

Swath Compressor for M1 Series Windrowers

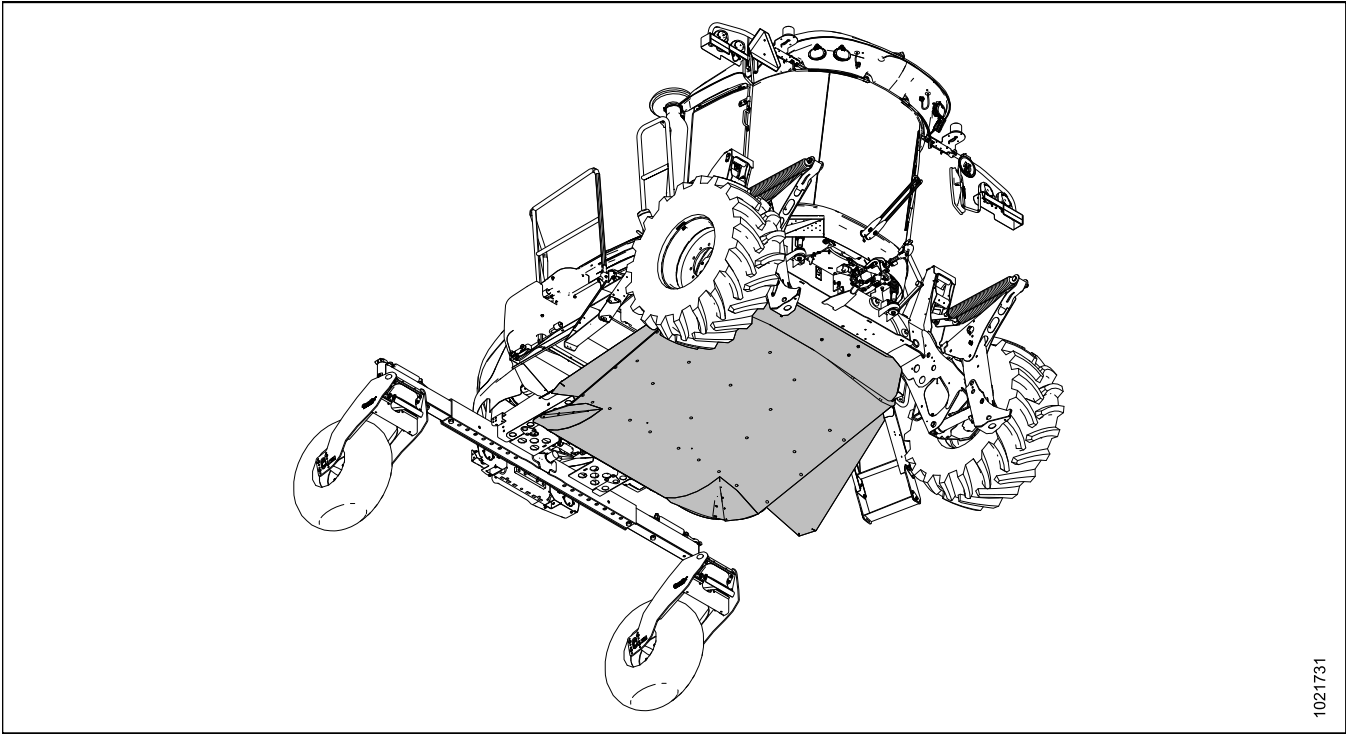
Setup, Operation, and Parts Manual

214496 Revision A

2018 Model Year

Original Instruction

Swath Compressor for M1 Series Windrowers



1021731

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List of Revisions

At MacDon, we're continuously making improvements, and occasionally these improvements affect product documentation. The following list provides an account of major changes from the previous version of this document.

Summary of Change	Location
Various wording changes. Switches replace buttons. Compression replaces down force.	Throughout manual
Figure 2.1 revised. Step 8 Remove pin added. Step 10 Remove shipping wire added.	2.1 Removing Swath Compressor from Shipping Crate, page 11
Chapter 2 Installation Instructions was Assembly Instructions.	2 Installation Instructions, page 11
Section 2.2 Installing Swath Compressor was Installing Swath Compressor on M1 Series Windrower. Separated into topics.	2.2 Installing Swath Compressor, page 14
Steps 20–23. Bolt tightening sequence changed. Figures 2.14, 2.18, 2.21 revised. Figures 2.11, 2.22 added. Order of frame installation revised. Step 3 added to loosen clamps added.	2.2.1 Installing Frame, page 14
Figures 2.23, 2.24 added.	2.2.2 Installing Electrical Harness, page 19
Figures 2.25, 2.28 added. Figures 2.26, 2.29 revised. Item (C) added to step 2.	2.2.3 Connecting Hydraulics, page 20
Step 3 and Figure 2.30 moved from unpacking to installing shield. Procedure revised and Figure 2.34 revised. Figures 2.37, 2.38 replaced by Figures.2.39, 2.40.	2.2.4 Installing Shield Assembly, page 22
A header must be attached.....added to second paragraph. Step 1 added.	3.1 Activating the Swath Compressor, page 27
Calibrating Position Sensor and Calibrating Sensors with Header Attached added.	3.2.1 Calibrating Sensors with Header Attached, page 29
Using the Swath Compressor section added.	3.3 Using the Swath Compressor, page 33
Controlling the Swath Compressor was Operating the Swath Compressor. Step 1 deleted.	3.3.1 Controlling the Swath Compressor, page 33
Step 7 deleted.	3.3.2 Setting up the Swath Compressor, page 34
Locking the Swath Compressor was Operating the Swath Compressor Lock.	3.3.6 Locking the Swath Compressor, page 37
Chapter 4 Maintenance division added to include Removing Swath Compressor Shield.	4 Maintenance, page 39

Summary of Change	Location
Figure 4.1 added. Figure 4.4 replaced Figure 3.17. Steps 1 and 5 to 11 added.	<i>4.1 Removing Swath Compressor Shield, page 39</i>
Titles revised. Item C 252872 screw was 184622 bolt. Item T 30635 washer deleted. Illustrations revised.	<i>5 Illustrated Parts Lists, page 41</i>
Predelivery Checklist moved to last page. Predelivery Checklist reference column revised.	<i>Predelivery Checklist, page 65</i>

Introduction

The MacDon Swath Compressor is a large, formed polyethylene sheet which is designed to mount to the underside of a MacDon M1 Series Windrower. The MacDon Swath Compressor is designed for use with D Series Draper Headers cutting canola.

The swath compressor shapes the windrow and anchors it into the stubble behind the header to help prevent shelling in ripe conditions and wind damage. Excessive compression by a swath compressor or roller can increase losses from crop shelling, and may increase drying time; inadequate compression can leave a windrow prone to wind damage.

The swath compressor height can be adjusted and monitored with the cab display. Height can be adjusted for crop ripeness, yield, and the amount of compression required. The swath compressor will automatically lift up if an Operator stops and reverses the windrower.

NOTE:

A preferred height can be saved under a One-Touch-Return preset.

When setting up the machine or making adjustments, review and follow the recommended machine settings in all relevant MacDon publications. Failure to do so may compromise machine function and machine life and may result in a hazardous situation.

MacDon provides warranty for Customers who operate and maintain their equipment as described in this manual. A copy of the MacDon Industries Limited Warranty Policy, which explains this warranty, should have been provided to you by your Dealer. Damage resulting from any of the following conditions will void the warranty:

- Accident
- Misuse
- Abuse
- Improper maintenance or neglect
- Abnormal or extraordinary use of the machine
- Failure to use the machine, equipment, component, or part in accordance with the manufacturer's instructions

NOTE:

Keep your MacDon publications up-to-date. The most current version can be downloaded from our website www.macdon.com or from our Dealer-only site (<https://portal.macdon.com>) (login required).

This manual is currently available in the English language only.

Conventions

M1 Series Windrowers are Dual Direction®, meaning the windrower can be driven in cab-forward or engine-forward modes. When referencing specific locations on the machine, this manual always assumes a cab-forward direction when using the terms right and left.

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1 Safety

1.1 Safety Alert Symbols

This safety alert symbol indicates important safety messages in this manual and on safety signs on the machine.

This symbol means:

- **ATTENTION!**
- **BECOME ALERT!**
- **YOUR SAFETY IS INVOLVED!**

Carefully read and follow the safety message accompanying this symbol.

Why is safety important to you?

- Accidents disable and kill
- Accidents cost
- Accidents can be avoided



Figure 1.1: Safety Symbol

1.2 Signal Words

Three signal words, **DANGER**, **WARNING**, and **CAUTION**, are used to alert you to hazardous situations. Signal words are selected using the following guidelines:

DANGER

Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.

WARNING

Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury. It may also be used to alert against unsafe practices.

CAUTION

Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may be used to alert against unsafe practices.

1.3 General Safety

CAUTION

The following are general farm safety precautions that should be part of your operating procedure for all types of machinery.

Protect yourself.

- When assembling, operating, and servicing machinery, wear all protective clothing and personal safety devices that could be necessary for job at hand. Do **NOT** take chances. You may need the following:
 - Hard hat
 - Protective footwear with slip resistant soles
 - Protective glasses or goggles
 - Heavy gloves
 - Wet weather gear
 - Respirator or filter mask
- Be aware that exposure to loud noises can cause hearing impairment or loss. Wear suitable hearing protection devices such as earmuffs or earplugs to help protect against loud noises.



Figure 1.2: Safety Equipment



Figure 1.3: Safety Equipment

- Provide a first aid kit for use in case of emergencies.
- Keep a fire extinguisher on the machine. Be sure fire extinguisher is properly maintained. Be familiar with its proper use.
- Keep young children away from machinery at all times.
- Be aware that accidents often happen when Operator is tired or in a hurry. Take time to consider safest way. Never ignore warning signs of fatigue.

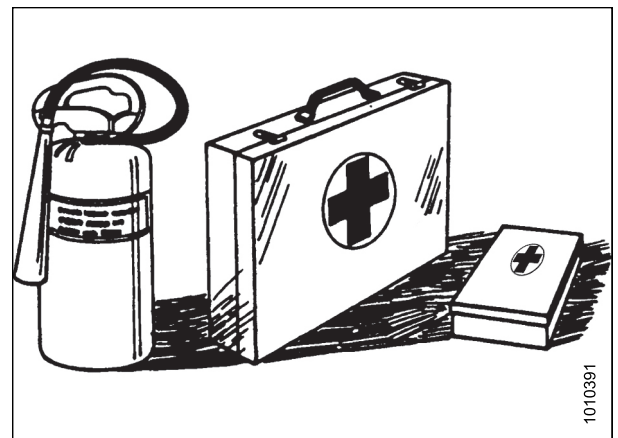


Figure 1.4: Safety Equipment

SAFETY

- Wear close-fitting clothing and cover long hair. Never wear dangling items such as scarves or bracelets.
- Keep all shields in place. **NEVER** alter or remove safety equipment. Make sure driveline guards can rotate independently of shaft and can telescope freely.
- Use only service and repair parts made or approved by equipment manufacturer. Substituted parts may not meet strength, design, or safety requirements.



Figure 1.5: Safety around Equipment

- Keep hands, feet, clothing, and hair away from moving parts. **NEVER** attempt to clear obstructions or objects from a machine while engine is running.
- Do **NOT** modify machine. Unauthorized modifications may impair machine function and/or safety. It may also shorten machine's life.
- To avoid bodily injury or death from unexpected startup of machine, **ALWAYS** stop the engine and remove the key from the ignition before leaving the operator's seat for any reason.

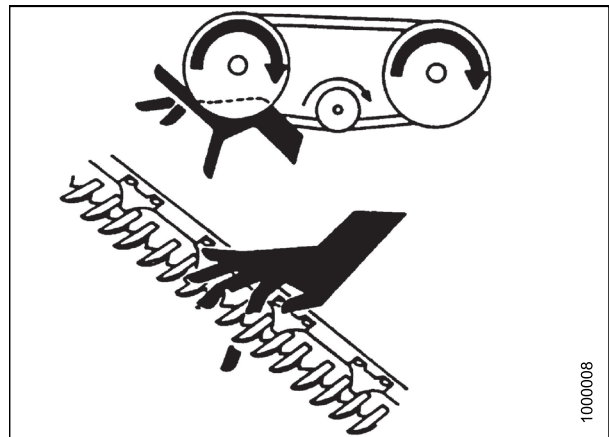


Figure 1.6: Safety around Equipment

- Keep service area clean and dry. Wet or oily floors are slippery. Wet spots can be dangerous when working with electrical equipment. Be sure all electrical outlets and tools are properly grounded.
- Keep work area well lit.
- Keep machinery clean. Straw and chaff on a hot engine is a fire hazard. Do **NOT** allow oil or grease to accumulate on service platforms, ladders, or controls. Clean machines before storage.
- **NEVER** use gasoline, naphtha, or any volatile material for cleaning purposes. These materials may be toxic and/or flammable.
- When storing machinery, cover sharp or extending components to prevent injury from accidental contact.



Figure 1.7: Safety around Equipment

1.4 Maintenance Safety

To ensure your safety while maintaining machine:

- Review operator’s manual and all safety items before operation and/or maintenance of machine.
- Place all controls in Neutral, stop the engine, set the park brake, remove the ignition key, and wait for all moving parts to stop before servicing, adjusting, and/or repairing.
- Follow good shop practices:
 - Keep service areas clean and dry
 - Be sure electrical outlets and tools are properly grounded
 - Keep work area well lit
- Relieve pressure from hydraulic circuits before servicing and/or disconnecting machine.
- Make sure all components are tight and that steel lines, hoses, and couplings are in good condition before applying pressure to hydraulic systems.
- Keep hands, feet, clothing, and hair away from all moving and/or rotating parts.
- Clear area of bystanders, especially children, when carrying out any maintenance, repairs, or adjustments.
- Install transport lock or place safety stands under frame before working under machine.
- If more than one person is servicing machine at same time, be aware that rotating a driveline or other mechanically-driven component by hand (for example, accessing a lube fitting) will cause drive components in other areas (belts, pulleys, and knives) to move. Stay clear of driven components at all times.
- Wear protective gear when working on machine.
- Wear heavy gloves when working on knife components.



