

Adjust the other cam bolt of this particular knife using the same procedure. Recheck the previous cam bolt adjustment and adjust the next knife.

NOTE: Always finish adjusting one knife before adjusting another knife.

Tighten each cam bolt (Fig. 12) to 375 ft-lbs (508 Nm) torque using an AE32021 torque wrench. Use a 2 x 4-in (5.1 x 10.2 cm) piece of wood to prevent cutterhead from rotating when tightening cam bolts.

IMPORTANT: Torque indicator on torque wrench must be centered in slot at zero torque. Correct bolt torque is attained when indicator reaches end of slot.

Tighten each set screw against the knife cam bolt to a maximum of 25 ft-lbs (34 Nm) torque. Hold the set screw and tighten the hex. nut.

Recheck the knife edge radius and readjust if necessary.

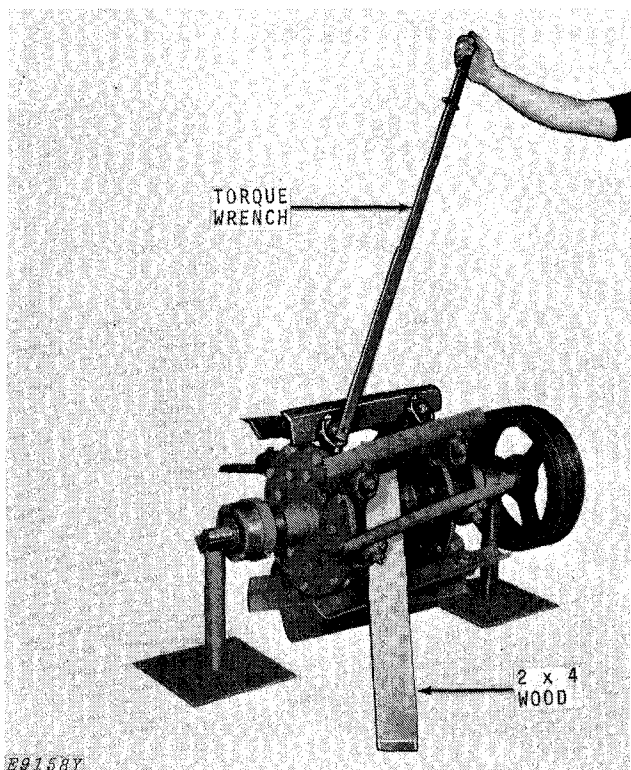
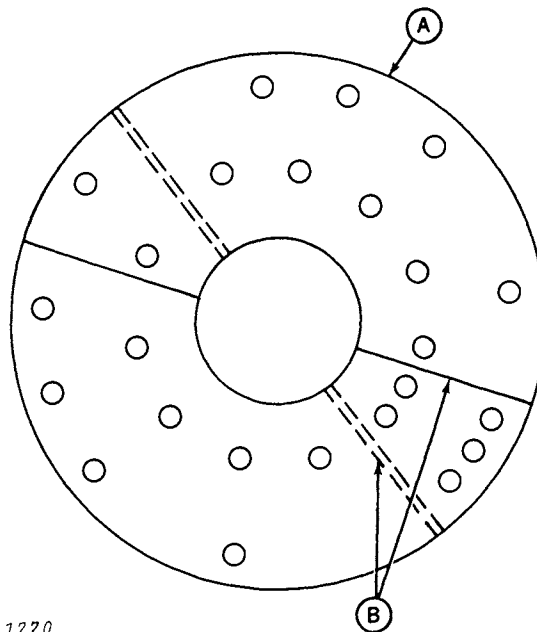


Fig. 12-Tightening Cam Bolts

Three Support Cutterhead

If the cutterhead is a three support cutterhead, follow the instructions below to install the center support.

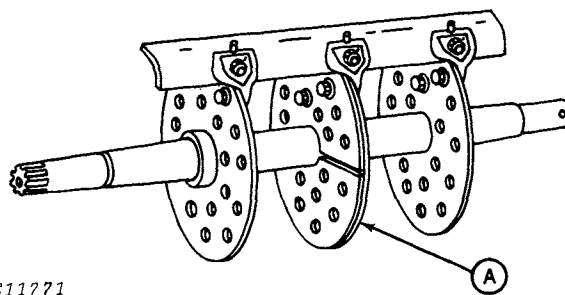


A—Center Plates B—Joints

Fig. 13-Indexing Plates

Install two sets of center plates (A) and nine knife supports. Index the plates to stagger the joints (B) and align all the holes. Use small washers under bolt heads and nuts on knife support bolts. Do not tighten at this time.

