

PERRY

OF OAKLEY LTD

60 YEARS OF EXPERIENCE

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CUSTOMER BENEFITS FROM WORKING TOGETHER

Park Farm near Banbury, Oxfordshire had a new **PERRY** 37 tph M510 continuous flow grain drier and storage handling equipment all installed and operational for the 2006 harvest. Local agent and handling engineers, BK Grain, designed a cost-effective scheme to allow the farm's existing tipping pit and **PERRY** floor store filling system to be retained whilst adding a new drier and conveyor system.

The **PERRY** drier is manufactured at the Devon based factory. Combining latest manufacturing technology to ensure quick and easy on-site assembly, the continuous flow drier features a three-stage burner. Easily adjustable flaps control the percentage of the drier used for cooling or drying, whilst generous inlet points in the discharge section of the drier help with greater grain cooling prior to storage.

In addition to the existing **PERRY** top conveyor and travelling conveyor for store filling, BK Grain recommended additional wet grain storage which was provided by an outdoor hopper bottom silo. Horizontal conveyors were chosen from the **PERRY** store conveyor range with dimple style joints for good mechanical strength and standard plastic flighted chain with a breaking strain of 7,200 lb. The 60 tph in wheat belt bucket elevator is one of the new **PERRY** 220/440 range of high specification elevators designed to offer reliable performance at a competitive price.

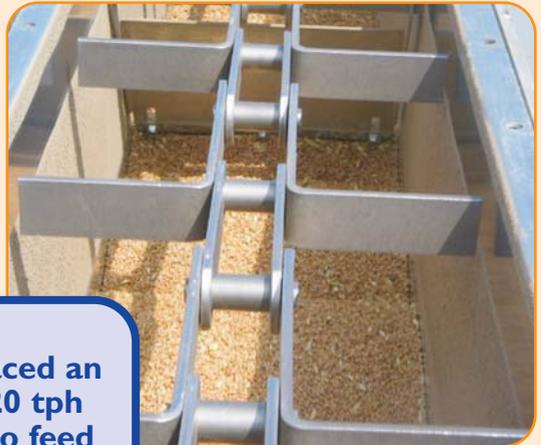
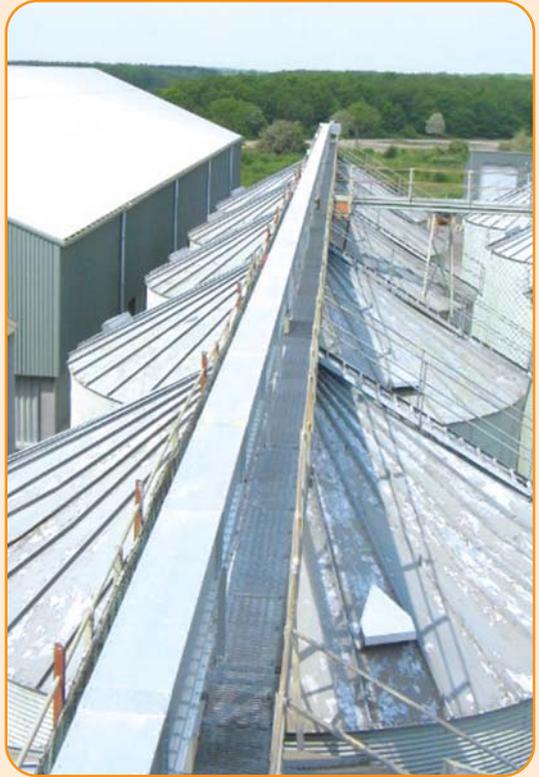


GRAINFARMERS PLC STORE UPGRADE

For 2006 harvest **PERRY** supplied a silo filling conveyor to Grainfarmers Plc. for use at their Honey Pot Grain Store. Grainfarmers is the UK's largest farmer owned arable business and has in excess of 500,000 tonnes of grain storage.

The model 300/45 chain and flight conveyor is 69.25 m overall length and has a capacity of 80 tph (upgradable to 120 tph). One of the most significant features is the 6 inline pneumatically operated outlets with brush gear. The inline outlets do not project from the side of the conveyor like a standard cross slide so the cat walk area for access is not restricted and does not present any health and safety problems associated with climbing / stepping over cross slide outlets on catwalks. The outlets also have stainless steel slides to prevent corrosion.

Other standard features are the 22 kw drive compactly mounted using a 90° gearbox. This allows as much room as possible on the catwalk for access and maintenance. The conveyor is fitted with a steel plate chain with a breaking strain of 25,000 lb fitted cleaning flights every 5 m. Spring assisted tail end tension is designed to smooth out the running of the conveyor and to help maintain correct chain tension.



