BR-3, B R-3A

Table Top Bucking Machine

Owner's Manual

BE Hemp Equipment

Safety

At BE Hemp Equipment (BE), safety is our number one priority. The following information provides guidelines for safety when using BE equipment. Any piece of machinery can become dangerous to personnel when improperly operated or poorly maintained. All employees operating and maintaining BE equipment should be familiar with its operation and should be thoroughly trained and instructed on safety. Most accidents are preventable through safety awareness.

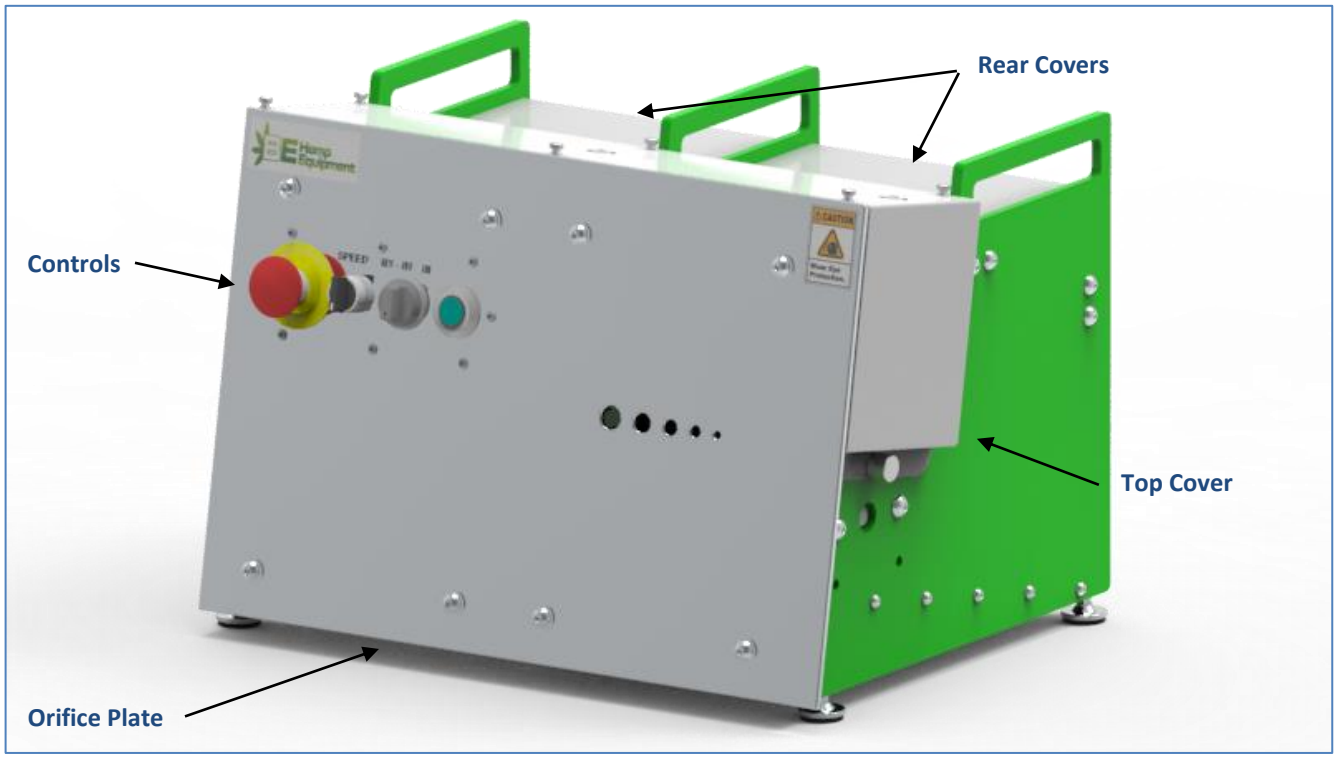
Every effort has been made to engineer safety into the design of BE equipment per standards set forth by ANSI, the National Electric Code, and others that apply as necessary. Areas of potential danger are mechanically and/or electrically protected. Safety labels and instructional decals are visible to the operator and located near any potential hazard.

General Safety Guidelines

- Ensure that all power sources are turned off or unplugged when the machine is not in use. Understand the LOCKOUT/TAGOUT procedure and use it before inspecting, maintaining, servicing or cleaning the equipment to help prevent anyone from accidentally turning on power to the machine.
- Read the manual for any special operational instructions for each piece of equipment. A hard copy can be made available if requested.
- Know how the equipment functions and understand the operating processes.
- Know how to shut down the equipment. Stop buttons, emergency stop buttons or cables are located at various locations on the machinery.
- Understand the equipment safety labels and heed them.
- Wear the appropriate personal protective equipment for the job to be performed (EX: eye protection, hearing protection, gloves, etc.). Ensure that nothing you are wearing could get caught in the machinery
- When working on or around all equipment, avoid wearing loose clothing, jewelry, unrestrained long hair, or any loose ties, belts, scarves or articles that may be caught in moving parts. Keep all extremities away from moving parts. Entanglement can cause death or severe injury.
- For new equipment, check plant voltage with the voltage specified on the machine. Electrical specifications for your machine are printed on the machine serial number tag.
- A properly grounded electrical receptacle is required for safe operation regardless of voltage requirements.
- Treat this equipment with the respect its power and speed demand. Use it only for its intended purpose.

- Keep the operating zone free of obstacles that could cause a person to trip or fall toward an operating machine. Keep fingers, hands or any part of the body out of the machine and away from moving parts when the machine is operating.
- Any machine with moving parts and/or electrical components can be potentially dangerous no matter how many safety features it contains. Stay alert and think clearly while operating or servicing the equipment. Be aware of operations and personnel in your surroundings. Be attentive to indicator lights, warning lights and/or operator interface screens displayed on the machine and know how to respond.
- Rotating and moving parts are dangerous. Keep clear of discharge area of the machine.
- Never put any foreign objects, other than what the machine is intended for, into the machine's input ports.
- Use proper lifting and transporting devices for heavy equipment. This equipment is heavy. An appropriate lifting device should be used.
- Use caution when moving portable equipment. In some cases the machinery can be heavy and/or may be top heavy if loaded. Portable equipment can gain momentum during transporting and must be controlled at all times.
- Always operate in a well ventilated area. Bucking produces dust!

MACHINE OVERVIEW

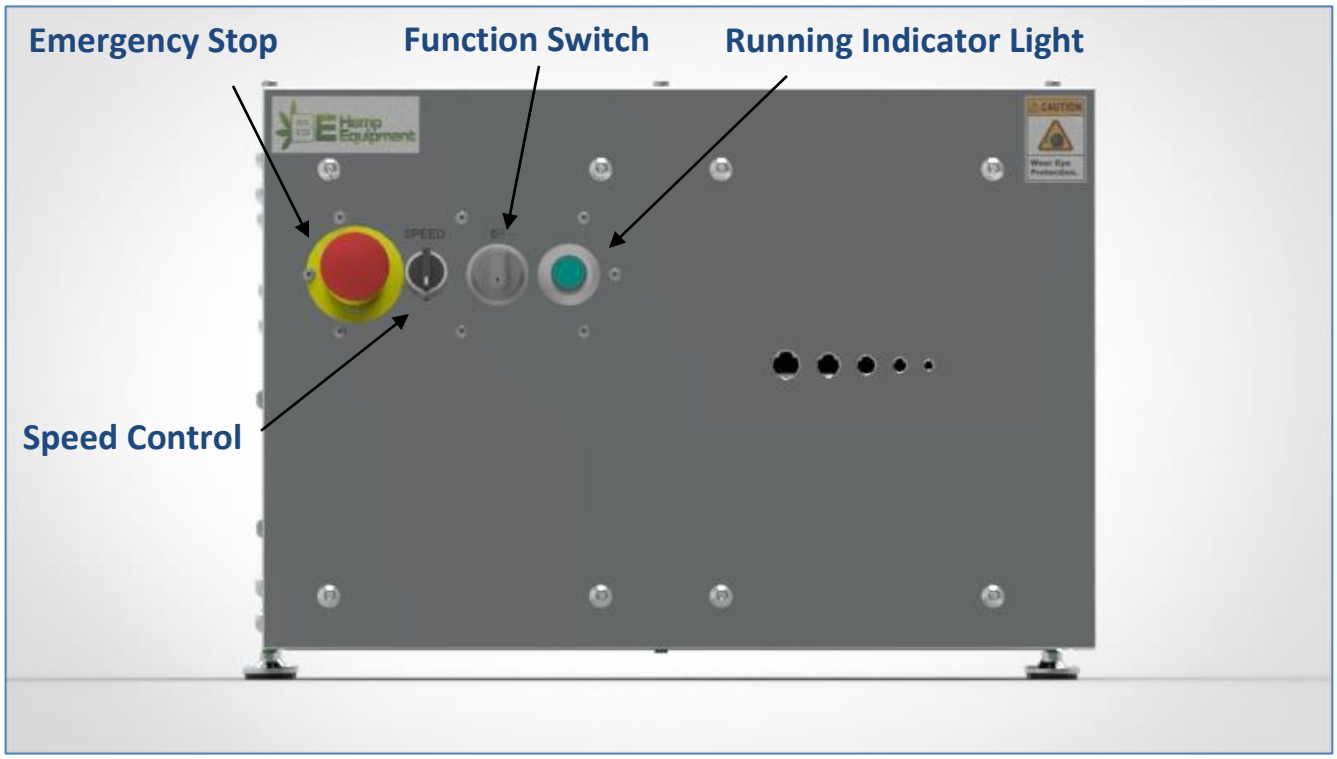


WHATS IN THE BOX

The BR-3 comes fully assembled and ready to buck. When unpacking the machine, please ensure the following items are present;

- BR-3 Bucker Machine (obviously)
- Allen Wrench, 5/16"

CONTROLS



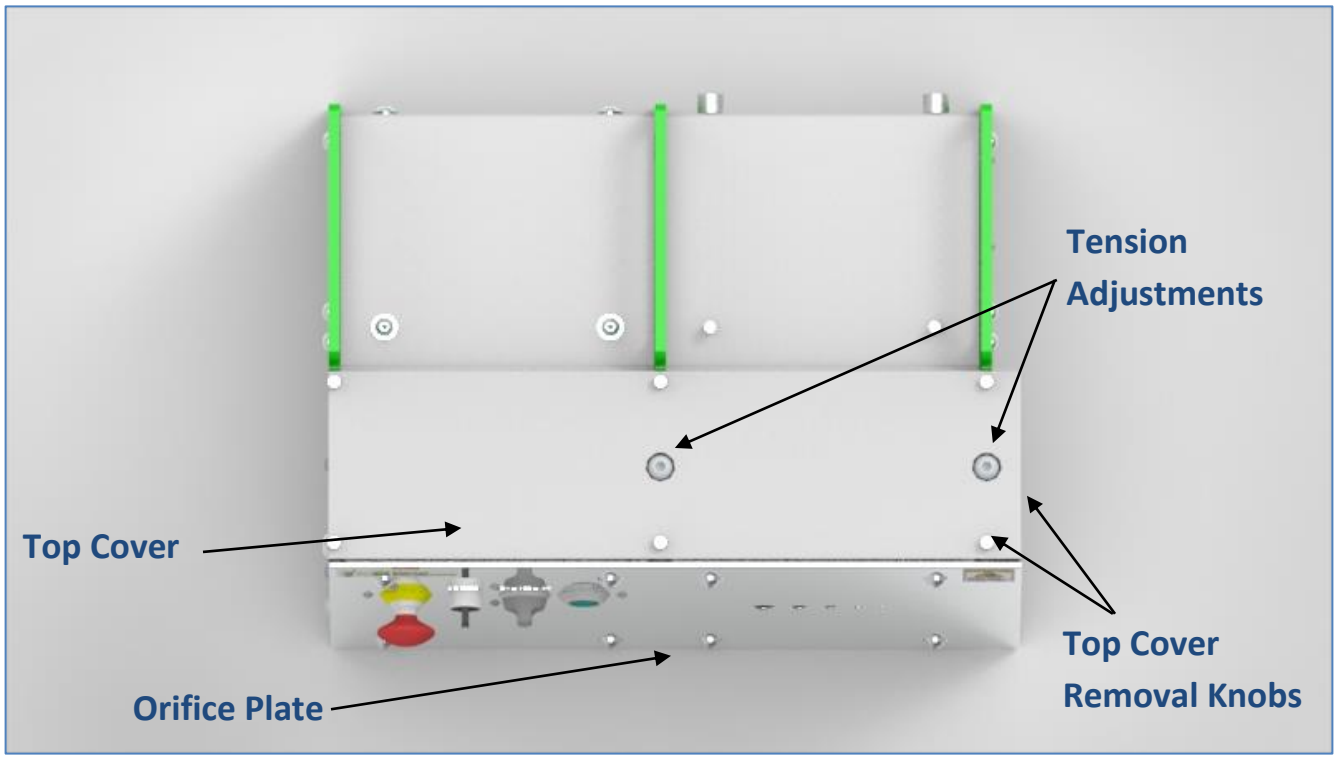
Function Switch: Able to control operation between OFF, ON, AND REVERSE function

Speed Control: Controls the speed of the bucker

Running Indictor Light: Illuminates green when operating bucker in ON function.

Emergency Stop: Push in to stop function immediately. Pull outwards after to return to normal operation

BUCKER ADJUSTMENTS



Orifice Plate: Front plate used to shed flower and leaf from stem.

Top Cover: Safety shield used to cover rotating parts.

Tension Adjustments: 5/16" Allen headed screws sued to adjust tension (grabbing grip of stem) to roller assemblies. Clockwise tightens grip and counterclockwise releases it.

Top Cover Removal Knobs: These 6 knobs on top and one on the side keep the cover attached the rest of the bucker assembly. Tighten by hand only. Do not overtighten.

WHEN TO BUCK

Wet Bucking: Wet bucking can occur anytime!

Dry Bucking: Obviously, different strains will require different moisture content, but we recommend between **12-14%** total moisture content.

- Check the flower by pinching it between two fingers. It should spring back to original shape.
- Flower that is too dry will break apart during bucking
- Flower that is too wet will deform

PREPERATION

Prepare both the plant and area prior to bucking.

Area Preparation

1. Ensure adequate space around the equipment. Ensure that extra space behind the machine (where the stem is exits the machine). Hurd is going to stack up quick!
2. Review electrical requirements.
   - Try to buck in as cool as an environment as possible (65°F-75°F is ideal).

Plant Preparation

1. Cut the main stalk and separate into individual stems removing any "Y"s from the stems, trying to leave at least 2"-3"s of bare stem at the bottom.
   - Place in container pointed in one direction for speed of process.

GENERAL OPERATION

Normal Operation

- Inspect bucker for any damage. Do not operate if damage is observed.
- Place desired "Tote" below the Orifice Plate in front of the stem ports.
  - Place the "Tote" just below the orifice plate for best results.
- Adjust Roller Tensioners clockwise, until you feel slight resistance.
- Ensure Emergency Stop is pulled to outward position.
- Turn Function Switch to ON position
  - Running light should turn on, indicating that the rollers are moving.
- Adjust speed to desired output speed.
  - When bucking dry, use lower speed settings to reduce potential damage to flower.
- Feed stem side into an appropriately sized hole on the Orifice Plate until you feel the rollers grab onto stem and pull it into the machine.
  - The flower and leaves should drop into the Tote below.
  - Periodically check the stem pile behind the machine and remove the stems as required to ensure adequate ejection space for the machine!

Clearing a Stuck Hurd (Stem)

- Turn Function Switch REV positon and hold until Hurd is backed out of the Orifice Plate.
  - You may need to help guide the stem from the orifice by pulling on it at the same time as reversing the machine.

Machine Shutting Down

- Turn Function Switch to OFF position
- Push Emergency Stop Switch downward into STOP position
- Adjust Roller Tensioners counterclockwise to remove all pressure from roller assembly

CLEANING

Cleaning of your machine will ensure that your machine can be used for years to come. We suggest a light cleaning daily after each shift and more thorough cleaning every week and/or before being stored.

⚠ Use standard water based, non-caustic, FDA Food grade approved detergents and/or clean water to clean machine.

