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## SERVICE BULLETIN

MANDATORY

FIX ON FAILURE

INFORMATION ONLY

Ref: SRV-025-001

Date: 1-07-25

**Product: Grain Belt Headers**

**Re:**

**Problem:**

Failure of the Auger drive or any of the components, such as, driveshaft, auger spider, or u-joints.

**Solution:**

The slip clutch is designed to protect the system. If the clutch is locked up and too much torque is applied to the drive, system components may fail. With the headers in storage during the off season the slip clutch friction discs may rust to the clutch plates. If the clutch rusts it will not protect the drive system should a slug go through the auger, damage to the drive components will occur

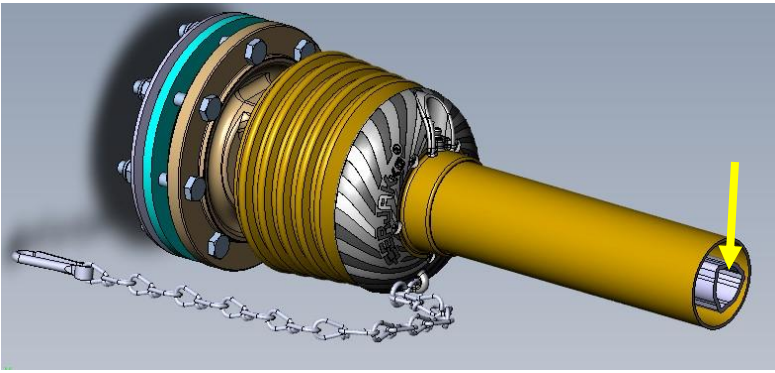
To make certain the clutch works the slip clutch should be burnished each season before use. This will make certain that the clutch is free from rust. The following is the procedure to burnish the clutch assembly.

Note: There are three different style clutches depending on the year the header was built.

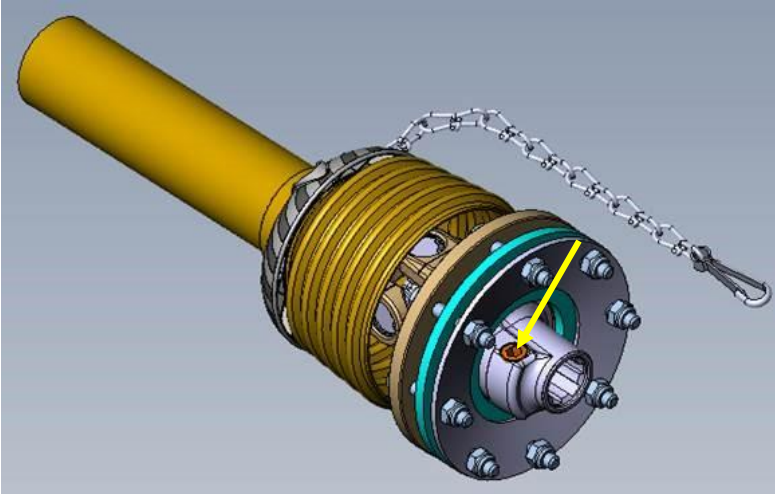
The following are the instructions for burnishing the clutches.

