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SERVICE BULLETIN

MANDATORY X	FIX ON FAILURE	INFORMATION ONLY

SRV 09-011 **Date: Dec. 30, 2009**

Product: Grain Belt WS 2009.

Re: Valve block replacement.

Please note: This bulletin pertains to 2009 Honey Bee Grain WS tables only.

Problem: Inadequate oil flow causing poor header performance.

Solution: Replace existing aluminum block and remove 50/50 flow divider.

Ordering Information:

Parts Required

Qty	Part #	Description
1	27734	Valve Block.
1	69663	Hose 48” 10FJX-12FJ.
1	79367	Hose 20” 12FJ-12FJ.
1	21228	12MJ-12MJ (2 required if single knife drive).
1	26815	12MJ-12FJ Elbow.
1	21113	10MJ-10FJ Elbow.

Labor Allowance: 2 hour.

Reimbursement: Full credit for parts as well as labor allowance will be issued when a completed warranty claim has been submitted to Honey Bee Mfg. Ltd. Claim must include the **serial #** of the unit updated, **service bulletin number** as well as **part numbers** and **quantities** purchased.

2009 WS Valve Block Replacement And Plumbing Modification
Instruction for service bulletin SVR 09-011

NOTE

All fittings in old block will be re-used in new block.
Knife speed to be reduced to 600-620 rpm.

Tools required.

- Wrenches up to 1 ¼ inch.
- Brake cleaner.
- 12 MJ caps and plugs (to reduce leakage and clean up).
- Hydraulic oil to top up tank (minimal or none required).
- Hydraulic flow meter (required when converting 4995 power unit).

Directional Reference: As sitting in cab. Front = towards Knife, Back = towards cab.

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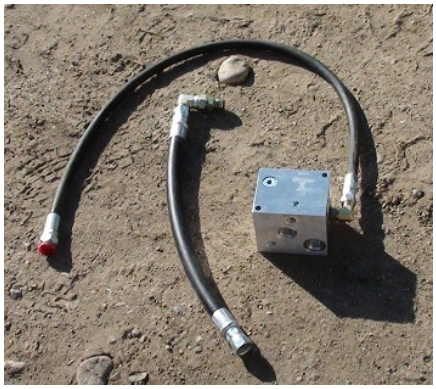
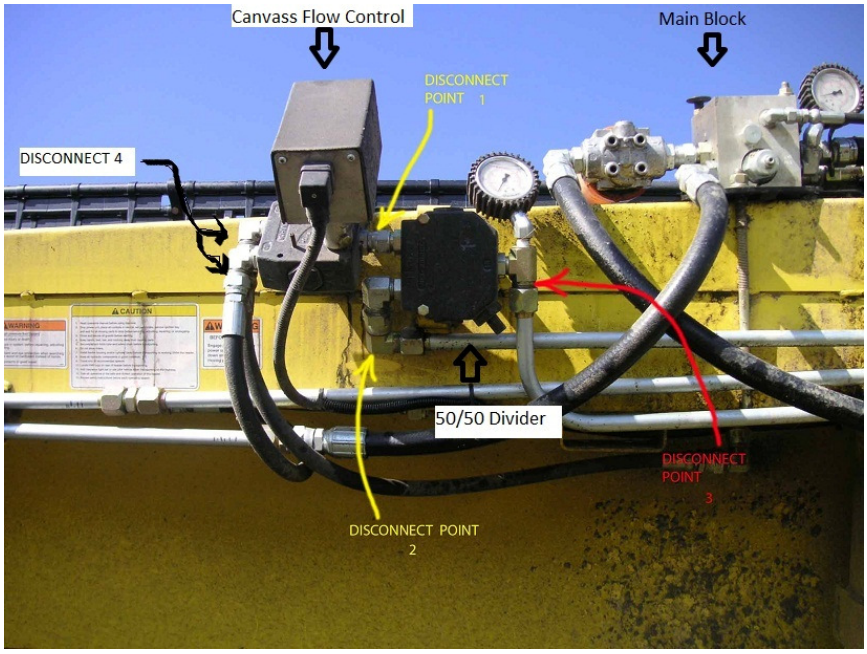
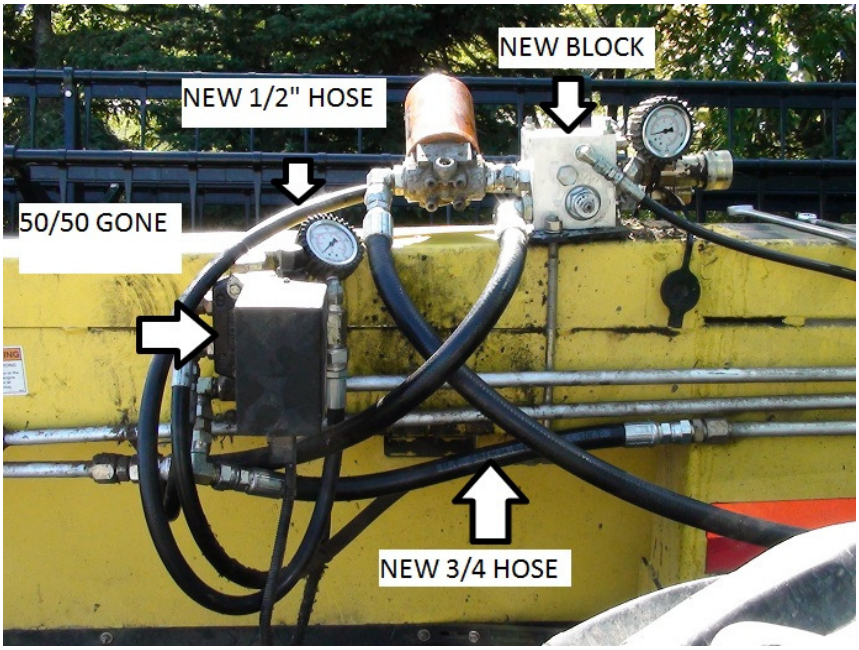


