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## SERVICE BULLETIN

MANDATORY

FIX ON FAILURE

INFORMATION ONLY

Ref: SRV-020-003

Date: 3-17-20

**Product:** AirFlex 200 Series and SDX Headers

**Upgrade Available At Customers Cost**

**Problem:** New Chain drive for center deck.

**Solution:** On model year 2020 headers the center deck drive has been changed from a belt drive to a chain drive. The new chain drive will provide a more positive drive in tough crop conditions. Figure 1.

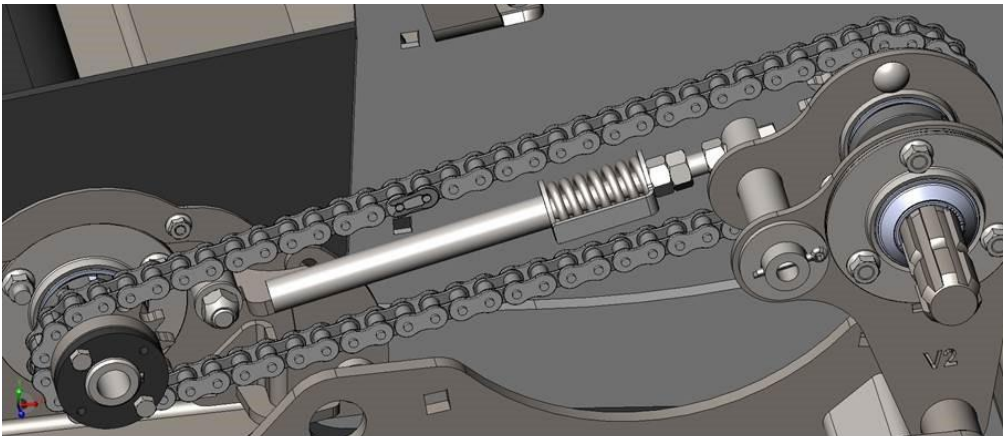


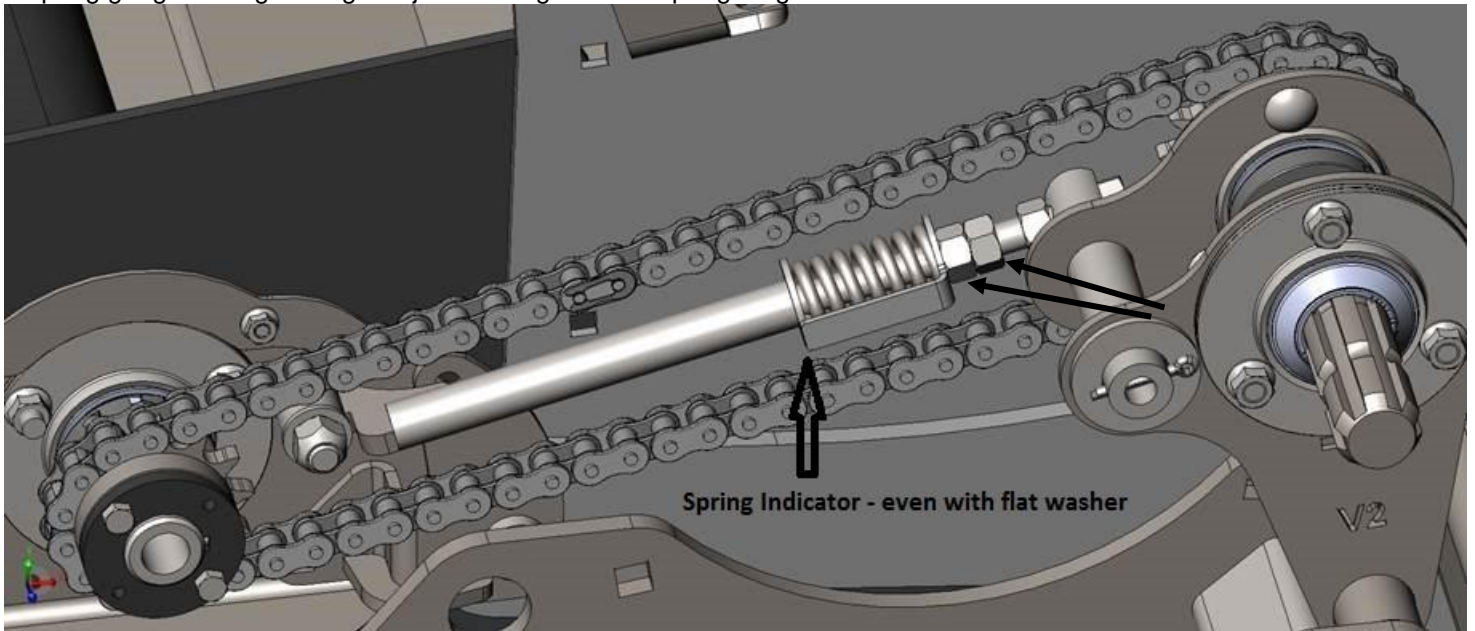
Figure 1



### IMPORTANT!

Re-check the center draper drive chain tension when the header is lifted off the ground by the combine and when the tilt cylinder is retracted as this may change the geometry of the center draper drive system.

The chain drive replaces the belt drive and should also be easier to keep the drive adjusted. The drive is adjusted using a spring gauge and tightening two jam nuts against the spring. Figure 2.



