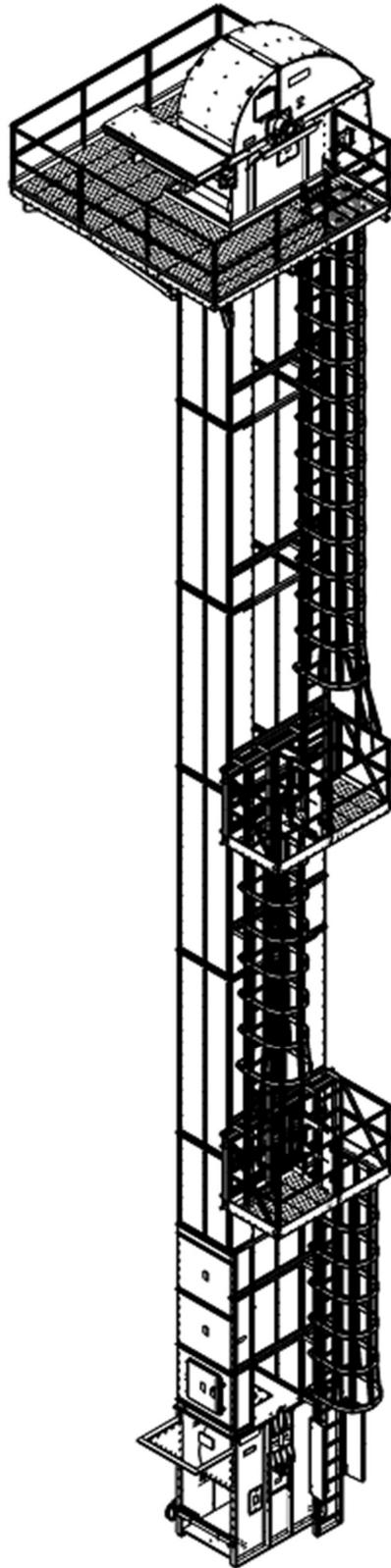


CBE42-20 LADDER & PLATFORMS



INSTALLATION MANUAL

P/N 161580

CHIEF 

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Manual Revisions

- 01-21-2026
 - Initial Release

STANDARD LIMITED WARRANTY

Material Handling Product

1. **Definitions.** The following terms, when they appear in the body of this Standard Limited Warranty for Material Handling Products in initial capital letters shall have the meaning set forth below:
 - A. Accepted Purchase Order shall mean the Purchase Order identified below.
 - B. Chief shall mean Chief Agri, a division of Chief Industries, Inc.
 - C. Original Owner shall mean the original owner identified below.
 - D. Product shall mean the Agri Equipment as described in the Accepted Purchase Order.
 - E. Reseller shall mean the authorized Chief Agri dealer identified below.

2. **Limited Product Warranty.** Upon and subject to the terms and conditions set forth below, Chief hereby warrants to the Reseller, and, if different, the Original Owner as follows:
 - A. All new Products delivered to the Reseller or the Original Owner by Chief pursuant to the Accepted Purchase Order will, when delivered, conform to the specifications set forth in the Accepted Purchase Order;
 - B. All new Products delivered pursuant to the Accepted Purchase Order will, in normal use and service, be free from defects in materials or workmanship; and
 - C. Upon delivery, Chief will convey good and marketable title to the Products, free and clear of any liens or encumbrances except for, where applicable, a purchase money security interest in favor of Chief.

3. **Duration of Warranty and Notice Requirements.** Subject to the **Exceptions, Exclusions and Limitations** set forth below, the warranties set forth in Section 2 above shall apply to all covered non-conforming conditions that are discovered within the first twenty-four (24) months following delivery of the Product to the carrier designated by the Reseller and/or the Original Owner at Chief's manufacturing facility in Kearney, Nebraska (the "Warranty Period") and are reported to the Chief as provided in Section 4 below within thirty (30) days following discovery (a "Notice Period").

4. **Notice Procedure.** In order to make a valid warranty claim, the Reseller and/or the Original Owner must provide Chief with a written notice of any nonconforming condition discovered during the Warranty Period within the applicable Notice Period specified in Section 3 above. Said notice must be in writing; be addressed to Chief Industries, Inc., Agri, Customer Service Department, P.O. Box 848, Kearney, NE 68848; and contain the following information: (a) the Customer's name and address; (b) the Reseller's name and address; (c) the make and model of the Product in question; (d) the current location of the Product; (e) a brief description of the problem with respect to which warranty coverage is claimed; and (f) the date on which the Product was purchased.

5. **Exceptions and Exclusions.** Anything herein to the contrary notwithstanding, the warranties set forth in Section 2 above do **not** cover any of the following, each of which are hereby expressly excluded:
 - A. Defects that are not discovered during the applicable Warranty Period;
 - B. Defects that are not reported to the Chief Agri/ Customer Service Department in conformity with the notice procedure set forth in Section 4 above within the applicable Notice Period specified in Section 3;
 - C. Any used or pre-owned Products;
 - D. Any Chief manufactured parts that are not furnished as a part of the Accepted Purchase Order;

- E. Any fixtures, equipment, materials, supplies, accessories, parts or components that have been furnished by Chief but are manufactured by a third party;
- F. Any Products which have been removed from the location at which they were originally installed;
- G. Any defect, loss, damage, cost or expense incurred by the Reseller or the Original Owner to the extent the same arise out of, relate to or result, in whole or in part, from any one or more of the following:
 - (i) Usual and customary deterioration, wear or tear resulting from normal use, service and exposure;
 - (ii) Theft, vandalism, accident, war, insurrection, fire or other casualty;
 - (iii) Any damage, shortages or missing parts which result during shipping or are otherwise caused by the Reseller, the Original Owner and/or any third party;
 - (iv) Exposure to marine environments, including frequent or sustained salt or fresh water spray;
 - (v) Exposure to corrosive, chemical, ash, smoke, fumes, or the like generated or released either within or outside of the structure on which the Product is installed, regardless of whether or not such facilities are owned or operated by the Reseller, the Original Owner or an unrelated third party;
 - (vi) Exposure to or contact with animals, animal waste and/or decomposition;
 - (vii) The effect or influence the Product may have on surrounding structures, including, without limitation, any loss, damage or expense caused by drifting snow;
 - (viii) Any Product or portion thereof that has been altered, modified or repaired by the Reseller, the Original Owner or any third party without Chief's prior written consent;
 - (ix) Any Product or portion thereof that has been attached to any adjacent structure without Chief's prior written approval;
 - (x) Any Product to which any fixtures, equipment, accessories, materials, parts or components which were not provided as a part of the original Accepted Purchase Order have been attached without Chief's prior written approval;
 - (xi) The failure on the part of the Reseller, the Original Owner or its or their third party contractors to satisfy the requirements of all applicable statutes, laws, ordinances rules, regulations and codes, (including zoning laws and/or building codes);
 - (xii) The use of the Product for any purpose other than the purpose for which it was designed; and/or
 - (xiii) The failure of the Reseller, the Original Owner and/or any third party to:
 - (a) properly handle, transport and/or store the Product or any component part thereof;
 - (b) properly select and prepare a site that is adequate for the installation and/or operation of the Product or any component part thereof;
 - (c) properly design and construct a foundation that is adequate for the installation and/or operation of the Product or any component part thereof;
 - (d) properly set up, erect, construct or install the Product and/or any component part thereof; and/or
 - (e) properly operate, use, service and/or maintain the Product and each component part thereof.

