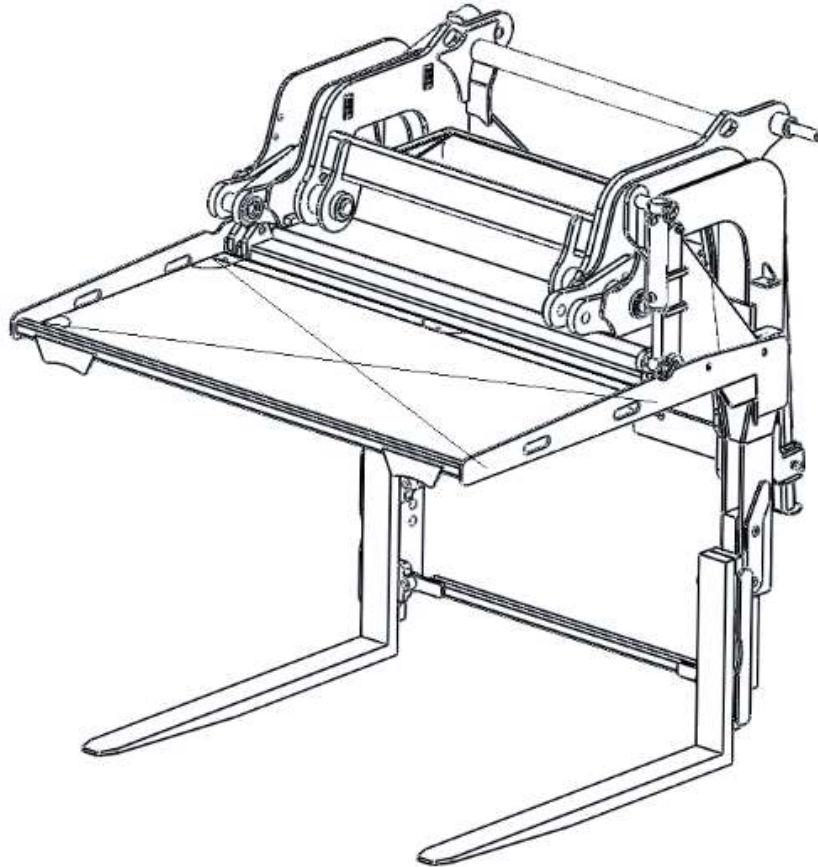


AGRI WELD

OPERATOR MANUAL

Revolution



AGRI WELD

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User Information

Before using your REVOLUTION Box Rotator for the first time it is IMPORTANT that all operators make themselves familiar with the unit and must read this OPERATORS MANUAL and SAFETY INSTRUCTIONS attentively.

Getting Started

The REVOLUTION Box Rotator will be fitted and delivered with the correct Bolt-On brackets/carriage blocks to suit the fork-lift/loader it is intended to fit. SEE BOLT ON BRACKETING INSTRUCTIONS AND BOLT SPECIFICATIONS SECTION FOR FULL INFORMATION. If for any reason the fittings are lost or damaged, or if the bracketing is removed for any reason, please refer back to this information in order to refit the brackets and/or replace any lost fittings with the correct specification.

The REVOLUTION Box Rotator will also be fitted with the correctly swaged hydraulic pipes and fittings applicable to your forklift/loader and as per your request. If these pipes are damaged they must be replaced immediately with NEW pipes and fittings. **DO NOT ATTEMPT TO REPAIR HYDRAULIC PIPES OR ALLOW ANY ONE ELSE TO REPAIR THEM.**

Replacement parts can be ordered directly from us and sent to you overnight if required, although, overseas orders will take longer.

The REVOLUTION Box Rotator is a low maintenance unit, and requires little mechanical attention as such, other than **lubricating regularly at the greasing points located and visible on the unit and by following a general basic care routine.**

The **REVOLUTION Box Rotator weighs 930kg** excluding bracketing and has a **max. loading of 1.5 tonnes.**

NOTE: During use, please be aware of increased weight due to shock loading. This includes performing manoeuvres such as driving down a rough field, at some speed, with a full box. The resulting bouncing effect is known as shock loading and the weights can be significantly magnified to the point of overload.

The REVOLUTION Box rotator is not to be used for any other purpose than for which it is intended - that is the lifting and rotating of one box containing free flowing product at a time. **It is not to be used as a fork lift.** Damage to the unit resulting from overload will not be covered under a warranty or liability claim.

The specifications, descriptions and illustrations in this manual are accurate at the time of publication but may be subject to change.

Safety

All operators of the REVOLUTION and forklift/loader must hold the appropriate forklift licence or certificate of competence to do so.

All operators must be familiar with the REVOLUTION Operators Manual and forklift/loader operations prior to use. If safety instructions are not observed and complied with it can lead to the risk of injury to the operator and others as well as damage to the machine, property and the environment. Non-compliance to the safety instructions can lead to claims for damages/injury becoming invalid.

Dangers, operating errors and exemption from liability

1. No responsibility will be accepted for possible dangers arising from operations complying with the designated use.
2. Damage to agricultural produce particularly vulnerable to damage during processing cannot be entirely ruled out. Weather conditions, the quality of the produce and many other circumstances beyond our or the operator's control have an influence on the vulnerability to damage of the produce being processed. For example, when processing potatoes the submerged weight of the potatoes, the manuring (nitrogen content) of the potatoes, the degree of maturity (firmness of the skin) of the potatoes, the temperatures during processing and many other circumstances can have an influence on the vulnerability to damage. These examples do not claim to be exhaustive.
3. To avoid damage to agricultural produce the user must adapt the machine to the respective operating conditions. The results produced by the machine must be constantly monitored and checked.
4. Agriweld shall not be liable for any damage to agricultural produce and other items, which occurs as a result of normal operating, adjustments errors or other incorrect usage.
5. Agriweld accepts no liability for any damage caused as a result of operations not complying with the designated use of the machine. This also applies to damage to agricultural produce caused by certain external influences, which cannot be avoided with the current state of the art.

Qualification & Training

Only personnel with the appropriate forklift/loader licence are authorised to use this machine.

Statutory minimum age limits must be observed and reliable personnel only should perform maintenance/work on this machine.

Persons undergoing training or instruction or taking part in a general training course should only use this machine under direct supervision of an experienced and trained person.

Agriweld shall not be responsible for any damage/injury caused by the use of parts/repairs not supplied and/or approved by Agriweld.

General Safety before use

Any warning signs/instructions on the machine provide important information and must be observed.

Ensure that you are familiar with the machine before starting work.

Check round the machine for any noticeable damage, or missing parts before starting work.

It is advisable that the operator does not wear jewellery and baggy clothing to avoid the risk of snagging and trapping.

Ensure that you are working in an area clear of obstructions and watch out for wandering individuals (particularly children!).

Important safety instructions before use

Take extra care when attaching the REVOLUTION to the forklift/loader to ensure that it is attached correctly via the bracketing and hydraulic fittings.

Ensure that the forklift/loader and its hydraulic system is in full working order. It is advisable for the operator to run the machine without a loaded box attached to familiarise themselves with the machines working action.

Never allow any person to stand between the forklift/loader and the REVOLUTION during connection or at any time.

There is 200mm of travel on the hydraulic clamping lid and the operator needs to ensure that this is appropriate for the various heights of boxes being handled. Use the manual adjustment on the height setting of the pallet forks if required for additional adjustment.

