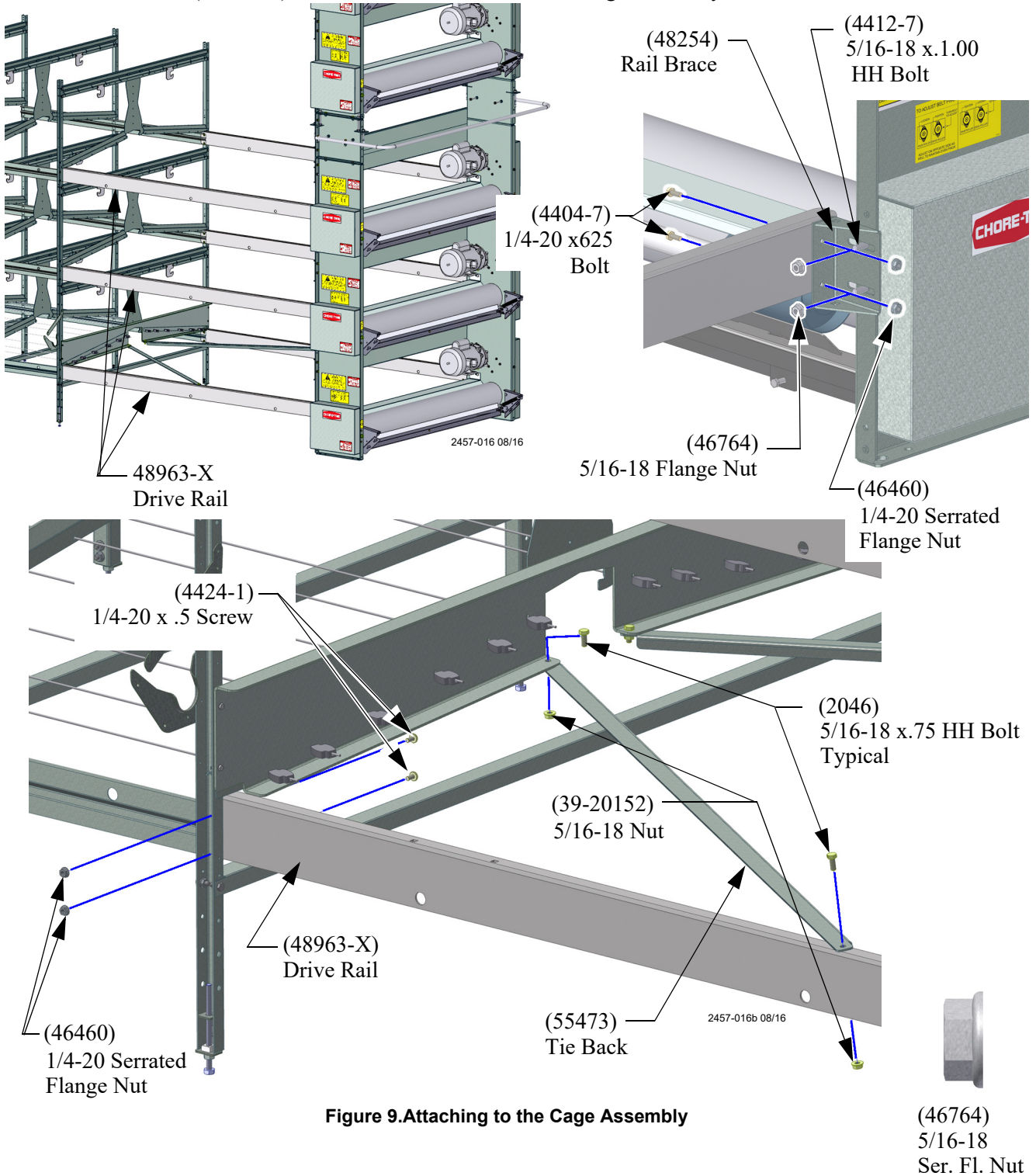
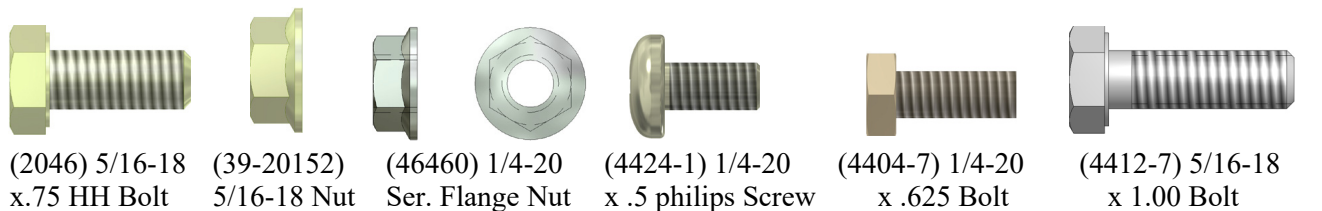


Figure 9. Attaching to the Cage Assembly



## Manure Scraper Linkage Kit and Levers

### Linkage Kit installation

Using tier to tier linkages and a Lever, as many as 6 tiers of Scrapers can be engaged/disengaged from the Drive Rollers in a single motion. Install Linkage Kits as shown below.

### Pivot Arm Installation

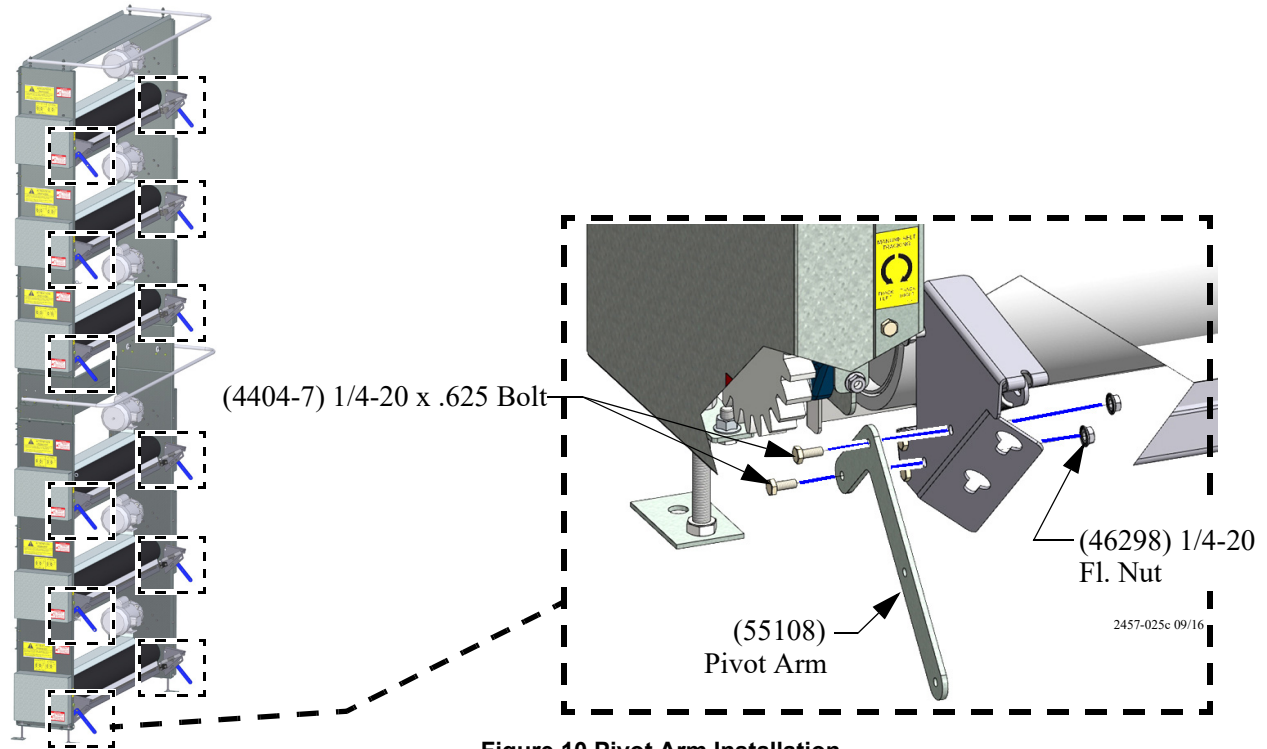


Figure 10.Pivot Arm Installation

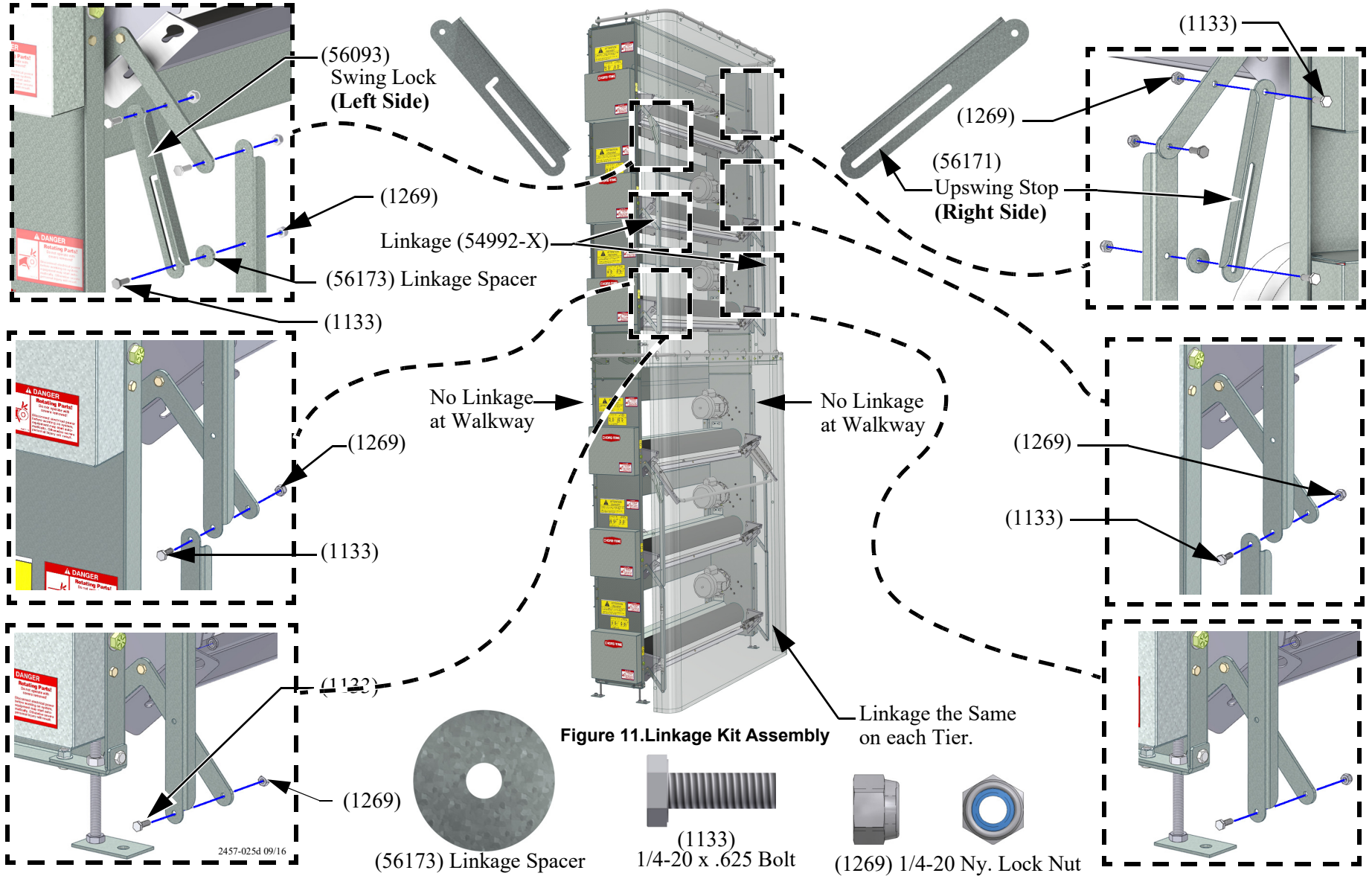


### Linkage Kit Assembly

Do not Install Linkage Kits at Walkway Tiers! See Figure 11.

Install Swing Lock where you plan to install Lever. See "Lever Installation" on page 19.

**Important!** Do not tighten Nuts all the way down. Linkage must be able to rotate.



## Belt Installation

Linkage Kits should already be installed prior to Belt installation so Scrapers can be disengaged and to prevent Spring over-rotation.

See **Figure 12.** for the correct way to feed the belt.

