

THE FEED



2019
ISSUE 21

THE FEED

The Feed is designed to bring awareness to the latest equipment offerings and updates, customer and dealer success stories and upcoming industry and factory events from Kolberg-Pioneer, Johnson Crushers International and Astec Mobile Screens.

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ABOUT

Kolberg-Pioneer, Inc., Johnson Crushers International, Inc. and Astec Mobile Screens, Inc. of Astec Industries (NASDAQ: ASTE) are worldwide leaders in manufacturing equipment for the aggregate, construction and recycling industries. As innovative, high-integrity manufacturers, the three companies develop quality, state-of-the-art products and have the ability to engineer custom products because of a highly-qualified sales application and engineering staff. Kolberg-Pioneer, Inc. manufactures its products in Yankton, South Dakota, Johnson Crushers International, Inc. in Eugene, Oregon and Astec Mobile Screens, Inc. in Sterling, Illinois. For more information, call (605)668-2524 or visit www.kpijci.com.

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EVENTS

SEPTEMBER

September 11 - 12
National Dealer Conference
Aurora, CO

OCTOBER

October 22-24
Mobile (Track) and High Frequency School
2704 West LeFevre Road
Sterling, IL

DECEMBER

December 10-12
Service Application School
700 West 21st Street
Yankton, SD

APPLICATION ANGLE

***IT'S ALL ABOUT
PERSPECTIVE.
IT'S ALL ABOUT
RESULTS.***



THE OBJECTIVE

The contractor, who had processed large quantities of a 3/8" x 30 mesh gravel material, stockpiled over one million tons of the unsold product at several locations. With a lack of storage, and a sizeable amount of time and money invested into the product, the producer wanted to salvage as much of the undesirable material as possible by converting it into concrete and asphalt sand.

THE SOLUTION

The customer had tried a variety of crushers from several different manufacturers without the desired results. Impact crushers produced too much fine material from the product and, because of the small feed size, other manufacturers' cone crushers were unable to perform without causing the bowl to float.

Johnson Crushers International introduced the producer to its new Kodiak® Plus cone crusher, the K350+. This high-speed, roller bearing cone features an extra-fine liner to handle the small feed. This model also has twenty percent more hold-down force than cones of a similar size. The newest cone has the advantages of a large model with the medium-sized capacity for choke-feeding.

The Astec Mobile Screens GT205 multi-frequency screening plant, which combines a high frequency screen on the bottom deck and a conventional screen on the top deck, was used to close the circuit.

A fine material washer from Kolberg-Pioneer was also used to remove excess minus 150 and 200 mesh material to produce a product that met the specifications for both asphalt and concrete sand.

THE FIGURES

Prior to washing out the fines, the Johnson Crushers International K350+ was producing the manufactured sand at a rate of sixty-eight percent. After rinsing the fines away, the in-spec product could be produced at 120 tons-per-hour. The K350+ reduced the amount of recirculated loads and helped the customer produce a high-quality, high-demand manufactured sand product out of what was once a useless material.

THE BOTTOM LINE



250,000 tons of material processed annually at 125 STPH; turning waste material into concrete, asphalt and mortar sand.



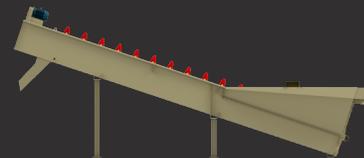
K350+ HIGHLIGHTS

- 20% more hold-down force than similar-sized cones
- Roller bearing design can reduce operating expenses by as much as 50%
- Tramp iron relief system eliminates maintenance costs



GT205 HIGHLIGHTS

- Ability to screen fine and coarse material using one unit
- Features a two-bearing vibrator, found on incline screens, on the top deck and a high frequency vibrator on the bottom deck for maximum efficiency
- Transfers more energy into both the screen body and screen media



FINE MATERIAL WASHER HIGHLIGHTS

- High-efficiency v-belt drive assembly reduces horsepower requirements and maintenance
- Adjustable weir boards and collecting flume allow for precise control of overflow slurry
- Easily-adjustable shaft speed allows users to match the washer speed to the application

THE VALUE OF A RELATIONSHIP





The crew at General Materials works nearly around the clock to produce a wide variety of products for their customers. A unique new venture has given them an industry advantage to clearly set them apart.

The history of General Materials begins in 1948, with the founding of Haskell Lemon, the group's sister company. Over the last decades, Haskell Lemon grew from a small paving company into a large, diversified

contracting company. In 1975, to complement the expansion of Haskell Lemon, the group established General Materials to expand their resources into the sand processing industry. Jay Lemon and Ken Wert, partners at General Materials and Haskell Lemon, took a chance on an unrealized opportunity within General Materials' operation that allowed them to expand into the frac sand market. With stable market conditions and an increased

need for the product, it was an opportune time for General Materials to expand its capabilities. Being so familiar with Kolberg-Pioneer, Inc. and its sister companies through a long-spanning relationship, the group didn't turn anywhere else when they needed new equipment.