Figure 1.8: Safety around Equipment

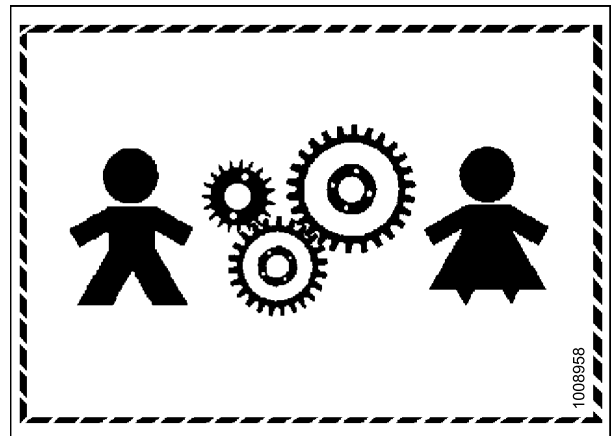


Figure 1.9: Equipment NOT Safe for Children

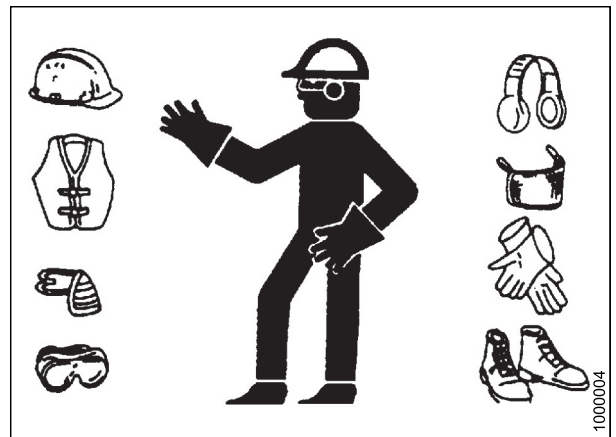


Figure 1.10: Safety Equipment

1.5 Hydraulic Safety

- Always place all hydraulic controls in Neutral before dismantling.
- Make sure that all components in hydraulic system are kept clean and in good condition.
- Replace any worn, cut, abraded, flattened, or crimped hoses and steel lines.
- Do **NOT** attempt any makeshift repairs to hydraulic lines, fittings, or hoses by using tapes, clamps, cements, or welding. The hydraulic system operates under extremely high pressure. Makeshift repairs will fail suddenly and create hazardous and unsafe conditions.

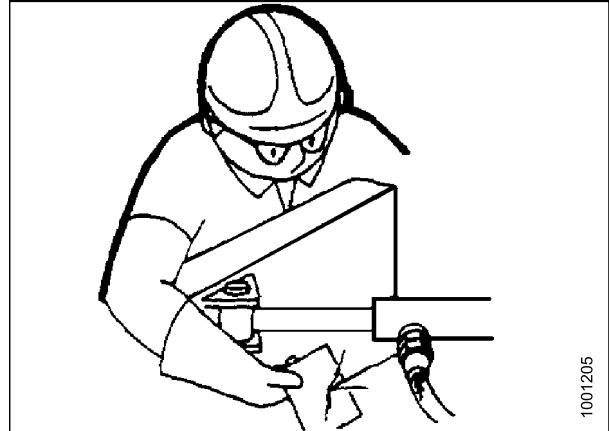


Figure 1.11: Testing for Hydraulic Leaks

- Wear proper hand and eye protection when searching for high-pressure hydraulic leaks. Use a piece of cardboard as a backstop instead of hands to isolate and identify a leak.
- If injured by a concentrated high-pressure stream of hydraulic fluid, seek medical attention immediately. Serious infection or toxic reaction can develop from hydraulic fluid piercing the skin.



Figure 1.12: Hydraulic Pressure Hazard

- Make sure all components are tight and steel lines, hoses, and couplings are in good condition before applying pressure to a hydraulic system.

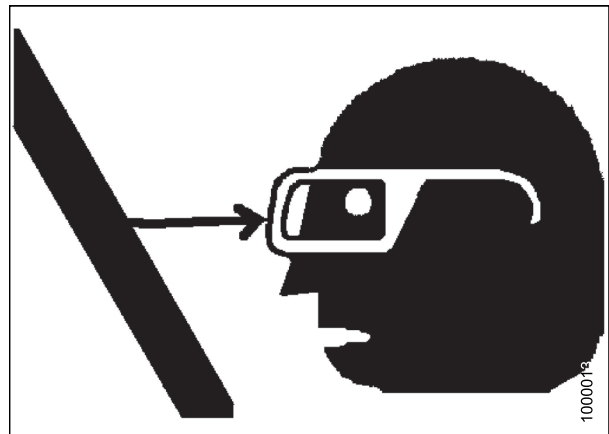


Figure 1.13: Safety around Equipment

1.6 Welding Precaution

Welding should never be attempted on the attachment while it is connected to a windrower.

WARNING

Severe damage to sensitive, expensive electronics can result from welding on the attachment while it is connected to the windrower. It is impossible to know what effect high current could have with regard to future malfunctions or shorter lifespan. It is very important that welding to the attachment frame is not attempted while connected to the windrower.

If an Operator needs to weld to the attachment frame, it should be removed from the windrower.

If the attachment can not be removed from the windrower, refer to the windrower's technical manual for welding precautions detailing electrical components that must be disconnected before welding.

SAFETY

1.7 Safety Signs

- Keep safety signs clean and legible at all times.
- Replace safety signs that are missing or become illegible.
- If original parts on which a safety sign was installed are replaced, be sure repair part also bears current safety sign.
- Replacement safety signs are available from your Dealer Parts Department.

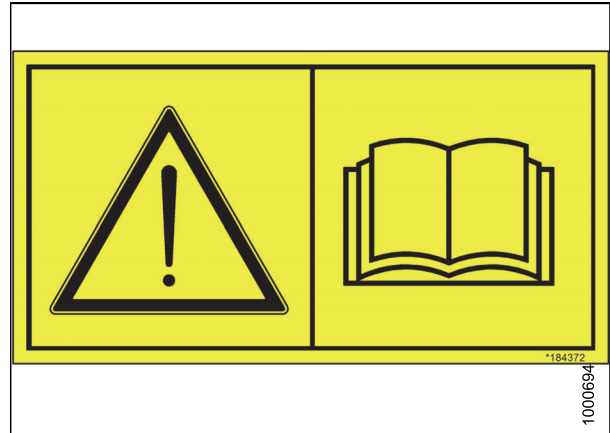


Figure 1.14: Operator's Manual Decal

1.7.1 Installing Safety Decals

1. Clean and dry installation area.
2. Decide on exact location before you remove decal backing paper.
3. Remove smaller portion of split backing paper.
4. Place decal in position and slowly peel back remaining paper, smoothing decal as it is applied.
5. Prick small air pockets with a pin and smooth out.

1.8 Safety Sign Decals

MD #184372

General hazard pertaining to machine operation and servicing.

CAUTION

- Read the operator's manual and follow all safety instructions. If you do not have a manual, obtain one from your Dealer.
- Do not allow untrained persons to operate the machine.
- Review safety instructions with all Operators every year.
- Ensure that all safety signs are installed and legible.
- Make certain everyone is clear of machine before starting engine and during operation.
- Keep riders off the machine.
- Keep all shields in place and stay clear of moving parts.
- Disengage header drive, put transmission in Neutral, and wait for all movement to stop before leaving operator's position.
- Stop the engine and remove the key from ignition before servicing, adjusting, lubricating, cleaning, or unplugging machine.
- Engage locks to prevent lowering of header or reel before servicing in the raised position.
- Use slow moving vehicle emblem and flashing warning lights when operating on roadways unless prohibited by law.

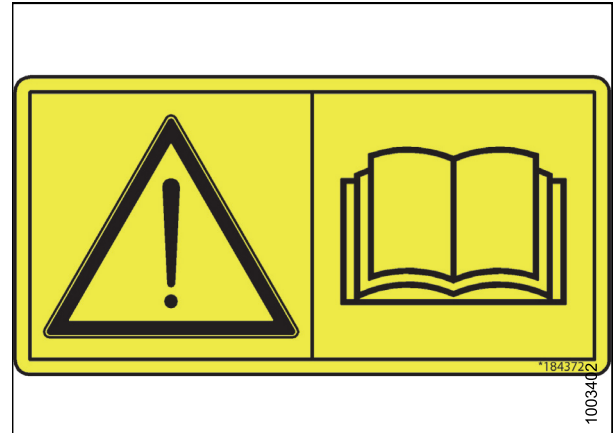


Figure 1.15: MD #184372

MD #166466

HIGH PRESSURE HYDRAULICS

DO NOT GO NEAR LEAKS

- High pressure oil easily punctures skin causing serious injury, gangrene or death.
- If injured, seek emergency medical help. Immediate surgery is required to remove oil.
- Do not use finger or skin to check for leaks.
- Lower load or relieve hydraulic pressure before loosening fittings.



Figure 1.16: MD #166466

SAFETY

MD #174683

PINCH POINT - MOVING PARTS

STAND CLEAR



Figure 1.17: MD #174683

MD #291638

LOCK - SWATH COMPRESSOR DECK

- Engage lock when swath compressor is not in use.
- Lock compressor shield before servicing or working under the windrower.
- Lock compressor shield before operating in engine-forward mode.



Figure 1.18: MD #291638

2 Installation Instructions

2.1 Removing Swath Compressor from Shipping Crate

Follow these steps to unpack the swath compressor from the shipping crate. Retain all parts for installation unless instructed to discard.

1. Remove the top cross members (A) from shipping crate and discard.

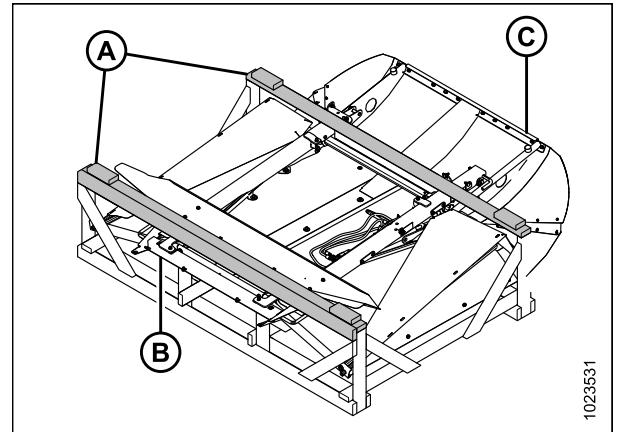


Figure 2.1: Shipping Configuration

A - Cross Members B - Front C - Rear

2. Remove four bolts (A) securing deflector (B) to left and right supports, and remove deflector (B). Retain hardware for reinstallation.

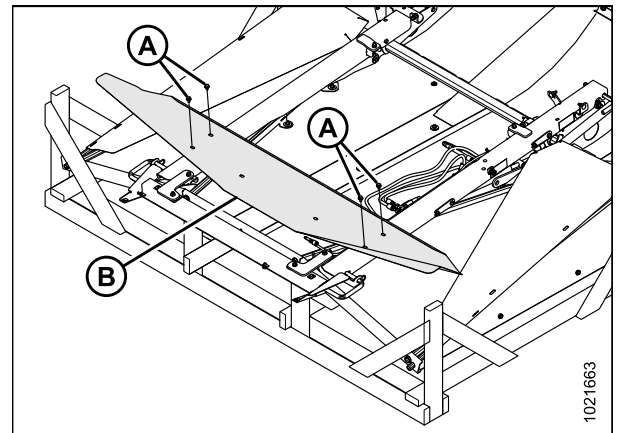


Figure 2.2: Front Deflector

INSTALLATION INSTRUCTIONS

3. Remove four bolts and nuts (A) and remove two bar clamps (B) from front pivot support (C).

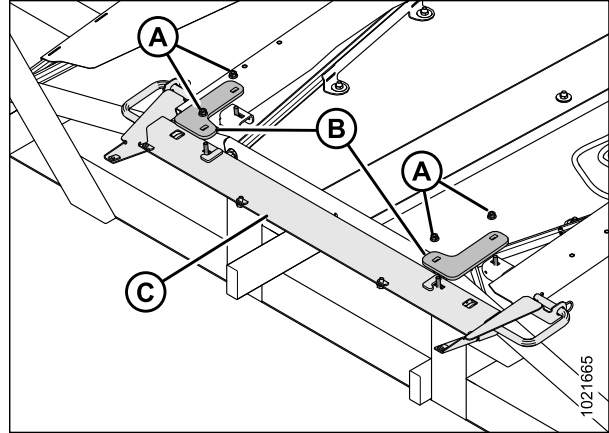


Figure 2.3: Front Pivot Support

4. Remove bolts and nuts (B) securing front support (A) to the left and right supports.
5. Remove hairpins (C) from pivot pins (D) and pull pivot pins to disengage from side supports. Remove front pivot support (A).