The Belt surface the Manure will rest on should be **curled down as shown.**

**Warning!** Be careful to avoid pinching fingers in rollers!

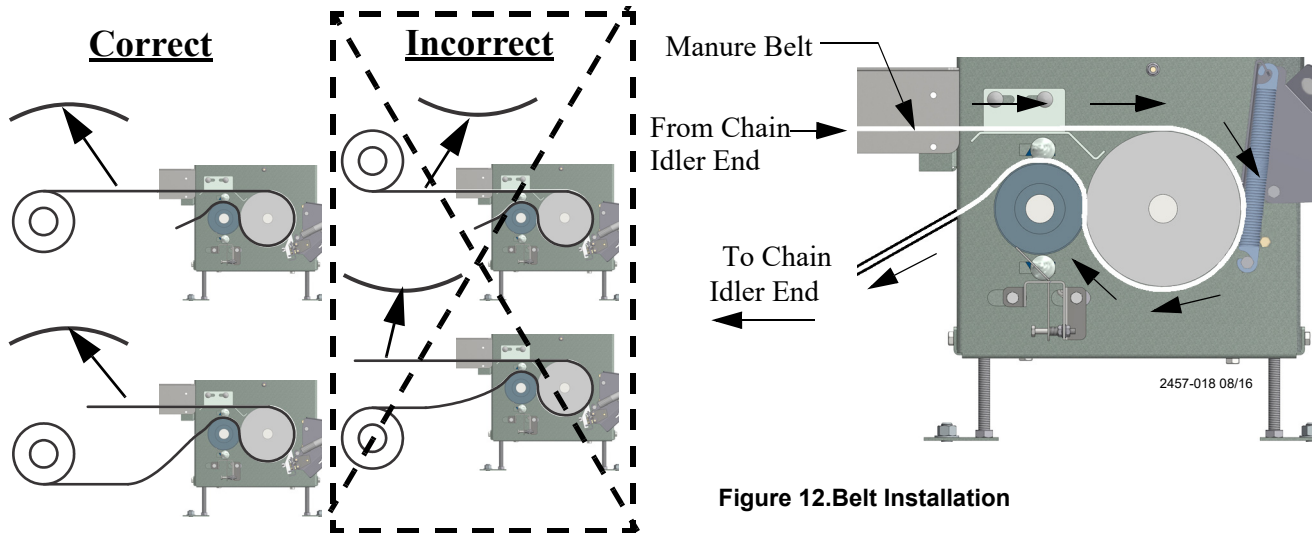
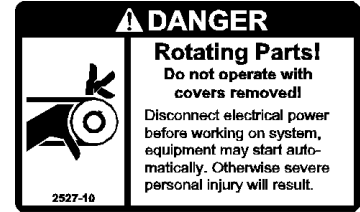


Figure 12. Belt Installation

## Welding the Belt

1. Cut the Belt ends at an angle as shown with a 4" [10 cm] overlap as shown in **Figure 13.**
2. Overlap the Belts with the Belt from the Manure Drive end on top of the Belt from the Idler End as shown. Failure to do so could cause the Belt to get caught causing damage to the Belt!
3. Sonic Weld the Belt ends together **as shown.**

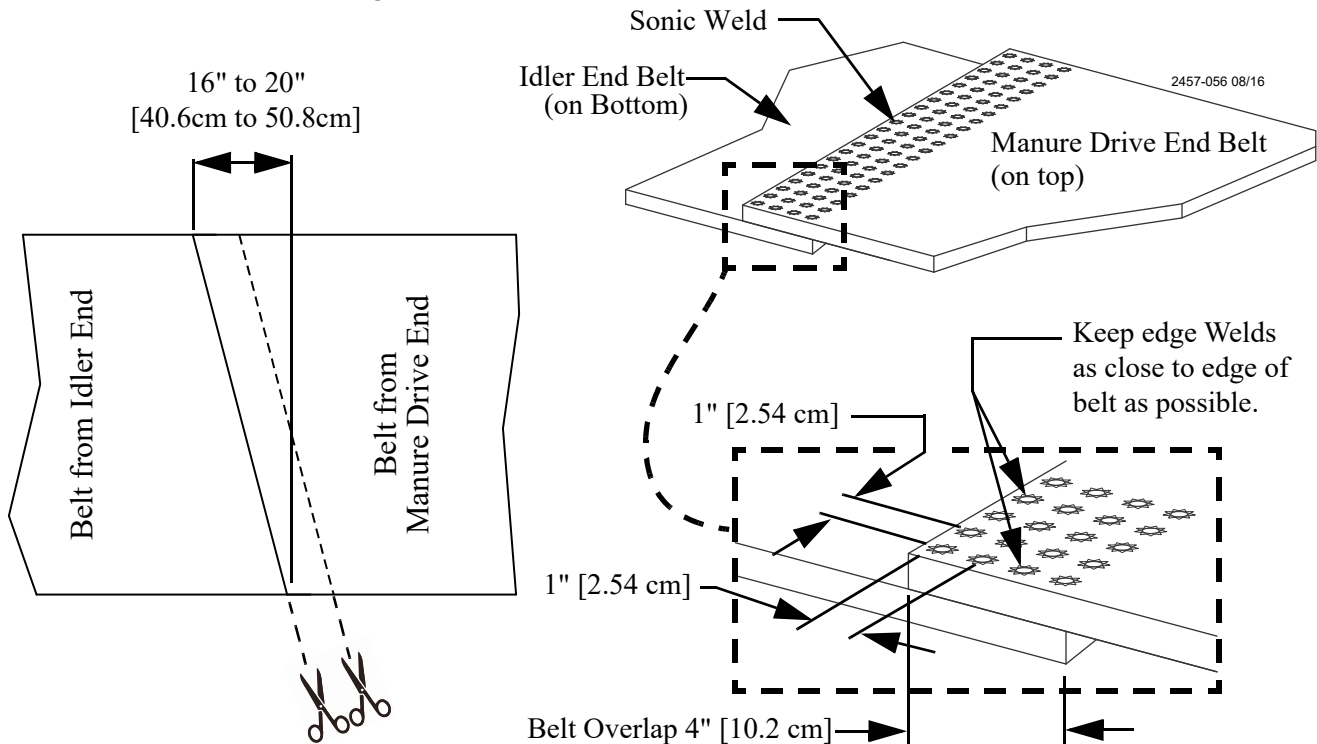


Figure 13. Belt Welding

## Tensioning Belt

**Note:** Belt tensioning information also shown in Chore-Time manual ME2442.

When the Belt is running, the Tension should be maintained such that the Sag is between 9"-18" [22.9cm-45.7cm] at the Drive end. Tensioning adjustments are made at the Idler end of the system.

**Note:** Belts should be loosened when the house is depopulated. They shrink at lower temperatures.

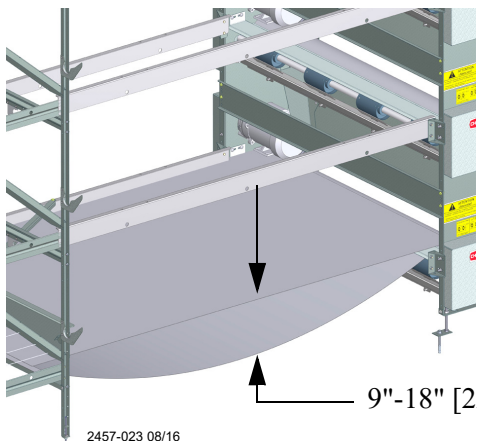


Figure 14. Belt Sag

### Coarse Tension Adjustment

The Belt can be Tensioned in Large increments using the Sprocket and Catch Mechanism.

### Tightening the Belts

One person can increase belt tension by placing a 3/4" Wrench onto the end of the Hex Shaft protruding from either side of the system See Figure 15. Make sure that the Sprocket Catch engages the Sprocket when finished tightening.

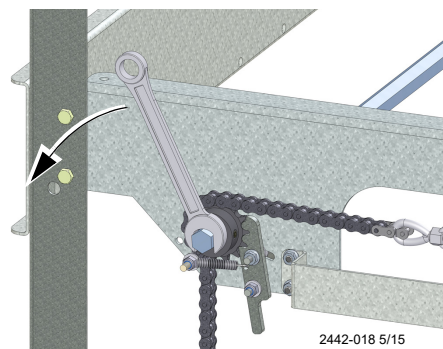


Figure 15. Coarse tension Adjustment (Tightening)

### Loosening the Belts

1. Two people (one on each side) are required to loosen the belts in large increments.
  2. Put a 3/4" Wrench on one end of the Hex Shaft and turn the wrench as if to tighten the belt until the teeth of the Sprocket Catch are disengaged with the Sprocket.
- Danger!** When the Sprocket Catches are disengaged keep a tight grip on the wrench and keep hands away from pinch points!
3. Once the teeth are disengaged, press the Sprocket Catches on both sides (requires person on other side) to allow the Hex Shaft to rotate freely.
  4. Turn the wrench Carefully toward the Auger Idler until the desired tension is reached and release the Sprocket Catches.
  5. Make sure that the Sprocket Catch teeth are engaged completely with the Sprockets.

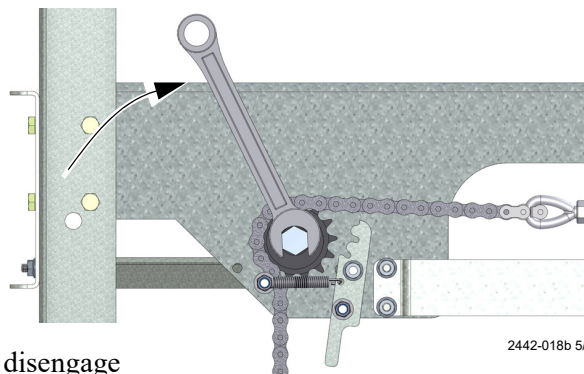
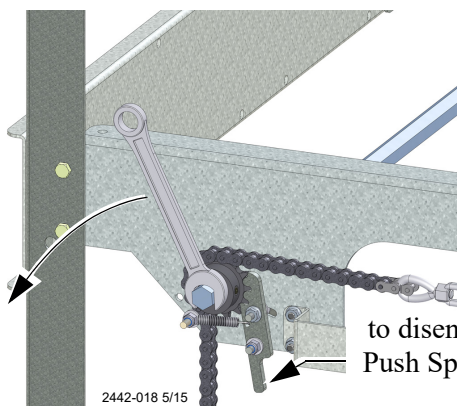


Figure 16. Large tension Adjustment (Loosening)



### Fine Tension Adjustment/Belt Tracking

**Note:** Using the Turnbuckles for tracking should only be used when all other methods are not working. Belt Tracking and over-all tension can be adjusted and maintained using the Turnbuckles at the Idler end. The Belt tension can be fine tuned by using the Turnbuckles **as shown below**. The Belt can be tightened on one or both sides to the desired tension.

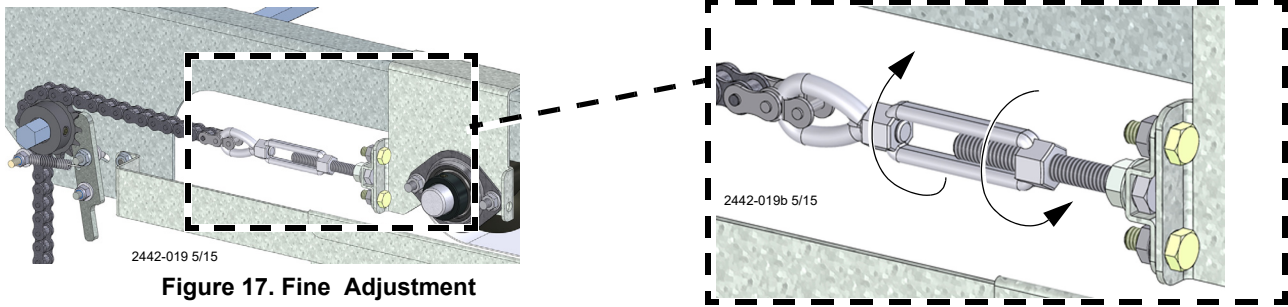


Figure 17. Fine Adjustment

### Setting the Belt Pinch point

Pinch point is the point of contact where the Belt is pinched between the Drive Roller and the Snub roller.

1. Remove the Cover from the side of the Drive unit.
2. The Pinch point should initially be set to the middle setting.
3. It may be necessary to adjust the pinch point if there is belt slipping or to help tracking if normal methods are not working. Pinch is normally set once and does not need to be adjusted.
4. Always adjust the belt pinch equally on both sides to maintain even pinch.
5. See the Decal below (decal also located above the Drive and Snub Rollers) for instructions on how to adjust the Belt Pinch.

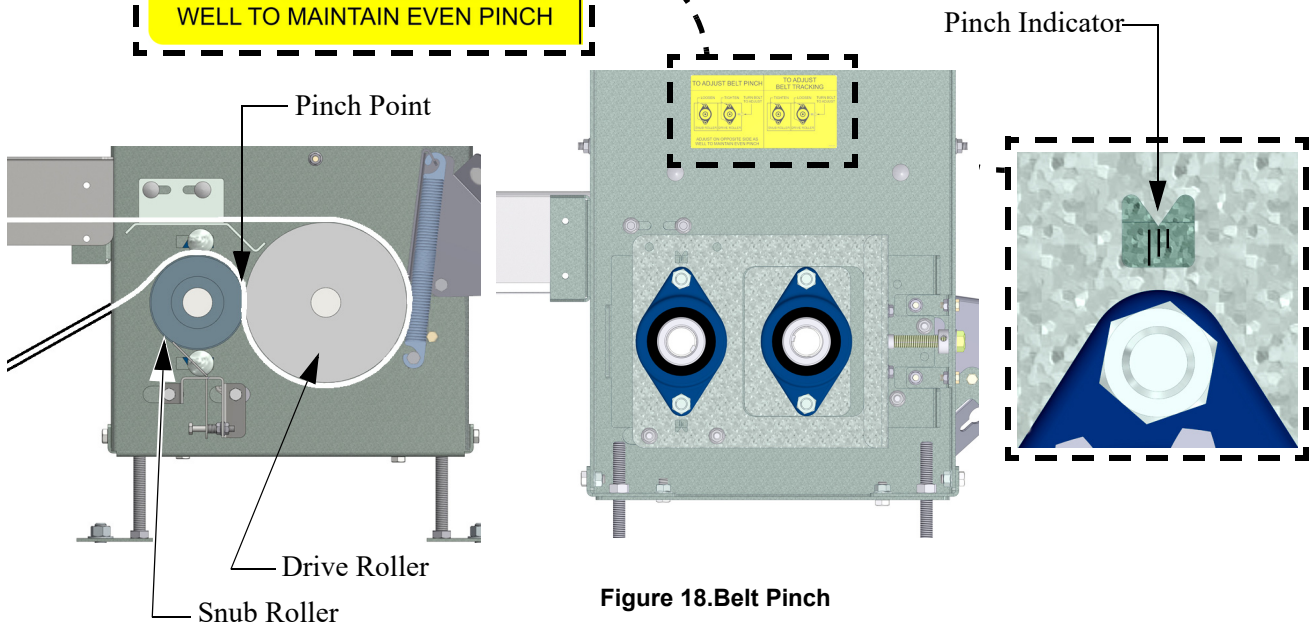
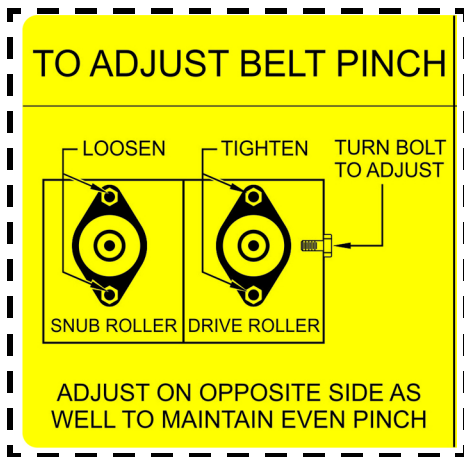


Figure 18. Belt Pinch

### Adjusting the Belt Tracking

Belt Tracking is the side to side alignment/angle of the belt in relationship with the Snub and Drive Rollers.

