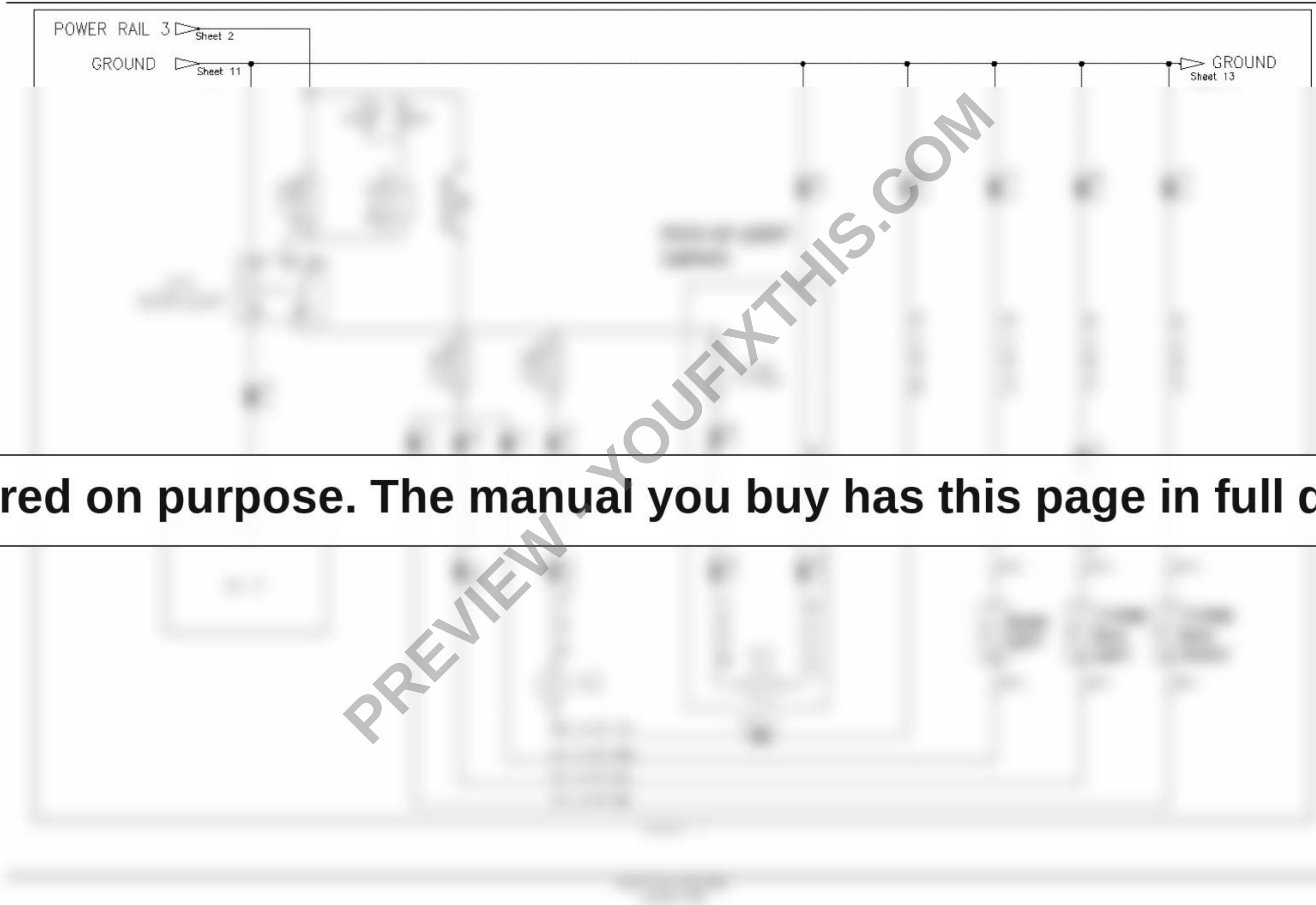


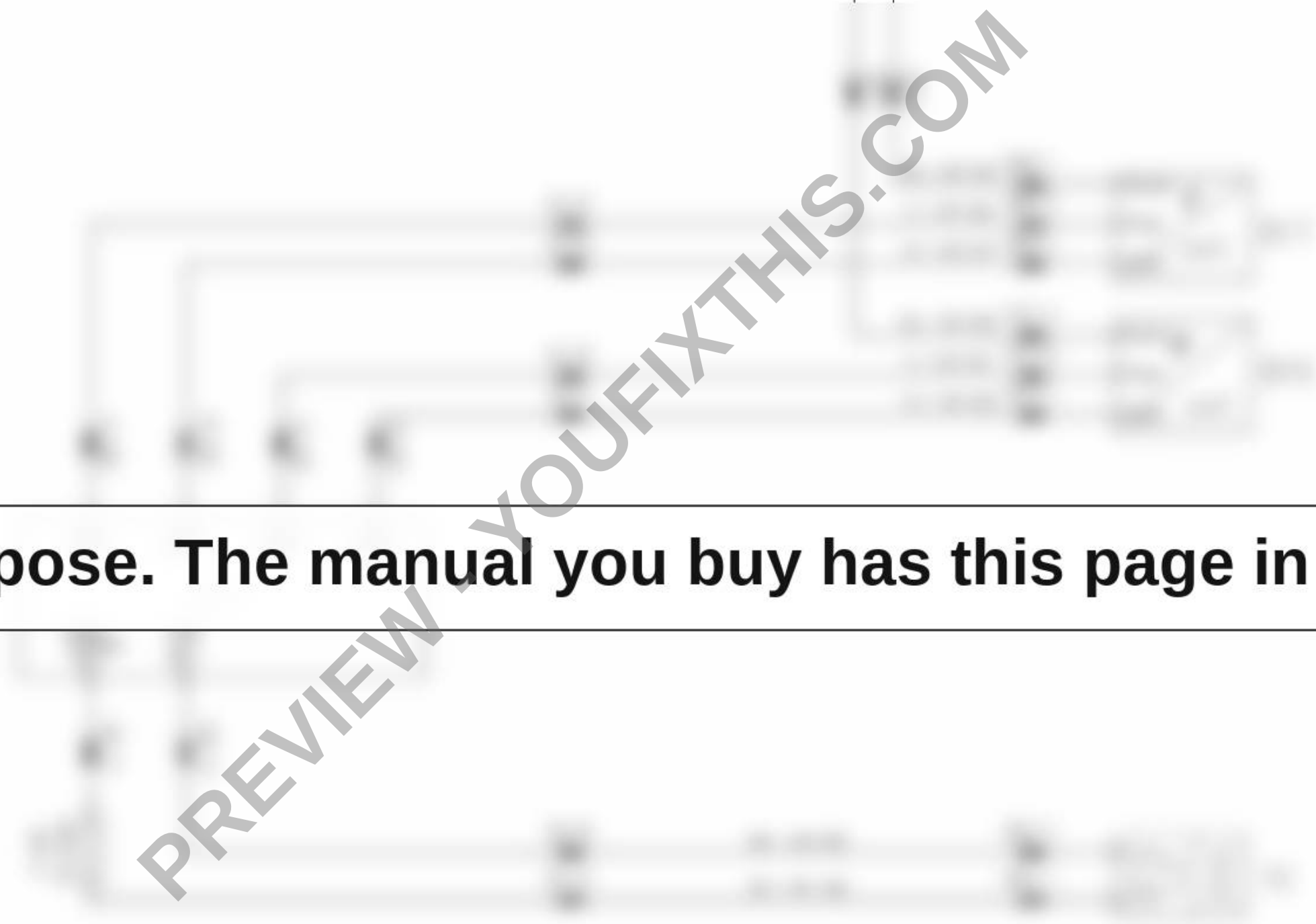


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ECU GROUND  Sheet 8Sheet 10  ECU GROUND

