



8Z1105 - Spray Fill Xpress

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# Operator's Manual



## **SFX1630 & SFX2430** (Spray Fill Xpress)



### CAUTION

READ & UNDERSTAND OPERATOR'S MANUAL BEFORE OPERATING MACHINE.

*See [www.summersmfg.com](http://www.summersmfg.com) for latest version of all Summers Operator's Manuals.*

**SUMMERS MANUFACTURING CO., INC.**  
WEB SITE: [www.summersmfg.com](http://www.summersmfg.com)

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## Preface

This manual is intended for use with SFX1630 & SFX2430 Spray Fill Xpress for Summers® Manufacturing Company, Inc.

This book is composed of these basic sections: Safety, Operation & Maintenance, Troubleshooting and Parts. The Operation & Maintenance section provides information for the proper operation and maintenance of your Summers Spray Fill Xpress. A complete Parts breakdown is provided in the Parts section.

Parts are referenced in each drawing with an item number. On following page the item number is associated with the Summers Manufacturing part number and description. Use this part number when ordering replacement parts from your Summers dealer.

## Disclaimer

It is the policy of this company to improve its products whenever possible and practical to do so. We reserve the right to make changes or improvements in the design or construction of parts at any time without incurring the obligation to install such changes on products previously delivered.

Summers Manufacturing Company, Inc. strongly recommends that each Spray Fill Xpress operator READ and UNDERSTAND the Operator's Manual before using the machine. In addition, the Operator's Manual should be REVIEWED at least Annually thereafter.

## Contact Information

Summers Manufacturing Company, Inc.  
103 Summers St. NW  
Devils Lake, ND 58301  
Toll Free: 1-800-732-4392  
Local: 1-701-662-5391 (Devils Lake, ND)  
1-605-226-3644 (Aberdeen, SD)  
[www.summersmfg.com](http://www.summersmfg.com)

*Scan code below for  
the latest version of all  
Summers Operator's Manuals.*



## Owner Registration Information

Bring this information when ordering parts (Serial Number is located attached to bottom of Spray Fill Xpress skid).

Name \_\_\_\_\_  
Address \_\_\_\_\_  
City \_\_\_\_\_  
State/Prov. \_\_\_\_\_  
Mail Code \_\_\_\_\_

Size \_\_\_\_\_  
Serial Number \_\_\_\_\_  
(located by the hitch)  
Date Purchased \_\_\_\_\_  
Dealer \_\_\_\_\_

# WARRANTY

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Summers warrants only products of its manufacture against operational failure caused by defective materials or workmanship which occur during normal use within 36 months from the date by the end user from Summers' dealer.

Summers' obligation is to replace, free of charge, any part of the product that Summers inspection shows to be defective excluding transportation charges to Devils Lake, ND and return and also excluding all transportation costs from Summers' dealer to the dealer's customer and all other costs, such as removal and installation expense.

Summers shall not be liable for loss of time, manufacturing costs, labor, material, loss of profits, consequential damages, direct or indirect, because of defective products whether due to rights arising under the contract of sale or independently thereof, and whether or not such claim is based on contract, tort or warranty.

Written permission for any warranty claim return must be first obtained from authorized Summers' personnel. All returns must be accompanied with a complete written explanation of claimed defects and the circumstances of operational failure.

Written warranty for all component parts used in the manufacture of Summers products is available upon request. Warranty of such component parts will be determined by said component manufacturer upon their inspection of the claimed defective part.

This express warranty is the sole warranty of Summers. There are no warranties, which extend beyond the warranty therein expressly set forth. The sales for products of Summers under any other warranty or guarantee express or implied is not authorized. This warranty voids all previous issues.

**Summers® Manufacturing Co., Inc.**  
Devils Lake, ND 58301

01/16

## Safety Information



This safety alert symbol is used to denote possible danger and care should be taken to prevent bodily injury. When you see this symbol it means ATTENTION, BECOME ALERT! and/or YOUR SAFETY IS INVOLVED!

**WARNING: Safe practices must be followed when working on or operating this equipment. All personnel involved must:**



- Read and understand the instructions and manuals for this machine.
- Be instructed in the safe use of tools and all lifting devices involved in the assembly of this equipment.
- Clear the area of all personnel not involved in the assembly of this machine.

## General Safety Practices

1. READ and UNDERSTAND the Operator's Manual before using any equipment. Review at least annually thereafter.
2. VERIFY all safety devices and shields are in place before using any equipment.
3. KEEP hands, feet, hair and clothing away from moving parts.
4. STOP engine, place all controls in neutral, set parking brake, remove ignition key and wait for all moving parts to stop before servicing, adjusting, maintaining or unplugging.
5. BE CAREFUL when working around high pressure hydraulic system.
6. DO NOT ALLOW RIDERS.

## Safety During Transportation

1. ONLY TOW at a safe speed. Use caution when making corners and meeting traffic.
2. USE safety chain between tractor drawbar and implement hitch when transporting on public roads.
3. ALWAYS use transport locks when transporting on public roads.
4. COMPLY with local lighting, marking and oversize regulations when transporting on highways.
5. FREQUENTLY check for traffic from rear, especially during turns.

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## Safety Decals



Indicates an immediate hazardous situation that will result in death or serious injury. The color associated with Danger is RED.



Indicates a potentially hazardous situation that could result in death or serious injury. The color associated with Warning is ORANGE.



Indicates a potentially hazardous situation that may result in minor or moderate injury. It may also be used to alert against unsafe practices. The color associated with Caution is YELLOW.



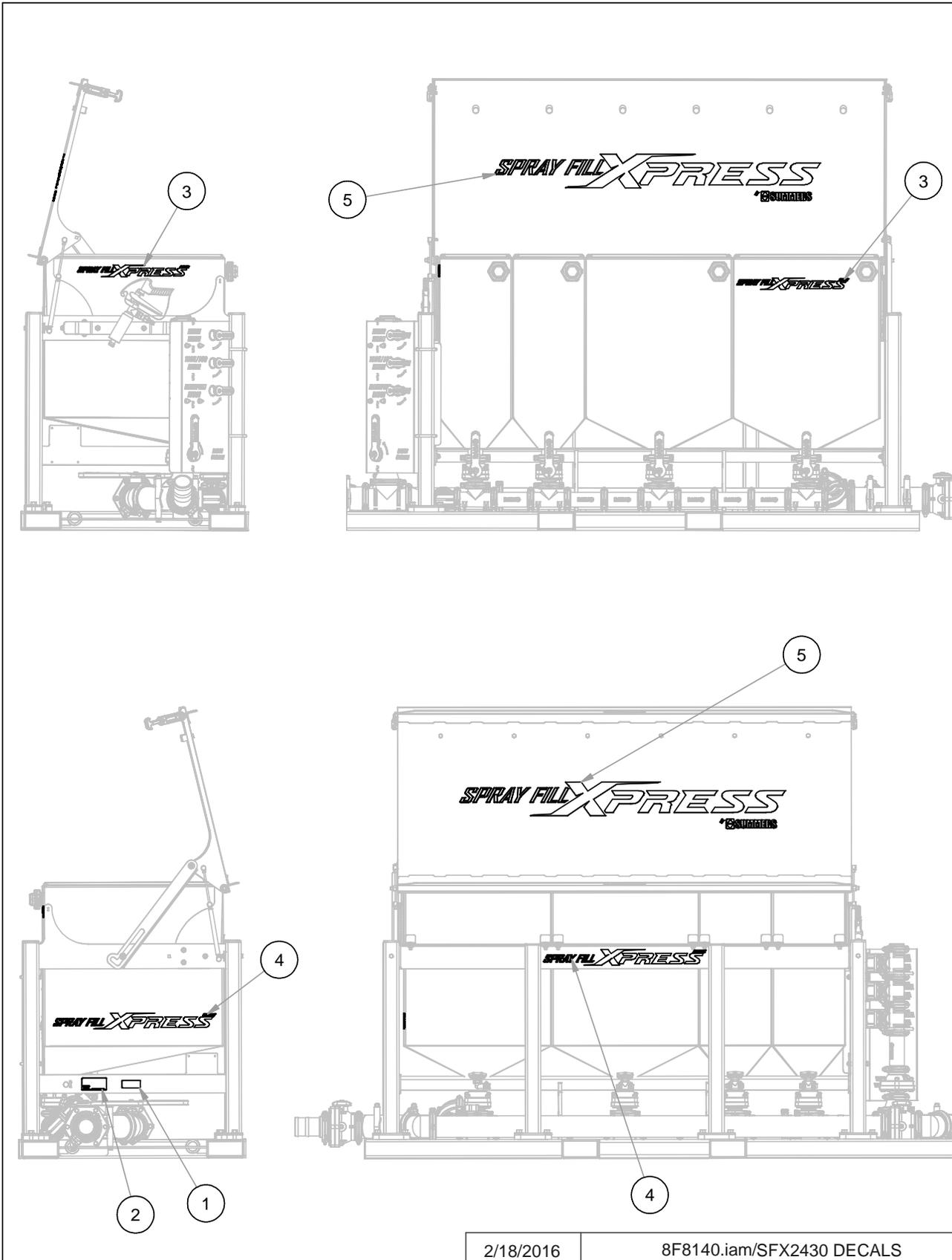
The Notice decals and statements in this manual are to inform the operator of the correct fluids or operational practices for this machine. Failure to follow these notices will result in damage to the machine. The color associated with Notice is GREEN.

1. Keep safety signs clean and legible at all times.
2. Replace safety signs that are missing or have become illegible.
3. Replaced parts that displayed a safety sign should also display the current sign.
4. Safety signs are available from your dealer's parts department or the factory.

### *How to install safety signs?*

1. Be sure that the installation area is clean and dry.
2. Be sure the temperature is above 50° F (10° C).
3. Decide on the exact position before removing the backing paper.
4. Remove the smallest portion of the split backing paper.
5. Align the sign over the specified area and carefully press the small portion with the exposed sticky backing in place.
6. Slowly peel back the remaining paper and carefully smooth the remaining portion of the sign in place.
7. Small air pockets can be pierced with a pin and smoothed out using the piece of sign backing paper.





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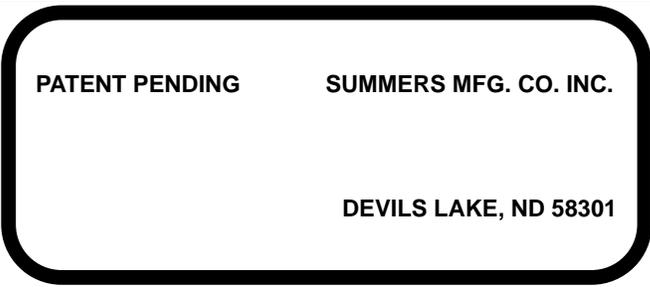
8F8140.iam/SFX2430 DECALS

**Safety Decal Locations**

The types of safety signs and locations on the equipment are shown in the illustrations below. Good safety requires that you familiarize yourself with the various safety signs, the type of WARNING and the area or particular function related to that area, that requires your SAFETY AWARENESS.

**IMPORTANT:** If Safety Signs have been damaged, removed, become illegible or parts replaced without safety signs, new signs must be applied. New safety signs are available from your authorized dealer.

*Safety Decals*

SFX2430 DECALS				
ITEM	PN	QTY	DESCRIPTION	
1	8Z0046	1	PATENT PENDING DECAL	
2	8Z0100	1	MADE IN THE USA DECAL	
3	8Z2508 8Z2510	2	18" SFX1630 DECAL 18" SFX2430 DECAL	
4	8Z2513 8Z2515	2	24" SFX1630 DECAL 24" SFX2430 DECAL	
5	8Z2518 8Z2520	2	36" SFX1630 DECAL 54" SFX2430 DECAL	

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## General Maintenance Safety Practices

**NOTE: Read the entire section before beginning work.**

### *Before You Begin*

- **YOU ARE RESPONSIBLE** for the safe maintenance of the Spray Fill Xpress.
- **DO NOT ALLOW CHILDREN** or other unauthorized persons within the Spray Fill Xpress operational area.
- **WEAR PERSONAL PROTECTIVE EQUIPMENT** which could include a hard hat, eye protection, rubber gloves and steel toed boots with slip resistant soles.
- **DO NOT MODIFY** the equipment or substitute parts in any way. Unauthorized modifications may impair the function and/or safety of the machine.
- **USE SUITABLE LIFTING DEVICE** for components which could cause personal injury.
- **BLOCK UP ANY RAISED PART** of the machine. Be sure machine is stable after blocking.
- **ALWAYS INSPECT LIFTING CHAINS AND SLINGS** for damage or wear.
- **BE SURE LIFTING DEVICE IS RATED TO HANDLE THE WEIGHT.**
- **STOP ENGINE**, place all controls in neutral, set parking brake, remove ignition key and wait for all moving parts to stop before servicing or adjusting. For plumbing repairs make sure valves are closed to avoid water or chemical spills.
- **BE SURE PRESSURE IS RELIEVED** from hydraulic circuits before servicing or disconnecting from tractor.
- **USE EXTREME CARE** when assembling, servicing or adjusting.