1. Remove the Cover from the side of the Drive unit.
2. Loosen the Drive Roller Nuts as shown below (See decal located above the Drive and Snub Rollers).
3. Use Adjustment Bolt to adjust the Belt tracking. (See Figure).
4. Re-tighten Nuts on the Driver Roller.

If Belt Tracking at the Drive end of the System is not responding, adjustments can also be made at the Idler end. See “Fine Tension Adjustment/Belt Tracking” on page 16.

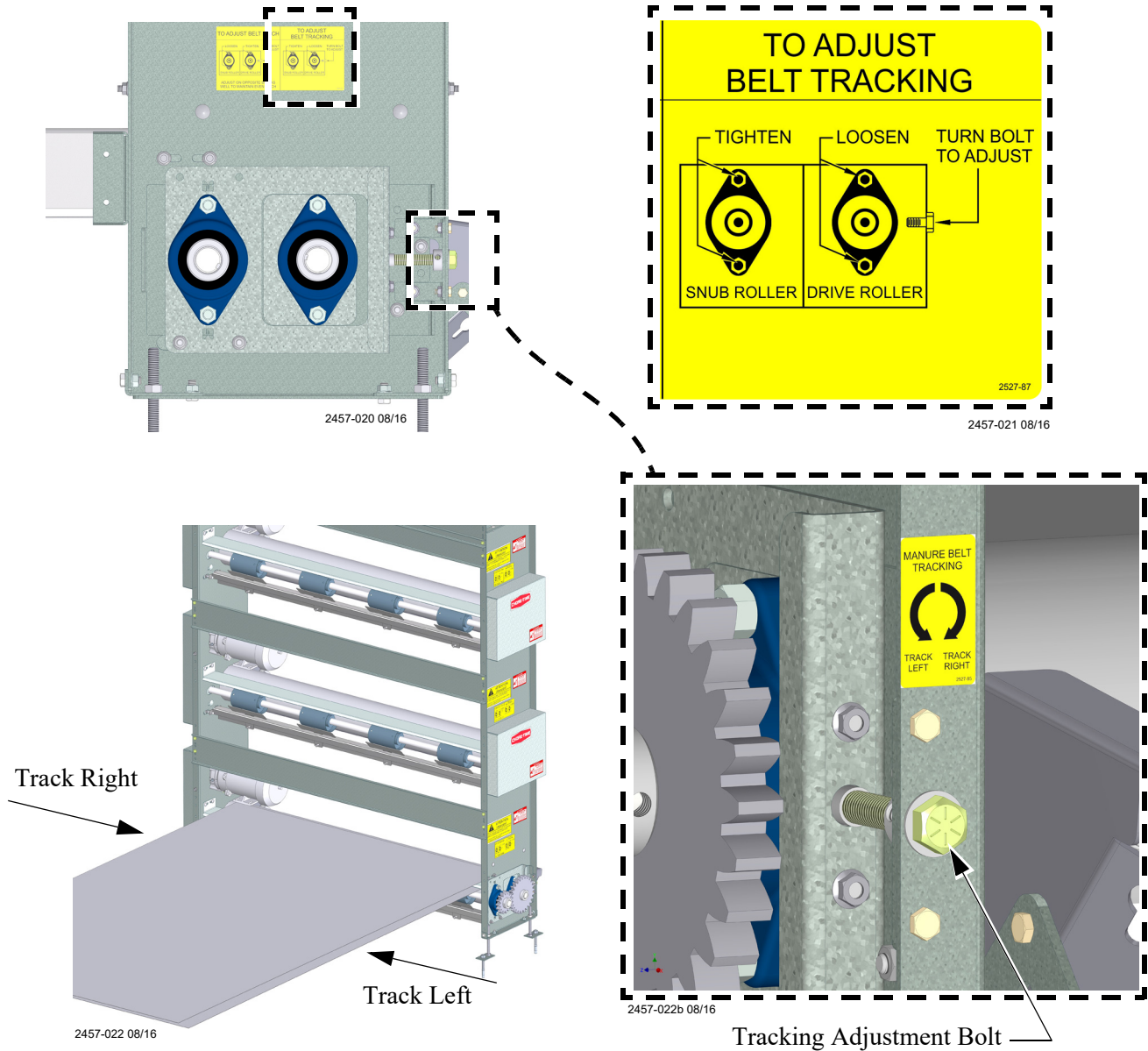
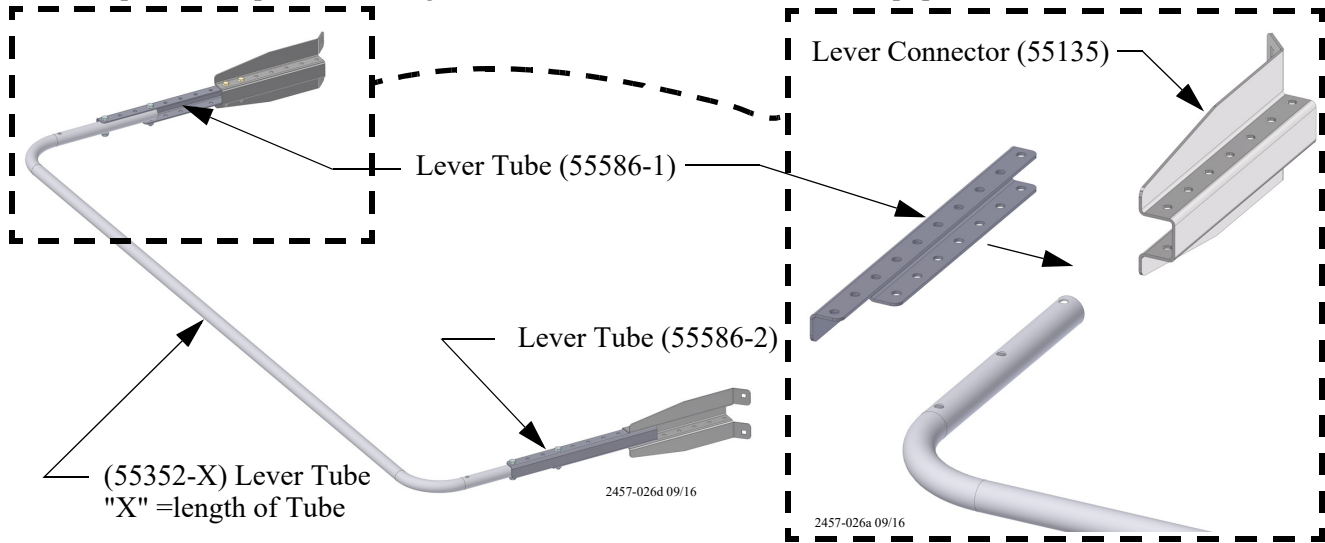


Figure 19. Belt Tracking

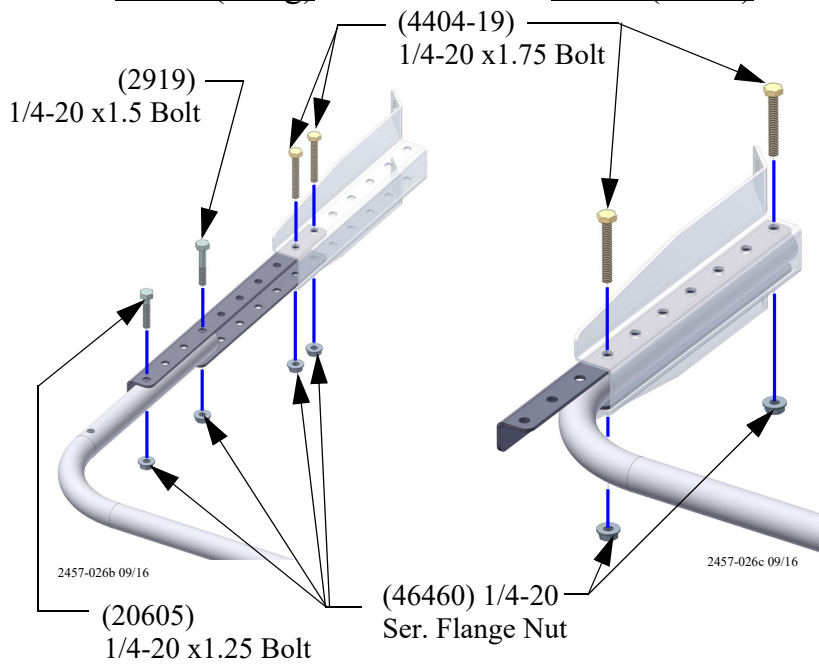
### Manure Scraper Lever Assembly

1. Assemble the Manure Scraper Levers as shown. Assemble the Handles with the maximum length possible to provide leverage, but check for clearance with other equipment.



#### Lever (Long)

#### Lever (Short)



Leave (46464) Nuts loose so the Handle Assembly can be inserted easily into slots. See Figure 21 (on page 19)

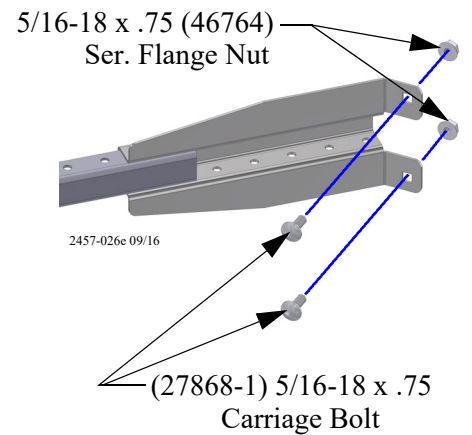


Figure 20. Manure Scraper Levers



(4404-19) 1/4-20 x 1.75 Bolt



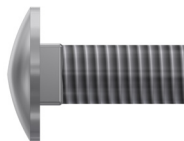
(4404-19) 1/4-20 x 1.25 Bolt



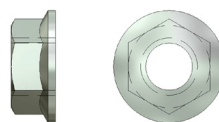
(4404-19) 1/4-20 x 1.5 Bolt



(46764) 5/16-18 x .75 Ser. Flange Nut



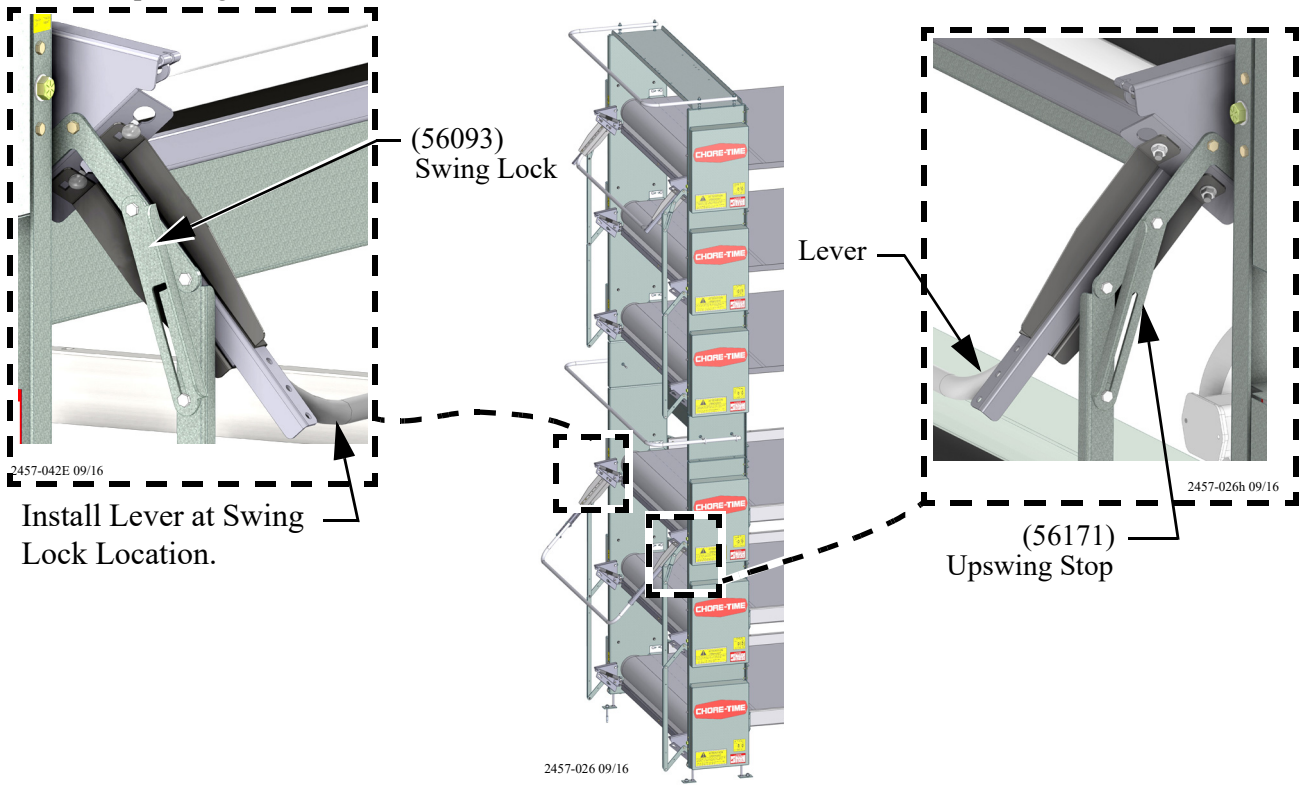
(27868-1) 5/16-18 x .75 Carriage Bolt



(46460) 1/4-20 Ser. Flange Nut

### Lever Installation

1. Install the Manure Levers as shown at **any tier** desired where there is no interference.
2. It is best to install Levers at Swing Lock location so Swing Stops and Upswing Stops can be easily accessed when operating.



Install Lever at Swing Lock Location.

Slide Lever Assembly down to lock bolt heads into the Keyhole slots and tighten down hardware.

