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SERVICE BULLETIN

MANDATORY	FIX ON FAILURE X	INFORMATION ONLY

SRV 09-012 **Date: Dec. 31, 2009**

Product: Grain Belt WS 2008.

Re: Plumbing modification.

Please note: This bulletin pertains to 2008 Honey Bee Grain WS tables only.

Problem: Inadequate oil flow causing poor header performance.

Solution: Modify plumbing and remove 50/50 flow divider.

Ordering Information:

Parts Required

1		INSTRUCTION MANUAL (8 pages)
1	19499	BOLT 3/8 X 1 UNC
1	19922	WASHER FLAT 3/8
1	19950	WASHER LOCK 3/8
1	21228	NIPPLE 12MJO-12MJO
1	21231	PLUG-HEX HEAD 12MB
1	21333	PLUG-HEX HEAD 6MB
1	21687	TEE 12MJO-12MJO-12MJO
1	21691	ADAPTOR 10MJ-12FJ
1	21777	ADAPTOR 6MJ-12FJ
1	26815	ELBOW SW 12MJO-12FJX-90
1	69663	HH08 48 10FJX-12FJX
1	79367	HH12 20 12FJX-12FJX ELIM
1	27908	PLUG/CARTRIDGE
1	G82773	FILTER MOUNTING PLATE

Reimbursement: Full credit for parts 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.

2008 WS Valve Block And Plumbing Modification
Instruction for service bulletin SVR 09-012

NOTE

Knife speed to be reduced to 600-620 RPM.

Tools required.

- Wrenches up to 1 ¼".
- 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.

Parts Required:

1	19499	BOLT 3/8 X 1 UNC
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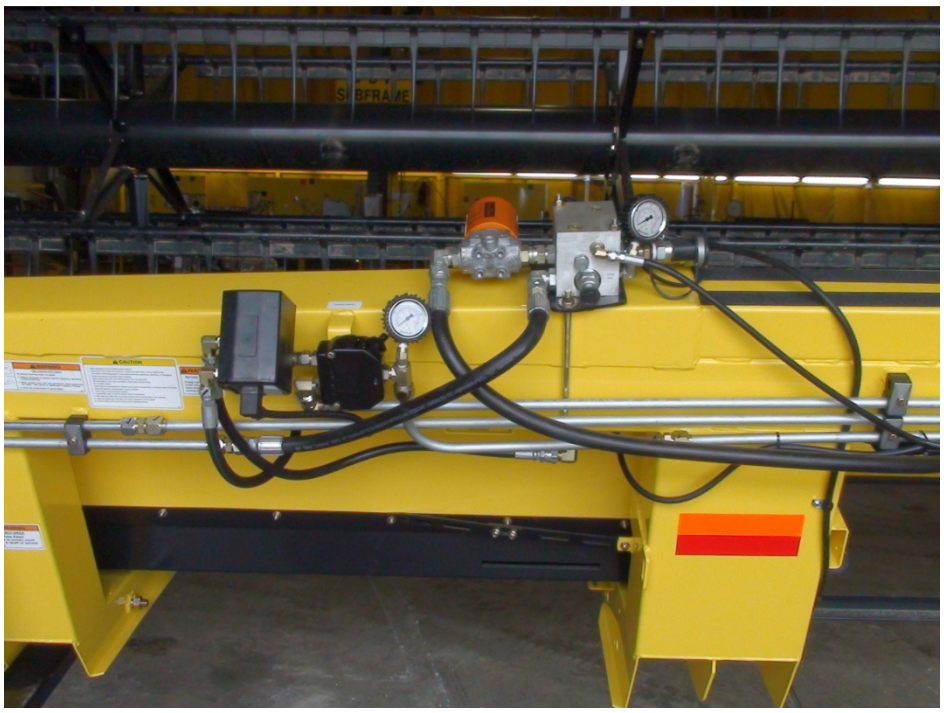
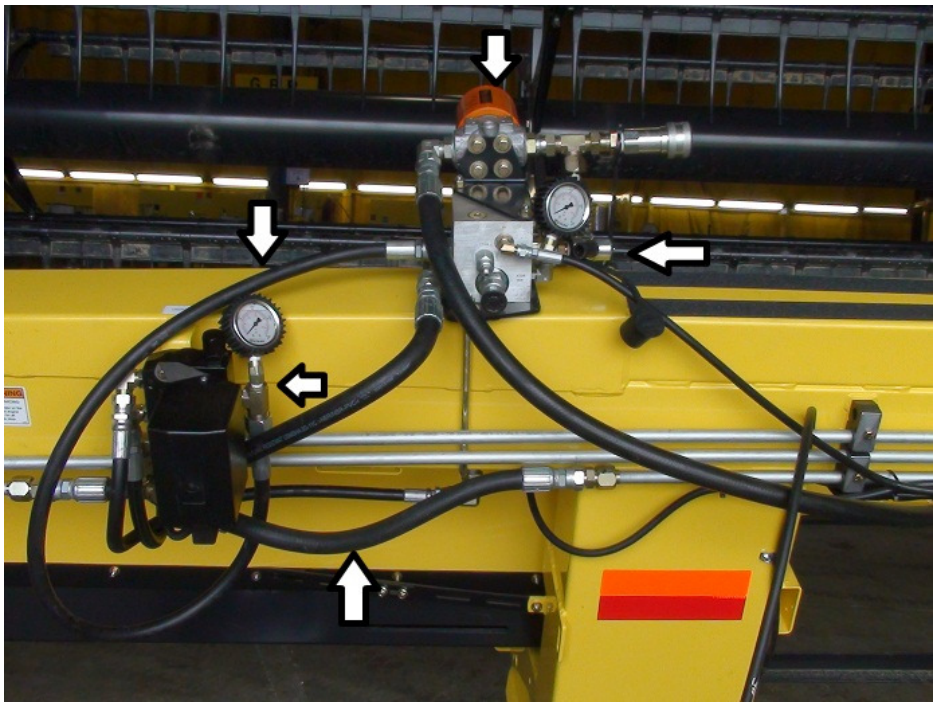
Before