Take into account the protrusion of the REVOLUTION pallet forks (a further 1200mm from the carriage of the unit) when manoeuvring around and take particular care when approaching junctions and negotiating corners.

The driving characteristics of the forklift/loader are influenced and altered by the attachment of mounted machines and it is important to ensure adequate steering and braking ability as required.

Never allow any person to sit or ride on the REVOLUTION at any time.

Never perform any adjustments to the REVOLUTION whilst mounted, unless the forklift/loader is stopped, turned off and the REVOLUTION is resting on the ground where possible.

Ensure that the forklift/loader cannot roll away by use of a park brake or wheel chocks.

NEVER ALLOW ANY PERSON TO STAND OR WORK BENEATH A SUSPENDED LOAD!

Connection to the forklift/loader

The REVOLUTION will be delivered already fitted with the correct bolt-on bracketing, hydraulic fittings and hydraulic hose to fit your forklift/loader.

If for any reason the fittings are lost or damaged they must be replaced with the following specification of fitting;

QUICK-HITCH brackets or CARRIAGE BLOCKS require the following fittings;

8 X M20 X 50mm counter sunk socket head setscrew BZP - high tensile 10.9

8 X M20 high tensile grade 8.8 Nylock nuts

8 X M20 good quality washers (fitted nut side.)

IMPORTANT NOTE (FOR YARD TRUCKS - Excludes telehandlers)

CARRIAGE BLOCKS ONLY REQUIRE THE TOP BLOCK FITTING WITH "LOCKTITE" Top blocks are pre LOCKTITED before dispatch but will require LOCKTITE again if removed and re-fitted at any time.

For your own safety and the safety of others, always use the correct fittings to attach bolt-on bracketing to the rear of the unit. Always place the unit on the ground and turn off the forklift/loader before attempting any changes.

Attachment

Stand the REVOLUTION up the correct way, in an area free from obstruction to allow you to drive the forklift/loader towards the bracketing.

For Quick Hitch bracketing, connect as you would with any other attachment and the type of bracketing fitted to the box rotator.

For Carriage blocks, drive forward and locate the forklift carriage with the top block ensuring the centre castellation is lined up with the notch inside the top block to prevent unwanted movement left or right. Lift the unit off the ground enough to give access to bolt the bottom blocks in position. BE AWARE OF YOUR OWN SAFETY AND THE SAFETY OF OTHERS.

Attach the hydraulic hoses via the pipes and fittings supplied to fit your forklift/loader whilst it is TURNED OFF. The hoses are marked "FEED" and "RETURN"

The REVOLUTION may have been drained of hydraulic oil prior to delivery and will re-fill itself on first use.



If your machine is being exported out of the UK, for safety purposes we cannot run any hydraulic oil through the machine for shipping, please be aware that you will need to plug your hydraulic couplings in to the forklift/loader and run the machine through with hydraulic oil for operation.

Setting up the pallet forks

After attachment of the unit to your fork lift / loader and connection to the hydraulics (as on page 6) you need to set the fixed height of the pallet forks.

Set the height between the pallet forks and lid to allow sufficient clearance to drive in to the box, see "SETTING THE PALLET FORKS" instructions below. To determine the adjustment, if any, drive up to a box and put the forks on the ground to help gauge the clearance required. (There is 200mm of clamping stroke to allow for varying box heights)

Setting the pallet forks - Requires 2 men

There is 200mm of travel on the hydraulic clamping lid and the operator needs to ensure that this is appropriate for the various heights of boxes being handled. Use the manual adjustment on the height setting of the pallet forks if required for additional adjustment as follows;

With the unit attached correctly to the forklift/loader, rotate the unit through approx. 90 degrees (on the rotators hydraulic system.) Turn off the loader. Remove pallet fork pins from 1 side first (the second person is required to support and steady the fork during this process) and slide the fork up or down as required. Replace the pins and ensure that the lynch pin is attached and secured. Repeat this on the other side.

LID CLEARANCE MUST BE 150mm TO ALLOW EASY ACCESS AND AVOID COLLISION ISSUES WHEN COLLECTING A BOX AND WHEN ROTATING.

IMPORTANT - Always adjust both pallet forks to the same setting and always replace the pins immediately after any adjustments. **NEVER** operate the unit without the pallet fork pins fitted and secured using the lynch pins. Replace any lost or missing pins immediately.

The specification for these pins is standard CAT 2 Top Link pins.

YOU ARE NOW READY FOR OPERATION

AGRI WELD

Rules of Conduct for Operation

The following points must always be observed before the machine is started up and during operation:

- Never leave the machine unattended.
- Check the machine regularly for oil leakage. Replace defective components immediately.
- The user is responsible for damage to the produce caused by oil leakage.
- Check the machine for dirt accumulation and clean it on a regular basis.

Rules of conduct when handling the hydraulic system

DANGER

The hydraulic system is under high pressure!

Fluids escaping under high pressure can penetrate the skin and cause serious injuries! If such injuries occur, call a doctor immediately as otherwise there is a risk of serious infection!

Consequently: Work only on the hydraulic system when the hydraulic system is depressurized and the drive is switched off.

Note

All components of the machine are driven hydraulically. Replace defective hose connections immediately. The user is responsible for damage to the produce caused by oil leakage.

Operation

Once the REVOLUTION is attached to the forklift/loader correctly and adjusted for the correct box size you can begin operation.

The following step by step procedure will take you through the basic operation of the machine;

The REVOLUTION is a high visibility unit and the pallet forks can be seen below the rotator to guide you. The marker on the left side of the clamping lid will also enable you to gauge access to the box. **Ensure that you have set the machine up before operation as per instructions earlier in this manual.**

1. Drive in to collect a full box until it touches the REVOLUTIONS carriage (as far back as it will sit)
2. Ensure that the REVOLUTION IS NOT TILTED FORWARDS ON THE FORKLIFT / LOADER as the box could slide off.



3. Pick up the box, tilt the rotator back slightly to keep the load against the carriage and operate the hydraulic spool to clamp the lid. Drive to the desired tipping point.
4. Position the forklift/loader so that on rotating the SOCK will fall in the desired location. The sock position indicates the drop location of the product when you continue rotation. If you are not happy with the location STOP rotation and move to new desired location. CONTINUE WITH ROTATION to begin to empty the box.

VERY IMPORTANT: Use the hydraulics of the REVOLUTION to rotate the box fully and NOT the crowd of the forklift until the REVOLUTION has completed its own cycle. You can use the crowd of the forklift if additional rotation is required once the REVOLUTION has completed its tipping cycle.

WHILST ROTATING TO EMPTY THE BOX ensure that the forklift carriage and REVOLUTION is NOT tilted forwards to prevent the box sliding off. The speed is pre-set before delivery and you do not need to worry about “feathering” the controls as the rotator will rotate at a steady speed without jarring.

5. Once the box is empty, rotate the box fully back to the starting position. STOP the flow of oil before the clamping lid is raised to ensure the box is held until you want to release it.
6. To drop the empty box off where required, continue the flow of oil to release the clamping lid. On leaving the box it is easier to slightly tilt the forklift carriage forwards to aid exit from the box.

If you decide not to empty a box fully, the REVOLUTION will return the partially full box back if required. REPEAT THE PROCESS.

MINIMISING DAMAGE/BRUISING

It is the normal procedure, during use, to keep the discharge sock full of produce to prevent the crop “dropping” – which is one of the main causes of damage and bruising.