6. **Resolution of Warranty Claims.** In the event any nonconforming condition is discovered within the Warranty Period and Chief is notified of a warranty claim as required by Section 4 prior to the end of the applicable Notice Period set forth in Section 3 above, Chief shall, with the full cooperation of the Reseller and the Original Owner, immediately undertake an investigation of such claim. To the extent Chief shall determine, in its reasonable discretion, that the warranty claim is covered by the foregoing Limited Product Warranty, the following shall apply:

- A. Warranty Claims With Respect to Covered Non-Conforming Conditions Discovered Within the First Three Hundred Sixty Five (365) Days and Reported to Chief Within Thirty (30) Days of Discovery. In the case of a warranty claim which relates to a covered non-conforming condition that is discovered during the first three hundred sixty five (365) days of the Warranty Period and is reported to Chief as required by Section 4 within thirty (30) days of discovery as required by Section 3, Chief will, as Chief's sole and exclusive obligation to the Reseller and the Original Owner, and as their sole and exclusive remedy, work in cooperation with the Reseller and the Original Owner to correct such non-conforming condition, and in connection therewith, Chief will ship any required replacement parts to the "ship to address" set forth in the Accepted Purchase Order FOB Chief's facilities in Kearney, Nebraska, and will either provide the labor or reimburse the Reseller or the Original Owner, as may be appropriate in the circumstances, for any out of pocket expense the Original Owner may reasonably and necessarily incur for the labor that is required to correct such non-conforming condition, provided that if work is to be performed by the Reseller or a third party contractor, Chief may require at least two competitive bids to perform the labor required to repair or correct the defect and reserves the right to reject all bids and obtain additional bids. Upon acceptance of a bid by Chief, Chief will authorize the necessary repairs.
- B. All Other Warranty Claims. Except as is otherwise provided in subsection 6A above, in the case of all other warranty claims which relate to covered non-conforming conditions that are discovered during the Warranty Period and are reported to Chief as required by Section 4 within thirty (30) days following discovery, Chief will, as Chief's sole and exclusive obligation to the Reseller and the Original Owner, and as the Reseller's and the Original Owner's sole and exclusive remedy, ship any required replacement parts to the Original Owner at the "ship to address" specified in the Accepted Purchase Order FOB Chief's facilities in Kearney, Nebraska; and **in such event, Chief shall have no responsibility or liability to either the Reseller or the Original Owner for the cost of any labor required to repair or correct the defect.**
7. Warranty Not Transferable. This Warranty applies only to the Reseller and the Original Owner and is **not transferable**. As such, this Warranty does **not** cover any Product that is sold or otherwise transferred to any third party following its delivery to the Original Owner.
8. Limitation on Warranties, Liabilities and Damages. The Reseller and the Original Owner expressly agree that the allocation of the risk, liability, loss, damage, cost and expense arising from any Product that does not conform to the limited warranty given in Section 2 above are fair and reasonable and acknowledge that such allocation was expressly negotiated by the parties and was reflected in the Purchase Price of the Product. Accordingly the Reseller and the Original Owner expressly agree as follows:
- A. Disclaimer of Implied Warranties. **EXCEPT AS IS OTHERWISE EXPRESSLY SET FORTH HEREIN, CHIEF MAKES NO OTHER REPRESENTATIONS OR WARRANTIES OF ANY KIND WHATSOEVER, WHETHER EXPRESS OR IMPLIED, BY OPERATION OF LAW, COURSE OF DEALING OR OTHERWISE WITH RESPECT TO THE PRODUCT, ANY COMPONENT PART THEREOF OR ANY OTHER GOODS OR SERVICES THAT CHIEF MANUFACTURES, FABRICATES, PRODUCES, SELLS OR PROVIDES TO THE DEALER OR THE ORIGINAL OWNER PURSUANT TO THE TERMS OF ANY ACCEPTED PURCHASE ORDER, INCLUDING WITHOUT LIMITATION ANY REPRESENTATION OR WARRANTY WITH RESPECT TO DESIGN, CONDITION, MERCHANTABILITY OR FITNESS OF THE PRODUCT OR ANY OTHER GOODS OR SERVICES FOR ANY PARTICULAR PURPOSE OR USE.**
- B. Limitation on Liability. **EXCEPT AS IS OTHERWISE EXPRESSLY SET FORTH**

IN SECTION 6 ABOVE, CHIEF'S LIABILITY TO THE DEALER AND/OR THE ORIGINAL OWNER WITH RESPECT TO ANY DEFECTS IN ANY PRODUCTS OR FOR ANY OTHER GOODS OR SERVICES WHICH DO NOT CONFORM TO THE WARRANTIES SET FORTH ABOVE SHALL NOT, IN ANY EVENT, EXCEED THE ACTUAL COST OF SUCH NON-CONFORMING PRODUCT, GOODS OR SERVICES AS DETERMINED PURSUANT TO THE ACCEPTED PURCHASE ORDER; AND

C. Limitation on the Nature of Damages. EXCEPT AS EXPRESSLY PROVIDED IN SECTION 6 ABOVE, CHIEF SHALL NOT, UNDER ANY CIRCUMSTANCES, BE LIABLE TO THE DEALER, THE ORIGINAL OWNER OR ANY THIRD PARTY FOR ATTORNEY FEES COURT COSTS OR ANY OTHER SPECIAL, INDIRECT, INCIDENTAL, CONSEQUENTIAL, LIQUIDATED OR PUNITIVE DAMAGES OF ANY NAME, NATURE OR DESCRIPTION AS A RESULT OF THE FAILURE OF ANY PRODUCT OR ANY OTHER GOODS OR SERVICES PURCHASED BY THE DEALER OR THE ORIGINAL OWNER FROM CHIEF PURSUANT TO THE ACCEPTED PURCHASE ORDER TO CONFORM TO THE LIMITED WARRANTIES SET FORTH IN SECTION 2 ABOVE.

8. Applicable Law. This Limited Product Warranty has been issued, accepted and entered into by the Reseller, the Original Owner and Chief in the State of Nebraska and shall be governed by, and construed in accordance with, the internal laws of the State of Nebraska. Any legal action or proceeding with respect to any goods or services furnished to the Original Owner by Chief in connection herewith, or any document related hereto shall be brought only in the district courts of Nebraska, or the United States District Court for the District of Nebraska, and, by execution and delivery of this Limited Product Warranty, the undersigned Original Owner hereby accept for themselves and with respect to their property, generally and unconditionally, the jurisdiction of the aforesaid courts. Further, the undersigned Original Owner hereby irrevocably waives any objection, including, without limitation, any forum non conveniens, which it may now or hereafter have to the bringing of such action or proceeding in such respective jurisdictions.

ACKNOWLEDGMENT OF RECEIPT

By its signature hereto, the undersigned Reseller represents and warrants to Chief that the Reseller has provided a true, correct and complete copy of this Standard Limited Warranty to the Original Owner at the time the product was purchased.

Reseller Name and Address: _____

Original Owner Name and Address: _____

Accepted Purchase Order No. _____

Original Jobsite Address: _____

RESELLER:

By: _____
Date

Print name and title

4831-5139-8433, v. 1

Warning

Water Sensitive Materials - Read this notice carefully.

Items must be inspected, and the carrier advised immediately if damage is noted. White rust is a corrosion attack of the zinc coating resulting from the presence of water. Anywhere rust is found will result in a reduction of the life of the galvanized steel.

If water has entered a bundle or if condensation has formed between items, the bundle must be opened, the items separated and all surfaces dried.

If items are to be installed within 10 days:

Store bundled items off the ground high enough to allow air circulation beneath bundle and to prevent water from entering. Store one end at least 8" (20.32cm) higher than the opposite end. Support long bundles in the center. Prevent rain from entering the bundle by covering it with a tarpaulin, making provision for air circulation between the draped edges and the ground.

Do not wrap in plastic.

If items are not to be installed within 10 days:

Provide inside dry storage. Storage beyond 6 months is not recommended. If white rust is apparent upon receipt of shipment, notify Chief immediately. Damage to items resulting from improper storage is the responsibility of the receiver.

Before You Begin



Before starting the installation of the CBE42-20 platforms and ladders, take time to thoroughly study the construction methods in this manual, this will save you time and money.