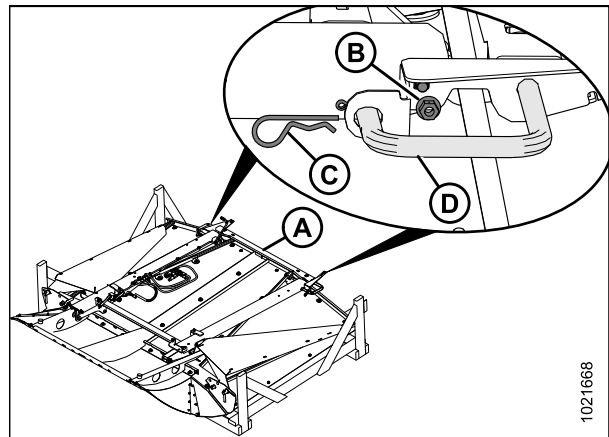


Figure 2.4: Front Pivot Support

6. Remove nut and bolt (A) and remove pivot pin (B) from the left support.

NOTE:

If necessary, loosen handle (C) and adjust deflector so pin (B) can be removed.

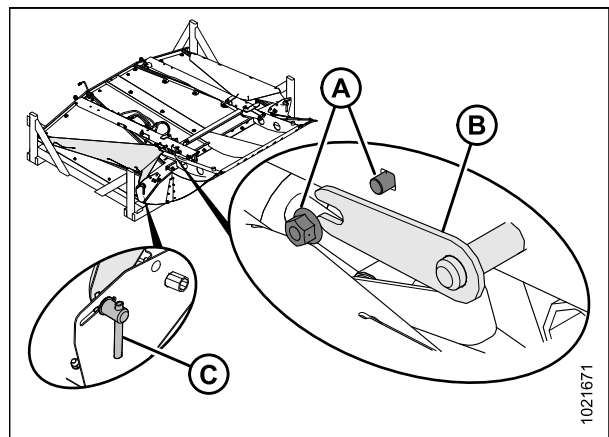


Figure 2.5: Left Support

INSTALLATION INSTRUCTIONS

7. Remove lynch pin (A) and washer (B) from pivot pin (C).
8. Remove pin (C) securing cylinder rod end to rock shaft.

NOTE:

If necessary, lift left support (E) out of frame so pin (C) can slide out.

9. Release latch (D) and remove left support (E) complete with cylinder and hydraulic hoses.
10. Remove shipping wire securing hoses to support.

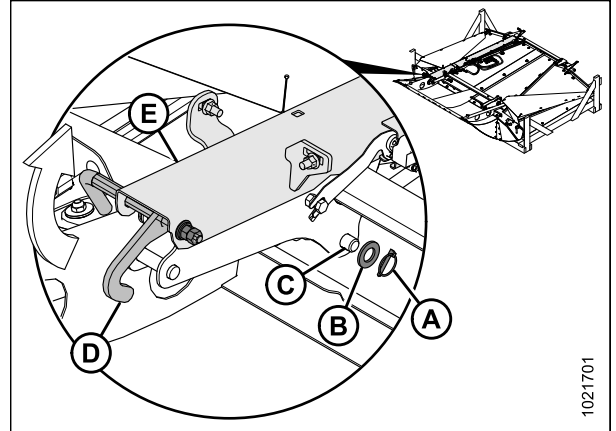


Figure 2.6: Left Support

11. Remove nut and bolt (A) and remove pivot pin (B) from right support.

NOTE:

If necessary, loosen handle (C) and adjust deflector so pin (B) can be removed.

12. Remove the right support (D).

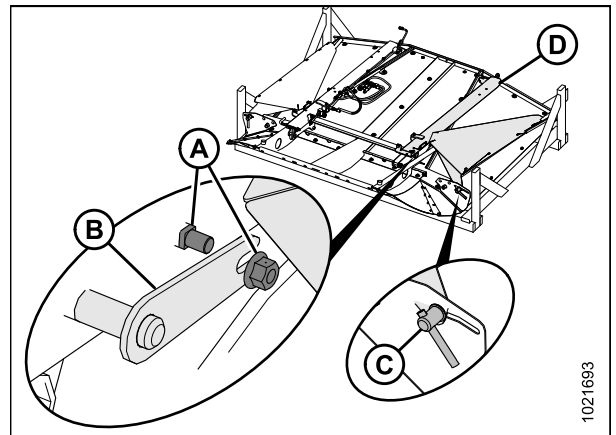


Figure 2.7: Right Support

13. Remove rock shaft (A).
14. Remove four lag screws (B) securing swath compressor to shipping crate. Discard lag screws and washers.
15. Leave swath compressor on shipping pallet.

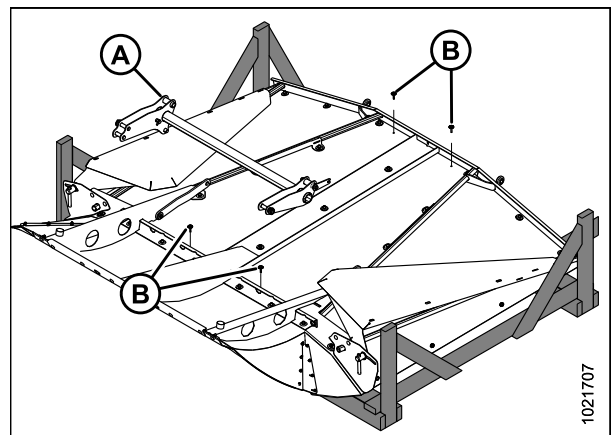


Figure 2.8: Rock Shaft

INSTALLATION INSTRUCTIONS

2.2 Installing Swath Compressor

Follow these steps to install the swath compressor onto a M1170 or M1240 windrower. The swath compressor weighs approximately 180 kg (400 lb.).

2.2.1 Installing Frame

1. Loosely attach bar clamps (A) to each side of front support with two M10 bolts and nuts (B).

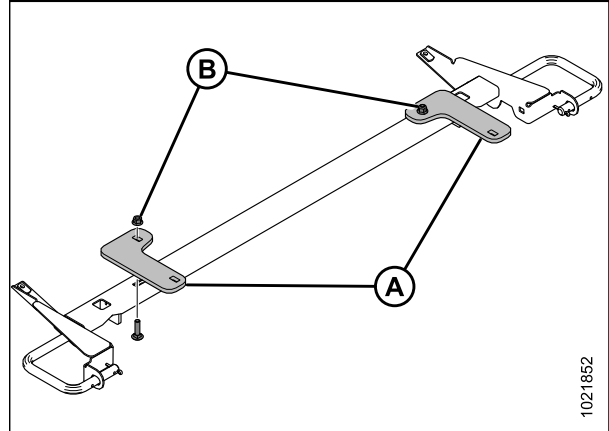


Figure 2.9: Front Support

2. Position front support (A) below the windrower frame at the cab end and adjust bar clamps (C) to hold support in place. Tighten bolts (B) sufficiently to hold support.

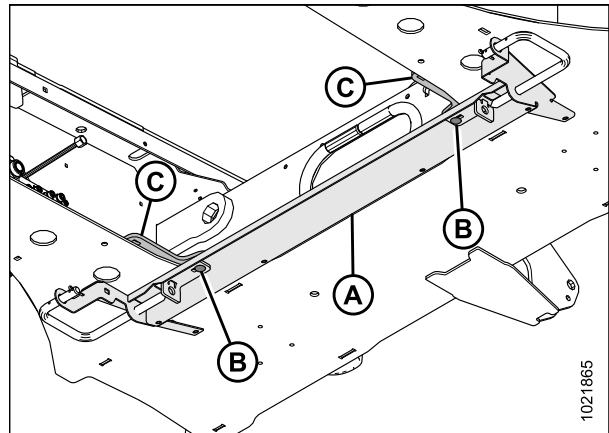


Figure 2.10: Front Support on Windrower Frame

INSTALLATION INSTRUCTIONS

- Loosen clamps (A) at rear of left and right supports.

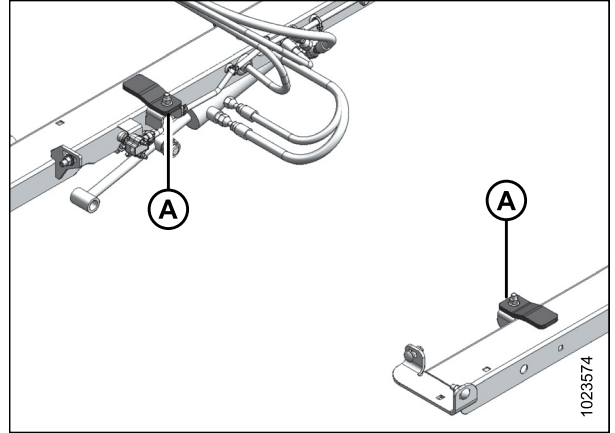


Figure 2.11: Left and Right Supports

- Locate left support (A) onto the left side of windrower frame as shown, and temporarily clamp in position with bar clamp (B) and M10 x 35 bolt (A) and nut.

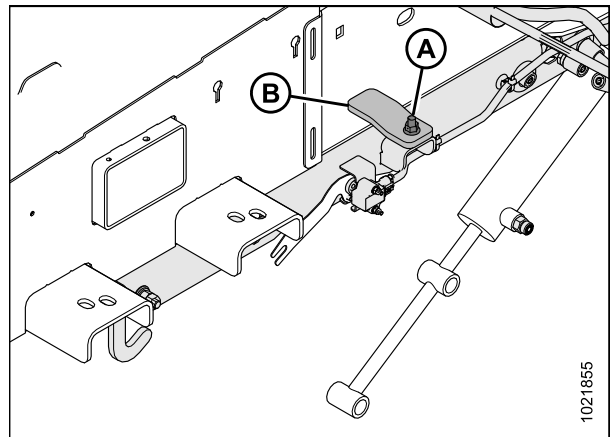


Figure 2.12: Left Support

- Install M10 x 35 mm bolt (B) and nut through support (A) and bar clamp. Do not tighten.
- Install M10 x 20 mm bolt (C) and nut through left support (A) and front support (D). Do not fully tighten bolt.

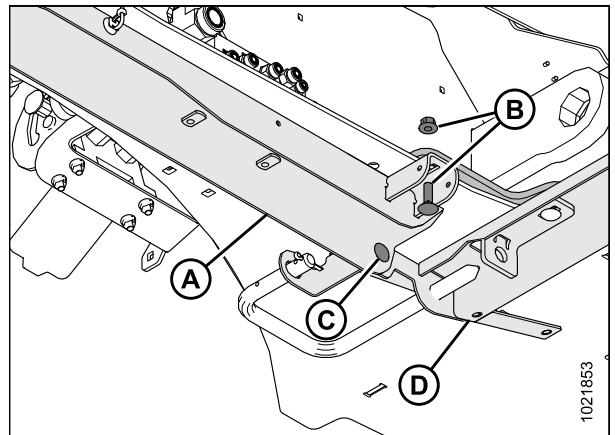


Figure 2.13: Left Support

INSTALLATION INSTRUCTIONS

- Secure rear of left support (A) with M10 x 35 mm bolts (B) and (C), and nuts through windrower frame. Do not fully tighten.

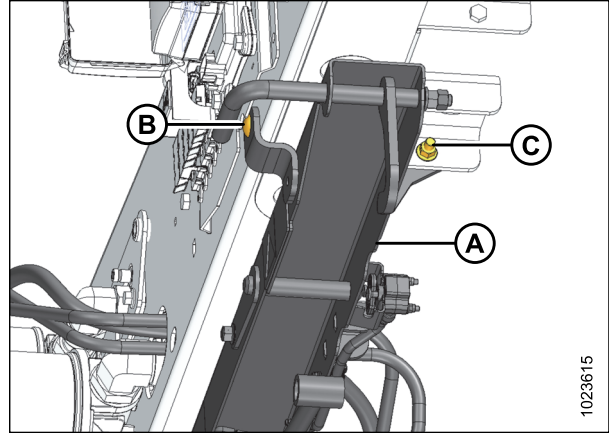


Figure 2.14: Left Support

- Remove bolt and nut (A) securing air cleaner support (B) to windrower frame (C). Discard bolt and nut.

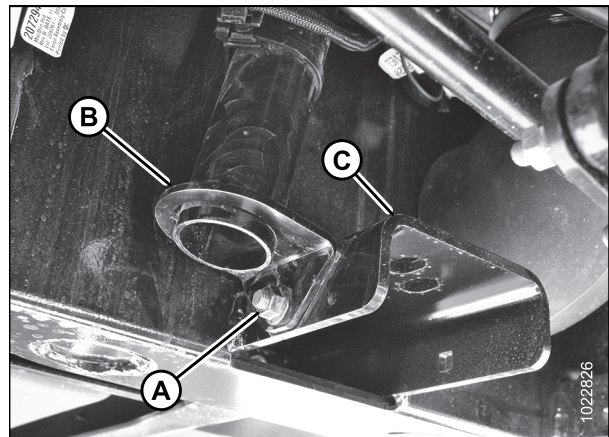


Figure 2.15: Air Cleaner Support

- Install front end of right support (A) to windrower frame with M10 x 35 bolt and nut (B) through bar clamp (C). Do not fully tighten.
- Install M10 x 20 bolt (D) and nut through right support and front support. Do not fully tighten.

