

# SILO ERECTION PROCESS



**1** Silo jacks are used for erecting the silo walls.



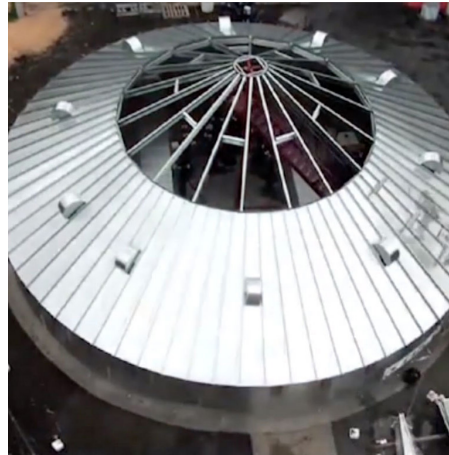
**2** Silo erection stairway attaches to the jinn pole and rotates around the floor area to assist in roof structure and roof panel installation.



**3** After the first two rings of wall sheets are erected, roof rafters and purlins are all attached, then all bolts are tightened.



**4** Lower roof panels are bolted to clips at the eave and fastened to the roof transition strip with self-drilling fasteners. Panels bolt together at the roof ribs.



**5** Upper roof panels bolt to clips at the roof transition strip and attach with a single bolt to the roof segment ring.



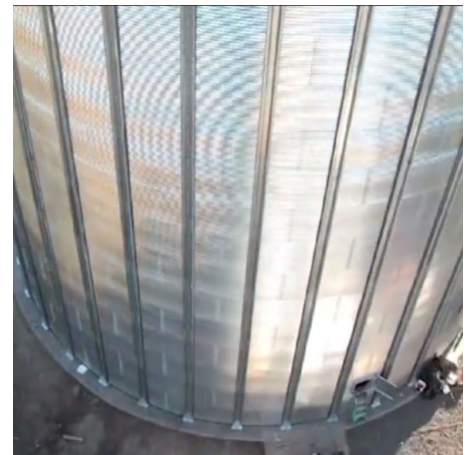
**6** Roof stairway is assembled on the ground and installed.



**7** Catwalk supports, if present, can now be attached to the external stiffeners on the silo wall. Silo wall and assembled roof are raised one ring at a time (1.08 m/3.5 ft per lift) with hydraulic jacks.



**8** Wind rings can now be bolted to the clips at the stiffeners. Wall sheets continue to be added as silo is jacked up one ring at a time. Additional tiers of stiffeners are added after every two rings.



**9** Bottom stiffeners and the bottom stiffer assemblies are installed. Silo is anchored to precast anchor bolts in the foundation.



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