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Torque

Minimum hardware tightening torques are Nm and Lbs ft or Lbs in for normal assembly applications unless otherwise stated

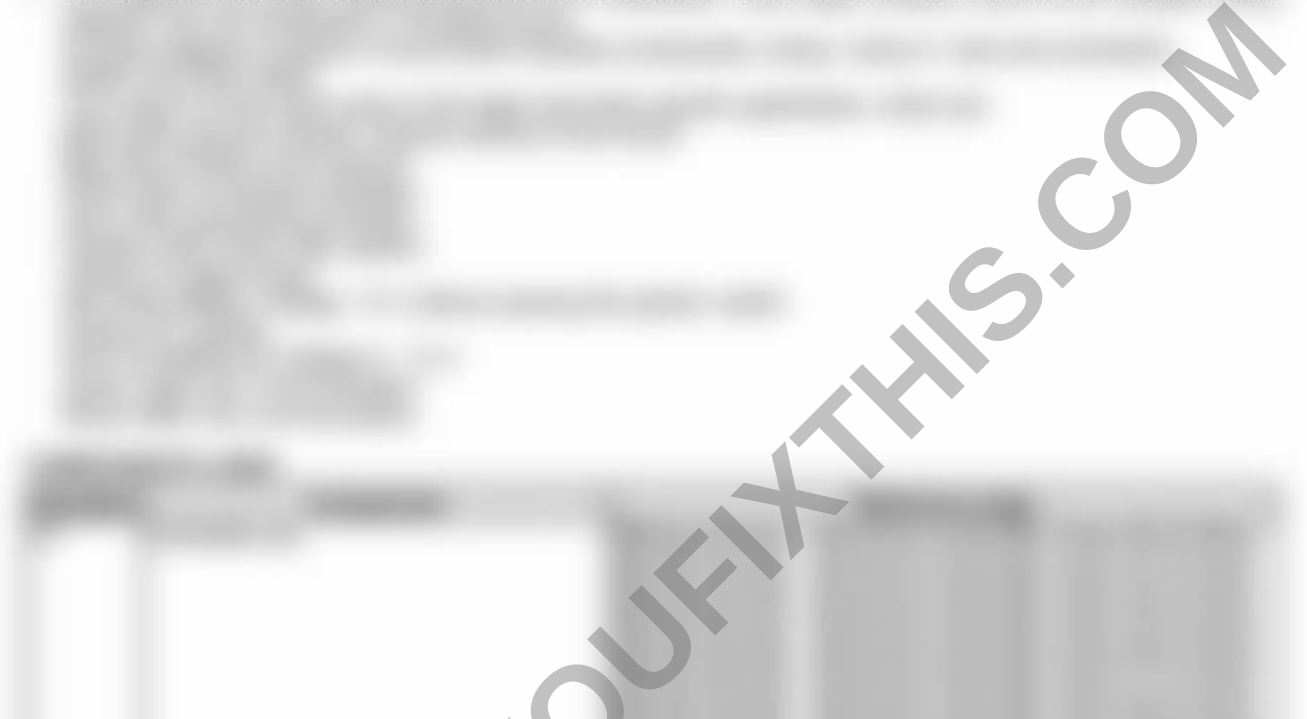
IMPORTANT: Always use the correct torque wrench for the application. Do not use a standard torque wrench for high torque applications. Use a high torque torque wrench for high torque applications.