NOTHING WASTED

During General Materials' initial introduction to the sand processing

industry in the 70s, they built their first plant to make concrete, asphalt and fill sands. Recently, the group added two new, turn-key plants to produce a wider variety of materials. One of the new systems is fed processed material from the company's existing wash plant, which was erected over twenty years ago. The product is fed into a new Kolberg-Pioneer model 1830 screening and washing plant, which has a 6' by 20' screen that separates the material to either be stockpiled as tailings, or sent to a set of dewatering cyclones and into a density classifier. The fine material from the density classifier is sent to a Kolberg-Pioneer series 9200 fines recovery system, where it is pumped through another dewatering cyclone and discharged onto a dewatering screen before being stockpiled as frac sand. The coarse material from the density classifier goes to a fine material washer and is stockpiled as an additional saleable product.

The second Kolberg-Pioneer system is fed using General Materials' on-site dredge. Since the beginning of the group's sand processing endeavor, they have been putting their unsaleable material back into their lake. After General Materials realized the potential of the built-up product, they needed the equipment to process it. Once the material is dredged up, it is sent to a series 1830 screening and washing plant with a 6' by 20' screen. From the screen, oversized material is stockpiled as a discarded product, while the smaller material is pumped to a Kolberg-Pioneer series 9000 sand plant with three classifying cyclones. After processing through the cyclones, the material goes through a 9200 fines recovery plant with another classifying cyclone and across a dewatering screen to be placed in a stockpile, dried and sold.

The group's unique set-up and resourcefulness have allowed them to fully utilize all of their resources and materials to make an additional saleable product from what was once thought to be waste. Jack Lemon, project manager at General Materials,



explains, "Our system that is hooked up to our dredge, which includes the 1830 screening plant, 9000 sand plant and 9200 fines recovery plant, is re-mining a wash back area that has been a waste product for us. Since the mid 70's, we've been putting our unsaleable material back into the lake and now we have the ability to go out there, dredge it, re-wash it, re-size it and put it through the plant to make a saleable product."

After realizing the potential of their material, the operation needed the necessary equipment and an engineering team that would stand behind them and their vision. "Our sand business, historically, has been wash classifiers and sand classifiers that

have been feeding the construction market materials with concrete sands, wash fill sands and other mason-type products. These two new plants are bringing on additional pieces and technology, and it's been great learning about the new-to-us processing that Kolberg-Pioneer brought to the table," says Jay. Jack adds, "The most useful features to our operation are the user-friendly controls that allow us to easily adjust the gradations of the finished product. You can adjust anything you want with three clicks on the touch screen. Most importantly, is the group of people we have gotten to know and work with, how helpful they've been



“HONESTLY, WHEN WE HAD THE OPPORTUNITY TO GROW INTO THIS NEW MARKET, WE DIDN’T CALL ANYBODY ELSE. WE DIDN’T FEEL THE NEED TO SHOP DESIGNS AGAINST ANYONE ELSE.” - JAY LEMON

on everything from plant set up to operation and now service.”

Easy access to parts and service is an essential factor in any operation. “Parts and service are arguably the most important factor. Without parts and service, we don’t run and without running, nothing else happens. We are always able to get our parts quickly,” says Jack. The group’s local dealer, Van Keppel, has provided them with parts and service for over twenty years. He adds, “Any sort of issue we had with set up, the team at Kolberg-Pioneer was also incredibly helpful. With just a phone call or video chat we had our issues resolved.” Jay adds, “American-made equipment and support has been

huge for us, the support especially. It gives us great pride, as an Oklahoma-based company to use American equipment every chance we get. The guys that helped design it got it shipped to us, helped us with the setup and they went online and started performing quicker than new plants we have erected in the past.” He says, “Our plant was a unique design, something we weren’t very familiar with, but Kolberg-Pioneer took a custom need and designed something they don’t have on their shelf, got it down here and we were able to start with the push of a few buttons.”