To keep the sock full during operation, lower the sock as far down into the desired location as possible until the sock fills with produce to maximum capacity. You will see the sock bulge when full. Use the forklift boom to slowly lift the REVOLUTION up so that the crop trickles out of the bottom of the sock, preventing any “dropping”. This procedure will help keep the chits on your seed and prevent/minimise damage and bruising.

Maintenance

Regular maintenance is a prerequisite for good operational reliability. The following safety advice is to be observed before starting any maintenance, cleaning or repair work.

Trained or experienced personnel may only execute maintenance activities.

Inform operating personnel before beginning special operations and maintenance work! Delegate a supervisor!

If necessary, ensure that the maintenance area is adequately secured.

Use suitable tools and wear gloves when working on the machine!

Switch off the machine completely for maintenance and repair work and ensure that it is protected against inadvertent starting by:

- Locking the principal controls and removing the ignition key and/or
- Detaching the hydraulic supply.

Carry out maintenance and repair work only when the machine is positioned on stable and level ground and has been secured against involuntary movement and toppling.

To avoid the risk of accidents, individual parts and larger subassemblies being moved for replacement purposes should be carefully securely attached to lifting tackle. Use only suitable hoisting and lifting gear with adequate load capacity, which is in proper working condition. Never work or stand under suspended loads!

The securing of loads and the instruction of crane operators should only be entrusted to experienced persons. A signaller giving instructions must be within sight of the crane operator or must be provided with a radio link.

For carrying out overhead work, always use specially designed facilities or safe ladders/platforms. Never climb on the machine itself! Wear a safety harness when carrying out maintenance work at greater heights.

Clean the machine, especially connections and threaded unions, of any traces of oil, fuel or preservatives before carrying out maintenance/repairs! Never use aggressive detergents. Use lint-free cleaning cloths.

Before cleaning the machine with water or steam jets (high-pressure cleaners) or other cleaning agents, cover or tape all openings which – for safety and operational reasons – must be protected against ingress of water, steam or cleaning agents.

After cleaning, examine all fuel, lubricant and hydraulic oil lines for leaks, loose connections, scuffing marks and damage. Any defects found must be rectified without delay.

Always retighten any screwed connections that have been unscrewed during maintenance and repairs.

Any safety devices removed for setting-up, maintenance or repair purposes must be refitted and checked immediately upon completion of the maintenance and repair work and prior to operation.

We recommend greasing your box rotator using good quality general purpose grease weekly whilst working under normal conditions, and twice weekly under extreme use and or very dry/dusty conditions.

GREASING INSTRUCTIONS.

We recommend using a good quality multipurpose Lithium EP2 grease, and grease weekly as follows;

- Whilst connected to the Forklift/loader grease all parts: 2 x Main pivot and 4 x hydraulic cylinders using at least 3 pumps from the gun.
- Being aware of your own safety/safety of others, rotate the machine through its entire cycle and repeat the greasing process.
- Rotate machine on forklift/loader back and forth several times to work the new grease in.
- You are now ready to use the machine again.

It is important to follow the recommended greasing routine to protect your Revolution from damage and prolong the lifespan of its main operating parts.

Failure to carry out this maintenance may result in your warranty becoming invalid due to non-maintenance.

Acquiring spare parts

Please quote the details on the type plate(s) as well as the machine's serial no. on every order for spare parts or accessories, or enquiries of a technical nature.

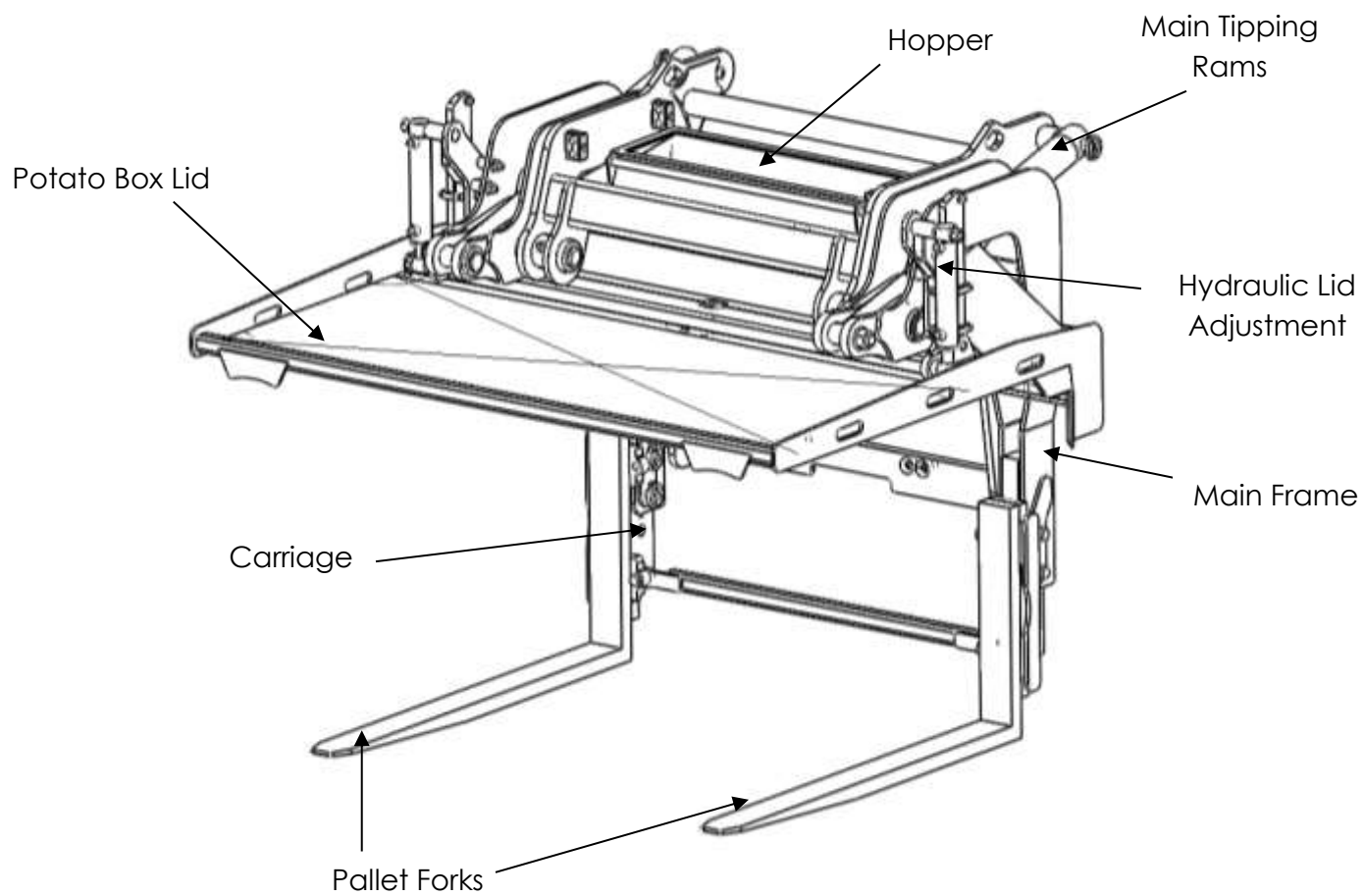
The use of spare parts supplied by others shall only be permitted after consultation with the manufacturer. Original spare parts and accessories authorised by the manufacturer ensure safe and reliable operation. The use of other parts may invalidate the liability of the manufacturer for any consequences arising from such use.