Hardware	Minimum Torque (Nm)	Minimum Torque (Lbs ft)	Minimum Torque (Lbs in)
1/4" x 1/2" Hex Bolt	10	7.5	100
1/4" x 3/4" Hex Bolt	15	11	150
1/2" x 1" Hex Bolt	25	18	250
1/2" x 1 1/4" Hex Bolt	35	26	350
3/4" x 1 1/2" Hex Bolt	50	37	500
1" x 2" Hex Bolt	75	55	750
1 1/4" x 2 1/2" Hex Bolt	100	74	1000
1 1/2" x 3" Hex Bolt	150	110	1500
2" x 4" Hex Bolt	250	184	2500
2 1/2" x 5" Hex Bolt	350	258	3500
3" x 6" Hex Bolt	500	368	5000
3 1/2" x 7" Hex Bolt	750	552	7500
4" x 8" Hex Bolt	1000	738	10000
4 1/2" x 9" Hex Bolt	1500	1107	15000
5" x 10" Hex Bolt	2500	1844	25000
5 1/2" x 11" Hex Bolt	3500	2581	35000
6" x 12" Hex Bolt	5000	3678	50000
6 1/2" x 13" Hex Bolt	7500	5517	75000
7" x 14" Hex Bolt	10000	7376	100000
7 1/2" x 15" Hex Bolt	15000	11064	150000
8" x 16" Hex Bolt	25000	18440	250000
8 1/2" x 17" Hex Bolt	35000	25812	350000
9" x 18" Hex Bolt	50000	36780	500000
9 1/2" x 19" Hex Bolt	75000	55170	750000
10" x 20" Hex Bolt	100000	73760	1000000
10 1/2" x 21" Hex Bolt	150000	110640	1500000
11" x 22" Hex Bolt	250000	184400	2500000
11 1/2" x 23" Hex Bolt	350000	258120	3500000
12" x 24" Hex Bolt	500000	367800	5000000
12 1/2" x 25" Hex Bolt	750000	551700	7500000
13" x 26" Hex Bolt	1000000	737600	10000000
13 1/2" x 27" Hex Bolt	1500000	1106400	15000000
14" x 28" Hex Bolt	2500000	1844000	25000000
14 1/2" x 29" Hex Bolt	3500000	2581200	35000000
15" x 30" Hex Bolt	5000000	3678000	50000000
15 1/2" x 31" Hex Bolt	7500000	5517000	75000000
16" x 32" Hex Bolt	10000000	7376000	100000000
16 1/2" x 33" Hex Bolt	15000000	11064000	150000000
17" x 34" Hex Bolt	25000000	18440000	250000000
17 1/2" x 35" Hex Bolt	35000000	25812000	350000000
18" x 36" Hex Bolt	50000000	36780000	500000000
18 1/2" x 37" Hex Bolt	75000000	55170000	750000000
19" x 38" Hex Bolt	100000000	73760000	1000000000
19 1/2" x 39" Hex Bolt	150000000	110640000	1500000000
20" x 40" Hex Bolt	250000000	184400000	2500000000
20 1/2" x 41" Hex Bolt	350000000	258120000	3500000000
21" x 42" Hex Bolt	500000000	367800000	5000000000
21 1/2" x 43" Hex Bolt	750000000	551700000	7500000000
22" x 44" Hex Bolt	1000000000	737600000	10000000000
22 1/2" x 45" Hex Bolt	1500000000	1106400000	15000000000
23" x 46" Hex Bolt	2500000000	1844000000	25000000000
23 1/2" x 47" Hex Bolt	3500000000	2581200000	35000000000
24" x 48" Hex Bolt	5000000000	3678000000	50000000000
24 1/2" x 49" Hex Bolt	7500000000	5517000000	75000000000
25" x 50" Hex Bolt	10000000000	7376000000	100000000000
25 1/2" x 51" Hex Bolt	15000000000	11064000000	150000000000
26" x 52" Hex Bolt	25000000000	18440000000	250000000000
26 1/2" x 53" Hex Bolt	35000000000	25812000000	350000000000
27" x 54" Hex Bolt	50000000000	36780000000	500000000000
27 1/2" x 55" Hex Bolt	75000000000	55170000000	750000000000
28" x 56" Hex Bolt	100000000000	73760000000	1000000000000
28 1/2" x 57" Hex Bolt	150000000000	110640000000	1500000000000
29" x 58" Hex Bolt	250000000000	184400000000	2500000000000
29 1/2" x 59" Hex Bolt	350000000000	258120000000	3500000000000
30" x 60" Hex Bolt	500000000000	367800000000	5000000000000
30 1/2" x 61" Hex Bolt	750000000000	551700000000	7500000000000
31" x 62" Hex Bolt	1000000000000	737600000000	10000000000000
31 1/2" x 63" Hex Bolt	1500000000000	1106400000000	15000000000000
32" x 64" Hex Bolt	2500000000000	1844000000000	25000000000000
32 1/2" x 65" Hex Bolt	3500000000000	2581200000000	35000000000000
33" x 66" Hex Bolt	5000000000000	3678000000000	50000000000000
33 1/2" x 67" Hex Bolt	7500000000000	5517000000000	75000000000000
34" x 68" Hex Bolt	10000000000000	7376000000000	100000000000000
34 1/2" x 69" Hex Bolt	15000000000000	11064000000000	150000000000000
35" x 70" Hex Bolt	25000000000000	18440000000000	250000000000000
35 1/2" x 71" Hex Bolt	35000000000000	25812000000000	350000000000000
36" x 72" Hex Bolt	50000000000000	36780000000000	500000000000000
36 1/2" x 73" Hex Bolt	75000000000000	55170000000000	750000000000000
37" x 74" Hex Bolt	100000000000000	73760000000000	1000000000000000
37 1/2" x 75" Hex Bolt	150000000000000	110640000000000	1500000000000000
38" x 76" Hex Bolt	250000000000000	184400000000000	2500000000000000
38 1/2" x 77" Hex Bolt	350000000000000	258120000000000	3500000000000000
39" x 78" Hex Bolt	500000000000000	367800000000000	5000000000000000
39 1/2" x 79" Hex Bolt	750000000000000	551700000000000	7500000000000000
40" x 80" Hex Bolt	1000000000000000	737600000000000	10000000000000000
40 1/2" x 81" Hex Bolt	1500000000000000	1106400000000000	15000000000000000
41" x 82" Hex Bolt	2500000000000000	1844000000000000	25000000000000000
41 1/2" x 83" Hex Bolt	3500000000000000	2581200000000000	35000000000000000
42" x 84" Hex Bolt	5000000000000000	3678000000000000	50000000000000000
42 1/2" x 85" Hex Bolt	7500000000000000	5517000000000000	75000000000000000
43" x 86" Hex Bolt	10000000000000000	7376000000000000	100000000000000000
43 1/2" x 87" Hex Bolt	15000000000000000	11064000000000000	150000000000000000
44" x 88" Hex Bolt	25000000000000000	18440000000000000	250000000000000000
44 1/2" x 89" Hex Bolt	35000000000000000	25812000000000000	350000000000000000
45" x 90" Hex Bolt	50000000000000000	36780000000000000	500000000000000000
45 1/2" x 91" Hex Bolt	75000000000000000	55170000000000000	750000000000000000
46" x 92" Hex Bolt	100000000000000000	73760000000000000	1000000000000000000
46 1/2" x 93" Hex Bolt	150000000000000000	110640000000000000	1500000000000000000
47" x 94" Hex Bolt	250000000000000000	184400000000000000	2500000000000000000
47 1/2" x 95" Hex Bolt	350000000000000000	258120000000000000	3500000000000000000
48" x 96" Hex Bolt	500000000000000000	367800000000000000	5000000000000000000
48 1/2" x 97" Hex Bolt	750000000000000000	551700000000000000	7500000000000000000
49" x 98" Hex Bolt	1000000000000000000	737600000000000000	10000000000000000000
49 1/2" x 99" Hex Bolt	1500000000000000000	1106400000000000000	15000000000000000000
50" x 100" Hex Bolt	2500000000000000000	1844000000000000000	25000000000000000000
50 1/2" x 101" Hex Bolt	3500000000000000000	2581200000000000000	35000000000000000000
51" x 102" Hex Bolt	5000000000000000000	3678000000000000000	50000000000000000000
51 1/2" x 103" Hex Bolt	7500000000000000000	5517000000000000000	75000000000000000000
52" x 104" Hex Bolt	10000000000000000000	7376000000000000000	100000000000000000000
52 1/2" x 105" Hex Bolt	15000000000000000000	11064000000000000000	150000000000000000000
53" x 106" Hex Bolt	25000000000000000000	18440000000000000000	250000000000000000000
53 1/2" x 107" Hex Bolt	35000000000000000000	25812000000000000000	350000000000000000000
54" x 108" Hex Bolt	50000000000000000000	36780000000000000000	500000000000000000000
54 1/2" x 109" Hex Bolt	75000000000000000000	55170000000000000000	750000000000000000000
55" x 110" Hex Bolt	100000000000000000000	73760000000000000000	1000000000000000000000
55 1/2" x 111" Hex Bolt	150000000000000000000	110640000000000000000	1500000000000000000000
56" x 112" Hex Bolt	250000000000000000000	184400000000000000000	2500000000000000000000
56 1/2" x 113" Hex Bolt	350000000000000000000	258120000000000000000	3500000000000000000000
57" x 114" Hex Bolt	500000000000000000000	367800000000000000000	5000000000000000000000
57 1/2" x 115" Hex Bolt	750000000000000000000	551700000000000000000	7500000000000000000000
58" x 116" Hex Bolt	1000000000000000000000	737600000000000000000	10000000000000000000000
58 1/2" x 117" Hex Bolt	1500000000000000000000	1106400000000000000000	15000000000000000000000
59" x 118" Hex Bolt	2500000000000000000000	1844000000000000000000	25000000000000000000000
59 1/2" x 119" Hex Bolt	3500000000000000000000	2581200000000000000000	35000000000000000000000
60" x 120" Hex Bolt	5000000000000000000000	3678000000000000000000	50000000000000000000000
60 1/2" x 121" Hex Bolt	7500000000000000000000	5517000000000000000000	75000000000000000000000
61" x 122" Hex Bolt	10000000000000000000000	7376000000000000000000	100000000000000000000000
61 1/2" x 123" Hex Bolt	15000000000000000000000	11064000000000000000000	150000000000000000000000
62" x 124" Hex Bolt	25000000000000000000000	18440000000000000000000	250000000000000000000000
62 1/2" x 125" Hex Bolt	35000000000000000000000	25812000000000000000000	350000000000000000000000
63" x 126" Hex Bolt	50000000000000000000000	36780000000000000000000	500000000000000000000000
63 1/2" x 127" Hex Bolt	75000000000000000000000	55170000000000000000000	750000000000000000000000
64" x 128" Hex Bolt	100000000000000000000000	73760000000000000000000	1000000000000000000000000
64 1/2" x 129" Hex Bolt	150000000000000000000000	110640000000000000000000	1500000000000000000000000
65" x 130" Hex Bolt	250000000000000000000000	184400000000000000000000	2500000000000000000000000
65 1/2" x 131" Hex Bolt	350000000000000000000000	258120000000000000000000	3500000000000000000000000
66" x 132" Hex Bolt	500000000000000000000000	367800000000000000000000	5000000000000000000000000
66 1/2" x 133" Hex Bolt	750000000000000000000000	551700000000000000000000	7500000000000000000000000
67" x 134" Hex Bolt	1000000000000000000000000	737600000000000000000000	10000000000000000000000000
67 1/2" x 135" Hex Bolt	1500000000000000000000000	1106400000000000000000000	15000000000000000000000000
68" x 136" Hex Bolt	2500000000000000000000000	1844000000000000000000000	25000000000000000000000000
68 1/2" x 137" Hex Bolt	3500000000000000000000000	2581200000000000000000000	35000000000000000000000000
69" x 138" Hex Bolt	5000000000000000000000000	3678000000000000000000000	50000000000000000000000000
69 1/2" x 139" Hex Bolt	7500000000000000000000000	5517000000000000000000000	75000000000000000000000000
70" x 140" Hex Bolt	10000000000000000000000000	7376000000000000000000000	100000000000000000000000000
70 1/2" x 141" Hex Bolt	15000000000000000000000000	11064000000000000000000000	150000000000000000000000000
71" x 142" Hex Bolt	25000000000000000000000000	18440000000000000000000000	250000000000000000000000000
71 1/2" x 143" Hex Bolt	35000000000000000000000000	25812000000000000000000000	350000000000000000000000000
72" x 144" Hex Bolt	50000000000000000000000000	36780000000000000000000000	500000000000000000000000000
72 1/2" x 145" Hex Bolt	75000000000000000000000000	55170000000000000000000000	750000000000000000000000000
73" x 146" Hex Bolt	100000000000000000000000000	73760000000000000000000000	1000000000000000000000000000
73 1/2" x 147" Hex Bolt	150000000000000000000000000	110640000000000000000000000	1500000000000000000000000000
74" x 148" Hex Bolt	250000000000000000000000000		

