

INSTRUCTIONS FOR 360 CHAINROLL™

John Deere 600 Series

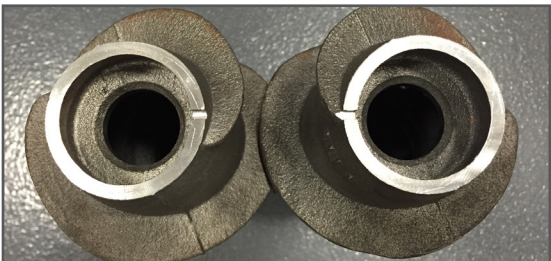
You are only a few steps away from better residue management.
If you have any issues along the way, feel free to give us a call at 309-321-0090.
Or, jump online for video instructions: [360YIELDCENTER/CHAINROLL](https://360YIELDCENTER.COM/CHAINROLL).



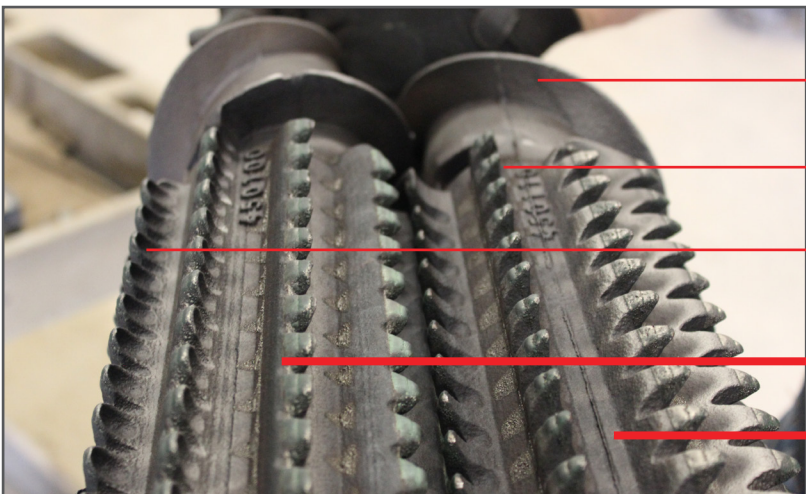
PARTS OVERVIEW

- + 360 CHAINROLL Row Unit Kit (Part No. 451100), includes:
 - Left Roll (Part No. 450100)
 - Right Roll (Part No. 450110)
- + Thread Locker (Part No. 207030)
- + Anti-Seize (Part No. 207031)

ROLL COMPONENTS AND ORIENTATION



IMPORTANT: Make sure the rolls are properly aligned and intermeshed when installing them onto the drive shafts. The notches at the top of the auger end allow for easy alignment. Match them up, and follow the instructions on the back for more detail.



- Auger End
- Chaining Flute
- Teeth Scoops
- LEFT ROLL
- RIGHT ROLL

HOW TO TELL THE LEFT ROLL FROM THE RIGHT ROLL

- When we reference left and right rolls, it is always from the perspective of the cab.
- Each roll has a part number on it - left roll is 450100 and right roll is 450110.
- The chaining flute on the left roll has teeth scoops on the back that makes it easy to distinguish at a glance. See photo at left.
- On both rolls, the chaining flutes face the same direction.

STEPS FOR OLD STALK ROLL REMOVAL

1. Remove Trash Knives

Tools and Parts Required:
+ 18 mm Socket Wrench

- Step 1:** Remove the four, 18 mm bolts. Start from the rear.
- Step 2:** Repeat Step 1 for the opposite side.



Remove bolts from trash knives.

2. Remove Drive Shaft Nuts

Tools and Parts Required:
+ 1-3/16" Socket Wrench

- Step 1:** Remove front-end nut from drive shaft.
- Step 2:** Repeat Step 1 for the opposite side.

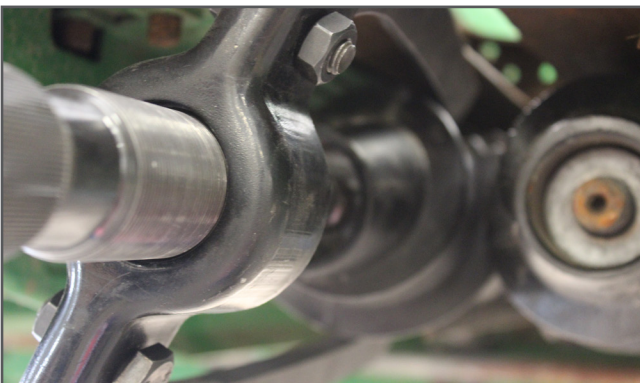


Remove front-end nut from drive shafts.