**Model Year 2020 and Above**

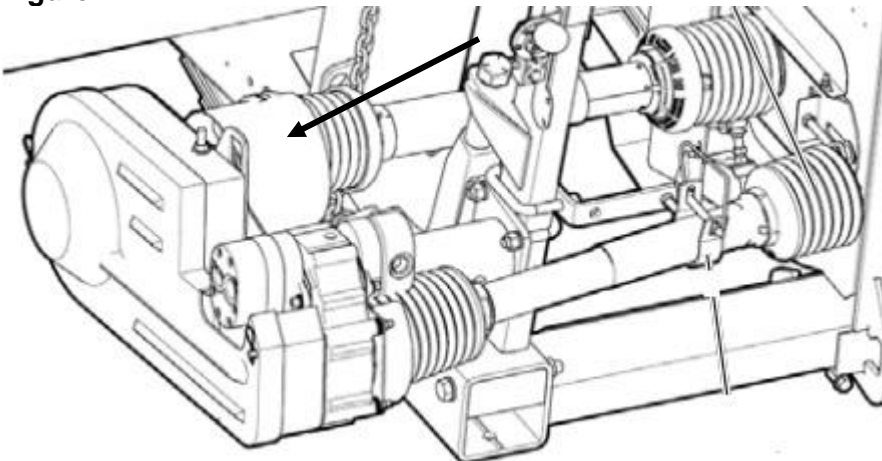
- These units can be identified by: Figure 1 and 2
  - 8-bolts around the clutch for adjusting the springs.
  - A telescoping shaft is a 3-sided lobe style profile.
  - Tapered bolt-on style yoke.
- With the header on the combine remove the left-hand shield over the slip clutch, to expose the clutch, Figure 3.



**Figure 1**

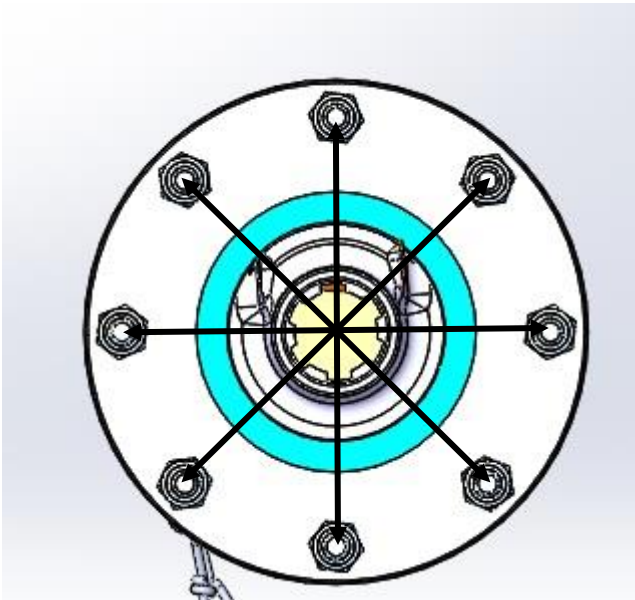


**Figure 2**



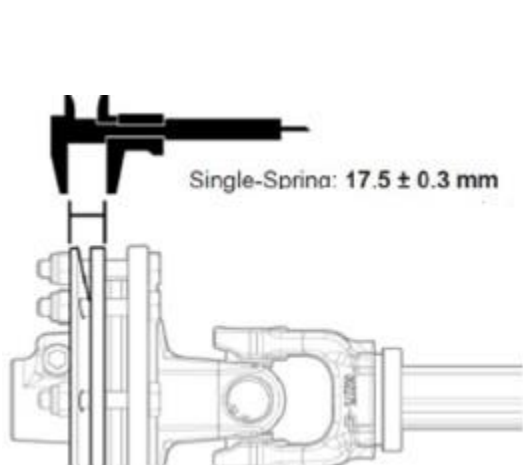
**Figure 3**

- Loosen the bolts on the clutch in a crossing pattern, Figure 4, until the clutch discs are loose but the bolts still hold them in place.
- Run the machine for 5 seconds and allow the clutch to slip. If the clutch does not slip then the clutch will need to be taken apart and parts either cleaned or replaced.