STOP PRESS

Grainfarmers have just placed an order for a model 330, 120 tph belt and bucket elevator to feed this conveyor.

INDUSTRIAL SPECIFICATION FOR WOLD APPLICATION

Wold Grain Ltd. near Gainsborough, Lincs, needed additional bulk out facilities to handle 120 tph. Working in conjunction with Game Engineering Ltd., **PERRY** was able to supply a curved conveyor that could accept grain from three 250 tonne hopper bottom silos and feed straight into the elevator boot without the need for any groundwork.

The conveyor selected was a 12/12 model with a 4 mm thick base, 3 mm thick sides and a reinforced 15,000 lb breaking strain chain with 10 mm thick plastic flights. To improve joint strength this conveyor now benefits from M8 dimple style joints. All of this equipment was galvanised for outdoor use.

Main features of this 330 model industrial specification belt and bucket elevator :

- Capacity 120 tph in wheat
- All outdoor galvanised construction
- Solid head drum
- Slatted boot pulley
- Fitted SPS buckets onto nitrile rubber belt
- Removable head shaft with bearings and gearbox attached



ALL OUTDOOR GALVANISED CONSTRUCTION

PERRY was asked to supply two 330 model industrial elevators to Craven Grain Storage Ltd. in Leominster, Herefordshire, to replace two badly corroded intake elevators. The site has a total storage capacity of 30,000 tonnes and each elevator handles 12,000 tonnes of grain per year, operating to an overall height of 16.75 m.

These particular outdoor **PERRY** belt and bucket elevators were chosen to improve reliability and provide a longer life expectancy. Using the latest design in elevator buckets fitted to a nitrile, oil-resistant belt. With a capacity of 120 tph in wheat, the elevators feature a solid head drum plus a removable head shaft with the bearings and gearbox in position.



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DUST BUSTER SYSTEM

Marcham Farms of Newbury, Berks, asked Trevor Nash Installations to look at different ways of filling their grain floor store whilst creating less dust than the existing grain blower. Drawing upon **PERRY**'s experience, a model TF300 belt conveyor with a motorised tripper was selected to provide the ability to discharge grain at any position along the store.

The installation also required a 35 tph capacity 7/35 model store conveyor plus an inclined flight elevator, 4912 model, capable of handling 30 tph at 60 degrees inclination.

The final phase of the installation is to add a **PERRY** levelling / travelling conveyor, so that the grain store operator does not need to be present in the store to fill it. The levelling conveyor will provide a completely level fill with minimum operator attention and will allow an extra 250 tonnes of grain to be stored.

PERRY's belt conveyor range spans from 300 mm wide trough form belt conveyors with a capacity of 40 tph to 1000 mm wide roller trough belt conveyors with a capacity of 600 tph. All belt conveyors are designed and manufactured in house. They have a 90° gear motor drive, lagged drive drum, oil resistant belting, galvanised construction with dimple style bolted joints to provide high mechanical strength and the ability to easily span 6 m unsupported.



CORNWALL FARMERS

Cornwall Farmers Ltd., based in Truro, had the requirement for a 45 tph replacement conveyor to carry rolled and crushed products from its mill building into the mixing area, reaching across a 100 ft wide yard.

The selected 12/12 **PERRY** conveyor has a 15,000 lb breaking strain chain with plastic flights, a 3 mm thick base and sides with a 2 mm thick cover. This replaces an existing conveyor and can easily meet the required capacity of 45 tph.



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SAVINGS IN MONEY AND SPACE

J E Alston at Church Farm Nr. Diss, is a perfect example of how to integrate a large capacity drier into an existing grain store complex in the most cost-effective way.

Marrison Agriculture Ltd. working in conjunction with **PERRY** designed the installation of an M508 model 28 tph continuous flow drier outside the existing store and intake pit. It is fed by a 60 tph double lift elevator with two separate legs - one for dry product and one for wet grain. This makes a double saving, both in financial and space terms, when compared to having two separate single lift elevators.



A **PERRY** 6912 flow and return conveyor fills the drier and returns excess grain to the wet storage pit inside the building. There is also a drier discharge conveyor, built into the actual drier hopper, which feeds back into the main floor store system. This reduces the height of the drier by nearly 400 mm.

