



**1000 SERIES
GRAIN HANDLING EQUIPMENT
PARTS & SET-UP MANUAL**

2565-787-REV B • 02/2025

AUGER ACE™



YETTER MANUFACTURING CO.
FOUNDED 1930

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Yetter

FOREWORD

You've just joined an exclusive but rapidly growing club.
For our part, we want to welcome you to the group and thank you for buying a Yetter product.

We hope your new Yetter products will help you achieve both goals-increase your productivity and increase your efficiency so that you may generate more profit.

This operator's manual has been designed into four major sections: Foreword, Safety Precautions, Installation Instructions and Parts Breakdown.

This **SAFETY ALERT SYMBOL** indicates important safety messages in the manual. When you see this symbol, be alert to the possibility of **PERSONAL INJURY** and carefully read the message that follows.



DANGER: Indicates an imminently hazardous situation which, if not avoided "will" result in death or serious injury. This signal word is to be limited to the most extreme situations



WARNING: Indicates a potentially hazardous situation which, if not avoided, "could" result in death or serious injury.



CAUTION: Indicates a potentially hazardous situation, which if not avoided, "may" result in minor or moderate injury. It may also be used to alert against unsafe practices.



NOTICE: Indicates information considered important, but not hazard related (e.g., messages relating to property damage).

It is the responsibility of the user to read the operator's manual and comply with the safe and correct operating procedure and to lubricate and maintain the product according to the maintenance schedule in the operator's manual.

The user is responsible for inspecting his machine and for having parts repaired or replaced when continued use of the product would cause damage or excessive wear to the other parts.

It is the user's responsibility to deliver his machine to the Yetter dealer who sold him the product for service or replacement of defective parts, which are covered by the warranty policy.

If you are unable to understand or follow the instructions provided in this publication, consult your local Yetter dealer or contact:

YETTER MANUFACTURING CO.

309/776-4111

800/447-5777

309/776-3222 (FAX)

Website: www.yetterco.com

E-mail: info@yetterco.com

WARRANTY

Yetter Manufacturing warrants all products manufactured and sold by it against defects in material. This warranty being expressly limited to replacement at the factory of such parts or products as shall appear to be defective after inspection. This warranty does not obligate the Company to bear cost of labor in replacement of parts. It is the policy of the Company to make improvements without incurring obligations to add them to any unit already sold. No warranty is made or authorized to be made, other than herein set forth. This warranty is in effect for one year after purchase.

DEALER: _____

Yetter Manufacturing warrants its own products only and cannot be responsible for damages to equipment on which mounted.



SAFETY PRECAUTIONS



A brief description of signal words that may be used in this manual:

DANGER: Indicates an imminently hazardous situation which, if not avoided “will” result in death or serious injury. This signal word is to be limited to the most extreme situations.

WARNING: Indicates a potentially hazardous situation which, if not avoided, “could” result in death or serious injury.

CAUTION: Indicates a potentially hazardous situation, which if not avoided, “may” result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE: Indicates information considered important, but not hazard related (e.g., messages relating to property damage).

Consult your implement and tractor operator’s manual for correct and safe operating practices. Be aware of towed implement width and allow safe clearance.

Safety decals are placed on the implement to alert the operator and others to the risk of personal injury or unsafe operation during normal operations and servicing.

1. The safety decals must be kept clean and in good condition to ensure that they are legible.
2. Safety decals must be replaced if they are missing or illegible.
3. When components are replaced during repair or servicing, check that the new components include the necessary safety signs.
4. Replacement safety decals may be obtained from your local dealer.



WARNING

Read these instructions carefully to acquaint yourself with the Equipment. Working with unfamiliar equipment can lead to accidents.

Never park the equipment on a steep incline or leave the equipment running unattended.

Never clean, lubricate or adjust a machine that is in motion.

Always check that straps are secure.

Make sure latches are in pinned position when moving equipment.

Do not allow children to operate this equipment.

Do not allow riders on the equipment, trailer and/or pick-up.

Use speed and caution dictated by the terrain being traversed. Do not operate on any slope steep enough to cause tipping or loss of control.

Read and understand the operator’s manual and require all other persons who will operate the equipment to do the same.

If operating on public roadways, where legal, be certain all lighting is operating properly and observe all traffic laws.

Beware of increased stopping distances and control effort when operating with implements attached.

Be familiar with all controls and be prepared to stop equipment quickly in an emergency.

FAILURE TO HEED MAY RESULT IN PERSONAL INJURY OR DEATH.

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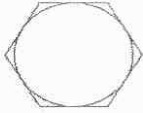
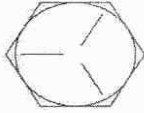

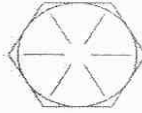
GENERAL INFORMATION

BOLT TORQUE

READ THESE INSTRUCTIONS FIRST:

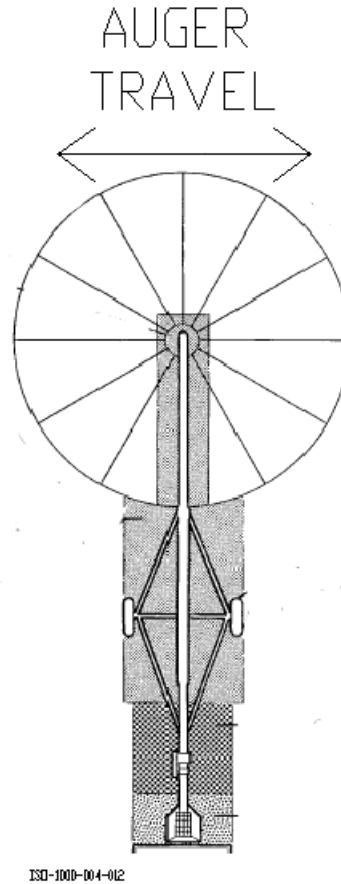
1. Improperly tightened bolts will result in damage, breakage, expense, and down time.
2. Always replace bolts with the specified grade and type.
3. Torque properly before first use of the machine and every 2-4 hours of use until you are sure bolts are staying tight.
4. The chart below is a guide for proper torque. Use it unless a specified torque is called out elsewhere in the manual.
5. Torque is the force you apply to the wrench handle or the cheater bar, times the length of the handle or bar.
6. Use a torque wrench whenever possible.

The following table shows torque in ft. lbs.

BOLT DIA. AND THREADS PER INCH	 GRADE 2	 OR  GRADE 5 A-325	 GRADE 8
1/4	6	10	14
5/16	12	20	30
3/8 - 16	25	35	50
7/16 - 14	35	55	80
1/2 - 13	55	85	125
9/16 - 12	75	125	175
5/8 - 11	105	170	235
3/4 - 10	185	305	425
7/8 - 9	170	445	690
1-8	260	670	1030
1 1/8 - 7	365	900	1460
1 1/4 - 7	515	1275	2060
1 3/8 - 6	675	1675	2700
1 1/2 - 6	900	2150	3500
1 3/4 - 5	1410	3500	5600

Lubricate all bearings and moving parts as assembled and make certain that they work freely.

