



# 360 CHAINROLL®

INSTALLATION INSTRUCTIONS  
CASE IH 4000 SERIES



[360YIELDCENTER.COM](http://360YIELDCENTER.COM)

FOR QUESTIONS PLEASE CONTACT OUR  
PRODUCT SUPPORT TEAM AT 309-300-3120

6.26.23 • V7



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## CROSS AUGER SIDE

SPACER  
(x8)



R1



R2



R3



R4



HARDWARE



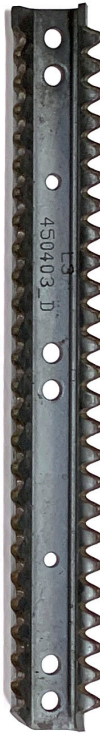
L1



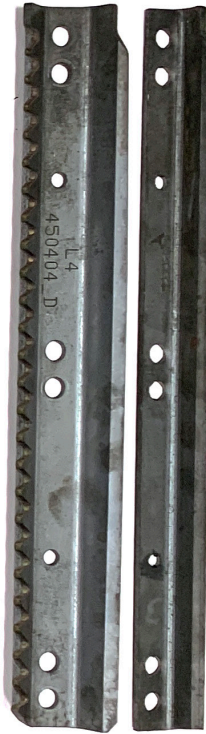
L2



L3



L4



## FRONT OF SNOOT

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## BEFORE YOU BEGIN



### HELPFUL TOOLS

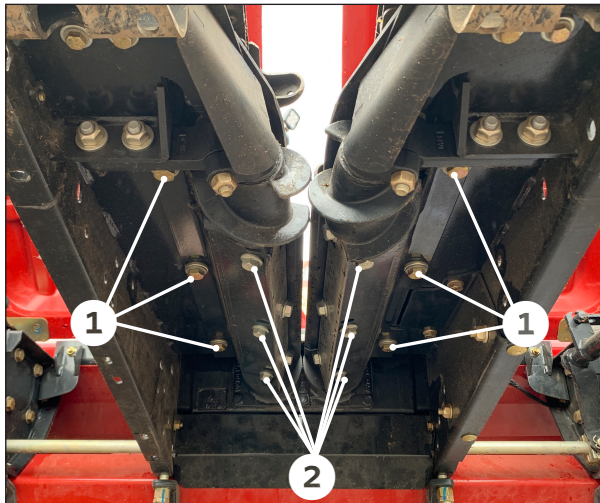
- 10 mm hex shaft driver (allen socket)
- Socket set
- Torque wrench
- Hammer

### NEED HELP?

Call our Product Support team at 309-300-3120.

## STEP 1

### OEM ROLL DISASSEMBLY



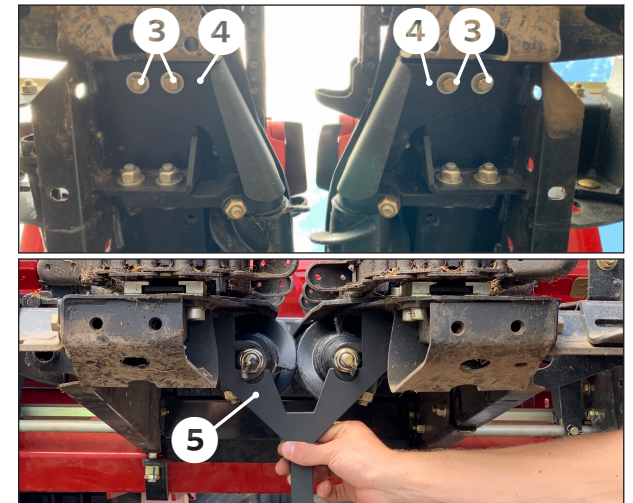
We have found the best way to install 360 CHAINROLL is by removing the residue knives and replacing the OEM roll knives with 360 CHAINROLL from the bottom side of the head.

On each row where 360 CHAINROLL will be installed, remove the three bolts **1** on each OEM residue knife. Retain these bolts for use when installing the 360 Residue Knives later in the installation process.

Remove the three bolts **2** in each OEM plate to uninstall all OEM plates on each row where 360 CHAINROLL will be installed. To gain access to all four sides of each shaft, the rolls may need to be rotated multiple times. This hardware can be discarded.