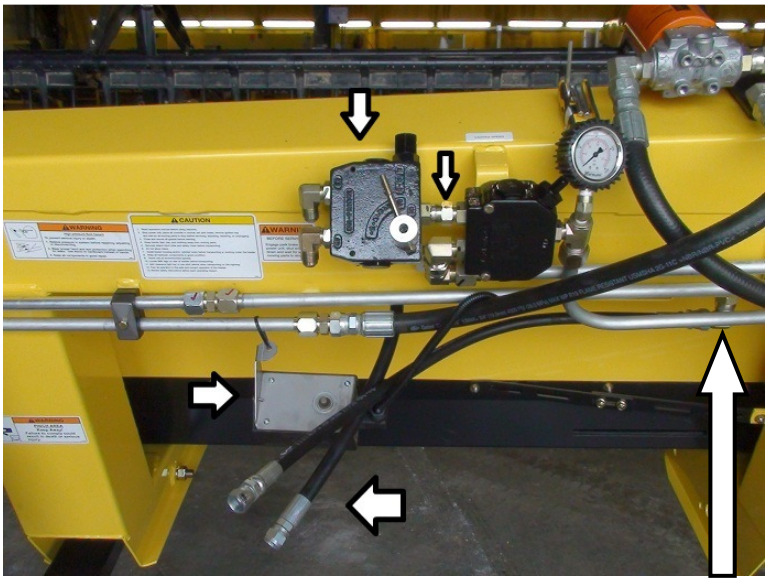


After

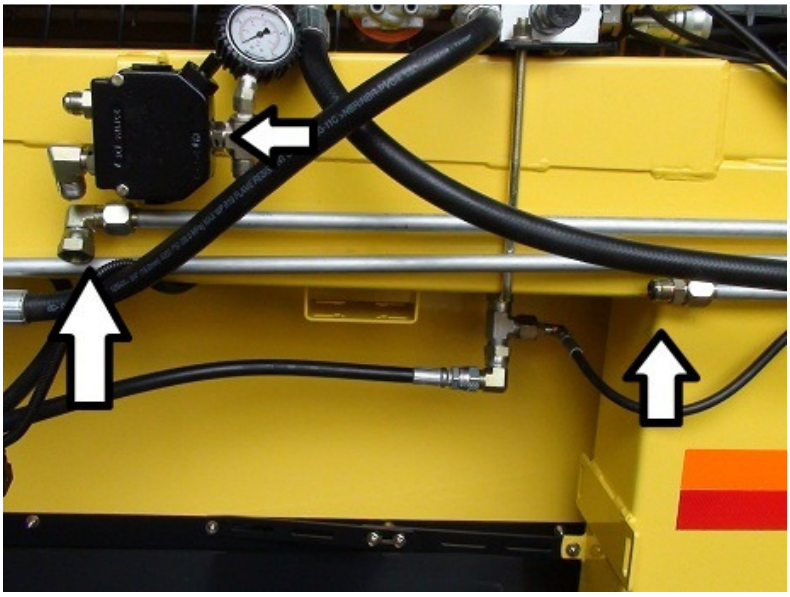


Procedure

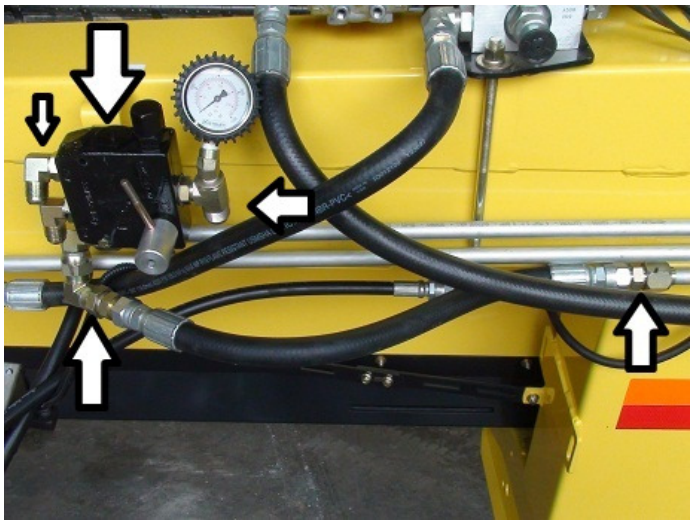
1. Back off float pressure on power unit to aid in quick coupler removal and connection.
2. Remove quick couplers between power unit and table.
3. Remove electric motor from canvass flow control and remove 2 hoses from flow control and remove flow control.



4. Loosen Fittings on 50/50 flow divider and remove divider. Remove steel line with 90 degree bend.