Being a multi-generational company, the group is very familiar with the

Kolberg-Pioneer family. “Our company has had KPI equipment longer than I have been employed here. It’s those relationships that give us the reliability we need, as well as the expertise from their engineering, and new products that help us create new materials for our expanding market,” explains Jay. When asked how Kolberg-Pioneer equipment compared to competitive equipment while they were searching for new plants, Jay says, “Honestly, when we had the opportunity to grow into this new market, we didn’t call anybody else. We didn’t feel the need to shop designs against anyone else.” Jay continues on to say, “Relationships are the key to this whole deal; trust and

**“RELATIONSHIPS ARE THE KEY TO THIS WHOLE DEAL. PEOPLE CAN MAKE IRON, OTHER PEOPLE CAN DREDGE, BUT IT’S HAVING FAITH IN A COMPANY THAT BRINGS YOU A NEW PRODUCT AND HELPS YOU EVERY STEP OF THE WAY. THERE’S A VERY COMPLICATED SET OF MACHINES BEHIND US, AND THEY’VE GIVEN US THE TOOLS WE NEED TO PROVIDE FOR OUR CUSTOMERS.”
- JAY LEMON**



relationships. People can make iron, other people can dredge, but it's having faith in a company that brings you a new product and helps you every step of the way. There's a very complicated set of machines behind us, and they've given us the tools we need to provide for our customers."

A THRIVING FUTURE

Ken, Jay, Jack and the whole crew at General Materials have conquered a new market by utilizing unconventional resources and techniques to create two additional saleable products. When asked about the future of General Materials, Jay says, "We are working towards more than doubling our annual volume. We love new opportunities and challenges and we are constantly seeking out what we can do with the resources we already have to serve new markets. We expect to get very comfortable with our new equipment and will continue to look for new ways we can use these tools and the raw materials we have to serve anyone else we can reach. It's always fun to find a new opportunity and work with people like those at Kolberg-Pioneer to turn those ideas into reality."

**"PARTS AND SERVICE ARE ARGUABLY THE MOST IMPORTANT FACTOR. WITHOUT PARTS AND SERVICE, WE DON'T RUN AND WITHOUT RUNNING, NOTHING ELSE HAPPENS."
- JACK LEMON**





MICHAEL EDWARDS
Channel Development Manager

EDWARDS HIRED AS CHANNEL DEVELOPMENT MANAGER

Kolberg-Pioneer, Johnson Crushers International, and Astec Mobile Screens have hired Michael Edwards as channel development manager.

In his new role, Edwards will be responsible for all elements of managing and developing the group's market channels to meet both short and long term goals. He will work with a variety of management teams to execute the strategic and tactical plans

for strengthening our market channels. "We are excited to add Michael to our expanding team. With his unique sales background and many years of industry experience, he will be a valuable asset to our team," says Ron Earl, executive vice president, sales and marketing – Aggregate and Mining - USA.

Michael Edwards can be reached by email at michaelledwards@kpijci.com or by phone at (603) 333-6491.

FIELD SALES TRANSITIONS

We are pleased to announce the transitions of Paul Smith and Don Mueller into their new roles with Kolberg-Pioneer, Johnson Crushers International and Astec Mobile Screens and welcome Lauren DeBow to the group.

Paul Smith previously worked as the director of international sales and marketing for Astec Aggregate and Mining Group. Smith has transitioned into his new role as regional sales manager - mountain for Kolberg-Pioneer, Johnson Crushers International

and Astec Mobile Screens.

Don Mueller has changed roles from regional sales manager to technical sales manager - west. In his new role, Mueller will focus on strategic product and industry initiatives to better serve the group's dealers and customers.

Lauren DeBow has been hired as a technical representative. In her role, DeBow will focus on product and company initiatives and assist the regional sales managers in the North America – east region.



LAUREN DEBOW
Technical Representative

EXPANDING THE MARKETING TEAM

Kolberg-Pioneer, Johnson Crushers International and Astec Mobile Screens continue to expand their marketing capabilities with the addition of two new team members. Erik Schmidt, resource development manager, has worked with the group for twenty years in a variety of positions. In his new role, Schmidt will help drive sustainable and consistent training programs from sales to service for our employees, distributors and customers. Jaclyn Arens, marketing technologist, works to analyze and improve the technology used in our sales and marketing resources, which include the company website, our customer relationship management tool and quotation tool.