Current Setup

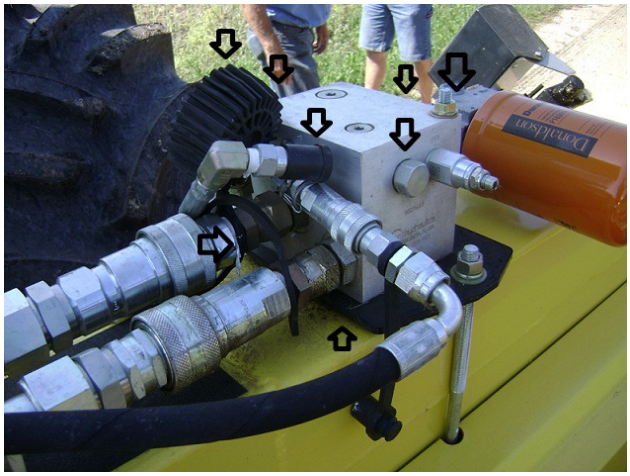


Set Up When Complete

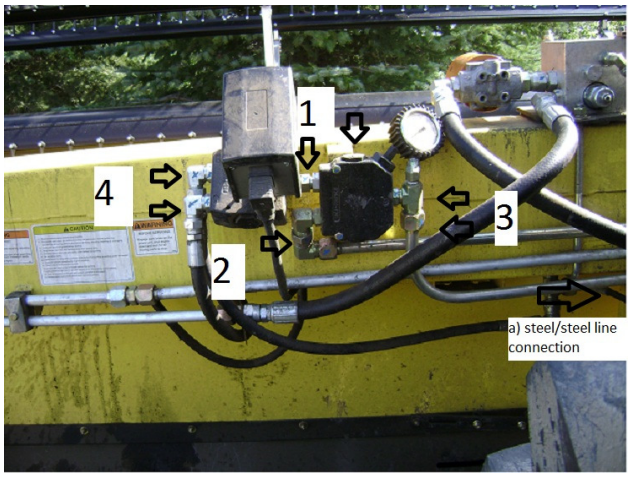


Instructions: Follow instruction order for ease of disassembly and re-assembly.

1) Release float (windrower) and uncouple the three quick coupler connections on aluminum valve block.
2) Aluminum Block
    a) Loosen and remove all fittings, noting each location for installation on new block.