Chief makes no warranty concerning components, accessories or equipment not manufactured by Chief.

When using a cutting torch or welding galvanized material, the possibility of developing toxic fumes will exist. Provide adequate ventilation and respiratory protection when using this type of equipment during installation.

Introduction

Thank you for purchasing Chief CBE42-20 platforms and ladders. Proper installation and operation will ensure the best overall experience with your equipment.

This proprietary information is loaned with the expressed agreement that the drawings and information herein contained are the property of Chief Industries, Inc. and will not be reproduced, copied, or otherwise disposed of, directly or indirectly, and will not be used in whole or in part to assist in making or to furnish any information for the making of drawings, prints or other reproduction hereof, or for the making of additional products or equipment except upon written permission of Chief Industries, Inc. first obtained and specific as to each case. The acceptance of this material will be construed as an acceptance of the foregoing agreement.

The technical data contained herein is the most recent available at the time of publication and is subject to modification without notice. Chief Industries, Inc. reserves the right to modify the construction and method of operation of their products at any time without any obligation on their part to modify any equipment previously sold and delivered.

Important Note: If you are unable to remedy any service problem after thoroughly studying this manual, contact the dealer from whom you purchased the unit. Your dealer is your first line of service. The following information is required for service:

1. Dealer purchased from: _____
2. Dealer address and phone number: _____
3. Date purchased: _____
4. Service contractor:
 - a. Name: _____
 - b. Address: _____
 - c. Phone: _____

Accessory Equipment

All accessory equipment should be installed and maintained in accordance with each individual supplier's installation and operation instructions. However, if any modifications to the Chief standard design are required, contact Chief for special recommendations.

Important Note: Do not modify the platforms or ladder designs without Chief approval. It is the responsibility of the general contractor to verify that all equipment is properly installed, and that the equipment is compatible with the intended use.

General Contractor Responsibilities

It is the responsibility of the general contractor to verify that the complete system is constructed with quality workmanship and that all equipment is installed per the respective manufacturer's instructions.

In addition, the general contractor is responsible for the fitness of use of any system which he constructs. All accessory equipment incorporated into the system should be approved for the intended use by each respective equipment manufacturer.

Field Modifications and Installation Defects

Chief assumes no responsibility for field modifications or installation defects which result in damage or operational problems. If any field modifications are necessary which are not specifically covered by the contents of this installation manual or project specific installation drawings supplied by Chief, contact Chief for approval. Any unauthorized modification or installation defect will void the warranty.

Checking Shipment

For your convenience individual items will be labeled with an appropriate part number and packages labeled. Hardware, including bolts, nuts, screws and other small clips or brackets may be divided into smaller packages for ease of use and identification.

Check your shipment at the time of delivery against the packing list provided with the shipment. If any items are missing or any damaged material is evident, note such shortage or damage on the freight bill before you sign the shipment paperwork.

Claims of shortages will not be honored after 30 days from receipt of shipment. Parts that are missing or damaged are the responsibility of the delivering carrier, not the manufacturer or dealer.

It is advisable to reorder damaged or missing parts immediately so that there will be no delay in the installation. After receiving the invoice for the reordered material, file a claim with the delivering carrier immediately.

Suggested Equipment

Chief recommends the following equipment and tools needed for installation. Individual installations may vary.

- Impact wrenches and sockets
- End wrenches
- Crescent wrenches
- Vise grip pliers
- Alignment punches
- Rubber mallets
- Level
- Drill and drill bits
- Screw Guns
- Metal Saw
- Extension cords

Hardware Torque

The following table contains recommended torque values for installation.

When installing hardware, the torque values shown below must be followed. All hardware must seat tight against the corresponding component.

Bolt Diameter	Torque
5/16" (.79cm)	16 ft.-lbs.
3/8" (.95cm)	29 ft.-lbs.
7/16" (1.11cm)	46 ft.-lbs.
1/2" (1.27cm)	70 ft.-lbs.
5/8" (1.59cm)	140 ft.-lbs.
3/4" (1.91cm)	250 ft.-lbs.
7/8" (2.22cm)	400 ft.-lbs.
1" (2.54cm)	600 ft.-lbs.
1 1/8" (2.86cm)	750 ft.-lbs.
1 1/4" (3.18cm)	1100 ft.-lbs.

Pre-Installation Planning Information

Ladders and platforms should be preplanned to meet the project requirements. Dealer/customer planning drawings will simplify the installation and should include the following:

- Site Layout
- Location and Orientation of Elevator
- Location of Accessories

The general installation of the components will be in the following order.

1. Ladder and Ladder Safety Cage
2. Reststop Platform
3. Distributor Platform
4. Head Service Platform

Important Note: Never weld the ladders or platforms to the support structures. Bolting allows for realignment of sections and replacement if necessary.

Ladder and Safety Cage Installation

Before starting installation refer to ladder field stack details included in shipment for ladder section requirements and placement specific to your bucket elevator.

Note: All figures show left hand drive configurations. For right hand drive, mirror components about the elevator centerline.

Boot Bracket Installation

Step 1: Attach the ladder boot bracket to the top of the leg flange as shown in **Figure 1** using existing hardware from the boot to leg connection. Attach standoff bracket using 3/8" hardware in the outer holes/slots.

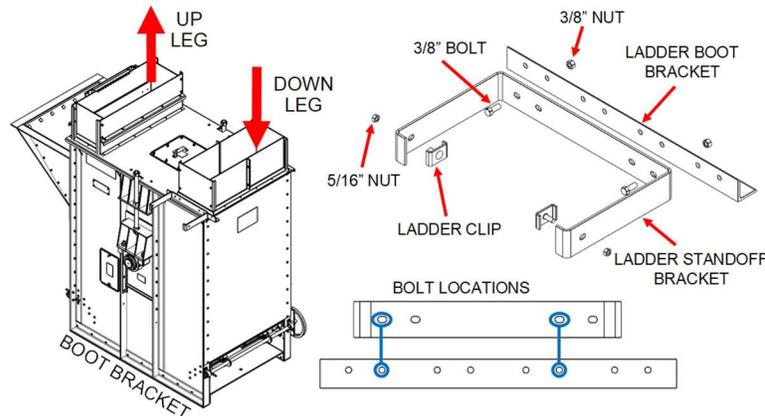


Figure 1

Step 2: Attach the bottom ladder section to the boot ladder bracket using ladder clip bolts and ensure the ladder is secured to the ground using a ground bracket. Some field cut modifications to the lower end of the final ladder section may be required.

Important Note: The bottom ladder section is required to have a ladder access door installed per OSHA standard. If any modifications are required, then the access door will need adjustment of hinges and latch bracket to center the door panel on the ladder section.

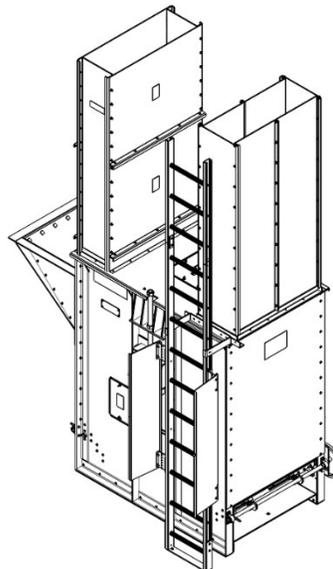


Figure 2

Note: To prevent unauthorized ladder access, a padlock device must be supplied by a party other than Chief.

Ladder Installation

Step 3: Install ladder brackets so they are at the bottom of each ladder section and at the top of the overall ladder assembly. Use existing bolt holes and hardware from the leg sections, only make modifications if the bolt spacing of one leg doesn't match the other.

Use either a ladder side bracket with a standoff bracket (**Figure 3**) or an angle spacer with a standoff bracket (**Figure 4**). Attach the standoff bracket using 3/8" hardware in the outermost holes/slots useable (**Figure 5**).