Disposing of replaced parts

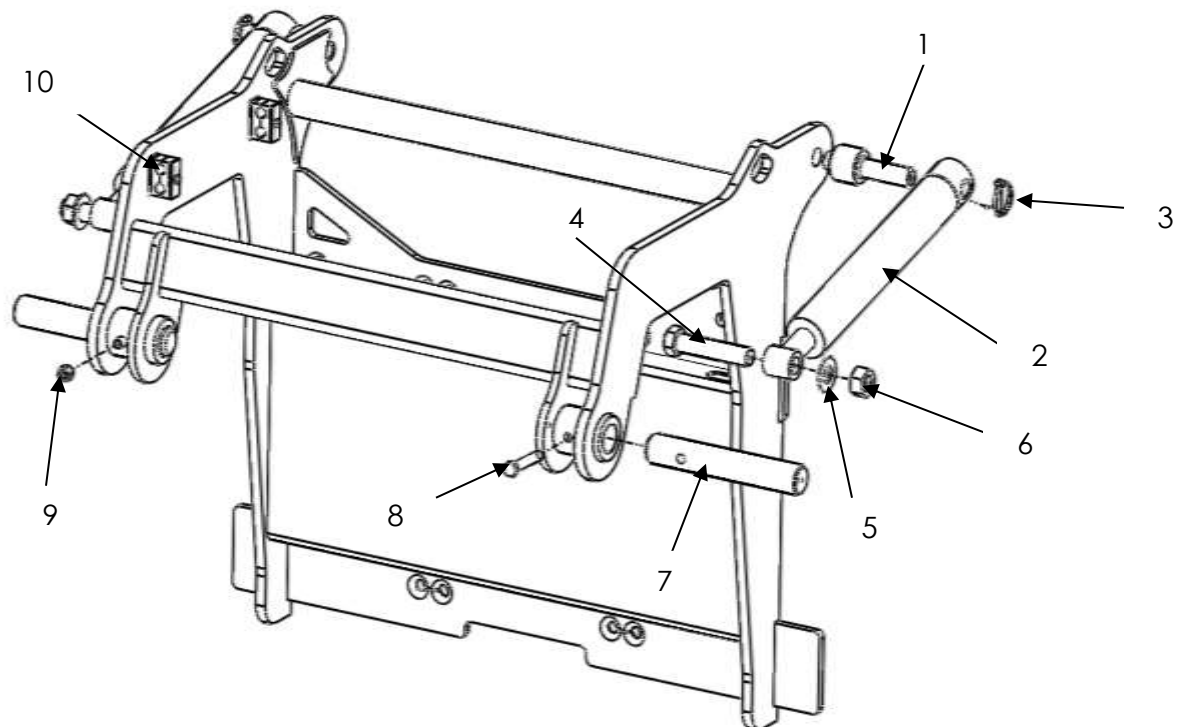
The following points should be observed before replacing or disposing of parts.

- Replaced parts, which still function, should be cleaned and stored in an orderly manner.
- Machine parts, which cannot be repaired should only be disposed of at appropriate collecting points or be collected by a scrap metal dealer.
- So-called "valuable" materials should be disposed of in a proper way, i.e. plastics, rubber, scrap metal, etc. should be recycled.
- Collect and dispose of old oil in accordance with the current regulations.

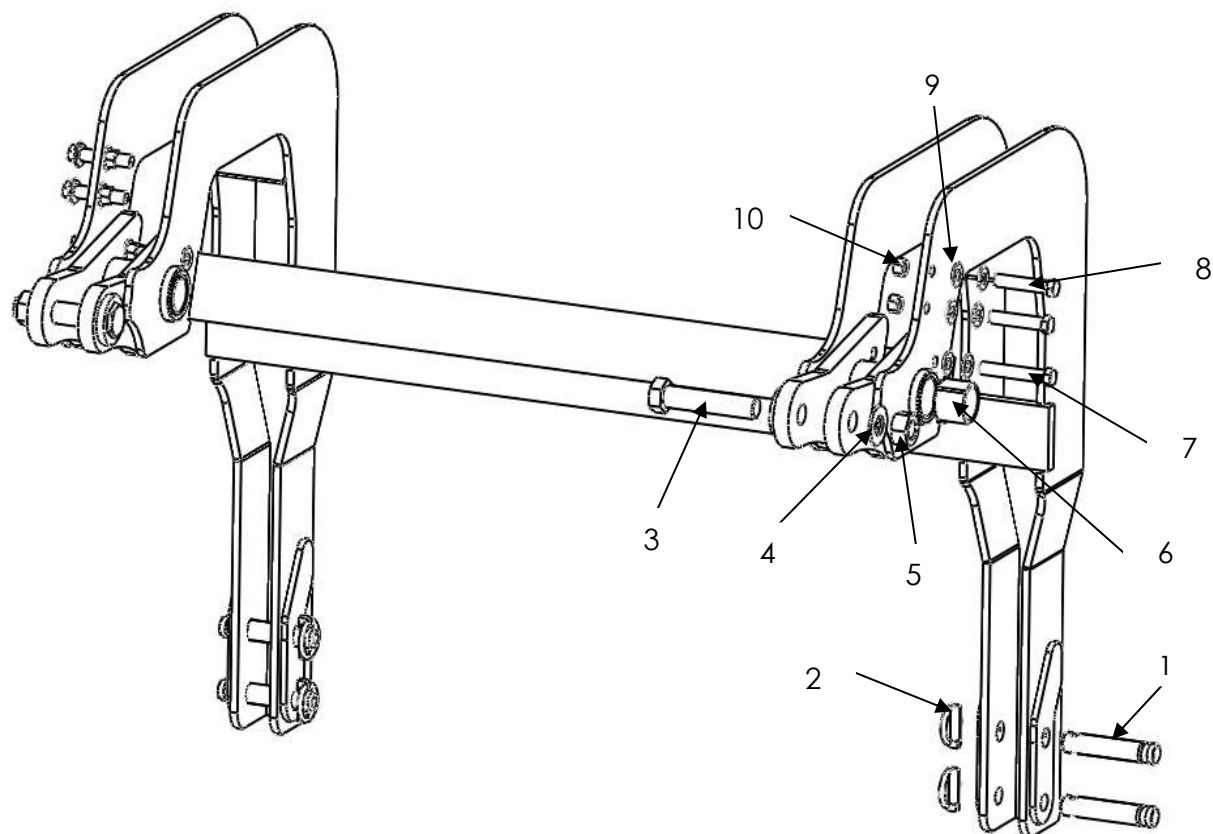
Full Assembly



Main Frame (Inner)