ERIK SCHMIDT
Resource Development Manager

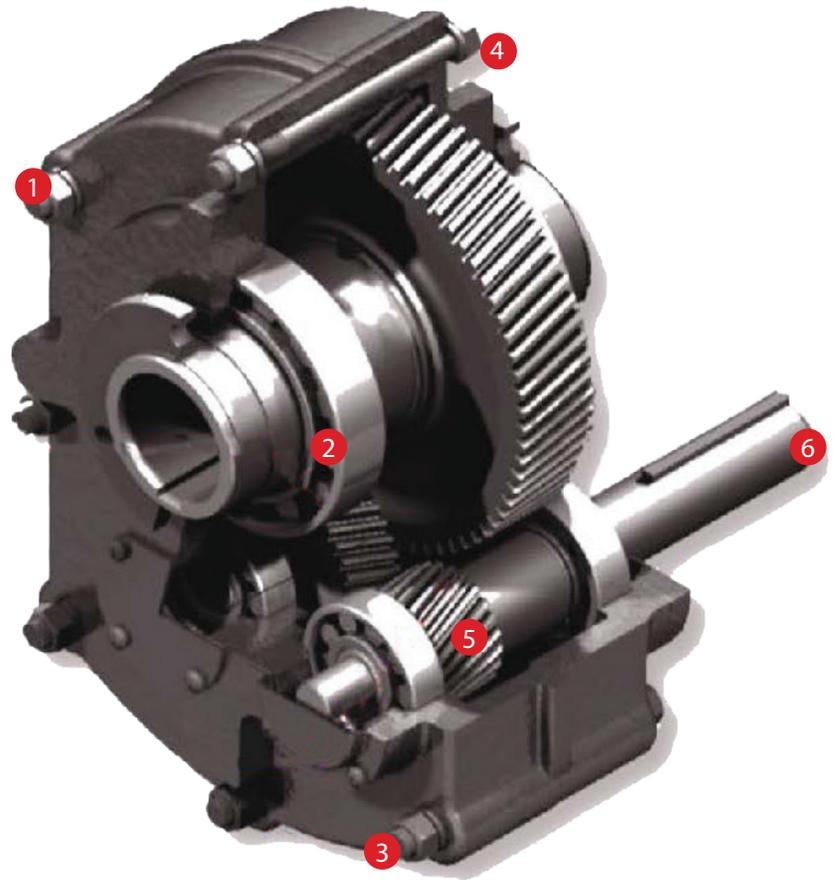


JACLYN ARENS
Marketing Technologist

ASTECC SHAFT-MOUNTED GEAR REDUCERS

Astec shaft-mounted gear reducers are engineered to offer high-quality performance at an affordable price. With immediate availability from our multiple stocking locations and standard warranty coverage, our gear reducers ensure quality and productivity.

- 1 Compatibility:**
With mounting holes and center distances matching the industry's most popular gear reducers, Astec gear reducers can replace many competitive market brands.
- 2 Operation:**
Premium ball and tapered roller bearings provide smooth, effortless operation with reduced noise. Bushing not included.
- 3 Durability:**
Heavy-duty FCD45 cast iron housing resists corrosion.
- 4 High-quality:**
Shafts and gears are manufactured from high-grade steel, case hardened and precision-ground to AGMA standards.
- 5 Expertly-engineered:**
Astec gear reducers are engineered with extended gear centers and tooth contact.
- 6 Reinforced:**
All shafts use metal-reinforced, double-lip seals to prevent oil leakage and contamination.



Options:

- Available in industry standard box sizes 2-10
- Output bores handle shaft sizes from 1¼" – 5 7/16"
- Full range of industrial-grade accessories compatible with many market brands
- Astec shaft reducers carry a two-year warranty

Offering includes the following for sizes 2 - 10:

- Backstops
- Belt Guards
- Breather Plugs
- Motor Mounts
- Shaft-Mounted Reducers
- Torque Arms
- Tapered Bushings
- Rebuild Kits

www.kpijci.com/parts

KOLBERG-PIONEER LAUNCHES WATER CLARIFICATION SYSTEMS

Kolberg-Pioneer has partnered with Tecnoidea Impianti to offer water clarification systems in North America.

The clarification systems accelerate the process of filtering fines from dirty water for reuse in the processing plant. These systems are designed to eliminate the need for large and expensive settling ponds by recovering up to 95% of the water that flows to