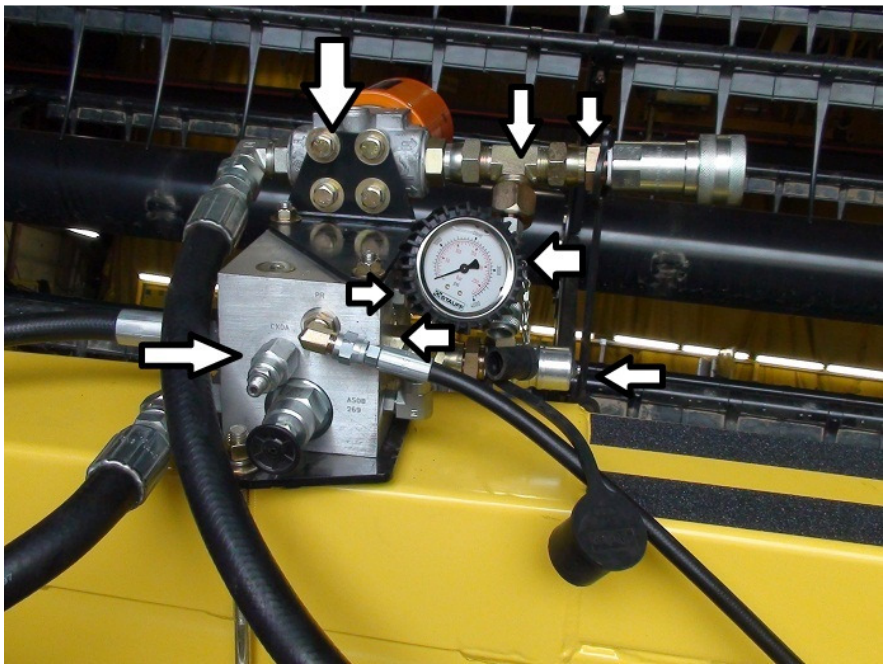


5. Install new ¾" hydraulic line with 90 degree fitting between the 2 steel lines.
6. Install Gauge from 50/50 divider into Canvass Flow control.
7. Attach Canvass flow control where 50/50 divider was previously.
8. Pivot 90 degree fittings on left hand side to allow for better hose alignment.
9. Re-attach the 2 lines to the same locations on the left hand side of canvass flow control.