**Figure 2**

Conversion kits are available to up-grade older units to the Model Year 2020 configuration.

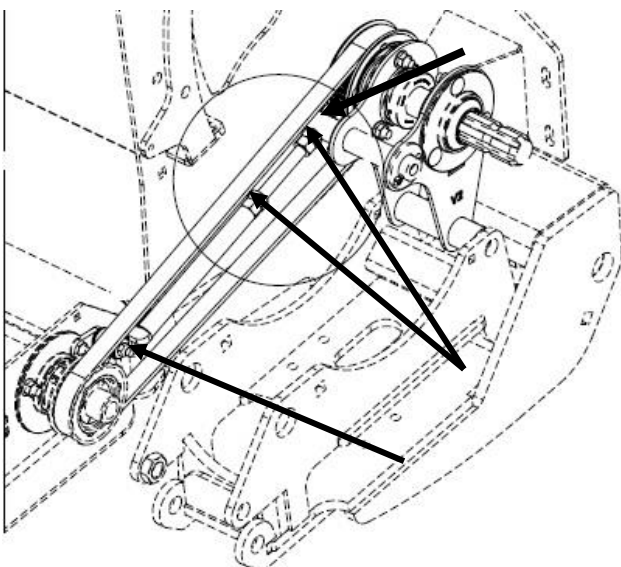
**Note:** There are two different kits depending on the year the header was made. One kit for a Model Year 2019 header and one kit for a Model Year 2017/2018 headers.

**This kit can not be installed on any header that is a model year 2016 or older header or any header that had a Model Year 2016 subframe installed.**

#### **Installation Instructions:**

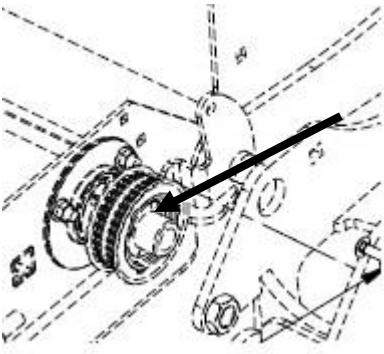
##### **Model Year 2019**

- Remove the belt by loosening the adjustment rod Figure 3
- Remove the adjustment rod from the lower mounting point.
- Remove the belt from the lower pulley.
- Remove the idler assembly by removing retaining bolt for the pivot pin on the idler assembly and remove the pin. This will allow you to pull the idler assembly off the subframe. Leave the tension bolt in the pivot.
- Remove pulley and hub from idler assembly.