Daily Cleaning

- Dust off all exposed machine surfaces with a clean cloth
- Remove Top Cover and Rear Cover from Bucker Assembly and wipe total surface of both upper and lower roller using Isopropyl Alcohol with a clean cloth.
  - ⚠ **Do not pressure wash rollers.** Damage can occur over time.
- Using a plastic brush and/or cloth, clean each orifice

Weekly Cleaning

- Perform all daily cleaning tasks
- With cover removed, pressure wash interior of Bucker Assembly paying special attention not to spray electrical controls, motor assembly, or rollers.
- Pressure Wash Frame
- Using water with detergent, dampen cloth and wipe down entire Drive/Control Assembly.
  - ⚠ **Do not pressure wash Drive/Control Assembly.**

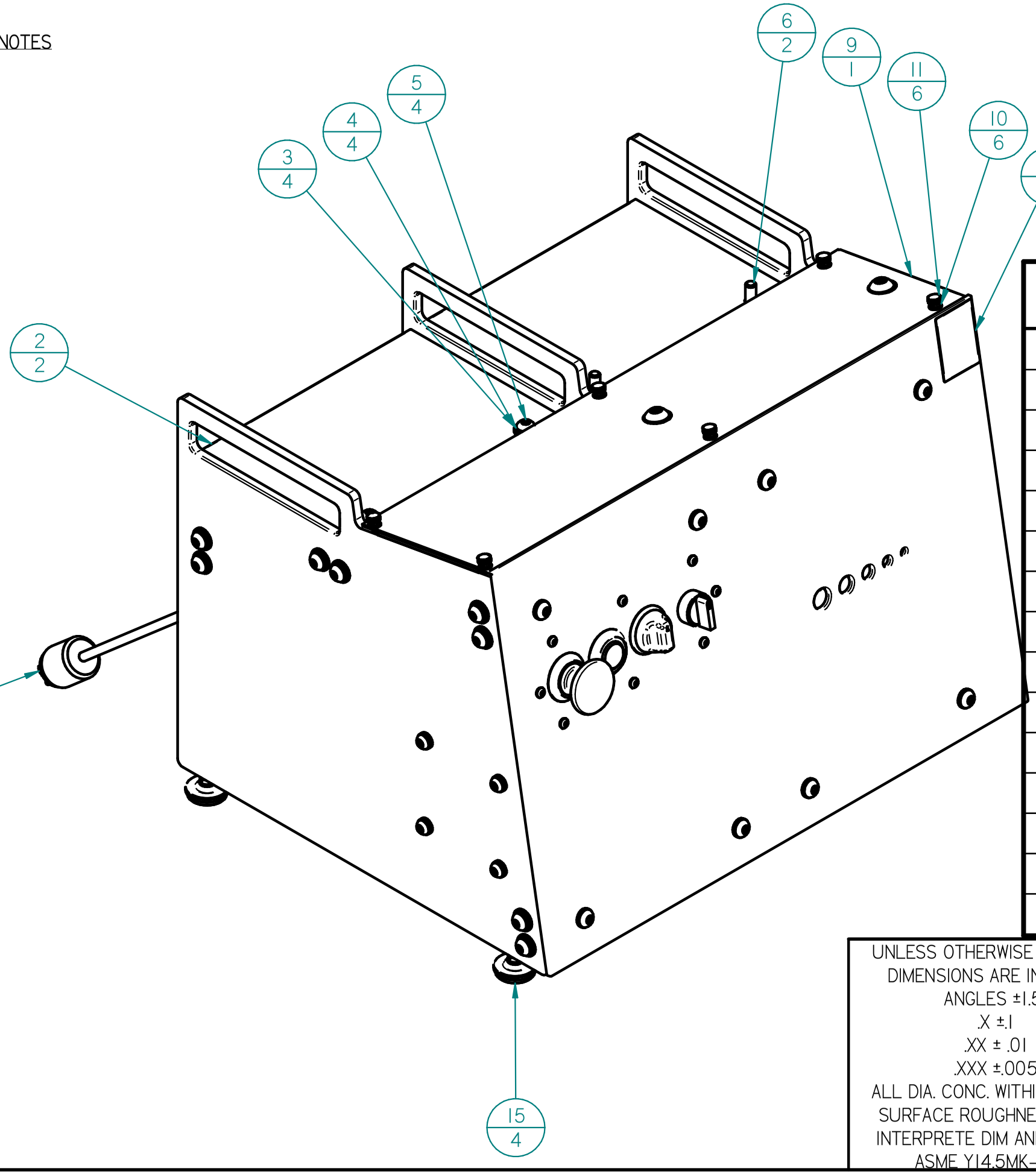
MAINTENANCE

Annual and periodic maintenance is suggested to keep you Bucker operating at peak performance.

Checks

- Check the cord and receptacle for damage. Any damage should be repaired immediately.
- Inspect electrical conduit and connections for damage and signs of leakage.
- Inspect rollers for uneven wear, groves, or damage.
  - ⚠ Replace if damage prevents normal operation. BE Hemp Equipment offers a roller exchange program. Contact BE Hemp Equipment for details.
- Verify that all electrical controls are in good working condition.

NOTES



Item Number	Quantity	Document Number	Title
1	1	2-A007-02	ASSY, FINAL, #2
2	2	2-0027-01	COVER, REAR
3	4	91950A031	WASHER, SAE, 3/8
4	4	92147A031	WASHER, SPLIT, 3/8
5	4	92949A623	SCREW, BUTTON, 3/8-16 X .875
6	2	97042A316	STUD, PARTIAL,LY THREADED
7*	3	90295A471	WASHER, NYLON, 3/8
8*	3	93585A390	THUMB SCREW, 3/8-16 X 3/4
9	1	2-0026-01	PLATE, TOP
10	6	90295A422	WASHER, NYLON, #10
11	6	99607A145	THUMBSCREW, 10-24 X 1/2
12	1	5948T921	PLACARD, EYE PROTECTION
13*	2	7967T55	PLACARD, WARNING, GAURDS
14*	1	5891T48	PLACARD, DANGER, GAURDS
15	4	6167K15	LEVELING MOUNT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

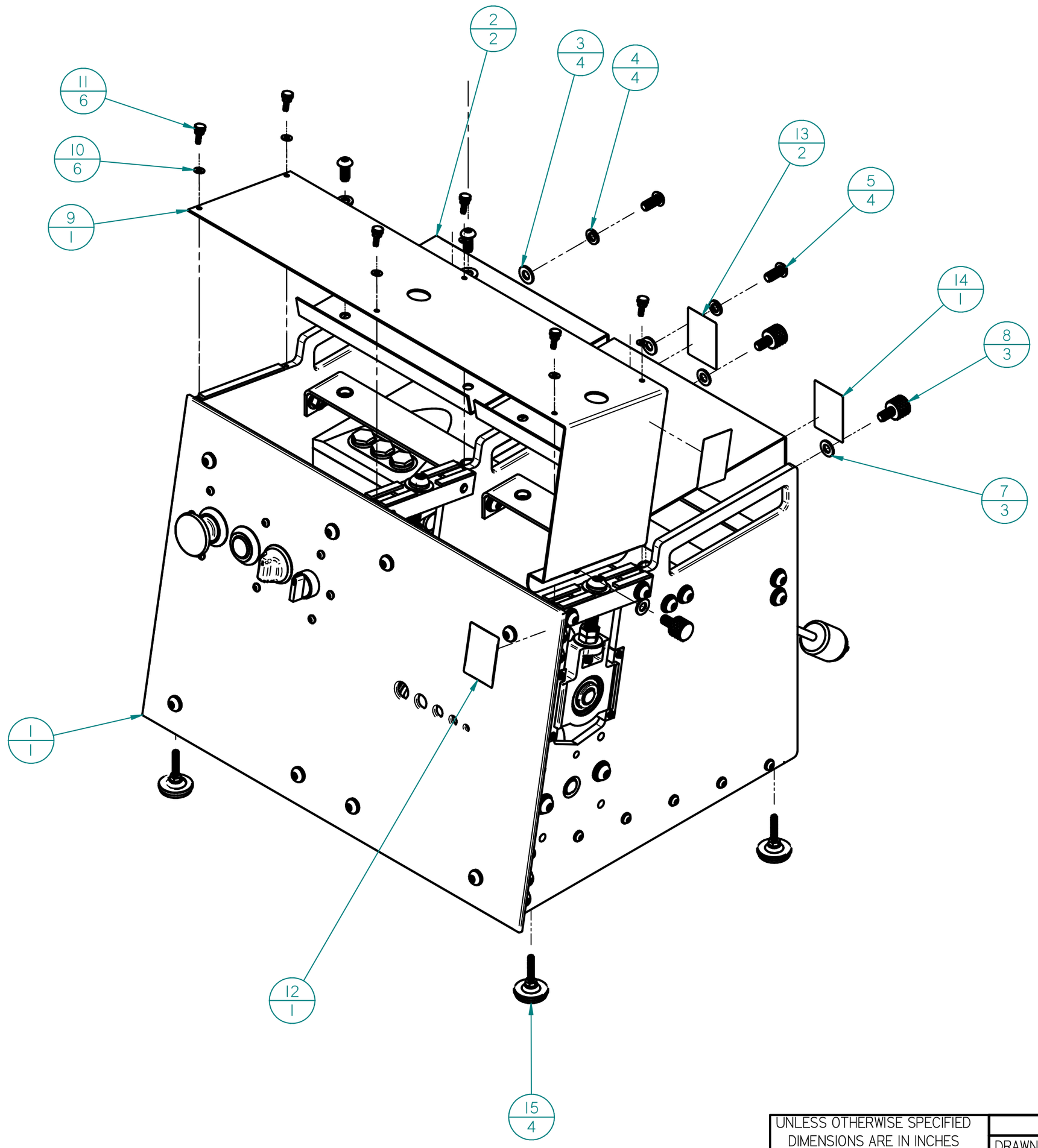
TITLE
ASSY, FINAL # 1

SIZE	DWG NO	REV
B	2-A007-01	A

FILE NAME: 2-A007-03-A 3.dft

SCALE:	WEIGHT:	SHEET 1 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	12/03/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, FINAL # 1

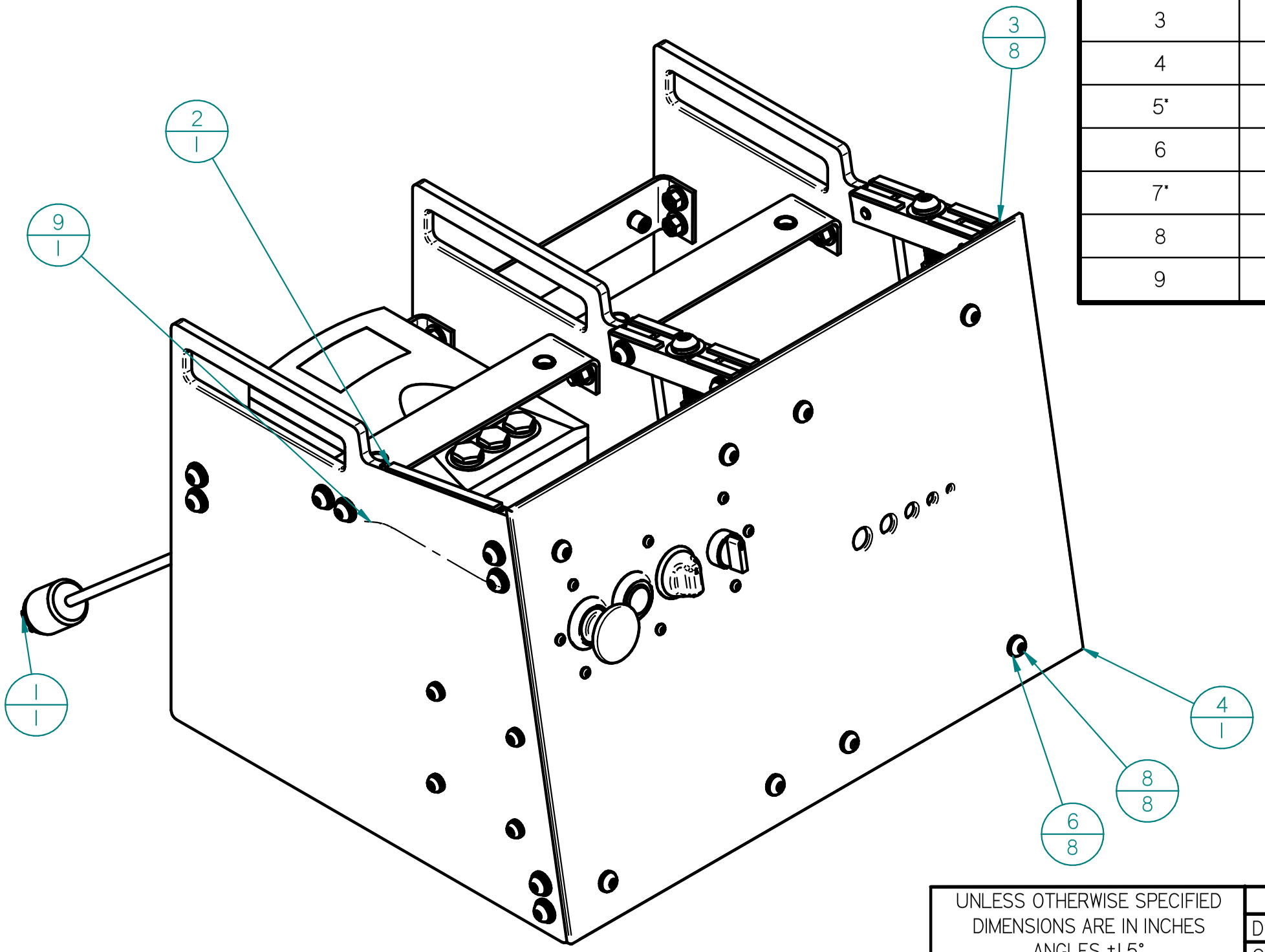
SIZE	DWG NO	REV
C	2-A007-01	A

FILE NAME: 2-A007-03-A 3.dft

SCALE:	WEIGHT:	SHEET 2 OF 3

NOTES

1. TORQUE ALL FASTENERS PER SAE STANDARDS



Item Number	Quantity	Document Number	Title
1	1	2-A007-01	ASSY, FINAL, # 1 STEP
2	1	NA	RUBBER, .375 X .125 X 5.0
3	8	AR	RUBBER STRIP, .375 X .125 X 2
4	1	2-A006-01	ASSY, PANEL AND ELECTRICAL
5*	8	91950A031	WASHER, SAE, 3/8
6	8	92147A031	WASHER, SPLIT, 3/8
7*	8	91845A031	NUT, 3/8-16
8	8	92949A623	SCREW, BUTTON, 3/8-16 X .875
9	1	NA	LIQUID TIGHT, 1/2" X 6 1/2"