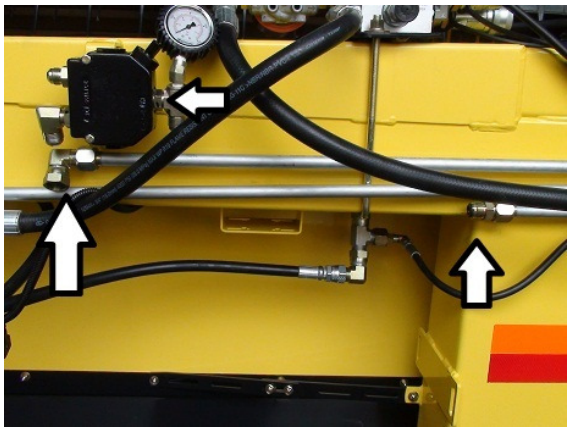


3) Flow Control Area
    a) Remove electric motor on canvass flow control and hang out of way (set screw and 1 mounting nut/bolt).
    b) Remove 2 hoses left hand side of canvass flow control leaving 90 degree fittings installed but loose (note orientation of hoses for later install).
    c) Remove flow control from 50/50 flow divider, fully remove fitting on right hand side of flow control (gauge will later be installed in port).
    d) Disconnect steel line at bottom of gauge tee, on left side of 50/50 (pivot line bent at 90 degrees but leaving it attached strut end).
    e) Loosen gauge tee fitting into 50/50 flow divider for later removal.
    f) Remove 50/50 flow divider as well as attached gauge and tee. (gauge and tee to be installed in canvass flow control).
    g) Remove steel line 90 bend at connection by left hand strut.

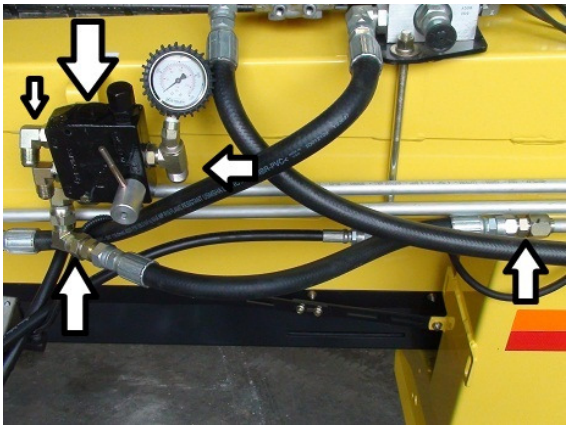


4) Install Flow Control
   a) Install new ¾" hose between two steel lines.
   b) Attach Gauge to side of canvass flow control, Gauge pointing up (tighten later).
   c) Mount Flow control where 50/50 flow divider had previously been installed (tighten).
   d) Re-install two hoses on LH side in same location previously removed from.