## STEP 2:

### CHECK OEM STALK ROLL ALIGNMENT



Remove the bolts **3** holding the covers **4** on the stalk roll bearings and set the covers aside. Retain all hardware.

Slide the alignment tool **5** over the front of the stalk rolls with the top of the tool contacting the bottom of the row unit.

Check that the stalk roll nuts are seated in the notch of the alignment tool.

If the nuts are not sitting in the notch (as seen in the picture above), loosen the two bearing mount bolts slightly so you can tap the roll to move it into the correct position. Once positioned correctly, re-tighten the bearing mount bolts.



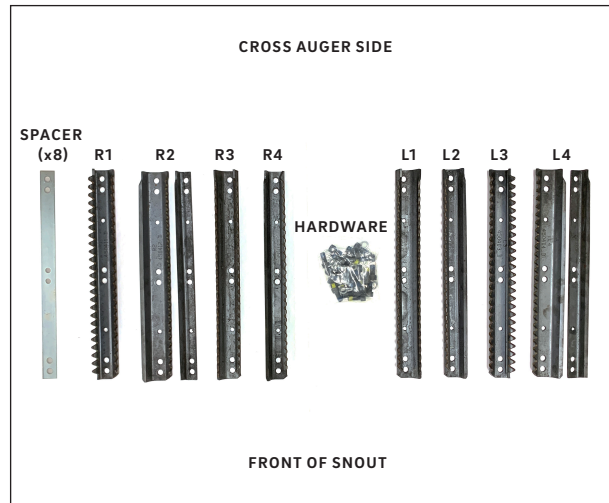
# INSTALLATION INSTRUCTIONS

CASE IH 4000 SERIES



## BEFORE YOU BEGIN ASSEMBLY

### PLEASE NOTE



We recommend opening **only one row at a time**. Layout one bundled left kit and one bundled right kit under each row, keeping in mind that **left and right are determined from the operator's seat**.

Arrange the knives as shown in the picture above:

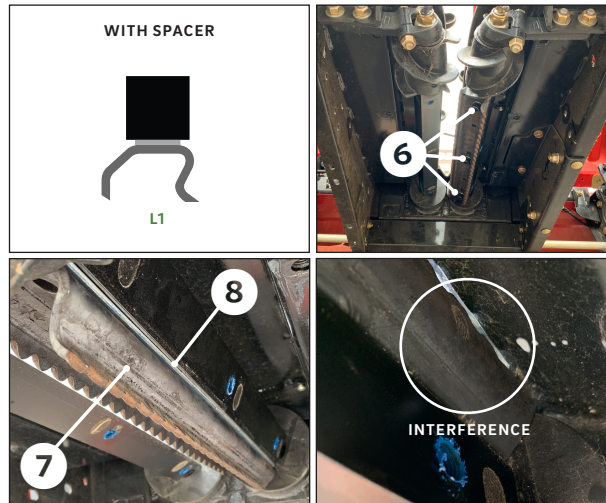
R1 - R2 (consists of two pieces) - R3 - R4

L1 - L2 - L3 - L4 (consists of two pieces)

The stamped numbers indicated the back of the knife which should be oriented towards the cross auger side of the head.

## STEP 3

### INSTALL L1 AND R1



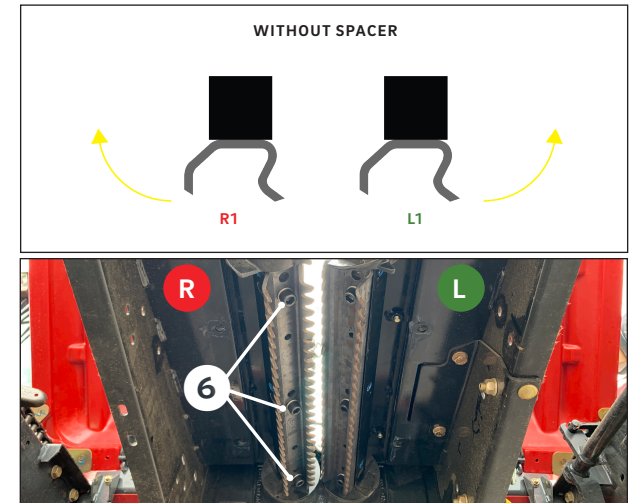
Using three of the shorter M12 bolts and lock washers from **hardware kit 450420 ⑥**, install the **L1** plate ⑦ and spacer ⑧ on the **left roll**. The spacer should be installed between the L1 plate and the shaft.