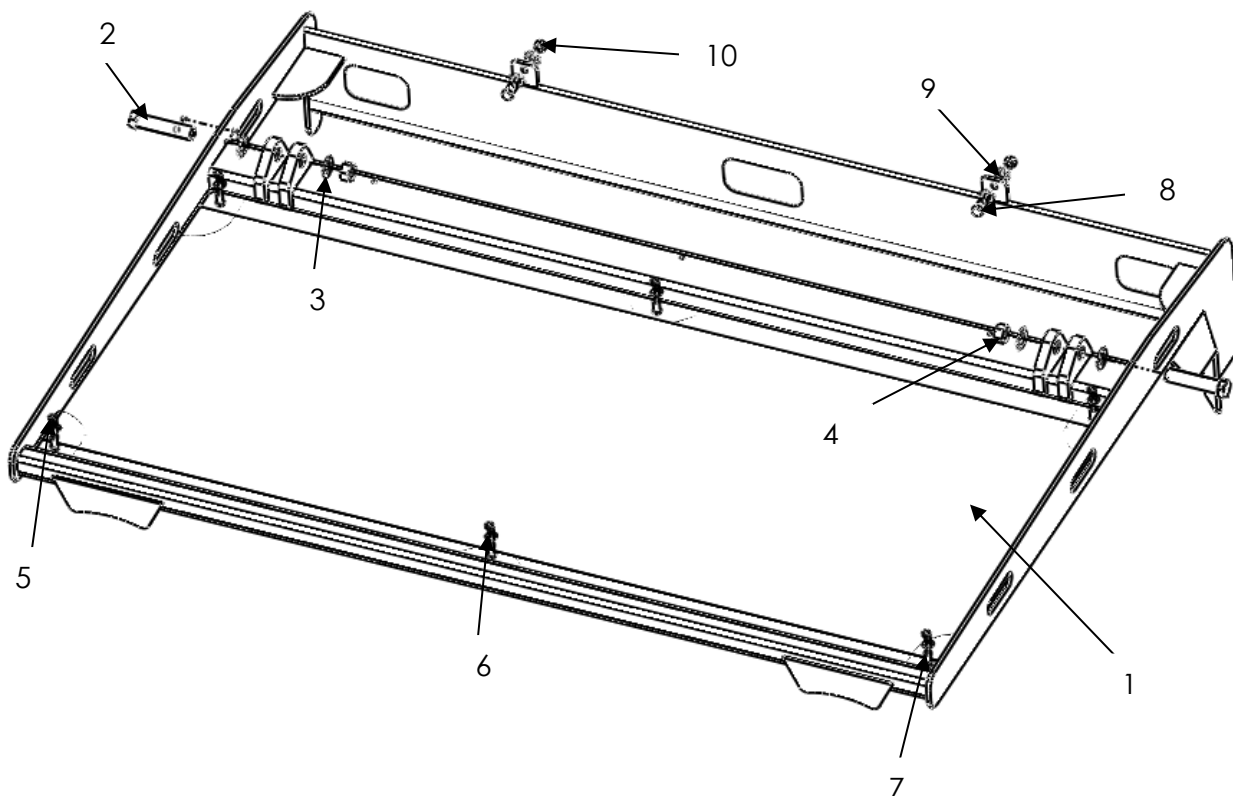


Item Number	Part Number	Description	Quantity per Machine
1	WK_REV_505	Ram Pin	2
2	AW_704_4_RAM	400 Stroke Ram	2
3	LP6Z	Lynch Pin	2
4 / 5	M30 x 150 / M30 Washer	Bolt / -	2 / 4
6	M30 Nyloc	Nut	2
7	WK_REV_509	Main Pivot Pin	2
8/9	M16 x 100 / M16 Nyloc	Bolt / Nut	2 / 2
10	SP110APPDPAS	Pipe Clamp Kit	4

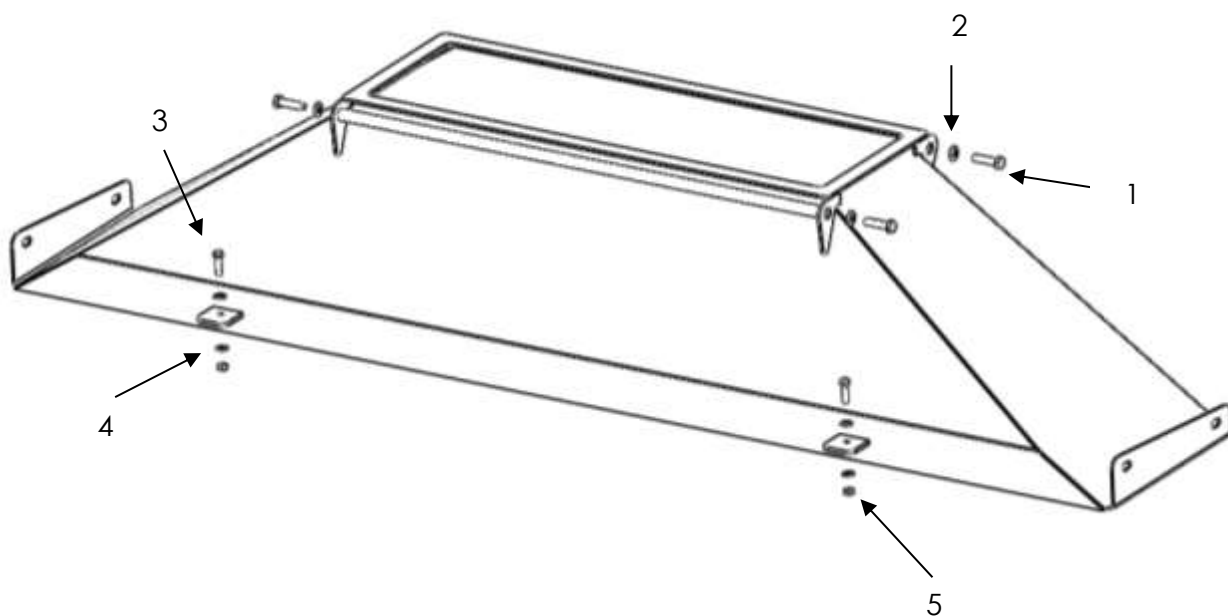
Main Frame (Outer)

Item Number	Part Number	Description	Quantity per Machine
1	AW_Z325_105	Carriage Adjustment Pin	4
2	AW_LP11Z	Pin	4
3 / 4	M30 x 150 / M30 Washer	Ram Bolt / -	2 / 2
5	M30 Nyloc	Ram Nut	2
6	AW_STB_60	Knock In Bush	4
7 / 8	M16 x 110 / M16 x 90	Slider Adjustment Bolts	2 / 4
9 / 10	M16 Washer / M16 Nyloc	-	18 / 6

Lid Assembly

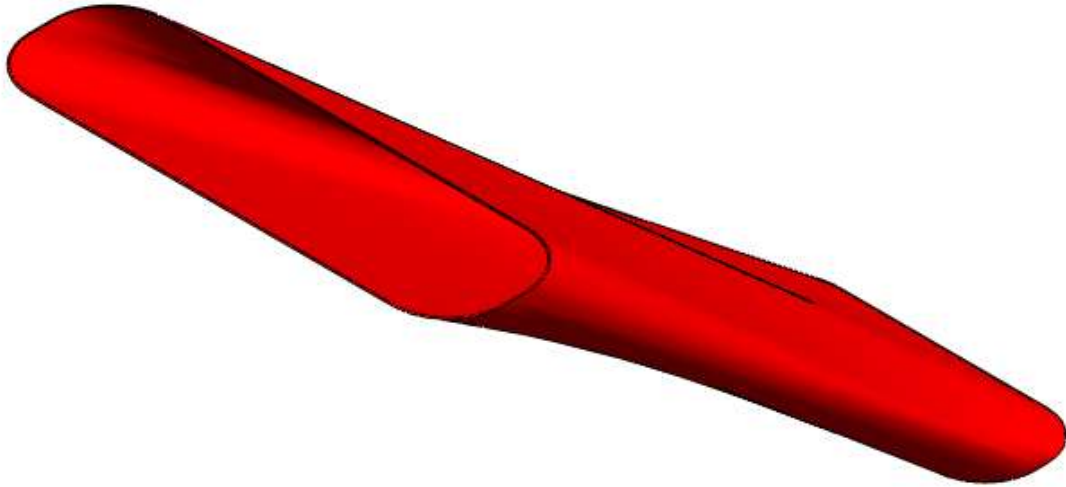


Item Number	Part Number	Description	Quantity per Machine
1	AW_005	Revolution Lid Plate	1
2	M20 x 110	Slide Adjuster Bolt	2
3	M20 Washer	-	4
4 / 5	M20 Nyloc / M8 x 25 Button Head	Slide Adjuster Nut / Lid Plate Bolt	2 / 6
6	M8 Washer	-	12
7	M8 Nyloc	Lid Plate Nut	6
8/9	M12 x 30 / M12 Washer	Hopper Bolt / -	2 / 4
10	M12 Nyloc	Hopper Nut	2