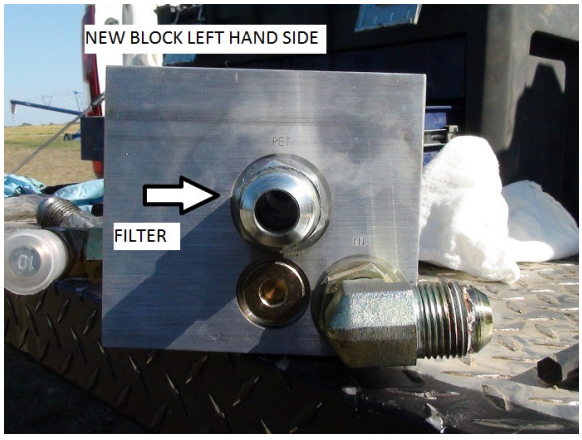
Before

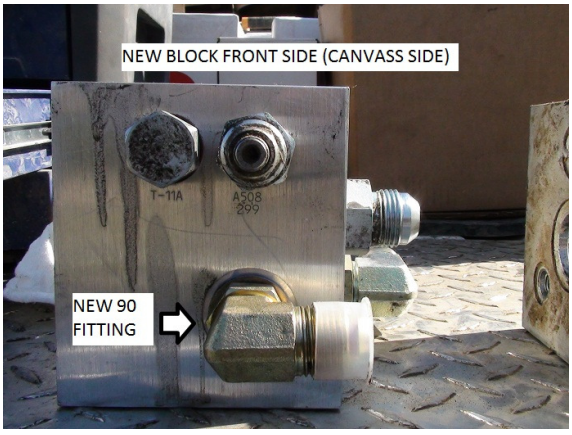


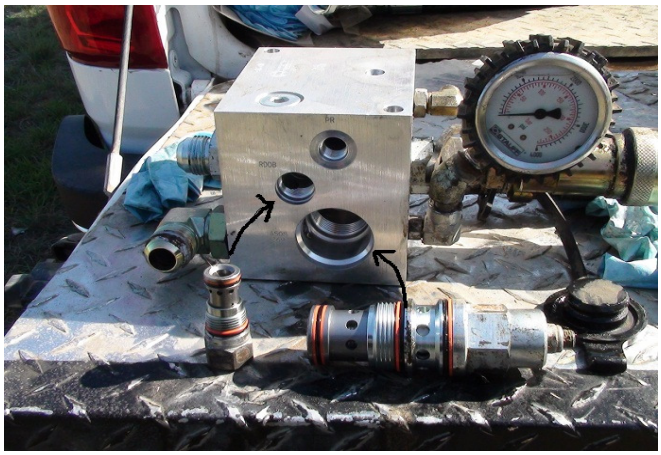
After

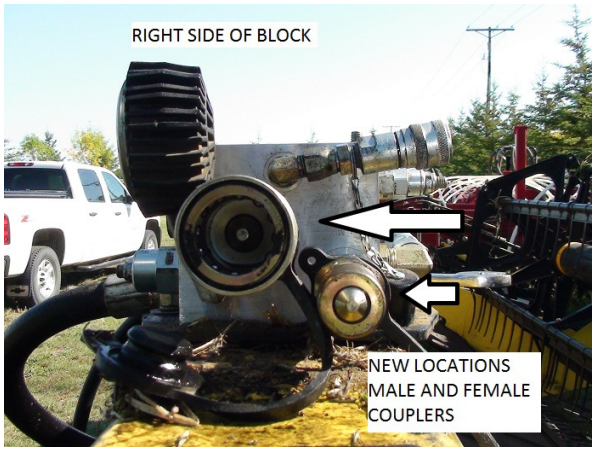


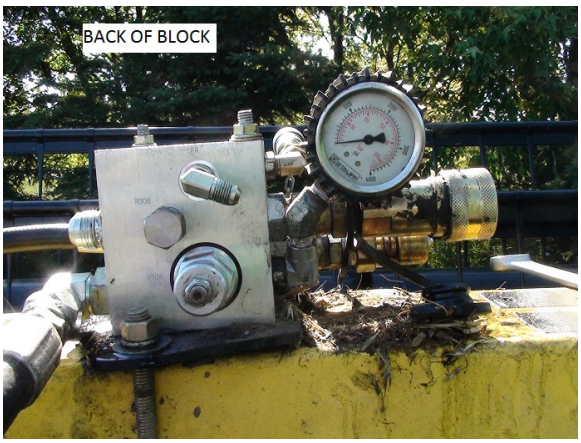
5) Install new Block
   a) Install Gauge on Right Hand side (marked G)
   b) Install 90 degree fitting on Left Hand side
   c) Install new 90 degree fitting on Front side
   d) Install Block on Mount Plate
   e) Re-install all other fittings
   f) **NOTE- male coupler is to be installed in front port and female coupler in back port.**