3. Remove Old Stalk Rolls

Tools and Parts Required:
+ 360 CHAINROLL Stalk Roll Puller
+ 5/8" Socket Wrench
+ Impact or Ratchet Wrench

- Step 1:** Orient old stalk rolls by manually turning the header to allow for better access to pulling features on the castings. Improve accessibility by opening up stripper plates, if possible.
- Step 2:** Attach puller arms to pulling features on the castings, as shown. Use the stalk roll puller for convenience.
- Step 3:** Tighten the puller and the extension rod on the shaft.
- Step 4:** Extend hydraulic puller by driving center ram, as shown. Remove rounded washer from drive shaft.
- Step 5:** Repeat Steps 1 to 4 for opposite side.



Attach puller arms to pulling features on castings.



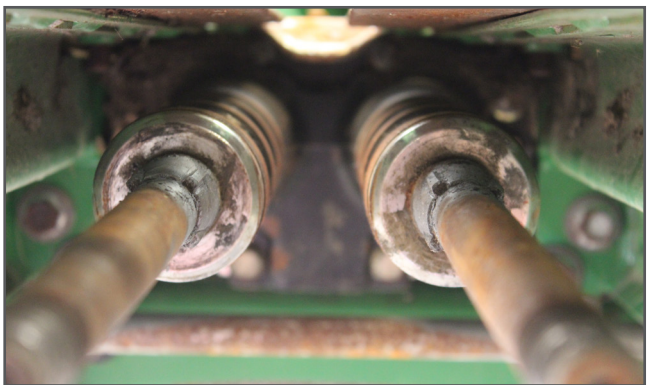
Extend hydraulic puller.

STEPS FOR 360 CHAINROLL INSTALLATION

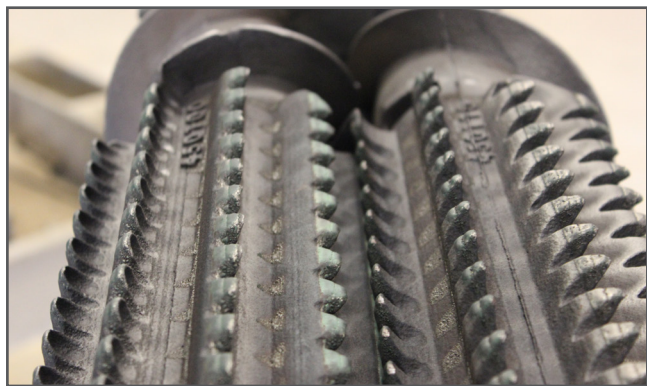
1. Install 360 CHAINROLL Stalk Rolls

Tools and Parts Required:
+ Anti-Seize
+ 360 CHAINROLL Left Roll
+ 360 CHAINROLL Right Roll

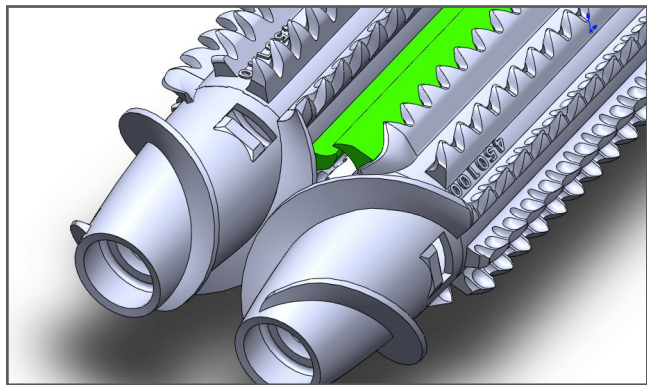
- Step 1:** Orient drive shafts so that the male keys are in an X pattern, as shown.
- Step 2:** Apply liberal amounts of anti-seize to the tapered portion of the drive shafts.
- Step 3:** Orient 360 CHAINROLL stalk rolls so that the **part number is facing up and the cutting flutes are intermeshed**, as shown.
- Step 4:** Use one hand to support the stalk rolls on the bottom. With the other hand, pinch the nosecones on the auger end together with thumb and index finger.
- Step 5:** **Lift both rolls simultaneously** to place them on the drive shafts, ensuring that the **cutting flutes remain interlocked**, as shown.
- Step 6:** Moving **both rolls together**, slide them back into the drive shafts, rotating them slightly back and forth until you feel the keyways engage.
- Step 7:** Continue to push the rolls back into the drive shafts until the threads protrude from the front support far enough for proper engagement. The drive shaft should be approximately even with the nose of the 360 CHAINROLL stalk rolls.