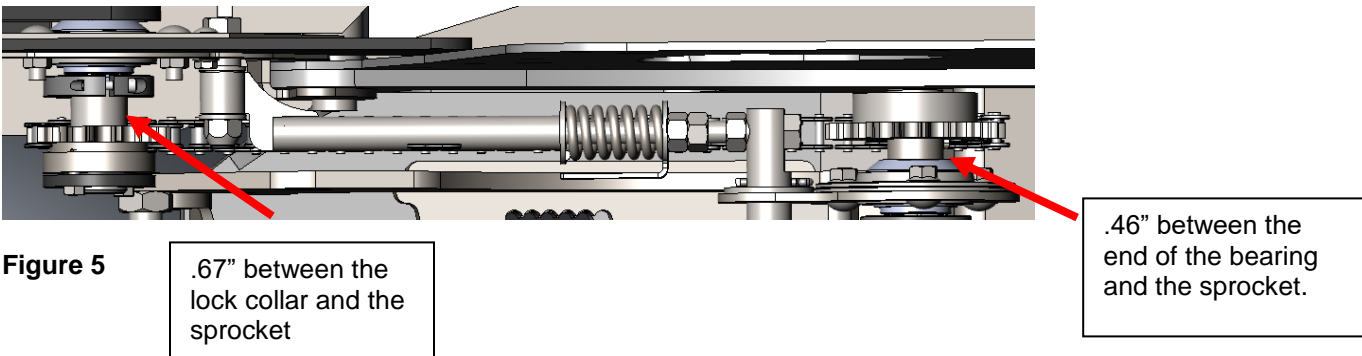
**Figure 3**

- Remove center deck drive pulley and hub. Figure 4



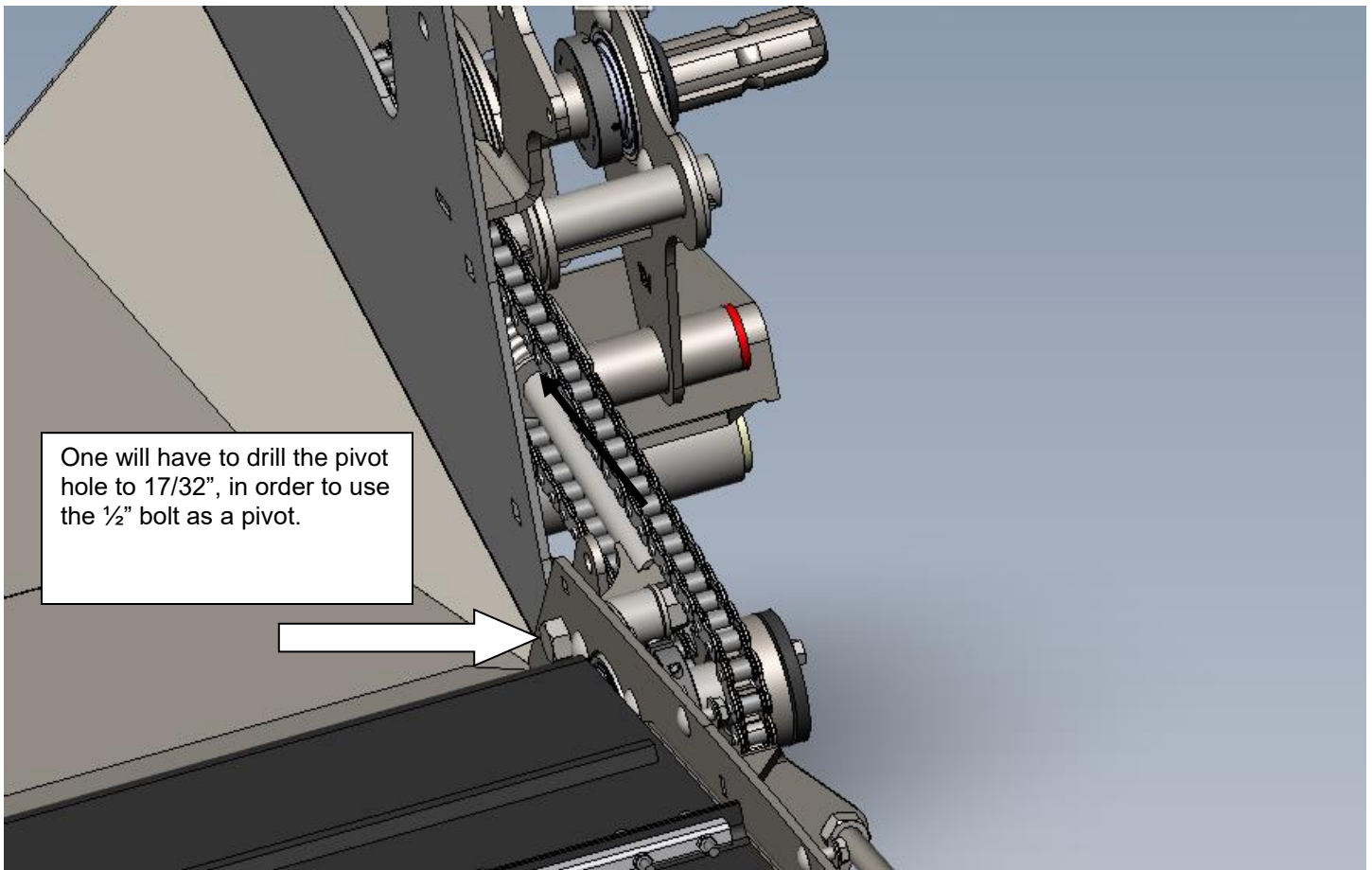
**Figure 4**

- Install the 18-tooth sprocket and hub on the idler assembly. The sprocket needs to be located 0.46" away from the end of the bearing as shown in figure 5.
- Tighten the setscrews on the sprocket on the assembly to 15 ft. lbs. with red Loctite.
- Install the 14-tooth sprocket, hub and key provided on the center deck drive roller. Note: This hub has a flange on it.
- Install it approximately 0.67" away from the bearing collar as shown in figure 5
- Adjust the spacing of the sprockets as shown in Figure 5.
- Tighten the hub bolts on the center deck sprocket hub to 8 ft. lbs. While tightening the 1/4" bolts tap the end of the hub. This will help seat the tapered hub into the sprocket.

