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## SERVICE BULLETIN

MANDATORY

FIX ON FAILURE

INFORMATION ONLY

Ref: SRV-018-002 REV

Date: 5-14-18

Product: AirFlex 200 Series and SDX series

**Re:**

**Problem:** On Model Year 2018 AirFlex headers the knife speed was increased by changing the knife drive pulley to a 9.88" pulley. Due to different lower jackshaft speeds on John Deere combines, the speed must be verified when installing the AirFlex on the John Deere combine.

**Solution:**

There are a couple of different feeder-house configurations on the JD that could affect the knife speed on the AirFlex. Due to the different speeds of lower feeder-house jack shafts it may be necessary to change the pulleys on the right-hand GT case. On the variable speed feeder-house we need to make certain that the feeder speed is set correctly. The lower jack shaft speed should be set at 490 RPM. This is the speed of the fixed speed feeder house on Model Year 2012 and above. **This is why it is important to check the lower jack shaft speed on the combine before installing an AirFlex header.**

On Model year 2011 and below the lowest speed for the jack shaft is 520 RPM. That is why when a Model Year 2018 and above header is installed on the older JD combine the front pulley on the Right-Hand GT case, Item 2 Figure 1, must be changed.

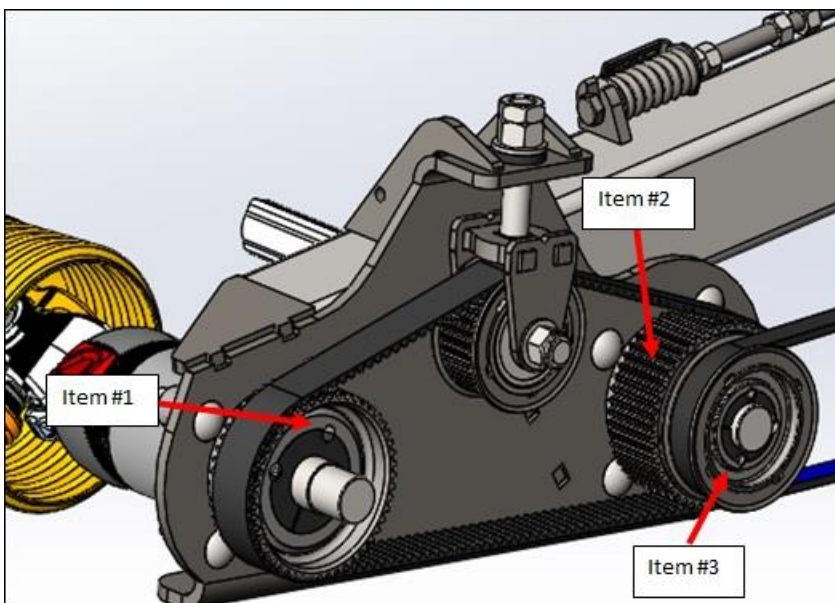
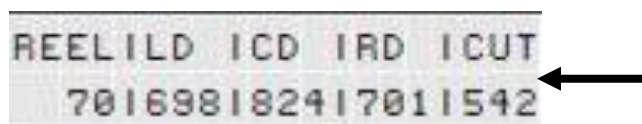


Figure 1

The pulley must be a 47T instead of a 45T on any John Deere combine with a jack shaft speed of 500 RPM and above. The following chart shows the pulley size, location and the knife speed that will be obtained.

	Rear pulley (from back of table) (Item #1)	Pulley PN	Front Knife Drive Pulley (Item #2)	Pulley PN	Front Draper Drive Pulley (Item #3)	Knife Speed (RPM)
JD 490 FDR House Speed (variable speed)	56T	101450	45T	101447	40T (PN#101453)	602
JD 520 FDR House Speed (MY2011 and older)	56T	101450	47T	203059	40T (PN#101453)	612

After the changes are made and the header is mounted on the combine check to make sure the knife speed is correct. This can be done by going to the info screen on the monitor for the AirFlex 200 and scroll to the speed display as shown in Figure 2. The speed of the knife should be very close to the knife speed listed in the chart.



**Figure 2**

On the SDX headers it will be necessary to use a hand-held tachometer on the lower knife drive pulley.

#### Ordering Information:

The headers with a John Deere adapter will be shipped with a 45T pulley in the number 2 position. If the combine has a jackshaft with a speed of 500 RPM or above Then the 45T pulley must be replaced with a 47T pulley.

Qty	Part Number	Description
1	203059	47T Pulley

**Labor Allowance:** N/A

**Note:** Use caution when using the tachometer on the lower pulley.

**Note:** This change is not covered by warranty.