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

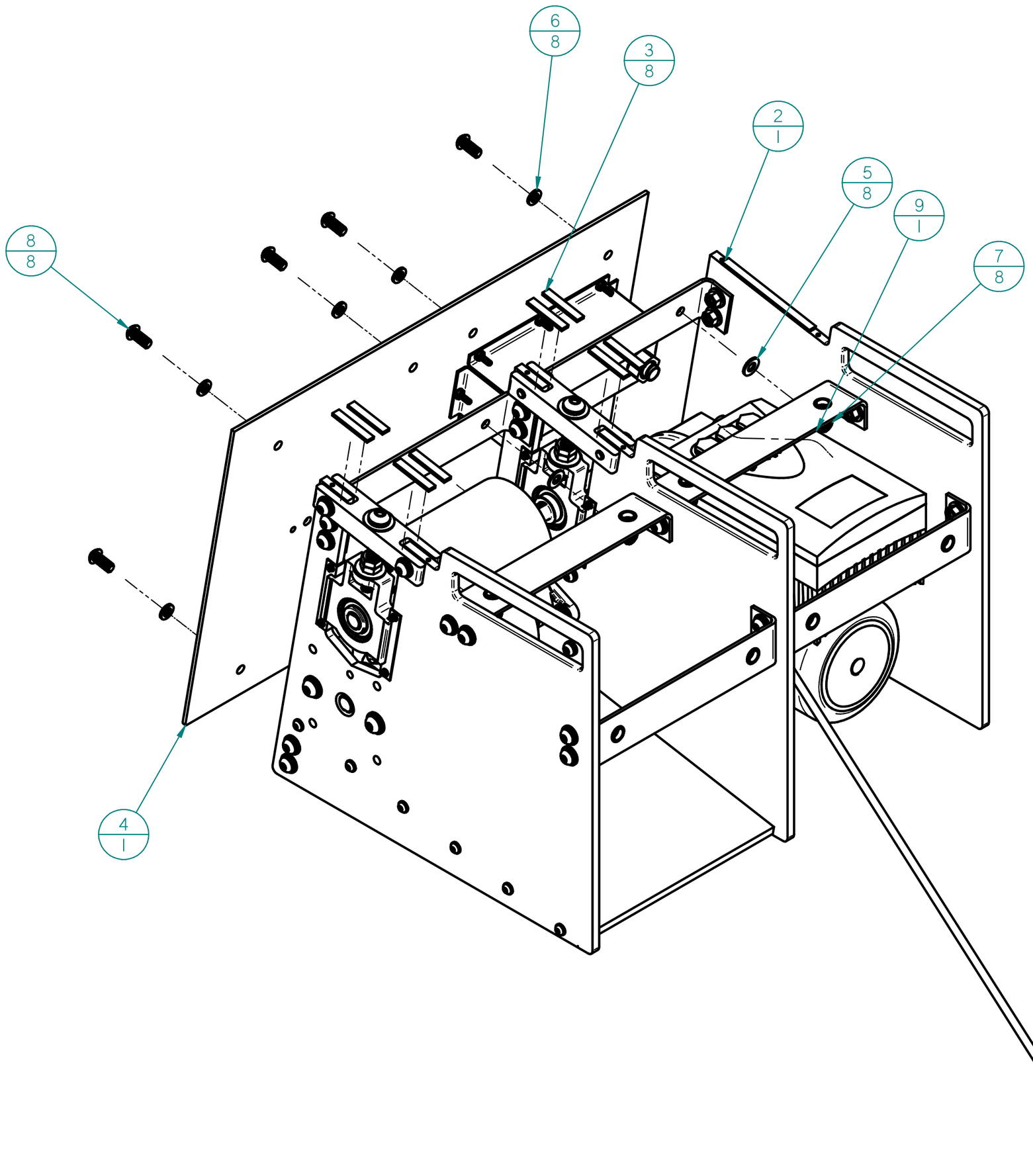
TITLE
ASSY, FINAL # 1

SIZE	DWG NO	REV
B	2-A007-01	A

FILE NAME: 2-A007-02-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

1	NAME	DATE
DRAWN	User	12/02/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

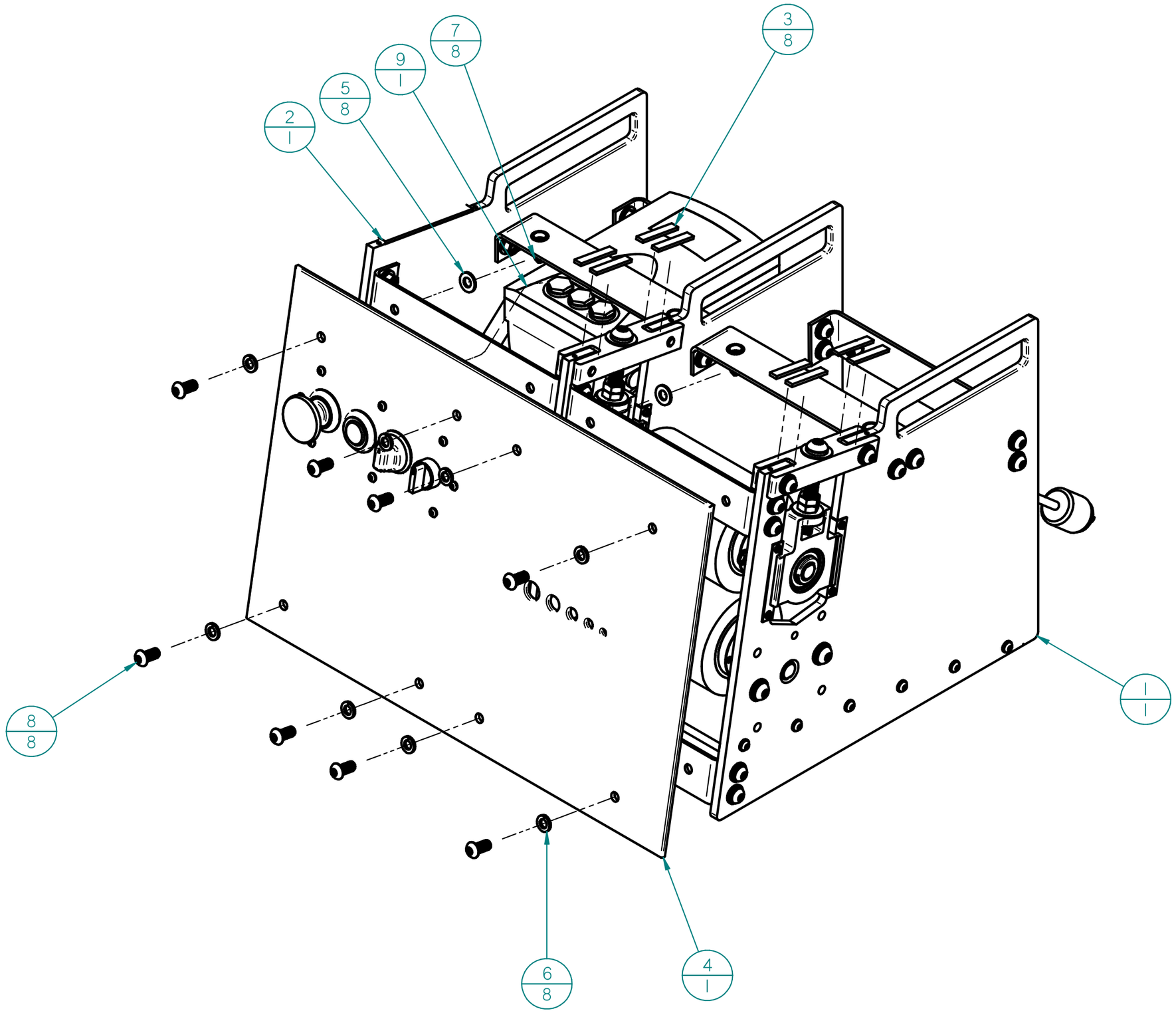
TITLE
ASSY, FINAL # 1

SIZE	DWG NO	REV
C	2-A007-01	A

FILE NAME: 2-A007-02-A.dft

SCALE:	WEIGHT:	SHEET 2 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	12/02/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, FINAL # 1

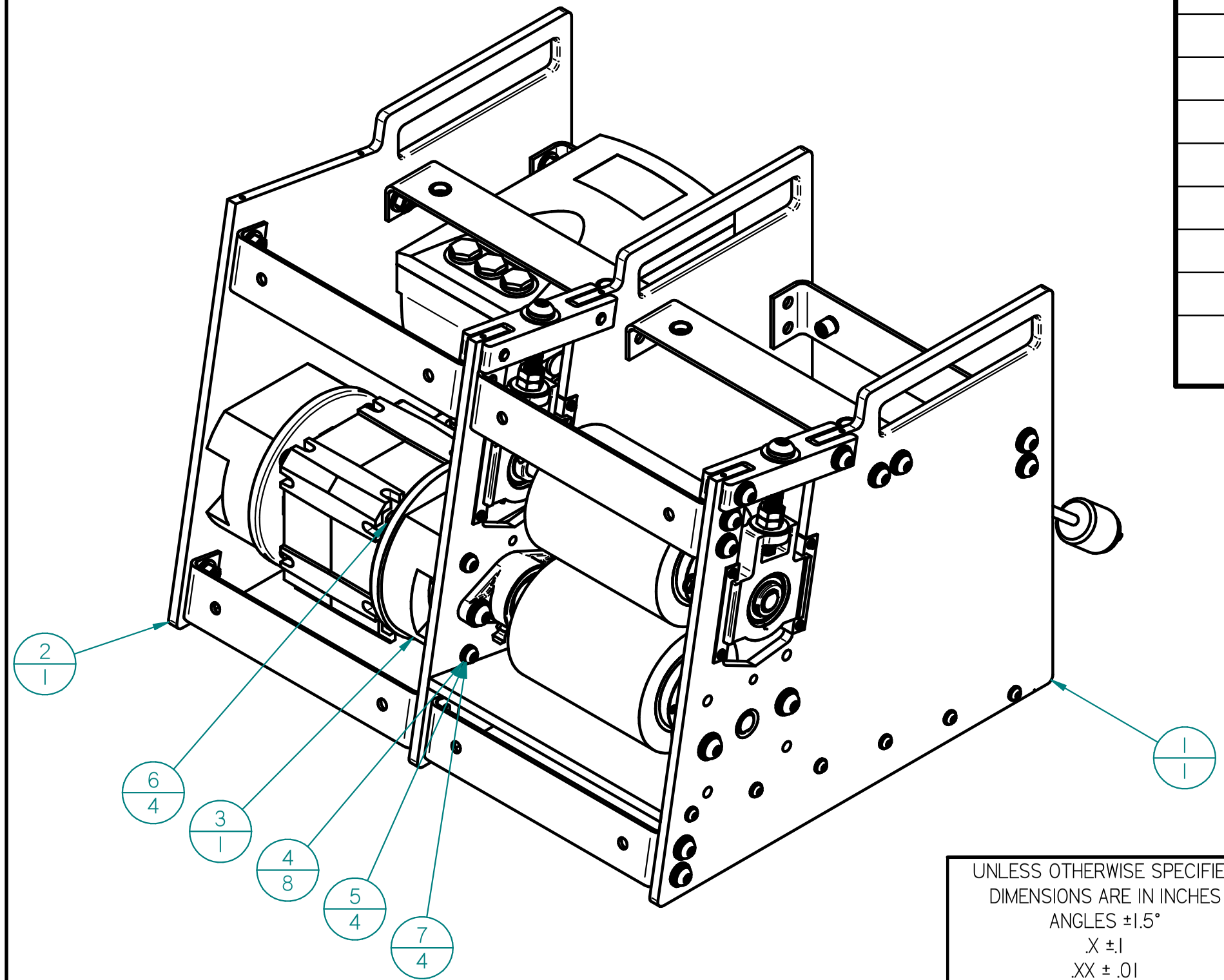
SIZE	DWG NO	REV
C	2-A007-01	A

FILE NAME: 2-A007-02-A.dft

SCALE:	WEIGHT:	SHEET 3 OF 3

NOTES

1. TORQUE ALL FASTENERS PER SAE STANDARDS



Item Number	Quantity	Document Number	Title
1	1	2-A003-01	ASSY, CARRIER
2	1		
3	1	2-0014-02	COLLAR, MOTOR
4	8	98689A116	WASHER, M8, SS
5	4	92148A200	WASHER, SPLIT LOCK, M8
6	4	91828A410	NUT, M8, SS
7	4	92095A336	SCREW, M8
8*	16	91950A031	WASHER, SAE, 3/8
9*	8	92147A031	WASHER, SPLIT, 3/8
10*	8	91845A031	NUT, 3/8-16
11*	8	92949A628	SCREW, BUTTON, 3/8-16 X 1 1/2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

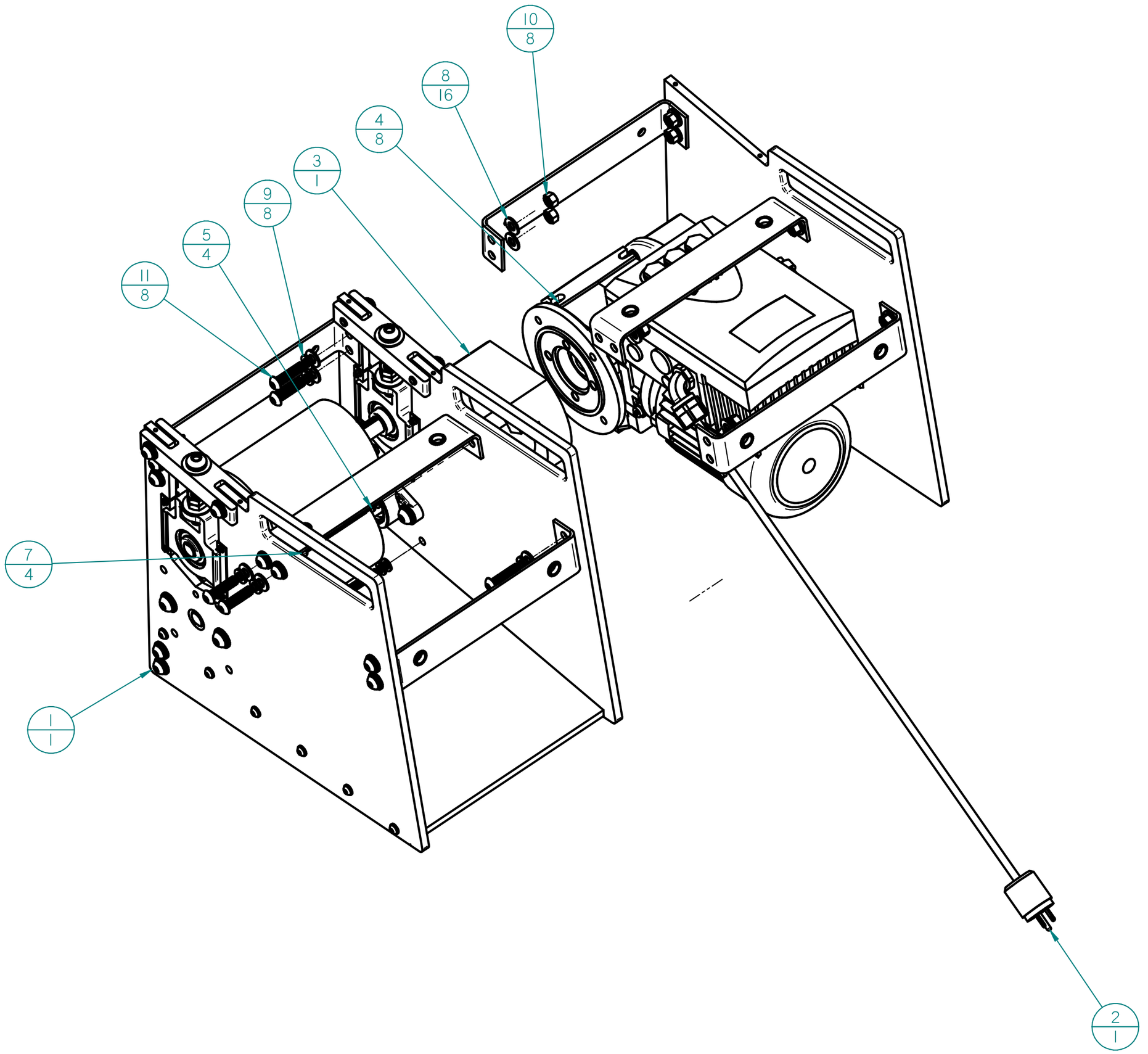
TITLE
ASSY, FINAL # 1

SIZE	DWG NO	REV
B	2-A007-01	A

FILE NAME: 2-A007-01-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	12/02/20
CHECKED		

MATERIAL: SEE BOM

FINISH: NONE

BE HEMP EQUIPMENT

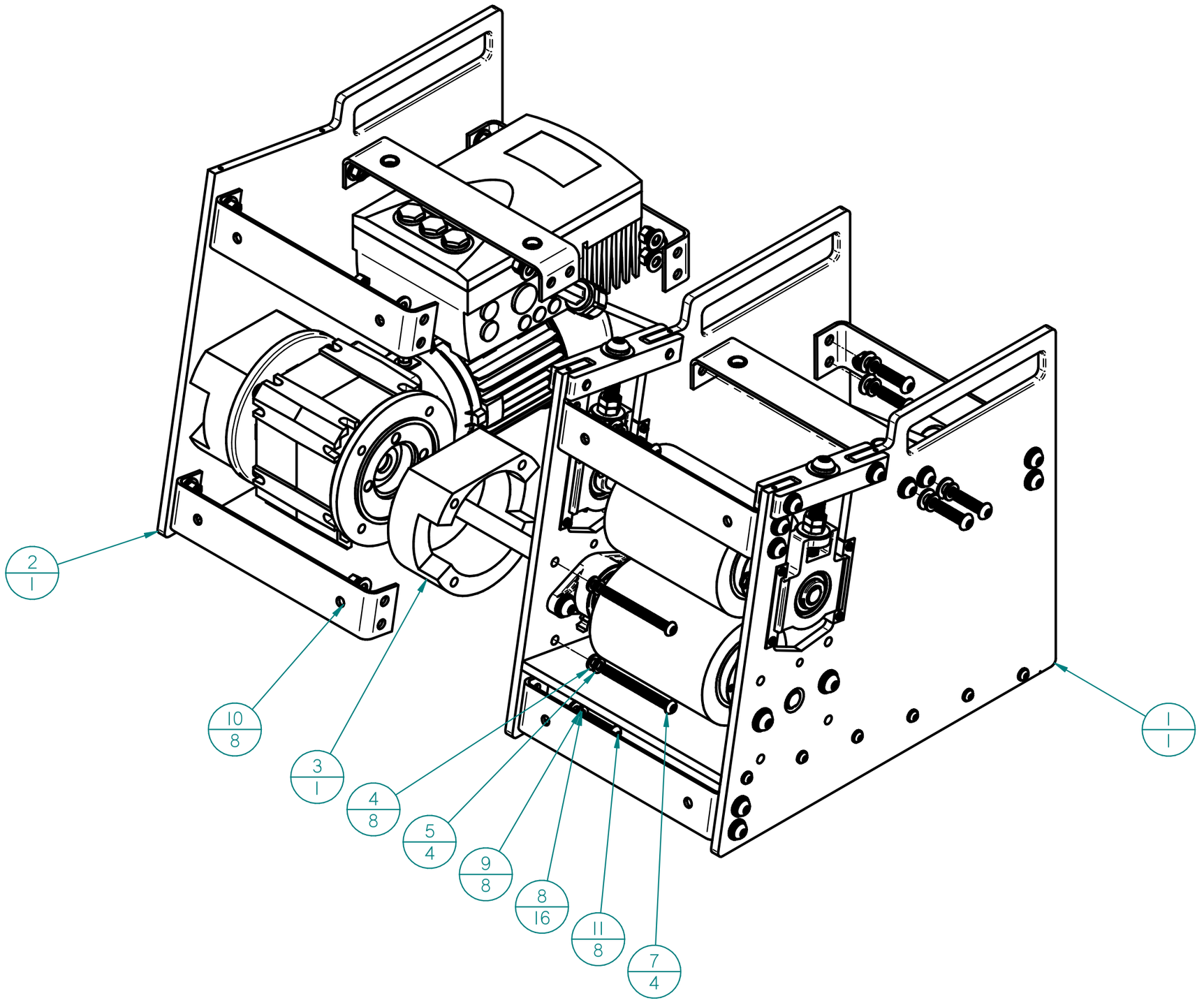
TITLE: ASSY, FINAL # 1

SIZE	DWG NO	REV
C	2-A007-01	A

FILE NAME: 2-A007-01-A.dft

SCALE:	WEIGHT:	SHEET 2 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	12/02/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, FINAL # 1