## Operation Safety

1. READ AND UNDERSTAND Operator's Manual before using machine. Review at least annually thereafter.
2. VERIFY that all safety devices and shields are in place before using machine.
3. KEEP hands, feet, hair and clothing away from moving parts.
4. STOP engine, place all controls in neutral, set parking brake, remove ignition key and wait for all moving parts to stop before servicing, adjusting, maintaining or unplugging.
5. BE CAREFUL when working around high pressure hydraulic system and farm chemicals.
6. ALWAYS make sure that pressure is relieved from hydraulic circuits before servicing or disconnecting from tractor.
7. DO NOT ALLOW RIDERS.
8. USE EXTREME CARE when making adjustments.
9. KEEP CHILDREN AWAY from machinery at all times.
10. NEVER ALLOW anyone to walk or work under a raised piece of equipment without installing cylinder and transport locks.

## Steps Prior to Operation

1. COMPLETE WARRANTY REGISTRATION CARD
  - A. Complete and return WARRANTY REGISTRATION CARD located at the beginning of this manual. **RETURNING CARD ENTITLES YOU TO A FREE GIFT.**
  - B. Complete the OWNER REGISTER also located at the beginning of this manual (Serial Number is located on base piece). OWNER REGISTER INFORMATION MAY BE NEEDED WHEN ORDERING PARTS.



## Description

Spray Fill Xpress chemical fill system is designed with an in-line educator to mix fluids and dry chemicals in a self-contained system quickly, easily, and safely. The Spray Fill Xpress operates by receiving water into a venturi educator where liquid or dry chemicals are mixed while they are routed to the sprayer tank. The Spray Fill Xpress is constructed out of 304 stainless steel with a venturi type polypropylene educator that routes the spray solution through an assembly of fittings and hose to the spray tank. The Spray Fill Xpress is designed to be used by an operator, when installed in an approved location, during loading and draining of multiple chemicals from the hoppers while the sprayer tank is loaded.

## Intended Uses

The Spray Fill Xpress is designed and constructed to be a part of applications that require rapid mixing of a recipe of multiple liquid and or dry chemicals and transport them to the sprayer tank via some carrier that could be water. The Spray Fill Xpress can be used in a wide variety of conditions, but must be used in outdoor or well ventilated areas.

## Unintended Uses

Do not use the Spray Fill Xpress with explosive materials.

Do not operate the Spray Fill Xpress with missing, damaged, or leaking parts.

Do not use the Spray Fill Xpress in applications where fluid could be used for human consumption.

Do not use the Spray Fill Xpress if it is not properly secured to application.

Do not exceed the maximum pressure of 75 psi when using the Spray Fill Xpress.

## Initial Check

1. After receiving or assembling your Spray Fill Xpress, it is a good practice to double check the entire machine to be sure all fasteners are securely tightened.
2. Make sure all fittings are in place and clamps are tight.

## Before Operation

1. Park Spray Fill vehicle on a firm level surface large enough for good access of your field sprayer.
2. Ensure all Spray Fill Xpress valves are closed prior to starting engine and inspect for leaks.
3. Open Spray Fill Xpress lid and lock lid support brace into place so wind cannot close lid on you. Inspect hoppers for cleanliness, remove foreign material as necessary.
4. Turn on scale if equipped and verify scale is zeroed prior to filling hopper with material to be measured.
5. Measure required amount of chemical into each hopper using scale, flowmeter or other accurate measuring vessel.
6. Each hopper is equipped with container rinse system that can be used to rinse empty liquid containers just by pushing the plunger down with the container. Engine and pump need to be operating for jug rinse nozzles to function.
7. Each container should be rinsed for 30 seconds or longer so operator is certain the container is visibly clean.
8. Repeat 4 & 5 as required to make recipe.

**Start-Up**

1. Start engine and divert pump flow to venturi.
2. Open each hopper outlet valve until hopper is empty. Hand wand can be used to aid washing chemical into plumbing. Close hopper valves when hopper is clean and empty.
3. Ensure chemical residue had been flushed from the hopper and hopper has been rinsed using the hand wand or by closing lid and using the hopper rinse system.
4. Open the bypass valve and allow water diverted through venturi to flow freely through plumbing until sprayer tank loading is complete.

**Shutdown**

1. Close inlet water source.
2. Close Spray Fill Xpress valve.
3. Close sprayer bottom fill valve.
4. Turn engine off.
5. Disconnect sprayer bottom fill hose.

**Transporting Spray Fill Xpress**

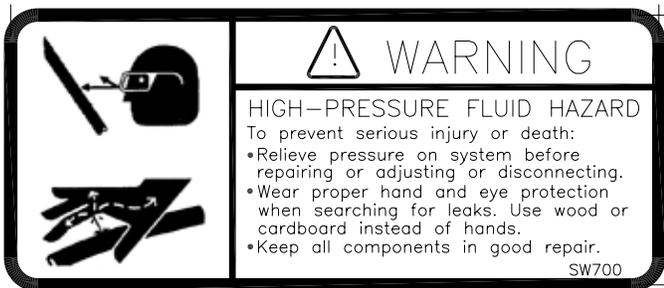
1. Close and secure lid.
2. Secure any loose chemical containers.
3. FOLLOW ALL local laws governing transporting of farm machinery.
4. Stay clear of overhead lines and other overhead obstructions.

## Maintenance Safety

1. STOP engine, place all controls in neutral, set parking brake, remove ignition key and wait for all moving parts to stop before servicing, adjusting or maintaining.
2. BE CAREFUL when working around high pressure hydraulic system.
3. ALWAYS make sure that pressure is relieved from hydraulic circuits before servicing or disconnecting from tractor.
4. USE EXTREME CARE when making adjustments.
5. KEEP CHILDREN AWAY from machinery at all times.
6. NEVER ALLOW anyone to walk or work under a raised piece of equipment without installing cylinder and transport locks.

## Maintenance after the 1st day and week of Operation

1. Check all plumbing components for leaks.
2. Check for any lose or missing fasteners.



3. Check engine oil and fuel levels.
4. Check valves operation and conditions.

## Daily Maintenance

1. Check all hydraulic components for leaks. (SEE HIGH-PRESSURE FLUID WARNING.)

## Periodic Maintenance

1. Check tightness of all hardware. Pay special attention to hinges and support bolts.
2. Check Spray Fill Xpress for damaged or worn parts. Replace as needed.
3. Check Spray Fill Xpress for frayed, chaffed, or leaking hoses. Verify all clamps are tight. System must be leak free.

## Storage

1. Clean and remove all excessive dirt and grease from Spray Fill Xpress.
2. To prevent rusting, repaint any areas that have been worn, chipped or scratched.

## SPECIFICATIONS

Model	Width	Height	Length w/o Engine	Length w/Engine
SFX1630	40"	46"	91"	119"
SFX2430	40"	46"	114"	142"

## APPROXIMATE WEIGHTS OF COMPONENTS

Maximum Pressure Rating	75 PSI
Scale Capacity	2500 lbs.
13 HP Engine with 3" pump	Max GPH - 440 Max PSI - 54
8F8115 - 2 Compartment (SFX1630)	Weight - 945 lbs.
8F8125 - 3 Compartment (SFX1630)	Weight - 1003 lbs.
8F8135 - 4 Compartment (SFX1630)	Weight - 1065 lbs.
8F8130 - 3 Compartment (SFX2430)	Weight - 1297 lbs.
8F8140 - 4 Compartment (SFX2430)	Weight - 1372 lbs.
8F8150 - 5 Compartment (SFX2430)	Weight - 1523 lbs.
8F8160 - 6 Compartment (SFX2430)	Weight - 1530 lbs.

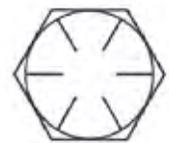
## PROPER BOLT USE

DO NOT use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only. Check tightness of fasteners periodically.

BOLT SIZE	WRENCH SIZE	GRADE 5		GRADE 8	
		ft-lbs	N • m	ft-lbs	N • m
1/4"	7/16" or 3/8"	7	9.5	12	17
5/16"	1/2"	15	20	25	34
3/8"	9/16"	30	41	45	61
7/16"	5/8" or 11/16"	45	61	70	95
1/2"	3/4"	70	95	105	142
9/16" wheel bolts	7/8"	170	231		
5/8"	15/16"	170	231	210	285
5/8" wheel nuts	1-1/16"	240	325		
3/4"	1-1/16"* or 1-1/8"	250	339	375	509
7/8"	1-5/16"	350	475	600	814
1"	1-1/2"	450	610	880	1193
1-1/4"	1-7/8"	500	678		
1-1/2"	2-1/4"	570	773		
2"	3-1/8"	1200	1627		



SAE  
GRADE 5



SAE  
GRADE 8

\*Nylon Lock Nut

3/8/12 TILLAGE

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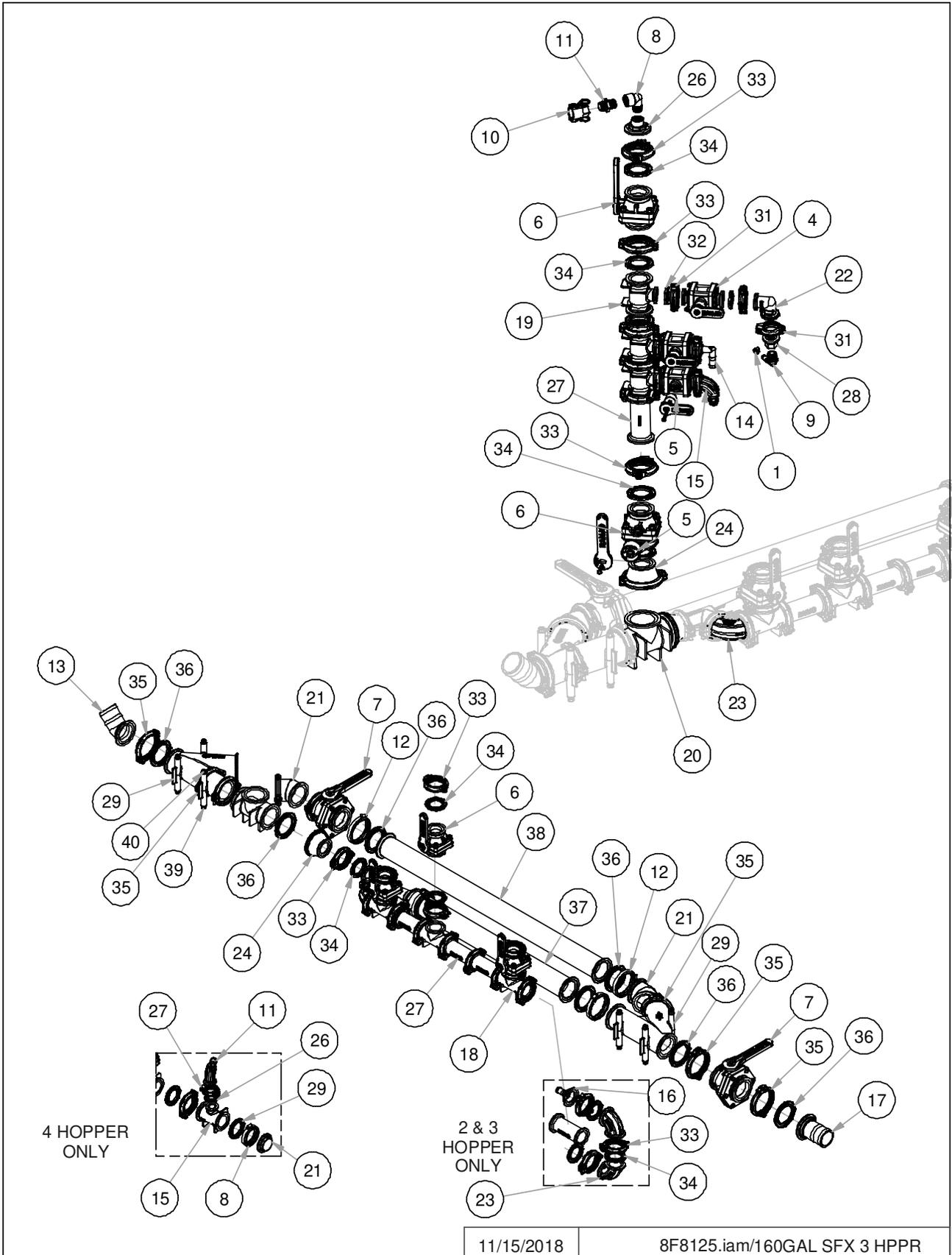
## **Parts Ordering Procedure**

When ordering parts for your Summers Spray Fill Xpress, please contact an authorized Summers dealer in your area. If the parts are associated with a possible warranty claim, make sure that you contact the original dealer from which you purchased the Summers implement. Make sure to provide the Summers implement model, Serial number, Part number, Part description and quantity.