GENERAL INFORMATION



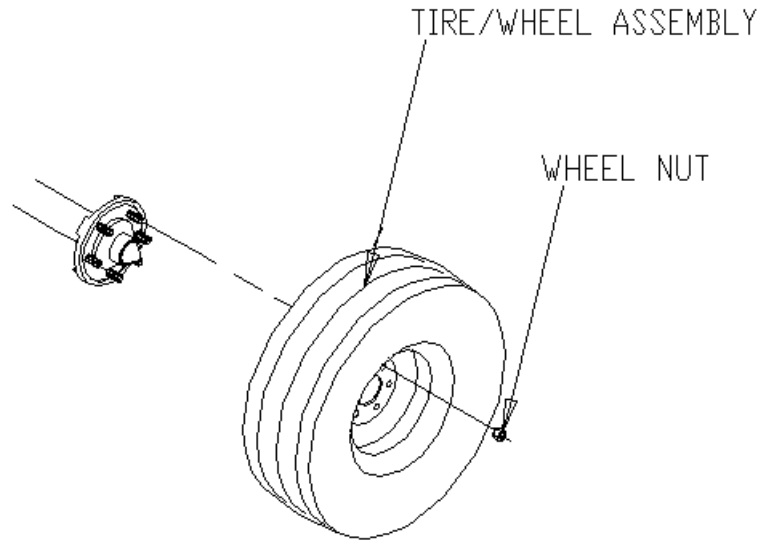
WORK AREA: AUGER ACE will move the auger side to side at the discharge end.



KEEP AWAY FROM OVER HEAD WIRES

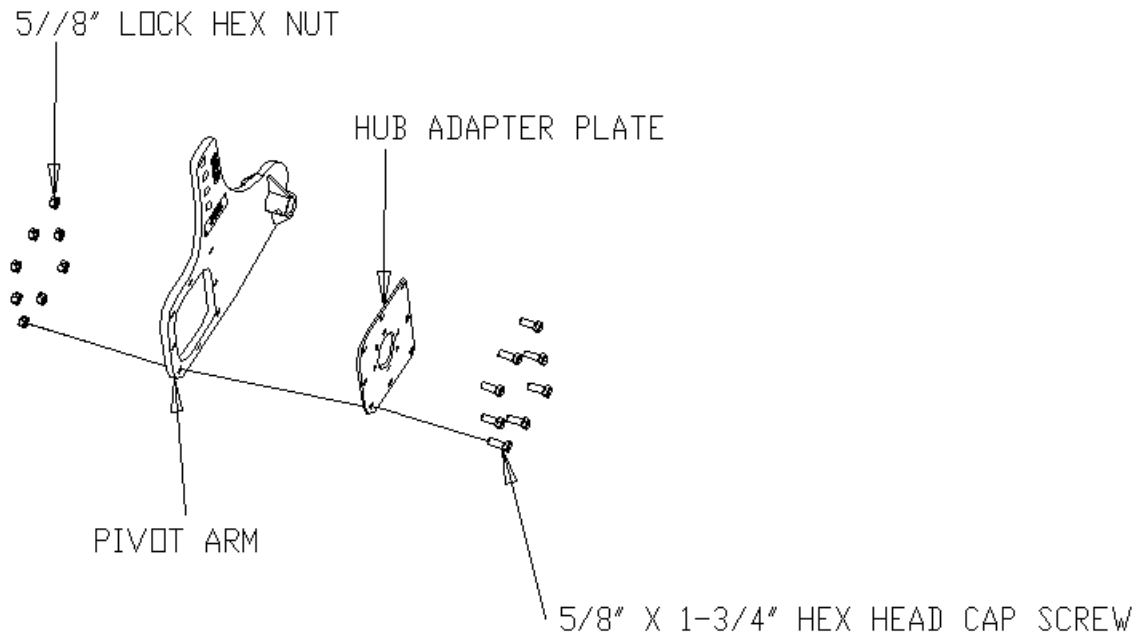
ASSEMBLY INSTRUCTIONS

STEP 1. Remove the tire/wheel assembly from the Auger.



ISD-1000-004-002

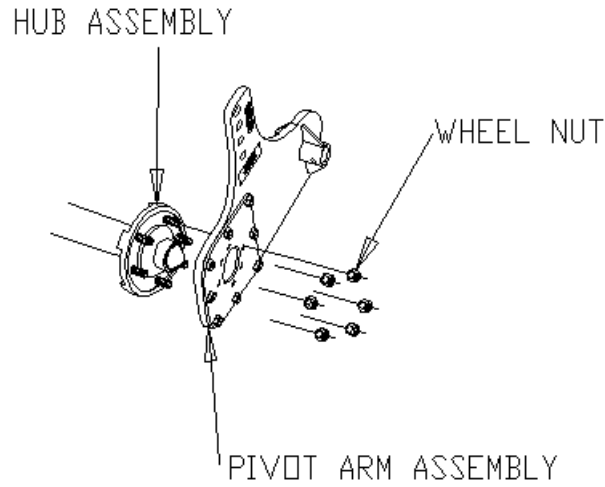
STEP 2. Attach the hub adapter plate to the pivot arm using the 5/8" hex head bolts and lock nuts.



ISD-1000-004-003

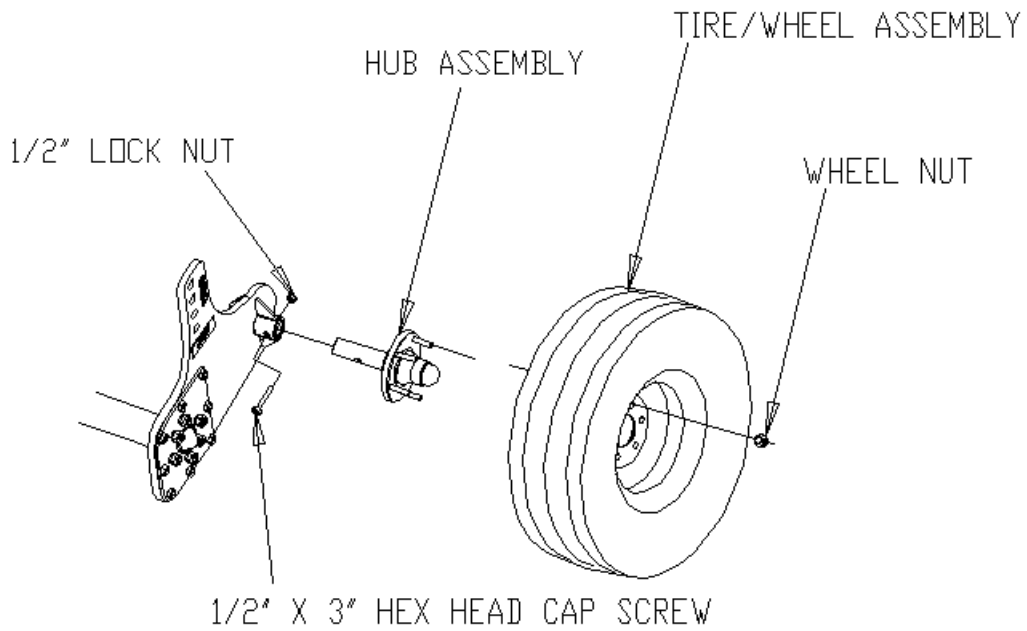
ASSEMBLY INSTRUCTIONS

STEP 3: Attach the pivot arm assembly to the auger. Secure with the wheel nuts removed in Step 1. The taper on the wheel nut will face out or away from the adapter plate.