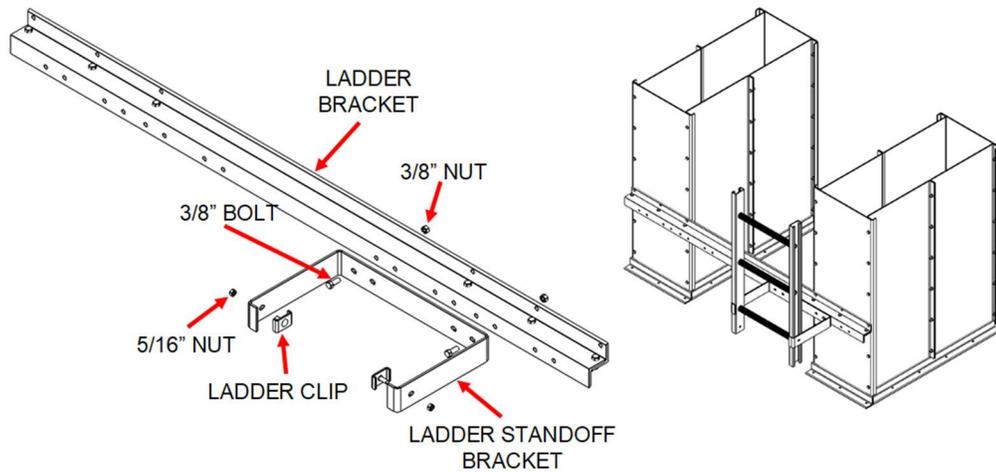


Figure 3

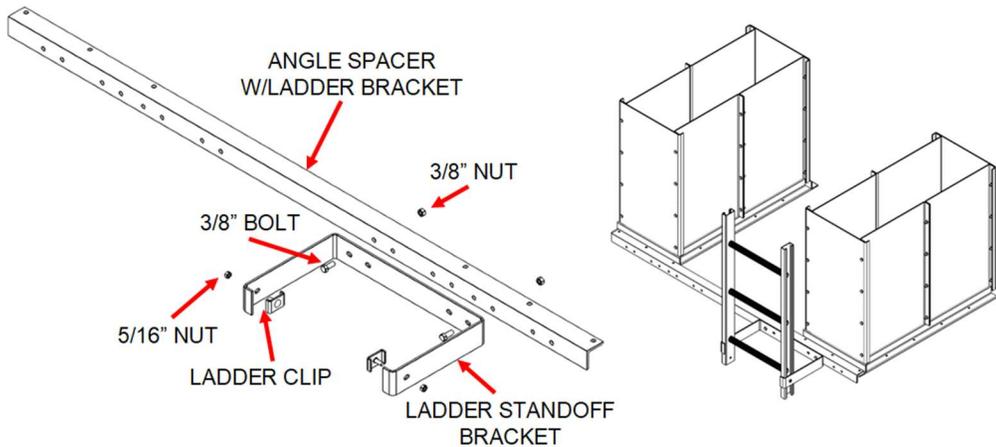
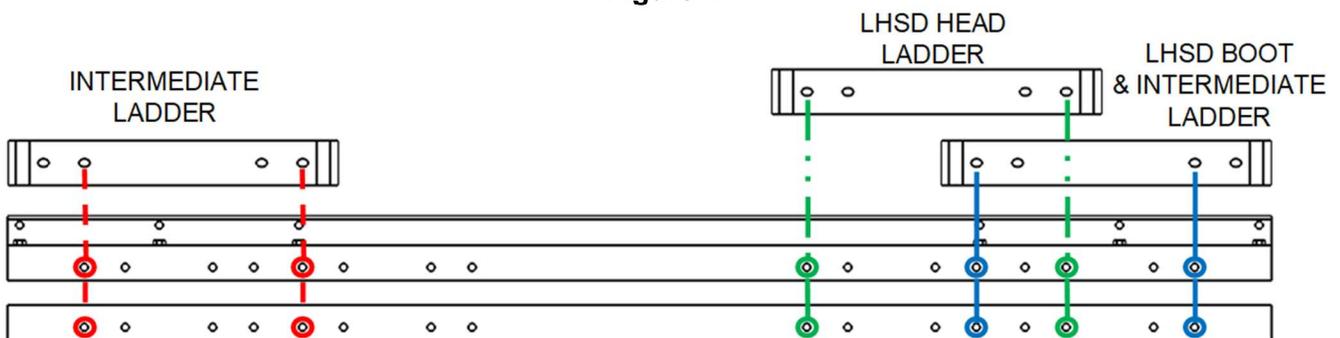


Figure 4



LADDER BRACKET & ANGLE SPACER STANDOFF BOLT POSITIONS

Figure 5

Step 4: Bolt the next section of ladder to the first using a ladder connection strap and two 5/16" bolts and nuts on each ladder leg. Repeat as needed.

Note: If the length of the ladder assembly needs to be shortened, then take the extra height from the very bottom of the last ladder.

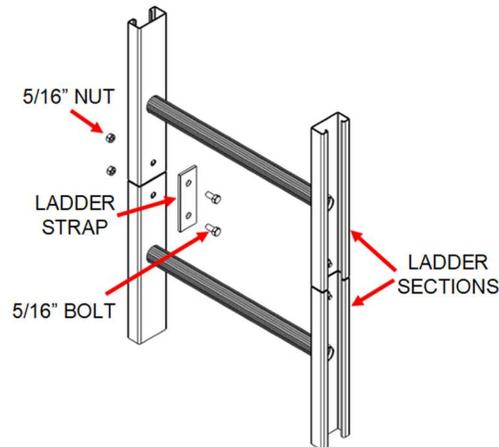


Figure 6

Step 5: Secure the ladder to the bracket using ladder clips. Ensure the ladder assembly extends at least 42" above the platform floor surface.

Note: Complete each platform to platform segment of ladder and safety cage before proceeding to next platform segment.

Step 6: Secure the bottom ladder section of the next ladder assembly to the platform floor surface using a ground bracket with ladder clips and repeat Steps 3-5 as needed.

Safety Cage Installation

Refer to ladder field stack details included in shipment for safety cage section requirements and placement of safety cage sections or flare safety cage sections.

Step 7: Install the cages to the ladders using ladder clips. Entrance cage sections are always the bottom section. The entrance cage is assembled the same as standard safety cages except the bottom hoop on the lowest cage in the assembly should be a cage entrance strap and end 7'-8' from the ground or platform floor surface.

Note: Some field cut modifications to the final safety cage section vertical bands may be required and omitting the necessary safety cage rings to meet height requirement.

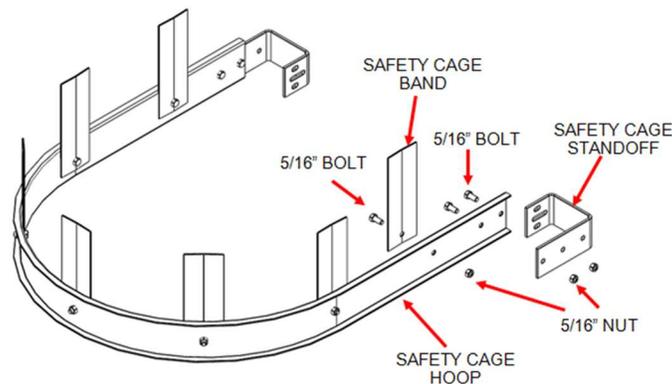


Figure 7

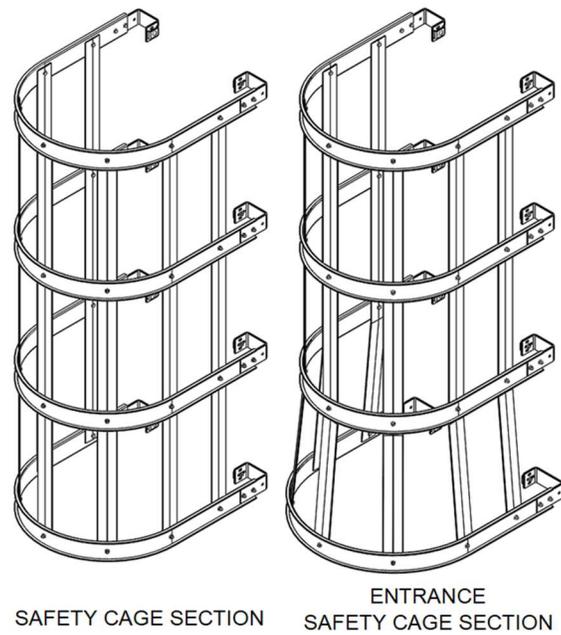


Figure 8

Step 8: Bolt backstraps into the entrance safety cage hoop, hand form the straps to flare to the top handrail. Field drill 3/8" holes in the top rail to bolt the backstrap into. Remove excess material.