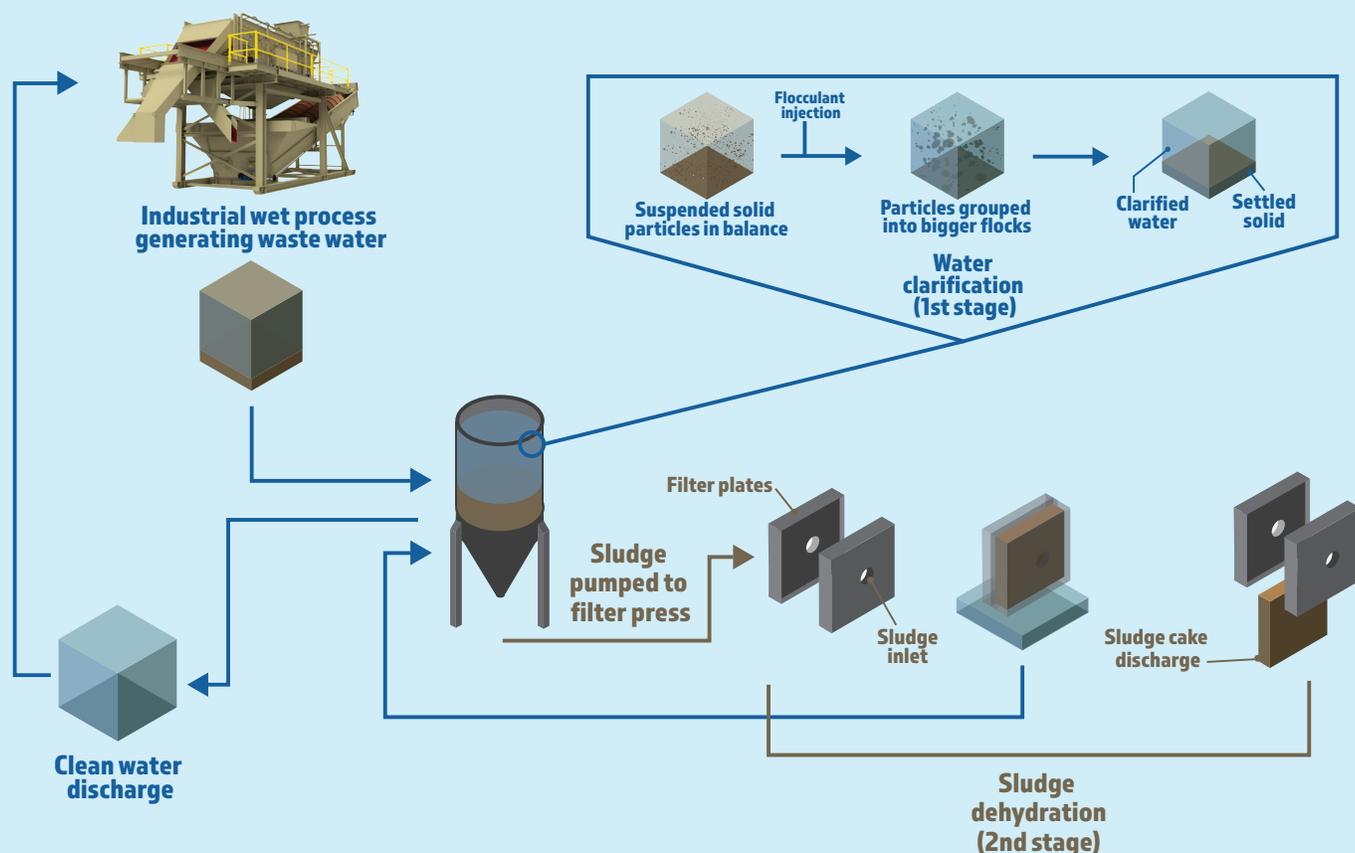
the clarification system. This allows producers to use significantly less water in their system.

"Water clarification systems save producers time and money associated with building, using and maintaining settling ponds. This partnership with Tecnoidea Impianti will allow us to continue to offer a one-source solution for our customers," said Brett Casanova, washing and classifying product

manager for Kolberg-Pioneer.

The water clarification systems will include: flocculation preparation units, static vertical settling tanks, thickened sludge tanks, side and overhead beam plate presses and other accessory components.

For more information regarding water clarification systems, contact Brett Casanova at brettcasanova@kolbergpioneer.com.





JOHNSON CRUSHERS INTERNATIONAL SHOWCASES NEW KODIAK® PLUS CONE CRUSHER MODEL

Johnson Crushers International has expanded its Kodiak® Plus cone crusher series with the new K350+. This mid-range model offers higher production with a smaller footprint. In comparison to the K300+, the K350+ features increases in drive train, stroke, horsepower, weight, head diameter and hold-down force, resulting in an up to 10% capacity increase.

With the same bolt pattern, the new cone can be mounted in most current K300+ applications.

“We have been testing the K350+ for a few years, especially on portable plants, and it has far surpassed our expectations. We are excited to release the K350+ to the market,” said Nick Hahn, product manager for Johnson Crushers International.

Like other cones in the Kodiak® Plus

cone crusher series, the K350+ will feature an industry-leading tramp iron relief system, fully-protected internal counterweights, precision roller bearing design, patented liner retention system and 360° thread locking ring for consistent product quality.

For more information regarding Kodiak® Plus cone crushers, contact Nick Hahn at NHahn@jcieug.com.

NORTH AMERICA MARKET CHANNEL UPDATES

Kolberg-Pioneer, Johnson Crushers International and Astec Mobile Screens are pleased to announce the group's newest North America market channel updates.