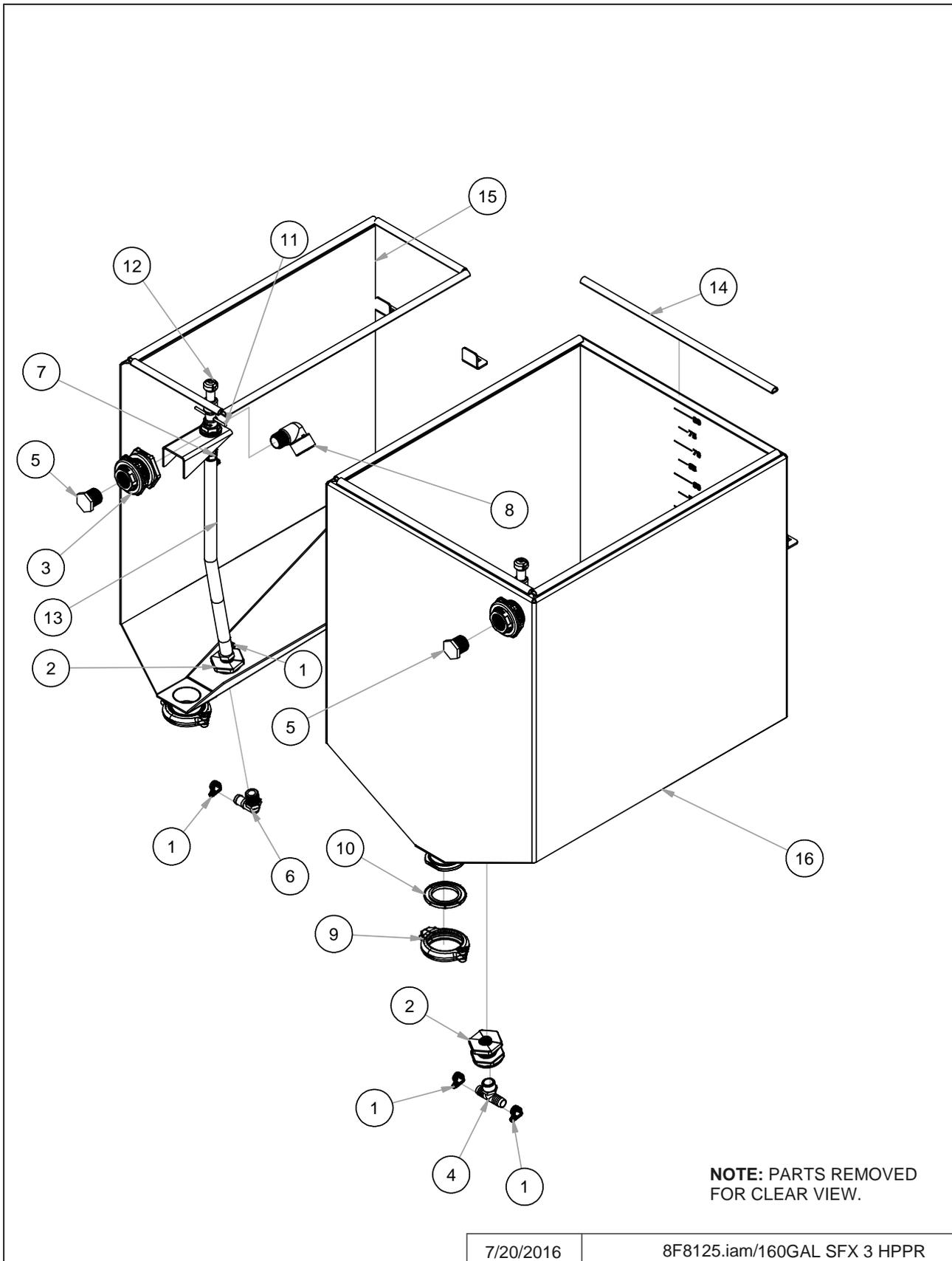
**SFX1630 TANK BASE**

ITEM	PART NUMBER	DESCRIPTION
1	8F0004	STAINLESS STEEL BOLT SPACER
2	8F0100	HINGE SUPPORT
3	8F0102	HINGE PLATE
4	8F0400	UHMW HINGE BUSHING
5	8F0414	GAS SPRING
6	8F0424	RUBBER LATCH STRAP
7	8F6004	LID 160 GALLON SPRAY FILL XPRESS
8	8F6100	RINSEBALL DEPRESSER SS304
9	8F6110	VALVE PANEL SPRAY FILL
10	8F8004	SPRAY FILL SIDE RAILING LFT
11	8F8006	SPRAY FILL SIDE RAILING RGT
12	8F8010	SPRAY FILL EXPRESS BASE
13	8F8012	BACK SUPPORT 160 SF PTD 15-
14	8G8020	U-BOLT 3/8 X 2-9/16 X 3-1/2" SQ
15	8L3376	SPRAY FILL RINSE GUN HOLDER
16	8S0295	U-BOLT 3/8 X 2-5/8 X 4-1/4"RND
17	8X0018	SS 3/8 X 16NC - 1/2" BOLT
18	8X0060	1/2" - 13 FLANGED BOLT
19	8X0065	CRG 1/2-13NC X 2" GR5 ZDI
20	8X0161	SCREW SKT HD 10 X 24 X 1" SS
21	8X0200	NUT 3/8"-16NC SERFLANG GR2 SS
22	8X0202	NUT 3/8"-16NC NY-LOCK GR2 YZ
23	8X0207	NUT THIN 10 X 24 NYLOCK SS
24	8X0212	NUT 5/16"-18NC NY-LOCK GR2 ZDI
25	8X0242	NUT 1/2"-13NC NY-LOCK GR2 YZ
26	8X0319	WASHER 17/32"IDX7/8ODX16GA ZDI
27	8X0320	WASHER 3/8" (7/16" ID)FLAT ZDI
28	8X1112	CRG 3/8-16NC X 1" SS
29	8X1113	CRG 3/8-16NC X 1.5" SS



**SFX1630 PLUMBING**

ITEM	PART NUMBER	DESCRIPTION
1	8A1003	CLAMP HOSE 1/2" MINI
2	8A1007	CLAMP HOSE 3/4" #12
3	8A1009	CLAMP HOSE 1" #16
4	8A1253	1" FLANGED VALVE
5	8A1254	BV HANDLE RISER 2X1.38" 15-
6	8A1734	2" SHORTY BALL VALVE
7	8A1742	BALL VALVE 3" STUBBY DBLFLNG
8	8A2008	STREET ELBOW 3/4"
9	8A2108	ELBOW 1/2" HB X 3/4 MPT
10	8A2204	3/4"COUPLER X 3/4" GHFTHREAD
11	8A2212	3/4" MPT X 3/4" GHMTHREAD
12	8A2235	FLANGE CLAMP FC300 WORM SCREW
13	8A2249	FLANGE ELBOW 45° M300 X 3" HB
14	8A2250	FLANGE ELBOW 90 M100 X 3/4"HB
15	8A2251A	1" FLANGE SWEEP ELBOW 90 DEGREE
16	8A2287	FLANGE M220 X 1"HB
17	8A2293	FLANGE M300 X 3" HB FULL PORT
18	8A2297	FLANGE TEE M220 FULL PORT
19	8A2298	FLANGE TEE M220 X M220 X M100
20	8A2299	FLANGE TEE M300 FULL PORT
21	8A2317A	FLANGE ELBOW 45° M300
22	8A2318	FLANGE ELBOW 90 M100
23	8A2319	2" FULL PORT SWEEP ELBOW
24	8A2328	FLANGE REDUCER M300 X M220
25	8A2332	FLANGE PLUG M220 FULL PORT
26	8A2334	FLANGE PLUG M220 W/3/4" FPT
27	8A2338	2" X 6" FULL PORT COUPLING
28	8A2340	FLANGE M100 X 3/4" FPT
29	8A2342	FLANGE 3" FP 45° Y
30	8A2345	FLANGE 2" FP POLY INDUCTOR
31	8A2380	1" UNIVERSAL FLANGE CLAMP
32	8A2381	FLANGE GASKET 1" HYPRO
33	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
34	8A2385	FLANGE GASKET 2" HYPRO
35	8A2386	HYPRO 3" UNIVERSAL FLANGE CLAMP
36	8A2387	FLANGE GASKET 3" HYPRO
37	8F6134	FLANGEPIPE 3 X 33.75" SS304
38	8F6150	FLANGEPIPE 3 X 50.06" SS304
39	8X0046	BOLT 7/16-14NC X 7-1/4"GR5 ZDI
40	8X0234	NUT 7/16"-14NC NY-LOCK GR2 ZDI