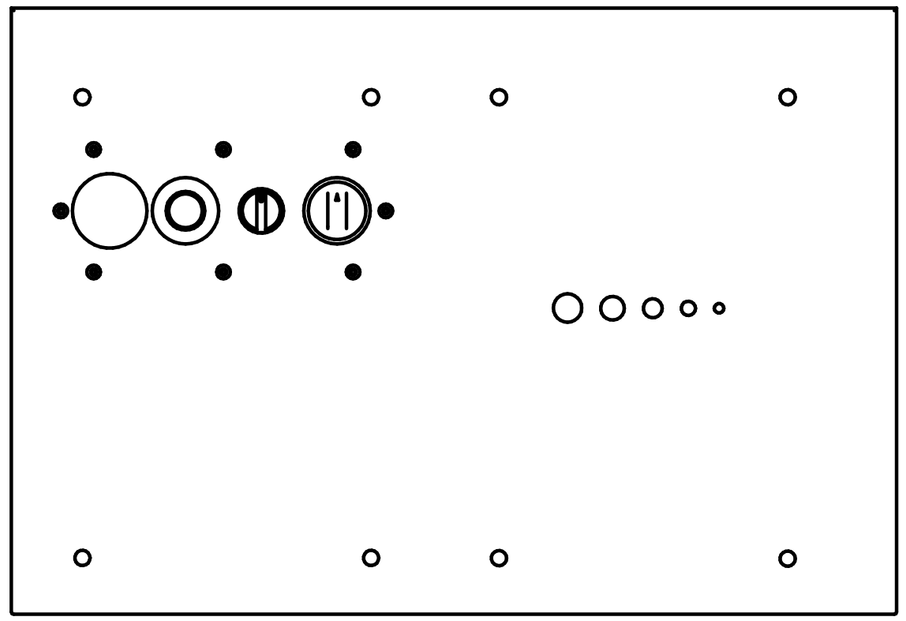
SIZE	DWG NO	REV
C	2-A007-01	A

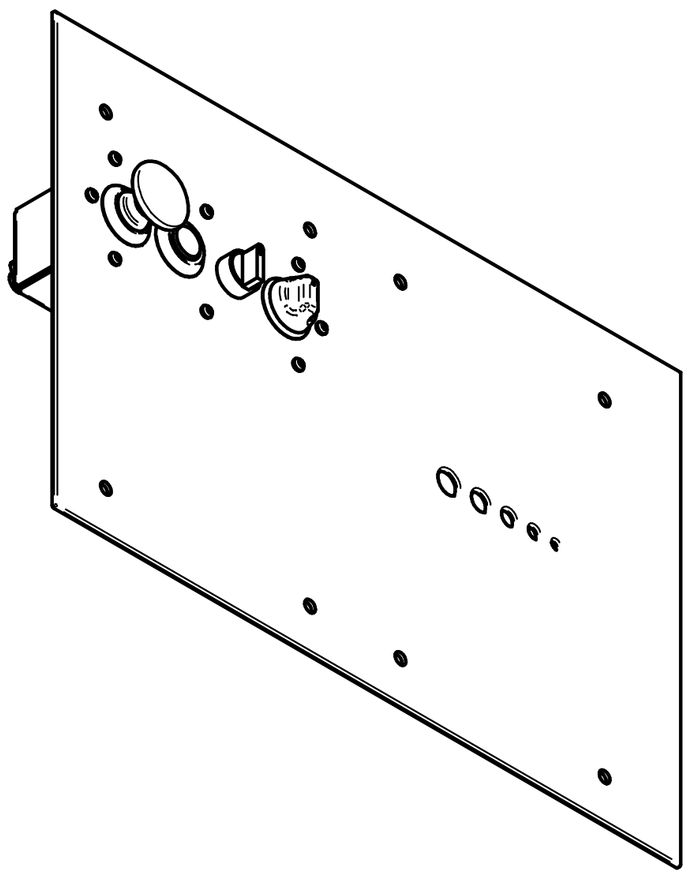
FILE NAME: 2-A007-01-A.dft

SCALE:	WEIGHT:	SHEET 3 OF 3

NOTES

ASSEMBLE PER INSTRUCTIONS





Item Number	Quantity	Document Number	Title
		2-A006-01	ASSY, PANEL AND ELECTRICAL
1	1	2-0017-01	PLATE, FRONT DIE
2	1	NWTS32	SELECTOR SWITCH, 3 POS
3	1	NDRZ50RT-2905-1	SWITCH, ESTOP
4	1	NMLGN	INDICATOR, GREEN
5	1	EF03.1	BLOCK, NO, POS 1
6	1	EF03.3	BLOCK, TERMINAL, NO, 3 POS
7	1	EF303.3	BLOCK, NO, POS 3
8	1	ELDE.NGN24	BLOCK, TERMINAL, LED 24VDC
9	1	2-0025-01	BOX, ELECTRICAL
10	8	90107A011	WASHER, #10
11	8	92147A430	WASHER, SPLIT LOCK, #10
12	8	92949A247	SCREW, BUTTON HEAD, 10-24-1
13	8	91841A011	NUT, 10-24
14	1	9106K42	STRAGHT CONNECTOR, 1/2 LIQUID TIGHT
15*	2		CONDUIT, 1/2 LIQUID TIGHT, 5.25" LONG
16	1	ECX2300-10K	POTENTIOMETER, 10K

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ± .1
.XX ±.01
.XXX ± .005
ALL DIA CONC WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM AND TOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	07/26/21
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSEMBLY, ELECTRICAL PANEL

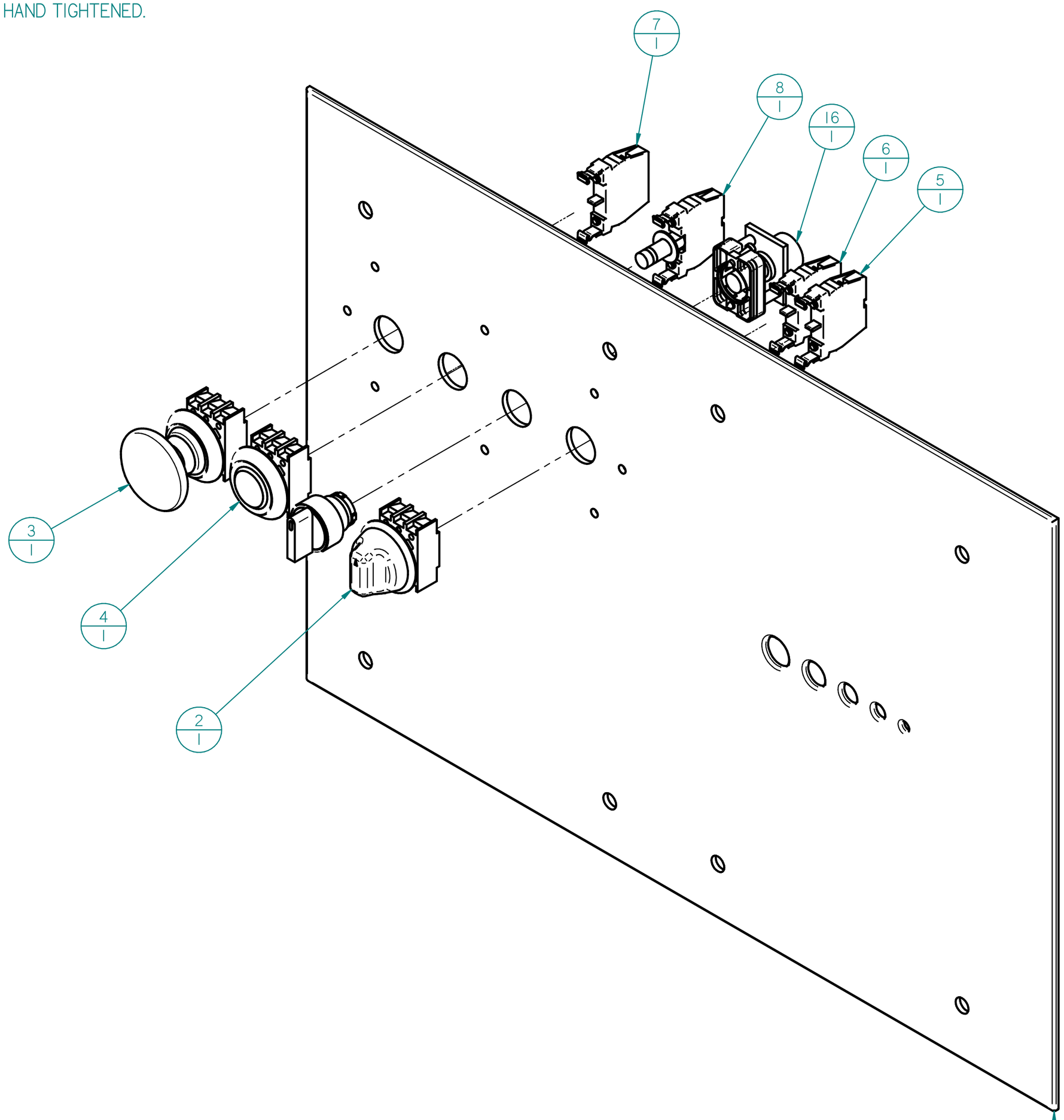
SIZE	DWG NO	REV
C	2-A006-01	A

FILE NAME: 2-A006-01.dft

SCALE:	WEIGHT:	SHEET 1 OF 4

NOTES

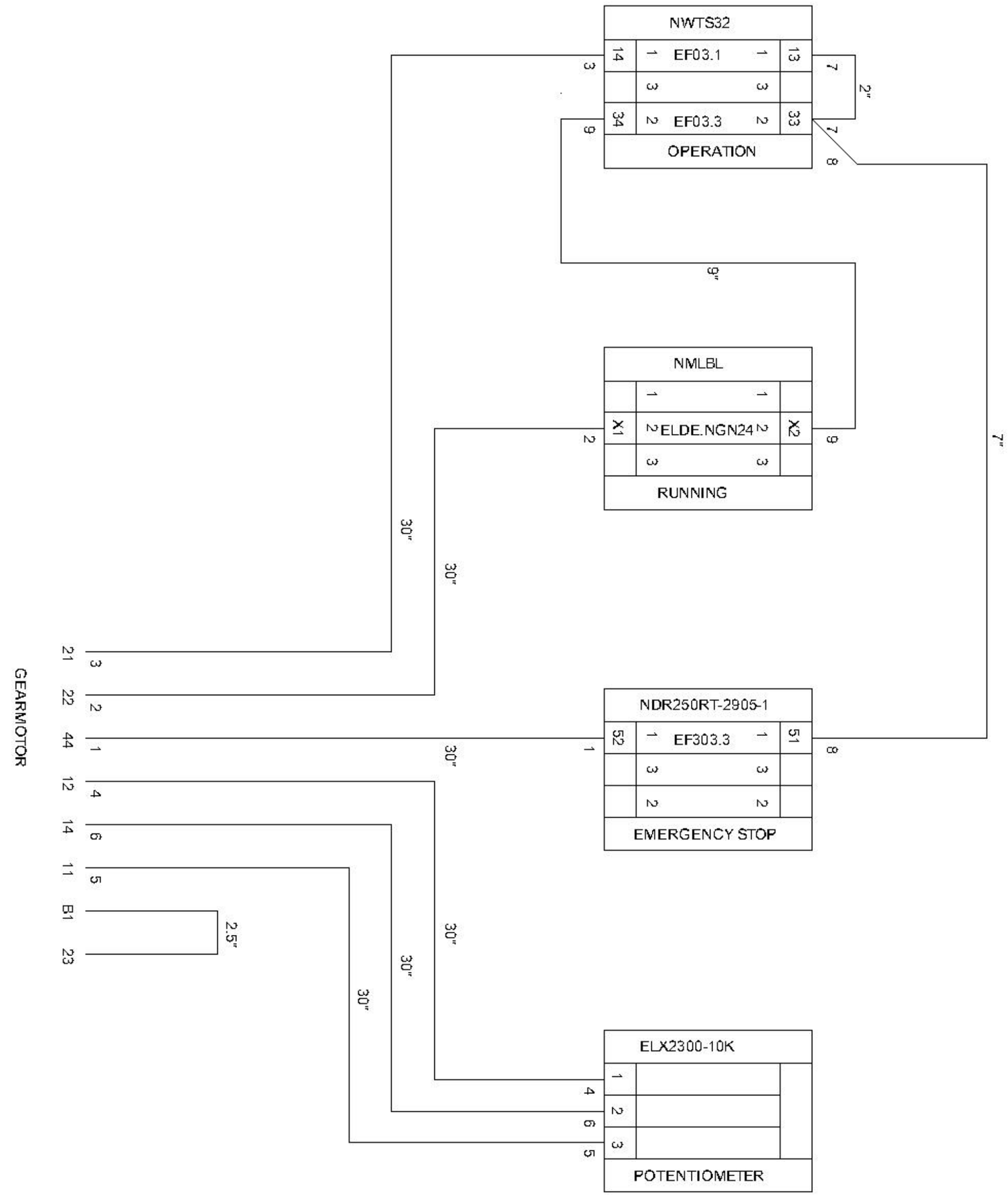
1. ASSEMBLE PER BOM.
2. ENSURE ALL MOUNTING SCREWS ARE HAND TIGHTENED.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES ANGLES ±1.5° .X ± .1 .XX ±.01 .XXX ± .005 ALL DIA CONC WITHIN .005 TIR SURFACE ROUGHNESS OF 63 INTERPRETE DIM AND TOL PER ASME Y14.5MK-1994		NAME	DATE	BE HEMP EQUIPMENT
	DRAWN	B P BALE	07/26/21	TITLE: ASSEMBLY, ELECTRICAL PANEL
	CHECKED			
	MATERIAL: SEE BOM			SIZE: C / DWG NO: 2-A006-01 / REV: A
	FINISH: NONE			FILE NAME: 2-A006-01.dft
				SCALE: / WEIGHT: / SHEET 2 OF 4

NOTES

1. CUT ALL WIRES TO LENGTH IAW SCHEMATIC
2. STRIP WIRES BEING INSERTED INTO TERMINALS $\frac{1}{4}$"
3. INSERT WIRES AND TIGHTEN TO "HAND TIGHT"
4. USE ZIP TIES AT EVERY ENTRANCE/EXIT OF WIRE/WIRE FROM BUNDLE IN ROUTING.