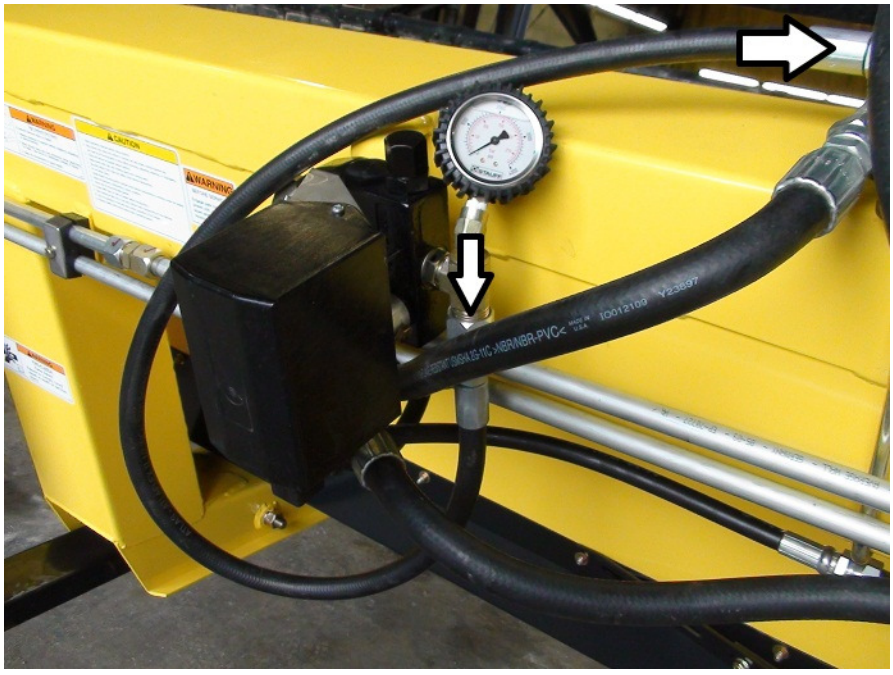


10. Aluminum valve block modification.

    a) Install filter mount on top of block.
    b) Remove filter connection from block.
    c) Remove small quick coupler on Right Hand side.
    d) Remove Female coupler on Right Hand side.
    e) Remove Male coupler on Right Hand side.
    f) Plug ports for male coupler and small coupler with plugs provided.
    g) Install male coupler in port closest to canvass (front port, Left Hand side where female coupler was previously).
    h) Mount filter housing on Filter Mount.
    i) Install tee fitting provided on end of filter.
    j) Connect small coupler to top of tee.
    k) Install female coupler to end of tee.
    l) Install new cartridge/plug into back of Aluminum block.

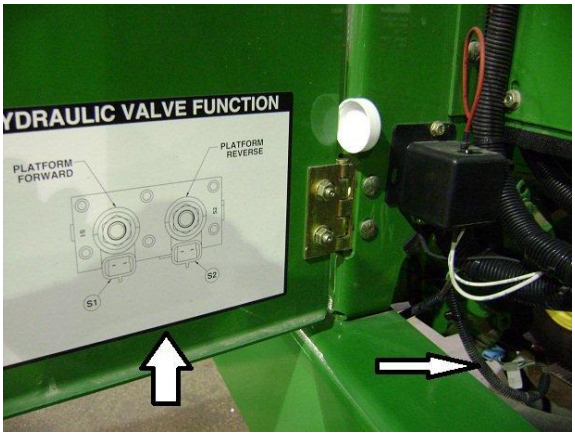


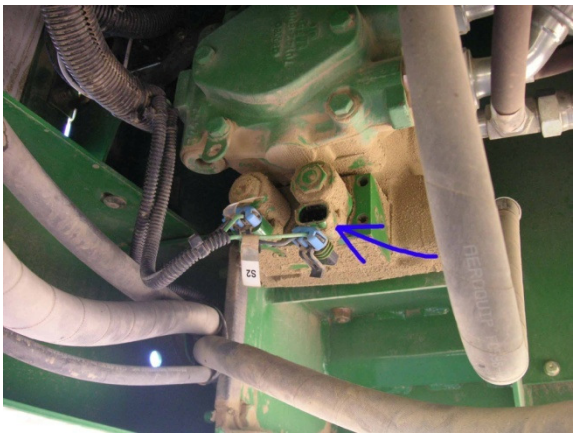
m) Run new ½ inch hydraulic hose from Left side of block (where filter was previously connected) to the bottom of the Gauge tee on the canvass flow control.



Power unit and Adjustments

1. If 4895, outer solenoid to be plugged into **S1, S2** should be unplugged and taped off. This will allow us to operate off of front side of pump.