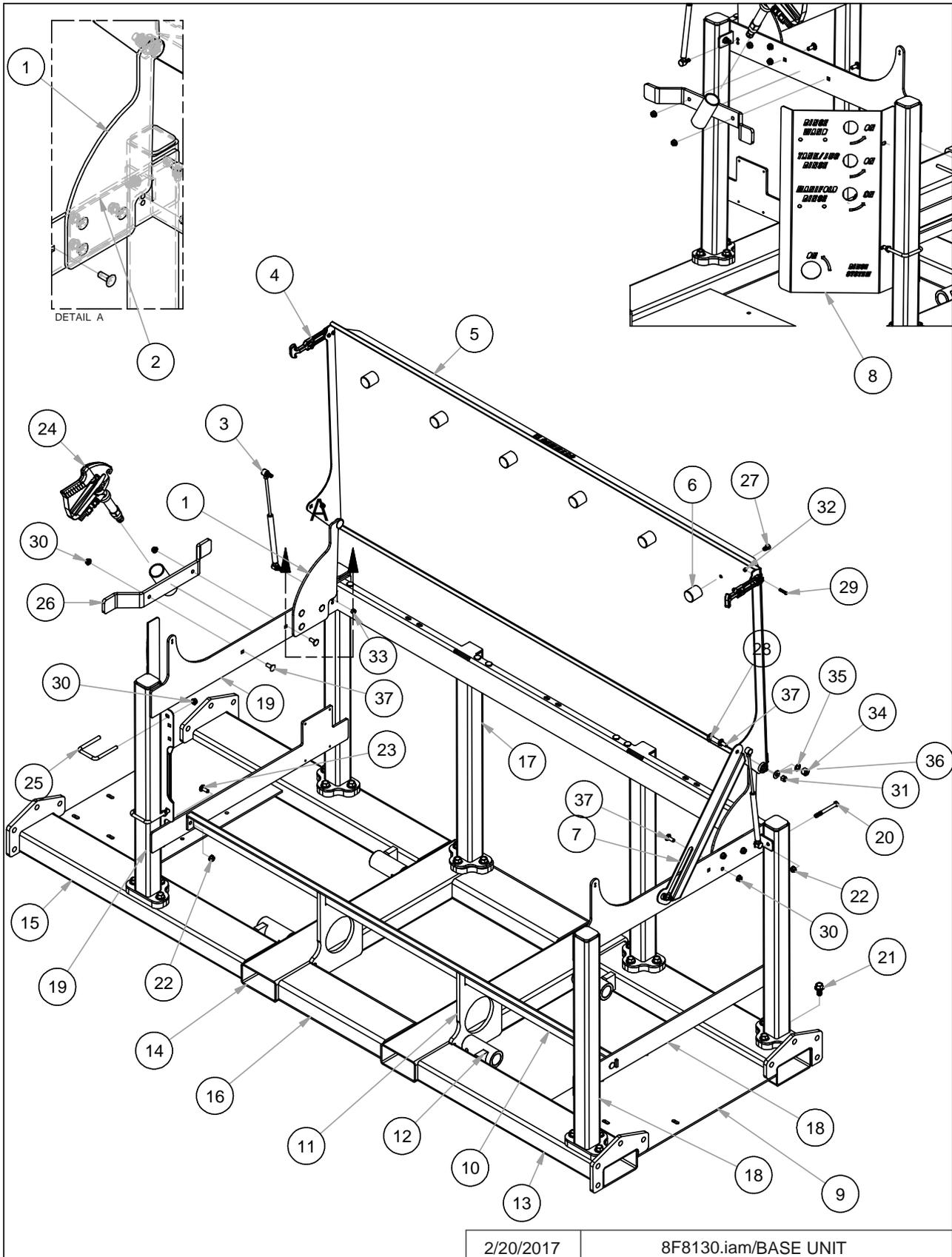


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**SFX1630 TANKS**

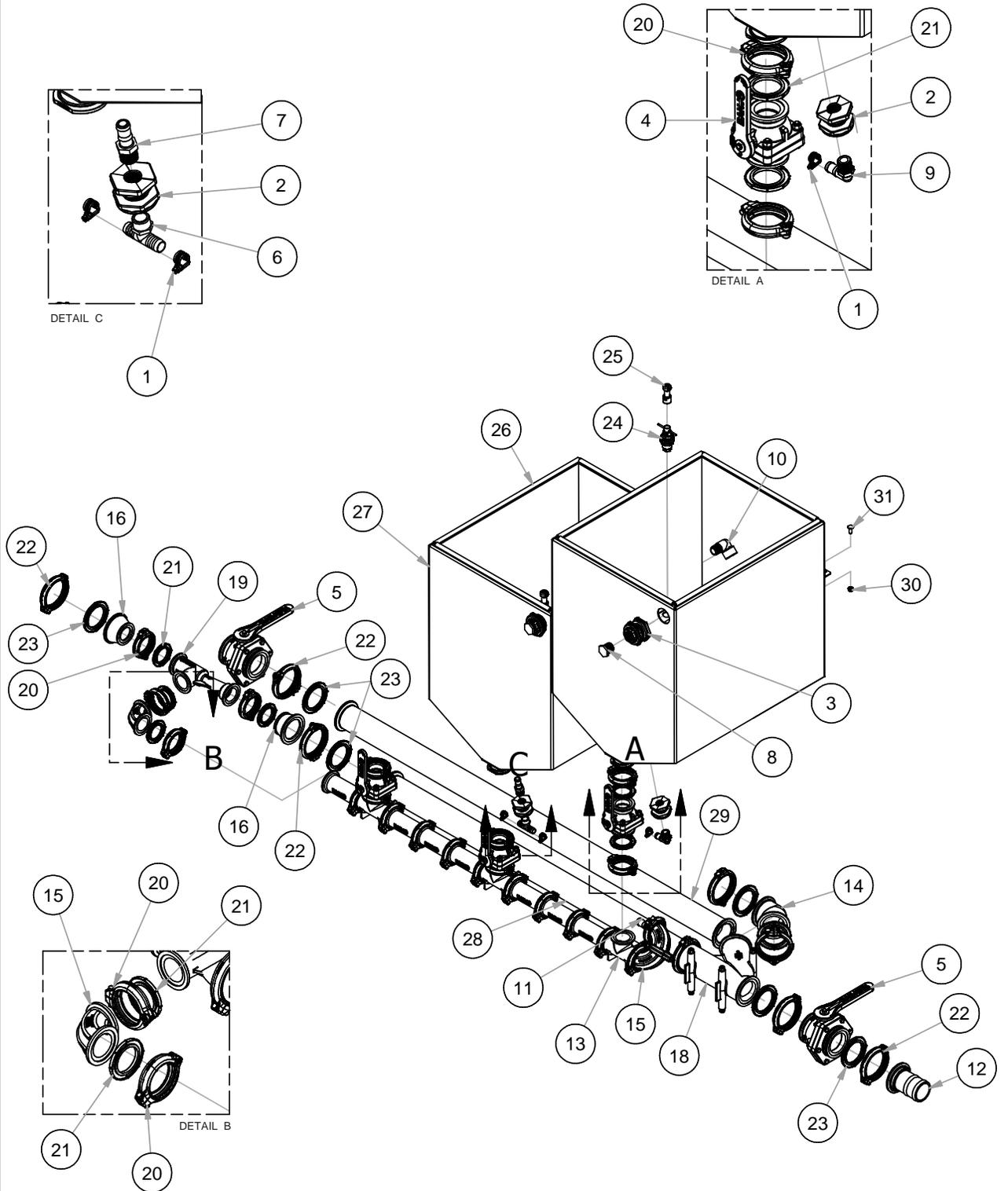
ITEM	PART NUMBER	DESCRIPTION
1	8A1007	CLAMP HOSE 3/4" #12
2	8A1400	BANJO 3/4" FITTING COMPLETE
3	8A1403	BANJO 1" FITTING COMPLETE
4	8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB
5	8A2013B	PLUG 1"
6	8A2015	ELBOW 3/4" HB X 3/4 MPT
7	8A2021	BARB HOSE 3/4" X 1/2 MPT
8	8A2032	STREET ELBOW 1"
9	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
10	8A2385	FLANGE GASKET 2" HYPRO
11	8A2508A	BOTTLE RINSE PLUNGER HYPRO
12	8A2508B	BOTTLE RINSE NOZZLE HYPRO
13	8A4008	HOSE 1/2" EPDM AG 200PSI BLACK
14	8F0420	SEAL RUBBER TRIM LOC 15-
15	8F6040	CHEMTANK SS 40GAL
16	8F6080	CHEMTANK SS 80GAL



**SFX2430 TANK BASE**

ITEM	PART NUMBER	DESCRIPTION
1	8F0100	HINGE SUPPORT
2	8F0102	HINGE PLATE
3	8F0414	GAS SPRING
4	8F0424	RUBBER LATCH STRAP
5	8F6006	LID 6-BANK SPRAY FILL
6	8F6100	RINSEBALL DEPRESSER SS304
7	8F6105	LOCKARM SPRAY FILL LID
8	8F6110	VALVE PANEL SPRAY FILL
9	7F0104	LOWER SHEET METAL BOLTPLATE
10	7F0108	FORMED ANGLE
11	7F0200	STIFFENER PLATE
12	7F0300	MOUNTING SUPPORT
13	7F1818	TUBE REC 6 X 3 X 3T
14	7F1820	REC TUBE 6 X 3 X 3T
15	7F1822	TUBE REC 6 X 3 X 3T
16	7F1920	TUBE REC 6 X 3 X 4T
17	8F8002	SPRAY FILL BACK
18	8F8004	SPRAY FILL SIDE RAILING LFT
19	8F8006	SPRAY FILL SIDE RAILING RGT
20	8X0016B	3/8 - 16 x 3.5" SS bolt
21	8X0060	1/2" - 13 FLANGED BOLT
22	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
23	8X1112	CRG 3/8-16NC X 1" SS
24	8F8714	WASH GUN GUNJET SHORT
25	8G8020	U-BOLT 3/8 X 2-9/16 X 3-1/2" SQ
26	8L3376	SPRAY FILL RINSE GUN HOLDER
27	8X0018	SS 3/8 X 16NC - 1/2" BOLT
28	8X0065	CRG 1/2-13NC X 2" GR5 ZDI
29	8X0161	SCREW SKT HD 10 X 24 X 1" SS
30	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
31	8X0202	NUT 3/8"-16NC NY-LOCK GR2 YZ
32	8X0207	NUT THIN 10 X 24 NY-LOCK SS
33	8X0212	NUT 5/16"-18NC NY-LOCK GR2 ZDI
34	8X0242	NUT 1/2"-13NC NY-LOCK GR2 YZ
35	8X0319	WASHER 17/32"IDX7/8ODX16GA ZDI
36	8X0320	WASHER 3/8" (7/16" ID)FLAT ZDI
37	8X1112	CRG 3/8-16NC X 1" SS

### 3 TANK PLUMBING



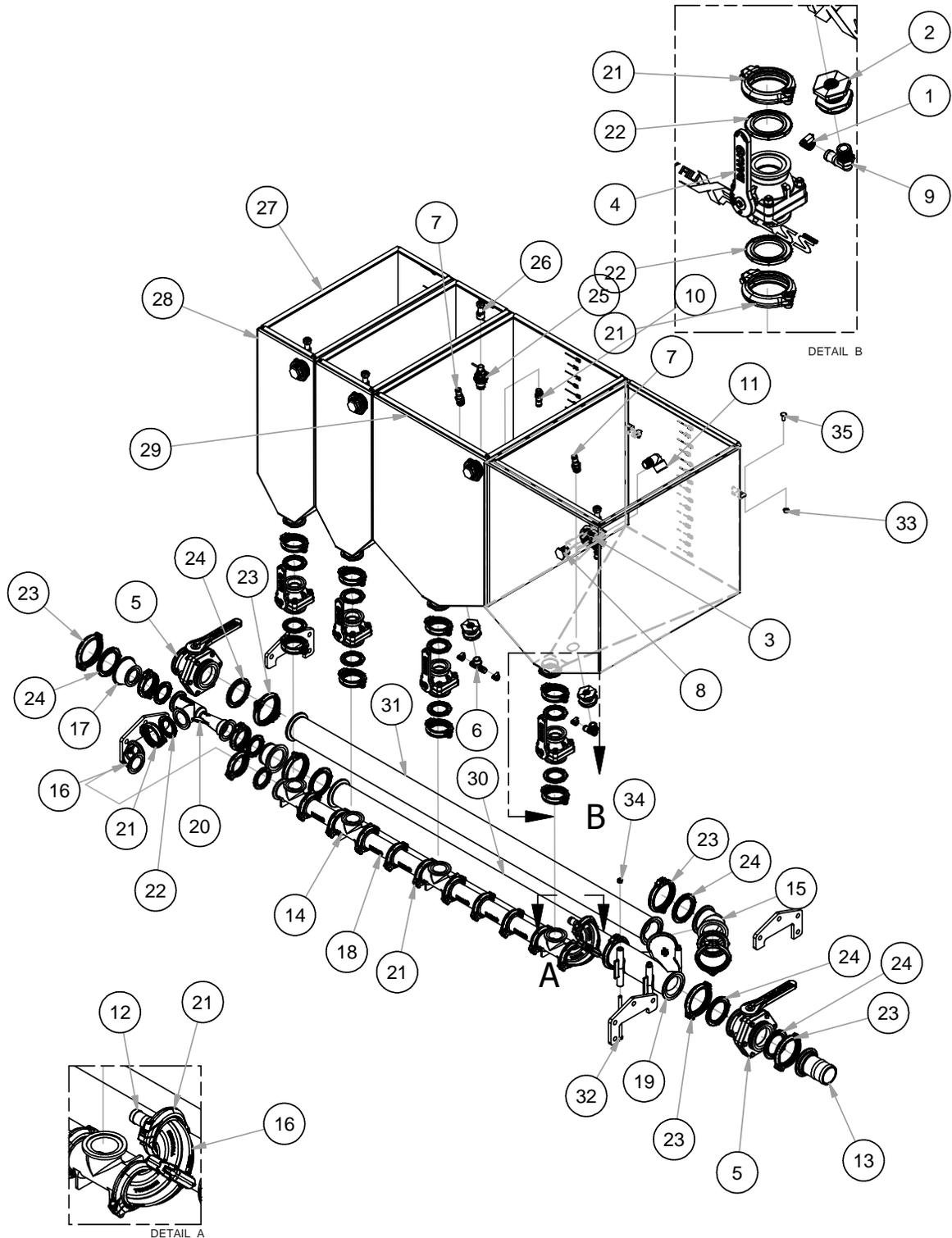
12/15/2015

8F8130.iam/3 COMPARTMENT PLUMBING

### SFX2430 3 TANK PLUMBING

ITEM	PART NUMBER	DESCRIPTION
1	8A1007	CLAMP HOSE 3/4" #12
2	8A1400	BANJO 3/4" FITTING COMPLETE
3	8A1403	BANJO 1" FITTING COMPLETE
4	8A1734	BALL VALVE 2" STUBBY
5	8A1742	BALL VALVE 3" STUBBY DBLFLNG
6	8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB
7	8A2007	BARB HOSE 3/4" X 3/4 MPT
8	8A2013B	PLUG 1"
9	8A2015	ELBOW 3/4" HB X 3/4 MPT
10	8A2032	STREET ELBOW 1"
11	8A2287	FLANGE M220 X 1" HB
12	8A2293	FLANGE M300 X 3" HB FULL PORT
13	8A2297	FLANGE TEE M220 FULL PORT
14	8A2317A	FLANGE ELBOW 45° M300
15	8A2319	2" FULL PORT SWEEP ELBOW
16	8A2328	FLANGE REDUCER M300 X M220
17	8A2338	2" X 6" FULL PORT COUPLING
18	8A2342	FLANGE 3" FP 45° Y
19	8A2345	FLANGE 2" FP POLY INDUCTOR
20	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
21	8A2385	FLANGE GASKET 2" HYPRO
22	8A2386	HYPRO UNIVERSAL FLANGE CLAMP
23	8A2387	FLANGE GASKET 3" HYPRO
24	8A2508A	BOTTLE RINSE PLUNGER HYPRO
25	8A2508B	BOTTLE RINSE NOZZLE HYPRO
26	8F0420	SEAL RUBBER TRIM LOC 15-
27	8F6080	CHEMTANK SS 80GAL
28	8F6156	FLANGEPIPE 3X56" SS304
29	8F6172	FLANGEPIPE 3X72.35" SS304
30	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
31	8X1112	CRG 3/8-16NC X 1" GR2 ZN