ELECTRICAL POWER SYSTEM - Component identification From serial number 4700

WIRING DIAGRAMS

The diagrams are drawn following the DIN 40710 standards. Each page contains a part of the complete wiring



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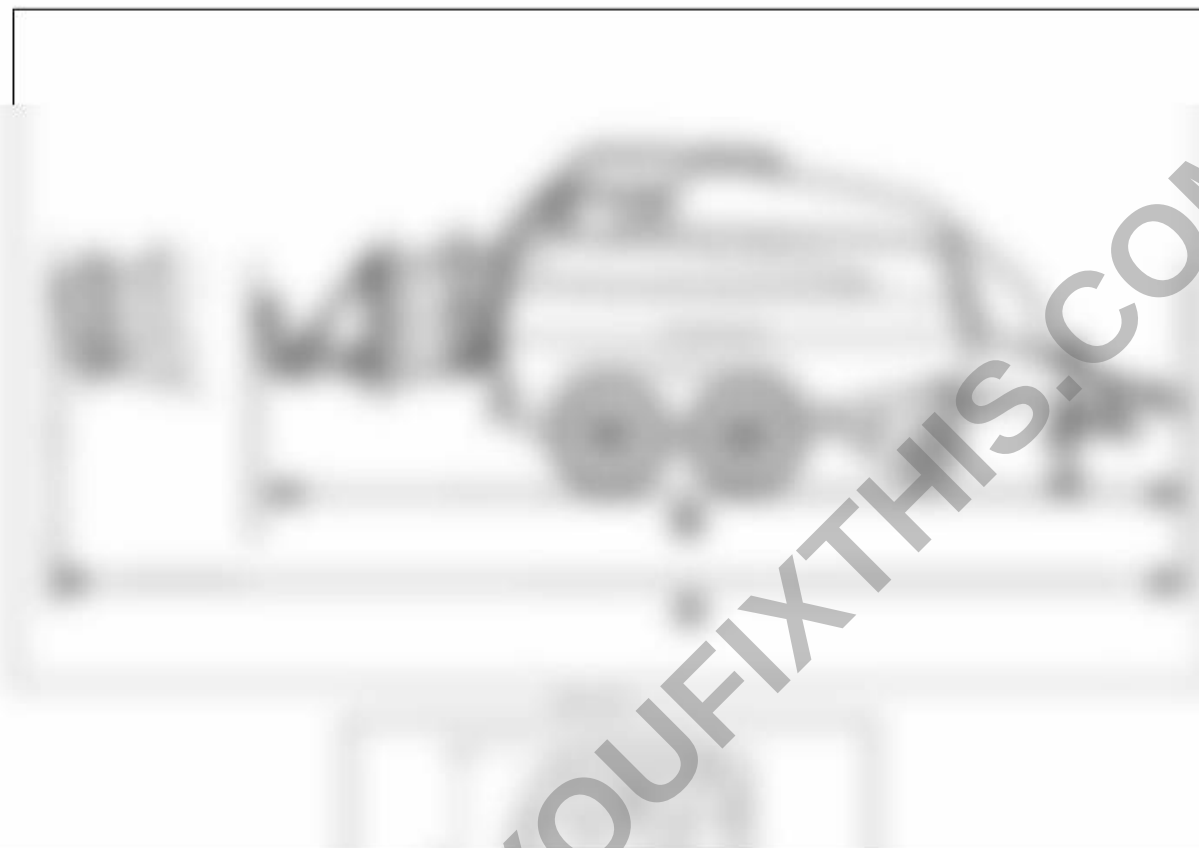


**Wiring harness - Electrical schematic frame 10 KNOTTER Fans
From serial number 4700**

Component Identifier	Component
A-1	Controller box

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General specification From serial number 4700



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Complete Contents

INTRODUCTION

DISTRIBUTION SYSTEMS.....A

ELECTRICAL POWER SYSTEM A.30.A

ELECTRONIC SYSTEM A.50.A

FAULT CODES A.50.A

LUBRICATION SYSTEM Greasing..... A.60.B

LUBRICATION SYSTEM Oiling A.60.C

POWER PRODUCTION B

PTO POWER IN B.90.A

POWER TRAIN C

PROCESS DRIVE Primary process drive C.50.B

TRAVELLING D

PARKING BRAKE Mechanical D.32.B

PULLED-TYPE VEHICLE BRAKE Pneumatic D.36.E

TOWED VEHICLE AXLE Single axle D.13.B

TOWED VEHICLE AXLE Tandem axle..... D.13.C

CROP PROCESSING K

PICKING Picking up K.20.B

FEEDING Precompression K.25.F

FEEDING Packer feeding K.25.M

FEEDING Rotor feeding K.25.N

FEEDING Stuffer K.25.P

CHOPPING Crop cutter K.30.E

PRESSING Square bale pressing..... K.50.E

WRAPPING AND TYING Twine tying K.55.B

EJECTING Square bale K.70.C

PROTECTION SYSTEMS Needle protecting system K.90.D

Foreword

How to use this manual

The information in this manual has been structured using the Integrated Coding Environment (ICE). Ice is the new way in which technical information is created, stored and retrieved in the new Technical Information Database.

ICE coding classifies each repair operation three ways

1. Location: the function or component on the machine to which the information is related e.g. Hydraulic pump
2. Information type: the type of information describing the repair operation e.g. Remove
3. Product: The machine that the repair operation is created for e.g. Big Balers

Section contents

Your manual is first divided in sections. Sections are classified according to the main functions of the product. Each Section has a Contents page listed in numerical order and Index page listed in Alphabetical order.