**Rotate the head as it would in normal operation to check clearance. If the plate interferes with the row unit, remove the plate and spacer and reinstall the plate without the spacer.**

**If the plate and spacer have adequate clearance, spacers should be installed with all remaining plates.**

## STEP 3 CONTINUED...

### INSTALL L1 AND R1



**NOTE: Because our roll had interference when the spacer was installed we will continue the rest of the installation process without installing the spacers.**

Using three of the shorter M12 bolts and lock washers from **hardware kit 450420 ⑥**, install the **R1** plate on the **right roll**.

Torque all three bolts on both the left and the right rolls to 100ft/lbs.

Rotate the head as it would in normal operation to access the next face of the shaft.

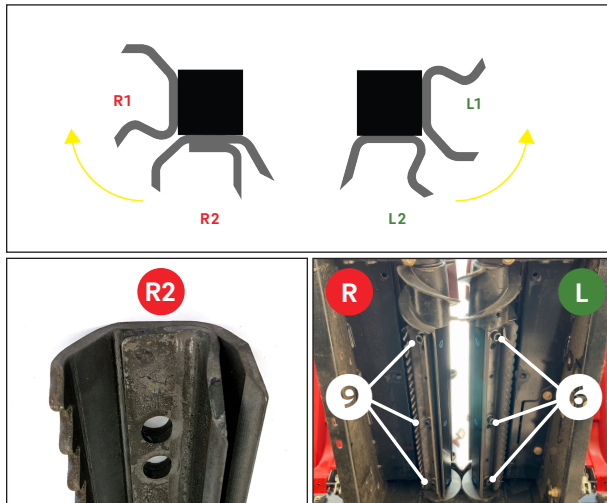
# INSTALLATION INSTRUCTIONS

CASE IH 4000 SERIES



## STEP 4

### INSTALL R2 AND L2



Using three of the longer M12 bolts and lock washers from hardware kit 450420 ⑨, install the two **R2** plates on the **right roll**.

**NOTE:** The larger **R2** plate should be installed against the shaft with the smaller **R2** plate (part #450415) installed on the larger **R2** plate. The longer M12 bolts will go through both plates.

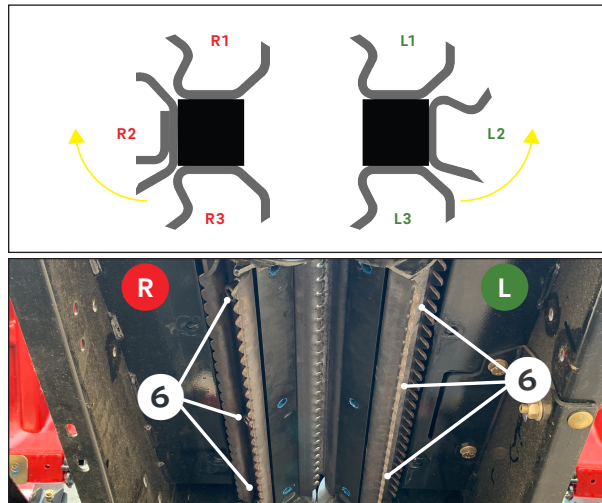
Using three of the shorter M12 bolts and lock washers from hardware kit 450420 ⑥, install the **L2** plate on the **left roll**.

Torque all three bolts on both the left and the right rolls to 100ft/lbs.

Rotate the head as it would in normal operation to access the next face of the shaft.

## STEP 5

### INSTALL R3 AND L3



Using three of the shorter M12 bolts and lock washers from hardware kit 450420 ⑥, install the **R3** plate on the **right roll**.