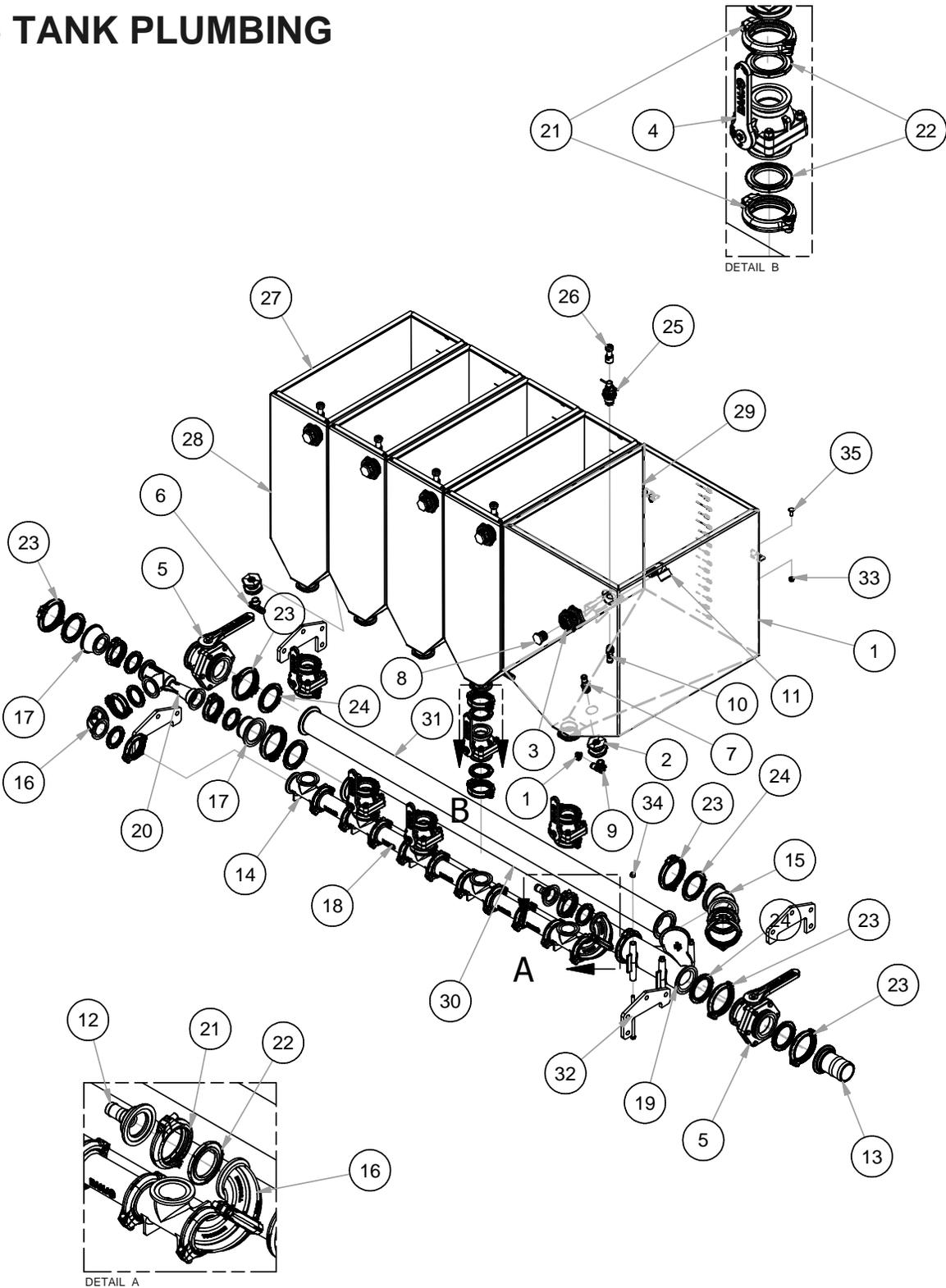
# 4 TANK PLUMBING



**SFX2430 4 TANK PLUMBING**

ITEM	PART NUMBER	DESCRIPTION
1	8A1007	CLAMP HOSE 3/4" #12
2	8A1400	BANJO 3/4" FITTING COMPLETE
3	8A1403	BANJO 1" FITTING COMPLETE
4	8A1734	BALL VALVE 2" STUBBY
5	8A1742	BALL VALVE 3" STUBBY DBLFLNG
6	8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB
7	8A2007	BARB HOSE 3/4" X 3/4 MPT
8	8A2013B	PLUG 1"
9	8A2015	ELBOW 3/4" HB X 3/4 MPT
10	8A2021	BARB HOSE 3/4" X 1/2 MPT
11	8A2032	STREET ELBOW 1"
12	8A2287	FLANGE M220 X 1" HB
13	8A2293	FLANGE M300 X 3" HB FULL PORT
14	8A2297	FLANGE TEE M220 FULL PORT
15	8A2317A	FLANGE ELBOW 45° M300
16	8A2319	2" FULL PORT SWEEP ELBOW
17	8A2328	FLANGE REDUCER M300 X M220
18	8A2338	2" X 6" FULL PORT COUPLING
19	8A2342	FLANGE 3" FP 45° Y
20	8A2345	FLANGE 2" FP POLY INDUCTOR
21	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
22	8A2385	FLANGE GASKET 2" HYPRO
23	8A2386	HYPRO UNIVERSAL FLANGE CLAMP
24	8A2387	FLANGE GASKET 3" HYPRO
25	8A2508A	BOTTLE RINSE PLUNGER HYPRO
26	8A2508B	BOTTLE RINSE NOZZLE HYPRO
27	8F0420	SEAL RUBBER TRIM LOK 15-
28	8F6040	CHEMTANK SS 40GAL
29	8F6080	CHEMTANK SS 80GAL
30	8F6156	FLANGEPIPE 3X56" SS304
31	8F6172	FLANGEPIPE 3X72.35" SS304
32	8X0046	BOLT 7/16-14NC X 7-1/4"GR5 ZDI
33	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
34	8X0234	NUT 7/16"-14NC NY-LOCK GR2 ZDI
35	8X1112	CRG 3/8-16NC X 1" SS

# 5 TANK PLUMBING



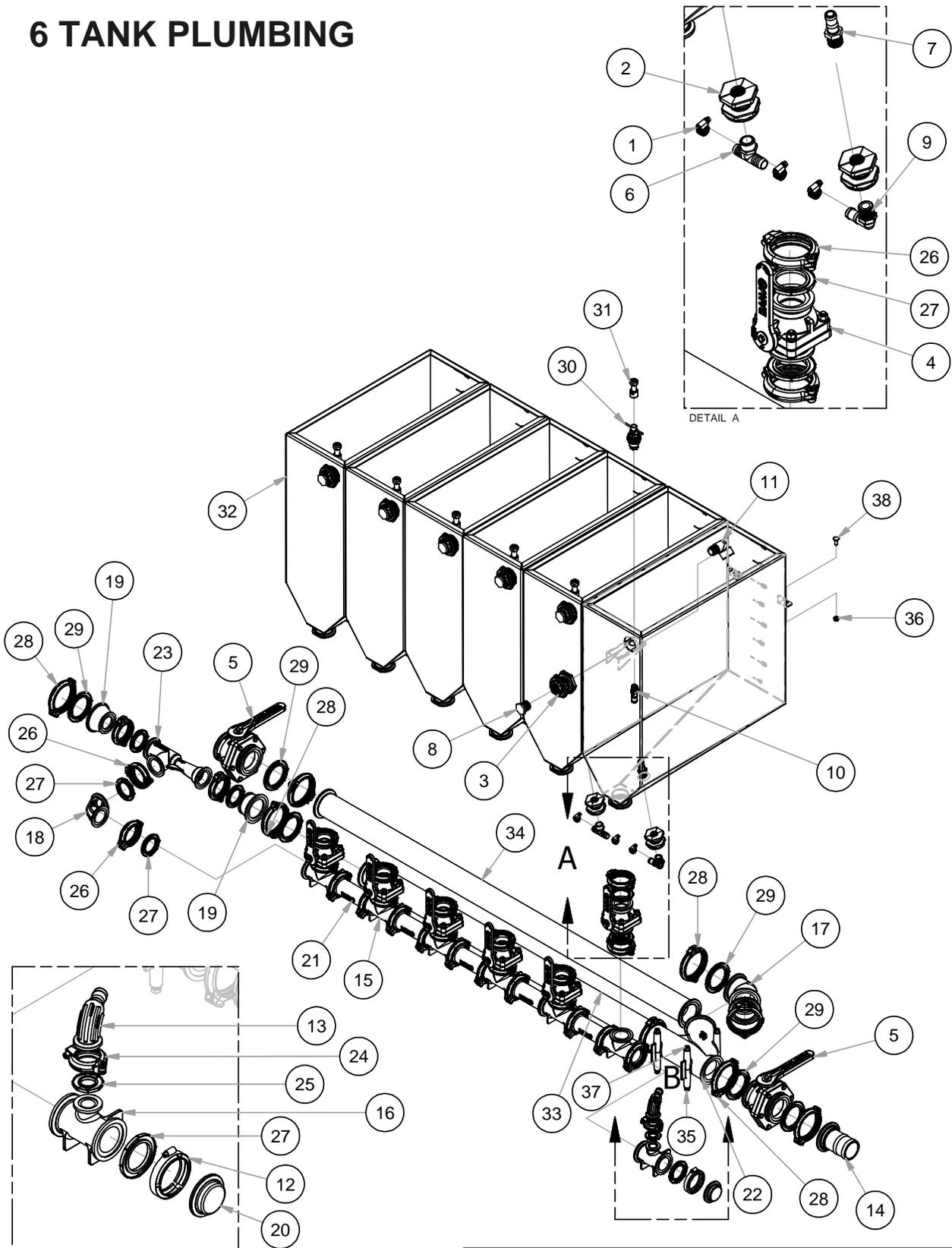
2/1/2016

8F8150.iam/5 TANK PLUMBING

**SFX2430 5 TANK PLUMBING**

ITEM	PART NUMBER	DESCRIPTION
1	8A1007	CLAMP HOSE 3/4" #12
2	8A1400	BANJO 3/4" FITTING COMPLETE
3	8A1403	BANJO 1" FITTING COMPLETE
4	8A1734	BALL VALVE 2" STUBBY
5	8A1742	BALL VALVE 3" STUBBY DBLFLNG
6	8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB
7	8A2007	BARB HOSE 3/4" X 3/4 MPT
8	8A2013B	PLUG 1"
9	8A2015	ELBOW 3/4" HB X 3/4 MPT
10	8A2021	BARB HOSE 3/4" X 1/2 MPT
11	8A2032	STREET ELBOW 1"
12	8A2287	FLANGE M220 X 1" HB
13	8A2293	FLANGE M300 X 3" HB FULL PORT
14	8A2297	FLANGE TEE M220 FULL PORT
15	8A2317A	FLANGE ELBOW 45° M300
16	8A2319	2" FULL PORT SWEEP ELBOW
17	8A2328	FLANGE REDUCER M300 X M220
18	8A2338	2" X 6" FULL PORT COUPLING
19	8A2342	FLANGE 3" FP 45° Y
20	8A2345	FLANGE 2" FP POLY INDUCTOR
21	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
22	8A2385	FLANGE GASKET 2" HYPRO
23	8A2386	HYPRO UNIVERSAL FLANGE CLAMP
24	8A2387	FLANGE GASKET 3" HYPRO
25	8A2508A	BOTTLE RINSE PLUNGER HYPRO
26	8A2508B	BOTTLE RINSE NOZZLE HYPRO
27	8F0420	SEAL RUBBER TRIM LOK 15-
28	8F6040	CHEMTANK SS 40GAL
29	8F6080	CHEMTANK SS 80GAL
30	8F6156	FLANGEPIPE 3X56" SS304
31	8F6172	FLANGEPIPE 3X72.35" SS304
32	8X0046	BOLT 7/16-14NC X 7-1/4"GR5 ZDI
33	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
34	8X0234	NUT 7/16"-14NC NY-LOCK GR2 ZDI
35	8X1112	CRG 3/8-16NC X 1" SS