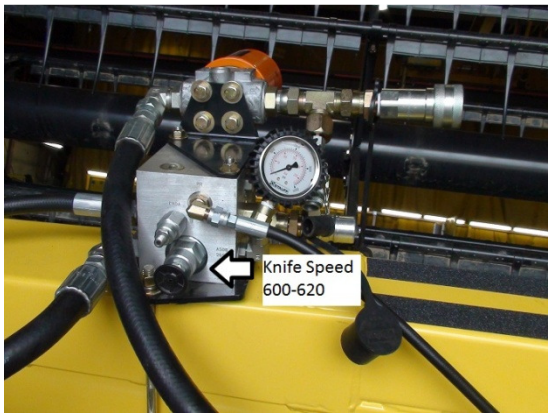


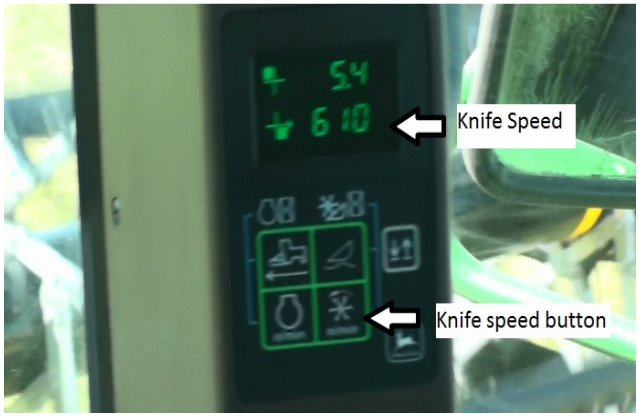


NOTE

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

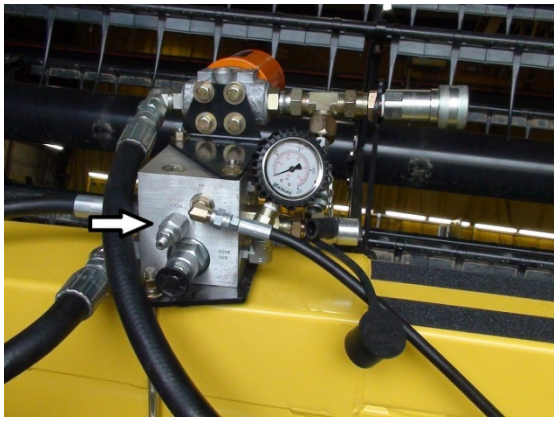
2. Start power unit and reset float to around 1200.
3. Engage table at low idle and check for Hydraulic leaks. Note- canvass will not turn at low idle, this is normal.
4. Run at full rpm and reduce knife speed to 600-620 (roughly 3-4 turns out if knife was at 720).



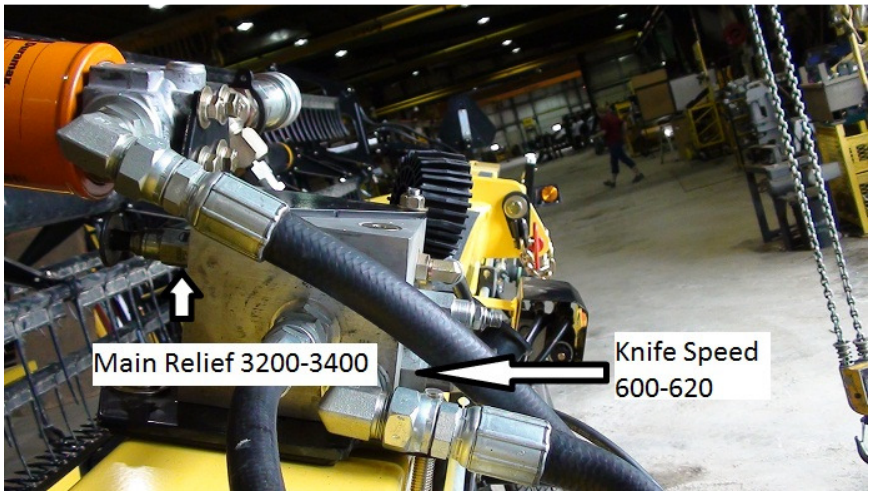


5. If not previously adjusted, screw in canvass flow control relief cartridge exposing 3 to 4 threads. This should set relief pressure to about 3000 on gauge.

6. If new cartridge has been installed in main valve block instead of plug, then bottom out new cartridge. If cap then no adjustment required.



7. Set main relief pressure to 3000-3400 if not previously adjusted.



NOTE

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

- Adjust flow with adjustment 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).