Hopper

Item Number	Part Number	Description	Quantity per Machine
1	M10 x 30	Sock Bolt	4
2	M10 Washer	-	4
3	M8 x 40	Hopper to Lid Bolt	2
4	M8 Washer	-	4
5	M8 Nyloc	Nut	2

Hopper Sock



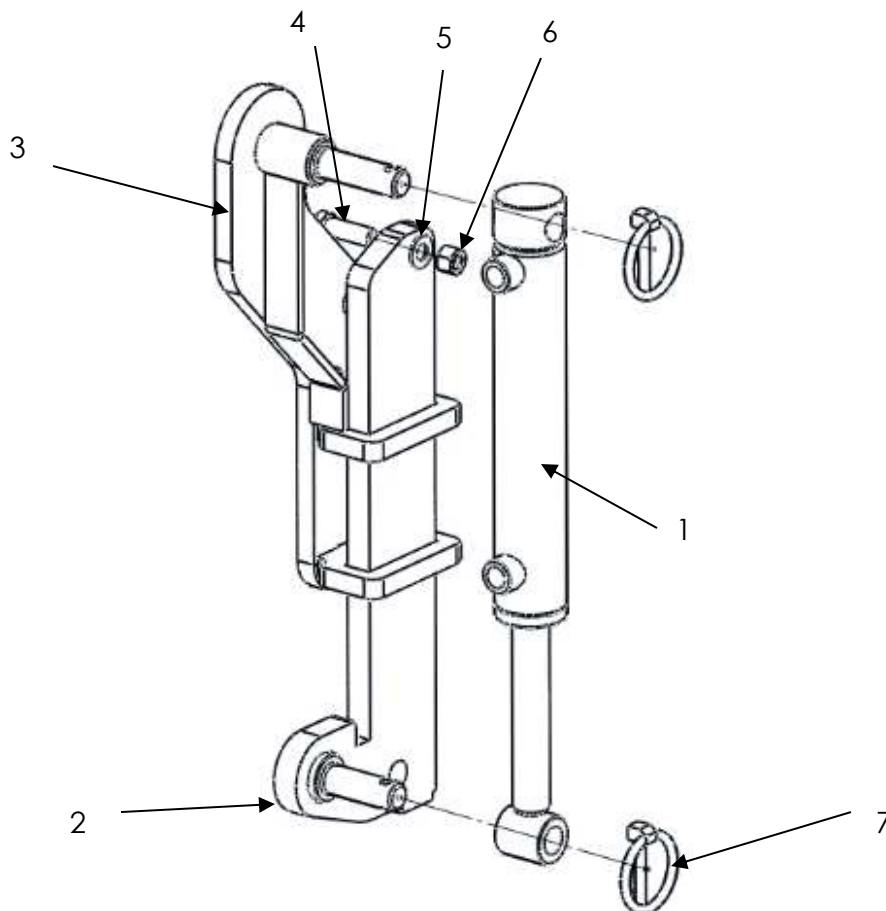
Hopper sock attaches to ITEM 1 on Hopper assembly (page 18.)

STANDARD LENGTH IS 1200mm

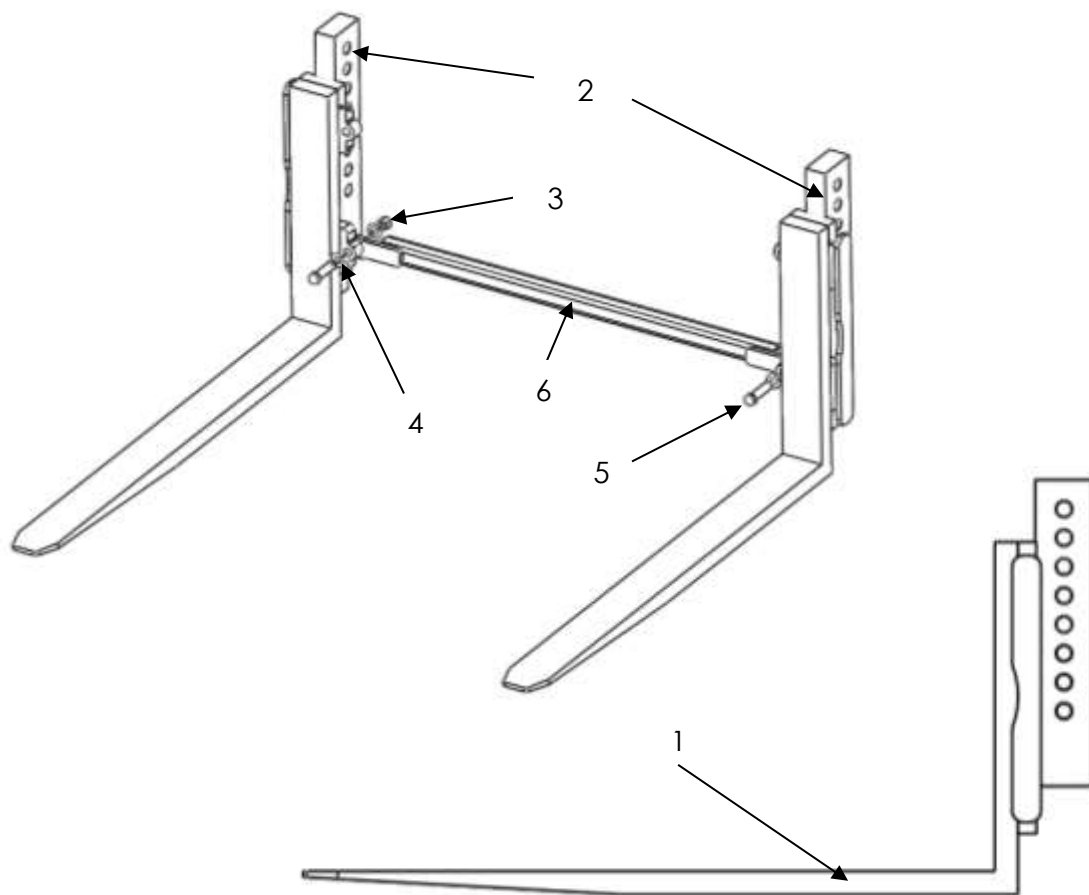
This item is a wearing part and will require replacement when worn.

Available in different lengths to suit your application.