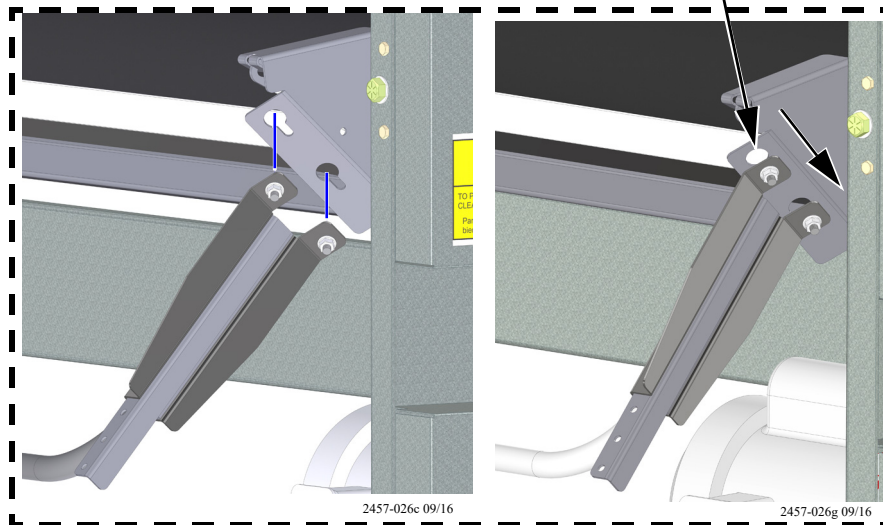


Figure 21. Installing Manure Scraper Levers

# Manure Curtains

## Curtain Installation location

To determine which Curtain to install at each tier for each system see the Chart below.

**Example:** A 10 tier MMB system with a 5" [12.7cm] walkways and tier configuration of 3-3-4 (3 tiers on bottom, 3 tiers in the middle, and 4 tiers on top) uses a 55633-3 on the 1st floor (ground level curtain), a 55633-3 curtain on the second floor (above the 1st walkway), and a 55633-4 curtain on the third floor (above the second walkway).

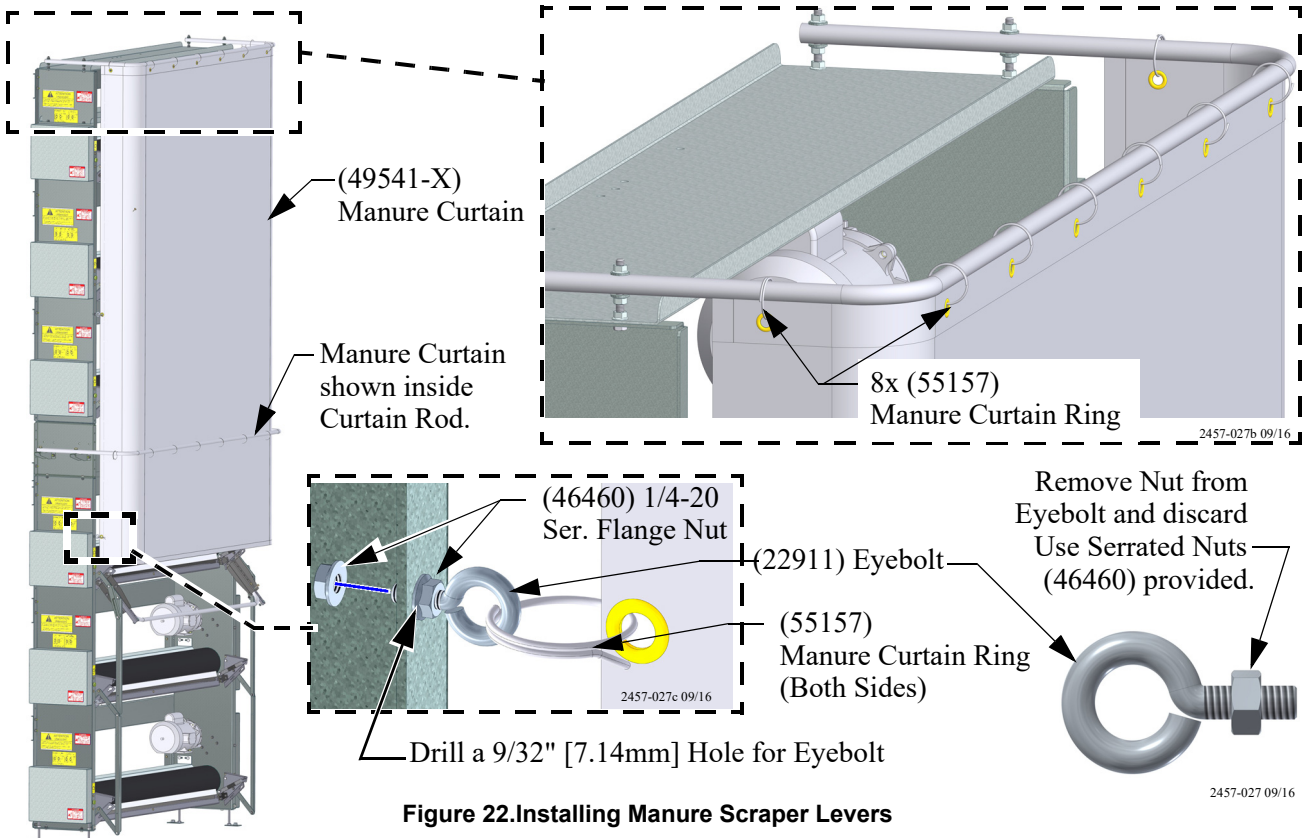
Curtain Part Numbers					
55633-3 90" Curtain	55633-4 112" Curtain	55633-5 135" Curtain	55633-6 160" Curtain	55633-7 184" Curtain	55633-8 206" Curtain

Cage System	Tier height	Walkway Height	Curtain Location	2 Tier	3 Tier	4 Tier	5 Tier	6 Tier	7 Tier	8 Tier	9 Tier	10 Tier				11 Tier						
				No w-way	No w-way	No w-way	No w-way	No w-way	(3-3)	(3-4)	(4-3)	(4-4)	(3-3-3)	(4-5)	(3-3-4)	(3-4-3)	(4-3-3)	(3-4-4)	(4-3-4)	(4-3-3)	(3-3-5)	
All MMB (5" WW)	22.5" [57.2cm]	5" [12.7cm]	4th Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	
			3rd Tier	--	--	--	--	--	--	--	--	-3	--	-4	-3	-3	-4	-4	-4	-3	-5	
			2nd Tier	--	--	--	--	--	--	-3	-4	-3	-4	-3	-5	-3	-4	-3	-4	-3	-4	-3
			1st Tier	--	-3	-4	-5	-5	-3	-3	-4	-4	-3	-4	-3	-3	-4	-3	-4	-3	-4	-3
All MMB (12" WW)	22.5" [57.2cm]	12" [30.5cm]	4th Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	
			3rd Tier	--	--	--	--	--	--	--	--	-3	--	-4	-3	-3	-4	-4	-3	-5		
			2nd Tier	--	--	--	--	--	-3	-4	-3	-4	-3	-5	-3	-4	-3	-4	-3	-4	-3	
			1st Tier	--	-3	-4	-5	-5	-3	-3	-4	-4	-3	-4	-3	-3	-4	-3	-4	-3	-4	-3
25.6 & 28.8 MMBBG	24" [70cm]	12" [30.5cm]	4th Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	
			3rd Tier	--	--	--	--	--	--	--	--	-3	--	-4	-3	-3	-4	-4	-3	-5		
			2nd Tier	--	--	--	--	--	-3	-4	-3	-4	-3	-5	-3	-4	-3	-4	-3	-4	-3	
			1st Tier	--	-3	-4	-5	-6	-3	-3	-4	-4	-3	-4	-3	-3	-4	-3	-4	-3	-4	-3
Versa, Versa 2 Ext'd Brood Grow, Versa Plus	26.5" [67.3cm]	12" [30.5cm]	4th Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	
			3rd Tier	--	--	--	--	--	--	--	--	3	--	5	3	3	5	5	3	6		
			2nd Tier	--	--	--	--	--	-3	-5	-3	-5	-4	-6	-4	-5	-4	-5	-4	-5	-4	
			1st Tier	--	-3	-4	-5	-6	-3	-3	-4	-4	-3	-4	-3	-3	-4	-3	-4	-3	-4	-3
2 + 2 Brood Grow	40" [101.6cm]	12" [30.5cm]	4th Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--				
			3rd Tier	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--				
			2nd Tier	--	--	--	--	--	--	--	--	-3	--	--	--	--	--	--				
			1st Tier	--	--	-3	--	-4	--	--	--	-3	--	--	--	--	--	--				

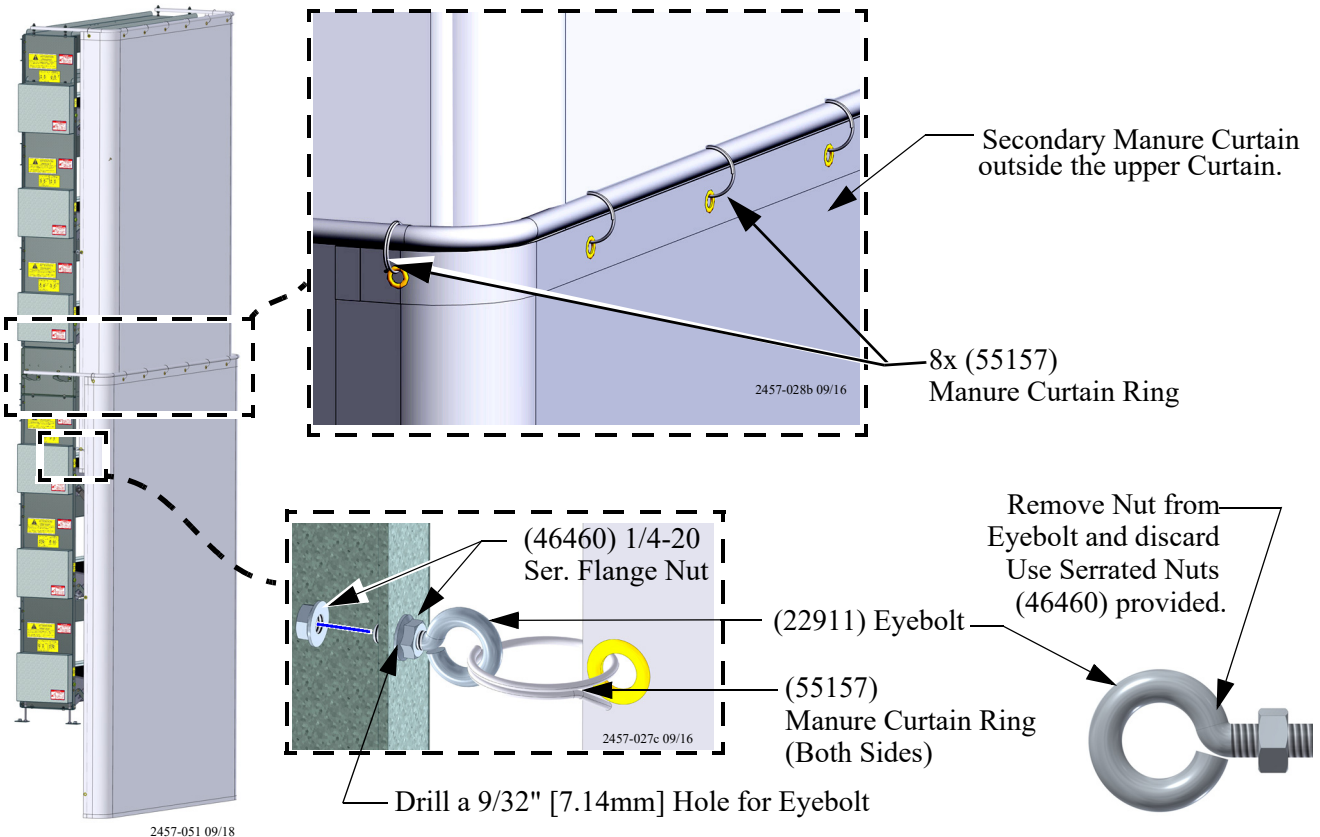


### Installation

1. Install top Manure Curtains **as shown**. Curtains can go inside or outside the Levers according to preference. In the example shown they are outside. Handles do get dirty if Curtains are outside.



2. Install Secondary (Walkway) Manure Curtains.



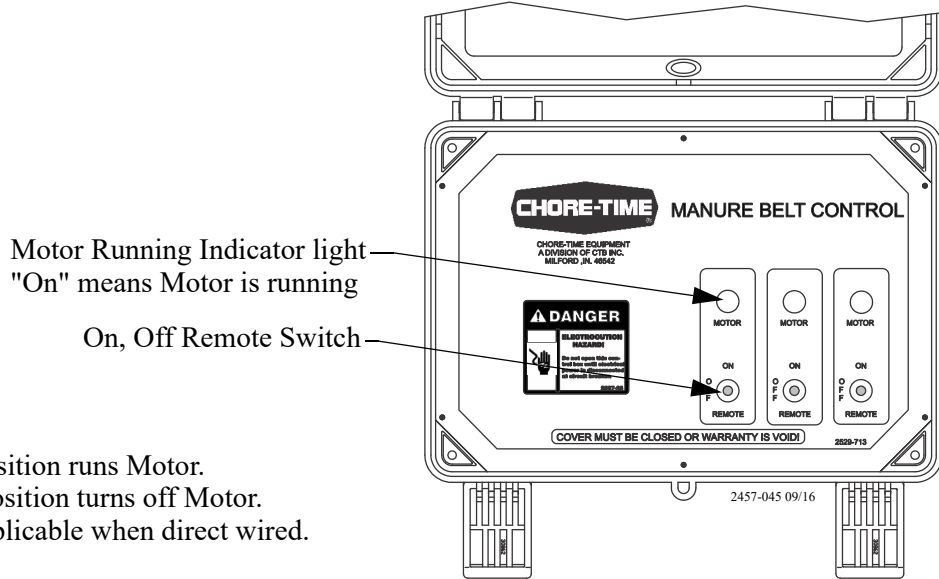
# Operation

## Frequency of Running

1. Only run 3 tiers per row at a time.
2. Chore-Time recommends running the Manure Belts 3 times per week: Monday, Wednesday, Friday for example.
3. Belts should only be run half the length of the house at one time, leaving half of the Belts loaded. Failure to leave the belts loaded could result in bad belt tracking.