Big Baler Section Contents

- DISTRIBUTION SYSTEMS
(A) that interact with most of the functions of the product. it contains the central parts of the hydraulic, electrical, electronic, pneumatic and lubrication systems.
- POWER PRODUCTION
(B) all of the functions related to the production of power to operate the vehicle PTO drive line and related parts.
- POWER TRAIN
(C) all of the functions related to the transfer of power to operate the vehicle though a gearbox.
- TRAVELLING
(D) this encompasses all parts related to the parts when the vehicle moves across ground, wheels, axles and brakes.
- BODY AND STRUCTURE
(E) and protective shields
- CROP PROCESSING
(K) encompasses all parts related to crop handling from pick up to bale ejecting.

Chapter contents

The Section is then divided in Chapters. Chapters are classified according to the specific function of the systems and components. Each Chapter has a contents page listed in numerical order and index page listed in alphabetical order.

An example of a Chapter and Contents, is the component e.g. LUBRICATION SYSTEM Greasing, where the system is sub divided and described through

1. TECHNICAL DATA, information describing specifications or characteristics of any function or system of the machine.
2. FUNCTIONAL DATA, information describing design and functional behavior of any function or system (How it works)
3. SERVICE, information describing the maintenance and repair of the machine.
4. DIAGNOSTIC, information related to systems, troubleshooting and errors.

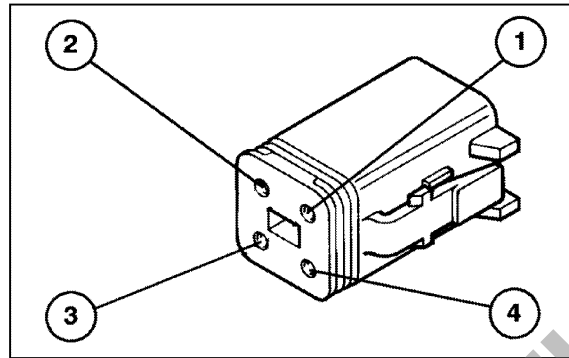
An example of the ICE Coding reference could look like:

Pump - Overhaul (A.60.B.20-F.10.A.40)

- A = SECTION
- 60 = CHAPTER
- B.20 = COMPONENT
- F = SERVICE

Greasing system - B15

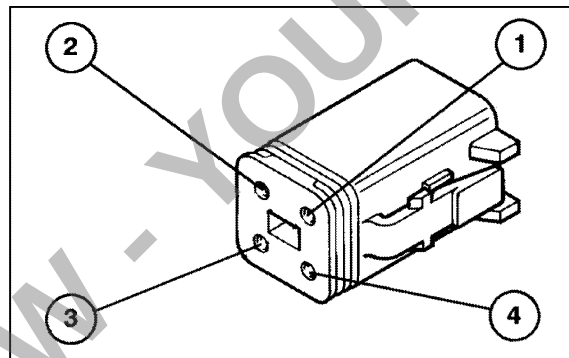
Pin No	Cable and Colour	To	Pin No	Function
1	BL 1	X4	7	GND
2	Y 1	X4	6	A10

X136

BBAS06X130 9

Trip motor - M 004

Pin No	Cable and Colour	To	Pin No	Function

X137

BBAS06X130 10

Moisture controller

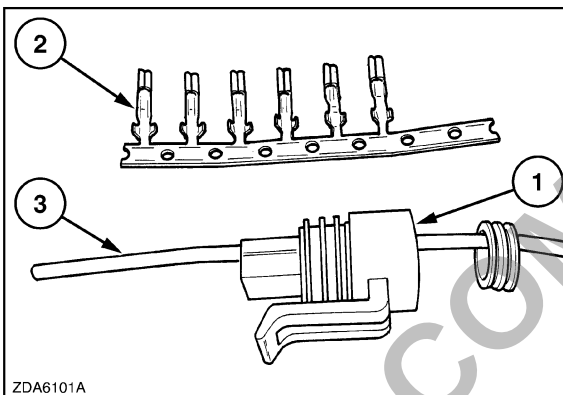
Pin No	Cable and Colour	To	Pin No	Function
1	OR 1.5	SPL12	X	Splice
3	BL 1.5	SPL13	X	Splice
4	GN 1.5	SPL14	X	Splice
2	Y 1.5	SPL15	X	Splice

Knotter Fans - Frame 10

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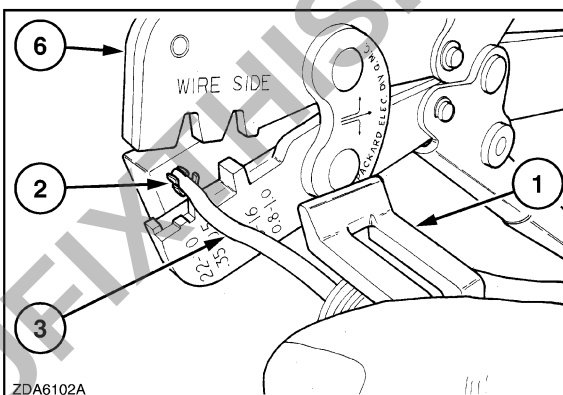
18. Wire and terminal installation. The seal and housing (1) must be installed on the wire(s) (3) PRIOR to crimping the terminal(s) (2) on the wire(s).

NOTE: Refer to the electrical wiring diagrams to determine the correct hole location for each of the wires.



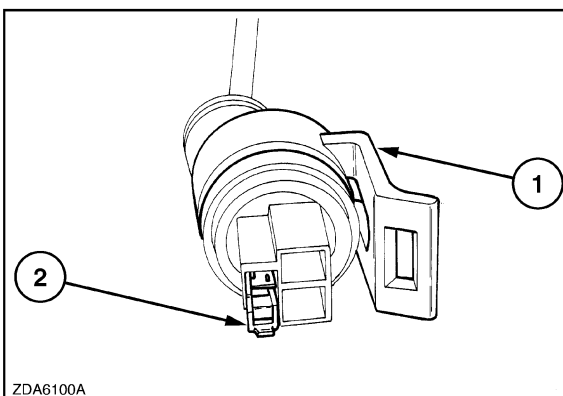
ZDA6101A 18

19. Now crimp the spade (2) onto the wire (3) with the special crimp tool (6). Mind the housing and seal are on the wire first.



ZDA6102A 19

20. Check that the lip on the spade is lifted, for positive retention. Pull the wire and spade (2) back into the housing (1). The spade has ONLY ONE particular position with respect to the housing cavity that it will fit in. Do not force the spade in the cavity, rotate the spade a ¼ turn at the time with respect to the cavity in the housing, until the position is found that it will slide in easily. Check that the seal is properly seated in the rear end of the housing.



ZDA6100A 20

21. X3, X4, X6 - CONNECTORS ON THE FUSE BOARD MODULE:

Plug

1 housing Deutsch HD 36-24-31 PE

2 90° elbow Deutsch WHDS 24-2

3 pin, male #16 Deutsch 0460-202-16141

4 blanking plug #16 Deutsch 114017 duplicated part number with or #16 Deutsch 114017 North America Socket

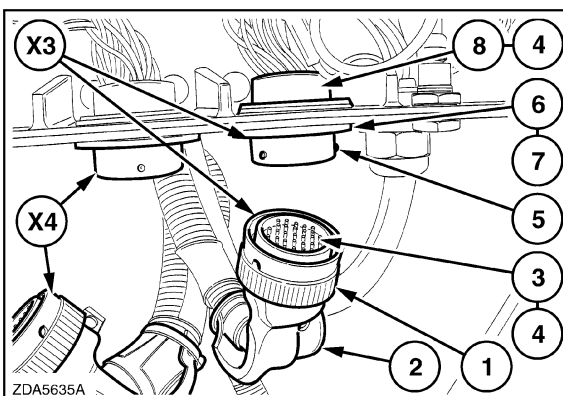
4 blanking plug #16 Deutsch 114017 duplicated part number with or #16 Deutsch 114017 North America

5 housing Deutsch HD 34-24-31 SE

6 lockwasher 24 Deutsch 112264

7 flat nut 24 Deutsch 112263-90

8 pin, female #16 Deutsch 0462-201-16141



ZDA5635A 21

229-Pick up speed sensor short to ground From serial number 4700

Cause:

Possible failure modes: sensor **(B8)**, controller.