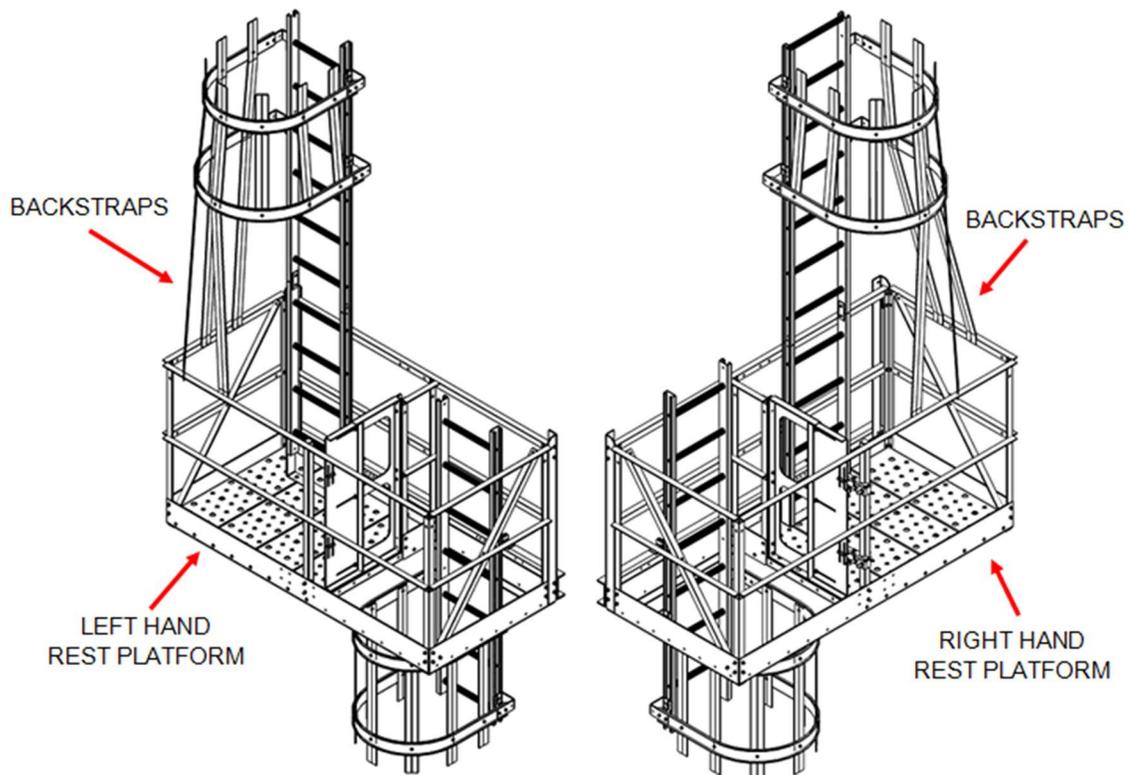


Figure 9

Reststop Platform Installation

Install either a left hand or right hand reststop platform following ladder field stack details included in shipment for correct reststop platform spacing for your bucket elevator.

Important Note: Failure to properly install reststop supports may result in reststop failure and/or user injury.

Floor and Handrails

Step 1: Bolt the 42" vertical posts to the toeboards then bolt in the horizontal handrails using 3/8" hardware.

Step 2: Bolt 52.863" diagonal rails to the top 38" handrails and the 40.50" toeboards using 3/8" hardware.

Step 3: Install safety gate to the 42" square post.

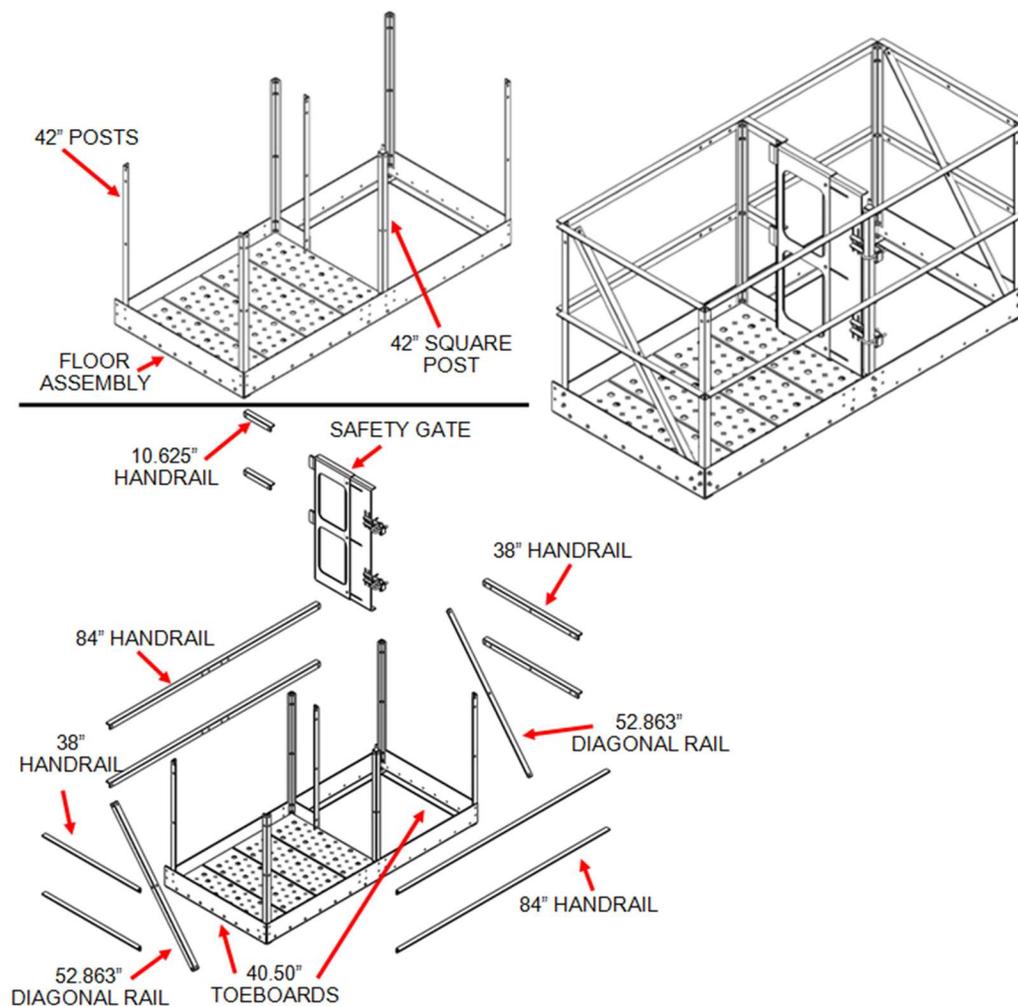


Figure 10

Step 4: Bolt in the spacer and bracket clip using 3/8" hardware.