## Using the Manure Belt Control

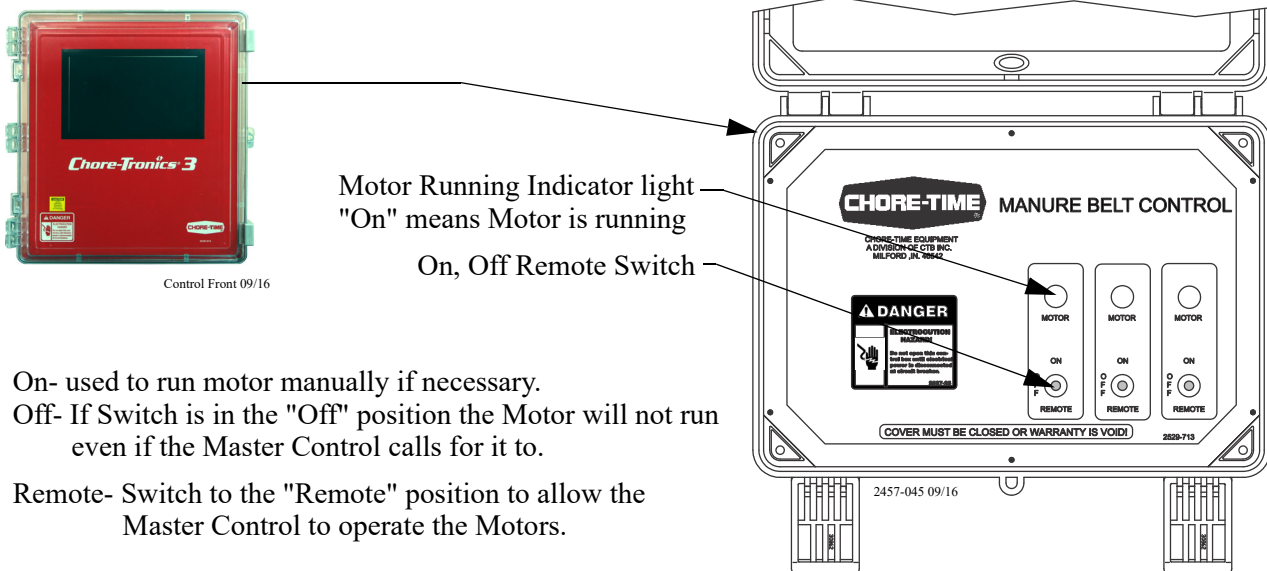
### Manure Belt Control Direct Wired



On- Switch in the "On" position runs Motor.  
 Off- Switch in the "Off" position turns off Motor.  
 Remote- Remote is not applicable when direct wired.

Figure 23. Manure Belt Control (Direct Wire)

### Manure Belt Control using a Master Control



On- used to run motor manually if necessary.  
 Off- If Switch is in the "Off" position the Motor will not run even if the Master Control calls for it to.  
 Remote- Switch to the "Remote" position to allow the Master Control to operate the Motors.

Figure 24. Manure Belt Control (Master Control)

### Scraper Lever Operation

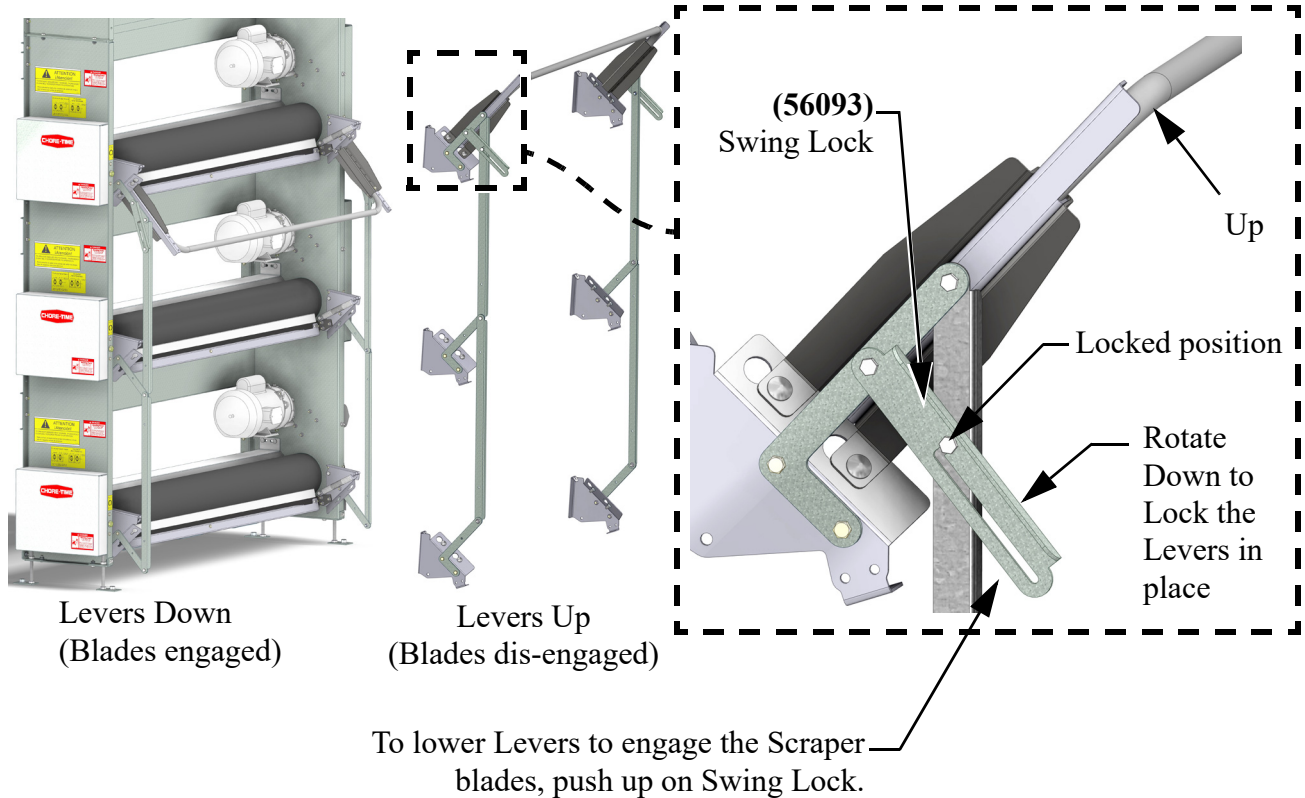
To disengage Scraper Blades, lift up on levers. Just apply solid pressure to operate the Handles. **Try to avoid jerk or slamming the Levers.**

**Warning!** Use Caution when operating Levers to avoid getting hands Pinched.



**Important!** When Scraper Handle is in the up position, use the Swing Lock (56093) to lock it in place as shown in **Figure 25.**

To re-engage the Scraper Blades, push up on the Swing Lock and pull down on the Lever.