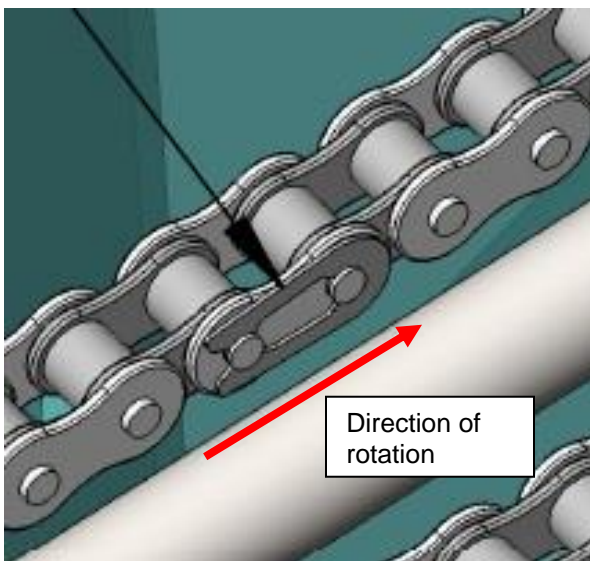


**Figure 5**

- Install the jack shaft assembly back on the subframe and attach with the pin and lock the pin in place with the bolt. Make sure the bushings are still in the pivot.
- Install the spring, indicator, and lower adjusting rod to the tension bolt.
- Secure the tension rod to the lower pivot. When installing this kit on a MY2019, one will have to drill the pivot hole to 17/32". The new chain kits will use a 1/2" bolt as a pivot, rather than the 5/16 carriage bolt that was originally used when this kit was released. Figure 6
- Install the chain and double check the sprockets are aligned with each other. Make sure the connector link is installed as shown in Figure 7.
- Make certain that the sprockets are aligned so the chain will run straight.



