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Faster Receiving, Smaller Piles

BRANCH ELEVATOR ADDS 1.5 MILLION BUSHEL OF STORAGE, NEW PIT, AND LEG



Cooperative Farmers Elevator's recently expanded 2.5-million-bushel branch elevator in Hudson, SD. The leftmost two tanks, legs in between them, and small overhead surge tanks are new. Aerial photo by Judy Hemphill.



Cooperative Farmers Elevator
Ocheyedan, IA • 712-758-3636
Rock Valley, IA • 712-476-5321

Founded: 1899
Storage capacity: 38 million bushels at 22 locations
Annual volume: 30 million bushels
Annual revenues: \$475 million
Number of members: 1,200
Number of employees: 300
Crops handled: Corn, soybeans, oats
Services: Grain handling and merchandising, feed, agronomy, energy, lumber

Key personnel at Hudson:

- Rob Jacobs, general manager/CEO
- Jim Jenson, western regional manager
- Randy Kooima, location manager
- Dave Mullenberg, operations manager
- Troy Bakker, grain operations

Supplier List

Aeration fans..... Rolfes@Boone
Bin sweeps Sioux Steel Co.
Bucket elevators..... Schlager Inc.
Catwalks Warrior Mfg. LLC
Concrete Van Voorst Concrete
Contractor ...LandMarc Construction
Conveyors Schlager Inc.

Distributor..... Schlager Inc.
Electrical contractor..... Ten Kley Electric
Elevator buckets Tapco Inc.
Engineering Nohr Wortmann Engineering
Grain temperature system.. Tri-States Grain Conditioning Inc.
Leg belting.... Continental Pathfinder
Millwright....LandMarc Construction
Motors Toshiba International
Spouting ... Premier Components Inc.
Speed reducers Dodge
Steel storage Behlen Mfg. Inc., Norwood Sales
Steel tank erection Dagal Steel Construction
Tower support system ...Warrior Mfg. LLC

Cooperative Farmers Elevator's (CFE) branch elevator in Hudson, SD (605-984-2224) checked off some items that you'd find on any country elevator's wish list during a \$4.5 million construction project in 2017.

"We wanted to dump faster, and we wanted to pile less grain on the ground," says Location Manager Randy Kooima, who has been with the organization since starting in the grain industry in 1987 (except for a four-year stint in 2004-08, when he worked elsewhere).

Kooima's facility, one of 24 operated by the Rock Valley, IA-based cooperative, is the coop's only South Dakota elevator, located directly across the state line running along the Big Sioux River. The Hudson elevator now can store 2.5 million bushels, most of which goes to the coop's adjacent feed mill.

The 2017 project involved removing a flat-storage bunker to make room for a pair of Behlen 750,000-bushel corrugated steel tanks, two new receiving pits that feed one 20,000-bph Schlagel leg and one 10,000-bph Schlagel



Closeup view of two new Behlen 750,000-bushel corrugated steel tanks, with Schlagel legs and distributor enclosed in a Warrior support tower. Ground-level photos by Ed Zdrojewski.

leg, a Schlagel distributor, and three 6,000-bushel truck-loading surge tanks from Norwood Sales.

CFE took bids on the project and awarded the contract to LandMarc Construction Inc., Hawarden, IA (712-552-1200). "LandMarc is lo-

cated only 11 miles away, and they've done all of our millwright work," Kooima says.

Among the other contractors on the project:

• Dagle Steel Construction Inc., Florence, SD (712-552-1200), erected ►

On-Site Dust Collection Surveys Guarantee Efficiency Improvement



Schenck Process provides engineering services to dust collection users that include on-site air filtration surveys. Program participants receive a full assessment of their current air filtration system along with recommendations on improving efficiencies. Key features of the program include:

- On-site dust collection analysis
- Preliminary drawings of plant/equipment layout to include NFPA recommendations
- Evaluate existing ductwork layout and sizing, duct discharge design and pneumatic transfer system
- Provide quotation for new and upgraded solutions



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the two Behlen tanks.

- Ten Kley Electric, Melvin, IA (712-736-2371), was the electrical contractor.

- Nohr Wortmann Engineering, Yankton, SD (605-665-1214), was the project engineer.

- H. Van Voorst Concrete Inc., Canton, SD (605-764-6033), was the concrete supplier.

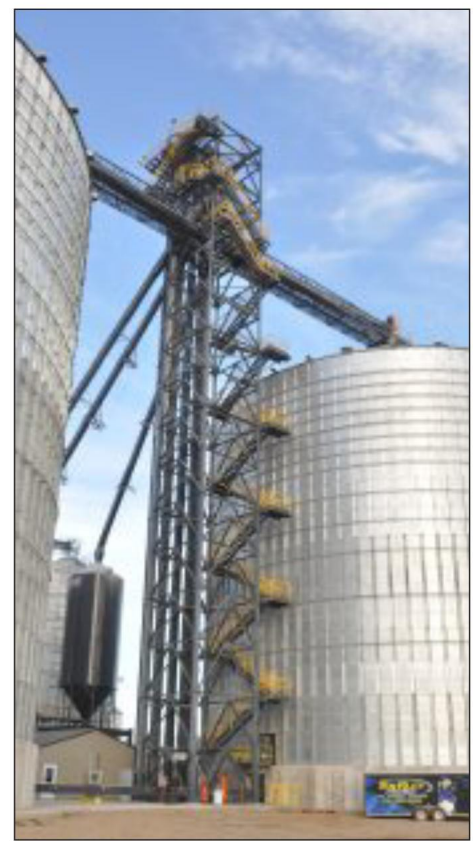
According to Kooima, construction began around April 20 and finished up Sept. 18.

Project Description

The two new Behlen tanks stand 105 feet in diameter, 92 feet tall at the eaves, and 120 feet tall at the peaks.

These tanks are outfitted with Daay zero-entry paddle sweeps and 24-cable TSGC grain temperature monitoring systems. There are no level indicators, but Kooima says the coop plans to add them in the future.

A set of four Rolfes@Boone 75-hp centrifugal fans per tank provide 1/7 cfm



Closeup of two Schlager 20,000-bph receiving legs and six-hole rotary distributor enclosed in a Warrior tower with switchback stairs. One of three Norwood 6,000-bushel surge tanks is visible to the left of the tower.

per bushel of aeration with the assistance of 12 roof exhausters per tank.

To the west of the new tanks is one 300-bushel mechanical receiving pit. This feeds the Schlager receiving legs between the two new tanks. The legs, which are outfitted with 20x8 Tapco low-profile, extreme-duty buckets mounted on 22-inch Continental Pathfinder belts, are enclosed in a 20-inch-x-20-inch Warrior support tower with switchback stairs.

The leg deposits grain into a Schlager six-hole rotary double distributor, with 20-inch Premier Components ceramic-lined spouts. The spouts send grain onto 30,000-bph Schlager drag conveyors running out to storage or down via gravity to the three Norwood surge tanks for truck loading.

The new tanks empty onto 10,000-bph Schlager drag conveyors in above-ground tunnels. These run to a 10,000-bph Schlager reclaim leg lifting grain back up to the distributor or the 20,000-bph leg.

Kooima says future plans call for the addition of four more Behlen 750,000-bushel tanks, a smaller wet tank, and a dryer.

Ed Zdrojewski, editor

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