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ± .1
.XX ±.01
.XXX ± .005
ALL DIA CONC WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM AND TOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	07/26/21
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSEMBLY, ELECTRICAL PANEL

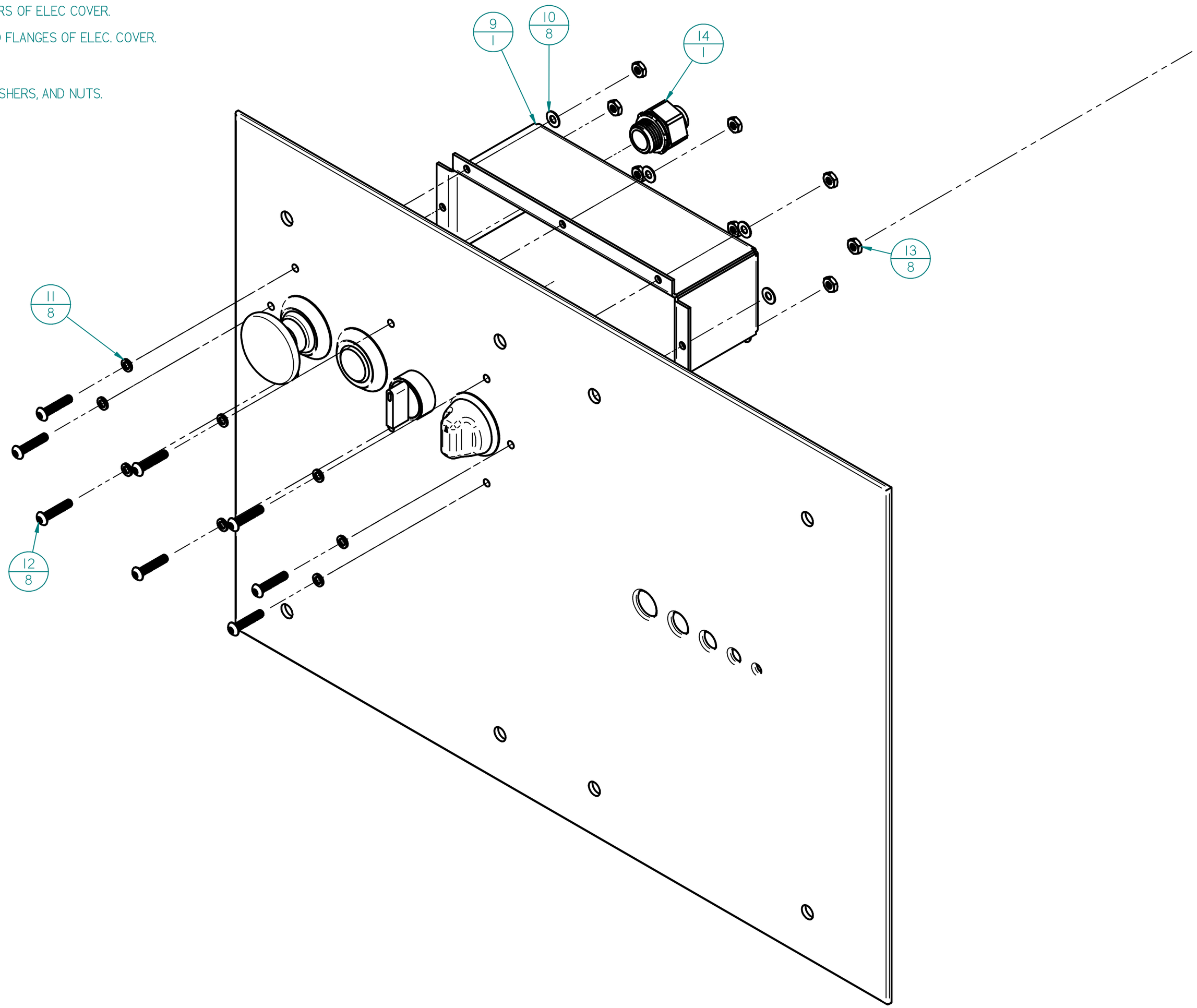
SIZE	DWG NO	REV
C	2-A006-01	A

FILE NAME: 2-A006-01.dft

SCALE:	WEIGHT:	SHEET 3 OF 4

NOTES

1. USING CLEAR SILICON, SEAL CORNERS OF ELEC COVER.
2. APPLY $\frac{1}{4}$" BEAD OF SILICON AROUND FLANGES OF ELEC. COVER.
3. INSTALL LOCTITE CONNECTOR
4. RUN WIRES THROUGH CONECTOR
5. INSTALL COVER USING SCREWS, WASHERS, AND NUTS.
6. TORQUE SCREWS TO 22 IN-LBS



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ± .1
.XX ±.01
.XXX ± .005
ALL DIA CONC WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM AND TOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	07/26/21
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSEMBLY, ELECTRICAL PANEL

SIZE	DWG NO	REV
C	2-A006-01	A

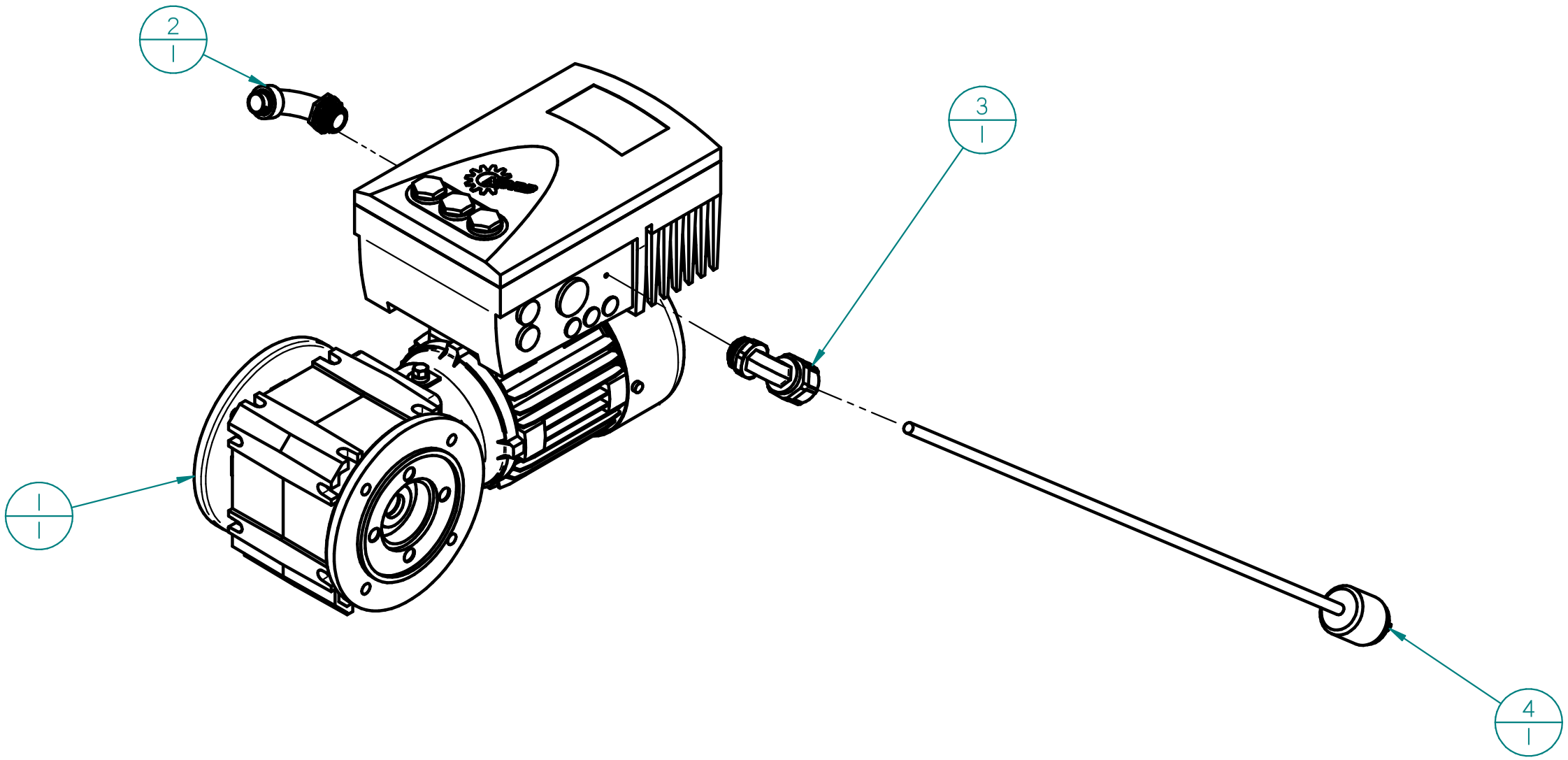
FILE NAME: 2-A006-01.dft

SCALE:	WEIGHT:	SHEET 4 OF 4

NOTES

1. INSERT CORD ASSY THROUGH CORD GRIP WITH 6 INCH STRIPPED TAIL ON INSIDE OF MOTOR.
2. REMOVE COVER AND CHANGE SWITCHES 4 AND 7 TO ON
3. CHANGE MOTOR ASSY JUMPERS.

Item Number	Quantity	Document Number	Title
1	1	SK02040.1AXFF-71S4	MOTOR AND VFD ASSY
2	1	9106K522	LIQUID TIGHT FITTING, 1/2, ELBOW
3	1	7489K320	CORD GRIP
4	1	70355K81	CORD ASSY



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/28/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, CARRIER

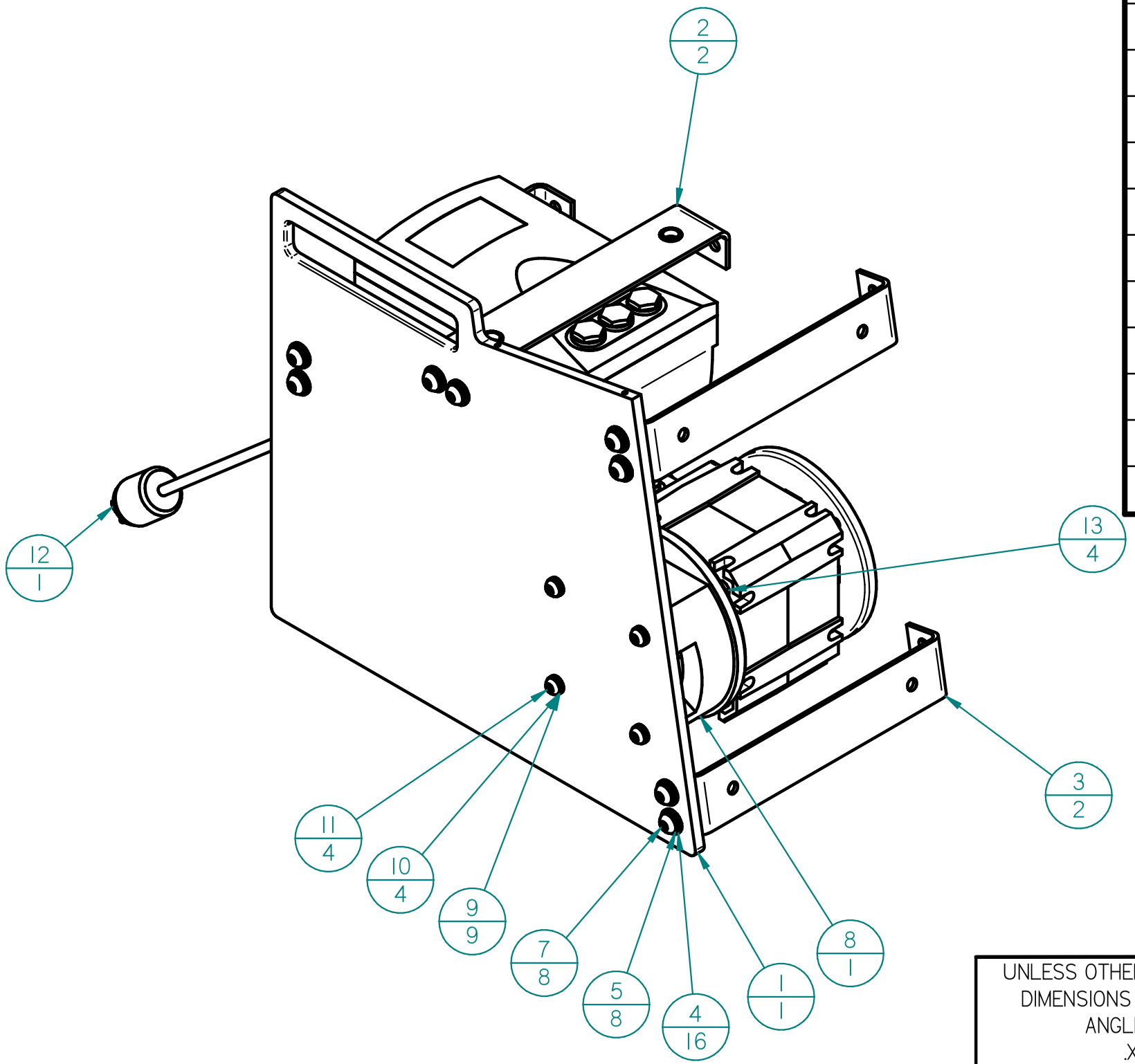
SIZE	DWG NO	REV
B	2-A003-01	A

FILE NAME: 2-A005-01.dft

SCALE:	WEIGHT:	SHEET 1 OF 1

NOTES

1. TIGHTEN ALL FASTNERES PER SAE STANDARDS



Item Number	Quantity	Document Number	Title
1	1	2-0018-02	PLATE, END MOTOR
2	2	2-0015-A1	ASSEMBLY, BRACKET, MODIFIED
3	2	2-0015-02	BRACKET, CARRIER
4	16	91950A031	WASHER, SAE, 3/8
5	8	92147A031	WASHER, SPLIT, 3/8
6*	8	91845A031	NUT, 3/8-16
7	8	92949A624	SCREW, BUTTON, 3/8-16 X 1
8	1	2-0014-02	COLLAR, MOTOR
9	9	98689A116	WASHER, M8, SS
10	4	92148A200	WASHER, SPLIT LOCK, M8
11	4	92095A336	SCREW, M8
12	1	2-A005-01	MOTOR ASSY, MODIFIED
13	4	91828A410	NUT, M8, SS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/28/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