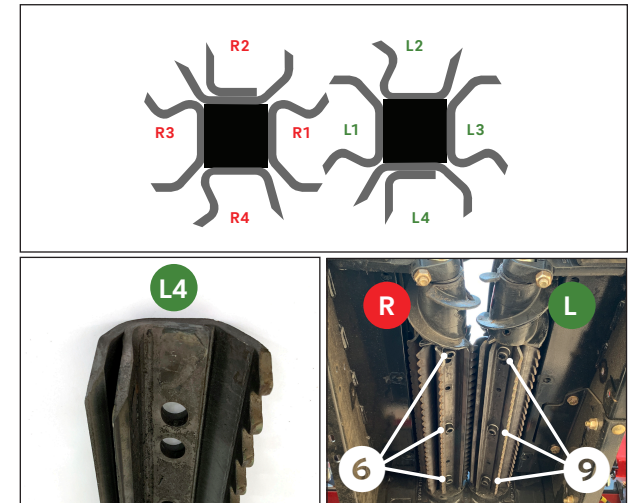
Using three of the shorter M12 bolts and lock washers from hardware kit 450420 ⑥, install the **L3** plate on the **left roll**.

Torque all three bolts on both the left and the right rolls to 100ft/lbs.

Rotate the head as it would in normal operation to access the last face of the shaft.

## STEP 6

### INSTALL R4 AND L4



Using three of the shorter M12 bolts and lock washers from hardware kit 450420 ⑥, install the **R4** plate on the **right roll**.

Using three of the longer M12 bolts and lock washers from hardware kit 450420 ⑨, install the two **L4** plates on the **left roll**.

**NOTE:** The larger **L4** plate should be installed against the shaft with the smaller **L4** plate (part #450405) installed on the larger **L4** plate. The longer M12 bolts will go through both plates.

Torque all three bolts on both the left and the right rolls to 100ft/lbs.

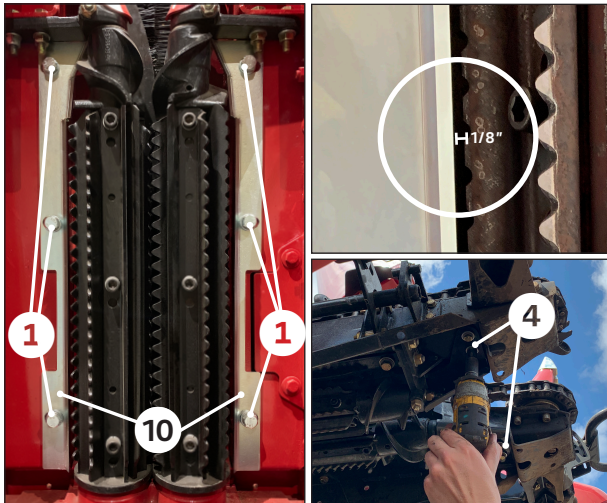
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## STEP 7

### INSTALL RESIDUE KNIVES



Using previously removed hardware ❶ install the 360 residue knives ❿.

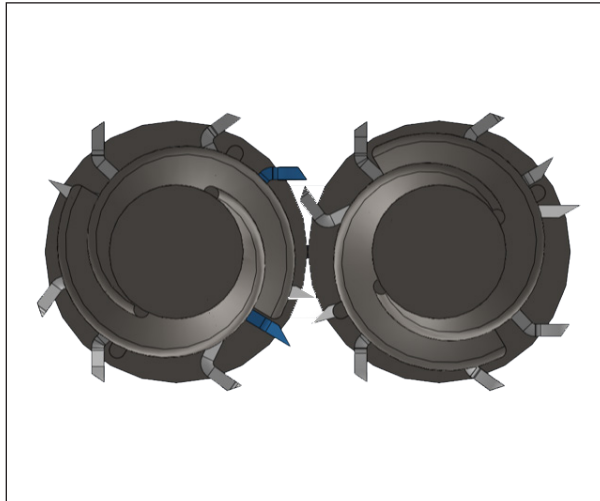
**NOTE:** Before completely tightening, ensure there is approximately 1/8" gap between the residue knife and the 360 CHAINROLL plates.

Reinstall stalk roll bearing covers ❹.

Rotate the rolls at least one revolutions to ensure there is no interference between the knives.

Repeat steps 1-7 for the remaining rows.

## INSTALLATION COMPLETE



**NOTE:** Ensure cutting flutes are properly timed. As long as matching knives (R1 and L1, R2 and L2, etc) are adjacent to each other and the single cutting flute goes in between dual cutting flutes on the opposite roll, the rolls should be timed correctly.

Refer to normal OEM procedure for further adjustments.