# 6 TANK PLUMBING



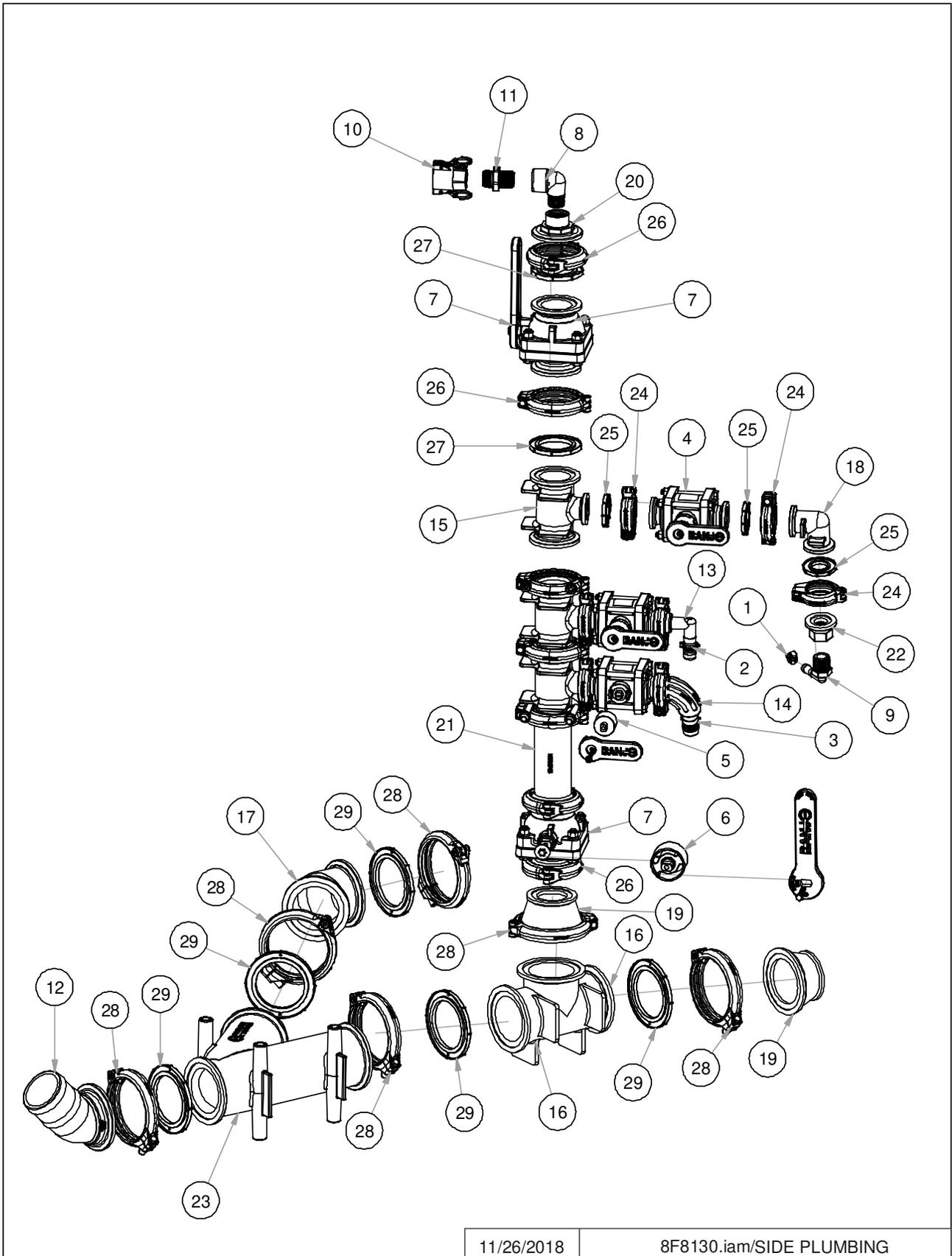
DETAIL B

1/18/2017

8F8160.iam/6 TANK PLUMBING

**SFX2430 6 TANK PLUMBING**

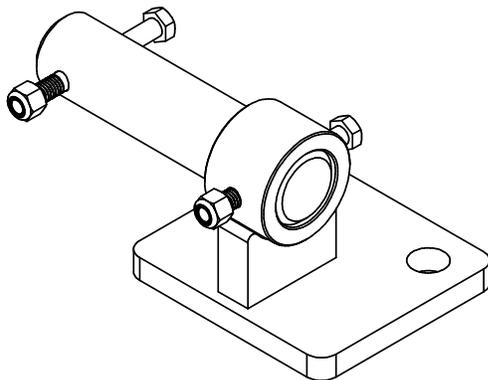
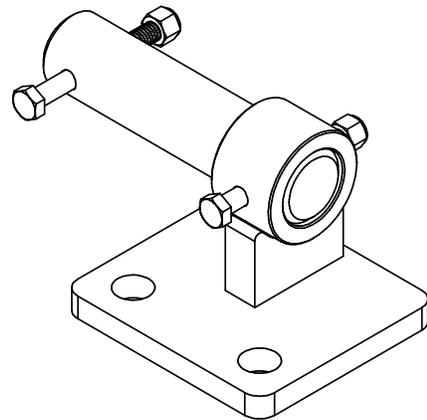
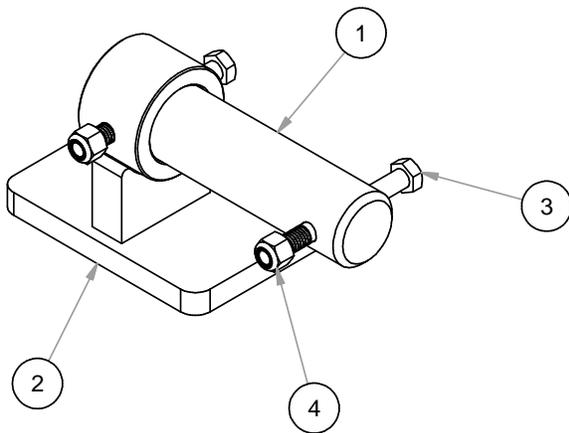
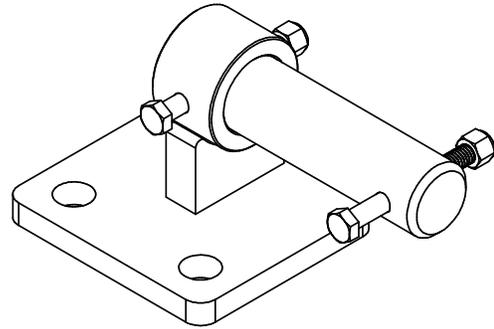
ITEM	PART NUMBER	DESCRIPTION
1	8A1007	CLAMP HOSE 3/4" #12
2	8A1400	BANJO 3/4" FITTING COMPLETE
3	8A1403	BANJO 1" FITTING COMPLETE
4	8A1734	BALL VALVE 2" STUBBY
5	8A1742	BALL VALVE 3" STUBBY DBLFLNG
6	8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB
7	8A2007	BARB HOSE 3/4" X 3/4 MPT
8	8A2013B	PLUG 1"
9	8A2015	ELBOW 3/4" HB X 3/4 MPT
10	8A2021	BARB HOSE 3/4" X 1/2 MPT
11	8A2032	STREET ELBOW 1"
12	8A2234	FLANGE CLAMP FC220 WORMSCRW 56
13	8A2251A	1" FLANGE SWEEP ELBOW 90 DEGREE
14	8A2293	FLANGE M300 X 3" HB FULL PORT
15	8A2297	FLANGE TEE M220 FULL PORT
16	8A2298	FLANGE TEE M220 X M220 X M100
17	8A2317A	FLANGE ELBOW 45° M300
18	8A2319	2" FULL PORT SWEEP ELBOW
19	8A2328	FLANGE REDUCER M300 X M220
20	8A2332	FLANGE PLUG M220 FULL PORT
21	8A2338	2" X 6" FULL PORT COUPLING
22	8A2342	FLANGE 3" FP 45° Y
23	8A2345	FLANGE 2" FP POLY INDUCTOR
24	8A2380	1" UNIVERSAL FLANGE CLAMP
25	8A2381	FLANGE GASKET 1" HYPRO
26	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
27	8A2385	FLANGE GASKET 2" HYPRO
28	8A2386	HYPRO UNIVERSAL FLANGE CLAMP
29	8A2387	FLANGE GASKET 3" HYPRO
30	8A2508A	BOTTLE RINSE PLUNGER HYPRO
31	8A2508B	BOTTLE RINSE NOZZLE HYPRO
32	8F6040	CHEMTANK SS 40GAL
33	8F6156	FLANGEPIPE 3X56" SS304
34	8F6172	FLANGEPIPE 3X72.35" SS304
35	8X0046	BOLT 7/16-14NC X 7-1/4"GR5 ZDI
36	8X0200	NUT 3/8"-16NC SERFLANG GR2 YZ
37	8X0234	NUT 7/16"-14NC NY-LOCK GR2 ZDI
38	8X1112	CRG 3/8-16NC X 1" SS



**SIDE PLUMBING**

ITEM	PART NUMBER	DESCRIPTION
1	8A1003	CLAMP HOSE 1/2" MINI
2	8A1007	CLAMP HOSE 3/4" #12
3	8A1009	CLAMP HOSE 1" #16
4	8A1253	1" FLANGED VALVE
5	8A1253A	HANDLE RISER
6	8A1254	BV HANDLE RISER 2X1.38" 15-
7	8A1734	BALL VALVE 2" STUBBY
8	8A2008	STREET ELBOW 3/4"
9	8A2108	ELBOW 1/2" HB X 3/4" MPT
10	8A2204	3/4" COUPLER X 3/4" GHFTHREAD
11	8A2212	3/4" MPT X 3/4" GHMTHREAD
12	8A2249	FLANGE ELBOW 45° M300 X 3" HB
13	8A2250	FLANGE ELBOW 90 M100 X 3/4" HB
14	8A2251A	1" FLANGE SWEEP ELBOW 90 DEGREE
15	8A2298	FLANGE TEE M220 X M220 X M100
16	8A2299	FLANGE TEE M300 FULL PORT
17	8A2317A	FLANGE ELBOW 45° M300
18	8A2318	FLANGE ELBOW 90 M100
19	8A2328	FLANGE REDUCER M300 X M220
20	8A2334	FLANGE PLUG M220 W/3/4" FPT
21	8A2338	2" X 6" FULL PORT COUPLING
22	8A2340	FLANGE M100 X 3/4" FPT
23	8A2342	FLANGE 3" FP 45° Y
24	8A2380	1" UNIVERSAL FANGE CLAMP
25	8A2381	FLANGE GASKET 1" HYPRO
26	8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP
27	8A2385	FLANGE GASKET 2" HYPRO
28	8A2386	HYPRO UNIVERSAL FLANGE CLAMP
29	8A2387	FLANGE GASKET 3" HYPRO

# MOUNTING PACKAGE

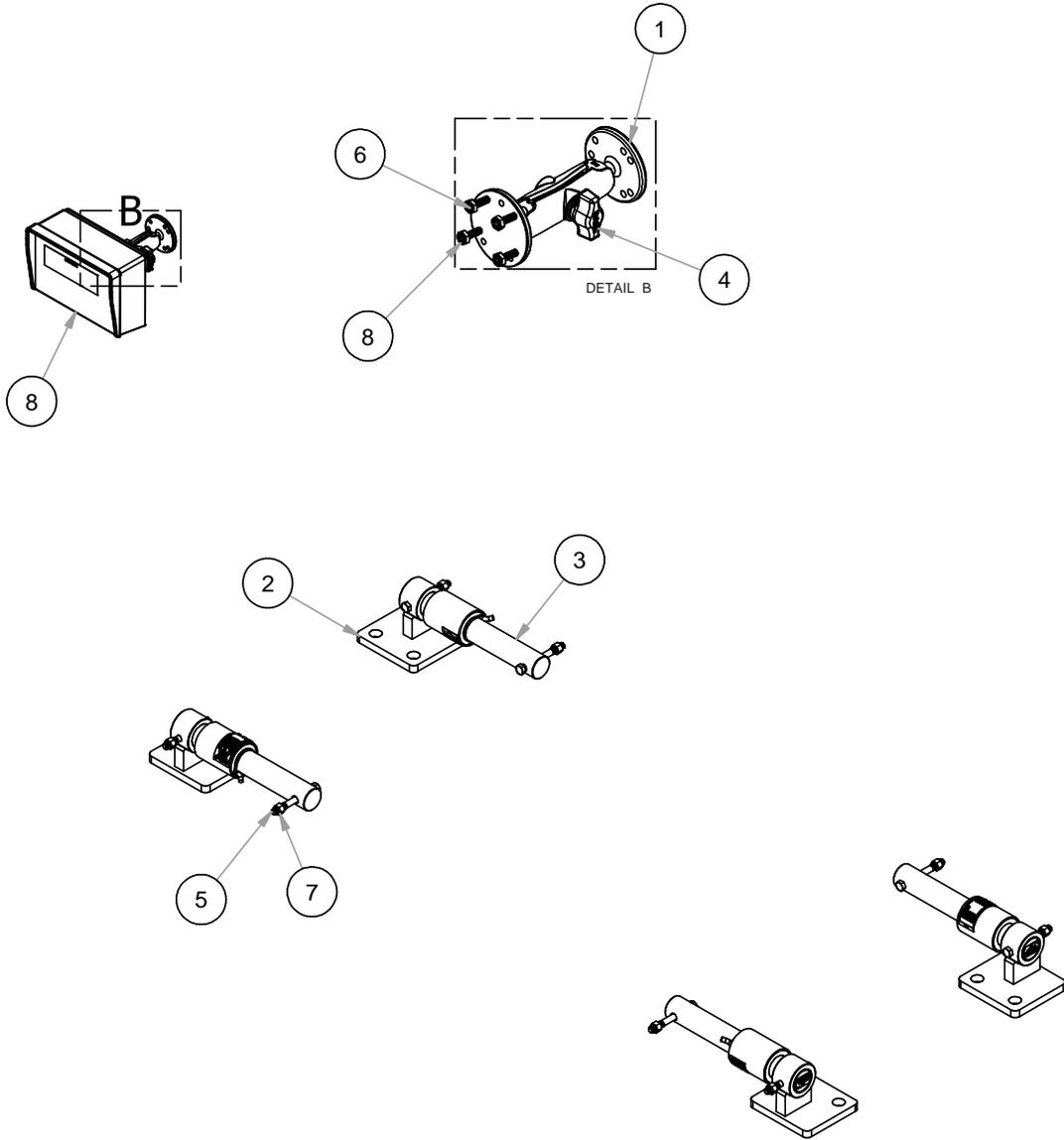


12/9/2015	8F6190.iam/MOUNTING PACKAGE
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**MOUNTING PACKAGE**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	8F0430	SPRAY FILL MOUNTING PIN PLTD
2	8F6180	WEIGHT SUPPORT BRACKET
3	8X0016A	3/8 - 16 x 3.5" SS bolt
4	8X0202	NUT 3/8"-16NC NY-LOCK GR2 YZ