ISD-1000-004-004

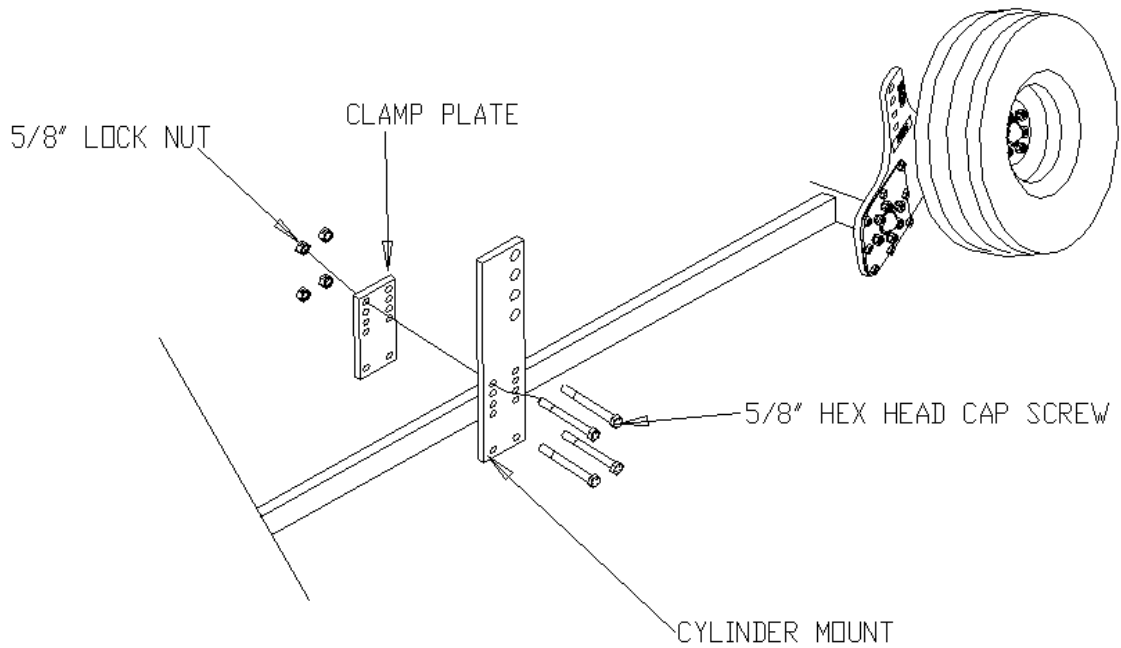
STEP 4: Install the hub assembly to the pivot arm with $\frac{1}{2}$ " hex head bolt and lock nut. Attach the wheel assembly and wheel nuts, tighten securely.



ISD-1000-004-005

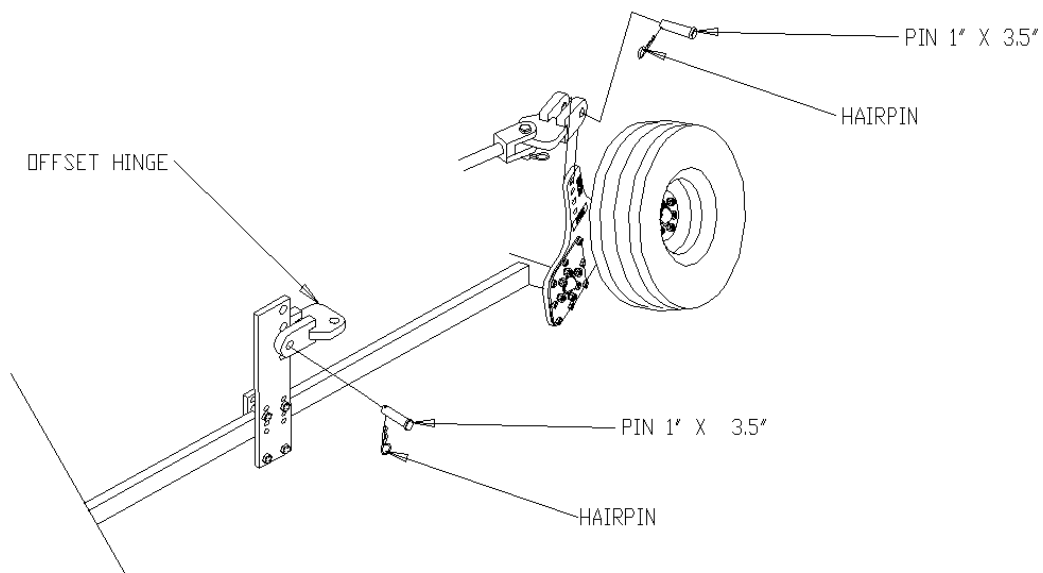
ASSEMBLY INSTRUCTIONS

STEP 5: Install the cylinder mount and clamp plate using 4) 5/8" hex head bolts and lock nuts. Leave loose to be able to slide on the auger under carriage.



ISD-1000-004-006

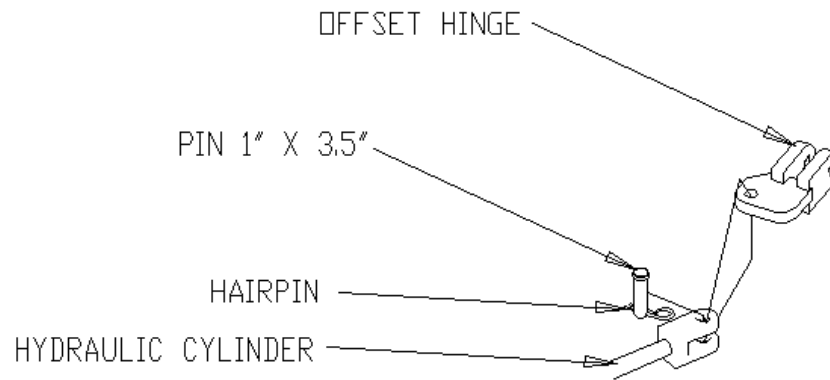
STEP 6: Attach the offset hinges to the cylinder mount and pivot arm using the headed pins and hair pins.



ISD-1000-004-008

ASSEMBLY INSTRUCTIONS

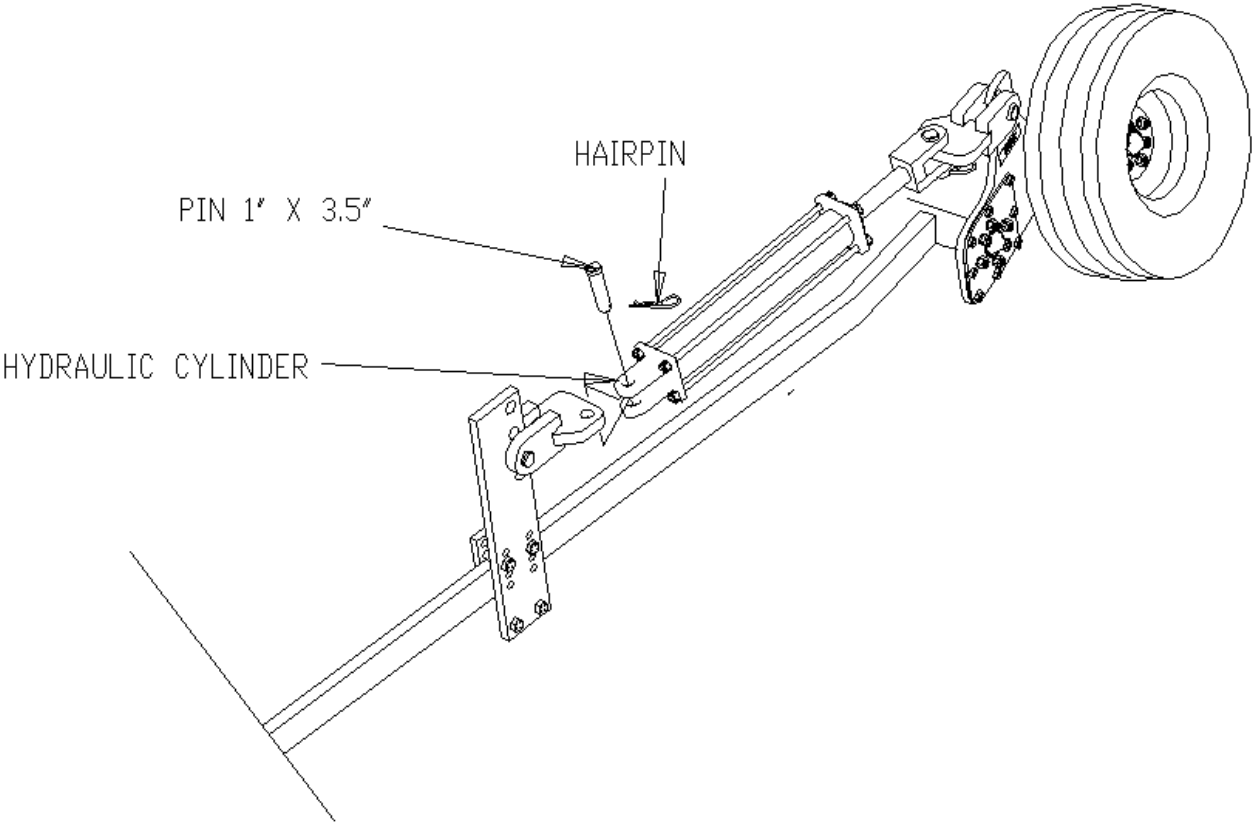
STEP 7: Attach the hydraulic cylinder to the offset hinge at the pivot arm.