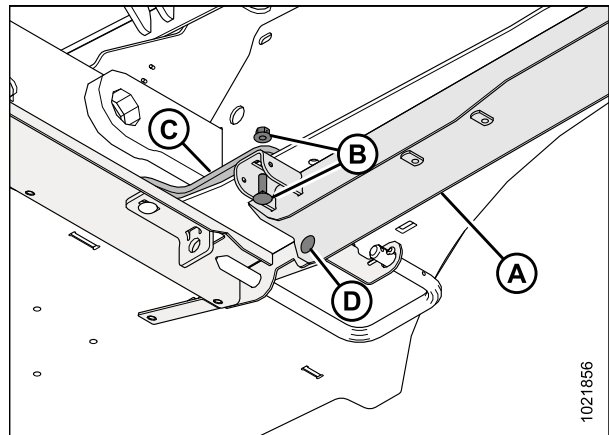


Figure 2.16: Right Support

INSTALLATION INSTRUCTIONS

11. Position air cleaner support (A) between windrower frame and right rear support (B) and secure with M10 x 35 bolt and nut (C). Bolt head faces aft.
12. Secure right support (B) to inside of windrower frame with bar clamp and M10 x 35 bolt (D) and nut. Do not fully tighten.

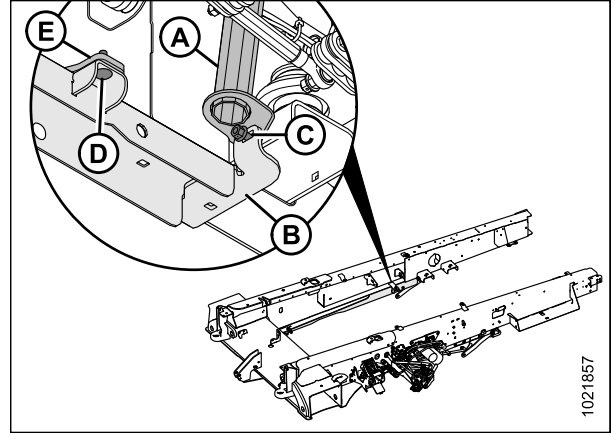


Figure 2.17: Right Support

13. Secure aft end of right support (A) to frame with M10 x 35 bolt (B) and nut. Do not fully tighten.

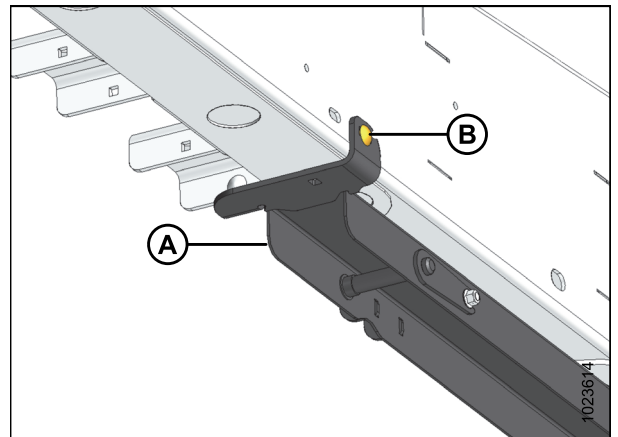


Figure 2.18: Right Support

14. Position rock shaft lift (A) inside left and right support channels and install pivot pins (B) on both sides.
15. Secure pivot pins (B) with M10 x 20 mm bolts and nuts (C). Tighten bolts.

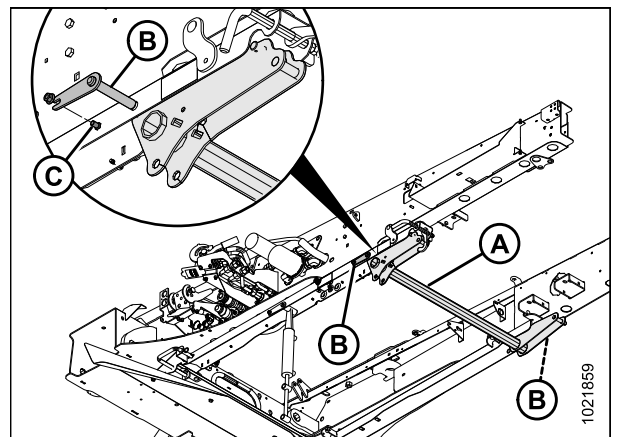


Figure 2.19: Rock Shaft

INSTALLATION INSTRUCTIONS

16. Ensure sensor arm (A) engages bolt (B) on left rock shaft lift support, and ensure it is not bent or damaged.

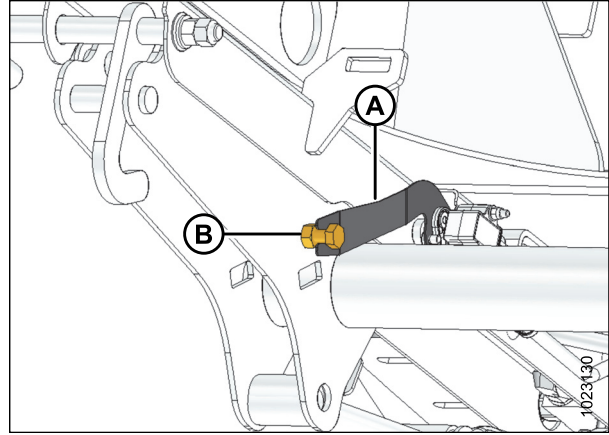


Figure 2.20: Sensor on Left Support

17. Tighten six bolts (A) attaching supports directly to frame and torque to 39 Nm (29 lbf·ft).
18. Tighten two bolts (B) attaching side supports to front support and torque to 39 Nm (29 lbf·ft).
19. Ensure front clamps (C) engage windrower frame as much as possible and torque four bolts (D) to 39 Nm (29 lbf·ft).
20. Ensure rear clamps (E) engage windrower frame as much as possible and torque two bolts (F) to 39 Nm (29 lbf·ft).

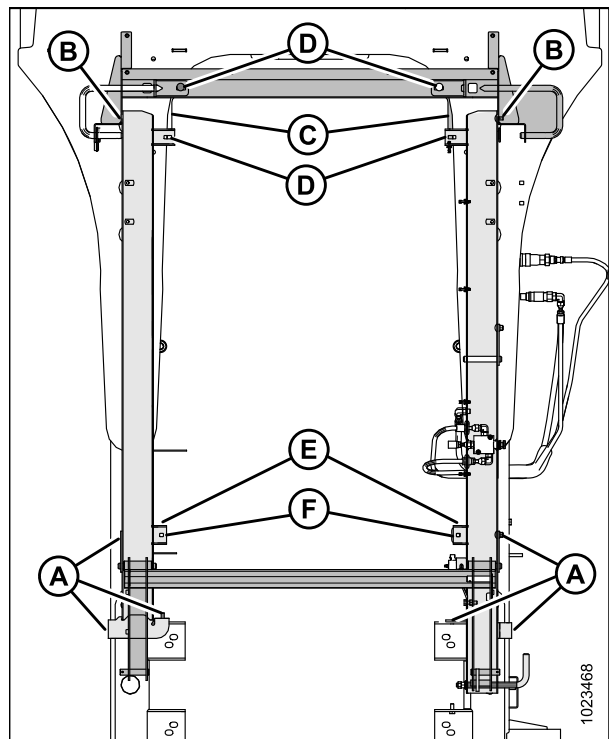


Figure 2.21: View from below Windrower

INSTALLATION INSTRUCTIONS

21. Secure fuel filter sensor harness (A) to connector at base of filter with cable tie (B) provided in manual bag. Ensure cable tie is over the harness loom, and a slight amount of slack remains in wires to connector.

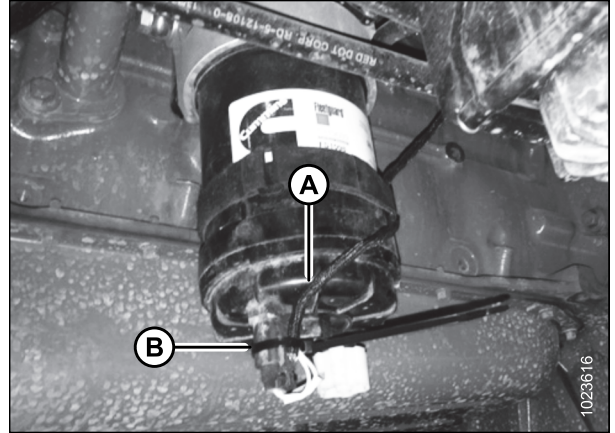


Figure 2.22: Fuel Filter Sensor Wire

2.2.2 Installing Electrical Harness

1. Locate the three-pin electrical connector P729 (A) above the front cross member of the windrower frame.
2. Cut cable tie (B) securing P729 (A) to the larger electrical harness.

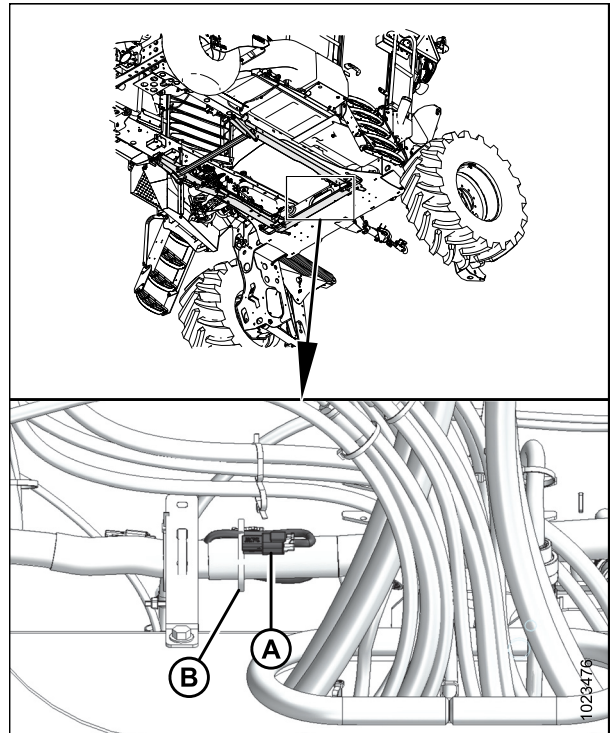


Figure 2.23: Windrower Electrical Harness

INSTALLATION INSTRUCTIONS

3. Route swath compressor harness (A) to P729 above front cross member, and connect to plug P729. Secure loose harness to frame with cable tie.

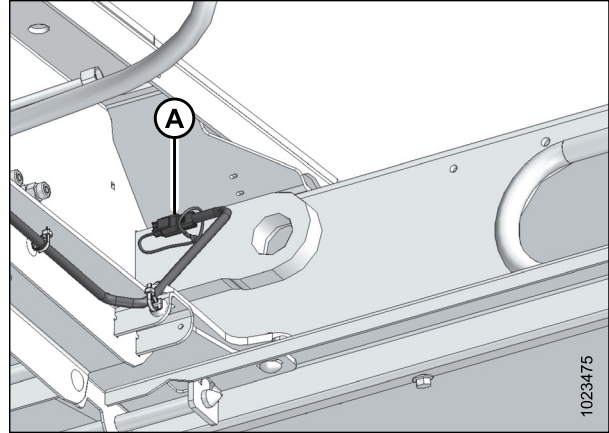


Figure 2.24: Windrower Electrical Harness

2.2.3 Connecting Hydraulics

M1240 Hoses

1. Route hydraulic hoses (A) through opening in left windrower frame.

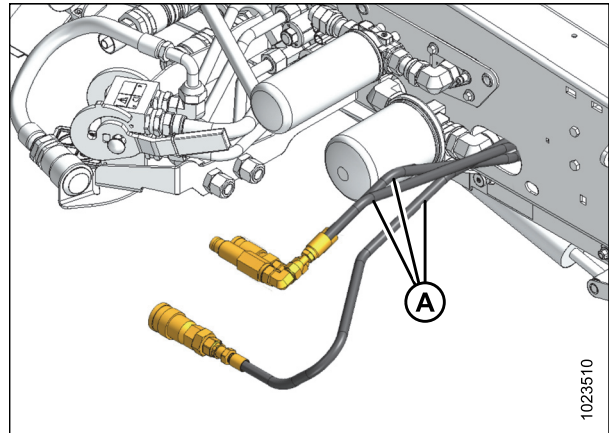


Figure 2.25: M1240 Hoses

M1170 Hoses (2017 and earlier)

2. Route hydraulic hoses (A) under windrower frame, and between the shield support (B) and hydraulic cylinder (C).

NOTE:

Position hoses to avoid pinching.

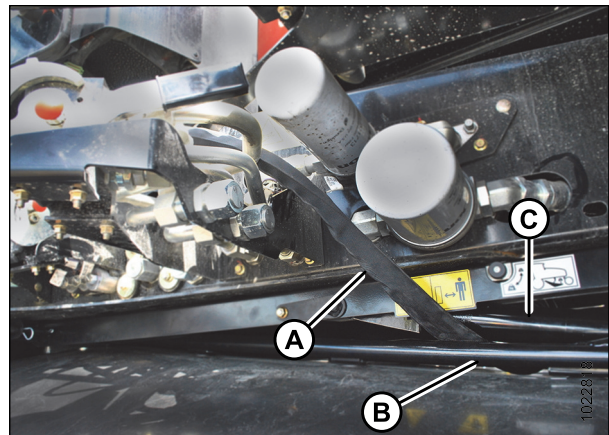


Figure 2.26: M1170 Hoses

INSTALLATION INSTRUCTIONS

CAUTION

Check to be sure all bystanders have cleared the area.

3. Start the engine and press the SWATH COMPRESSOR LOWER switch (A) for five seconds to relieve pressure behind couplers.
4. Shut off engine and remove key.