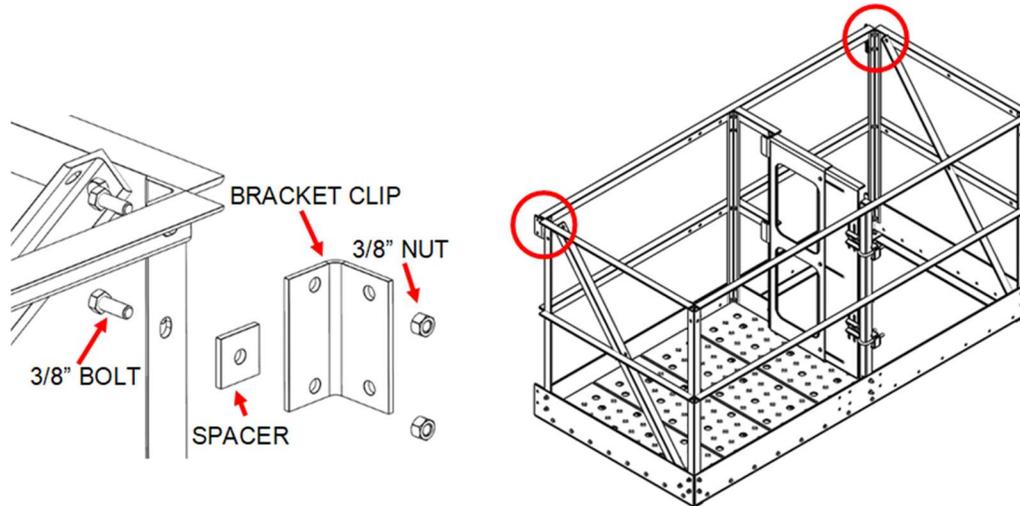


Figure 11

Step 4: With everything in place and squared, tighten all bolts.

Support Platform Mounting

Step 5: Attach 2 platform support channels to both legs 30" apart using the existing leg hardware.

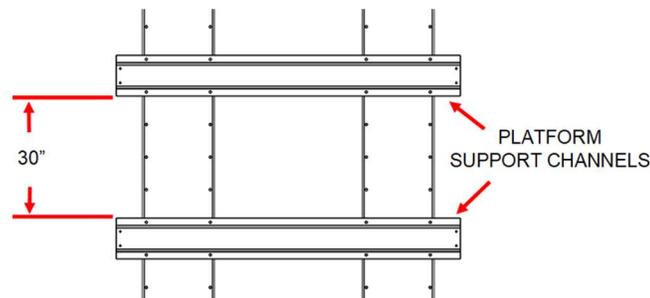


Figure 12

Step 6: Attach the left and right hand supports to the platform support bracket using 3/8" hardware.

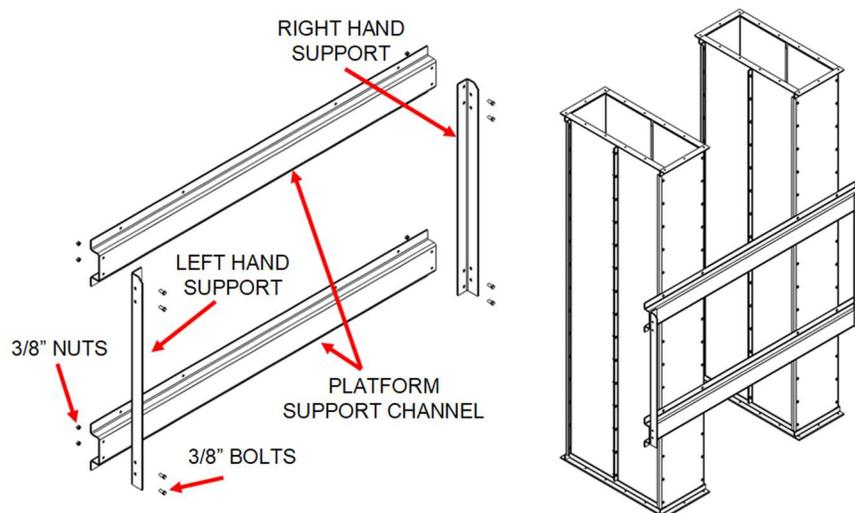


Figure 13

Step 7: Mount the rest platform assembly to the left and right hand supports using 3/8" hardware.

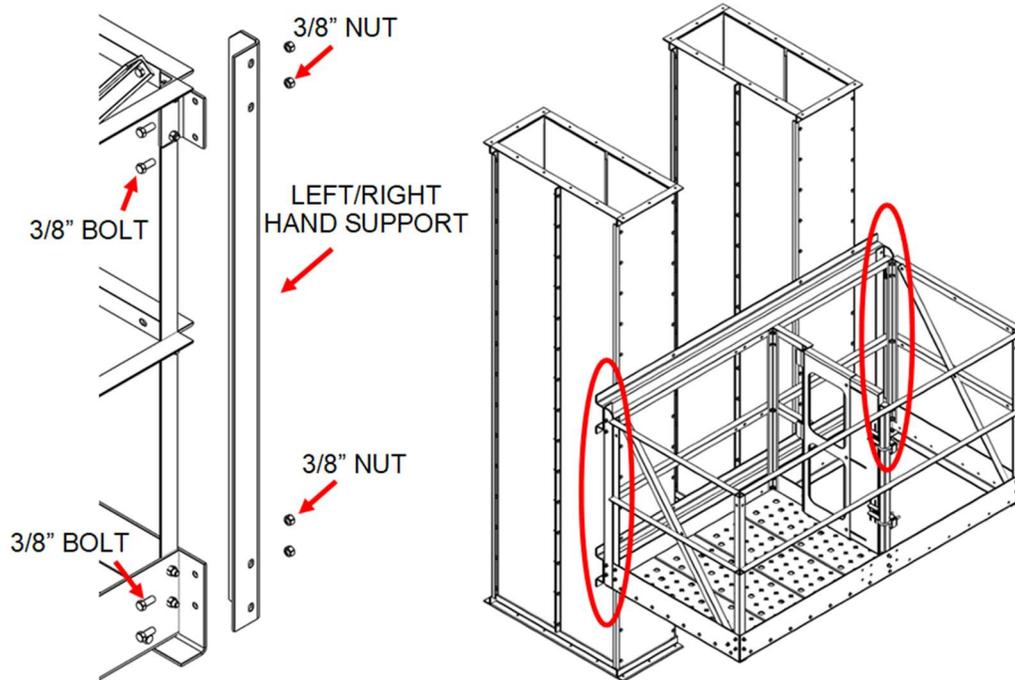


Figure 14

Step 6: Refer to **Ladder and Safety Cage Installation** section.

Distributor Platform Installation

The minimum installation distance between the head service platform and distributor service platform is approximately 7'. Before installing the distributor service platform it is recommended that the distributor location is determined for proper positioning of the platform.

Support Platform

Step 1: Mount support platform with brackets to the outside of the “down” leg using existing leg hardware.