ISO-1000-004-007

ASSEMBLY INSTRUCTIONS

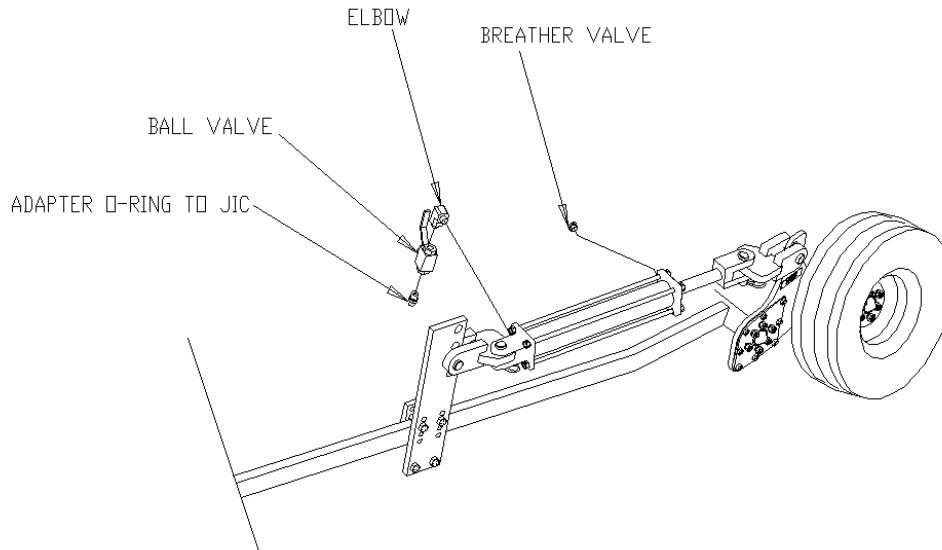
STEP 8: Secure the hydraulic cylinder to the cylinder mount using the headed pin and hair pin.



ISD-1000-004-009

ASSEMBLY INSTRUCTIONS

STEP 9: Install the breather valve and ball valve to the hydraulic cylinder



ISO-1000-004-010

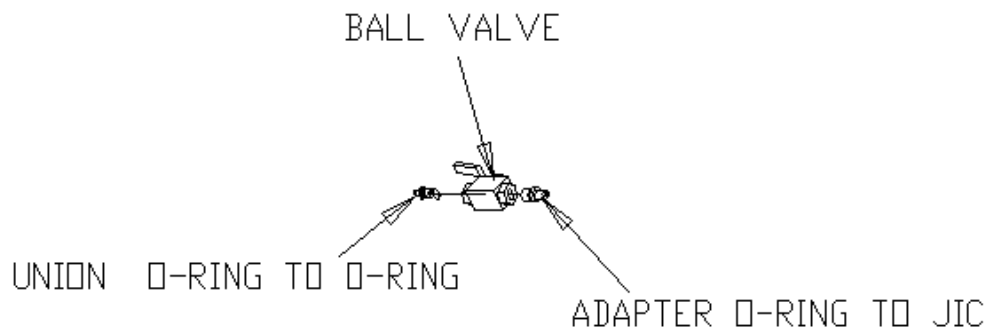
STEP 10: ROUTE HYDRAULIC HOSES- HYDRAULIC HOSES NOT SUPPLIED

Secure the hydraulic hoses to the under carriage of the auger. Beware of pinch points.

ASSEMBLY INSTRUCTIONS

STEP 11. Install the ball valve and ISO hydraulic coupler (not supplied) at the tractor. Lubricate the o-rings with oil before assembly of the components.

