

# Surge Hopper Assembly & Inverting Work Instructions

This work instruction provides a guide for the safe manipulation of the KE surge hopper. Following this procedure is always subject to our customers' own internal procedures including and not limited to safe lifting, control of potential/stored energy, exclusions zones and working at heights/with ladders. Always perform a job safety analysis, work with qualified crane and rigging personnel and play close attention to changing environmental conditions throughout the process.



**1.** Lift from the square side of the hopper.



**2.** Remove the first two 20mm stanchion leg bolts closest to the square side of the hopper.



**3.** Using 2 x M20 RUD lifts, attach them to the hopper as per photo instructions and as per manufacturers recommendations (4 better lifting guide).



**4.** Attach two legged chain sling to the RUD lifts.



- 5.** Slowly lift the hopper and turn it over. Lower it into the recommended resting position (refer label on side of hopper). Then remove the RUD lifters and replace the stanchion leg bolts.



- 6.** Using the crane and a soft sling, place the top hungry board into position and loosely bolt it.
- 7.** Place the side hungry boards into position and bolt them in place then tighten all hungry board bolts.



- 8.** To lift and position on the stack base, use two or four hook chains and use the supplied lifting points on either side of the hopper (refer to labels on each side).



- 9.** Once the legs of the hopper have been offered into the receive points then the locking pins must be inserted horizontally into the aligned holes at the bottom of the legs to secure the hopper and stacker base together.