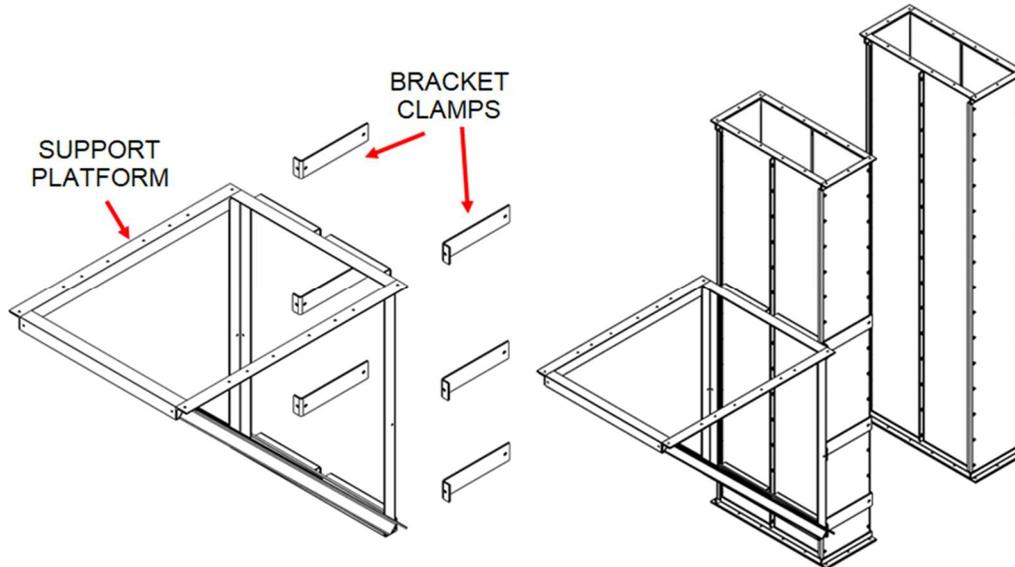


Figure 15

Floor and Handrails

Step 1: Bolt the platform floor assembly onto the supports using 1/2" hardware. Do not tighten until all bolts are in place and platform is square with the supports.

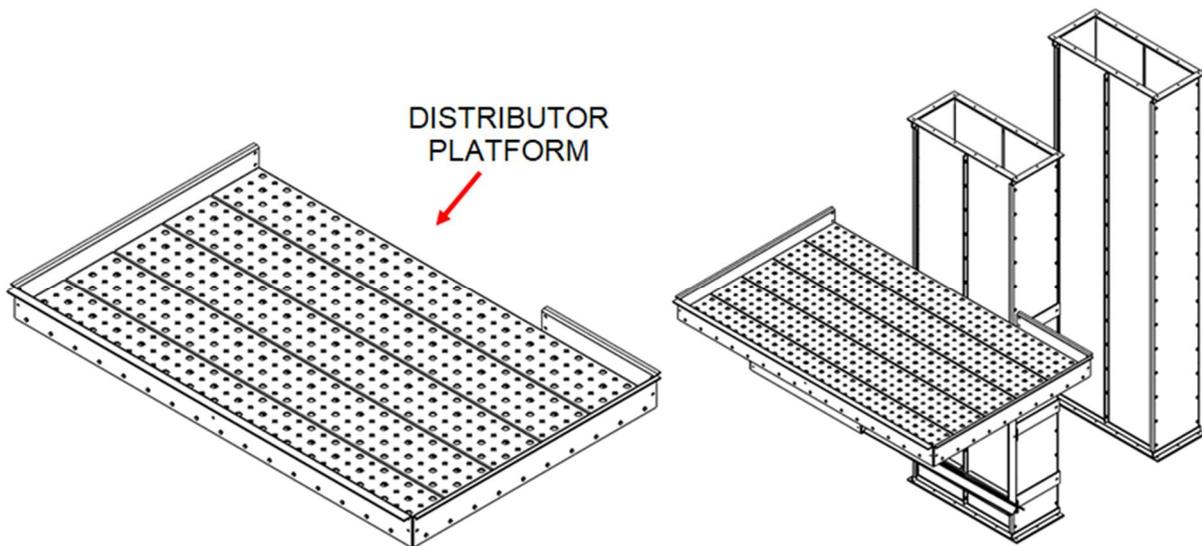


Figure 16

Step 2: Bolt the 42" vertical posts to the toeboards then bolt in the horizontal handrails using 3/8" hardware. The 80" handrails should project over the edge of the platform.

Step 3: Install safety gate to the 42" square post.

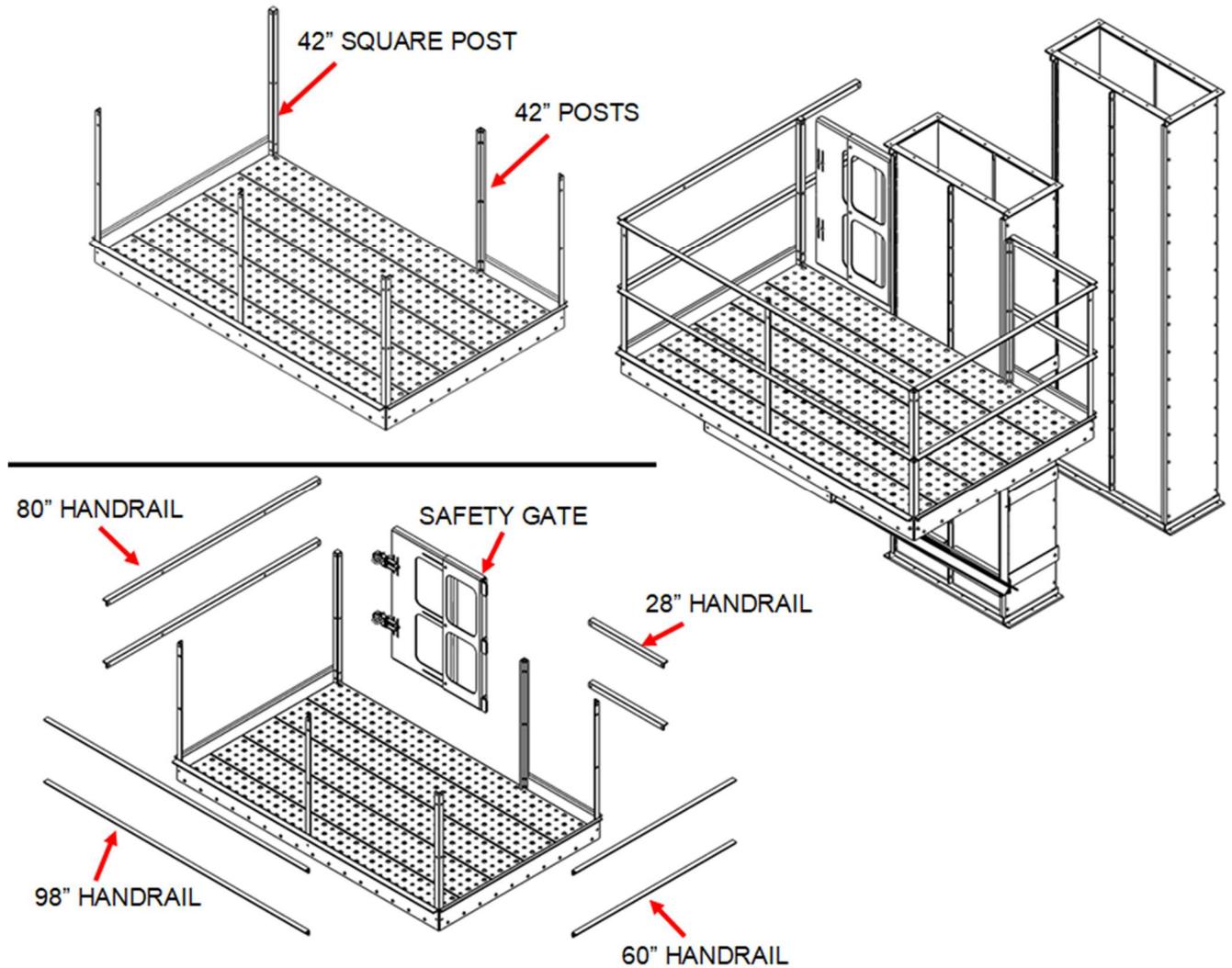


Figure 17

Step 4: With everything in place and squared, tighten all bolts.

Step 5: Refer to **Ladder and Safety Cage Installation** section.

Head Service Platform Installation

Your bucket elevator comes with platform mounting brackets welded to the head for the installation of the head service platform.

Support Platform

Step 3: Bolt the two head service platform support channels to the brackets on the head.