VALVE AT TRACTOR



ISO-1000-004-011

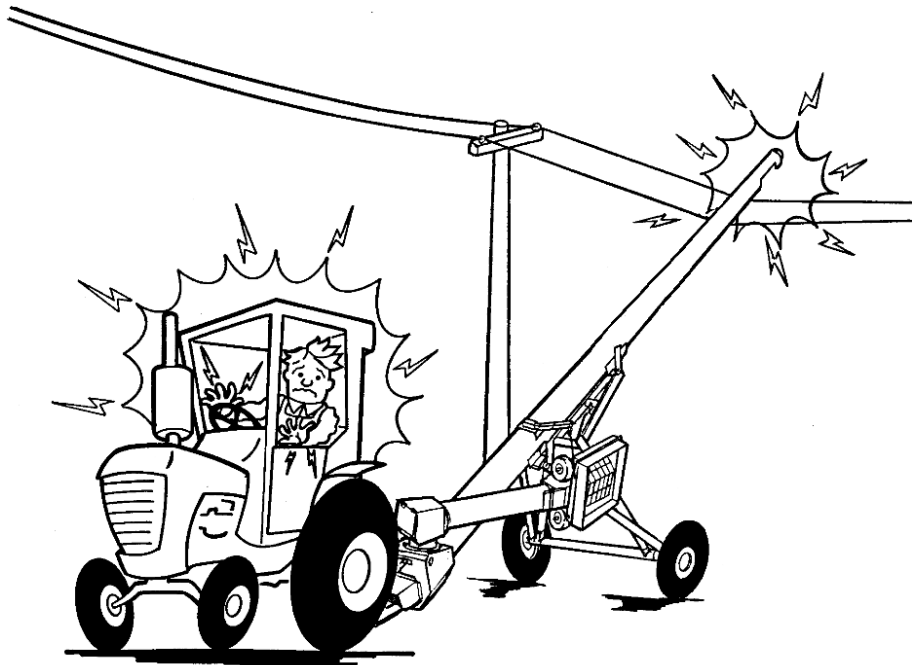
ATTACH BALL VALVE TO HYDRAULIC COUPLER AT TRACTOR-COUPLER NOT SUPPLIED

OPERATING INSTRUCTIONS

SAFETY

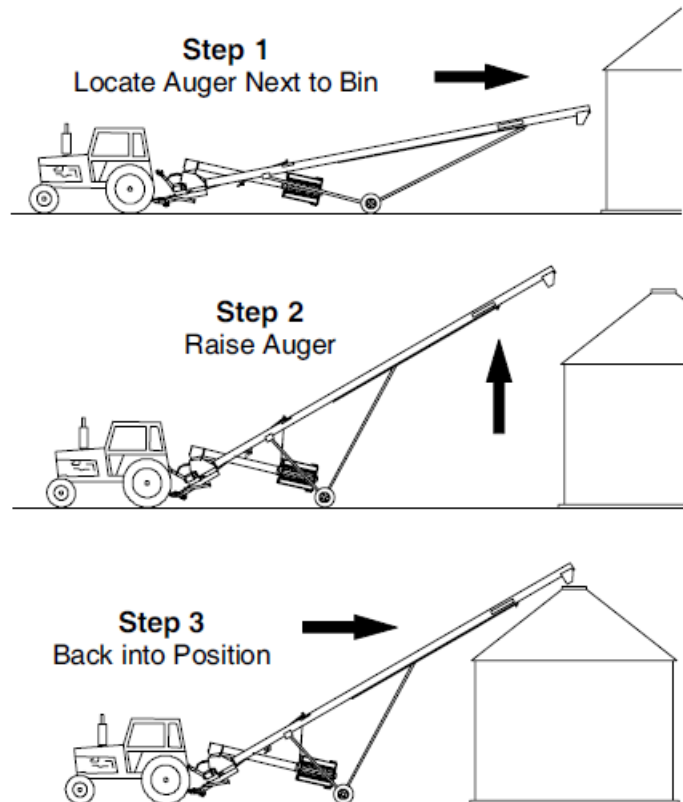


Overhead Wires,
Power Lines
▶ KEEP AWAY



CAUTION! Make sure entire area above auger and the path of travel is clear of overhead obstructions and electrical wires. Failure to do so can result in electrocution (maintain at least 10 feet of clearance from power lines, *electrocution can occur without direct contact of the power lines*).

To prevent tip-over when backing, avoid rolling over any obstructions and avoid steep slopes. If the auger is to be set on a slope, approach the bin uphill. Avoid moving the auger at right angles to a slope.



Step 1: Locate Auger Next to Bin

Move the auger into its working position with a towing vehicle. Locate the auger as close as possible to the bin (or other structure). Move auger slowly towards the bin with the towing vehicle – **not by hand**.

Step 2: Raise Auger

Raise the auger only high enough to clear the top of the bin.

Step 3: Back into Position

A: Back auger slowly into working position with the towing vehicle

Do NOT attempt to increase auger height by positioning its wheels on lumber, blocks, or any other means to raise its height.

B: Adjust the auger until the discharge is directly over the opening.*

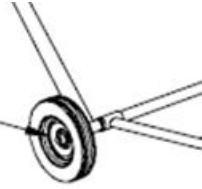
C: Close the ball valve on the hydraulic hose.

It is good practice to secure the discharge end of the auger to the bin or grain storage structure to prevent possible wind damage (remember to untie the auger before attempting to move).

*When discharging into a grain spreader, maintain at least 12" (305 mm) of space between the auger discharge and the spreader.

MAINTENANCE

Repack
Wheel Bearings
Annually

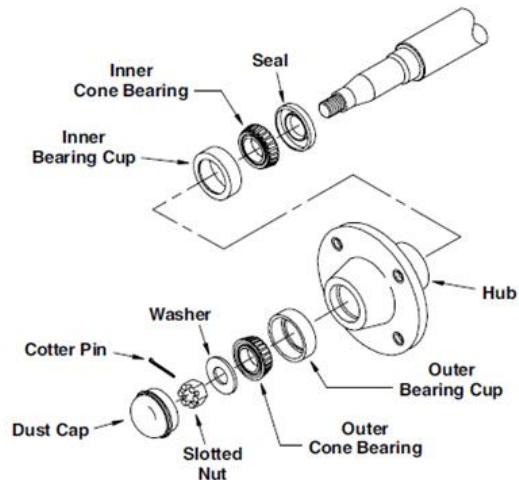


AXLE SPINDLE BEARING

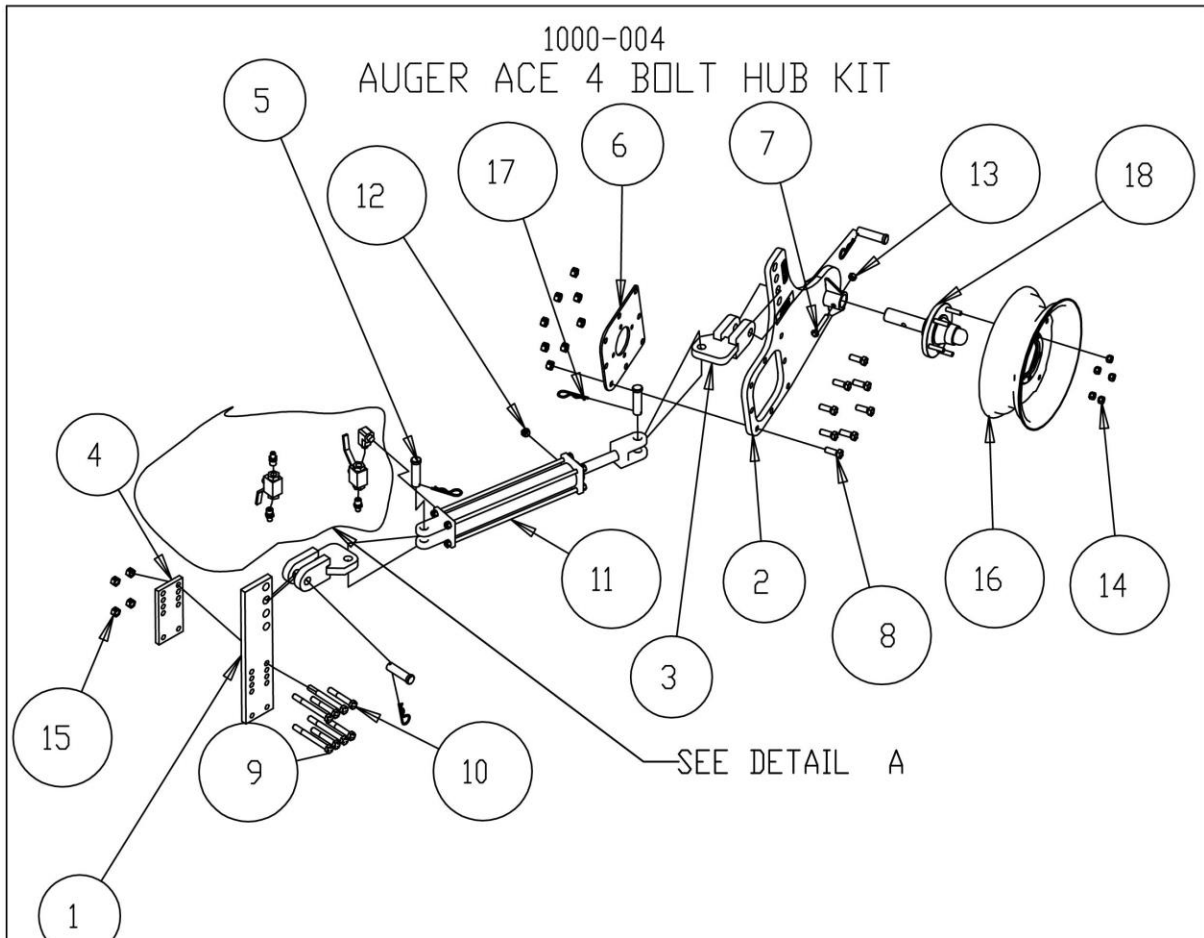
Tapered roller bearings are standard on all augers and should be repacked with grease annually or as needed determined by usage.