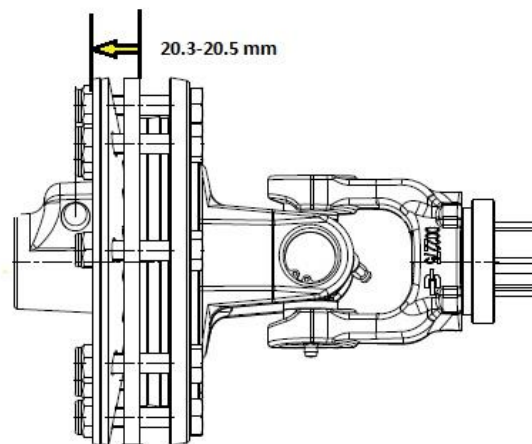


**Figure 4**

- Once the clutch is burnished tighten the bolts in the same crossing pattern until the dimension between the spring and plate is reached at each bolt location, Figure 5, and Figure 6. Tighten the bolts 2 flats and then go to the next bolt.
- On early units there are single spring clutches. These clutches should be adjusted to 17.5 mm plus or minus 0.3 mm. Figure 5
- There are two spring clutches used after 2020. The two spring slip clutches must measure 20.3-20.5mm, at each bolt location. Each bolt on the clutch must measure in the 20.3-20.5mm range, Figure 6
- Replace all shields that were removed to expose the slip clutch.



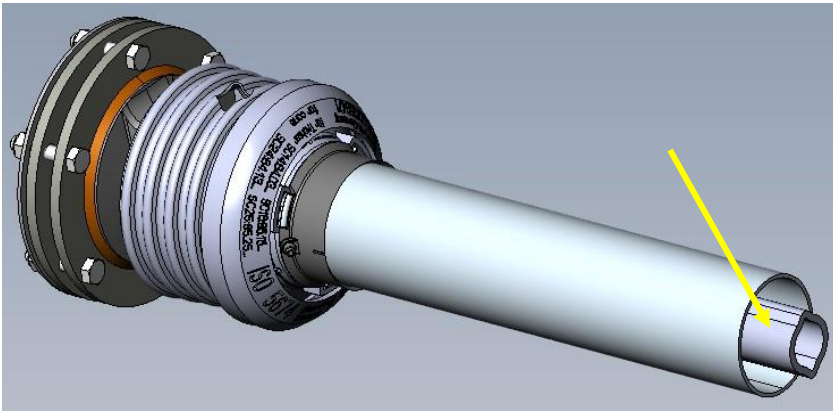
**Figure 5 (Single Spring)**



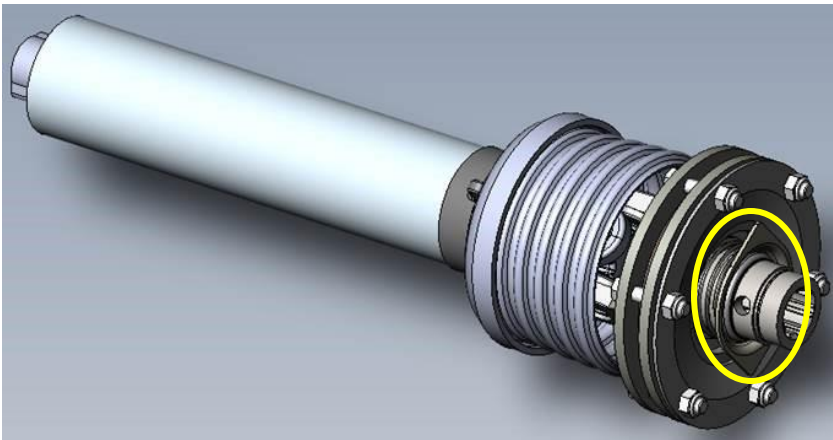
**Figure 6 (Double Spring)**

**Model Year 19 and below:**

- These units can be identified by: Figure 7 and 8
  - 6 bolts around the clutch.
  - The telescoping shaft is a lemon style profile.
  - Ball coupler style coupler yoke.