KPI-JCI and Astec Mobile Screens would like to announce **Hoffman Equipment** (Piscataway, N.J.) and **Conveying & Screening (C&S) Machinery, LLC.** (Pine Grove, La.) as the newest dealer appointments. Hoffman Equipment will represent mobile crushing and screening product lines in New Jersey and the boroughs of New York City. C&S Machinery will represent material handling and screening lines in Louisiana.

In addition to new dealer appointments, many others have expanded product offerings and territories. **Columbus Equipment Company, Inc.** has expanded its dealer representation of mobile crushing and screening product lines to include Indiana and Ohio.

Flagler Construction Equipment, Inc. has also expanded its dealer representation of mobile crushing and screening product lines to include all of Florida, with the exception of the

Florida panhandle.

Goodfellow Corporation, Inc. has expanded its dealer representation of mobile crushing and screening, material handling and washing and classifying lines to include Arizona, California, Nevada and Utah.

Modern Machinery has expanded its dealer territory of all product lines to include Alaska, Hawaii, Idaho, Montana, Oregon, Washington and northern Wyoming.

Murrysville Machinery Company, LLC has expanded its dealer representation of all product lines to include Delaware, Pennsylvania and West Virginia.

Power Motive Corporation has expanded its dealer representation of all product lines to include Colorado and southern Wyoming.

Stone Equipment Company, Inc. has expanded its dealer representation for all product lines to include Alabama, the Florida panhandle, Georgia and southeastern, central and western Tennessee.

For more information regarding the North America market channel updates, visit kpijci.com/support/dealer-locator/.



KOLBERG-PIONEER SHOWCASES NEW SAND PROCESSING PLANT AT BAUMA 2019

Kolberg-Pioneer has expanded its sand processing plant line to include the new 9201 model. This system is designed to dewater and fine-tune sand to a level not typically possible with traditional sand-dewatering equipment, while also using less water.

The custom-built systems are available in portable, semi-portable and stationary configurations with various types and quantities of cyclones, pumps and dewatering screen sizes.

"The 9201 is a very customizable unit that can be built to fit any application. The plant has many adjustable features like the deck liner and discharge dam and easy-to-replace parts for quick and simple maintenance," says Brett Casanova, product manager at Kolberg-Pioneer.

For more information regarding the 9201 sand processing plant, contact Brett Casanova at brettcasanova@kolbergpioneer.com.





RANGER™

COMPACT MOBILE EQUIPMENT

Astec Mobile Screens is launching a new line of compact, track-mounted equipment. The new equipment, marketed through licensed dealers as the Ranger™ line, will include a variety of jaw crushers, impact crushers, cone crushers, incline screens and trommels.

These compact units will serve a variety of new markets including

building and construction, landscaping, quarry operations and plant and tool hire. The ease-of-use, ease-of-transport, versatility and flexibility of compact, track-mounted units make them ideal for smaller operations that require powerful equipment with a limited footprint.

The Ranger™ line will be represented by a network of dealers that have the

capacity to support the equipment and sustain a strong rental program for its customers.

“The new Ranger™ line will help us reach a wider range of industries and customers. The compact units are going to be a great tool for contractors, quarry operators and many more. We are remaining very focused on providing excellent support for these units, just like our other products,” says Patrick Reaver, inside sales director at Astec Mobile Screens.

For more information regarding Ranger™ compact track units, contact Michael Edwards at michael.edwards@kpijci.com

BUILDING THE BASE

For Haupt Construction, time is of the essence for their latest 765,000 square-foot crushing project located just outside of Kansas City. With a hurried and rigorous deadline, the crew at Haupt is wasting no time with their production.

The multi-generational company, established in 1963 by Robert Haupt, started out with much smaller projects. Robby Haupt, an operator for the company, says, "We were founded by my grandpa and started out as a small dozing company just to supplement his farming, and it's really taken off from there."

Since the company's expansion and growth, it has taken on several large-scale projects including a variety of commercial infrastructure jobs, highway developments and residential work. When asked about their projects, Billy Winegar, foreman for Haupt Construction described their wide range of work as "Pretty much anything that has to do with dirt work in the industry."

With their current project, and its stringent timeline, the crew at Haupt knew they needed machines with the extra power and capacity to help them finish the project as quickly as possible. Rob Franklin, an aggregate specialist at Van Keppel, set Haupt up with three track-mounted FT4250 horizontal shaft impactor plants. Winegar explains, "We have three 4250 plants, two are open-circuit and being fed by one excavator and the other is closed-circuit and being fed by another excavator." Their operation begins with blasting the material from the ground, creating a ledge where the excavators add material into the crushing units to

be laid back down as a base. Franklin describes the process, "After the daily blast, they are using the FT4250s to make a base product. They're shooting every day around four o'clock to make the seven- to nine-foot ledge." Winegar adds, "We blast the rock down to size and we usually run in behind the blast and basically just use progressive crushing. We just keep stepping back through crushing along making about 600 to 800 tons per hour of the three inch minus base."