Hydraulic Lid Adjustment Assembly (Opposites)

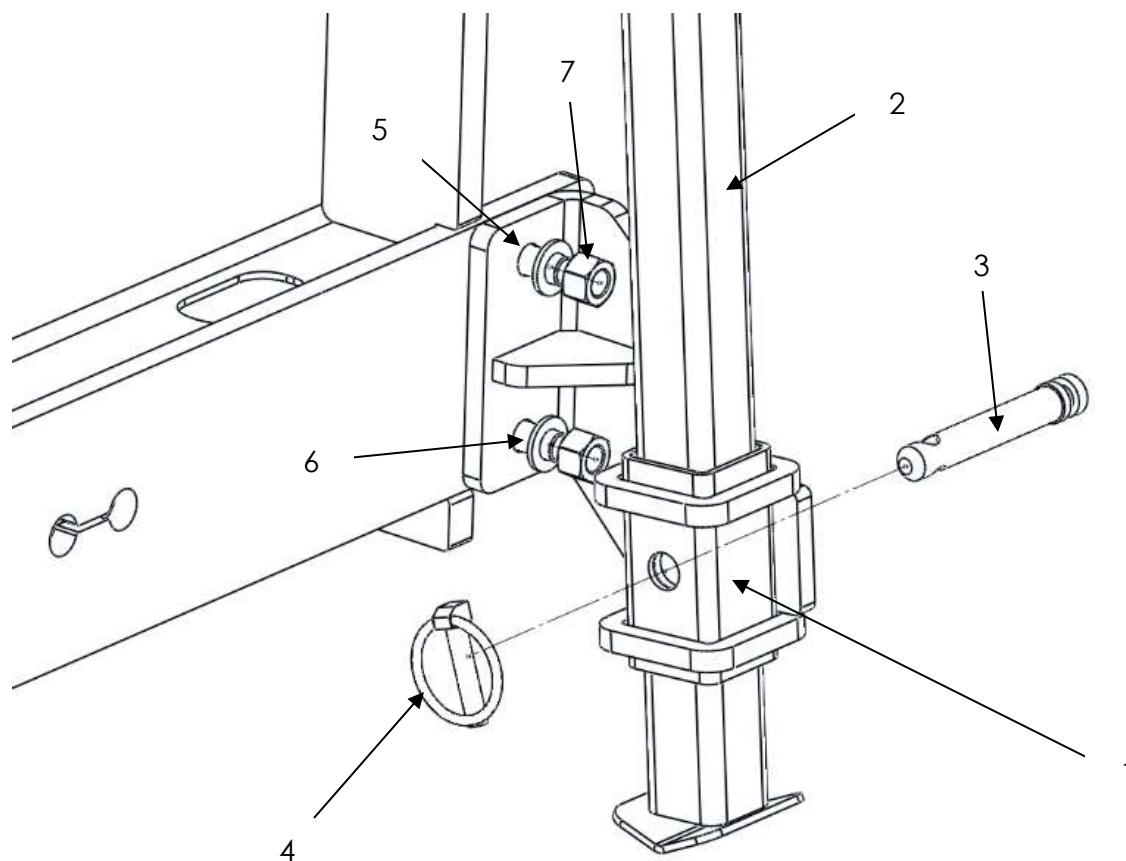


Item Number	Part Number	Description	Quantity per Machine
1	CY_701_2_(25_40)	Lid Adjustment Ram	2
2	AW_REV_1501	Lid Slider	2
3	AW_REV_SH	Slider Holder	2
4	M12 x 40	Slider Bolt Stop	2
5	M12 Washer	Slider Stop Washer	4
6	M12 Nylock	Slider Stop Nut	2
7	AW_LP6Z	Ram Linch Pin	4

Carriage

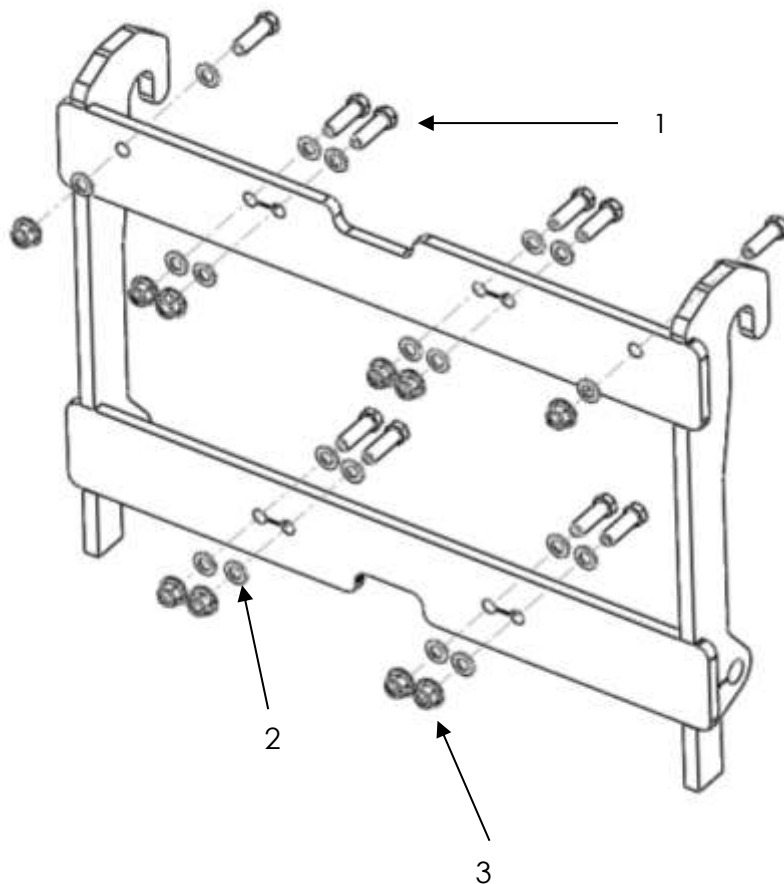
Item Number	Part Number	Description	Quantity per Machine
1	Class 2B	Pallet Fork	2
2	AW_CBF	Carriage Block Frame	1
3	M16 Nylock	Nut	2
4	M16 Flat Washer	-	4
5	M16 x 70	Bolt	2
6	AW_CB	40 x 40 Carriage Brace	1

Jack Stands (Opposites)

