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SERVICE BULLETIN

MANDATORY	FIX ON FAILURE	INFORMATION ONLY

Ref: SRV-019-007 **Date: 8-07-19**

Product: SDX AirFlex Header

Problem:
When the bell cranks are timed with the bell crank front face parallel the nuts on the end of the knives may touch each other while running.

Solution:
A new timing procedure for the SDX headers has been developed.
Note: This procedure can also be used on the 200 series headers to retain the same process though out the product line.

To maintain the clearance the length of the right-hand pitman arm must be changed. The right-hand pitman arm is screwed further into its ball joint. This pulls the RH knife further to the outside and does not allow it to stroke as close to the LH knife when they come together.
The timing procedure is as follows:

a. Run a long bolt or rod through the alignment hole of the two flywheels to keep them aligned with each other. Figure 1
b. Adjust timing on pitman arms so bell cranks are parallel with timing bolt installed on flywheels. Figure 2
c. Once bell cranks are parallel screw RH pitman arm in (clockwise rotation looking at back of pitman arm) 3 turns.
d. Apply Loctite to jam nuts and tighten them.

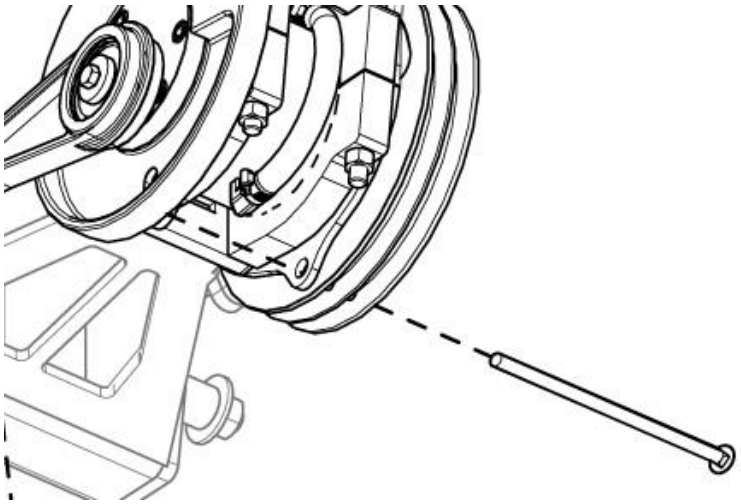

Figure 1

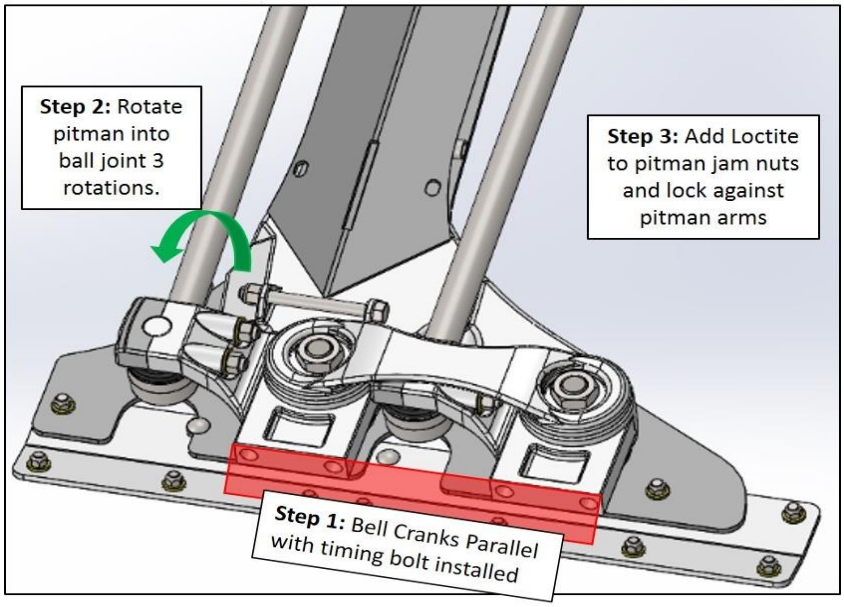

Figure 2

e. This timing procedure will give ¼" clearance between the ends of the SDX knives. With the knives running at full speed this gap reduces to approximately 1/8" clearance. Figure 3

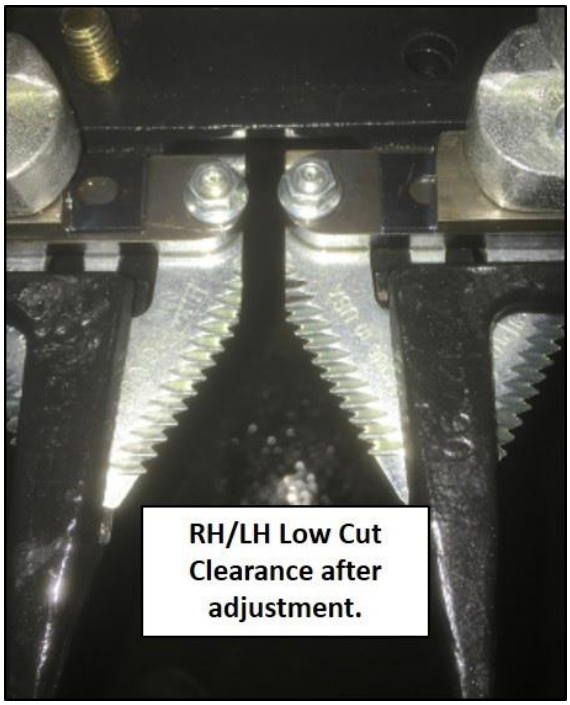

Figure 3

Ordering Information: No new parts are required

Labor Allowance: N/A