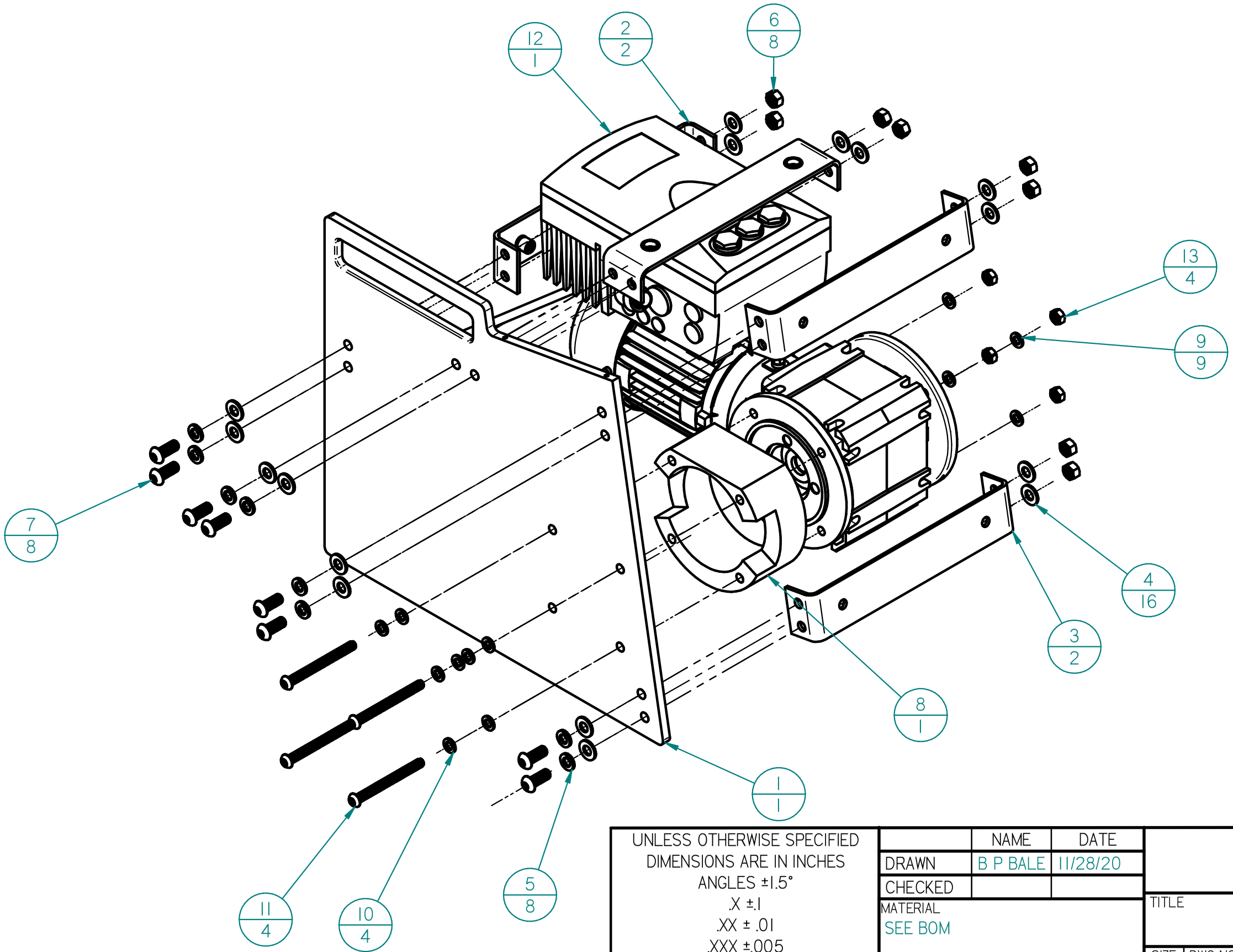
TITLE
ASSY, MOTOR

SIZE	DWG NO	REV
B	2-A004-01	A

FILE NAME: 2-A004-01.dft

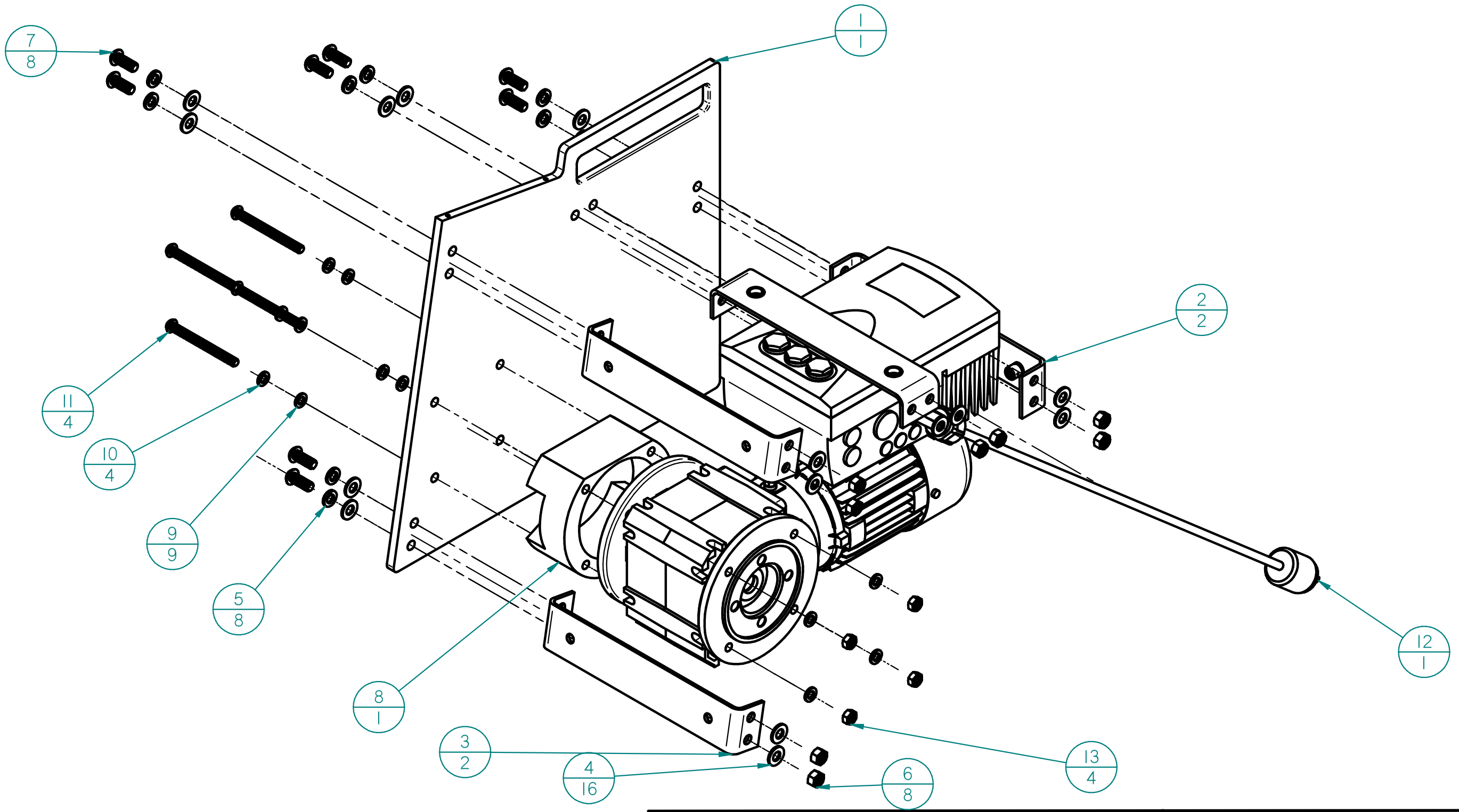
SCALE:	WEIGHT:	SHEET 1 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES ANGLES ±1.5° .X ±.1 .XX ± .01 .XXX ±.005 ALL DIA. CONC. WITHIN .005 TIR SURFACE ROUGHNESS OF 63 INTERPRETE DIM ANDTOL PER ASME Y14.5MK-1994		NAME	DATE	BE HEMP EQUIPMENT		
	DRAWN	B P BALE	11/28/20	TITLE: ASSY, MOTOR		
	CHECKED					
	MATERIAL: SEE BOM			SIZE: B	DWG NO: 2-A004-01	REV: A
	FINISH: NONE			FILE NAME: 2-A004-01.dft		
				SCALE:	WEIGHT:	SHEET 2 OF 3

NOTES



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES ANGLES ±1.5° .X ±.1 .XX ± .01 .XXX ±.005 ALL DIA. CONC. WITHIN .005 TIR SURFACE ROUGHNESS OF 63 INTERPRETE DIM ANDTOL PER ASME Y14.5MK-1994		
	NAME	DATE
DRAWN	B P BALE	11/28/20
CHECKED		
MATERIAL SEE BOM		
FINISH NONE		

BE HEMP EQUIPMENT

TITLE
ASSY, MOTOR

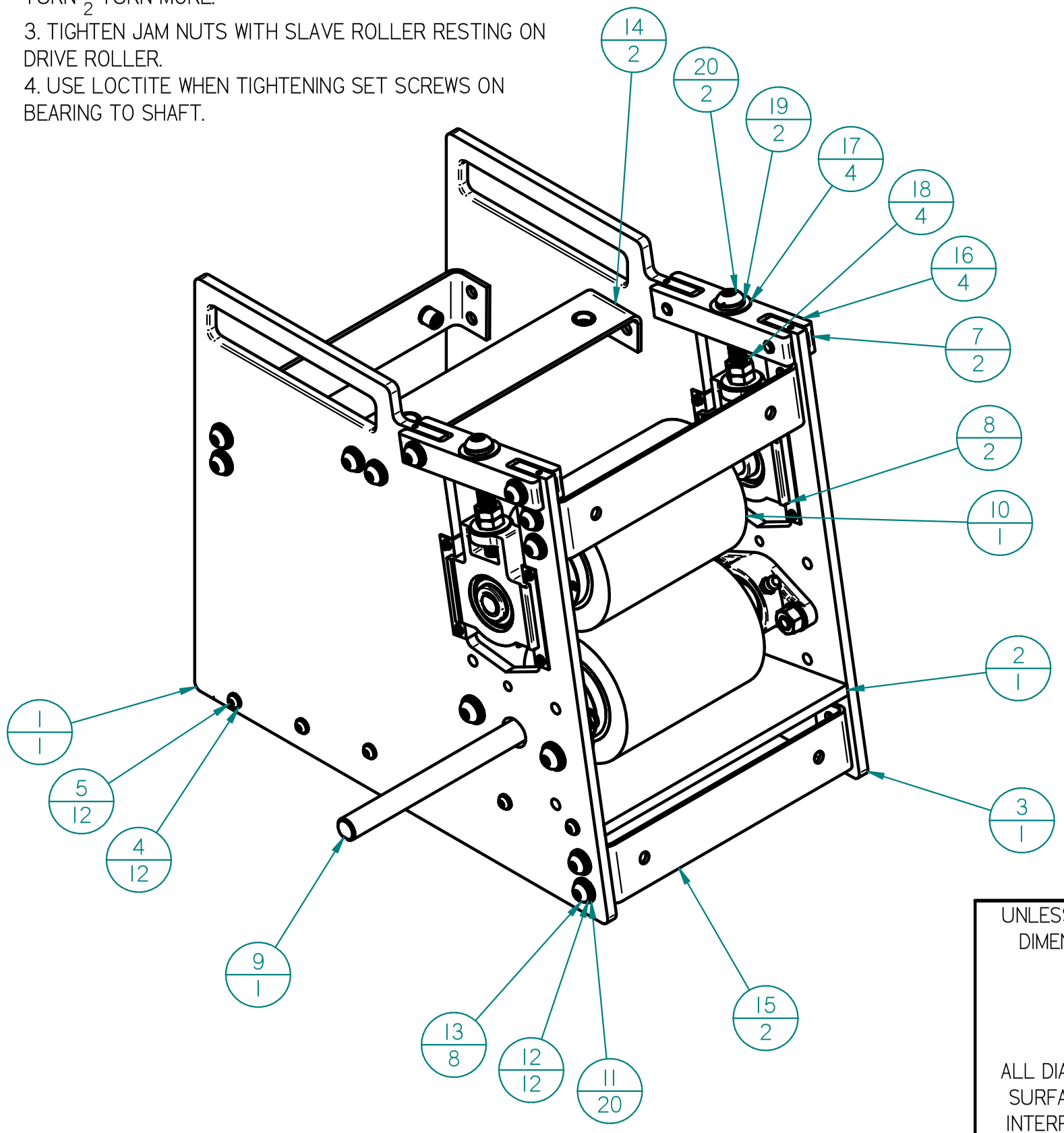
SIZE	DWG NO	REV
B	2-A004-01	A

FILE NAME: 2-A004-01.dft

SCALE:	WEIGHT:	SHEET 3 OF 3

NOTES

1. TORQUE PER SAE STANDARDS EXCEPT WHERE NOTED.
2. TIGHTEN 4" SCREW TO ENAGGE LOCK WASHER, THEN TURN $\frac{1}{2}$ TURN MORE.
3. TIGHTEN JAM NUTS WITH SLAVE ROLLER RESTING ON DRIVE ROLLER.
4. USE LOCTITE WHEN TIGHTENING SET SCREWS ON BEARING TO SHAFT.



Item Number	Quantity	Document Number	Title
1	1	2-A002-01	ASSY, CARRIER PLATE, RIGHT
2	1	2-0016-01	PLATE, LOWER
3	1	2-A002-02	ASSY, CARRIER PLATE, RIGHT
4	12	92147A029	WASHER, SPLIT, 1/4
5	12	92949A542	SCREW, BUTTON, 1/4-20 X 1
6*	8	90295A470	WASHER, NYLON, 3/8
7	2	2-0005-01	BRACE, TOP
8	2	2-0003-01	BEARING, MODIFIED
9	1	2-A001-02	ASSY, ROLLER, DRIVE
10	1	2-A001-03	ASSY, ROLLER, SLAVE
11	20	91950A031	WASHER, SAE, 3/8
12	12	92147A031	WASHER, SPLIT, 3/8
13	8	92949A624	SCREW, BUTTON, 3/8-16 X 1
14	2	2-0015-A1	ASSEMBLY, BRACKET, MODIFIED
15	2	2-0015-02	BRACKET, CARRIER
16	4	92949A628	SCREW, BUTTON, 3/8-16 X 1 1/2
17	4	90107A033	WASHER, 1/2, STAINLESS STEEL
18	4	91847A520	NUT, THIN, 1/2-13, SS
19	2	92147A033	WASHER, SPLIT LOCK, 1/2
20	2	92949A728	SCREW, 1/2-13 X 4, SS
21*	8	91845A031	NUT, 3/8-16

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL: SEE BOM

FINISH: NONE

BE HEMP EQUIPMENT

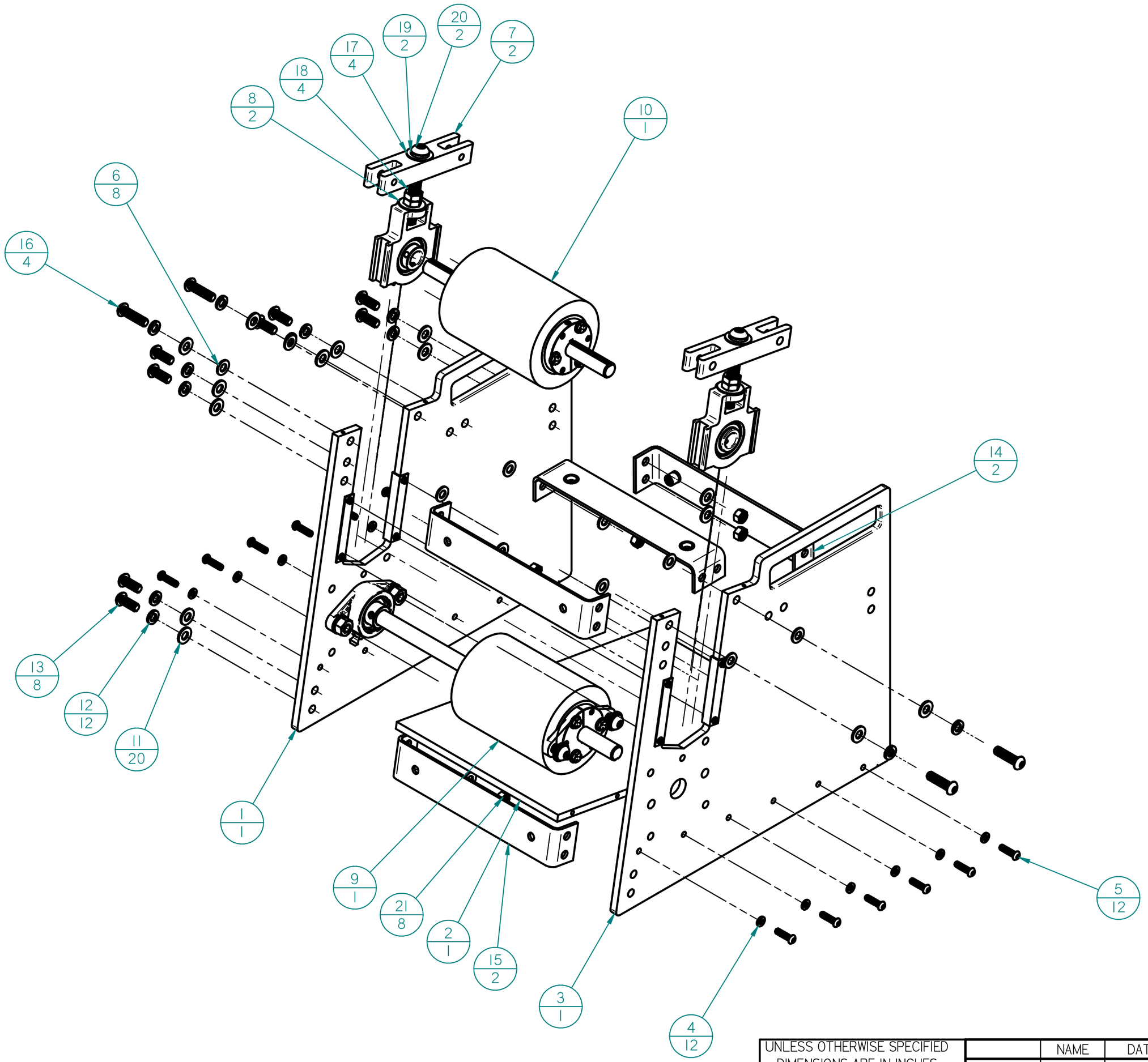
TITLE: ASSY, CARRIER

SIZE	DWG NO	REV
B	2-A003-01	A

FILE NAME: 2-A003-01-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 4

NOTES



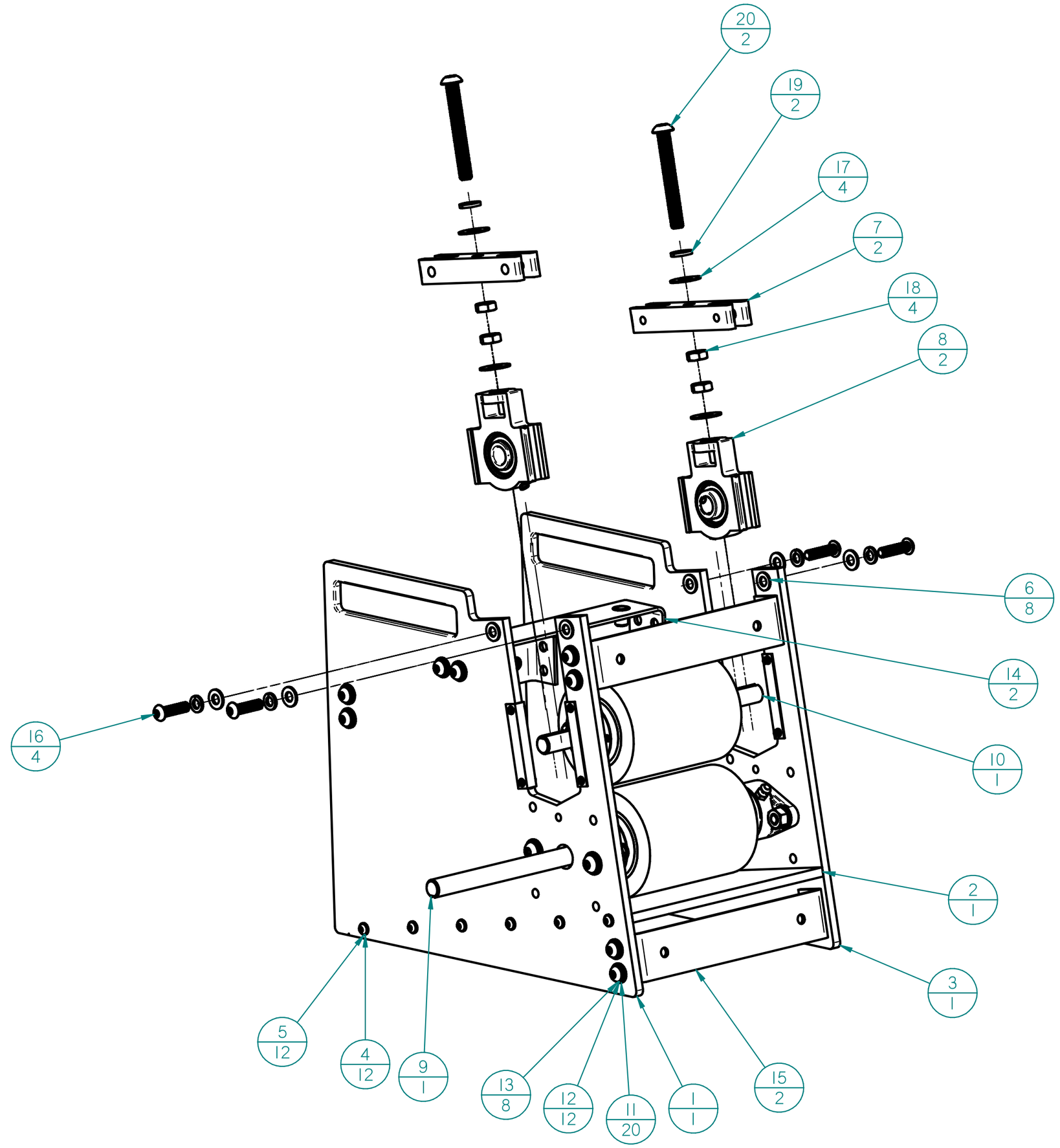
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	11/27/20
CHECKED		
MATERIAL	SEE BOM	
FINISH	NONE	