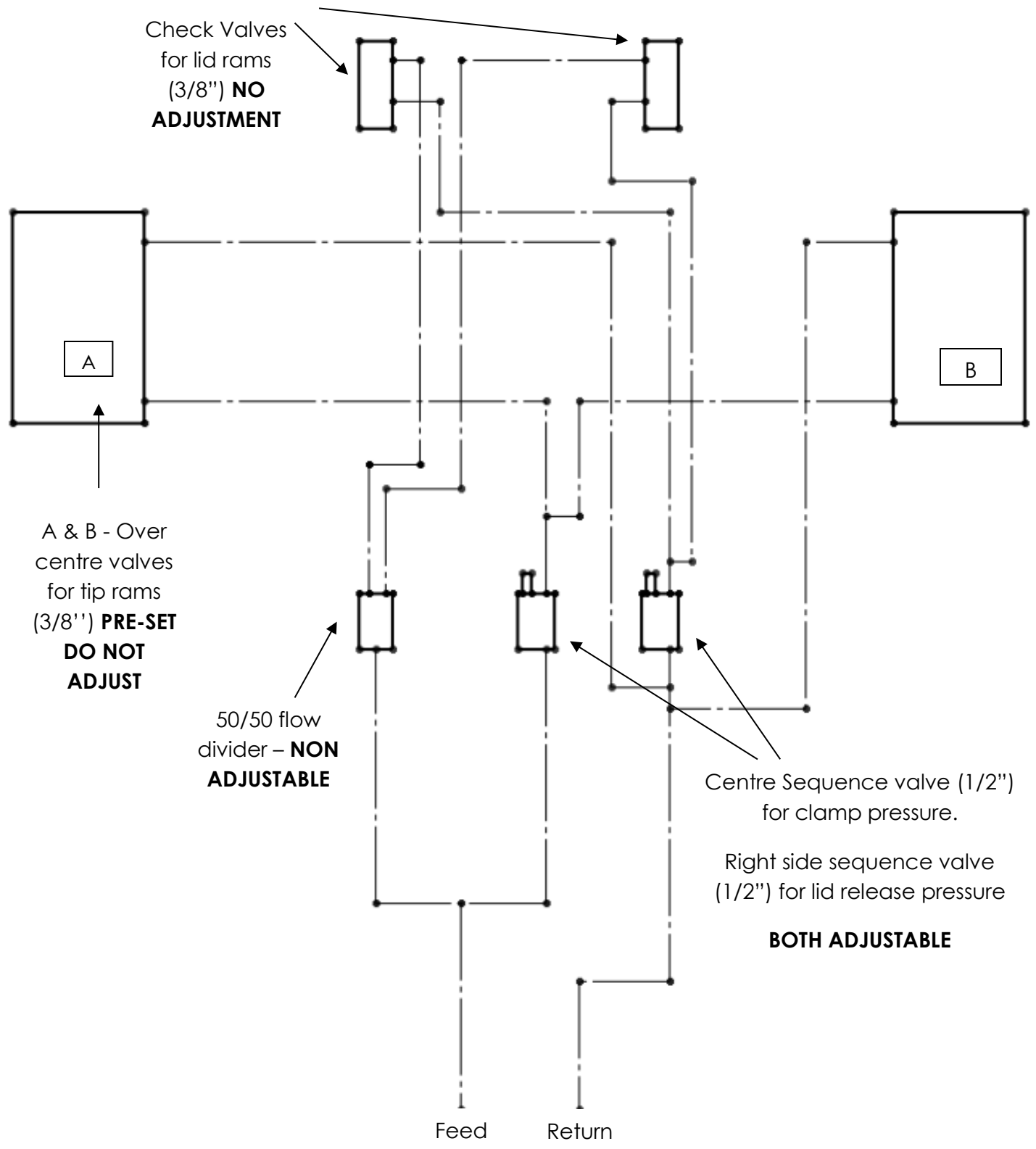


Item Number	Part Number	Description	Quantity per Machine
1	AW_JSH	Jack Stand Holder	2
2	AW_JSL	Jack Stand Leg	2
3	AW_JSP	Jack Stand Peg	2
4	AW_LP11Z	11mm Linch Pin	2
5	AW_M16_55	Stand Holder Bolts	4
6	AW_M16W	Stand Holder Washers	8
7	AW_M16N	Stand Holder Nuts	4

Brackets



Item Number	Part Number	Description	Quantity per Machine
1	M20 x70_CS	Counter Sunk Bolt	8
2	M20 Flat Washer	-	8
3	M20 Nylock	Nut	8



A & B - Over centre valves for tip rams (3/8") **PRE-SET DO NOT ADJUST**

Check Valves for lid rams (3/8") **NO ADJUSTMENT**

50/50 flow divider - **NON ADJUSTABLE**

Centre Sequence valve (1/2") for clamp pressure.

Right side sequence valve (1/2") for lid release pressure

BOTH ADJUSTABLE

Feed Return

The Revolution is run prior to dispatch to ensure all hydraulics are functioning correctly, however, allowing for a variation in hydraulic pressures there is adjustment available in the hydraulic system of the REVOLUTION as listed in the hydraulic diagram above. Please follow instructions on next page or contact us for assistance if required.



HYDRAULIC FUNCTION ADJUSTMENTS

You will only need to make adjustments if you find the clamping lid is;

RELEASING THE BOX TOO EARLY DURING RETURN ROTATION

On the RIGHT SIDE SEQUENCE VALVE – release the locking nut using a 13mm spanner and with a 4mm hex key, wind the hex key clockwise $\frac{1}{4}$ turn at a time to increase trip pressure and delay lid release. Run to test and repeat until you are happy with the lid release. Re-lock the 13mm nut.

BEGINNING ROTATION BEFORE THE LID CLAMPS THE BOX

On the CENTRE SEQUENCE VALVE – release the 13mm locking nut and using a 4mm hex key, wind the key clockwise a $\frac{1}{4}$ turn at a time to increase trip pressure at which the rotation starts and so the lid will then action before rotation. When you are happy, re-lock the 13mm nut.

Bolt on brackets for a JCB example.

QUICK-HITCH brackets or CARRIAGE BLOCKS require the following fittings;

8 X M20 X 70mm counter sunk socket head setscrew BZP - high tensile 10.9






8 X M20 high tensile grade 8.8 Nylock nuts

8 X M20 good quality washers (fitted nut side.)

IMPORTANT NOTE (FOR YARD TRUCKS - Excludes telehandlers)

CARRIAGE BLOCKS ONLY REQUIRE THE TOP BLOCK FITTING WITH “LOCKTITE” Top blocks are pre LOCKTITED before dispatch but will require LOCKTITE again if removed and re-fitted at any time.

Stickers

Sticker	Part Number	Description	Quantity per Machine
	AW_REV	Revolution Sticker	3
	AW_R_AS	Agriweld sticker	3
	AW_R_GB	Great Britain sticker	2
	AW_REV_OM	Read operator manual sticker	1
	AW_R_WS	Warning sticker	4

Warranty

Your Agriweld Revolution is covered for a period of 2 years from the date of dispatch (which is recorded on our files) against faulty components and/or bad workmanship.

Our welders are coded to ISO 9606-1 and our welding procedures are approved in accordance with ISO 15614-1 to manufacture your equipment. All products are checked for quality prior to delivery/collection.

We cannot be responsible for claims arising from ignorance, occurrences outside our control, such as accidents, and malicious damage and non-compliance with safety instructions.

Any damage occurred during transit must be reported on signing for the item from the haulier to enable us to enter a claim for damages direct with the haulier.

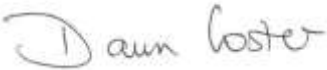
WARRANTY CLAIMS FOR DAMAGE DURING TRANSIT

Damage occurred during transit via an external haulier must be reported immediately upon unloading and signing for the item. The limit of our liability to undertake repairs to products damaged during transit is dependent on signing for any damaged product upon delivery as "DAMAGED".

CE DECLARATION OF CONFORMITY

The equipment which accompanies this declaration is in conformity with EU Directive(s):-

2006/42/EC Machinery Directive

Manufacturer Name:	Agriweld Ltd
Manufacturer Address:	Main Street Garton-on-the-Wolds Driffield East Yorkshire YO25 3ET
Product:	Revolution Box Rotator
Product Options:	All
Individual Serial Number:	
Product Description:	AGRIWELD Revolution Box Rotator
Date of Last Load Test Report:	N/A
Supplementary Information: MAX CAPACITY: 1500Kgs	
Authorised Signatory on Behalf of Manufacturer:	
Name of Signatory:	Dawn Foster
Position in Company:	Director
Date of Issue:	