Figure 2.27: Windrower Console Switches

M1240 Hose Connections

5. Connect hydraulic couplers as follows:
 - Hose with male coupler to female connector (A)
 - Hose with (smaller) female coupler to male connector (B)
 - Hose with (larger) female coupler to the male connector (C)
6. Position hose sheath (D) so sheath contacts coupler fittings. Secure sheath at both ends with cable ties (MD #30753) supplied in manual bag.

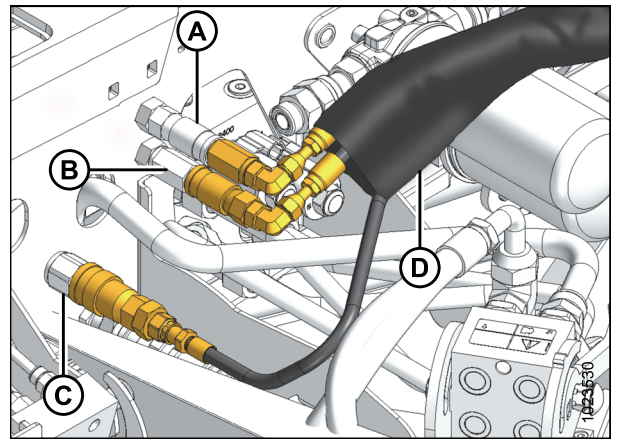


Figure 2.28: M1240 Hose Connections

M1170 Hose Connections (2017 and earlier)

7. Route hoses under the filters and connect hydraulic couplers as follows:
 - Hose with male coupler to female connector (A)
 - Hose with (smaller) female coupler to male connector (B)
 - Hose with (larger) female coupler to the male connector (C)
8. Position hose sheath (D) so sheath contacts fittings. Secure sheath at both ends with cable ties (MD #30753) supplied in manual bag.

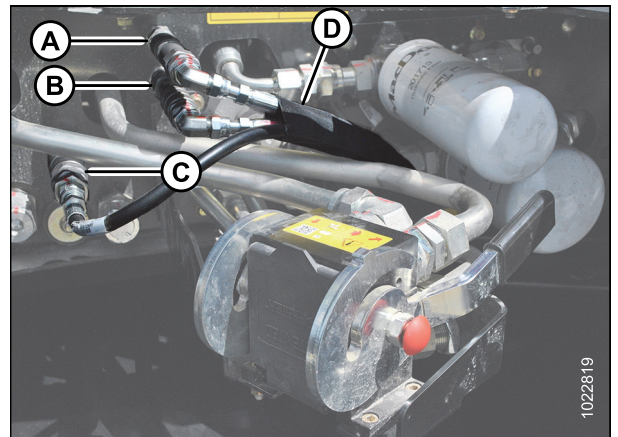


Figure 2.29: M1170 Hose Connections

INSTALLATION INSTRUCTIONS

2.2.4 Installing Shield Assembly

1. Start engine and raise header legs. Press SWATH COMPRESSOR LOWER button (A) to fully retract swath compressor cylinder.
2. Shut off engine and remove key.
3. Position forklift with forks over front of compressor shield, and attach lifting straps (A) through front and back of shield frame. Lift swath compressor shield out of shipping crate.
4. Approach windrower from front and move shield (A) under windrower. Lower to ground. Remove lifting straps and back forklift clear of windrower.



Figure 2.30: Windrower Console Buttons

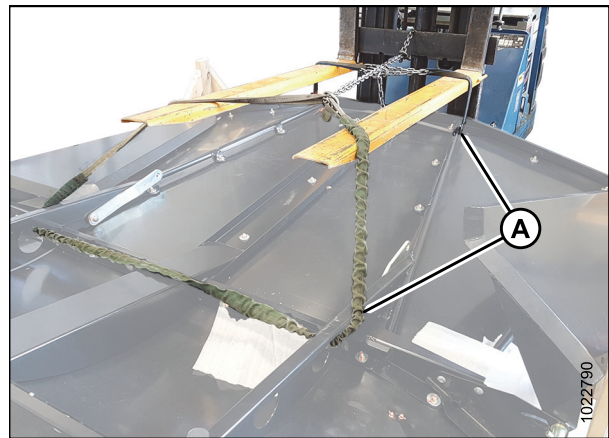


Figure 2.31: Lifting Swath Compressor Shield

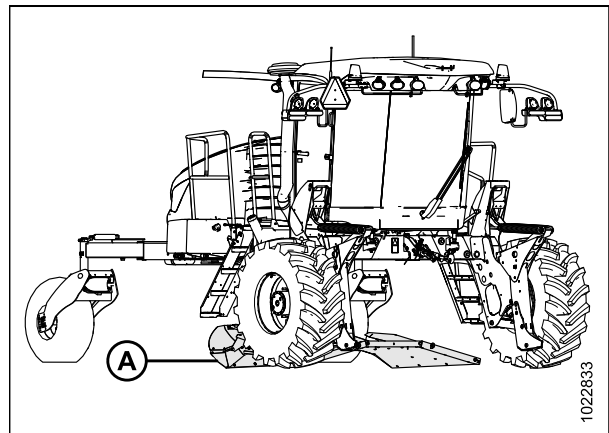


Figure 2.32: Compressor Shield under Windrower

INSTALLATION INSTRUCTIONS

5. To make connecting lowering arms easier, turn lock handle (A) counterclockwise and rotate rock shaft (B) so that supports are vertical.

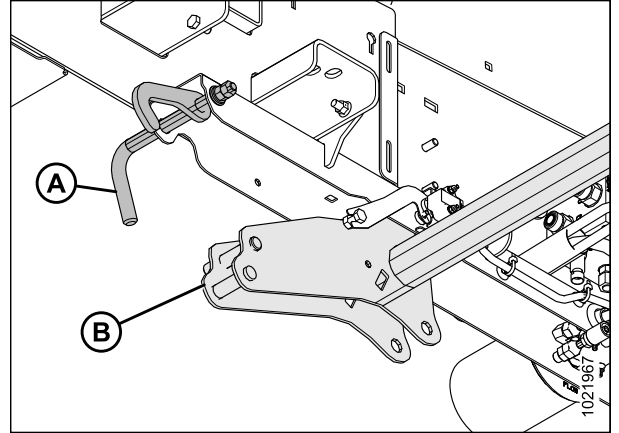


Figure 2.33: Rock Shaft and Lock

6. Ensure bushings (A) are installed onto pins (B) on both sides of rock shaft.
7. Position floor jack or equivalent under swath compressor shield cross member (C).
8. Raise shield with jack sufficiently to connect lowering arm (D) to pin (B) on rock shaft (G).
9. Secure lowering arm (D) to rock shaft (G) with washer (E) and lynch pin (F). Repeat on opposite side.
10. Lower jack and remove from work area.

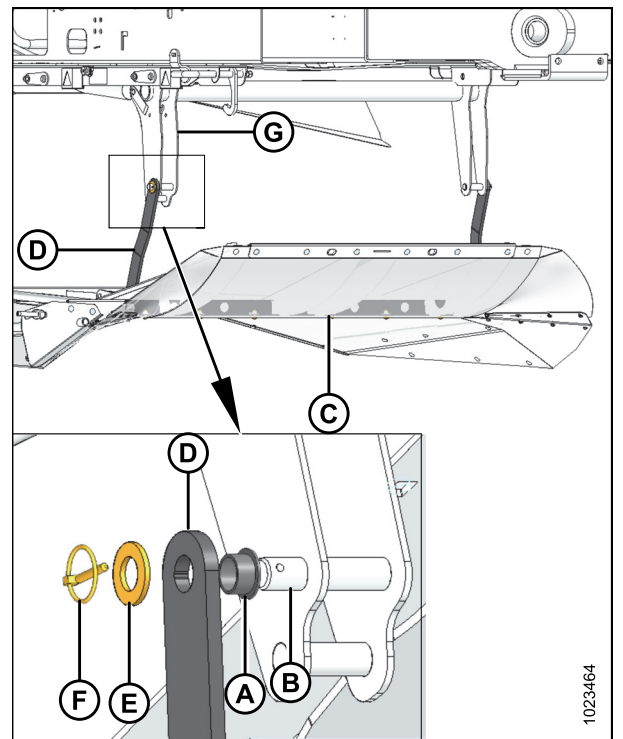


Figure 2.34: Shield Installation

INSTALLATION INSTRUCTIONS

- Loosen handle (A) and remove three bolts and nuts (B) from side deflector (C). Retain bolts and nuts.

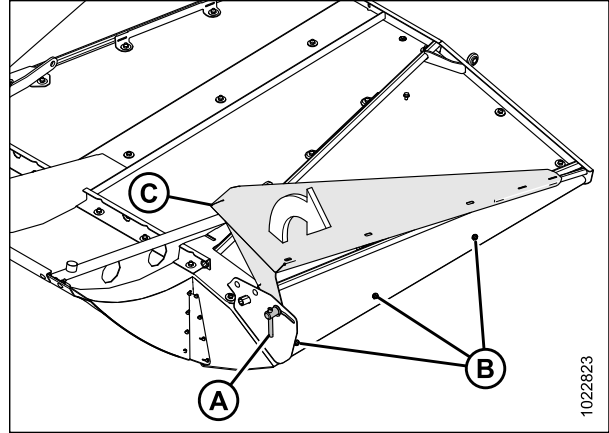


Figure 2.35: Side Deflector Shipping Position

- Rotate side deflector (A) to working position, and secure it to compressor shield with three bolts and nuts (B) from previous step. Install bolts with heads facing the crop.
- Torque nuts to 22 Nm (15 lbf-ft).
- Position the side deflector and tighten the adjustment handle (C). Repeat on opposite side.

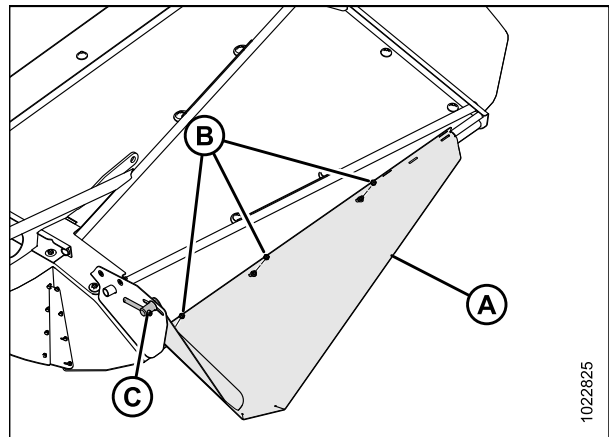


Figure 2.36: Side Deflector Working Position

- Push down on rear (A) of shield and another installer lifts the front (D).
- Align ball joints (C) with pins (B) at front of shield, and insert pins (B). Use a rubber mallet if pins are difficult to install.

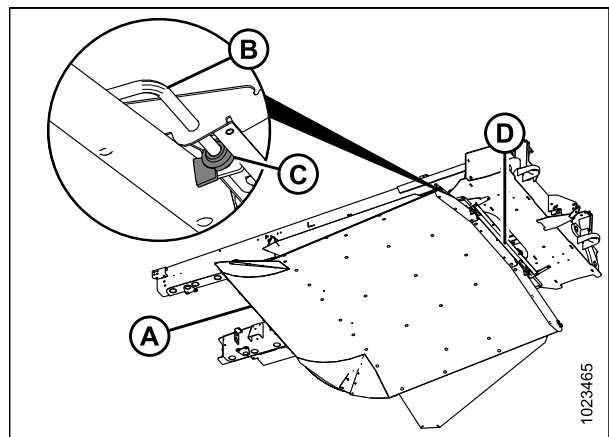


Figure 2.37: Front Pivot Pins

INSTALLATION INSTRUCTIONS

17. Install hairpin (A) to secure pivot pin (B). Repeat on opposite side.

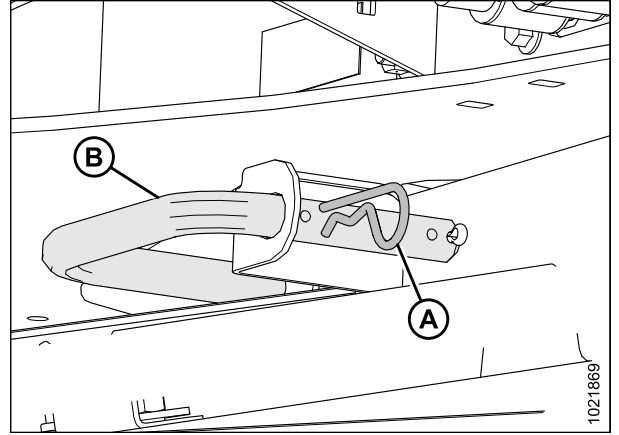


Figure 2.38: Front Pivot Pins

18. Align rod end of hydraulic cylinder (A) with holes in rock shaft and secure with pin (B). Ensure plate on pin engages slot (E) in rock shaft support.
19. Secure pin with washer (C) and lynch pin (D).

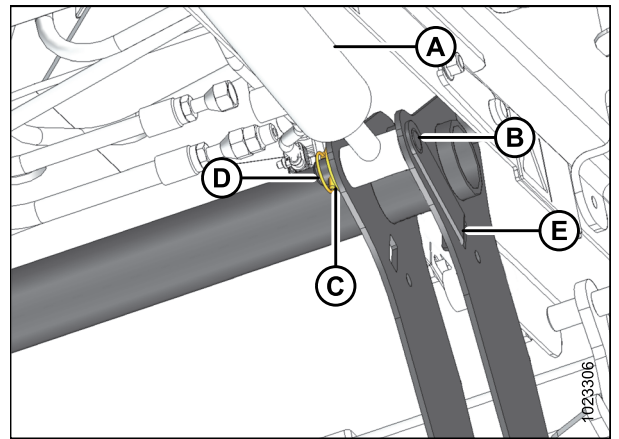


Figure 2.39: Rock Shaft

20. Position front deflector (A) onto front support (B) and remove the two existing bolts (C) that interfere with the deflector. Do not discard.
21. Secure deflector (A) to support with two M10 hex head bolts (C) removed in previous step and four M10 hex head bolts (D) that secured deflector to frame for shipping purposes. Center deflector with main shield before tightening bolts.