BE HEMP EQUIPMENT

TITLE		
ASSY, CARRIER		
SIZE C	DWG NO 2-A003-01	REV A
FILE NAME: 2-A003-01-A.dft		
SCALE:	WEIGHT:	SHEET 2 OF 4

NOTES



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	User	11/27/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

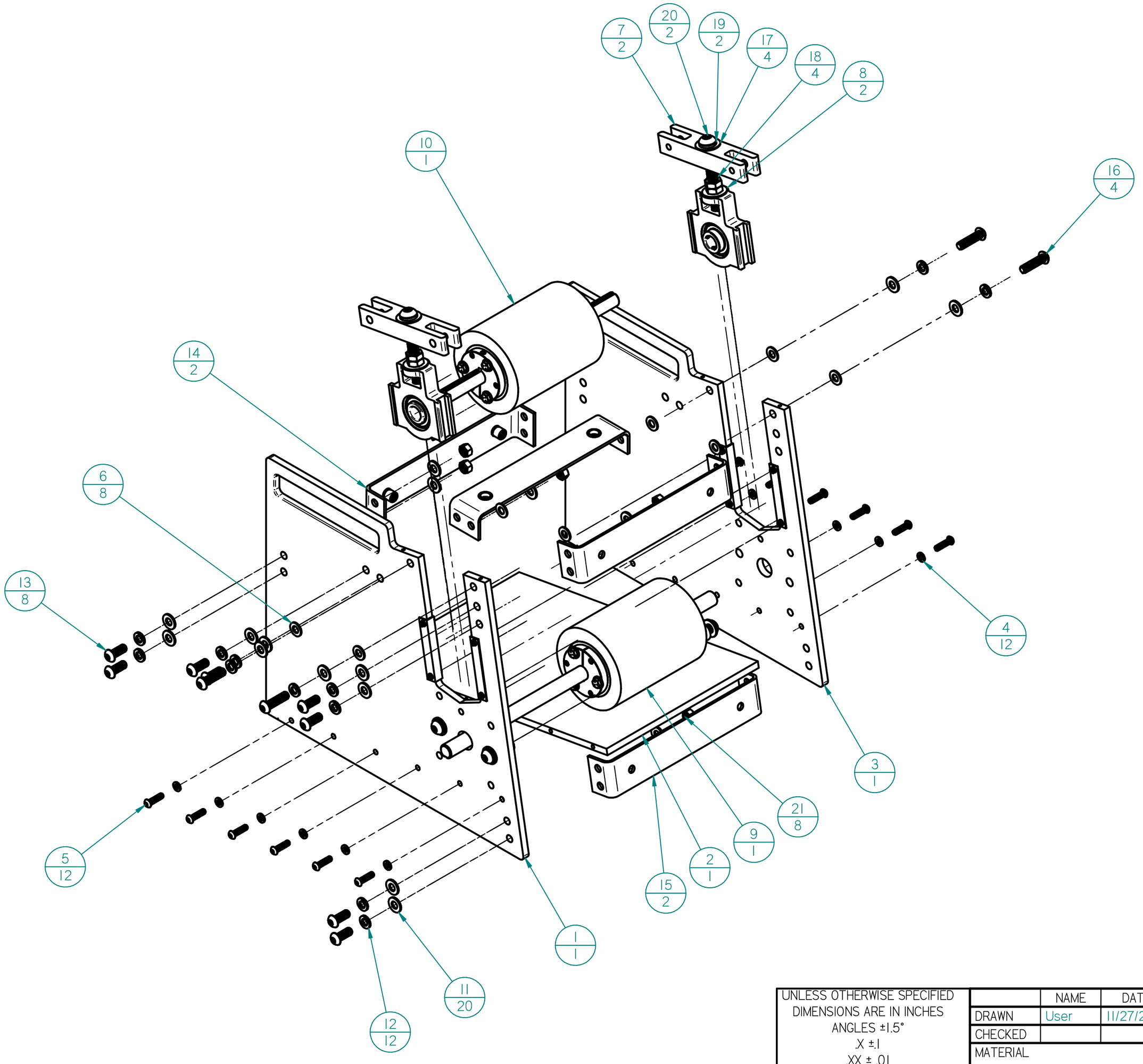
TITLE
ASSY, CARRIER

SIZE	DWG NO	REV
C	2-A003-01	A

FILE NAME: 2-A003-01-A.dft

SCALE:	WEIGHT:	SHEET 3 OF 4

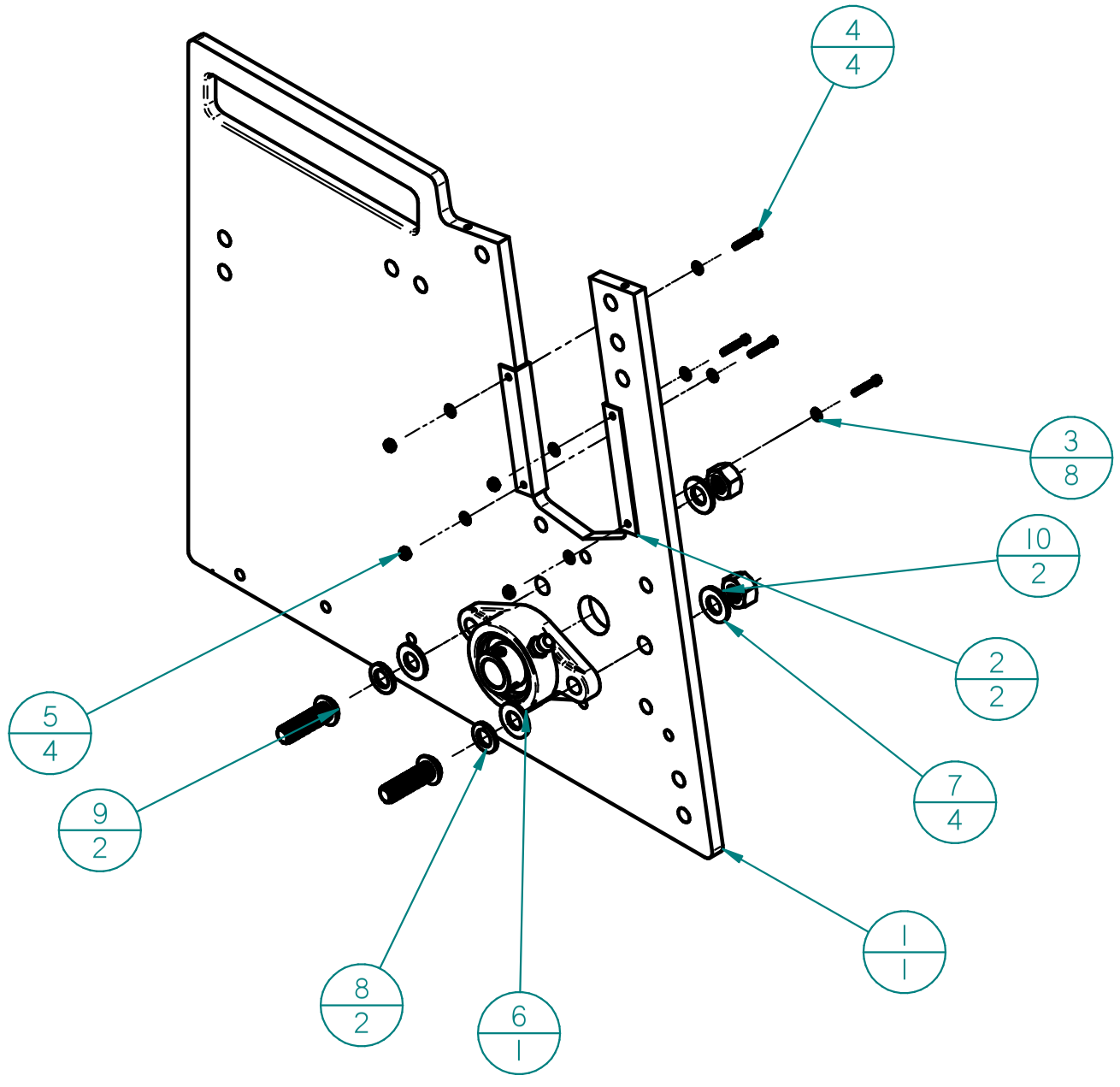
NOTES



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES ANGLES ±1.5° .X ±.1 .XX ± .01 .XXX ±.005 ALL DIA. CONC. WITHIN .005 TIR SURFACE ROUGHNESS OF 63 INTERPRETE DIM ANDTOL PER ASME Y14.5MK-1994		NAME	DATE	BE HEMP EQUIPMENT	
	DRAWN	User	11/27/20	TITLE: ASSY, CARRIER	
	CHECKED			SIZE: C	DWG NO: 2-A003-01 / REV: A
	MATERIAL: SEE BOM			FILE NAME: 2-A003-01-A.dft	
	FINISH: NONE			SCALE:	WEIGHT: / SHEET 4 OF 4

NOTES

1. TORQUE AS REQUIRED PER SAE STANDARD



Item Number	Quantity	Document Number	Title
1	1	2-0013-01	PLATE, SIDE
2	2	2-0010-01	LINNER, CARRIER
3	8	90107A005	WASHER, #4
4	4	92196A113	SCREW, CAP, 4-40 X 3/4
5	4	91831A005	NUT, SLEF LOCKING, #4
6	1	5968K73	BEARING, 2 BOLT FLANGE
7	4	91950A048	WASGER, 7/16, SAE
8	2	92147A032	WASHER, SPLIT, 7/16
9	2	92949A351	SCREW, BUTTON, 7/16-14 X 1 1/2
10	2	94252A711	NUT, 7/16-14

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, CARRIER PLATE, RIGHT

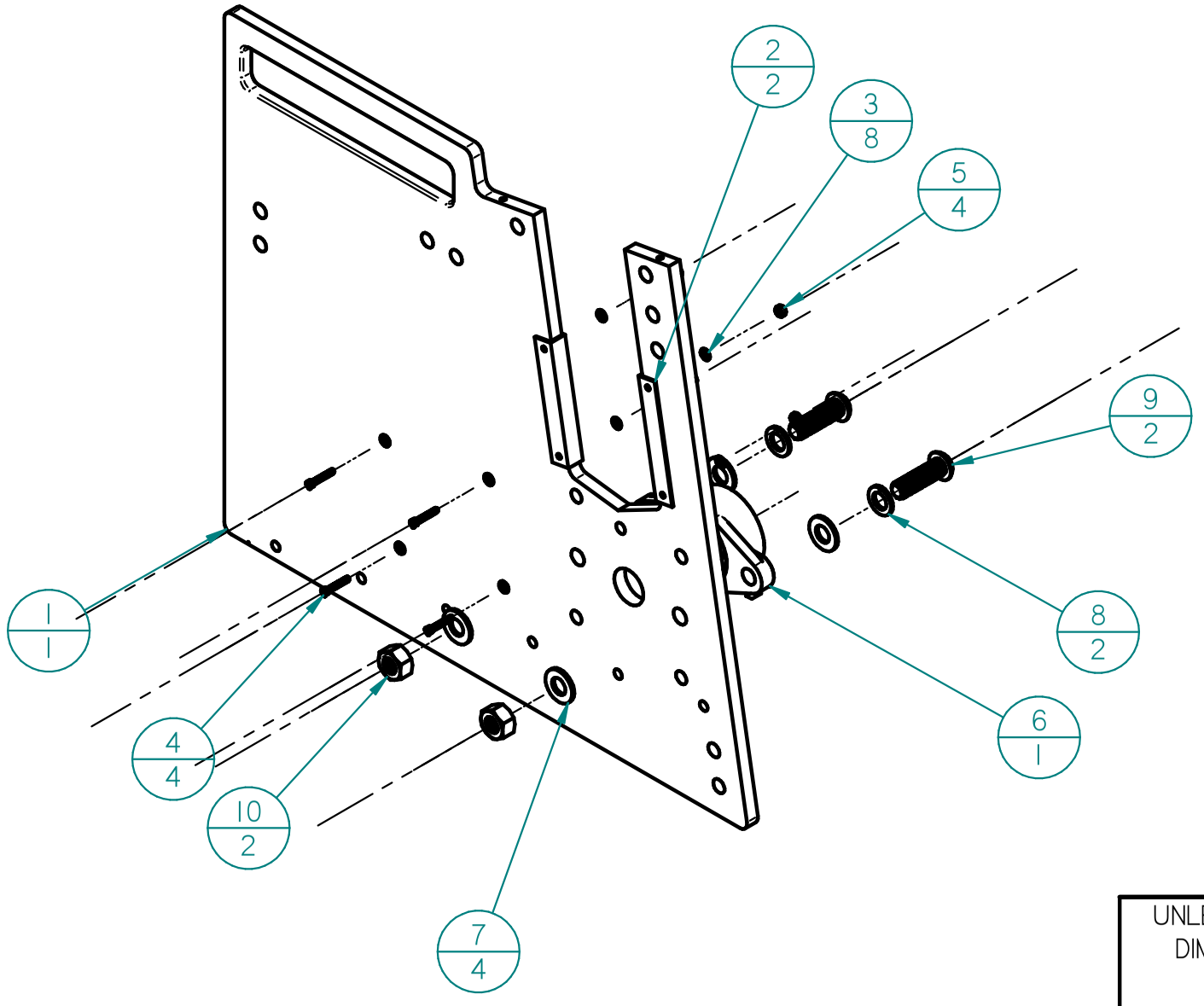
SIZE	DWG NO	REV
B	2-A002-02	A

FILE NAME: 2-A002-02-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 1

NOTES

1. TORQUE AS REQUIRED PER SAE STANDARD
2. TIGHTEN BEARING NUTS HAND TIGHT ONLY



Item Number	Quantity	Document Number	Title
1	1	2-0013-01	PLATE, SIDE
2	2	2-0010-01	LINNER, CARRIER
3	8	90107A005	WASHER, #4
4	4	92196A113	SCREW, CAP, 4-40 X 3/4
5	4	91831A005	NUT, SLEF LOCKING, #4
6	1	5968K73	BEARING, 2 BOLT FLANGE
7	4	91950A048	WASGER, 7/16, SAE
8	2	92147A032	WASHER, SPLIT, 7/16
9	2	92949A351	SCREW, BUTTON, 7/16-14 X 1 1/2
10	2	94252A711	NUT, 7/16-14

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
SEE BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, CARRIER PLATE, LEFT