1. Raise the undercarriage axle high enough to allow the tire to clear the ground, and support axle with jack stands or equivalent. Never rely solely on hydraulic or mechanical jacks for support, use jack stands or equivalent for support.
2. Remove the dust cover by prying around its edges.
3. Remove the cotter pin, slotted nut and flat washer from the end of the axle shaft. Carefully remove the hub and bearings from the shaft. Inspect all parts for wear or damage and replace as necessary.
4. When reassembling the hub, repack both bearing cones with grease and fill hub cavity 1/3 full..
5. Place inner bearing and seal into hub and carefully reinstall hub onto shaft (be careful not damage the lip of the seal).
6. Install outer bearing into hub and replace the flat washer and slotted nut. Tighten the slotted nut to seal the bearings until the hub binds as you rotate the hub.

Back off the slotted nut to the next slot and install a new cotter pin. Replace dust cap.

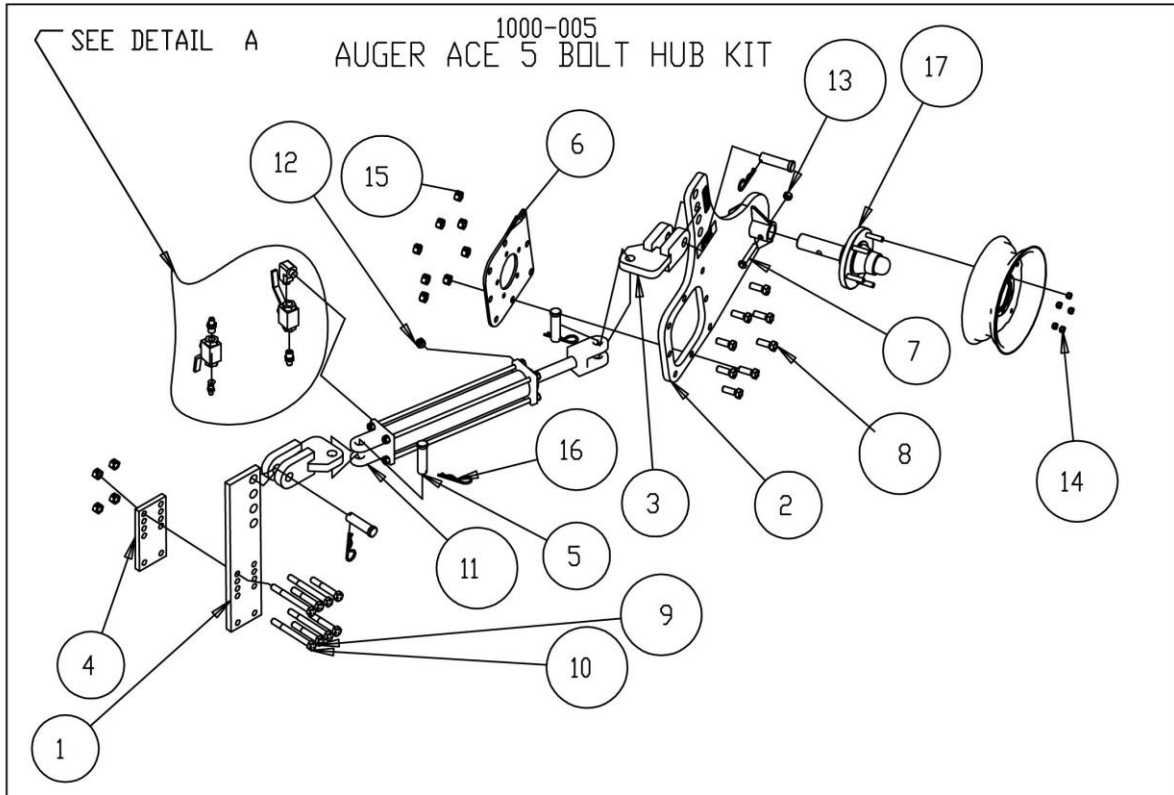


PARTS IDENTIFICATION



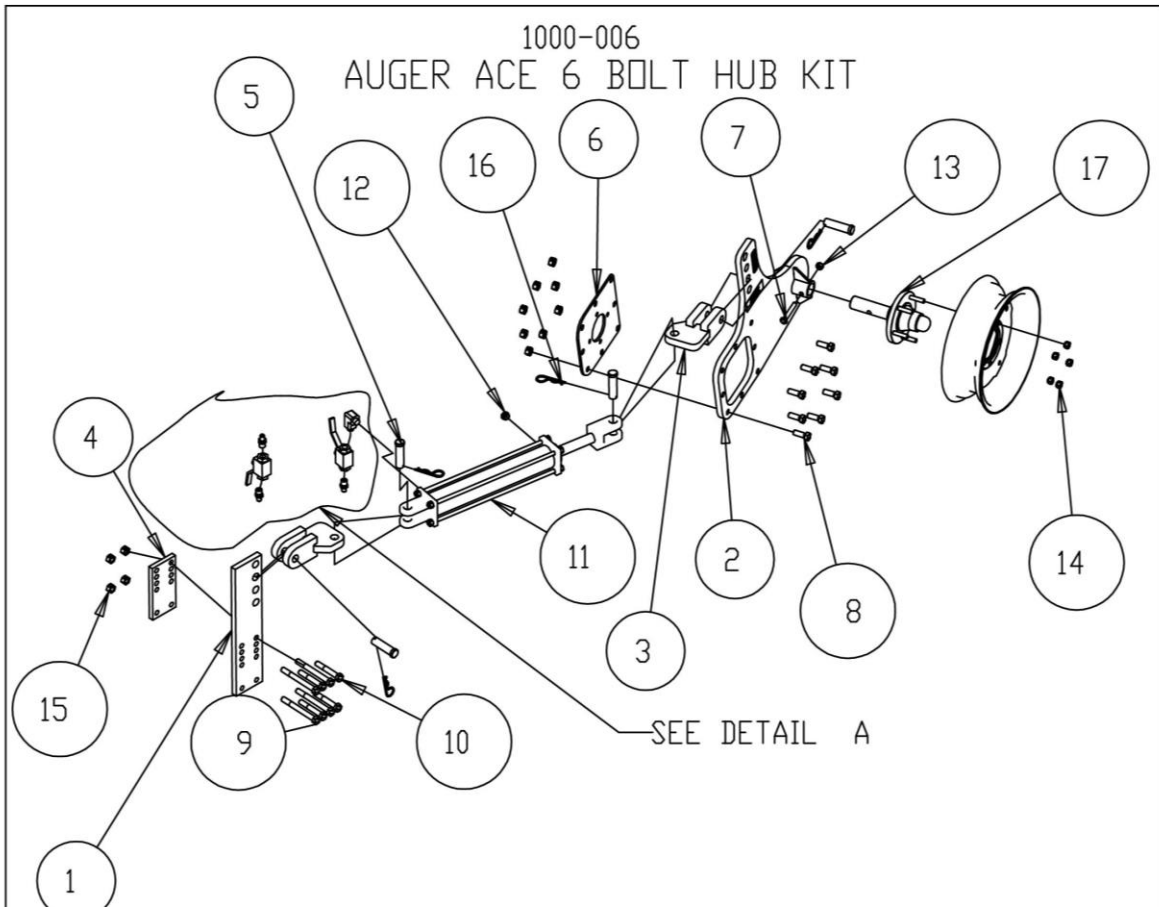
ITEM	PART #	DESCRIPTION	QTY
1	1000-382	CYLINDER MOUNT ADJUSTMENT PLATE	1
2	1000-218	MAIN ARM SHORT	1
3	1000-219	OFFSET HINGE	2
4	1000-383	CLAMP PLATE	1
5	1000-386	PIN 1" X 3.5"	4
6	1000-391	ADAPTER HUB PLATE 4 X 50-3620	1
7	2502-313	1/2-13 X 3 CAP SCREW GRADE 5	1
8	2502-331	5/8-11 X 1-3/4 CAP SCREW GRADE 5	8
9	2502-335	5/8-11 X 6 CAP SCREW GRADE 5	4
10	2502-336	5/8-11 X 4 CAP SCREW GRADE 5	4
11	2515-336A	HYDRAULIC CYLINDER 3 X 16	1
12	2515-836	BREATHER	1
13	2520-357	1/2-13 LOCK HEX NUT	1
14	2520-360	1/2-20 WHEEL HEX NUT	5
15	2520-459	5/8-11 LOCK HEX NUT	12
16	2570-323	WHEEL 15" X 5"	1
17	2520-465	HAIRPIN	4
18	3400-374	HUB/SPINDLE ASSEMBLY	1