12/17/2015 8F6210.iam/FAST FILL SCALE & MOUNTS

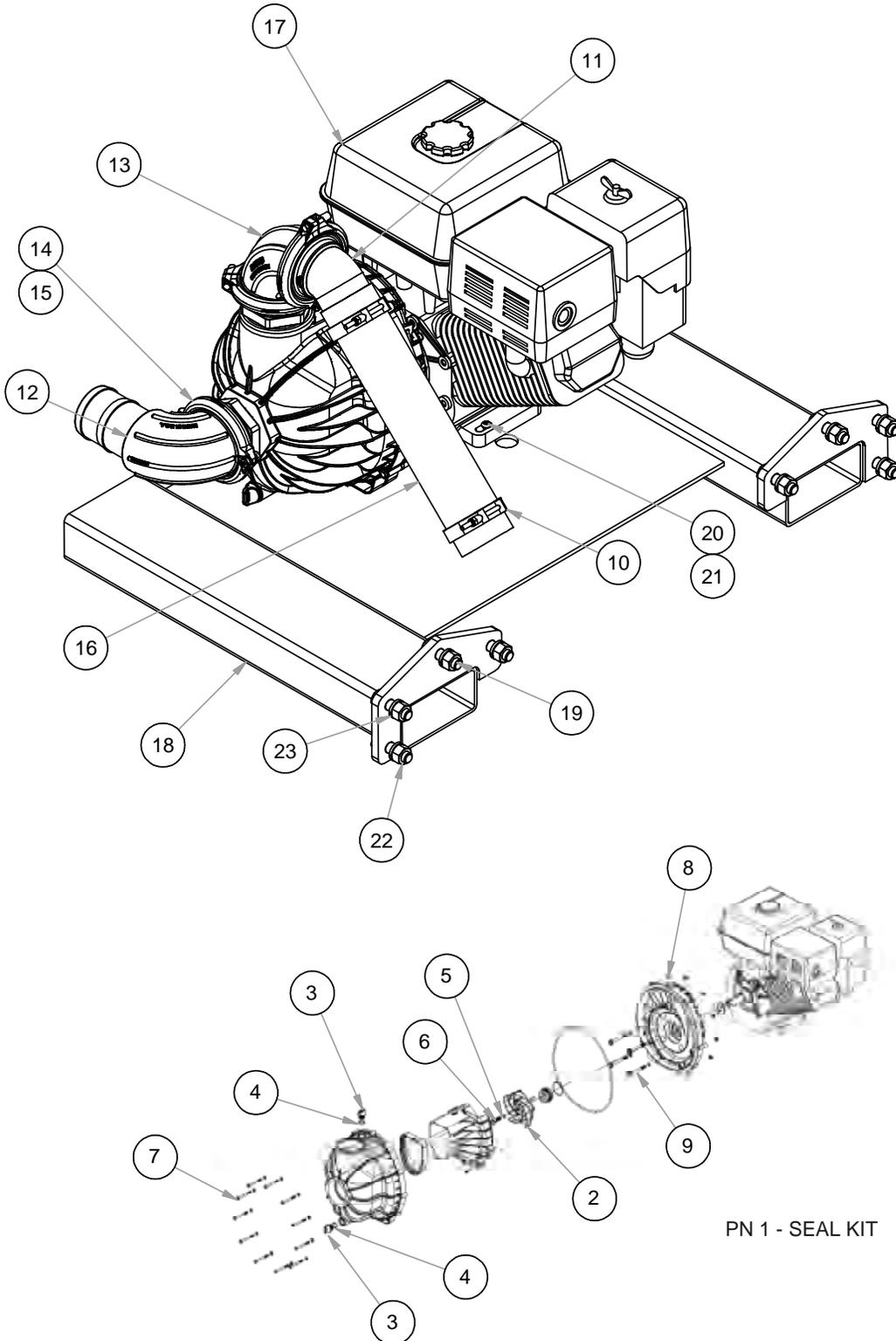
### SCALE & MOUNTING PACKAGE

ITEM	PART NUMBER	DESCRIPTION
1	8F0002	RAM BASE 2.5" W/1" BALL
2	8F6180	WEIGHT SUPPORT BRACKET
3	8F6200	EZ400 SCALE SYSTEM
4	8N0141	RAM MOUNT
5	8X0016A	3/8 - 16 x 3.5" SS bolt
6	8X0161	SCREW SKT HD 10 X 24 X 1" SS
7	8X0202	NUT 3/8"-16NC NY-LOCK GR2 YZ
8	8X0207	NUT THIN 10 X 24 NYLOCK SS

8A1840 FLOWMETER MINI-BULTK 1"



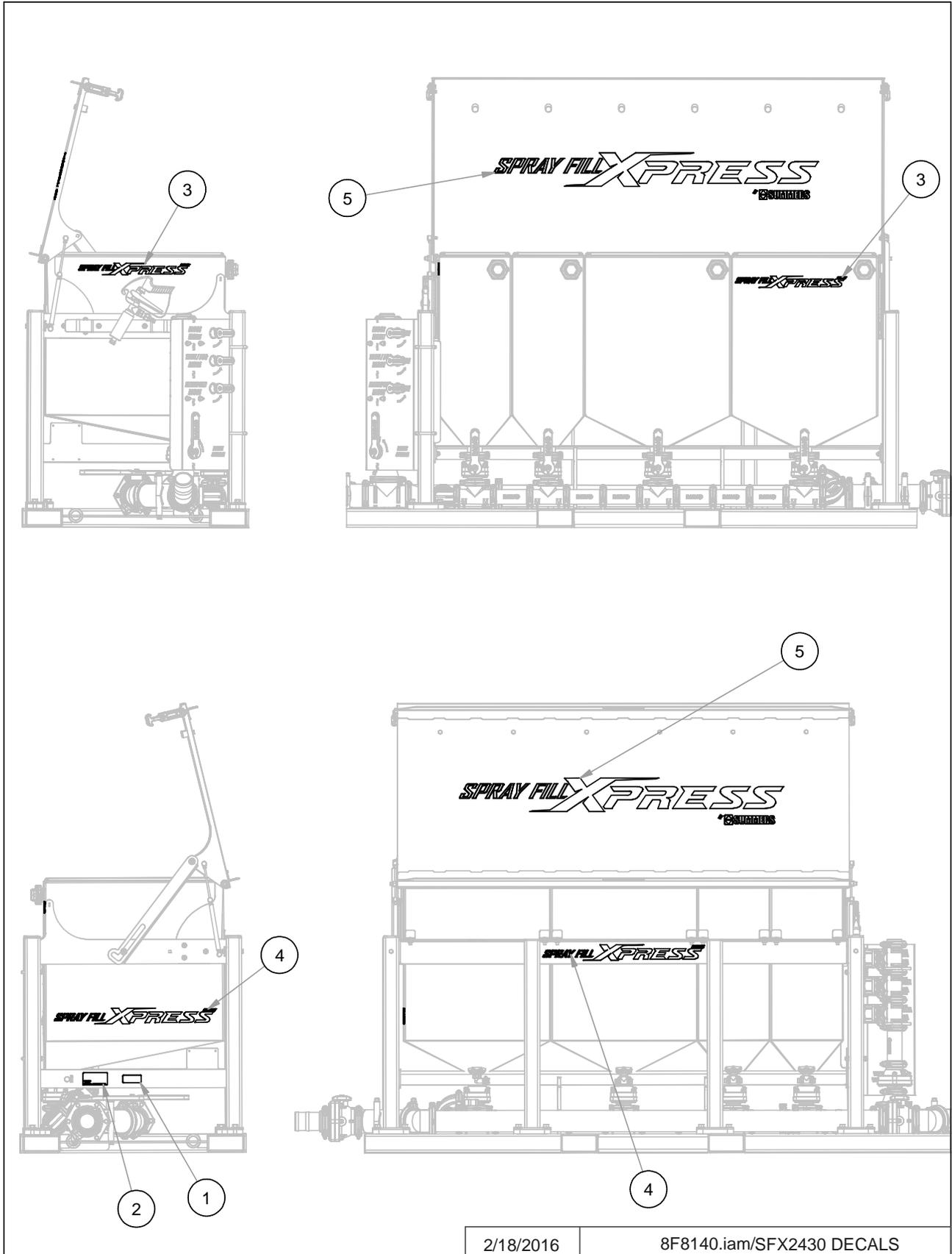
# 13 HP TRANSFER PUMP PACKAGE



7/28/2017 8F8020.iam/13HP TRANSFER ENGINE PKG 15-

**TRANSFER PUMP PACKAGE**

ITEM	PART NUMBER	DESCRIPTION
1	8A0970	SEAL KIT 3" POLY TRNS PMP
2	8A0971	IMPELLER 3" POLY TRNS PMP
3	8A0972	FILL/DRAIN PLUG 3" POLY TRNS PMP
4	8A0973	O-RING
5	8A0974	O-RING IMPELLER BOLT
6	8A0975	BOLT HEX FLNG IMPELLER
7	8A0976	BOLT PUMP HALF HX HD CP
8	8A0977	NUT HEX FLANGE
9	8A0978	BOLT PUMP TO ENGINE
10	8A1016	HEAVY DUTY 3" HOSE CLAMP
11	8A2249	FLANGE ELBOW 45 M300 X 3"HB
12	8A2261	M300BRBSWP90 FLING ELBOW 300BRB SWP 90 13-
13	8A2323	FLANGE SWEEP ELBOW 3" 90
14	8A2386	HYPRO 3" UNIVERSAL FLANGE CLAMP
15	8A2387	FLANGE GASKET 3" HYPRO
16	8A4036	HOSE 3" REINFORCED FERT X 1.25' 85PSI
17	8F5400	PUMP W/13HP ENGINE 3" TRANS
18	8F7900A	SKID ENGINE MOUNTING
19	8X0093	BOLT 5/8-11NC X 2" GR5 YZ
20	8X0168	SCRW TORXTAMPPRF5/16-18X2"ZDI
21	8X0212	NUT 5/16"-18NC NY-LOCK GR2 ZDI
22	8X0250	NUT 5/8"-11NC HEX GR2 YZ
23	8X0304	LOCKWASHER 5/8" YLW ZNC



2/18/2016

8F8140.iam/SFX2430 DECALS

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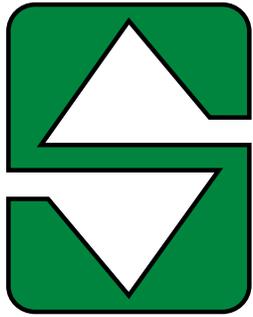
**DECALS**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	8Z0046	DECAL PATENT PENDING 1.25X3"
2	8Z0100	DECAL MADE IN USA
3	8Z2508 8Z2510	DECAL 18" SFX1630 DECAL 18" SFX2430
4	8Z2513 8Z2515	DECAL 26" SFX1630 DECAL 26" SFX2430
5	8Z2518 8Z2520	DECAL 36" SFX-SUMMERS DECAL 54" SFX-SUMMERS