**Figure 6**



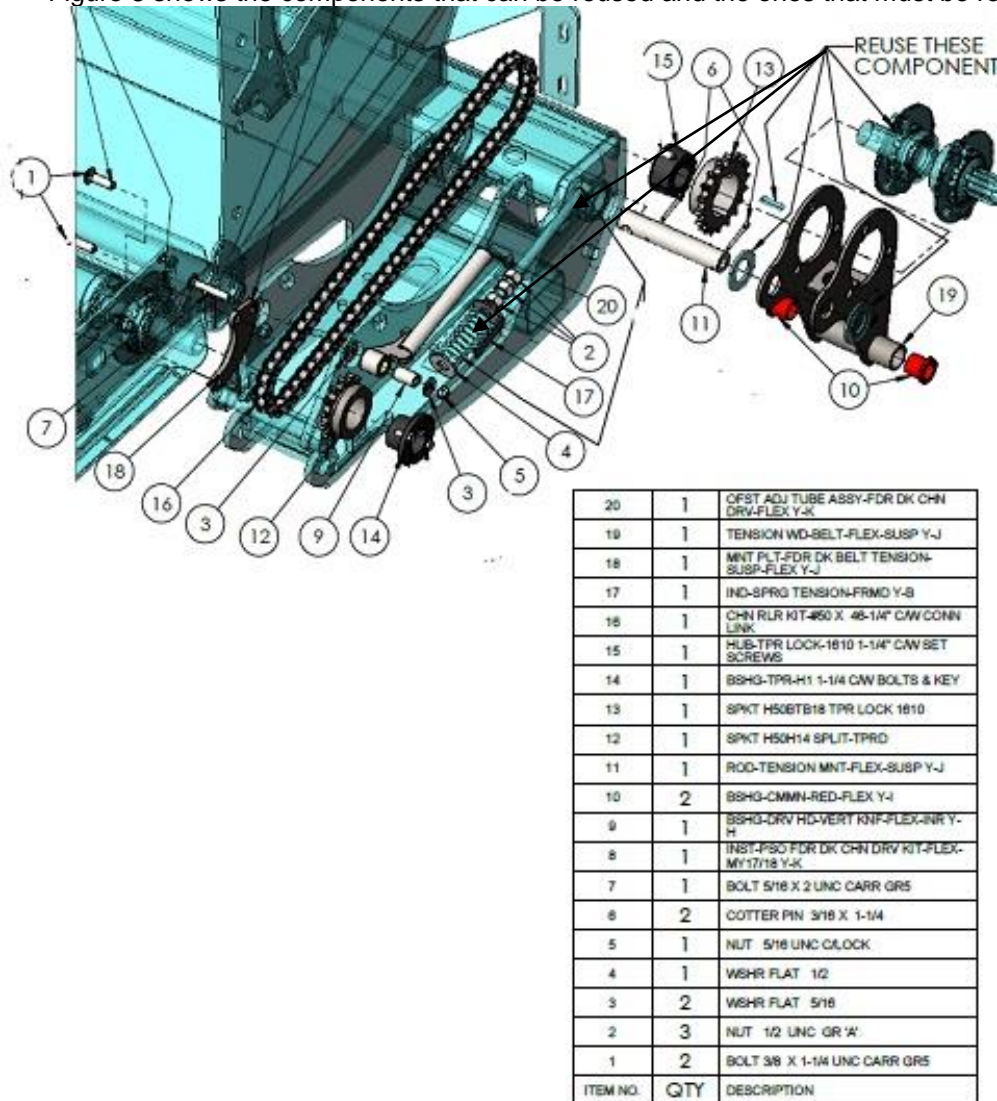
**Figure 7**



## Installation Instructions

### Model Year 2017 and 2018

- The Model Year 2017 and 2018 kit requires more components to change to the chain drive.
- Figure 8 shows the components that can be reused and the ones that must be replaced.



**Figure 8**

- Remove all the belt drive components from the subframe. Figure 9
- Disassemble the shaft from the jack shaft mount.



Figure 9

- Assemble the shaft and spring pivot mount into the new jack shaft mount. Install the outside bearing and shaft assemble in the mount and then install the inside bearing. Figure 10
- Tighten the lock collar set screw to 97 in. lbs. Install the key back in the idler shaft.
- Install the spring tension mount shaft in the jack shaft mount. Install the tension bolt in the pivot shaft and place the lock nuts loose on the bolt.
- Install the 18-tooth sprocket and hub on the idler assembly. The sprocket needs to be located 0.46" away from the end of the bearing as shown in figure 5.
- Install the bushings in the idler mount pivot and install the assembly back in the subframe.

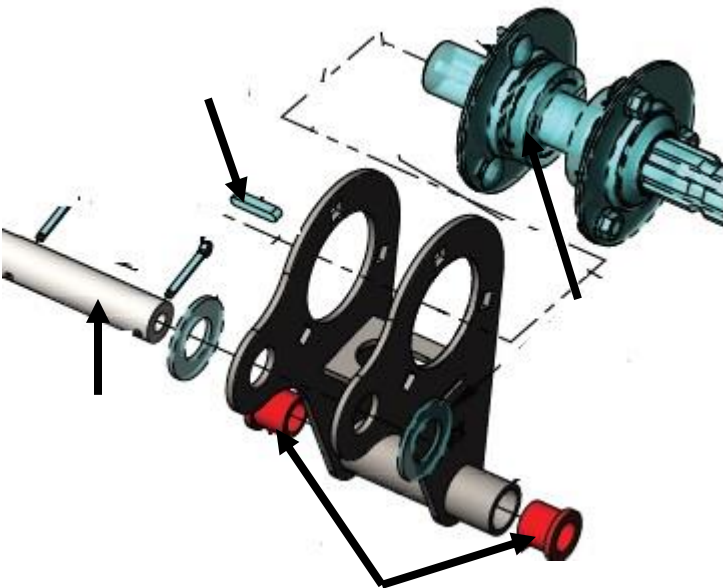
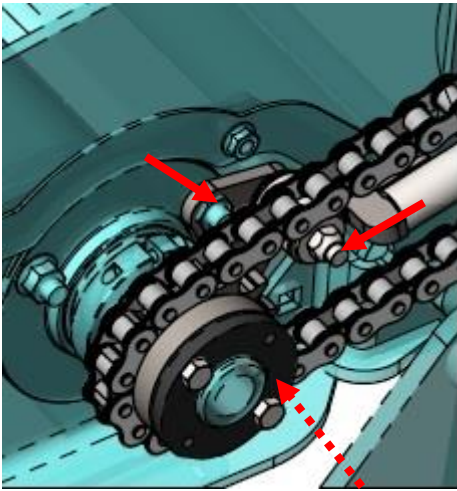