Solution:

1. Select the pick up speed **(B8)** routine in the dealer diagnostic input pages, refer to **Monitor - Service instruction (A.50.A)**.

The voltage bargraph will be **<0.5 V** and the digital option will show defect.

2. Disconnect **X113**.

Does the voltage bargraph is higher then **7.2 V**.

Replace sensor **(B8)**.

A. Else continue with **3**

3. Disconnect **X4** Pin 14.

Does the voltage bargraph read higher than **7.2 V**.

Repair wire MT 024 YE

Else try with new Baler Controller of known performance.

Wiring harness - Electrical schematic frame 17 (A.30.A.88 - C.20.E.17)

306-Motor trip system From serial number 4700

Cause:

Possible failure modes: controller, relay (**K15**), wires.

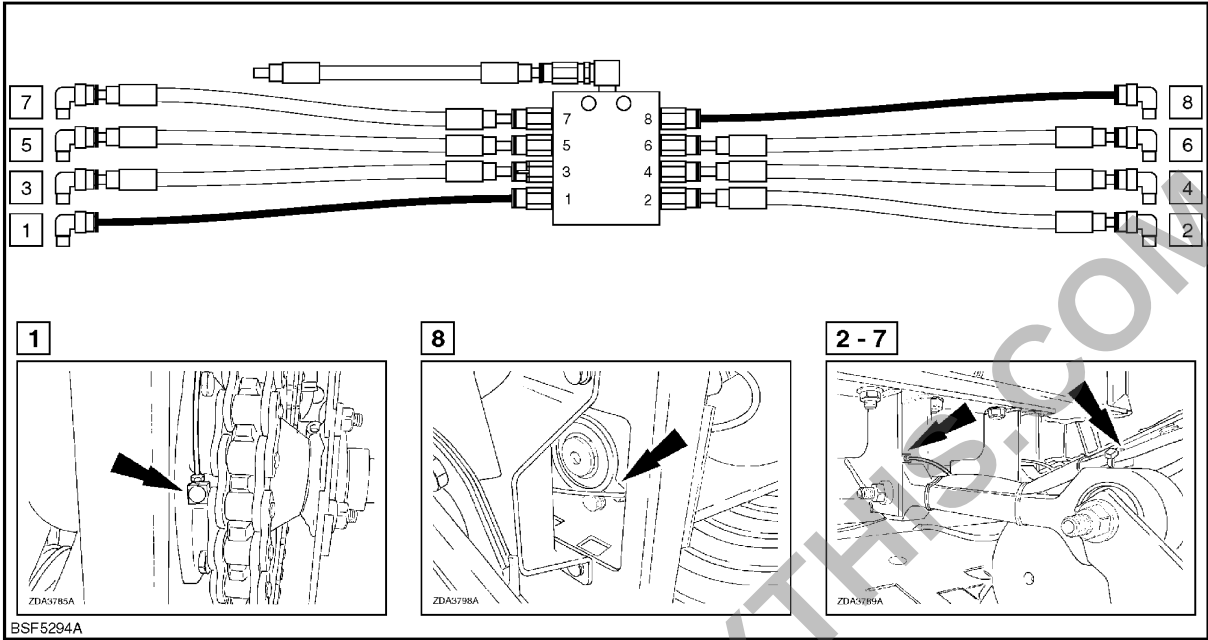
Solution:

1. Select the monitor for motor trip system on (refer to operators manual)
Check if (**K15**) is operational.
If not replace (**K15**) or try with new Baler Controller of known performance

A. Else go to **2**
2. Remove (**K15**) and check for **12 V** between pin 1 and 2.
If **12 V** replace (**K15**)

A. Else go to **3**
3. Measure between **X34** pin 19 and (**K15**)pin 2.
If **12 V** check or replace flat cable **X34** to **X31**.
Else try with new Baler Controller of known performance

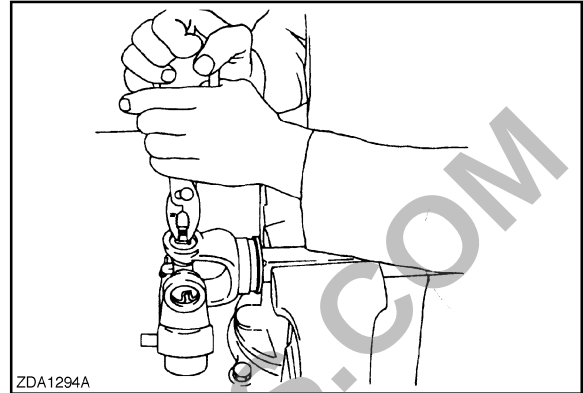
Wiring harness - Electrical schematic frame 16 (A.30.A.88 - C.20.E.16)



BSF5294A 11

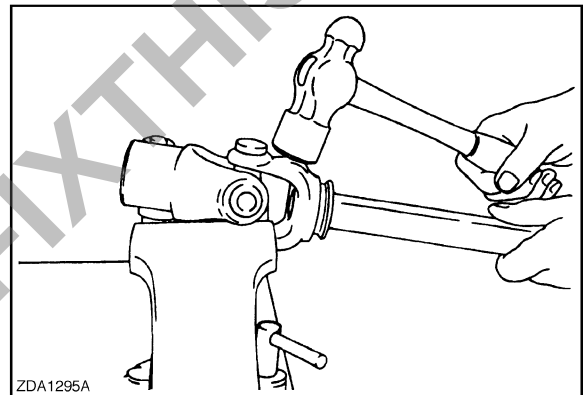
Drive system Standard U-Joint - Disassemble

1. Remove the four retaining rings on the cross to be repaired.



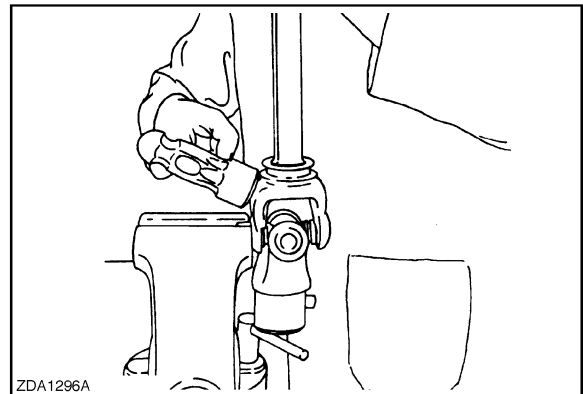
ZDA1294A 1

2. Set the U-Joint across the open jaws of a vise and drive the bearing cap out of the yoke.



ZDA1295A 2

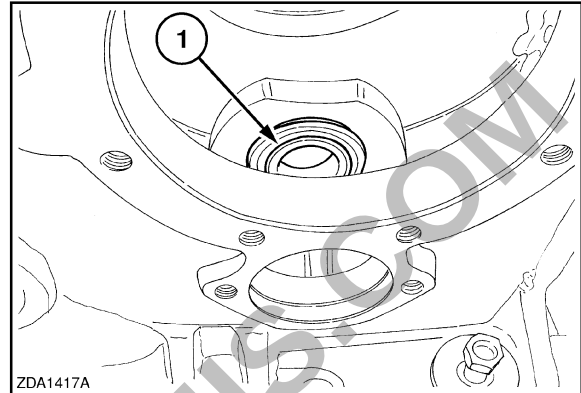
3. Getting the bearing cap all the way out may require clamping it in a vise and tapping the yoke.



ZDA1296A 3

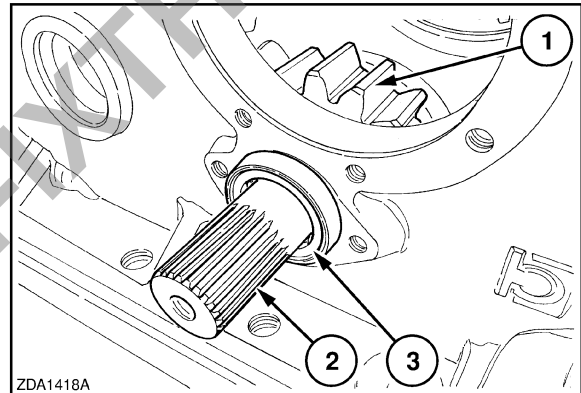
10. ASSEMBLY OF THE PACKER/ROTOR + PICK-UP
DRIVE SHAFT : **Gearbox Shaft - Sectional view**
(C.50.B)

11. Install bearing (1).



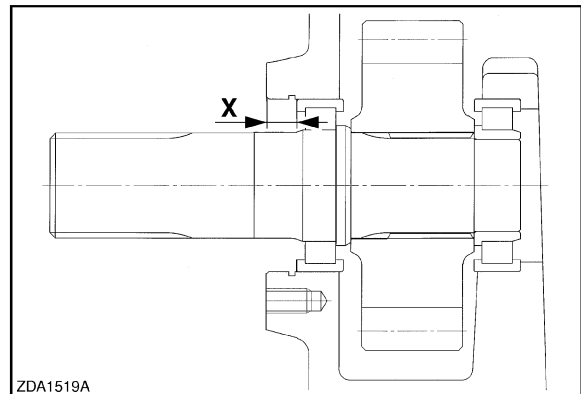
ZDA1417A 8

12. Position gear (1) and insert shaft (2).
Install bearing (3). Drive bearing (3) as far as possible into the housing.



ZDA1418A 9

13. Measure the dimension X.



ZDA1519A 10

Contents

TRAVELLING - D

TOWED VEHICLE AXLE Tandem axle - 13.C

TECHNICAL DATA

TOWED VEHICLE AXLE Tandem axle

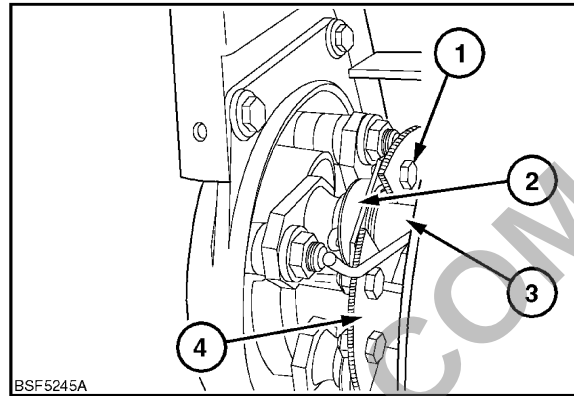
General specification	3
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FUNCTIONAL DATA

TOWED VEHICLE AXLE Tandem axle

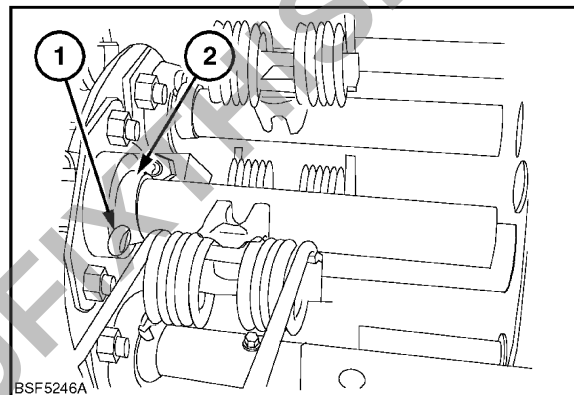
Static description	4
Overview	6

4. Remove the two bolts (1) in the bearing carriers (2) at both ends of each tooth bar (3) to be removed. The tooth bar is now free to be removed. Lift the tooth bar up out of the slot in the disc (4) and then to the left to free the cam follower.



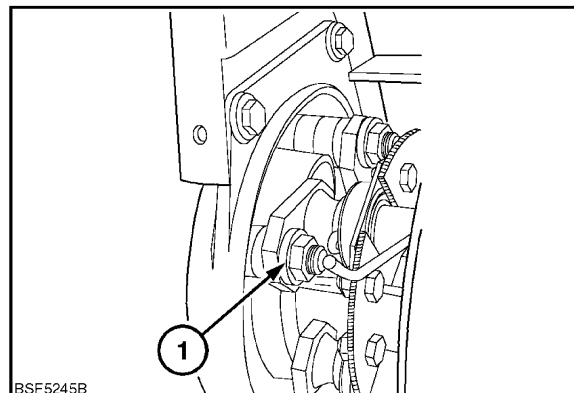
bsf5245a 4

5. Remove all the parts from the tooth bar. There is a special hardened cotter pin (1) holding the bearings (2) to the shaft. If the bearing on the left end of the tooth bar is the only failed part, only that part will have to be removed from the tooth bar.



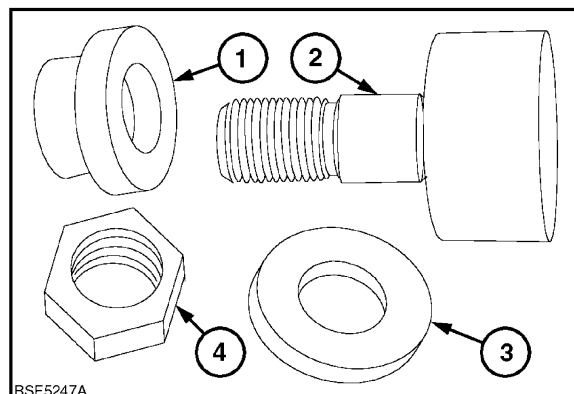
bsf5246a 5

6. If the tooth bar is to be replaced, remove all the parts including the cam follower bearing (1). To remove the bearing, use an **8 mm 0.315 in** Allen wrench to hold the bearing and unscrew the nut. With the nut at the end of the bearing stud, use a soft punch to drive the cam follower bearing out of the arm on the end of the tooth pipe.



