

## TECHNICAL BULLETIN:

### 360 CHAINROLL - 600 EARLY M6 REWORK

FIGURE 1

#### PURPOSE OF SET SCREWS

##### + WHY CLAMP?

Historically the 600 early series corn heads have had issues with the shaft splines shearing off over the lifetime of the stalkroll. The clamp design on the 600 early series 360 CHAINROLL compresses around the shaft and removes the possibility of "chatter" between the 360 CHAINROLL and the shaft. The chatter can occur during operation should the front nut become loose or be improperly torqued.

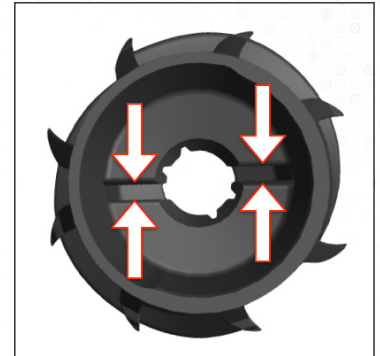


FIGURE 1

#### ROOT CAUSE

##### + HOLE MISALIGNMENT

During heat treat it is common for parts to slightly change dimensionally. We have found that after heat treat it is possible for the top and bottom holes to become misaligned and not allow the cap screw to thread properly.

##### + THREAD BURR

A slight chamfer has been added to the machining process to eliminate creating any thread burrs during the tapping process.

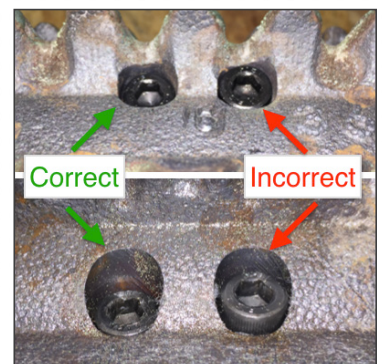


FIGURE 2

FIGURE 2

#### ISSUE

- + Final torque (17ft/lbs) is achieved before the M6 is properly seated as pictured in the far right of *FIGURE 2*.

If the issue exists, rework will be required. See rework instruction steps on next page.

#### ISSUE IDENTIFICATION

##### + VISUAL INSPECTION - PROPERLY SEATED & TORQUED

- The images at far left of *FIGURE 2* show the M6 cap screws when they are properly seated and torqued. This is critical to providing a reliable clamping force to the shaft.
- If rolls are installed, visually check the counter sunk depth of the M6 cap screw to ensure that it is making contact with the casting.
- Final torque should not be achieved until after the M6 cap screw is properly seated.

**SEE REWORK INSTRUCTION STEPS ON NEXT PAGE**

## TECHNICAL BULLETIN:

### 360 CHAINROLL - 600 EARLY M6 REWORK

#### TOOLS REQUIRED

- + M6 X 1.0 BOTTOM TAP (*FIGURE 3*)
- + TAP HANDLE OR RATCHET WRENCH
- + TAP EXTENSION
- + CUTTING OIL

#### REWORK INSTRUCTIONS

- + APPROXIMATE TIME: 2 MINUTES/HOLE
- + NOTE: Always try to install the M6 cap screws before employing the rework steps below.

**STEP 1** Apply cutting oil to the threaded portion of the clamp join as well as to the tap.

*FIGURE 4*

**STEP 2** Tap the hole being mindful not to bottom out the tap, thus breaking it off in the hole.

NOTE: Taps are brittle and can break if too much force is applied. The tap should turn with only slight effort during tapping. If the handle force increases moderately before the bottom of the hole is reached, alternate directions to work through the restricted area.

**STEP 3** Once the hole has been tapped, attempt to install the M6 cap screw once again.

**STEP 4** Repeat steps 1 through 3 for each hole requiring rework.

**⊕ REWORK COMPLETE**



*FIGURE 3*



*FIGURE 4*