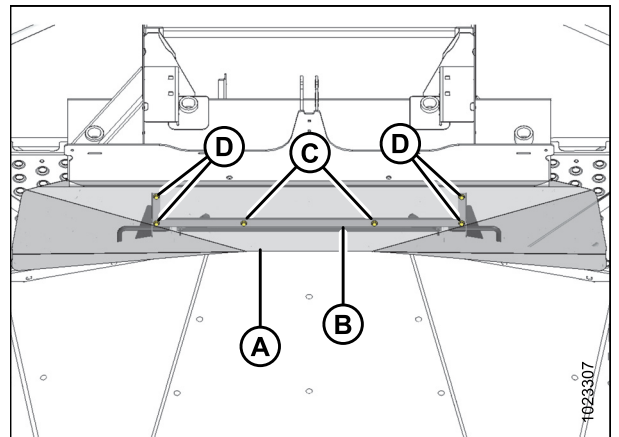


Figure 2.40: Front Deflector (View from under Shield)

3 Operation

3.1 Activating the Swath Compressor

The first time the swath compressor is attached to a windrower, it must be activated in the windrower's control system. To activate the swath compressor with the Harvest Performance Tracker (HPT), follow these steps.

If necessary, refer to the windrower operator's manual to review navigating the HPT display. A header must be attached to the windrower.

1. Turn ignition key to ON to activate the HPT.
2. Scroll down and select the HEADER SETUP menu (A).



Figure 3.1: Header Setup Screen

3. Select the correct header size and type from the HEADER list.

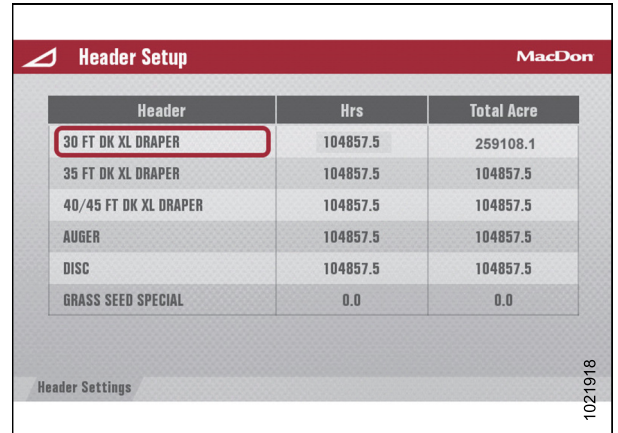


Figure 3.2: Header Setup Screen

OPERATION

4. Select ATTACHMENTS (A) from the HEADER SETUP screen.

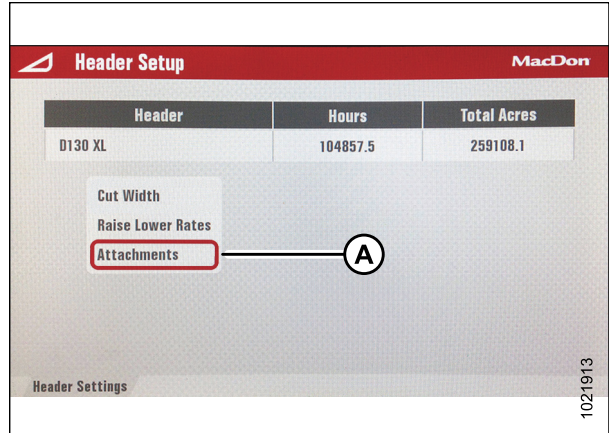


Figure 3.3: Header Setup Screen

5. Select SWATH COMPRESSOR (A) from the menu. The sensor is now active, and the HPT will control the swath compressor.
6. Calibrate sensor. Refer to [3.2 Calibrating Position Sensor, page 29](#).

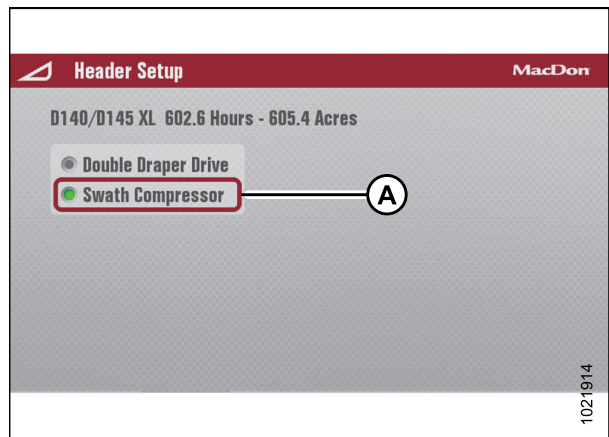


Figure 3.4: Attachments Screen

3.2 Calibrating Position Sensor

The swath compressor position sensor must be calibrated when the system is first installed.

To calibrate the system with header attached to the windrower, refer to [3.2.1 Calibrating Sensors with Header Attached, page 29](#).

3.2.1 Calibrating Sensors with Header Attached

The Harvest Performance Tracker (HPT) recognizes the header that is attached to the windrower and determines the systems that require calibration. The following sensors will be calibrated depending on header type:

- Header height
- Header angle
- Header float left
- Header float right
- Reel height
- Reel fore-aft
- Swath compressor height

CAUTION

Before starting the machine, check to be sure all bystanders have cleared the area.

1. Start the windrower, and engage the header.
2. Press soft key 5 (A) to open the main menu.
3. Use the HPT scroll knob (B) or the ground speed lever (GSL) scroll wheel (not shown) to highlight the SETTINGS icon (C).
4. Press the HPT scroll knob (B) or the GSL SELECT button (not shown) to activate the settings menu options.

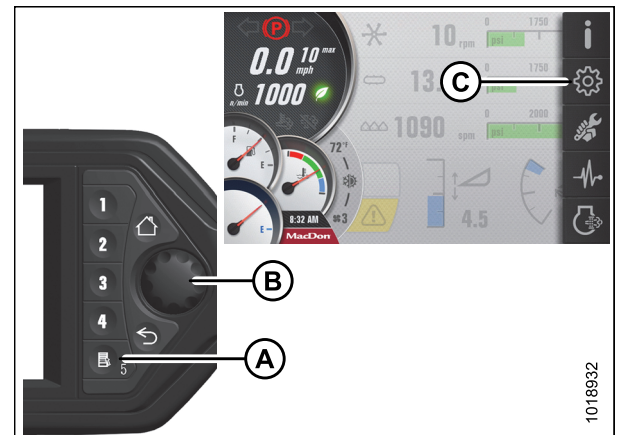


Figure 3.5: Opening the Main Menu

OPERATION

5. Scroll to the WINDROWER SETTINGS icon (A) and press SELECT.
6. Scroll to the CALIBRATION icon (B), and press SELECT to open the Calibration Selection screen.

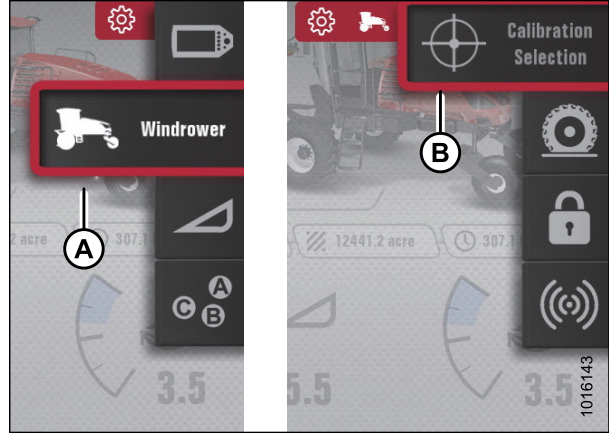


Figure 3.6: Windrower Settings Icon and Calibration Submenu Icon

7. In Calibration Selection screen, scroll to Position Sensors (A) and press SELECT.

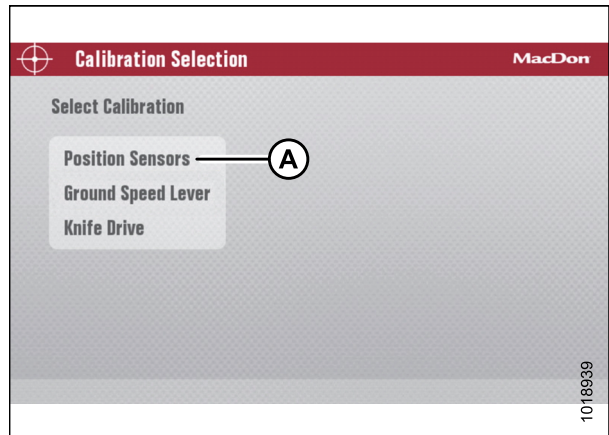


Figure 3.7: Calibration Selection Screen

NOTE:

If calibration is selected with header disengaged, a message ENGAGE HEADER will come up on the screen followed by the WARNING message on the right.

8. Press the PLAY icon on the screen to begin the calibration process. The display on the screen will change to show that calibration has started.

NOTE:

If the engine speed is less than 1500 rpm prior to starting the calibration, the system will accelerate the engine speed to 1500 rpm.

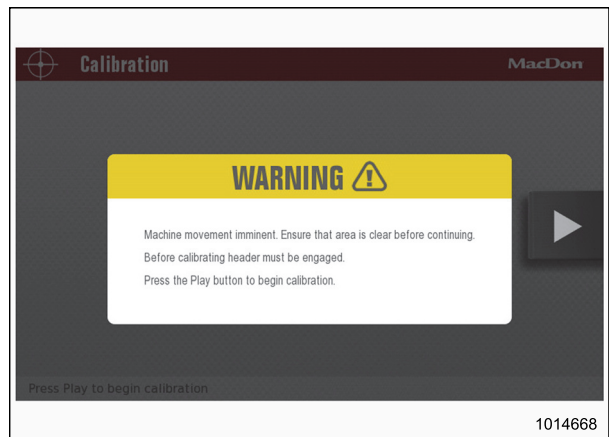


Figure 3.8: Calibration Screen

OPERATION

NOTE:

Pressing the X icon (A) on the screen (or pressing the HOME, BACK or any GSL button [buttons not shown]) at any time during calibration process will EXIT calibration without saving. The engine speed will also return to the original rpm prior to starting the calibration process.

NOTE:

If a sensor goes out of its normal operating range during the calibration process, calibration will stop and a message will appear on the screen indicating that the sensor is out of range.

10. When stage one of the calibration is complete, press the PLAY icon (A) on the screen to continue with stage two of the calibration process.

11. When stage two of the calibration is complete, press the RESUME icon (A) on the screen to set HEADER FLOAT, or press HOME or BACK button (not shown) to exit without setting the float.

NOTE:

The engine speed returns to the speed prior to calibration when stage two calibration is complete.



Figure 3.9: Calibration Screen

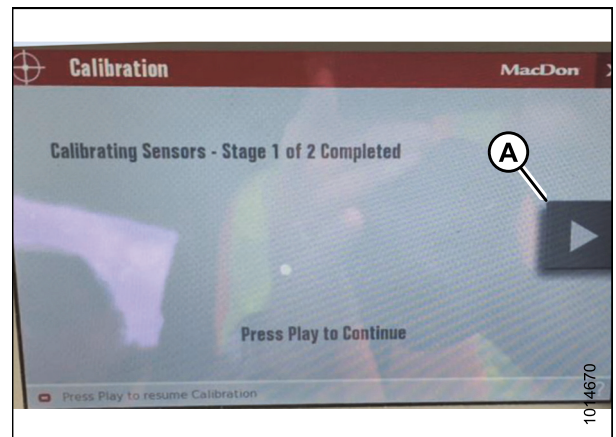


Figure 3.10: Calibration Screen

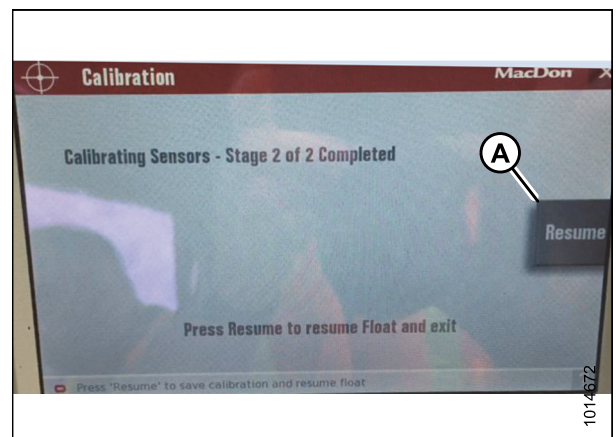


Figure 3.11: Calibration Screen

OPERATION

NOTE:

If the voltage of any sensor sweeps below what is acceptable during calibration, a message will be displayed after completing the calibration with a list of sensors with voltage range that is not acceptable. The Operator must then adjust the sensor and repeat the calibration process from the beginning.