Figure 10

- Install the Chain tension mounting plate on the rear drive roller for the center deck. The mounting plate is attached to the top RH and bottom bearing flange with the new mounting 3/8 X 1 1/4" Carriage bolts provided. The 5/16 X 2" carriage bolt goes through the center deck frame and the mounting plate. Figure 11
- Install the tension rod and spring assembly
- Attach the lower end of the tension rod on the 5/16" X 2" carriage bolt with a bushing, washer and nut. Figure 12.



**Figure 11**



**Figure 12**

- Install the 14-tooth sprocket, hub and key provided on the center deck drive roller. Note: This hub has a flange on it.
- Install it approximately 0.67" away from the bearing collar as shown in figure 5
- Install the chain with the master link as shown in figure 7.

### Chain adjustment and lubrication (Model year 2017-2019)

- Retract the tilt cylinder so the subframe is pulled to the rear.



## IMPORTANT!

Re-check the center draper drive chain tension when the header is lifted off the ground by the combine and when the tilt cylinder is retracted as this may change the geometry of the center draper drive system.

- Make certain the top jam nut is tight against the spring tension pivot rod. Adjust the lower two jam nuts until the spring gauge is aligned with the washer at the end on the spring. Figure 13
- Lubrication is not required during the use season. The chain must be well lubricated before the header is put in storage.

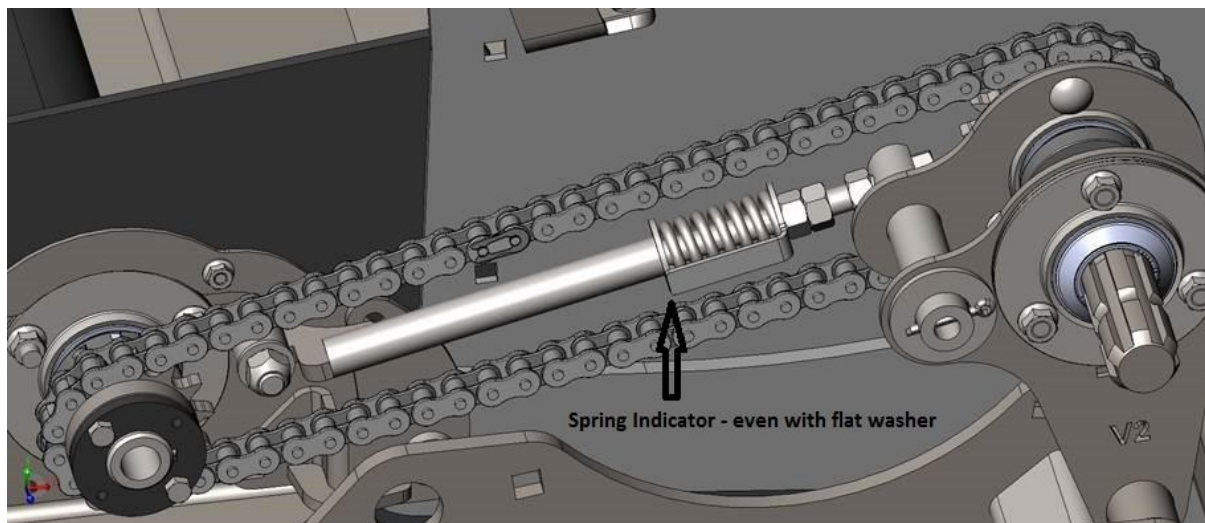


Figure 13

#### Ordering Information:

Qty	Part Number	Description
1	95191	Model Year 2019 Chain Drive Conversion Kit
1	95192	Model Year 2017/2018 Chain Drive Conversion Kit

Labor Allowance: N/A