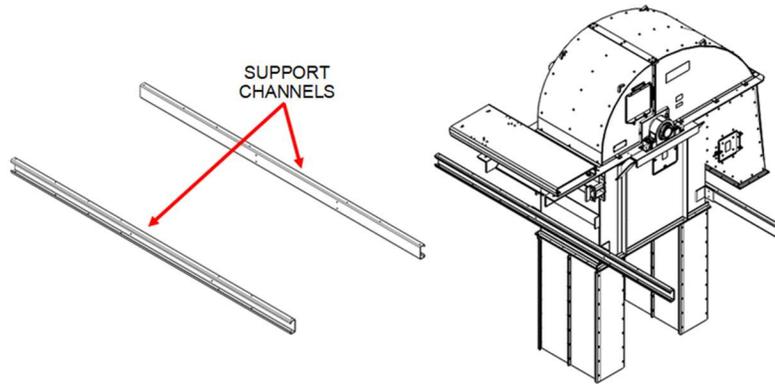


Figure 18

Floor and Handrails

Step 4: Install the platform sections on the door side and then drive side elevator, keeping the outside edge of the platforms even with the outside channel end. Then bolt the center floor section to the two outside sections

Step 5: Bolt the kicker supports to the platform and top leg sections.

Note: Do not tighten the bolts until all floor sections are in place.

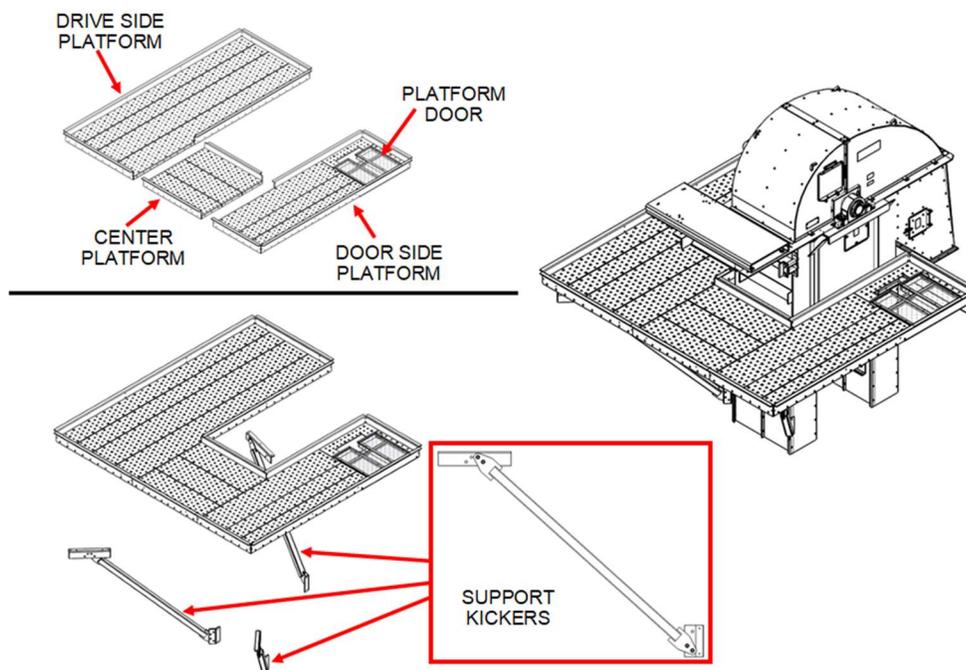


Figure 19

Step 5: Bolt the 42" vertical posts to the toeboards then bolt in the horizontal handrails using 3/8" hardware.

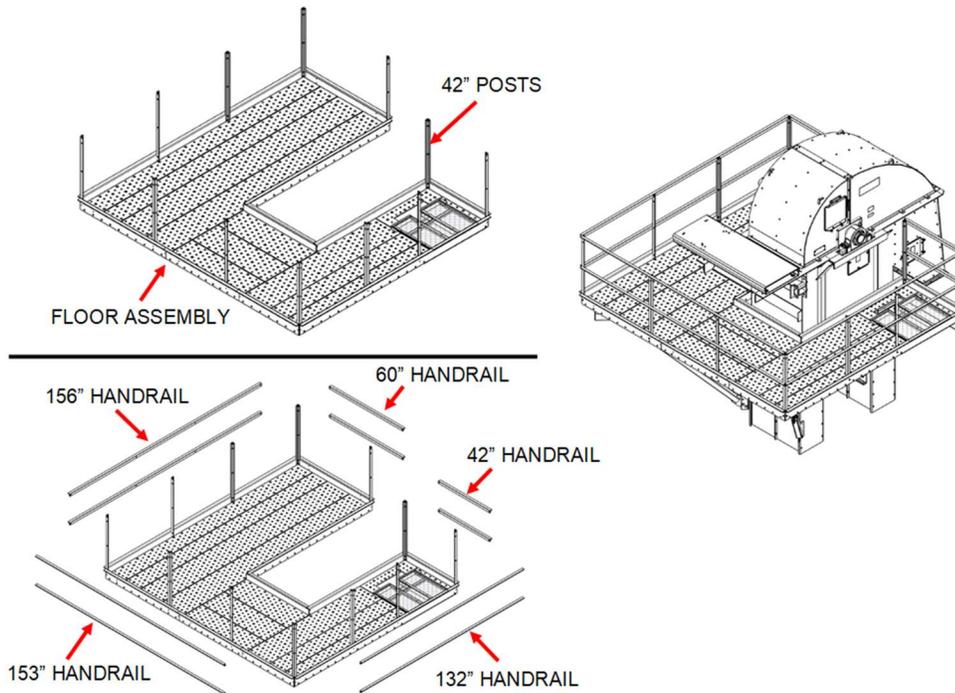


Figure 20

Step 6: With everything in place and squared, tighten all bolts.

Top Bracket Installation

Step 1: The ladder is positioned under the head service platform hatch on the non-driven side of the bucket elevator. Locate and field drill 3/8" holes to mount the brackets on the underside of the platform and install using 3/8" hardware. **Note:** Head is removed for visual clarity.

Step 2: Install the top ladder section. The ladder must extend at least 42" above the head service platform per OSHA requirements.

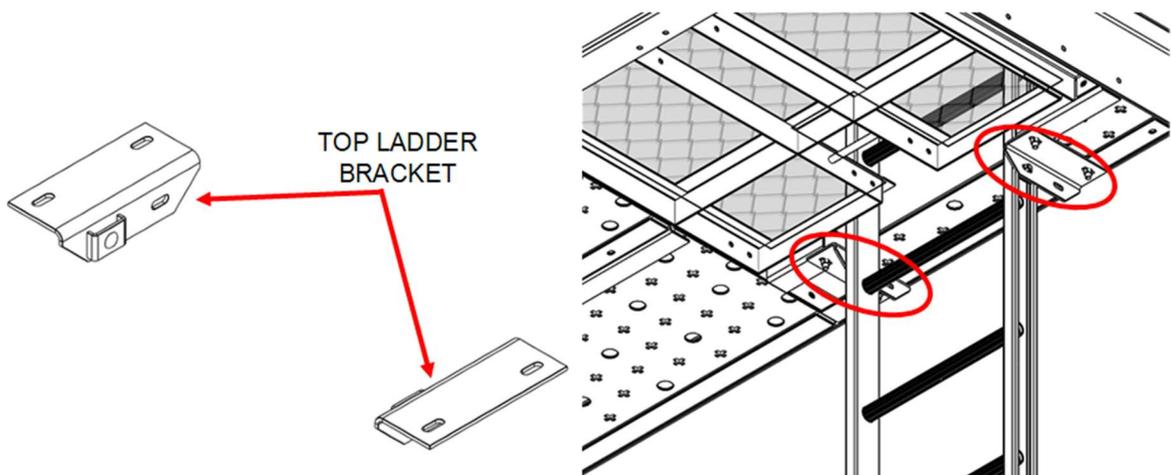


Figure 21