Put male keys in an X pattern.



Orient rolls so the part numbers are facing up.



Ensure the cutting flutes are intermeshed, as shown.

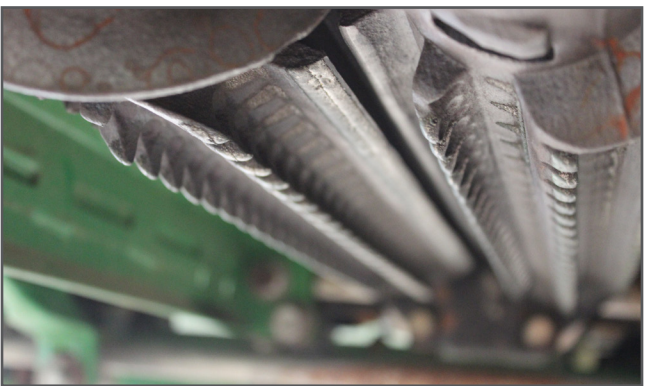


Lift rolls together and place rolls on drive shafts.

2. Tighten 360 CHAINROLL Rolls

Tools and Parts Required:
+ Thread Locker
+ 1-3/16" Socket Wrench

- Step 1:** Ensure that the timing remains consistent and that the **cutting flutes remain intermeshed**, as shown.
- Step 2:** Place the washers on the drive shafts and push them back into the nose of the rolls.
- Step 3:** Apply liberal amounts of thread locker onto the nuts and thread the nuts onto the drive shafts.
- Step 4:** Tighten the rolls to 100 lb./ft. (135 Nm) with a 60 degree torque turn.
- Step 5:** Manually turn rolls a full revolution to ensure that no interferences exist.



Ensure cutting flutes remain intermeshed.

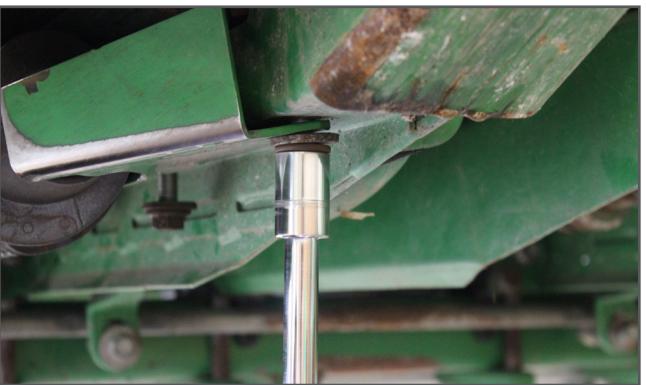


Apply thread locker.

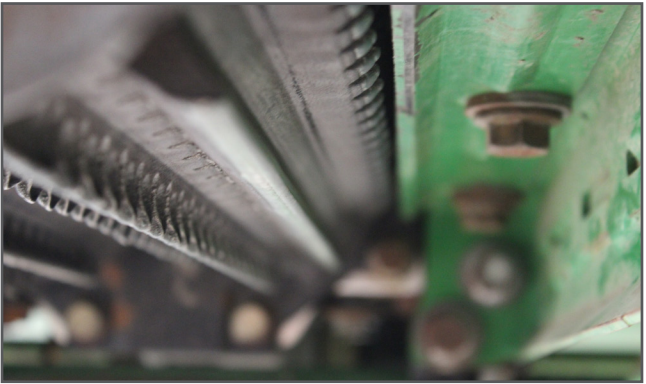
3. Reinstall Trash Knives

Tools and Parts Required:
+ 18 mm Socket Wrench

- Step 1:** Install four, 18 mm bolts. Start from the rear and do not fully tighten.
- Step 2:** Adjust spacing between the trash knife and the roll to approximately 1/4 in. Tighten the first and third bolts.
- Step 3:** Tighten the remaining bolts.
- Step 4:** Repeat Steps 1 to 3 for the opposite side.



Replace bolts in trash knives.



Adjust spacing to appropriate clearance.