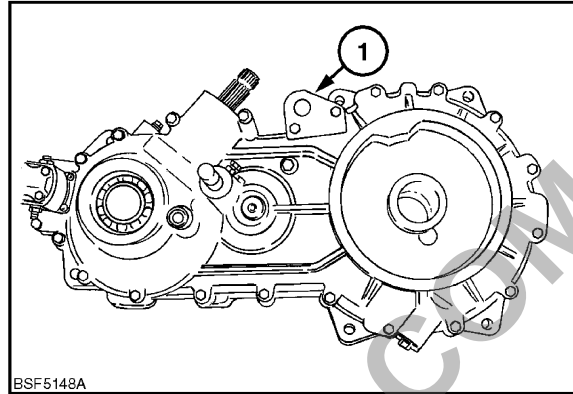
bsf5245b 6

7. The cam follower assembly consists of the spacer (1) bearing (2) washer (3) and nut (4).



bsf5247a 7

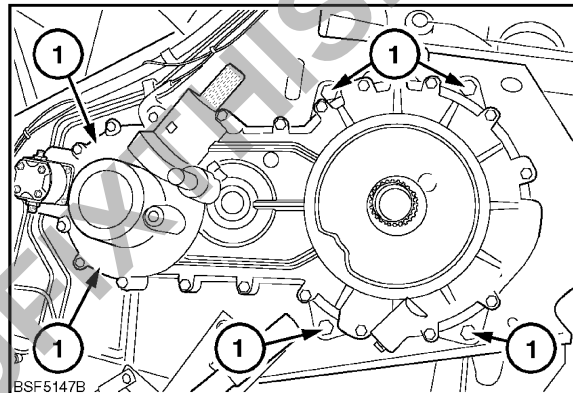
12. Using the lifting plate (1) and a lifting device, install the gearbox onto the baler.



bsf5148a 11

13. Install the six bolts (1) that secures the stuffer to the baler.

NOTE: Do not tighten the bolts. The stuffer must be shimmed to the baler properly.

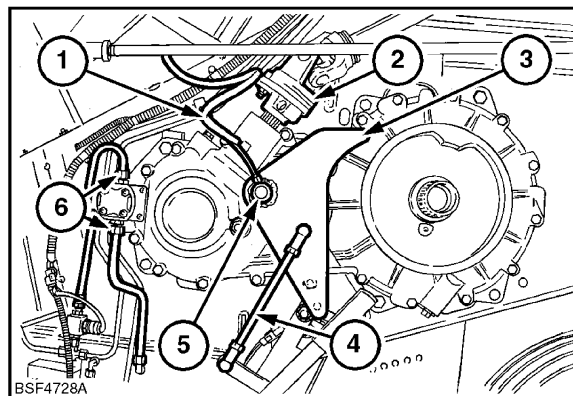


bsf5147b 12

14. The shimming procedures are as follows: w Remove the stuffer brake completely by removing the retaining ring do not loosen the brake nuts itself because this is a factory setting so that the stuffer shaft can be turned by hand.

NOTE: Refer to brake removal procedures in this section if required.

15. Tighten the bolt in the lower right hand corner of the gearbox securing it to the baler. Check if the stuffer shaft can still be turned by hand. It should be able to. Shim the remaining five bolt locations to prevent the gearbox from flexing or moving as they are tightened. Reinstall the stuffer brake.
16. Install stuffer engagement arm (3) shims and snap ring (5). Reconnect oil lines (1) and control linkage (4). Reconnect telescopic U-joint assembly (2). Reconnect hydraulic lines (6).



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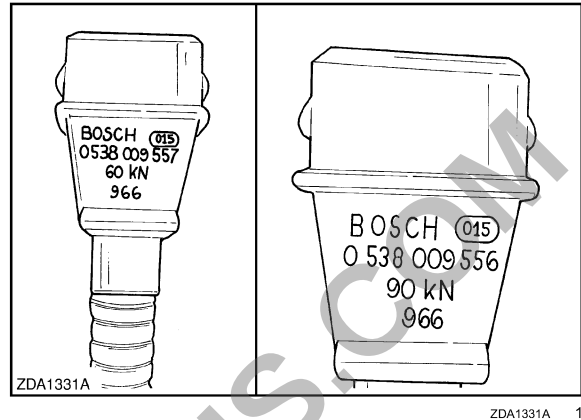
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PREVIEW - YOUFIXTHIS.COM

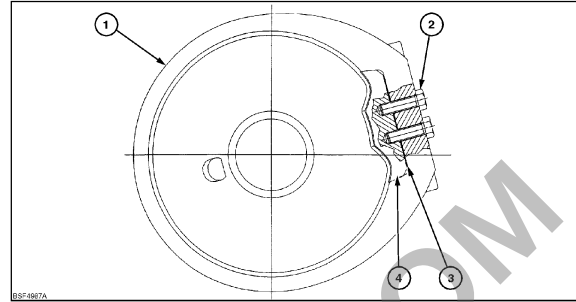
Sensing system - Visual inspection

1. The load sensor installed on 4 Knotter and 6 Knotter baler is not the same. Visually there is no difference, only **60 kN** 4 Knotter and **90 kN** 6 Knotter is mentioned on the connector.



15. knotter clutch cam lobe replacement

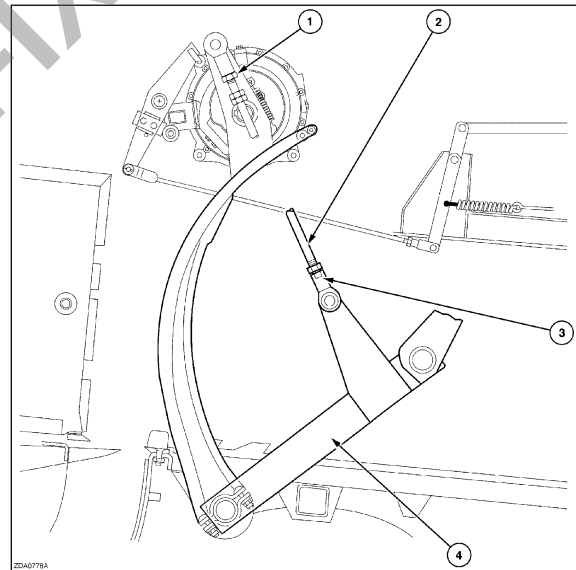
NOTE: The cam, 4, is an integral part of the gearbox. If the cam needs replacement, follow the directions to repair the gearbox.



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16. Remove the two M12 bolts (1) holding the lobe in the cam. Take out the lobe (2) and the shims (3) under the lobe. Install the new lobe. Tighten the two bolts together, alternating between the bolts until a torque of **35-40 Nm**. Measure the gap under the lobe with a thickness gauge. Determine the average gap. Remove the bolts. Add the required shims or slightly less to fill the gap. Add Loctite 270 to the bolts. Tighten the bolts together to a torque of **120 Nm**. Trip the clutch. Rotate the flywheel by hand. Check that the clutch resets properly.

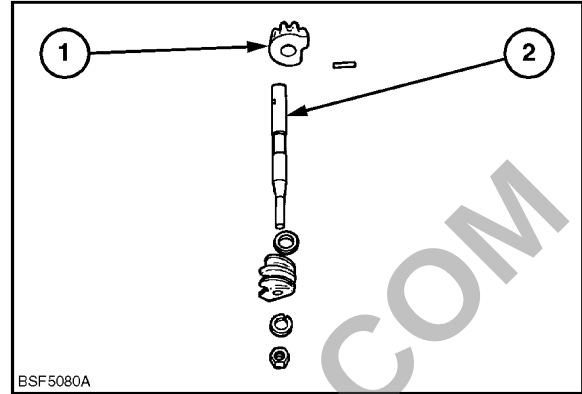
17. knotter clutch roller and arm replacement:



ZDA0778A 12

18. Trip the knotter. Rotate the flywheel in the normal direction until the tie rods (2) to the needle yoke (1) have no load. Lock the flywheel and do not rotate it while the gearbox is removed. Remove the bolt through the lower left ball joint (3). Slide the ball joint off the pin. Loosen the top jam nut (4). Screw the tie rod out of the top ball joint.

8. Worm gear (1) and shaft (2).



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