WEATHER PERMITTING

Through phase one of their current project, Haupt Construction has faced one major operational challenge: the weather. The majority of the Kansas City area, and many other parts of the Midwest, have experienced historical levels of flooding. Franklin says, "The rain has really set folks back. We have gotten twice as much rain in the last few months than we get annually in our area. It's been a fight; a huge struggle. Right now, thankfully, things are drying up. They are trying to make the most out of each dry day they have." Haupt adds, "The entire site was completely saturated. It was to the point where it didn't matter if it rained anymore because it was so wet they couldn't handle any more water, everything was just running off."

Through the difficult weather, the crew's three machines held strong and persevered past other units. When asked about how the equipment handles saturated material, Franklin says, "Much better than the competition. They had two other competitive units out here and they lasted one week during the wet









weather. They both plugged up, so we sent them back home." Haupt added, "The biggest thing that I will say about the FT4250s, is that they have managed to handle wet material and mud much better than anything else would have." Aside from handling soaked material, the crew appreciated many other aspects of the machines. "What they like about the units is the 18-foot feeder. They're able to load the feeder

and Astec Mobile Screens over and over again, Winegar says, "I've used other machines before, but we tend to go back to KPI-JCI and Astec Mobile Screens for the customer support," he adds, "It's been nice to be able to rely on American-made equipment because the support's all here and if there is a problem, it's always a quick fix."

Along with KPI-JCI and Astec Mobile Screens, the Van Keppel team has been working with the Haupt crew for several decades. Haupt says, "We have been working with Van Keppel longer than I can remember. We've rented and bought equipment from them for a long

"I'VE USED OTHER MACHINES BEFORE, BUT WE TEND TO GO BACK TO KPI-JCI AND ASTEC MOBILE SCREENS FOR THE CUSTOMER SUPPORT. IT'S BEEN NICE TO BE ABLE TO RELY ON AMERICAN-MADE EQUIPMENT BECAUSE THE SUPPORT'S ALL HERE AND IF THERE IS A PROBLEM, IT'S ALWAYS A QUICK FIX." - BILLY WINEGAR

and the crusher up and the opening is allowing the shot rock to go in and get them the production they need, especially running three crushers at a time, to get through as much of this project as they can every day. Time is valuable," says Franklin. Winegar also mentions the mobility of the FT4250s, "Mobility is obviously important to our 'crush and run' philosophy. Typically our cuts are not as deep as something you would see in a quarry, so we are constantly moving. Being able to adjust quickly cuts down on our downtime and lets us produce more." Haupt mentions the ease-of-use, as well as the easy set-up and operation, as some of the units' top features. Overall, the group is most impressed with the capacity and production of the equipment. Winegar says, "We've tried some other crushers in the past and for the multitude of material in our area, the FT4250 seems to be the only one that will pull through."

time." When asked about the support Van Keppel has provided, Winegar says, "The support has been excellent. Any time there has ever been an issue or service requirement, it's solved within a day." Franklin adds, "At Van Keppel, we have three excellent mechanics who are able to get on the project if they need us out there, and we always show up. We bend over backwards, not only for Haupt Construction, but for all of our customers. They deserve that kind of support."

With a well-supported operation and dedicated crew, the future of Haupt Construction is bright. Franklin says, "What do I see for the future of Haupt? Well they are a three-generation operation and I expect to see a lot of growth out of this company. The boys are young, they're eager and they're getting more and more experience with every job they get. They have a handle on how to move and build these paths quickly. They were indoctrinated with a huge project of over 800,000 yards of material for their first venture, and I think it will all be smooth from here." Haupt adds, "We hope to see a lot more growth in both projects and our team. There is a lot of work in this area right now, and we're doing our best to take on as much as we can."

RELIABILITY MATTERS

Haupt Construction has had a relationship with both KPI-JCI and Astec Mobile Screens and their dealer Van Keppel, for many years. When asked why the group chooses KPI-JCI



WADE LIPPERT
Field Service Representative

The radial stacker is a crucial aspect of any quarry operation. However, when it comes to maintenance, this machine is often overlooked. As with any other piece of equipment, the radial stacker should be properly maintained and those working with the stacker should be adequately trained on both operation and regular maintenance. It is critical to maintain all equipment; if one machine shuts down, the whole operation can come to a halt. Regularly lubricating the stacker is an important part of maintenance. The head and tail pulleys, and additional grease points, need to be kept on a consistent maintenance schedule. Depending on the design of the stacker, operators may also have to lubricate live shaft returns, snubber idlers or a combination of the two. If the stacker extends, guide and support rollers will also have to be kept maintained. Operators and maintenance crews should be trained and familiar with these crucial grease points and should follow the manufacturer's lubrication recommendations for grease type and intervals.