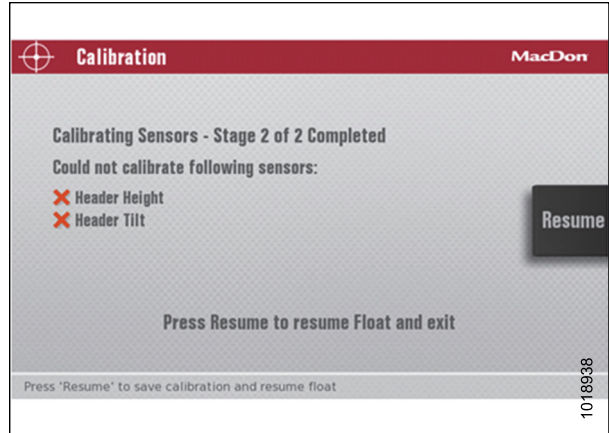


Figure 3.12: Sample of Failed Calibration Display Message

3.3 Using the Swath Compressor

3.3.1 Controlling the Swath Compressor

The following topic explains how the windrower controls the swath compressor, and describes the automated raise/lower functions.

CAUTION

To avoid bodily injury or death from unexpected startup of machine, always stop engine and remove key from ignition before leaving operator's seat for any reason.

Swath compressor height (A) is displayed on the Harvest Performance Tracker (HPT) with a scale from 0–10.



Figure 3.13: HPT Display

Switches (A) and (B) on the operator's console are used to adjust the position (height). Releasing the switch stops the movement.

NOTE:

Each momentary press of the switch changes the value by one. Pressing and holding changes the value by one increment per second.

NOTE:

The last position set with the console switches becomes the target height. When an adjustment is made, the display shows the target value. The system immediately adjusts to attain the target position. After the last adjustment, the display shows target value for 5 seconds then reverts to the actual position.

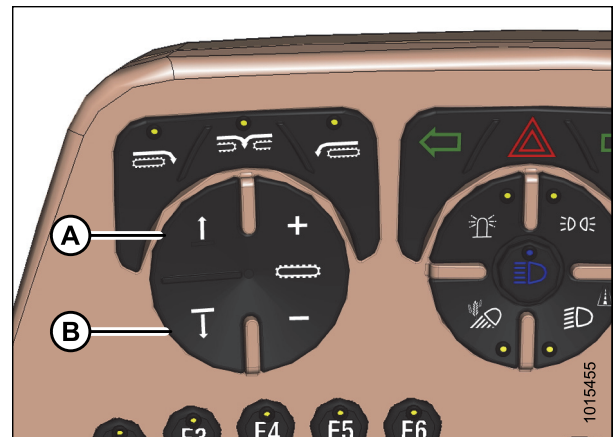


Figure 3.14: Operator's Console

OPERATION

Display functions

- As the swath compressor moves up or down, the target value (A) changes, the windrower icon (B) appears as an outline, and the swath compressor icon (C) flashes.
- Windrower icon (B) is solid when the target height is achieved.
- Value (A) is 0, and image (B) is an outline with the swath compressor fully raised.
- Icon (B) is not visible and automation is disabled without a header attached. Swath compressor height can still be adjusted.

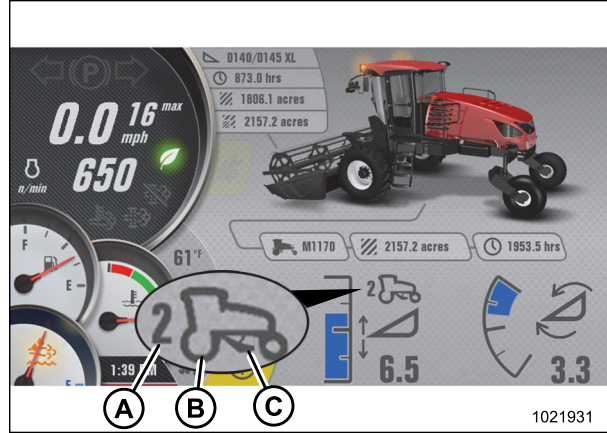


Figure 3.15: HPT Display

Swath compressor automated functions: header engaged

- The swath compressor lowers to target height at a ground speed higher than 2.5 km/h (1.6 mph).
- The swath compressor fully raises as the ground speed transitions through 1.6 km/h (1 mph) during deceleration.
- The swath compressor fully raises when the header is disengaged at a ground speed higher than 1.6 km/h (1 mph).
- An IMPORTANT message to raise the swath compressor appears on the HPT accompanied by a tone when the GSL is moved out of PARK in engine-forward mode if the swath compressor not fully raised.

Engage the swath compressor lock when the swath compressor is not in use, or when the windrower is in engine-forward mode. Refer to [3.3.6 Locking the Swath Compressor, page 37](#).

3.3.2 Setting up the Swath Compressor

Operate windrower in the crop and use the following procedure to determine the settings for the crop and crop conditions.

CAUTION

To avoid bodily injury or death from unexpected startup of machine, always stop engine and remove key from ignition before leaving operator's seat for any reason.

OPERATION

1. Rotate handle (A) counterclockwise to disengage lock on the left rear support.
2. Start the engine, set ground speed lever (GSL) in PARK, and ensure that the header is disengaged.

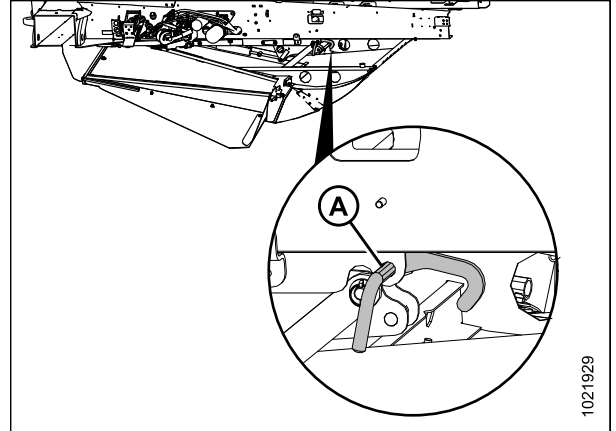


Figure 3.16: Swath Compressor Lock

3. Adjust swath compressor position with controls (A) and (B) on the console to the target (preferred) operating height. Set to 6 (C) if there is no preferred operating height.
4. Engage and then disengage the header. The swath compressor will raise fully.
5. Engage header and begin cutting crop. When ground speed exceeds 2.5 km/h (1.6 mph), the swath compressor will lower to the target (preferred) height (C).
6. Stop the windrower and check the formation of the windrow.
 - If necessary adjust the target height (C).
 - If the edges of the windrow are not sufficiently pressed into the stubble, adjust side deflectors. Refer to [3.3.5 Adjusting Side Deflectors, page 37](#).
 - If swath compressor shield raises too easily in dense windrows, adjust compression. Refer to [3.3.4 Adjusting Compression, page 36](#).

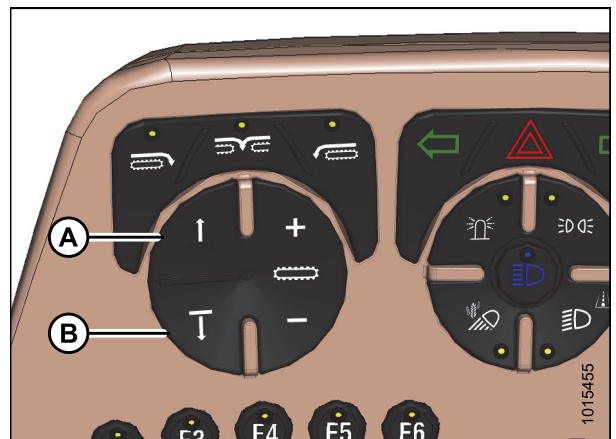


Figure 3.17: Operator's Console

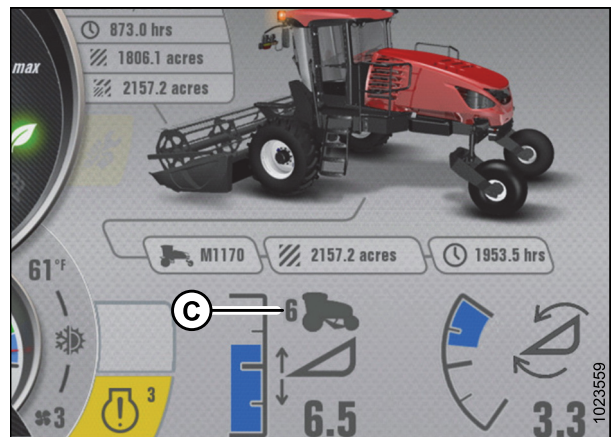


Figure 3.18: Display

3.3.3 Programming One-Touch-Return

The One-Touch-Return switches A, B, and C always save header height settings, but swath compressor settings can also be saved depending on the header type.

1. To program the One-Touch-Return switches, adjust header and swath compressor to desired position, then press and hold switch A, B, or C on the ground speed lever (GSL) handle for 3 seconds until an audible tone is heard. The current header/swath compressor settings are saved to that switch. To return header to a preset condition, quickly tap the A, B, or C switch.

NOTE:

A new swath compressor setting will only be stored if the compressor position was set with the UP/DOWN switches on the console. If swath compressor height sensor is disabled, automation is disabled. Raise/lower operation is only possible by pressing console switches.



Figure 3.19: Ground Speed Lever (GSL)

3.3.4 Adjusting Compression

The swath compressor automatically raises when the load on the shield exceeds the compression setting. When load decreases, the compressor deck automatically returns to the target height. The compression setting is set at the factory to suit most crop conditions and can be adjusted as follows:

1. Loosen jam nut (A) to allow the adjustment knob (B) to turn. Do **NOT** remove nut.
 - Turn adjuster knob (B) clockwise to increase compression for a more compact windrow and higher wind resistance.
 - Turn the adjuster knob (B) counterclockwise to decrease compression and minimize crop shelling.

NOTE:

Start with lowest compression (adjuster knob fully counterclockwise) and increase setting in 1/2 turn increments as required.

2. Tighten jam nut (A) sufficiently to maintain setting.

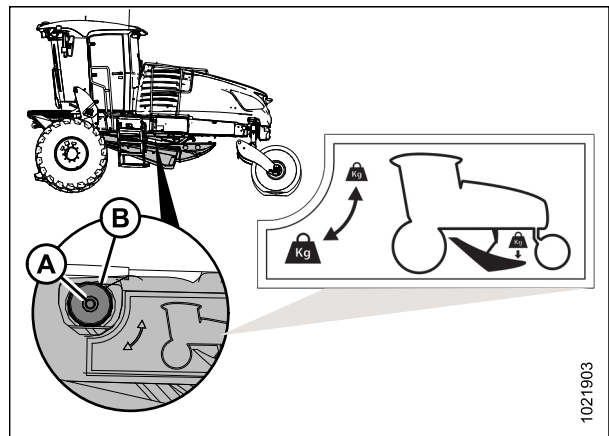


Figure 3.20: Compression Adjustment

3.3.5 Adjusting Side Deflectors

To reduce wind damage to the windrow, adjust side deflectors to ensure edges are tucked in and anchored to the stubble.

1. To adjust swath compressor side deflectors (A), loosen handles (B) and move deflectors to the desired position. To ensure windrow placement is centered, set both side deflectors to the same position.
2. Tighten handles (B) when adjustment is complete.

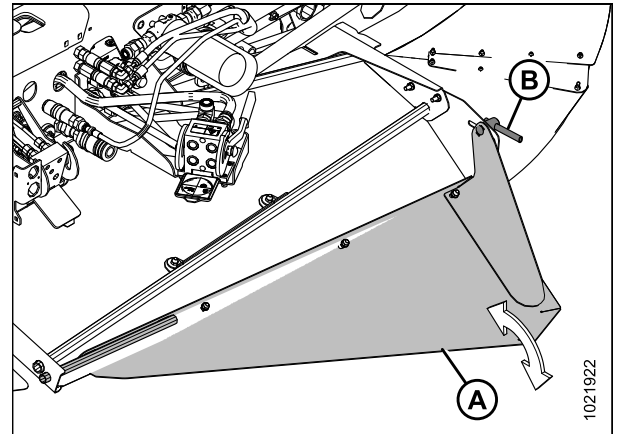


Figure 3.21: Swath Compressor Side Deflectors

3.3.6 Locking the Swath Compressor

The swath compressor lock is located on the left cab-forward side of the swath compressor frame. When engaged, the lock prevents the compressor shield from lowering.

1. Turn lock handle (A) clockwise to engage the swath compressor lock under the following conditions:
 - Swath compressor is not in use
 - Windrower is being serviced
 - Windrower is in engine-forward mode
2. Turn handle (A) counterclockwise to disengage the lock before operating the swath compressor.

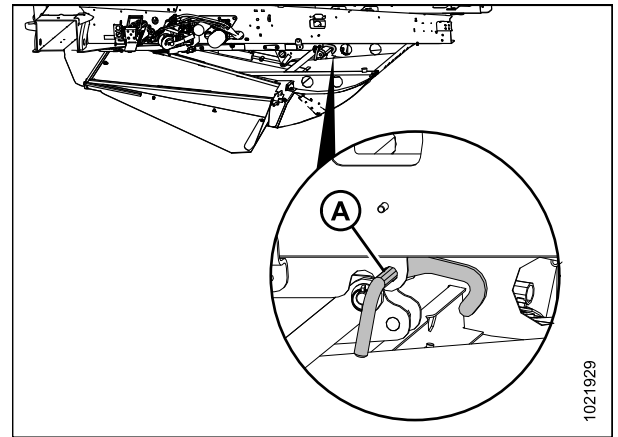


Figure 3.22: Swath Compressor Lock

4 Maintenance

The swath compressor does not require any scheduled maintenance or servicing. If necessary to replace components, refer to *5 Illustrated Parts Lists, page 41* in this manual.