**Figure 25. Operating Scraper Levers**

# Wiring

## Manure Drive Control Wiring

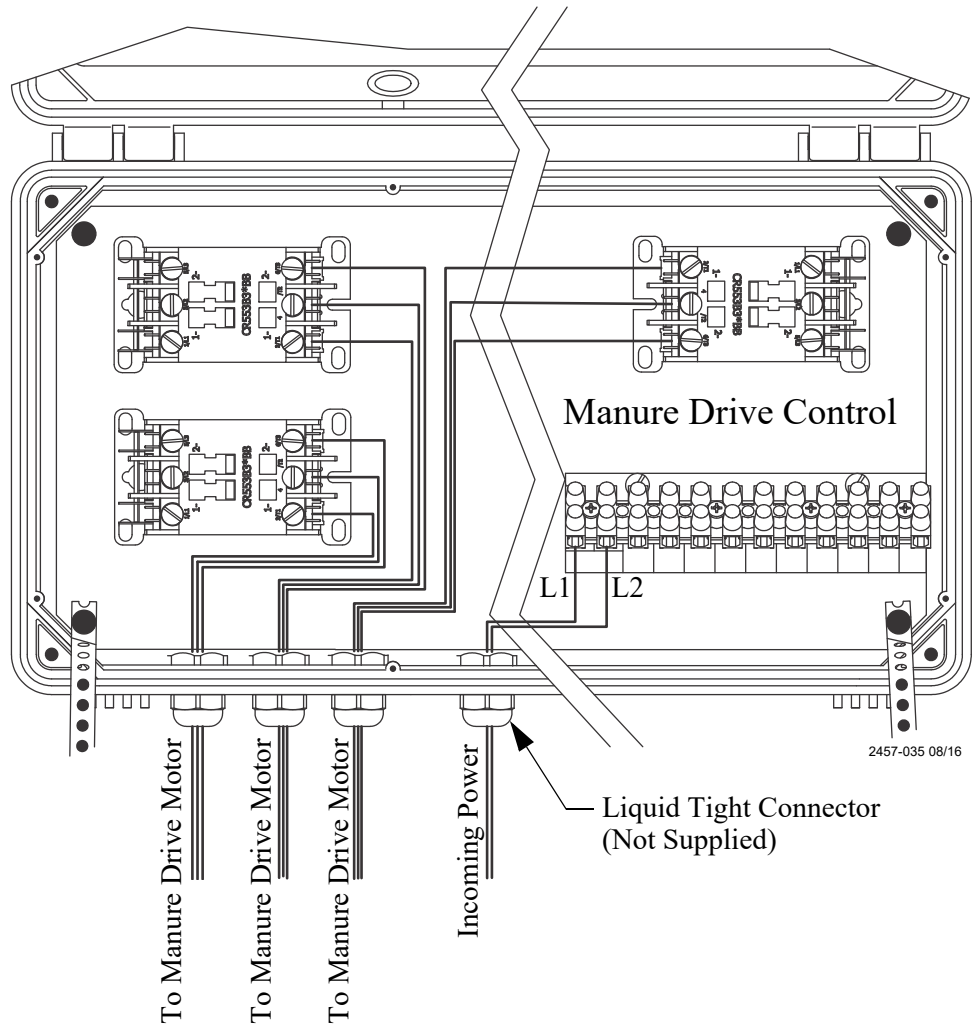


Figure 26. Control Wiring

# Maintenance

## Routine Maintenance

### Cleaning

1. Chore-Time recommends cleaning the Scrapers each time the Belts are run. Clean once a week minimum.

### Lubricate Bearings

1. Grease all Bearings every quarter (3 months) and between each flock after wash down.

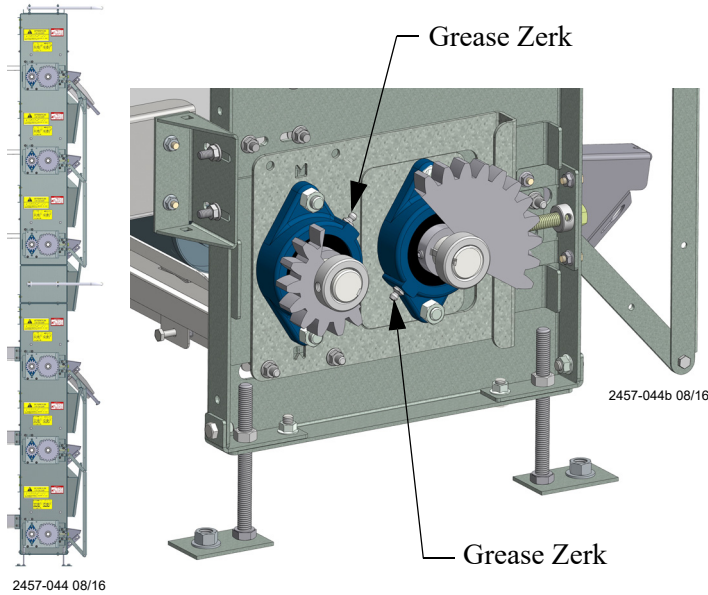


Figure 27. Grease Zerks

### Replacing Scraper Springs

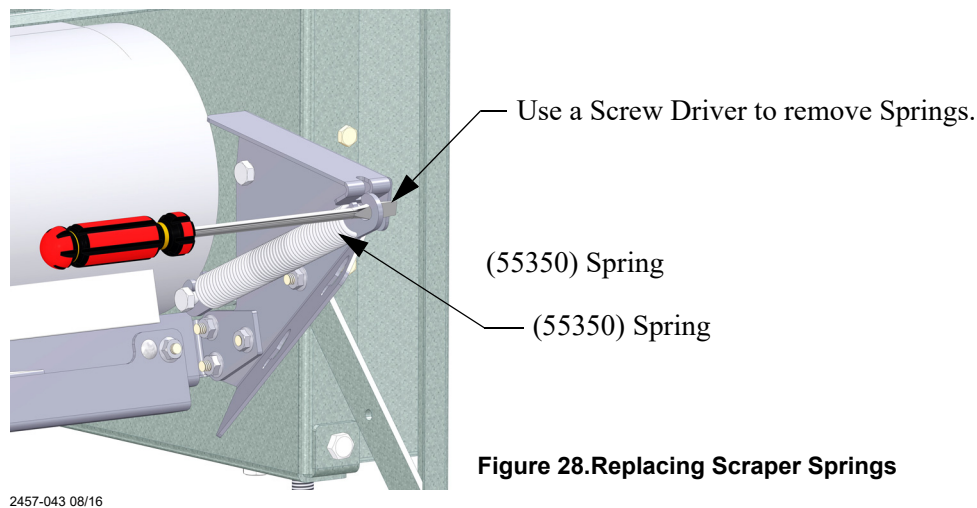


Figure 28. Replacing Scraper Springs



# Replacement/Repair

## Replacing Scraper Edge

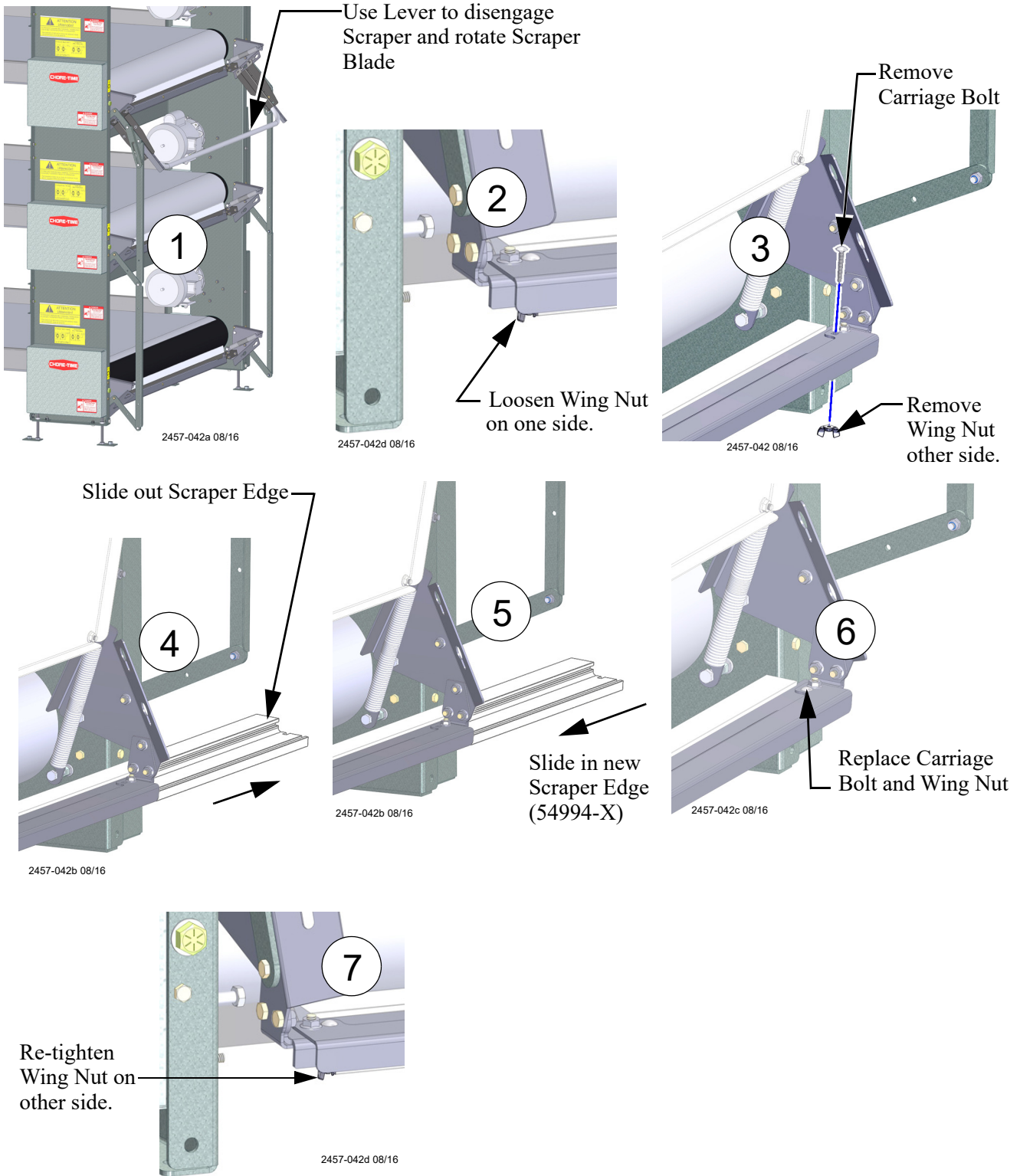
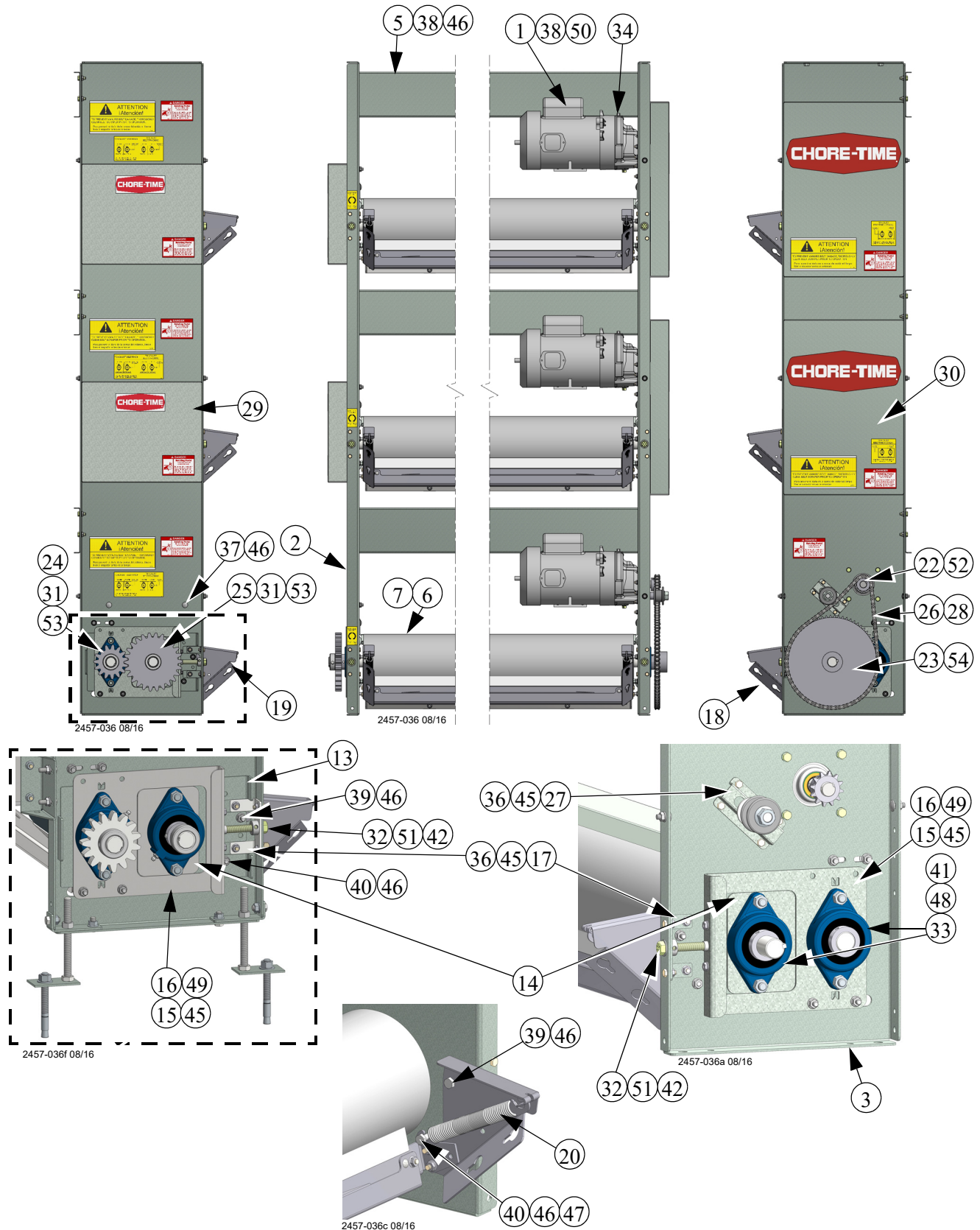


Figure 29.Replacing Scraper Edge

# Part Numbers

## Manure Drive 55154-XXXX







## Modular Manure Belt System Part Numbers

	Modular Manure Belt 18" Cage	Modular Manure Belt 49.07"/49.99"	Modular Manure Belt Brood Grow 24" CC 25.6"	Modular Manure Belt 55.07" Wide	
Item	Part No.				Description
1	3259-142	3259-142	3259-142	3259-142	.75hp, 62RPM,3ph,60hz,230v Power Unit
	3259-142EU	3259-142EU	3259-142EU	3259-142EU	.75hp, 52RPM,3ph,50hz,380v Power Unit
	3259-143	3259-143	3259-143	3259-143	.75hp, 62RPM,1ph,60hz,230v Power Unit
2	54891-21	54891-21	54891-22	54891-22	Adjust Side Panel
	54891-31	54891-31	54891-32	54891-32	Adjust Side Panel
3	54892-21	54892-21	54892-22	54892-22	Drive Side Panel
	54892-31	54892-31	54892-32	54892-32	Drive Side Panel
4	54893-1	54893-2	54893-2	54893-1	Belt Support Plate
5	28546-2	28546-5	28546-5	28546-6	Modular Manure Belt Cross Brace
6	34025-2	34025-5	34025-5	34025-6	Drive Roller
7	34002-4	34002-10	34002-10	34002-12	Roller Shaft
8	49235-2	49585-1	49585-3	49585-2	Snub Roller Weldment
10	54993-1	54993-2	54993-2	54993-4	Scraper Support
11	54994-1	54994-2	54994-2	54994-4	Scraper Edge
13	54895	54895	54895	54895	Side Adjusting Plate
14	54914	54914	54914	54914	Drive Bearing Mount
15	54894	54894	54894	54894	Snub Bearing Mount
16	55349	55349	55349	55349	Adjust Nut Retainer
17	54912	54912	54912	54912	Flange Support Bracket
18	54995-1	54995-1	54995-1	54995-1	LH Pivot Plate
19	54995-2	54995-2	54995-2	54995-2	RH Pivot Plate
20	55350	55350	55350	55350	Manure Scraper Spring
22	27970-3	27970-3	27970-3	27970-3	40# Roller Chain 12T Sprocket
23	41637	41637	41637	41637	70T 1/2" Pitch 11.43 Sprocket
24	37267	37267	37267	37267	15T 4 Pitch Spur Gear
25	37268	37268	37268	37268	26T 4 Pitch Spur Gear
26	21045-12	21045-12	21045-12	21045-12	42.50 Drive Chain
27	20359	20359	20359	20359	Chain Idler Assembly
28	20017	20017	20017	20017	Connecting Link
29	55164	55164	55164	55164	Adjust Side Drive Cover
30	55165	55165	55165	55165	Drive Side Cover
31	42088	42088	42088	42088	1.25 Set Collar
32	34558	34558	34558	34558	.500 Set Collar
33	50425	50425	50425	50425	Bolt Mounted Flange Bearing
34	3523	3523	3523	3523	.25 Pipe Plug
35	36828-1	36828-1	36828-1	36828-1	10-24 x 1.250 SS Carr. Bolt
36	4404-7	4404-7	4404-7	4404-7	1/4-20 x .625 HH Bolt
37	20125	20125	20125	20125	5/16-18 x .75 Carr Bolt
38	2046	2046	2046	2046	5/16-18 x .75 HH Bolt
39	4412-2	4412-2	4412-2	4412-2	5/16-18 x 1.5 HH Bolt
40	4412-12	4412-12	4412-12	4412-12	5/16-18 x 2.0 HH Bolt
41	25440-3	25440-3	25440-3	25440-3	1/2-13 x 1.5 Bolt
42	4415-5	4415-5	4415-5	4415-5	1/2-13 x 3.5 Bolt
44	23101	23101	23101	23101	10-24 Wing Nut
45	46298	46298	46298	46298	1/4-20 Hex Flange Nut
46	8490	8490	8490	8490	5-16-18 Serrated Flange Nut
47	2145	2145	2145	2145	5/16-18 Hex Nut
48	8917	8917	8917	8917	1/2-13 Hex Locka Nut
49	55359	55359	55359	55359	1/2-13 Weld Nut
50	547	547	547	547	.323 x .586 x .078 Lock Washer
51	2955-46	2955-46	2955-46	2955-46	.527 x 1 x .052 Washer
52	2112-1	2112-1	2112-1	2112-1	3/16 x 1 Square Key
53	2419-5	2419-5	2419-5	2419-5	1/4 x .75 Square Key
54	2419-3	2419-3	2419-3	2419-3	1/4 x 1 Square Key
62	55707-1	55707-2	55707-2	55707-4	Snub Scraper Base
63	55708	55708	55708	55708	Individual Snub Scraper
64	4404-20	4404-20	4404-20	4404-20	1/4-20 x 1.75 Bolt
65	7132	7132	7132	7132	Compression Spring
66	55657-1	55657-2	55657-2	55657-4	Manure Scraper Stiffener