Belt tensioning and training are also regular maintenance practices. New belts, as well as stretched-out belts, require tensioning. When tensioning a belt, operators should only tighten it enough to prevent slipping on the head and drive pulleys, further tensioning can shorten the life of the conveyor belt and bearings. If a belt

TALKING SHOP

BEST MAINTENANCE PRACTICES FOR RADIAL STACKERS

is over-tensioned, it will become very difficult to keep trained. Tension should be checked regularly, especially on newer belts.

Training a belt to track correctly is imperative for efficiency. When training a belt, operators should be sure to use the idlers, rather than the stacker's take-up. Using the take-up to train the belt can result in tension changes.

When training a loaded belt, operators should make adjustments using the troughing idlers, rather than return idlers, as a loaded belt will react much differently than an empty one. Operators should adjust the incoming feed material, or transfer point, to land in the center line of the belt and on the center of the anchor pivot. As the radial stacker moves up and down and side to side, the adjusted material positioning will ensure the product is hitting the stacker in the same place, regardless of its position.

When training an empty belt, producers should adjust return idlers in the direction they want to steer the belt, just like steering a bicycle using handle bars. This process takes more time, as it may require several revolutions of the belt to have a noticeable effect. Making too much of an adjustment can cause the belt to migrate too far in one direction.

Once the empty belt is trained, operators will want to test it with material. If a lot of adjustments were made, one should re-examine the transfer point to ensure the material is falling in the center and over the anchor pivot.

In addition to properly tracking the belt, the radial stacker should be cleared of material build-up daily. Excess built-up material can affect the belt tracking, damage parts and increase horsepower requirements.

A belt cleaner can be added to aid in keeping the stacker clear of excess material, especially in wet applications.

However, the belt cleaner needs to be properly installed. If the cleaner is too loose, it will have no effect and if it is too tight, it can affect the horsepower requirements as well as the tracking. Being proactive in the maintenance of equipment is critical. Operators should keep an accurate, detailed record of repairs, including completion information and historical data. Such a record allows maintenance crews to troubleshoot and focus on issues in their infancy, rather than suffering a major breakdown in the future. This simple record can also act as a powerful training tool and reminder for ordering regular wear parts.

The final aspect of maintaining a healthy machine is working with those who operate the stacker every day. Operators can provide valuable information regarding both maintenance and application improvements, which can help save producers time and money as well as increase profitability and efficiency.

Along with the regular maintenance of the radial stacker itself, its travel path also needs to be monitored. Its radial travel pattern, over time and with changing weather conditions, can become worn down. The worn travel path can make the stacker unstable and cause the machine to use more power to navigate the tattered path. Using more force and power to travel over the path can cause additional stress on the equipment. Maintaining a level, smooth path, as well as appropriate tire pressure, ensures the safety of operators and the longevity of the stacker.

Radial stackers are an imperative part of any operation. Without proactive maintenance, stackers can quickly become inefficient. Following a disciplined maintenance routine can increase the effectiveness and the life of radial stackers, saving producers time and money.

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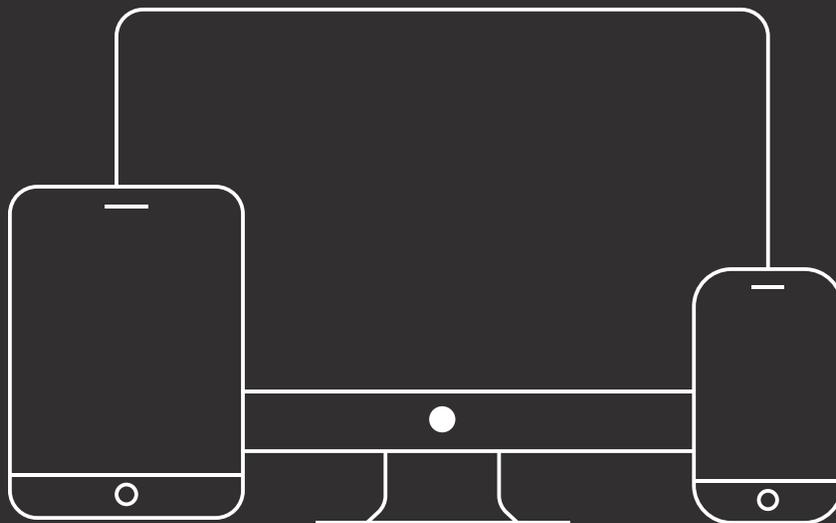
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