PARTS IDENTIFICATION



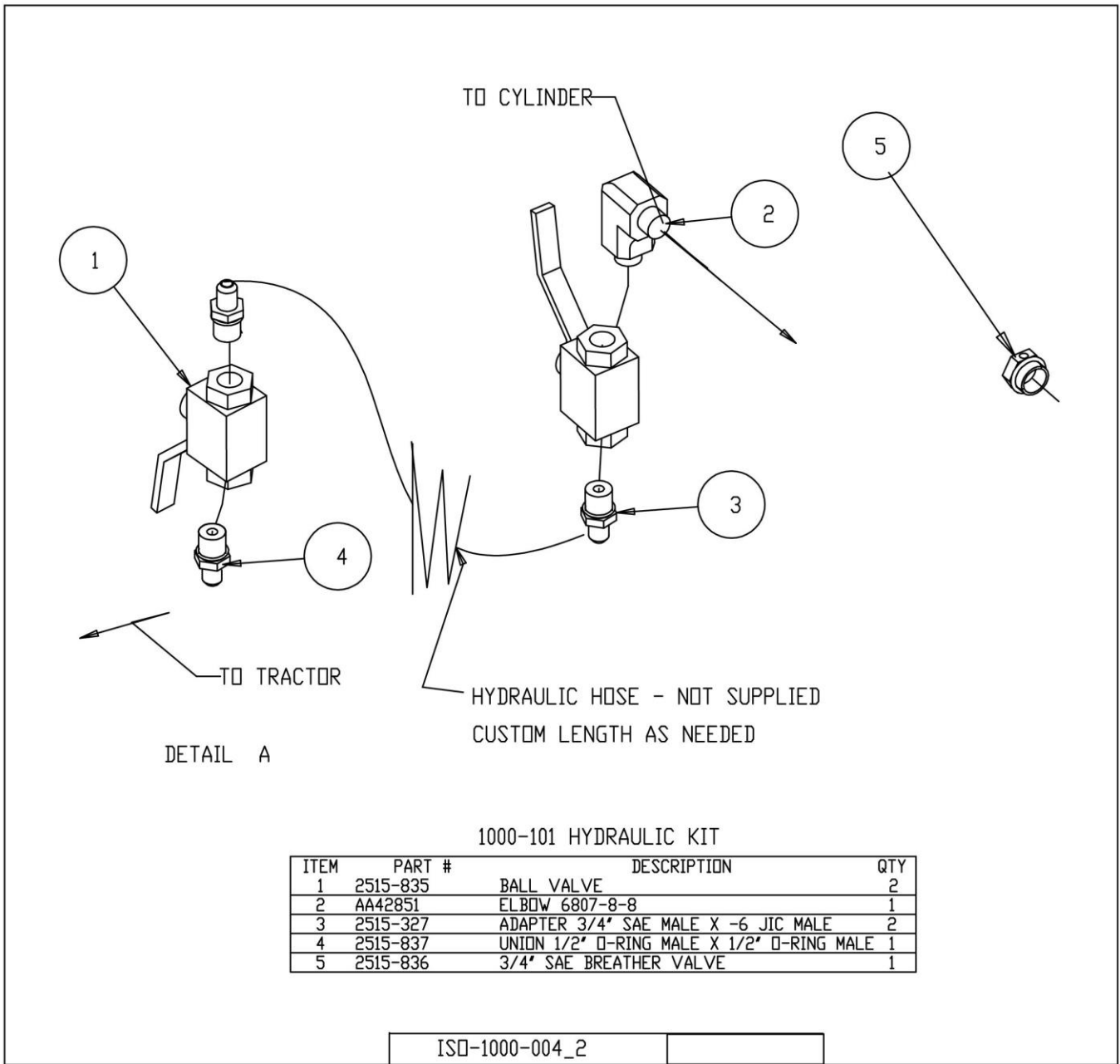
ITEM	PART #	DESCRIPTION	QTY
1	1000-382	CYLINDER MOUNT ADJUSTMENT PLATE	1
2	1000-218	MAIN ARM SHORT	1
3	1000-219	OFFSET HINGE	2
4	1000-383	CLAMP PLATE	1
5	1000-386	PIN 1" X 3.5"	4
6	1000-392	ADAPTER HUB PLATE 5 X 55-4000	1
7	2502-313	1/2-13 X 3 CAP SCREW GRADE 5	1
8	2502-331	5/8-11 X 1-3/4 CAP SCREW GRADE 5	8
9	2502-335	5/8-11 X 6 CAP SCREW GRADE 5	4
10	2502-336	5/8-11 X 4 CAP SCREW GRADE 5	4
11	2515-336A	HYDRAULIC CYLINDER 3 X 16	1
12	2515-836	BREATHER	1
13	2520-357	1/2-13 LOCK HEX NUT	1
14	2520-360	1/2-20 WHEEL HEX NUT	5
15	2520-459	5/8-11 LOCK HEX NUT	12
16	2520-465	HAIRPIN	4
17	3400-374	HUB/SPINDLE ASSEMBLY	1

PARTS IDENTIFICATION



ITEM	PART #	DESCRIPTION	QTY
1	1000-382	CYLINDER MOUNT ADJUSTMENT PLATE	1
2	1000-220	MAIN ARM LONG	1
3	1000-219	OFFSET HINGE	2
4	1000-383	CLAMP PLATE	1
5	1000-386	PIN 1" X 3.5"	4
6	1000-394	ADAPTER HUB PLATE 6 X 60-4625	1
7	2502-313	1/2-13 X 3 CAP SCREW GRADE 5	1
8	2502-331	5/8-11 X 1-3/4 CAP SCREW GRADE 5	8
9	2502-335	5/8-11 X 6 CAP SCREW GRADE 5	4
10	2502-336	5/8-11 X 4 CAP SCREW GRADE 5	4
11	2515-336A	HYDRAULIC CYLINDER 3 X 16	1
12	2515-836	BREATHER	1
13	2520-357	1/2-13 LOCK HEX NUT	1
14	2520-360	1/2-20 WHEEL HEX NUT	6
15	2520-459	5/8-11 LOCK HEX NUT	12
16	2520-465	HAIRPIN	4
17	6600-111	HUB/SPINDLE ASSEMBLY	1