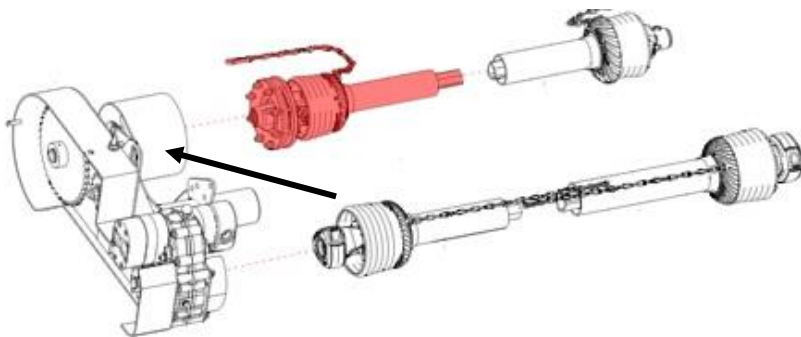


**Figure 7**



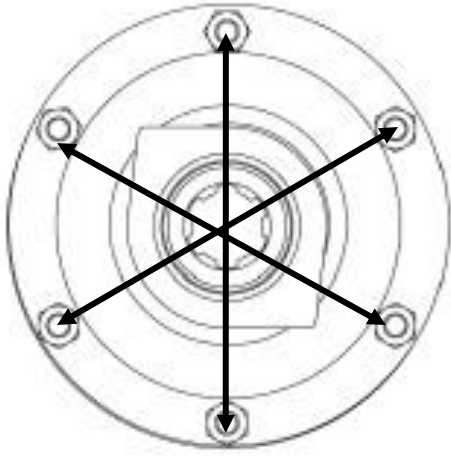
**Figure 8**

- With the header on the combine remove the left-hand shield to expose the clutch, Figure 9.



**Figure 9**

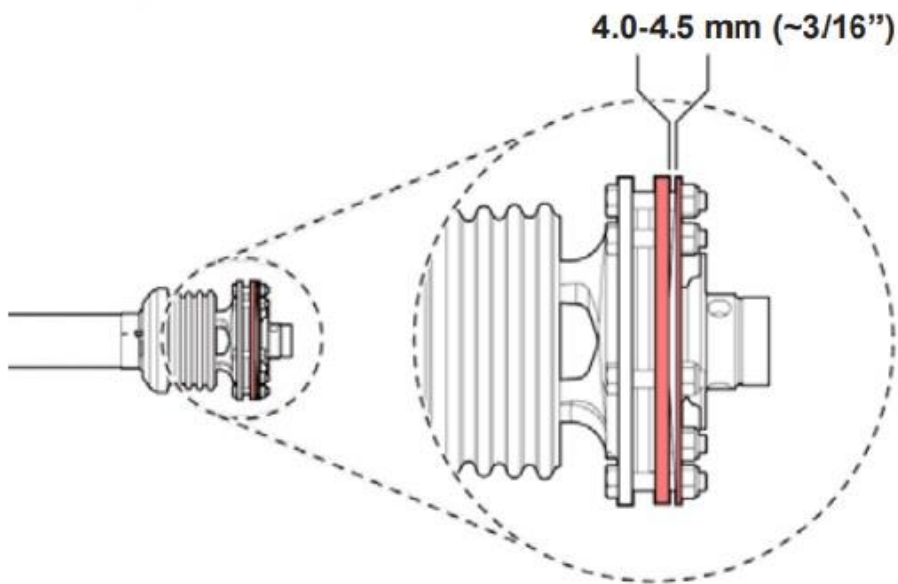
- Loosen the nuts A, Figure 10, on the clutch in a crossing pattern, Figure 10, until the clutch discs are loose but the bolts still hold them in place. Do not remove the nuts from the bolts.
- Run the machine for 5 seconds and allow the clutch to slip. If the clutch does not slip then the clutch will need to be taken apart and parts either cleaned or replaced.



**Figure 10**

Once the clutch is burnished tighten the nuts in the same crossing pattern in Figure 6 until the spring on the clutch is set to 4.0-4.5mm. Figure 11

- Replace all the shields removed to access the slip clutch.



**Figure 11**

**Ordering Information:**

No parts are needed

**Labor Allowance:** N/A

NOTE: