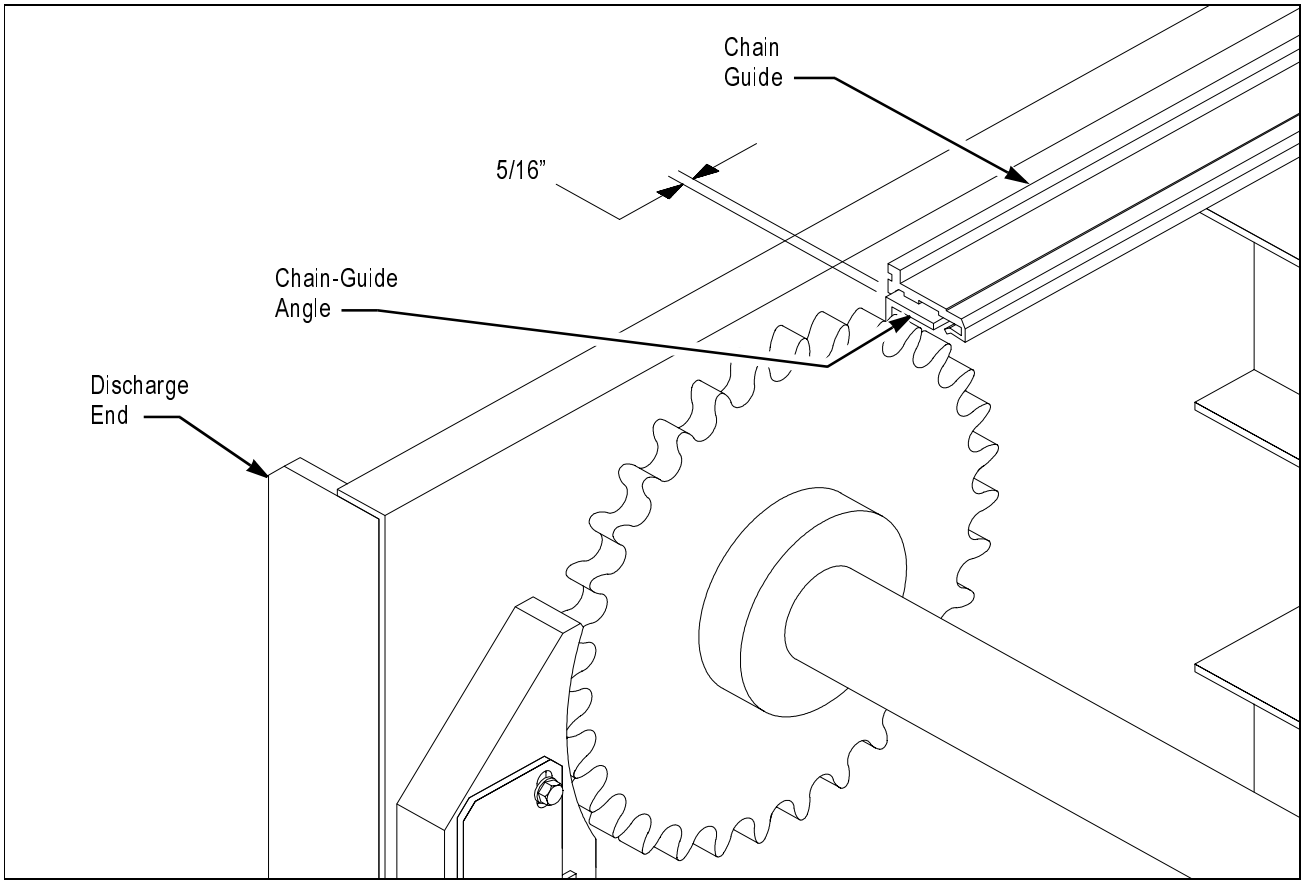

Figure A.32 – Trimming the Discharge End of the Top-Outside Chain Guides

Install Chain

Chain is provided in four matched sets, each matched set consisting of four strands. Each of the strands of three matched sets is 20 feet long, and each of the strands of one matched set is ten feet long. Each strand of chain is furnished with a coupler for assembling the strand to the complete chain. The length of a strand is measured from the centerline of the pin at one of the strand to the centerline of the pin at the other end, including the coupler. Each matched set consists of two outer strands and two inner strands (see Figure A.33).

Caution

Each set of four strands of chain is a matched, bench-drawn set of chains. Chains are provided in matched sets to ensure uniformity and consistent movement of the chain through the combiner. Do not mix any strand from one matched set with the strands from any other set. Make certain to install all four strands of each set together (aligned abreast of one another). Failure to install the chains properly may result in erratic operation and possible damage to the combiner.

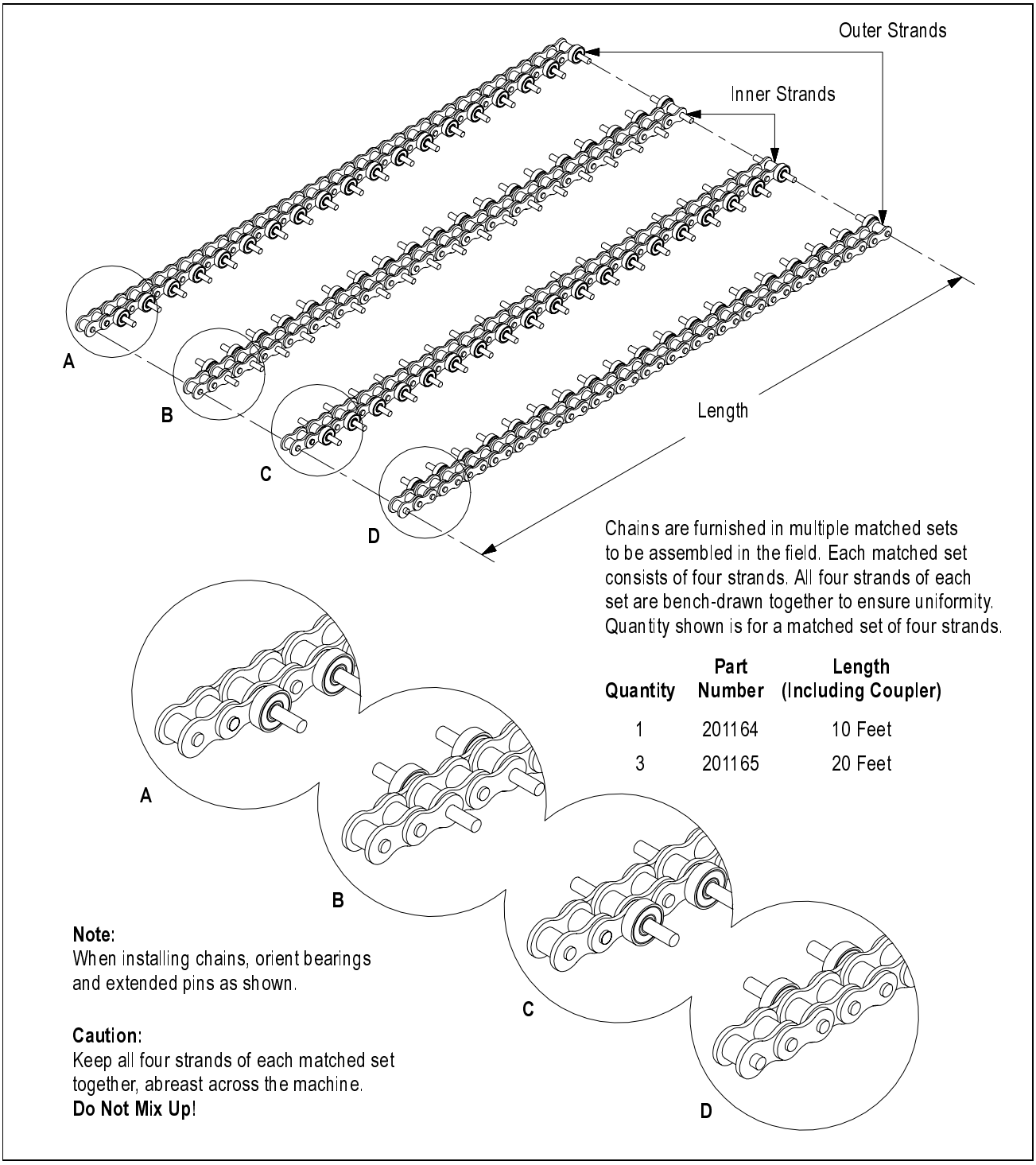

Figure A.33 – Combiner Chain Furnished in Matched Sets

Before assembling the chains, remove exactly 12 links (6 long pins and 6 short pins) from each of the four strands of the ten-foot section of chains. Make certain to remove the links from the same end of each of the four strands of chain.

After removing 12 links, the net length of each strand should be 105” measured from the centerline of the pin at one end to the centerline of the pin at the other end (including the coupler). If the chains provided contain more than one ten-foot long set of four matched strands, make certain to perform the removal of links on no more than one set of four matched strands.

Assemble each chain on the corresponding chain guide. As each chain is assembled, make certain not to mix up any strand from one matched set with the strands of any other set. Mark the ends of each strand if necessary to avoid mixing them up. Connect separate strands of chain with a chain coupler (see Figure A.34 and Figure A.35). Make certain that the chain coupler is oriented with the extended pin between two short pins. Do not position an extended pin adjacent to another extended pin.

Caution

Each strand of chain has a “free” end and a “coupling” end. The free end has one additional full link between the last extended pin and the end of the chain. At the coupling end, an extended pin is inserted through the last link. Be very careful to connect the “free” end of one strand to the “coupling” end of the adjoining strand.

Secure chain couplers to the chains as follows:

- Insert a cotter pin through the short chain-coupler pin; and
- Snap a retaining ring provided into the groove in the long chain-coupler pin.

After installing the chain coupler, install a bushing and a bearing on the extended pin.

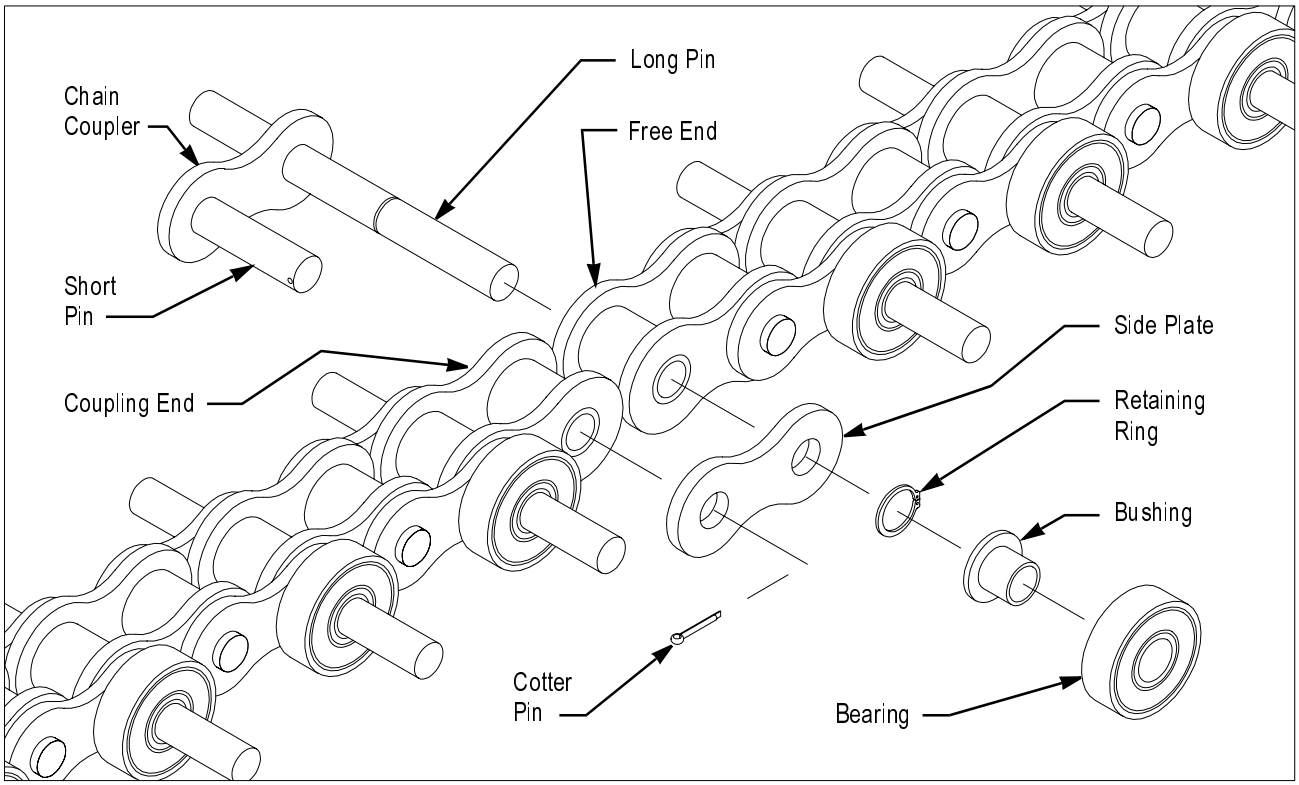

Figure A.34 – Installing a Chain Coupler on an Inner Strand

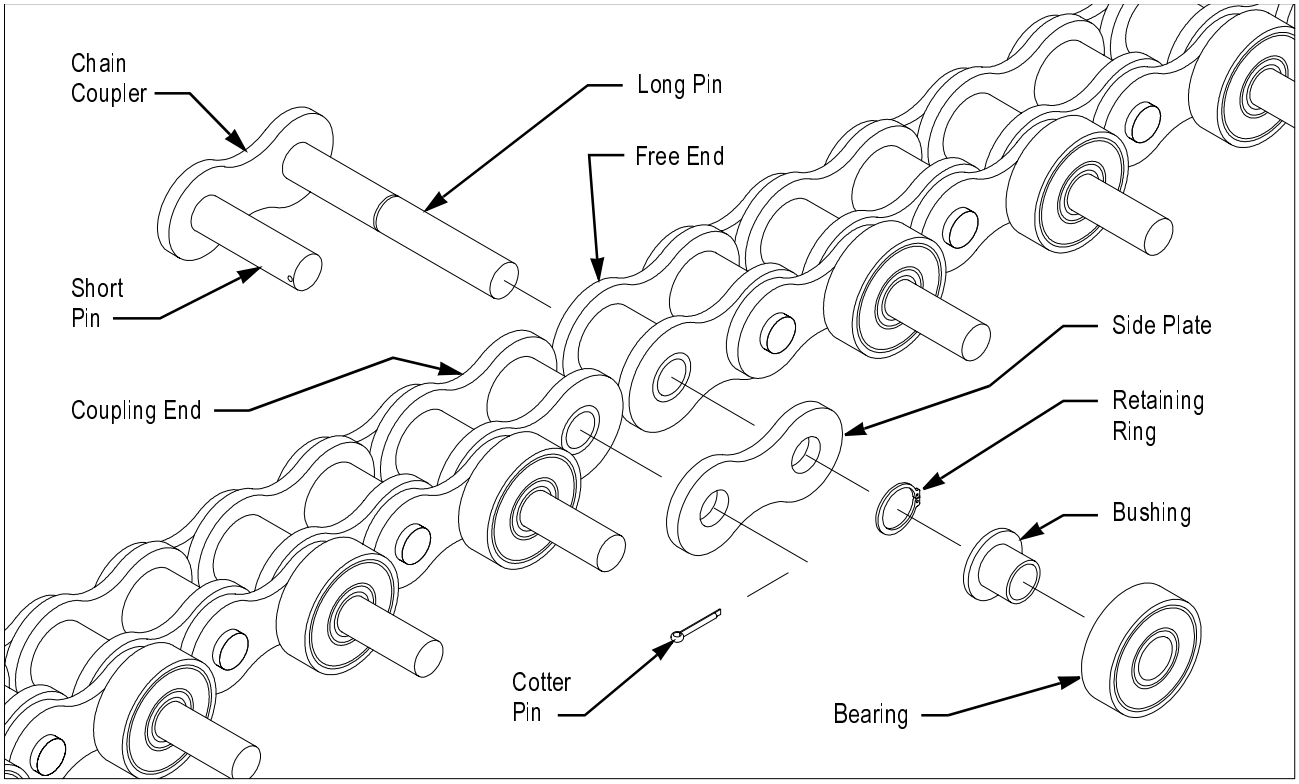

Figure A.35 – Installing a Chain Coupler on an Outer Strand

Assemble Chains and Slat Tubes

Warning!

Before installing the center slat tubes, make certain that no tools or other loose articles are left within the interior of the combiner. Failure to remove loose objects may cause an accident resulting in extensive damage to the machine or in serious injury to personnel.

Before installing the short slat tubes between the two center chains, make certain that the drive-shaft center coupling has been lubricated with the specified grease (refer to Section B, *Maintenance*). Inadequate lubrication of the center coupling will cause premature wear of the internal splines.

After all four chains are assembled, install slat tubes as follows (see Figure A.36):

- Between the two inside chains, install a short slat tube (31 $^{13}/_{16}$") on every set of extended pins.
- Between the inside chain and outside chain on each side of the machine, install one long slat tube (84 $^{5}/_{8}$").

Before the remaining long slat tubes and the pushers are installed, additional parts must be installed, and adjustments must be made. These procedures require access to areas which will become inaccessible once all of the tubes and pushers are installed.

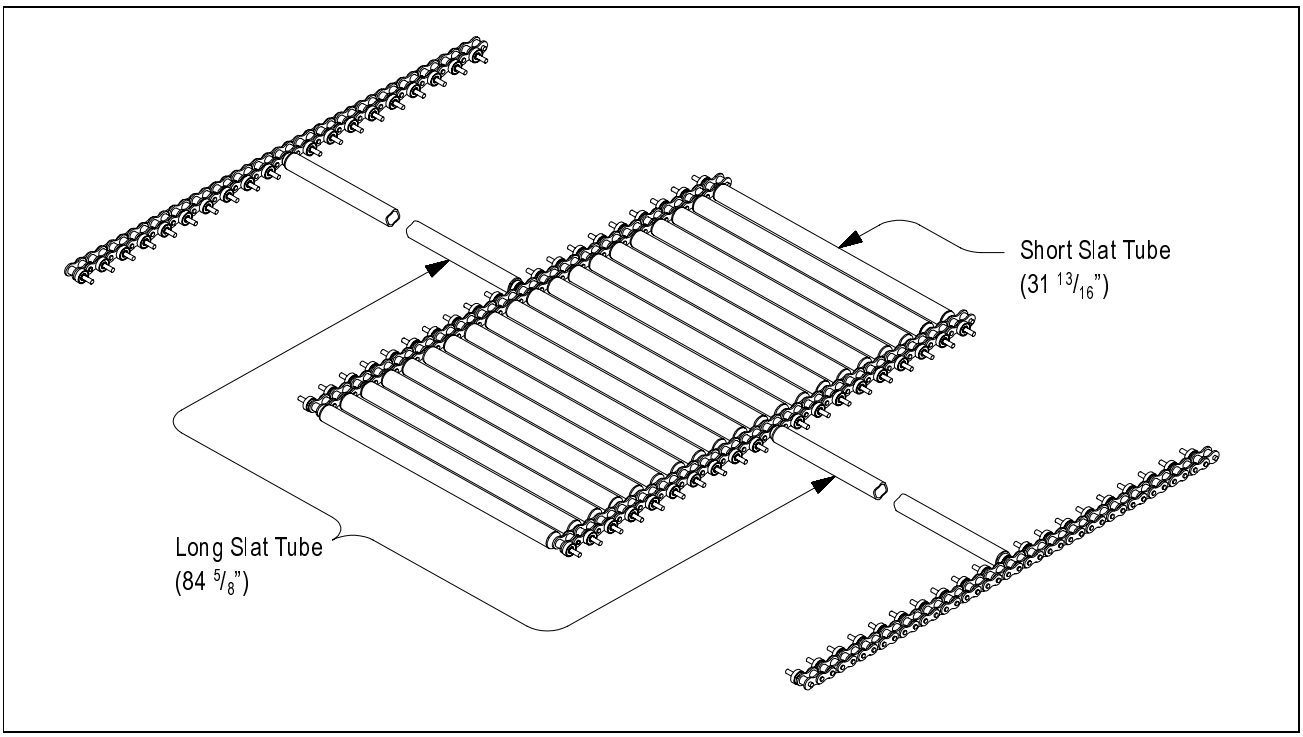

Figure A.36 – Assembling Chains and Tubes

Adjust Chain Hold-Downs

Chain hold-downs are located adjacent to each of the sprockets at the drive end of the combiner (see Figure A.37). The chain hold-downs are white UHMW blocks with a curved cut-out to fit around the chain. Adjust the position of each chain hold-down as necessary to provide sufficient clearance to allow free movement of the chain, but close enough to prevent the chain from jumping sprocket teeth during combiner operation. Note that the mounting arrangement for the hold-downs allows adjustment both up and down and toward and away from the sprocket. Position the hold-down to provide consistent space between the chain and the curvature of the cut-out.

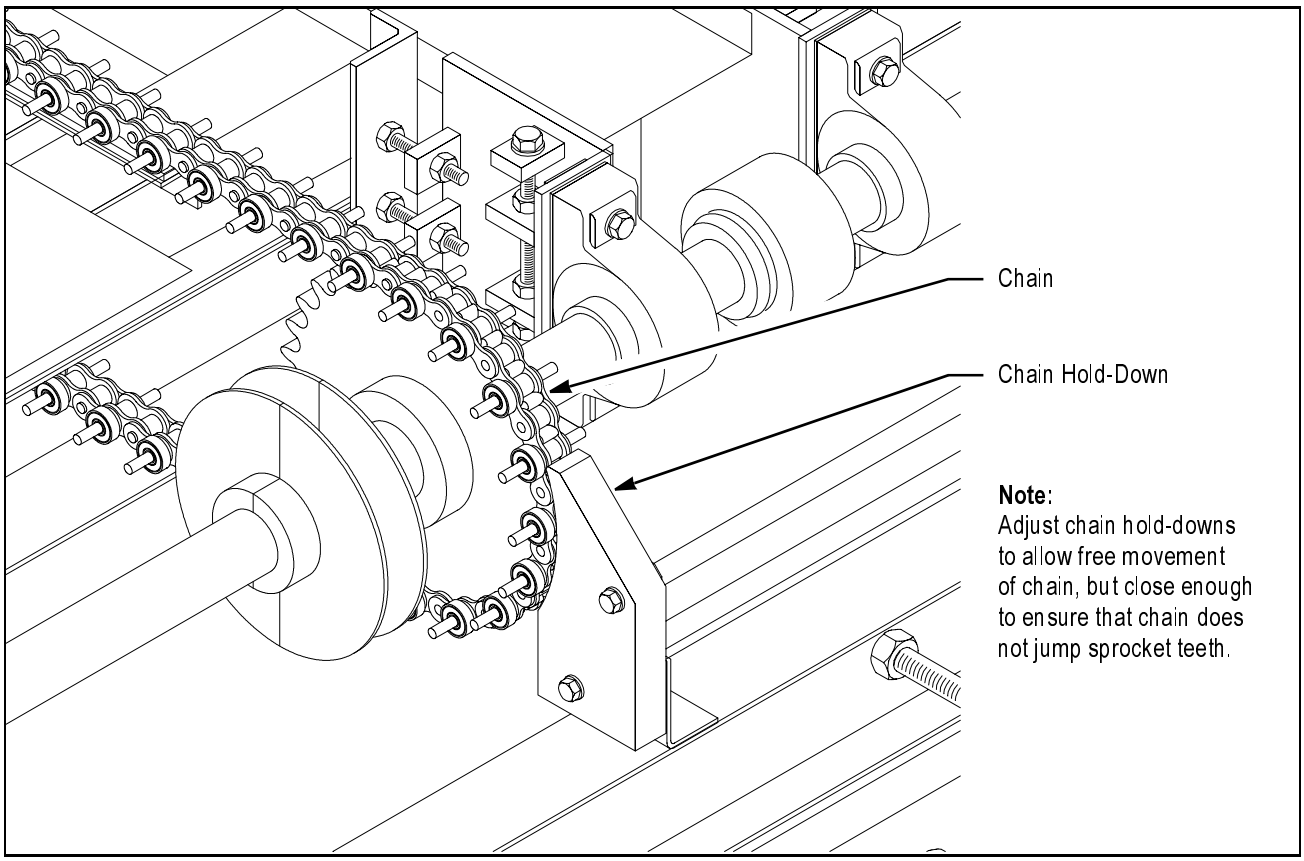

Figure A.37 – Adjusting the Position of the Chain Hold-Downs