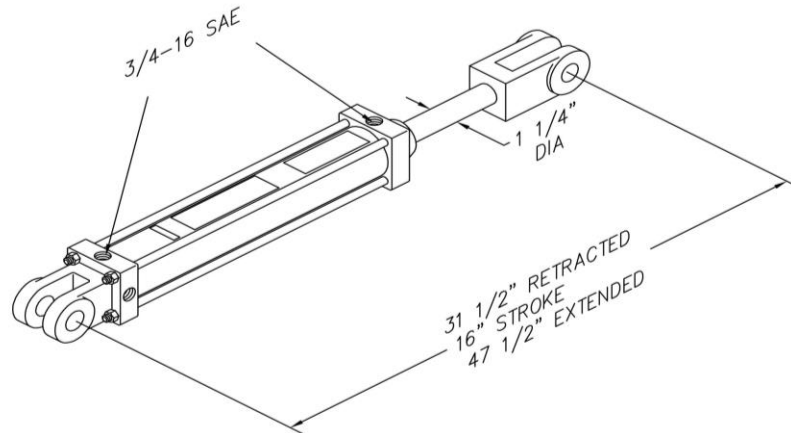
PARTS IDENTIFICATION



PARTS IDENTIFICATION

2515-336

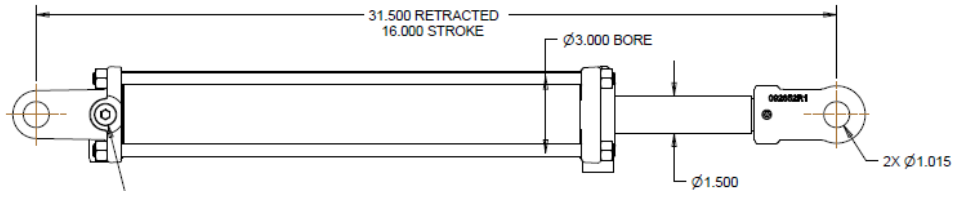
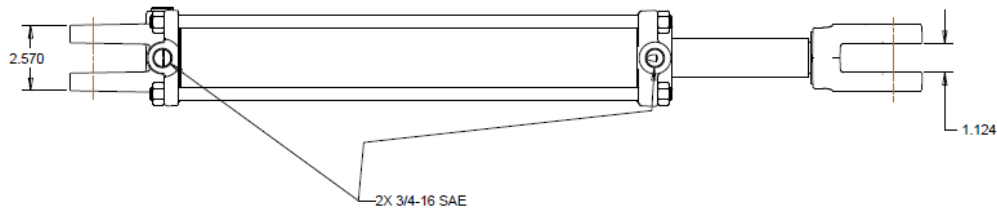
MANUFACTURED 01/2015 TO 12/2025



ITEM	PART #	DESCRIPTION	QTY
1	2515-336	HYDRAULIC CYLINDER 3 X 16 1-1/4" ROD	1
	2515-338	SEAL KIT	

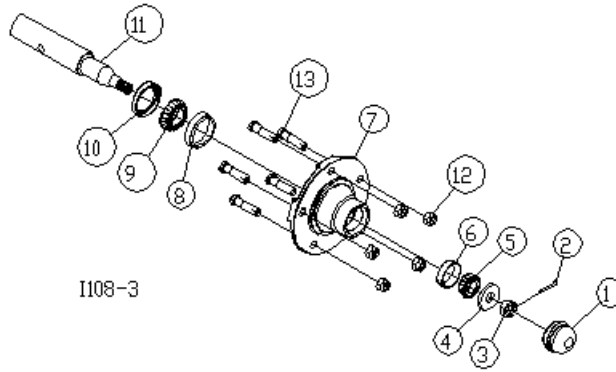
2515-336A

MANUFACTURED 01/2025 TO PRESENT



ITEM	PART #	DESCRIPTION	QTY
1	2515-336A	HYDRAULIC CYLINDER 3 X 16 1-1/2" ROD	1
	-----	SEAL KIT	

PARTS IDENTIFICATION



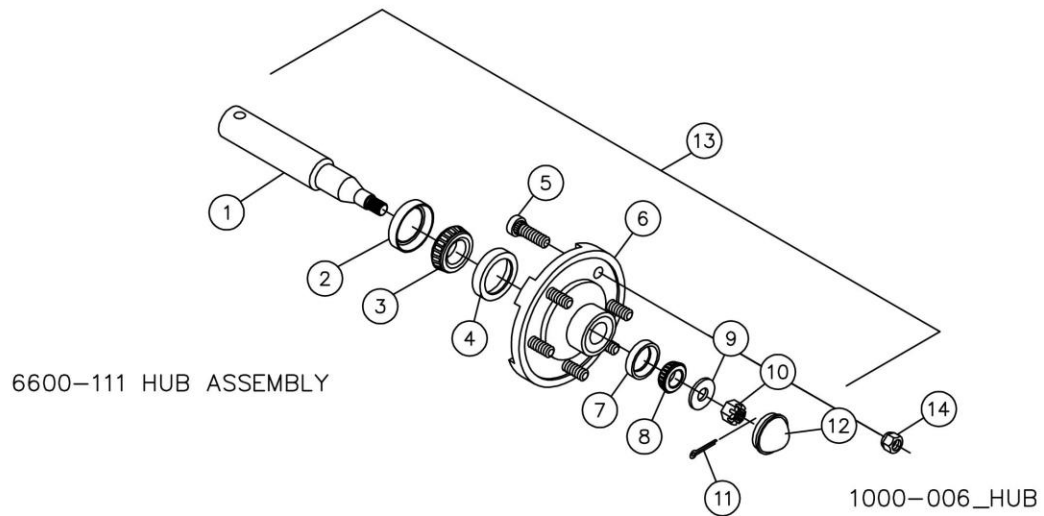
I108-3

3400-374 HUB AND SPINDLE ASSEMBLY

DET	QTY	PART NO.	DESCRIPTION
1	1	2570-308	HUB CAP
2	1	2531-108	5/32 X 1-1/4 COTTER PIN
3	1	2520-469	5/8-18 SLOTTED HEX NUT
4	1	2526-449	5/8 SAE FLATWASHER
5	1	2550-012	CONE (LM-11949)
6	1	2550-013	CUP (LM-11910)
7	1	HUB	4*PILOT 5-1/2" BOLT CIRCLE (NOT A SERVICE PART)
8	1	2550-029	CUP (LM-67010)
9	1	2550-027	CONE (LM-67048)
10	1	2550-115	SEAL (104078)
11	1	3400-378	SPINDLE, 2570-310
12	5	2520-360	1/2-20 WHEEL HEX NUT
13	5	2570-190	1/2-20 X 1.90" HUB BOLT

REVISED 09/09/2020

PARTS IDENTIFICATION



DET	QTY	PART NO.	DESCRIPTION
1	1	6600-336	SPINDLE
2	1	2570-191	SEAL (CR 17617)
3	1	2550-028	CONE LM29749
4	1	2550-030	CUP LM29710
5	6	2570-190	STUD BOLT 1/2-20
6	1	2570-189	HUB W/CUPS-STUDS
7	1	2550-029	CUP LM67010
8	1	2550-027	CONE LM67048
9	1	2526-501	3/4" FLATWASHER
10	1	2520-503	3/4"-16 SLOTTED HEX NUT
11	1	2531-106	3/16" X 1-3/4" COTTER PIN
12	1	2570-192	HUB CAP
13	1	6600-111	HUB ASSEMBLY 6 BOLT 6" B.C.
14	6	2520-360	1/2"-20 HEX NUT

Our name Is getting known

Just a few years ago, Yetter products were sold primarily to the Midwest only. Then we embarked on a program of expansion and moved into the East, the South, the West and now north into Canada. We're even getting orders from as far away as Australia and Africa.

So, when you buy Yetter products . . .you're buying a name that's recognized. A name that's known and respected. A name that's become a part of American agriculture and has become synonymous with quality and satisfaction in the field of conservation tillage.

Thank you.

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