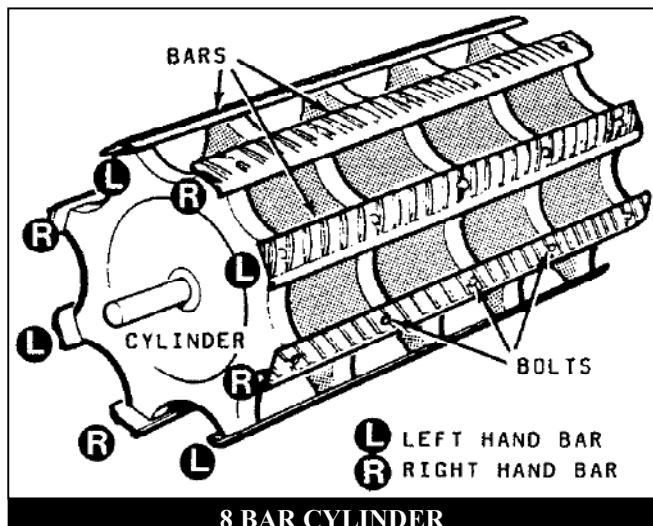


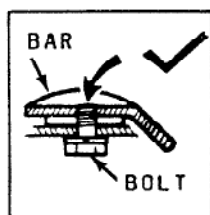
TECHNICAL BULLETIN



8 BAR CYLINDER

SPECIAL INSTRUCTIONS

On New Holland rotary bars where shims are used, be sure to use bolts of sufficient length (3/4" or 1"). The bolts must extend the full length in the solid portion of the bar.



For Gleaner F, G, L & M bars, put flat washers underneath bolt heads.

| BOLT TORQUE CHART - LB.-FT. | | | | | | |
|------------------------------------|-------|-----|-------|-----|----------|---------|
| Size | Gr. 5 | | Gr. 8 | | Gr. 10.9 | |
| | UNF | UNC | UNC | UNF | Unplated | Plated* |
| 3/8" | 35 | 30 | 45 | 50 | - | - |
| 7/16" | 55 | 50 | 70 | 80 | - | - |
| 1/2" | 85 | 75 | 110 | 120 | - | - |
| 14mm | - | - | - | - | 138 | 154 |
| 12mm | - | - | - | - | 88 | 97 |

*plated hardware is gold or silver in color.

A&I Products Cylinder Bars

Read the assembly instructions carefully and familiarize yourself with the assembly sequence before unpacking new bars, or removing existing cylinder bars from the combine.

INSTALLATION

Note: Install all bolts before torquing.

1. To remove old cylinder bars which have worn bolt heads, spot weld bolts to bar and then take off nuts.
2. Install new bars and tighten bolts. For combines with a 6 or 10 bar cylinder, left hand and right hand bars are located opposite each other.
3. After completing the assembly and torquing bolts (see chart), remove cylinder chains and check the cylinder balance.
4. Check the concave setting before operating.
5. Re-check bolt torques after the first hour of operation.

Note: If you are replacing two bars only, and you have an 8 bar cylinder, you can replace the bars in pairs, which are opposite each other, and have the teeth running in the same direction, either to the left or to the right. You will receive these packaged in pairs. If you have a 6 or 10 bar cylinder and you only want to replace two bars, you need to make sure the left hand and the right hand bars you are replacing are the same weight, or rebalance the cylinder after they have been installed.

Important: Most combine cylinders are factory balanced. If balancing weights are on the cylinder, retain and re-install at the same location.

To help keep the cylinder in balance, A&I cylinder bars are bundled in pairs, fours, fives, sixes or in complete sets, in which all the bars are the same weight. Do not mix bars. Remove an old bar with the teeth slanting to the left, and replace it with a bar with the teeth slanting to the left. Repeat with right hand slanting bars until all bars are replaced.