7F0104	LOWER SHEET METAL BOLTPLATE	8A2508A	BOTTLE RINSE PLUNGER HYPRO
7F0108	FORMED ANGLE	8A2508B	BOTTLE RINSE NOZZLE HYPRO
7F0200	STIFFENER PLATE	8A4008	HOSE 1/2" EPDM AG 200PSI BLACK
7F0300	MOUNTING SUPPORT	8A4036	HOSE 3" REINFORCED FERT X 1.25"
7F1818	TUBE REC 6 X 3 X 3T	8F0002	RAM BASE 2.5" W/1" BALL
7F1820	REC TUBE 6 X 3 X 3T	8F0004	STAINLESS STEEL BOLT SPACER
7F1822	TUBE REC 6 X 3 X 3T	8F0100	HINGE SUPPORT
7F1920	TUBE REC 6 X 3 X 4T	8F0102	HINGE PLATE
8A0970	SEAL KIT 3" POLY TRNS PMP	8F0400	UHMW HINGE BUSHING
8A0971	IMPELLER 3" POLY TRNS PMP	8F0414	GAS SPRING
8A0972	FILL/DRAIN PLUG 3" POLY TRNS PMP	8F0420	SEAL RUBBER TRIM LOK 15-
8A0973	O-RING	8F0424	RUBBER LATCH STRAP
8A0974	O-RING IMPELLER BOLT	8F0430	SPRAY FILL MOUNTING PIN PLTD
8A0975	BOLT HEX FLNG IMPELLER	8F5400	PUMP W/13HP ENGINE 3" TRANS
8A0976	BOLT PUMP HALF HX HD CP	8F6004	LID 160 GALLON SPRAY FILL XPRESS
8A0977	NUT HEX FLANGE	8F6006	LID 6-BANK SPRAY FILL
8A0978	BOLT PUMP TO ENGINE	8F6040	CHEMTANK SS 40GAL
8A1003	CLAMP HOSE 1/2" MINI	8F6080	CHEMTANK SS 80GAL
8A1003	CLAMP HOSE 1/2" MINI	8F6100	RINSEBALL DEPRESSOR SS304
8A1007	CLAMP HOSE 3/4" #12	8F6105	LOCKARM SPRAY FILL LID
8A1009	CLAMP HOSE 1" #16	8F6110	VALVE PANEL SPRAY FILL
8A1016	HEAVY DUTY 3" HOSE CLAMP	8F6134	FLANGEPIPE 3 X 33.75" SS304
8A1253	1" FLANGED VALVE	8F6150	FLANGEPIPE 3 X 50.06" SS304
8A1253A	HANDLE RISER	8F6156	FLANGEPIPE 3X56" SS304
8A1254	BV HANDLE RISER 2X1.38" 15-	8F6172	FLANGEPIPE 3X72.35" SS304
8A1400	BANJO 3/4" FITTING COMPLETE	8F6180	WEIGHT SUPPORT BRACKET
8A1403	BANJO 1" FITTING COMPLETE	8F6200	EZ400 SCALE SYSTEM
8A1734	BALL VALVE 2" STUBBY	8F7900A	SKID ENGINE MOUNTING
8A1742	BALL VALVE 3" STUBBY DBLFLNG	8F8002	SPRAY FILL BACK
8A1840	FLOWMETER MINI-BULTK 1"	8F8004	SPRAY FILL SIDE RAILING LFT
8A2005G	TEE 3/4"MPT X 3/4"HB X 3/4"HB	8F8006	SPRAY FILL SIDE RAILING RGT
8A2007	BARB HOSE 3/4" X 3/4 MPT	8F8010	SPRAY FILL EXPRESS BASE
8A2008	STREET ELBOW 3/4"	8F8012	BACK SUPPORT 160 SF PTD 15-
8A2013B	PLUG 1"	8F8714	WASH GUN GUNJET SHORT
8A2015	ELBOW 3/4" HB X 3/4 MPT	8G8020	U-BOLT 3/8 X 2-9/16 X 3-1/2" SQ
8A2021	BARB HOSE 3/4" X 1/2 MPT	8L3376	SPRAY FILL RINSE GUN HOLDER
8A2032	STREET ELBOW 1"	8N0141	RAM MOUNT
8A2108	ELBOW 1/2" HB X 3/4 MPT	8S0295	U-BOLT 3/8 X 2-5/8 X 4-1/4"RND
8A2204	3/4"COUPLER X 3/4" GHFTHREAD	8X0016A	3/8 - 16 x 3.5" SS bolt
8A2212	3/4" MPT X 3/4" GHMTHREAD	8X0016B	3/8 - 16 x 3.5" SS bolt
8A2234	FLANGE CLAMP FC220 WORMSCRW 56	8X0018	SS 3/8 X 16NC - 1/2" BOLT
8A2235	FLANGE CLAMP FC300 WORM SCREW	8X0046	BOLT 7/16-14NC X 7-1/4"GR5 ZDI
8A2249	FLANGE ELBOW 45° M300 X 3" HB	8X0060	1/2" - 13 FLANGED BOLT
8A2250	FLANGE ELBOW 90 M100 X 3/4"HB	8X0065	CRG 1/2-13NC X 2" GR5 ZDI
8A2251A	1" FLANGE SWEEP ELBOW 90 DEGREE	8X0065	CRG 1/2-13NC X 2" GR5 ZDI
8A2261	M300BRBSWP90 FLING ELBOW 300BRB SWP 90 13-	8X0093	BOLT 5/8-11NC X 2" GR5 YZ
8A2287	FLANGE M220 X 1"HB	8X0161	SCREW SKT HD 10 X 24 X 1" SS
8A2293	FLANGE M300 X 3" HB FULL PORT	8X0168	SCRW TORXTAMPPRF5/16-18X2"ZDI
8A2297	FLANGE TEE M220 FULL PORT	8X0200	NUT 3/8"-16NC SERFLANG GR2 SS
8A2298	FLANGE TEE M220 X M220 X M100	8X0202	NUT 3/8"-16NC NY-LOCK GR2 YZ
8A2299	FLANGE TEE M300 FULL PORT	8X0207	NUT THIN 10 X 24 NYLOCK SS
8A2317A	FLANGE ELBOW 45° M300	8X0212	NUT 5/16"-18NC NY-LOCK GR2 ZDI
8A2318	FLANGE ELBOW 90 M100	8X0234	NUT 7/16"-14NC NY-LOCK GR2 ZDI
8A2319	2" FULL PORT SWEEP ELBOW	8X0242	NUT 1/2"-13NC NY-LOCK GR2 YZ
8A2323	FLANGE SWEEP ELBOW 3" 90	8X0250	NUT 5/8"-11NC HEX GR2 YZ
8A2328	FLANGE REDUCER M300 X M220	8X0304	LOCKWASHER 5/8" YLW ZNC
8A2332	FLANGE PLUG M220 FULL PORT	8X0319	WASHER 17/32"IDX7/8ODX16GA ZDI
8A2334	FLANGE PLUG M220 W/3/4" FPT	8X0320	WASHER 3/8" (7/16" ID)FLAT ZDI
8A2338	2" X 6" FULL PORT COUPLING	8X1112	CRG 3/8-16NC X 1" SS
8A2340	FLANGE M100 X 3/4" FPT	8X1113	CRG 3/8-16NC X 1.5" SS
8A2342	FLANGE 3" FP 45° Y	8Z0046	DECAL PATENT PENDING 1.25X3"
8A2345	FLANGE 2" FP POLY INDUCTOR	8Z0100	DECAL MADE IN USA
8A2380	1" UNIVERSAL FLANGE CLAMP	8Z2508	DECAL 18" SFX1630
8A2381	FLANGE GASKET 1" HYPRO	8Z2510	DECAL 18" SFX2430
8A2384	HYPRO 2" UNIVERSAL FLANGE CLAMP	8Z2513	DECAL 26" SFX1630
8A2385	FLANGE GASKET 2" HYPRO	8Z2515	DECAL 26" SFX2430
8A2386	HYPRO 3" UNIVERSAL FLANGE CLAMP	8Z2518	DECAL 36" SFX-SUMMERS
8A2387	FLANGE GASKET 3" HYPRO	8Z2520	DECAL 54" SFX-SUMMERS

# History of Summers Manufacturing Co., Inc.

- 1965 – Summers Manufacturing is founded by Harley Summers, who purchases patent rights for Goebel truck and pickup hoists from the Goebel Brothers of Lehr, ND. These hoists, produced in Harley Summers' blacksmith shop the first year, were distributed nationwide by a Cincinnati, Ohio, dealer. With increasing sales, the company soon outgrows the small shop. Summers wins the Herman harrow contract, beginning the company's Herman culti-harrow line. Summers builds a 7,200 square-foot factory in Maddock to meet the demand for truck and pickup hoists, as well as Herman harrows.
- 1969 – Firm incorporates and becomes officially known as Summers Manufacturing Company, Inc.
- 1970 – Summers purchases rights to manufacture/market the Herman Harrow.
- 1973 – Company builds new 20,000 square-foot plant and offices in Maddock, adding a 20,000 square-foot assembly plant in the fall of 1975 (completed in January 1976), bringing total square footage of Maddock factories to 47,000.
- 1977 – Summers introduces the Agri-sprayer, used in conjunction with the Herman culti-harrow to incorporate herbicides and liquid fertilizer.
- 1980 – Company purchases manufacturing and distributing rights to Crown rockpickers from Crown Manufacturers of Regina, Saskatchewan. This forces another expansion project – a 26,000 square foot factory on a 24 acre site in Devils Lake, ND Industrial Park.
- 1981 – Company establishes a branch facility in Regina, Saskatchewan.
- 1982 – Devils Lake plant begins operations in January, manufacturing supersprayers and rockpickers. The Maddock factory begins producing the Superweeder, a combination cultivator and harrow.
- 1983 – Summers buys manufacturing and distributing rights to the Fargo Field Sprayer line from Mid America Steel (formerly Fargo Foundry), Fargo. This field sprayer line is manufactured at the Devils Lake plant. Harley Summers is selected North Dakota's small-businessman of the year by the Small Business Administration.
- 1984 – Herman Diamond Disk, a disk harrow made in a diamond shape to reduce blade breakage from rocks, comes off the assembly line.
- 1985 – Summers signs a contract with Melroe Company of Bismarck to obtain exclusive manufacturing rights to the Melroe harrow line.
- 1989 – Summers purchases TorMaster Company of Hordean, Manitoba, giving the company a line of rolling packer equipment, comprised of harrow packers and hydraulic fold coil packers.
- 1992 – A new engineering office/parts department is added to the Devils Lake factory.
- 1993 – Company adds two new products: a pickup-mounted sprayer with booms of 80 and 90 feet, and the Summers Superharrow, an extra-heavy-duty residue-management tool designed for the minimum and no-till farmer.
- 1994 – a 50 by 125 foot addition to the Maddock factory is completed. Construction begins on a 24,576 square-foot addition to the Devils Lake factory, which enables the company to increase production of truck-mounted and pull-type supersprayers and rockpickers.
- 1996 – 1500 square foot office area added to the Maddock plant. Company introduces Chisel Plow with floating hitch and 700# trip assembly. Introduced 2-point sprayer.
- 1997 – 16,800 square foot warehouse in Maddock purchased from local business.
- 1999 - Company introduces the Ultimate suspended boom trailer sprayer with hydraulic folding booms. Additional sizes added to the Chisel Plow line, now ranging from 28' to 54'.
- 2000 - Company introduces the Supercouler, the innovative solution for excessive field residue management on no-till, minimum-till, and conventional-till farming operations.
- 2001 - Cold storage building completed at Devils Lake. Company extends boom lengths up to 110 feet on the Ultimate Supersprayer.
- 2002 - Company adds a warehouse and service man in Aberdeen, SD.
- 2003 - Company introduces the Ultimate NT Supersprayer featuring a bolt on axle for easier adjustment, and a new family of tanks that feature a drainable sump and a common width dimension.
- 2004 - A 124 ft. x 310 ft. addition is added onto the current Devils Lake plant.
- 2005 - The Summers Superroller is added to the "Field Tested Tough" product line. Additional sizes of 56', 58' and 60' are added to the Superchisel line. Ultimate-Ultra NT Supersprayer introduced featuring 120' & 133' booms.
- 2006 - The Summers Coulter-Chisel, Rolling Choppers and 30' Superroller were included in product line.
- 2007 - 62' & 84' 5 Section Landrollers and a 20' Coulter-Chisel were introduced.
- 2008 - Disk-Chisels, ranging from 16' to 40' widths, are added to product line.
- 2009 – M105 and M108 Mounted Harrows added to selection of Mounted Attachments. SuperHarrow 2650, 50' SuperCoulter, Hydraulic Fold Rolling Chopper and 36" diameter Landrollers introduced.
- 2010 – Rolling Basket and 47' Diamond Disk added to product line. A 124 ft. x 310 ft. addition to Devils Lake factory built for a state of the art paint system.
- 2011 – Additional Supercouler sizes were added along with larger tires for tillage implements. Ultimate and Ultra Supersprayers received an additional tank size of 1650 gallons. Front Caster Wheel option was made available for chisel implements.
- 2012 – 41', 46' & 53' Trail Type Landroller added to product line. Additional Superchisel sizes of 16' & 20' were added.
- 2013 – DT9530 added to product line. Internal Scraper in Rolling Baskets introduced. Finishing Coulter Gang becomes standard on the Diamond Disk and 2510 DT. Corporate offices opened at Devils Lake plant. New building and location for the Aberdeen warehouse.
- 2014 – Introduced the VRT2530 (Variable Rate Tillage).
- 2015 – Introduced the VT Flex Applicator and Spray Fill Xpress.
- 2016 – Introduced the 8-Bar Superharrow.
- 2018 – Introduced the VRT Renegade.
- Summers distributes on a wholesale level to dealers and distributors throughout markets in North Dakota, South Dakota, Minnesota, Montana, Iowa, Washington, Idaho, Oregon, Utah, Colorado, Kansas, Nebraska, Oklahoma, Texas, Manitoba, Saskatchewan, Alberta, British Columbia, Kazakhstan, Russia and Australia, making it an international company.



# **SUMMERS<sup>®</sup>**

*... Field Tested TOUGH!*



**Tillage**



**Rock Picker**



**Land Rollers/Packers**



**Cultivators/Harrows**



**Mounted Attachments**



**Sprayers**



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