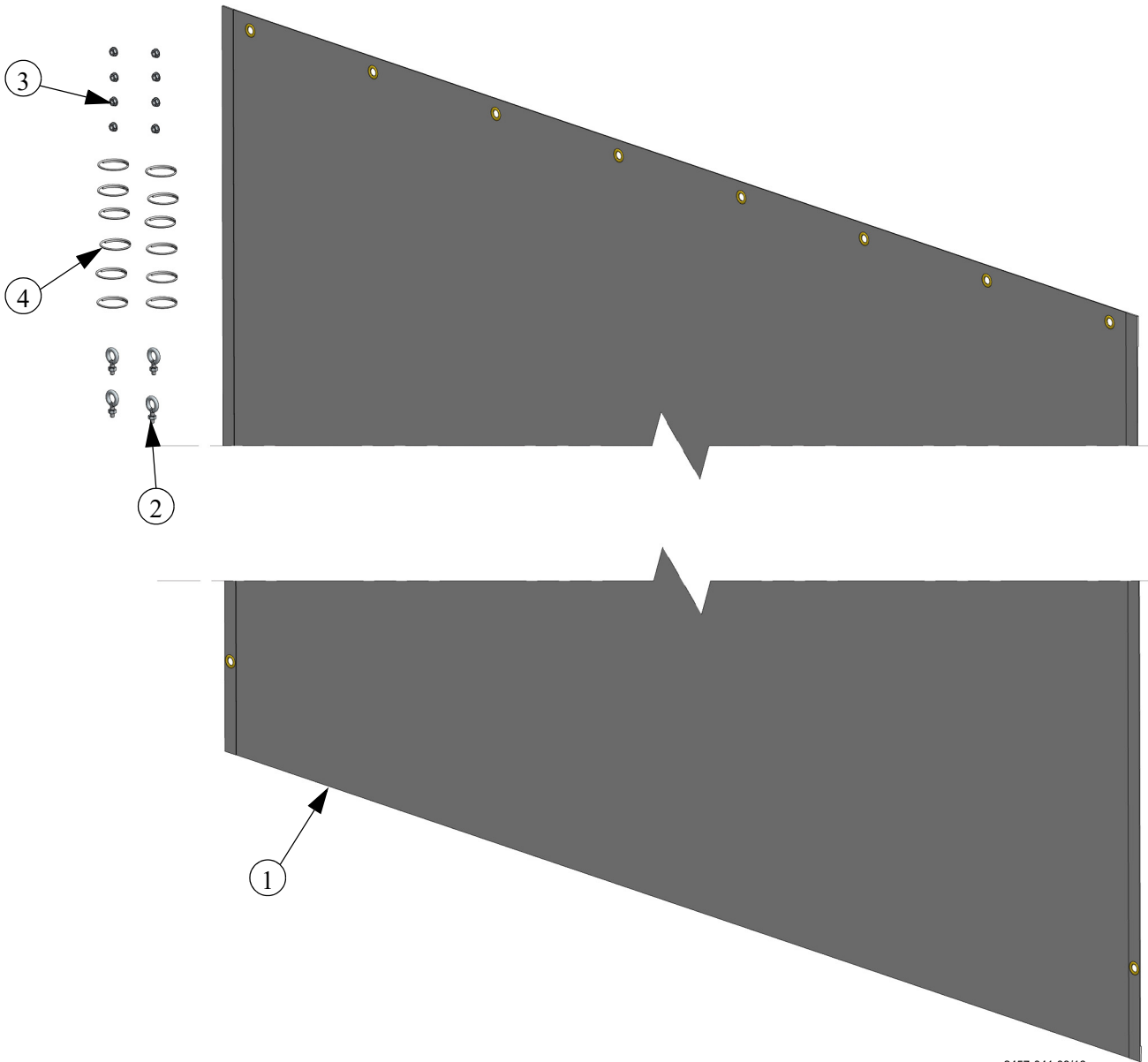
## Part Numbers Continued

	Modular Manure Belt Versa Colony	Modular Manure Belt Versa Colony 2	28.8" Wide 24" CC Modular Manure Belt Brood Grow	Versa Plus	
Item	Part No.				Description
1	3259-142	3259-142	3259-142	3259-142	.75hp, 62RPM,3ph,60hz,230v Power Unit
	3259-142EU	3259-142EU	3259-142EU	3259-142EU	.75hp 52RPM,3ph,50hz,380v Power Unit
	3259-143	3259-143	3259-143	3259-143	.75hp 62RPM,1ph,60hz,230v Power Unit
2	54891-21	54891-21	54891-22	54891-22	Adjust Side Panel
	54891-31	54891-31	54891-32	54891-32	Adjust Side Panel
3	54892-21	54892-21	54892-22	54892-22	Drive Side Panel
	54892-31	54892-31	54892-32	54892-32	Drive Side Panel
4	54893-2	54893-3	54893-5	54893-6	Belt Support Plate
5	28546-5	28546-7	28546-8	28546-10	Modular Manure Belt Cross Brace
6	34025-5	34025-7	34025-8	34025-10	Drive Roller
7	34002-10	34002-22	34002-24	34002-28	Roller Shaft
8	49235-1	49585-3	49585-4	49585-5	Snub Roller Weldment
10	54993-2	54993-3	54993-5	54993-6	Scraper Support
11	54994-2	54994-3	54994-5	54994-6	Scraper Edge
13	54895	54895	54895	54895	Side Adjusting Plate
14	54914	54914	54914	54914	Drive Bearing Mount
15	54894	54894	54894	54894	Snub Bearing Mount
16	55349	55349	55349	55349	Adjust Nut Retainer
17	54912	54912	54912	54912	Flange Support Bracket
18	54995-1	54995-1	54995-1	54995-1	LH Pivot Plate
19	54995-2	54995-2	54995-2	54995-2	RH Pivot Plate
20	55350	55350	55350	55350	Manure Scraper Spring
22	27970-3	27970-3	27970-3	27970-3	40# Roller Chain 12T Sprocket
23	41637	41637	41637	41637	70T 1/2" Pitch 11.43 Sprocket
24	37267	37267	37267	37267	15T 4 Pitch Spur Gear
25	37268	37268	37268	37268	26T 4 Pitch Spur Gear
26	21045-12	21045-12	21045-12	21045-12	42.50 Drive Chain
27	20359	20359	20359	20359	Chain Idler Assembly
28	20017	20017	20017	20017	Connecting Link
29	55164	55164	55164	55164	Adjust Side Drive Cover
30	55165	55165	55165	55165	Drive Side Cover
31	42088	42088	42088	42088	1.25 Set Collar
32	34558	34558	34558	34558	.500 Set Collar
33	50425	50425	50425	50425	Bolt Mounted Flange Bearing
34	3523	3523	3523	3523	.25 Pipe Plug
35	36828-1	36828-1	36828-1	36828-1	10-24 x 1.250 SS Carr. Bolt
36	4404-7	4404-7	4404-7	4404-7	1/4-20 x .625 HH Bolt
37	20125	20125	20125	20125	5/16-18 x .75 Carr Bolt
38	2046	2046	2046	2046	5/16-18 x .75 HH Bolt
39	4412-2	4412-2	4412-2	4412-2	5/16-18 x 1.5 HH Bolt
40	4412-12	4412-12	4412-12	4412-12	5/16-18 x 2.0 HH Bolt
41	25440-3	25440-3	25440-3	25440-3	1/2-13 x 1.5 Bolt
42	4415-5	4415-5	4415-5	4415-5	1/2-13 x 3.5 Bolt
44	23101	23101	23101	23101	10-24 Wing Nut
45	46298	46298	46298	46298	1/4-20 Hex Flange Nut
46	8490	8490	8490	8490	5-16-18 Serrated Flange Nut
47	2145	2145	2145	2145	5/16-18 Hex Nut
48	8917	8917	8917	8917	1/2-13 Hex Locka Nut
49	55359	55359	55359	55359	1/2-13 Weld Nut
50	547	547	547	547	.323 x .586 x .078 Lock Washer
51	2955-46	2955-46	2955-46	2955-46	.527 x 1 x .052 Washer
52	2112-1	2112-1	2112-1	2112-1	3/16 x 1 Square Key
53	2419-5	2419-5	2419-5	2419-5	1/4 x .75 Square Key
54	2419-3	2419-3	2419-3	2419-3	1/4 x 1 Square Key
62	55707-2	55707-3	55707-5	55707-6	Snub Scraper Base
63	55708	55708	55708	55708	Individual Snub Scraper
64	4404-20	4404-20	4404-20	4404-20	1/4-20 x 1.75 Bolt
65	7132	7132	7132	7132	Compression Spring
66	55657-2	55657-3	55657-5	55657-6	Manure Scraper Stiffener

## Part Numbers Continued

	Modular Manure Belt Brood Grow 2 + 2	Extended Brood Grow	
Item	Part No.		Description
1	3259-142	3259-142	.75hp, 62RPM,3ph,60hz,230v Power Unit
	3259-142EU	3259-142EU	.75hp, 52RPM,3ph,50hz,380v Power Unit
	3259-143	3259-143	.75hp, 62RPM,1ph,60hz,230v Power Unit
2	54891-21	54891-21	Adjust Side Panel
	54891-31	54891-31	Adjust Side Panel
3	54892-21	54892-21	Drive Side Panel
	54892-31	54892-31	Drive Side Panel
4	54893-2	54893-4	Belt Support Plate
5	28546-5	28546-6	Modular Manure Belt Cross Brace
6	34025-5	34025-6	Drive Roller
7	34002-10	34002-12	Roller Shaft
8	49235-1	49235-2	Snub Roller Weldment
10	54993-2	54993-4	Scraper Support
11	54994-2	54994-4	Scraper Edge
13	54895	54895	Side Adjusting Plate
14	54914	54914	Drive Bearing Mount
15	54894	54894	Snub Bearing Mount
16	55349	55349	Adjust Nut Retainer
17	54912	54912	Flange Support Bracket
18	54995-1	54995-1	LH Pivot Plate
19	54995-2	54995-2	RH Pivot Plate
20	55350	55350	Manure Scraper Spring
22	27970-3	27970-3	Drive Motor Sprocket
23	41637	41637	MDS Drive Sprocket
24	37267	37267	15T 4 Pitch Spur Gear
25	37268	37268	26T 4 Pitch Spur Gear
26	21045-12	21045-12	Drive Chain
27	20359	20359	Chain Idler Assembly
28	20017	20017	Connecting Link
29	55164	55164	Adjust Side Drive Cover
30	55165	55165	Drive Side Cover
31	42088	42088	1.25 Set Collar
32	34558	34558	.500 Set Collar
33	50425	50425	Bolt Mounted Flange Bearing
34	3523	3523	.25 Pipe Plug
35	36828-1	36828-1	10-24 x 1.250 SS Carr. Bolt
36	4404-7	4404-7	1/4-20 x .625 HH Bolt
37	20125	20125	5/16-18 x .75 Carr Bolt
38	2046	2046	5/16-18 x .75 HH Bolt
39	4412-2	4412-2	5/16-18 x 1.5 HH Bolt
40	4412-12	4412-12	5/16-18 x 2.0 HH Bolt
41	25440-3	25440-3	1/2-13 x 1.5 Bolt
42	4415-5	4415-5	1/2-13 x 3.5 Bolt
44	23101	23101	10-24 Wing Nut
45	46298	46298	1/4-20 Hex Flange Nut
46	8490	8490	5-16-18 Serrated Flange Nut
47	2145	2145	5/16-18 Hex Nut
48	8917	8917	1/2-13 Hex Locka Nut
49	55359	55359	1/2-13 Weld Nut
50	547	547	.323 x .586 x .078 Lock Washer
51	2955-46	2955-46	.527 x 1 x .052 Washer
52	2112-1	2112-1	3/16 x 1 Square Key
53	2419-5	2419-5	1/4 x .75 Square Key
54	2419-3	2419-3	1/4 x 1 Square Key
62	55707-2	55707-4	Snub Scraper Base
63	55708	55708	Individual Snub Scraper
64	4404-20	4404-20	1/4-20 x 1.75 Bolt
65	7132	7132	Compression Spring
66	55657-2	55657-4	Manure Scraper Stiffener

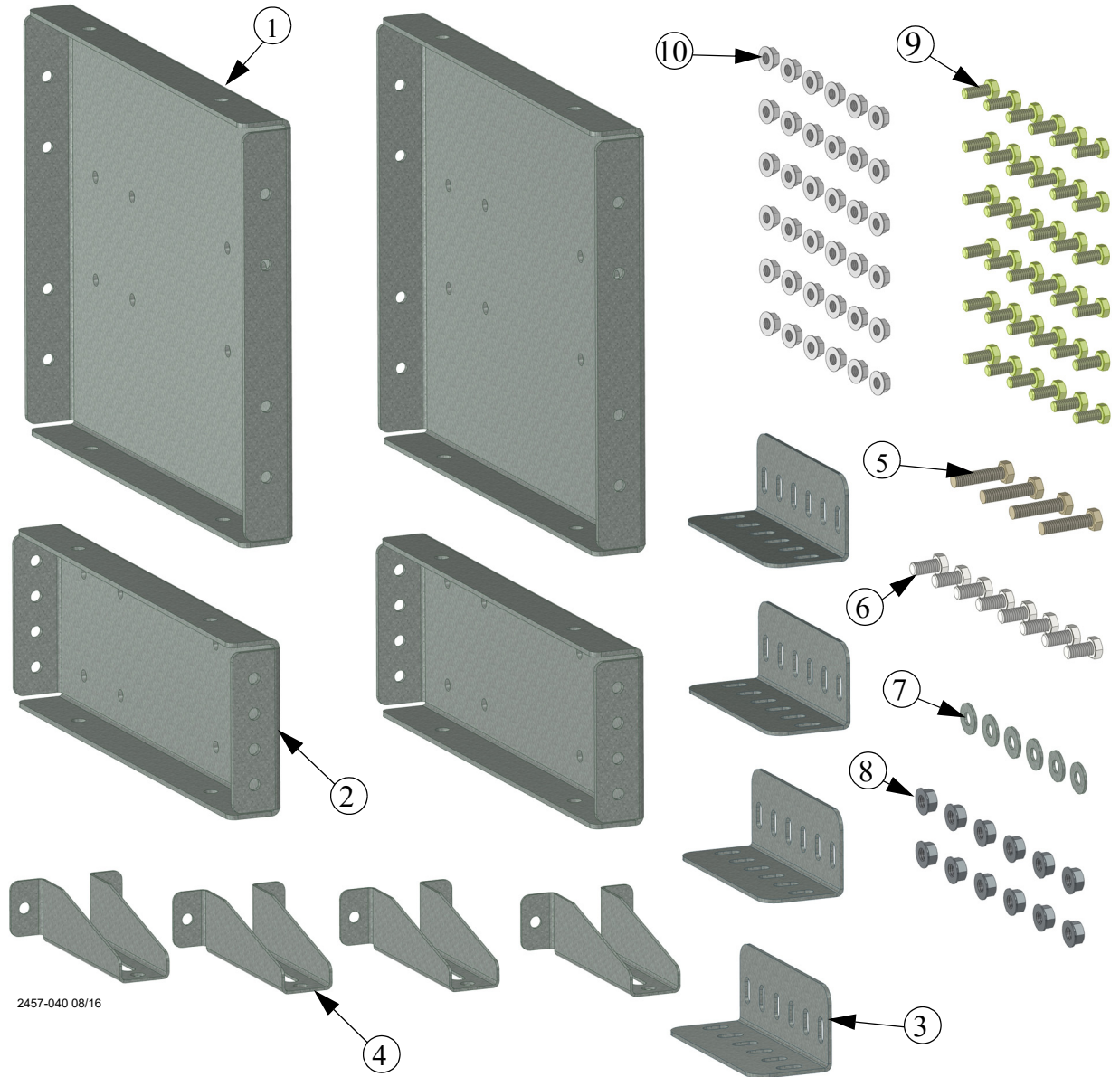
# Manure Curtain Kit (55633-X)



2457-041 08/16

	55633-3 90" Curtain	55633-4 112" Curtain	55633-5 135" Curtain	55633-6 160" Curtain	55633-7 184" Curtain	55633-8 206" Curtain	
Item	Part Number						Description
1	49541-3	49541-4	49541-5	49541-6	49541-7	49541-8	Manure Curtain
2*	22911	22911	22911	22911	22911	22911	1/4-20 Eyebolt
3*	46460	46460	46460	46460	46460	46460	1/4-20 Ser. Flange Nut
4*	55157	55157	55157	55157	55157	55157	Manure Curtain Ring
*Included in 55634 Parts Package							

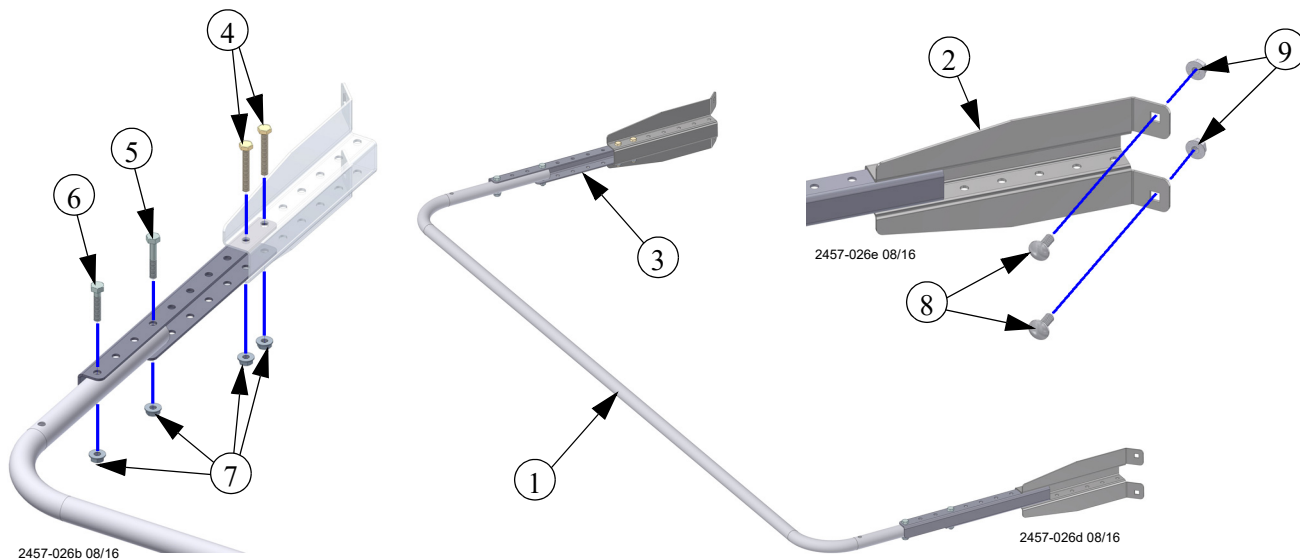
# Filler Panel Kit (55610-X)