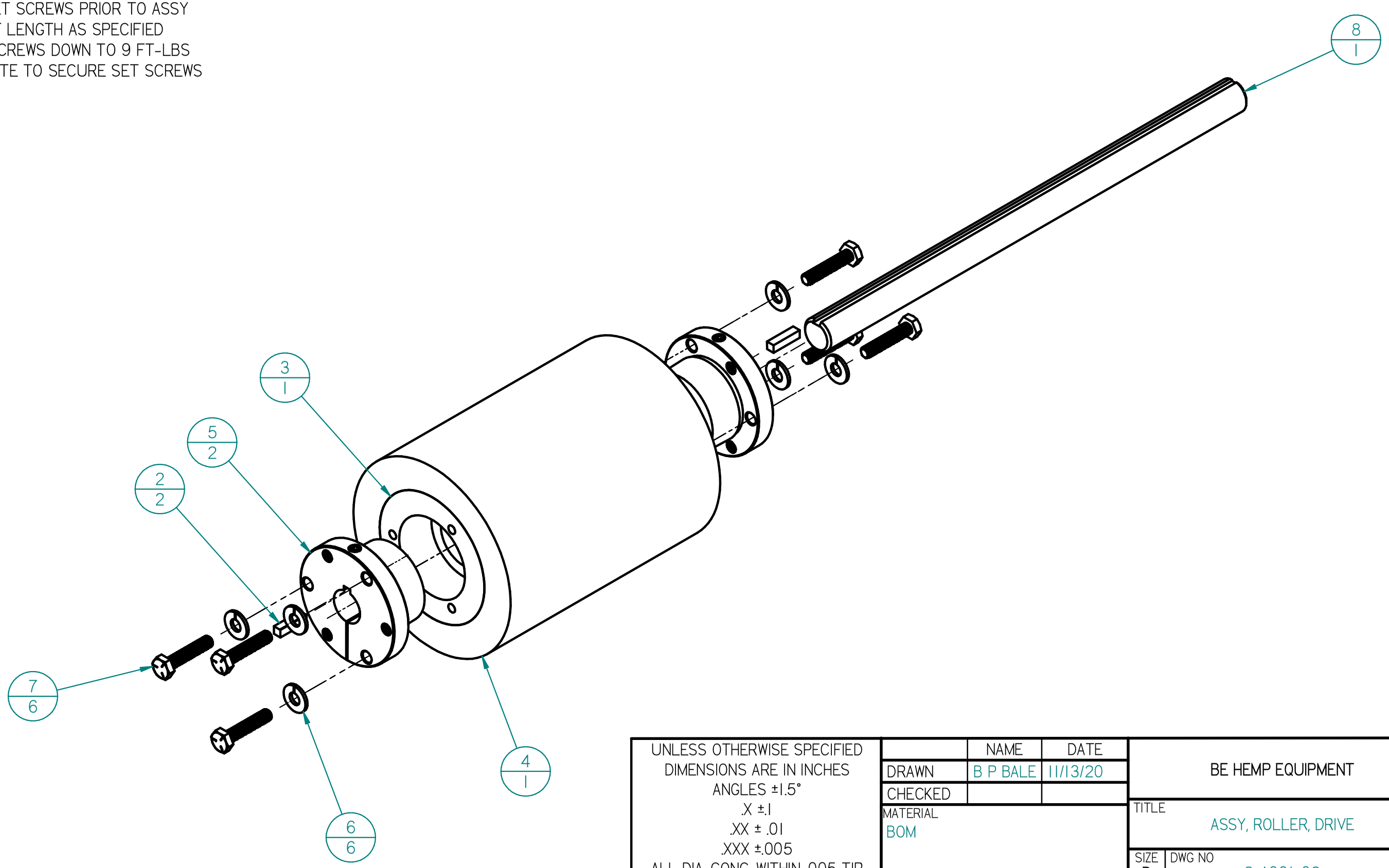
SIZE	DWG NO	REV
B	2-A002-01	B

FILE NAME: 2-A002-01-B.dft

SCALE:	WEIGHT:	SHEET 1 OF 2

NOTES

1. REMOVE SET SCREWS PRIOR TO ASSY
2. SET SHAFT LENGTH AS SPECIFIED
3. TORQUE SCREWS DOWN TO 9 FT-LBS
4. USE LOCTITE TO SECURE SET SCREWS



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, ROLLER, DRIVE

SIZE	DWG NO	REV
B	2-A001-02	A

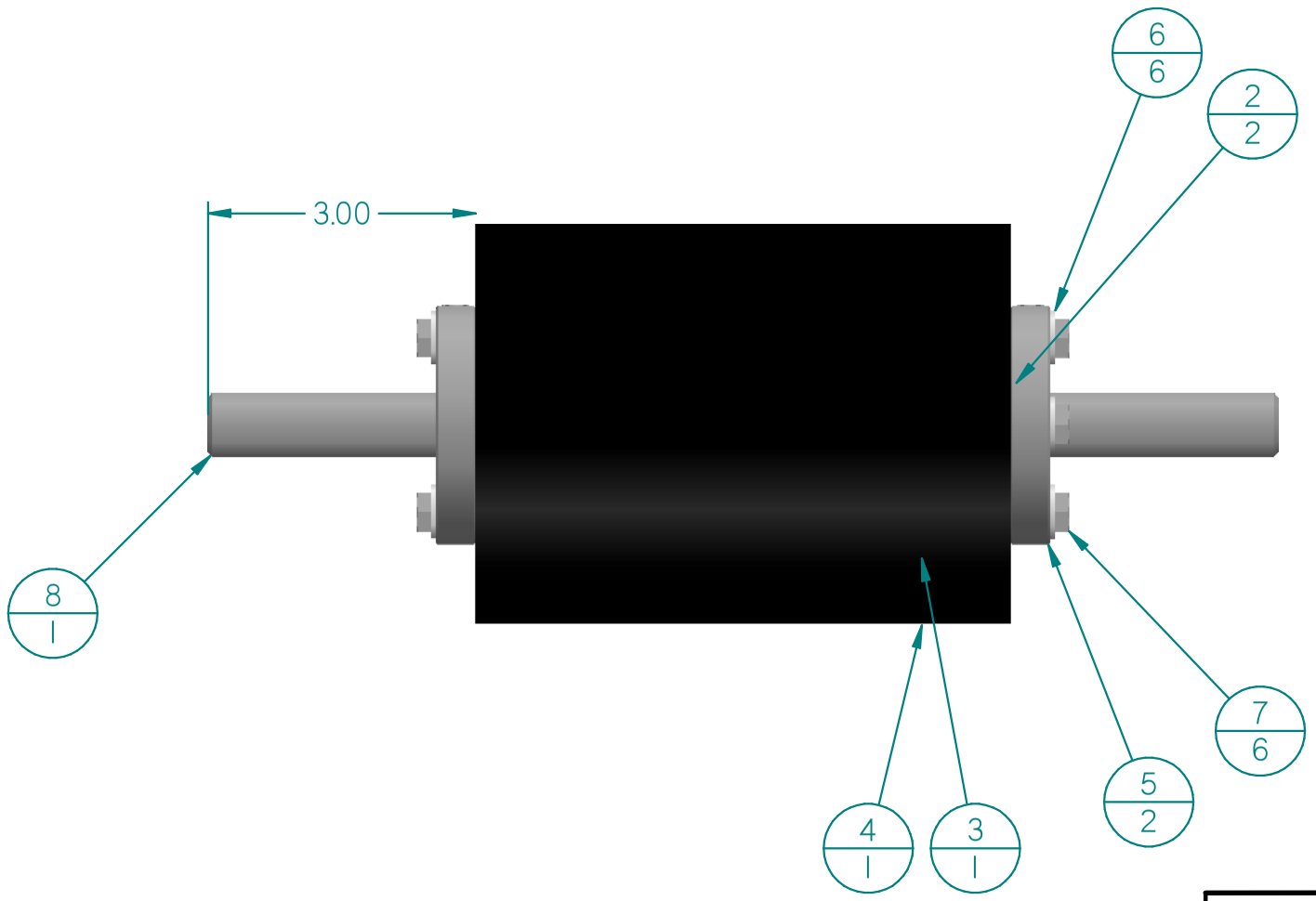
FILE NAME: 2-A001-03-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 2

NOTES

1. REMOVE SET SCREWS PRIOR TO ASSY
2. SET SHAFT LENGTH AS SPECIFIED
3. TORQUE SCREWS DOWN TO 9 FT-LBS
4. USE LOCTITE TO SECURE SET SCREWS

Item Number	Quantity	Document Number	Title
1*	1		
2	2	92624A130	KEY, .750 SHAFT, STAINLESS STEEL
3	1	2-0002-01	MANDREL, 3 INCH
4	1	2-0002-02	RUBBER, ROLLER ASSY
5	2	6086K213	QUICK DISCONNECT
6	6	92147A029	316 SS, SPLIT LOCK WASHER, 1/4
7	6	92865A544	SCREW, HEX HEAD, 1/4-20 X 1 1/2, GRADE 5
8	1	7398K240	SHAFT, KEYED, 12", STAINLESS STEEL



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, ROLLER, SLAVE

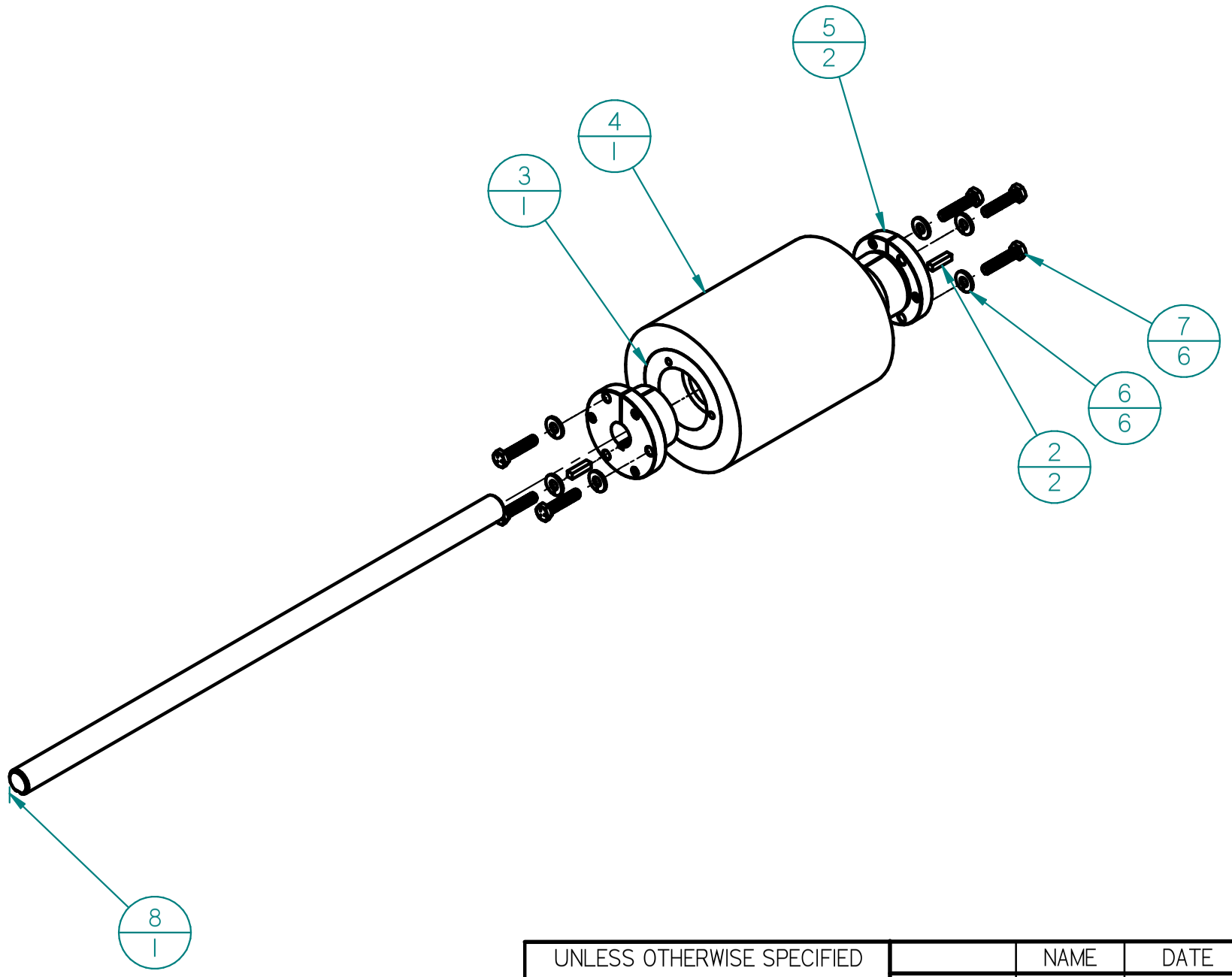
SIZE	DWG NO	REV
B	2-A001-03	A

FILE NAME: 2-A001-03-A.dft

SCALE:	WEIGHT:	SHEET 2 OF 2

NOTES

1. REMOVE SET SCREWS PRIOR TO ASSY
2. SET SHAFT LENGTH AS SPECIFIED
3. TORQUE SCREWS DOWN TO 9 FT-LBS
4. USE LOCTITE TO SECURE SET SCREWS



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL: BOM

FINISH: NONE

BE HEMP EQUIPMENT

TITLE: MANDREL, 3"

SIZE	DWG NO	REV
B	2-0002-01	B

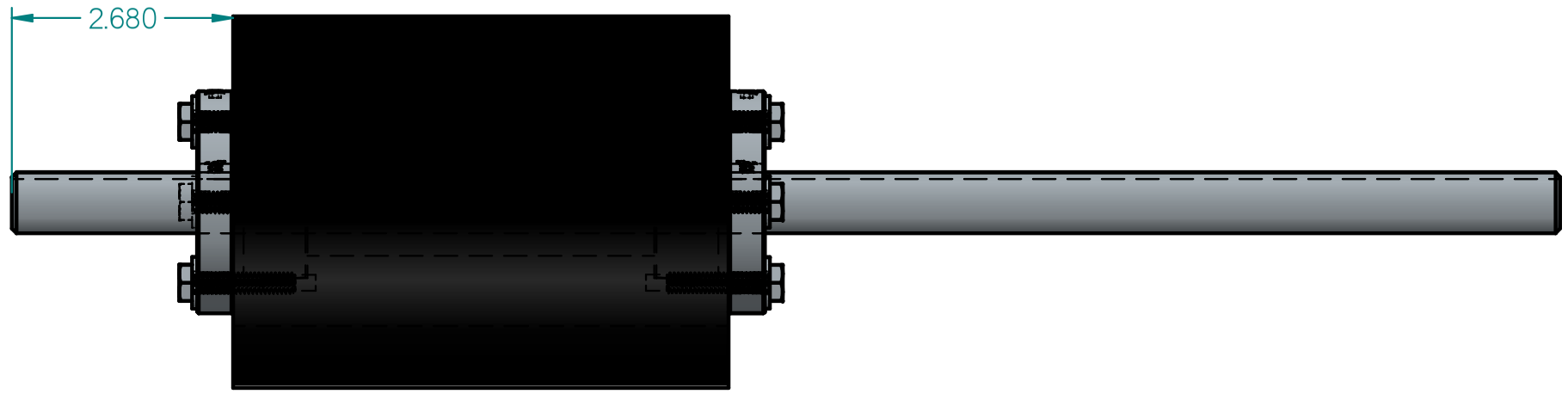
FILE NAME: 2-A001-02-A.dft

SCALE:	WEIGHT:	SHEET 1 OF 2

NOTES

1. REMOVE SET SCREWS PRIOR TO ASSY
2. SET SHAFT LENGTH AS SPECIFIED
3. TORQUE SCREWS DOWN TO 9 FT-LBS
4. USE LOCTITE TO SECURE SET SCREWS

Item Number	Quantity	Document Number	Title
1*			
2	2	92624A130	KEY, .750 SHAFT, STAINLESS STEEL
3	1	2-0002-01	MANDREL, 3 INCH
4	1	2-0002-02	RUBBER, ROLLER ASSY
5	2	6086K213	QUICK DISCONNECT
6	6	92147A029	316 SS, SPLIT LOCK WASHER, 1/4
7	6	92865A544	SCREW, HEX HEAD, 1/4-20 X 1 1/2, GRADE 5
8	1	2-0012-01	SHAFT, KEYED, 18.00, STAINLESS STEEL, .750



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
ANGLES ±1.5°
.X ±.1
.XX ± .01
.XXX ±.005
ALL DIA. CONC. WITHIN .005 TIR
SURFACE ROUGHNESS OF 63
INTERPRETE DIM ANDTOL PER
ASME Y14.5MK-1994

	NAME	DATE
DRAWN	B P BALE	11/13/20
CHECKED		

MATERIAL
BOM

FINISH
NONE

BE HEMP EQUIPMENT

TITLE
ASSY, ROLLER, DRIVE

SIZE	DWG NO	REV
B	2-A001-02	A

FILE NAME: 2-A001-02-A.dft

SCALE:	WEIGHT:	SHEET 2 OF 2