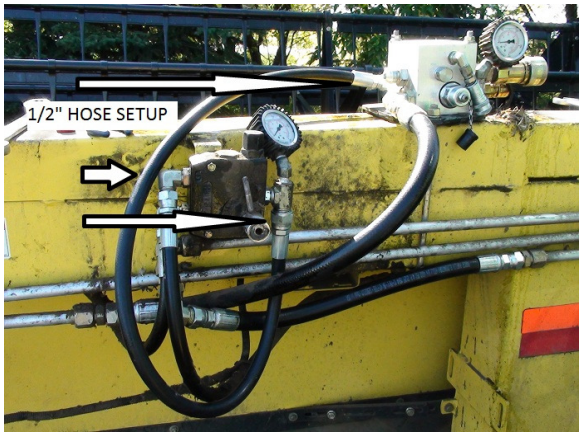


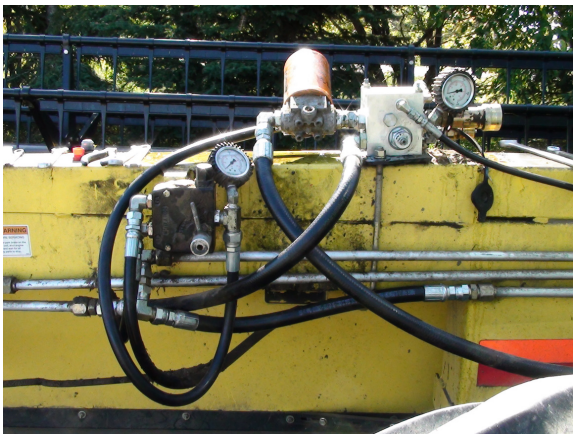




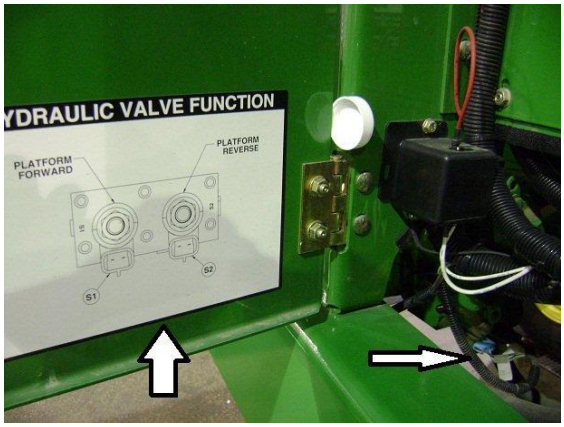


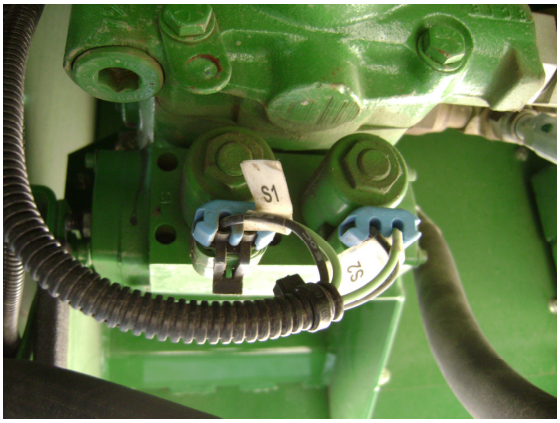
6) Install new smaller line from front of block (90 degree fitting) to bottom of gauge tee. Tighten gauge fitting into flow control. Turn gauge to face cab if possible.
7) Reconnect the 3 quick coupler fittings on main block to power unit.





8) Reverse solenoid S1/S2 (4895 only) table will now run off front side of pump.





NOTE

Refer to last page of this document for pump settings on 4995.

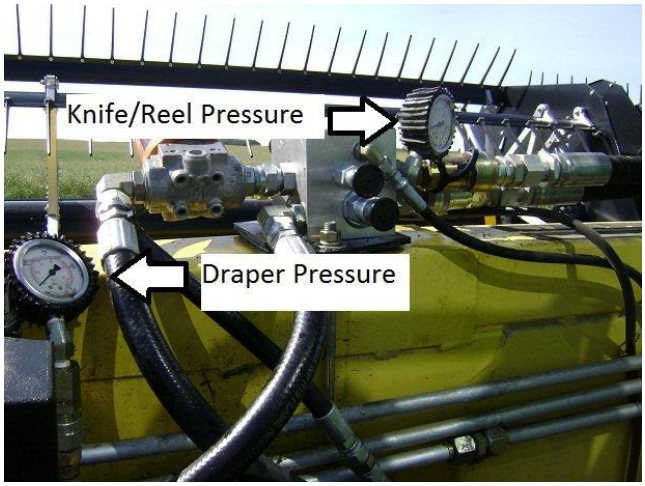
9) Adjust reel speed and draper speed relief settings to expose approximately four threads.

Draper

Reel

10) Set Knife speed **600-620** using power unit monitor. Speed adjustments made using large cartridge on main valve (large cartridge point towards the cab).

11) Gauges now. Left Hand Draper pressure, Right Hand Knife/reel.



12) Operation

- Start unit and reset float.
- Start up header and check for hydraulic leaks.
- Canvass will not engage until full rpm, this is normal.
- Run at full rpm.
- Pressures when operating should be around 1500-2300 on main and 1500-1800 on Draper but can fluctuate.

NOTE

4995 Pump Settings (proper knife speed to **600-620**).

- Adjust flow by rod underneath power unit.
- Will need flow meter hooked into front quick coupler on table to read flow.
- Lengthening adjustment rod increases flow, shortening adjustment rod decreases flow.
- 27-29 gpm. Required.
- **Note: power unit oil flow may already be set in proper range.**
- Adjust reel speed and Draper flow controls to 4 threads. Tighten.(as per 4895 instructions).