	55610-12 12" Panel Kit	55610-5 5" Panel Kit	
Item	Part Number		Description
1	48403	--	12" Filler Panel
2	--	49387	5" Filler Panel
3	48409	48409	Frame Splice
4	56342	56342	Curtain Rod Support
5*	4413-10	4413-10	3/8-16 x 1.5 Bolt
6*	2182	2182	3/8-16 x 3/4 Bolt
7*	546	546	.875 x .376 x .079 Washer
8*	39-45692	39-45692	3/8-16 Whiz Nut
9*	2046	2046	5/16-18 x .75 Bolt
10*	8490	8490	5/16-18 Serrated Fl. Nut

\*Included in 55611 Parts Package

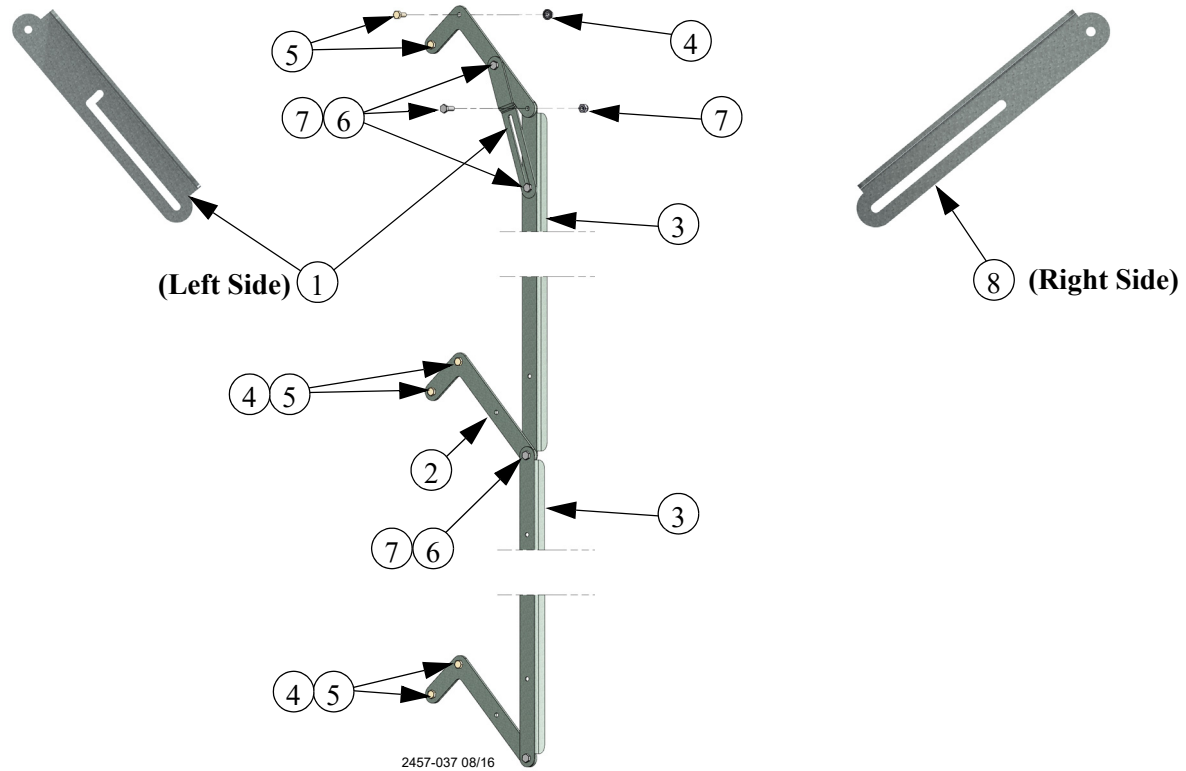
# Lever Kit (55360)



55360-XX		-21	-22	-23	-24	-25	-26	-27	-31	-32	-33	-34	-35	-36	-37
Item	Description	Part Number													
1	Lever Tube	55352-1	55352-2	55352-3	55352-4	55352-5	55352-6	55352-7	55352-1	55352-2	55352-3	55352-4	55352-5	55352-6	55352-7
2	Lever Connector	55135	55135	55135	55135	55135	55135	55135	55135	55135	55135	55135	55135	55135	55135
3	Lever Extension	55586-1	546	546	546	546	546	546	546	546	546	546	546	546	546
4*	1/4-20 x 1.75 Bolt	4404-19	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692
5*	1/4-20 x 1.50 Bolt	2919	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182
6*	1/4-20 x 1.25 Bolt	20605	20605	20605	20605	20605	20605	20605	20605	20605	20605	20605	20605	20605	20605
7*	1/4-20 Ser. Flange Nut	46460	46460	46460	46460	46460	46460	46460	46460	46460	46460	46460	46460	46460	46460
8*	5/16-18 x .75 SS Car. Bolt	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1	27868-1
9*	5-16 x 18 Ser. Flange Nut	46764	46764	46764	46764	46764	46764	46764	46764	46764	46764	46764	46764	46764	46764

\*Included in (55606) Parts Package

# Linkage Kit (55355)

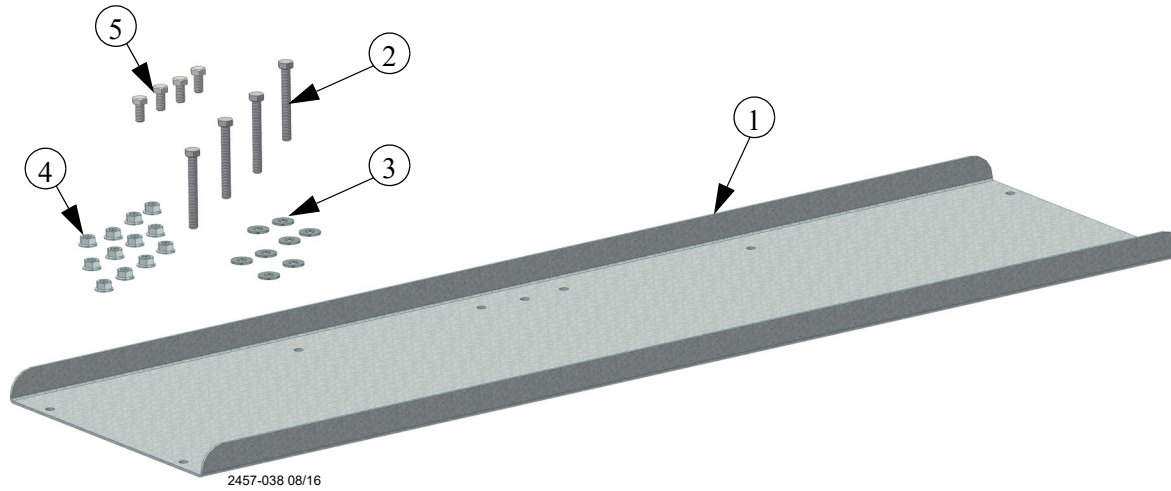


55355-XX		-21	-22	-23	-24	-25	-31	-32	-33	-35	-41	-42	-43	-51	-52	-53	-61	-62	-63	
Item	Description	Part Number																		
1	Swing Lock	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093	56093
2	Pivot Arm	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108	55108
3	48.35" Linkage	--	--	--	54992-4	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--
	40" Linkage	--	--	--	--	54992-5	--	--	--	54992-5	--	--	--	--	--	--	--	--	--	--
	26.5" Linkage	--	--	54992-3	--	--	--	--	54992-3	--	--	--	54992-3	--	--	54992-3	--	--	--	54992-3
	24" Linkage	--	54992-2	--	--	--	--	54992-2	--	--	--	54992-2	--	--	54992-2	--	--	--	54992-2	--
	22.5" Linkage	54992-1	--	--	--	--	54992-1	--	--	--	54992-1	--	--	54992-1	--	--	54992-1	--	--	54992-1
4	1/4-20 Hex Flange Nut	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298	46298
5	1/4-20 x .625 Bolt	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7	4404-7
6	1/4-20 x .75 Bolt	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133	1133
7	1/4-20 Locknut	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269	1269
8	Upswing Stop	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171	56171

# Top Panel Kit (55635-XX)

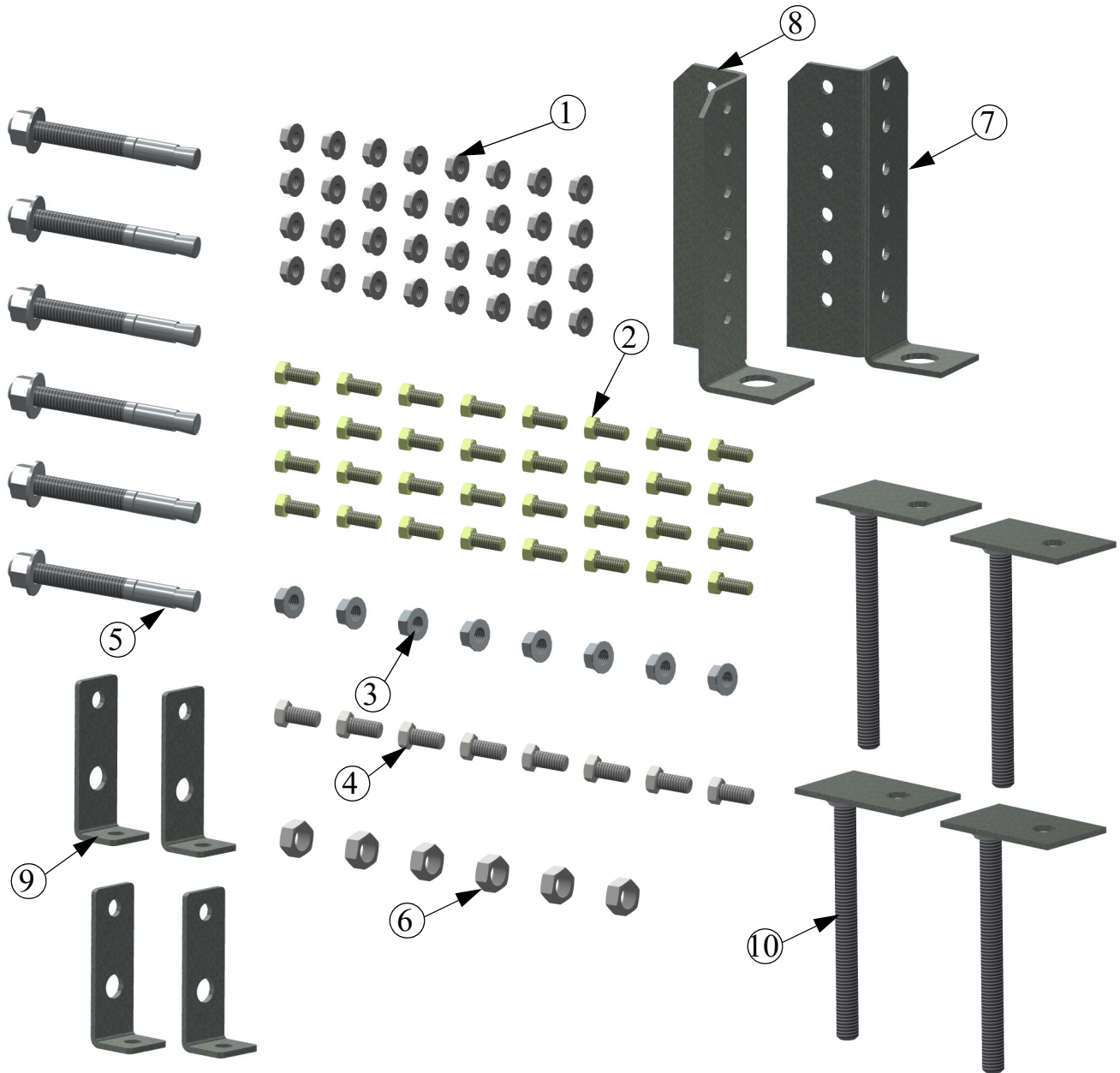
55635-XX		-21	-22	-23	-24	-25	-26	-27	-31	-32	-33	-34	-35	-36	-37
Item	Description	Part Number													
1	Top Support	48473	48473-2	48473-3	48473-4	48474-5	48473	48473-2	48473-3	48473-4	48474-5	48473-4	48473-5	48473-6	48473-7
2*	3/8-16 x 3.00 Bolt	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7	4413-7
3*	.875 x .376 x .079 Washer	546	546	546	546	546	546	546	546	546	546	546	546	546	546
4*	3/8-16 Whiz Nut	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692	39-45692
5*	3/8-16 x .75 Bolt	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182	2182

\*Included in (55636) Parts Package





# Drive and Idler Assembly Kit (48058)



Item	Part Number	Description
1*	8490	5/16-18 Serrated Fl. Nut
2*	2046	5/16-18 x .75 Bolt
3*	39-45692	3/8-16 Whiz Nut
4*	2182	3/8-16 x 3/4 Bolt
5*	21176	Wedge Anchor
6*	2042	1/2-13 Hx Nut
7	21226-1	L.H. Leg Extension
8	21226-2	R.H. Leg Extension
9	33639	Cement Base Weldment
10	54913	Bottom Flange Support Bracket

\*Included in 48342 Drive and Idler Hardware Kit



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**Revisions to this Manual**

<b>Page No.</b>	<b>Description of Change</b>	<b>ECO</b>
	New Manual	33893

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