IMPORTANT: Install knife support bolts with the bolts through the plates then through supports. Bolt heads must be on plate side.



A—Center Support

Fig. 14-Cutterhead With Center Support

IMPORTANT: Do not weld center supports (A) to cutterhead shaft.

Install knives on the supports. Tighten the bolts only until snug.

Tighten all the knife support bolts to 375 ft-lbs (508 Nm) torque, using torque wrench provided.

Adjust all knives as shown on page 80-25-5.

INSTALLATION

Lift the cutterhead assembly back into the housing.

Secure the cutterhead bearing housings (7, Fig. 6) to cutterhead housing. Tighten the bolts to 85 ft-lbs (115 Nm) torque.

Locate the cutterhead assembly in the center of the cutterhead housing. Measure the distance between the housing side and the ends of the knives on each side. Tighten the bearing collars to hold the cutterhead in the center of the housing.

Tighten the left-hand collar in a counterclockwise direction and the right-hand collar in a clockwise direction.

Install housing side fillers (9, Fig. 7).

Lift recutter screen frame into position and secure. Also, install recutter screen if it was removed. Rotate the cutterhead by hand to make sure the knives will not contact the stationary knife or recutter screen.

IMPORTANT: Move stationary knife away from cutterhead so it will not be contacted by the cutterhead knives as they rotate.

Install chain on coupler between cutterhead and feed roll drive gear case.

Reinstall cutterhead housing on harvester as illustrated in Section 10 - GENERAL.

CAUTION: Be certain all safety doors and shields are installed.

SHARPENING CUTTERHEAD KNIVES

CAUTION: The auger, fan, and cutterhead may continue to rotate for several minutes after power is shut off. To avoid bodily injury, do not open or remove any doors or shields until these rotating parts have stopped completely.

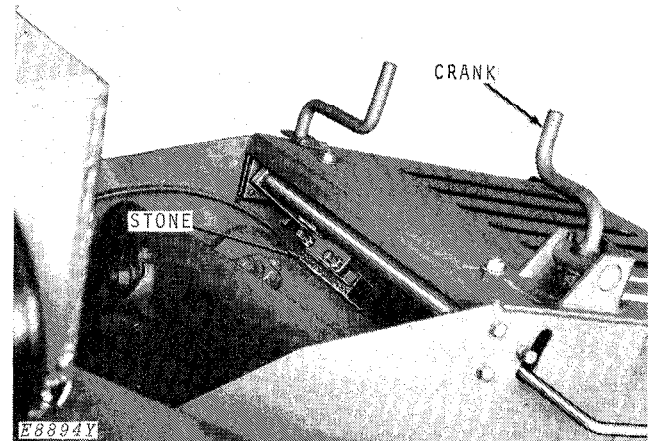


Fig. 15-Preparing to Grind Knives

Turn grinder crank clockwise to raise the stone off the grinder door. Remove the grinder door from under the stone. **Close and secure the cutterhead door.**

Shift the feed roll gearcase lever to neutral and disengage the fan and cutterhead clutch lever.

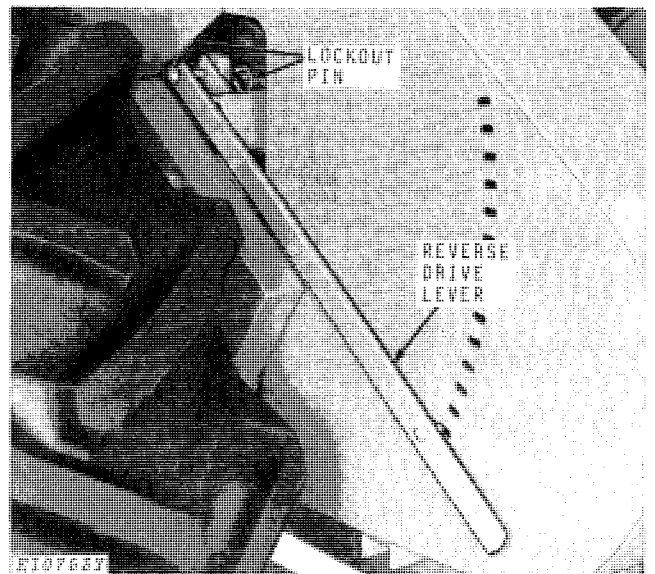


Fig. 16-Lockout Pin

Remove the cutterhead belt idler lockout pin from the reverse drive lever