The roller discharge from the **PERRY** drier allows grain to be discharged both evenly and continually at a steady rate, preventing surges affecting the equipment. The **PERRY** drier is fitted with a 3 stage burner to achieve greater control of heat whilst reducing the need to change nozzles. Also by utilising large diameter fans and silencers the drier is very quiet in operation.



INLINE SLIDES ALLOW A TIGHT FIT

Working in conjunction with TH White Installation Ltd., **PERRY** supplied a 36.3 m long outdoor 230/30 industrial specification conveyor to Ridgeway Grain Ltd., Membury. This conveyor is one of two main intake conveyors transferring product from the main store building out to silo filling elevators and conveyors during the busy harvest period. After harvest-time, the conveyor is operated in reverse mode, transferring product back to the main store building for bulking out.

The heavy duty construction of this conveyor comprises a 4 mm thick steel base and wearstrips. Three in-line pneumatically operated outlets with pneumatically operated brush gear has no side projections, which allowed this conveyor to be fitted as closely as possible to the existing conveyors and elevators. The mild steel plate chain has a breaking strain of 12,700 lb with cleaning flights fitted every 5 m to complete the unit.



EASY INSPECTION AND CLEANING

Wolverhampton & Dudley Brewery is the largest independent brewery in the UK with over 100 years of service to British beer drinkers.

PERRY was asked to supply a new intake conveyor capable of handling dry malt at between 30 and 40 tph. Inclined at 25 degrees and manufactured from stainless steel, a 350 mm diameter U trough screw conveyor was manufactured with specially shaped top covers to retain the characteristics of a tubular screw auger. The easily removable covers also provide the benefit of allowing easy inspection and cleaning.



TROUBLE-FREE PERFORMANCE WITH LITTLE MAINTENANCE ... EXACTLY WHAT A BUSY GRAIN STORE REQUIRES

Somerset based Cannington Grain Ltd. has been a **PERRY** customer for many years. The first equipment supplied was standard agricultural specification: 60 tph conveyors and elevators for outdoor operation fitted with 7,200 lb breaking strain chain. Various models followed including 100 tph belt and bucket elevators as well as 60 tph curved conveyors.

More recently, a main 150 tph industrial specification belt and bucket elevator has been supplied. The head and boot shells are manufactured from 5 mm thick mild steel, the head shaft is removable whilst the gearbox and bearings are attached. This 420 industrial model also has a solid head drum, slatted boot pulley and felt shaft seals. Belt tension is adjusted at the boot.



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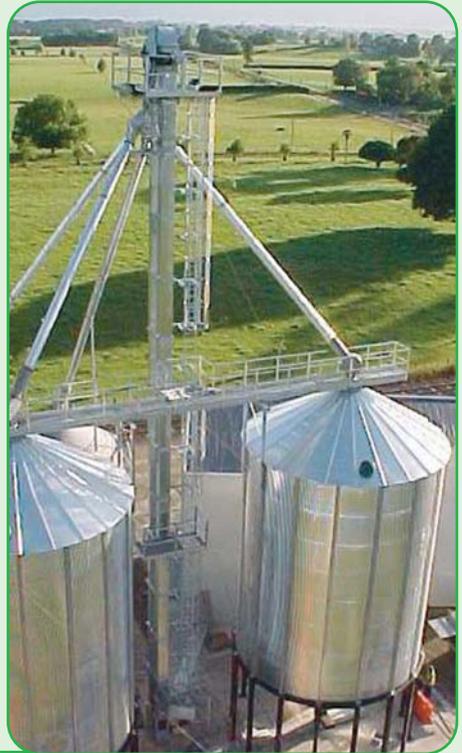
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EXPORT PROJECTS

From the other side of the world, **PERRY**'s were contracted to design and supply a range of industrial handling equipment with a somewhat different specification to take into account. Whilst the products had to be capable of handling maize at capacities of up to 200 tph, the equipment also had to be designed to withstand possible seismic earthquake activity. This was successfully achieved by working with local based civil engineers whilst **PERRY** provided the mechanical data on elevator legging, including compression and side load figures.

The 200 tph intake equipment comprised of a main intake pit with a screw discharger feeding a 420 model belt and bucket elevator, plus a U trough screw conveyor and a second 420 belt and bucket elevator, which had an overall height of 31 m.

The silo emptying and drier feed equipment was all 80 tph. **PERRY** conveyors were the 12/12 model standard specification with a 15,000 lb breaking strain chain, whilst the elevators comprised of two 250F model industrial elevators and two 330F industrial elevators. Again, the overall height was almost 30 m and all of the tall elevators had lagged head drums and rest platforms.



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