4.1 Removing Swath Compressor Shield

Windrower service or maintenance procedures may require access under the machine. Do **NOT** sit on swath compressor shield to service the windrower. Remove the shield as follows:

CAUTION

To avoid bodily injury or death from unexpected startup of machine, always stop engine and remove key from ignition before leaving operator's seat for any reason.

1. Disengage swath compressor lock (A).
2. Start windrower, fully lower swath compressor, turn off windrower, and remove key.

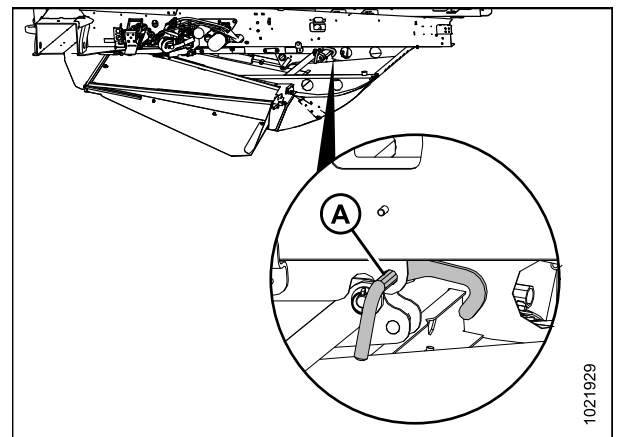


Figure 4.1: Swath Compressor Lock

3. At front of swath compressor, remove hairpin (A) from pivot pin (B) on both sides of frame.

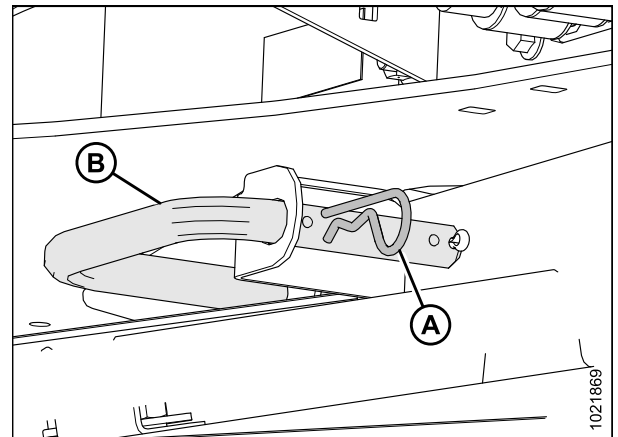


Figure 4.2: Forward Pivot Pin

MAINTENANCE

4. Push down on rear (A) of shield and another person supports the front (D). Pull pivot pins (B) from ball joints (C) on both sides of frame. To avoid misplacing parts, reinstall hairpins into pivot pins.
5. Lower forward end of shield to ground.

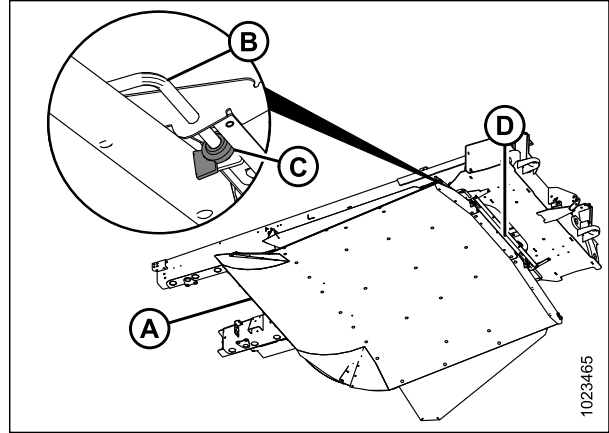


Figure 4.3: Front Pivot Pins

6. Support shield under support (C) at back end with a floor jack (or equivalent).
7. Remove lynch pins (F) and washers (E) from pins (B) on both ends of rock shaft.
8. Remove lowering arms (D) from rock shaft (G).
9. Store bushings (A), washers (E) and lynch pins (F) on pins (B).
10. Lower back end of shield to ground and move jack away from work area.
11. Start windrower and fully raise swath compressor lift mechanism. Slowly drive windrower away from shield.

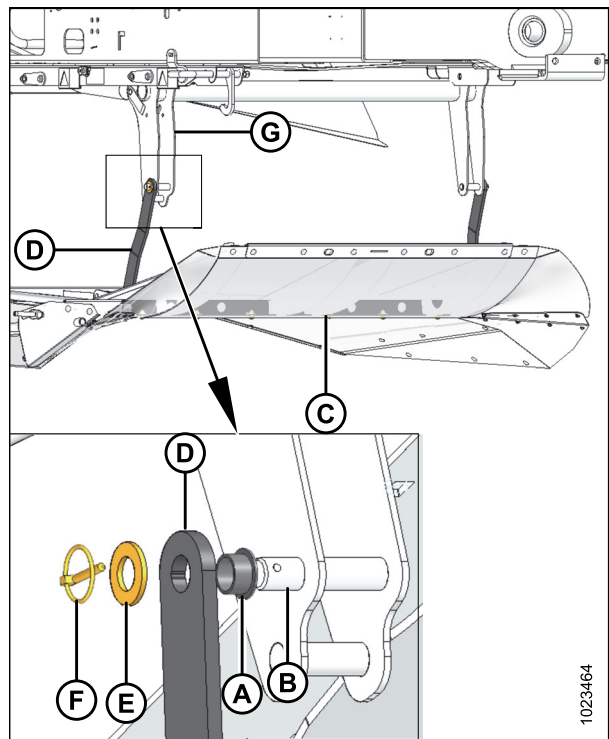
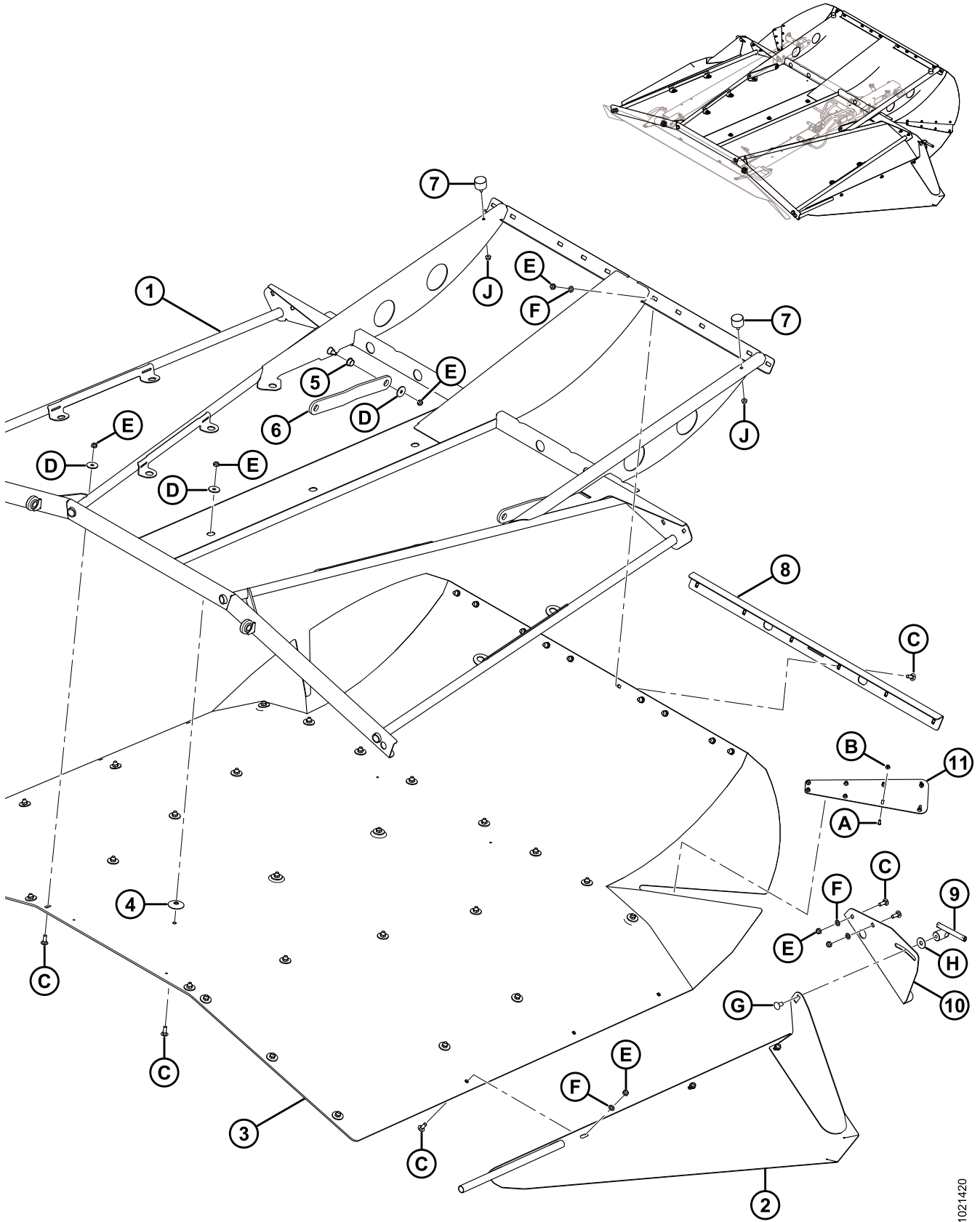


Figure 4.4: Disconnecting Lowering Arms

5 Illustrated Parts Lists

This section lists the replacement parts for the M1 Series windrower swath compressor.

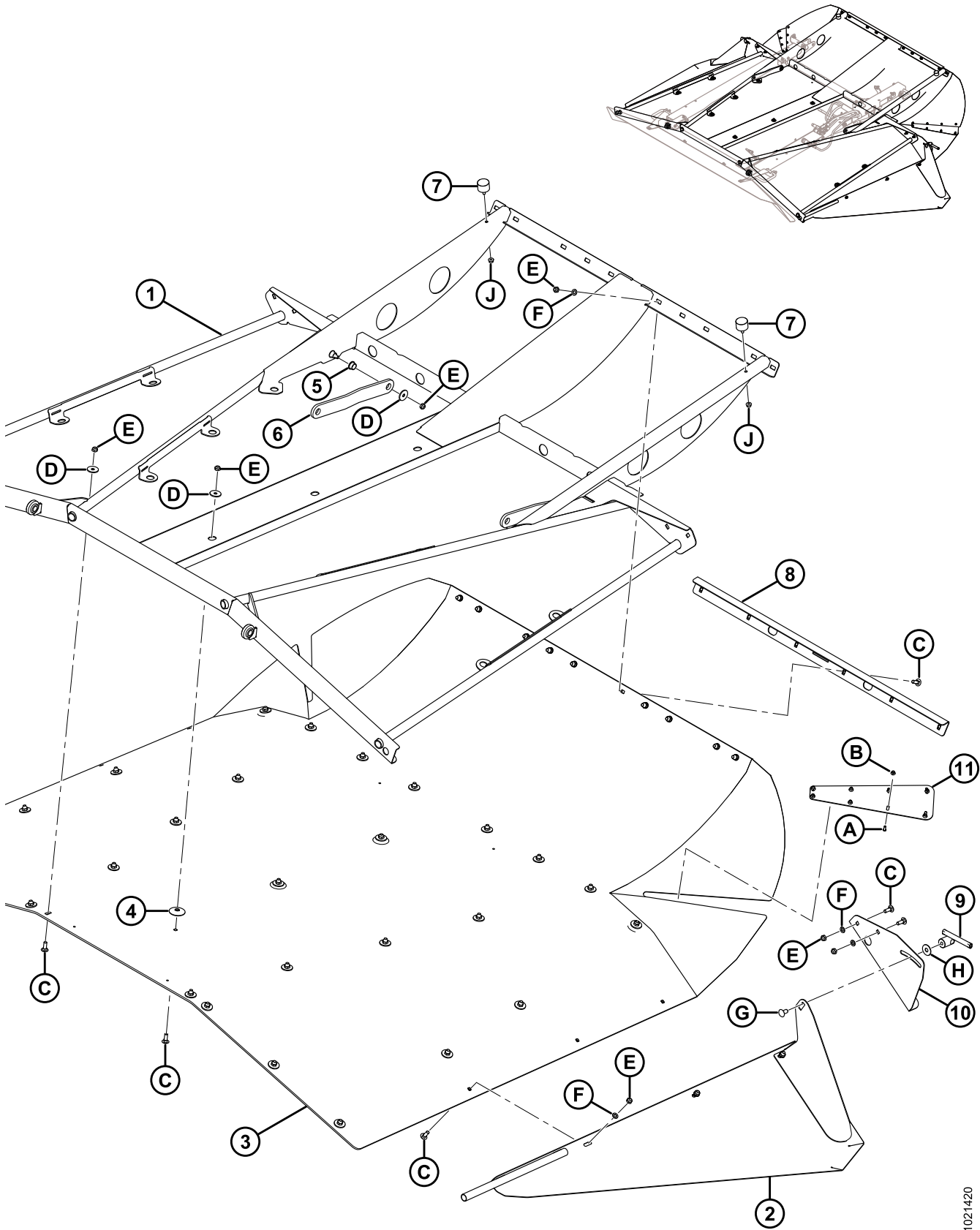
5.1 Swath Compressor Frame



ILLUSTRATED PARTS LISTS

Ref	Part Number	Description	Qty	Serial Number
		Swath Compressor Frame		
1	277318	SUPPORT – DEFLECTORS, WELD'T	1	
2	277410	DEFLECTOR – LH WELD'T	1	
	277411	DEFLECTOR – RH WELD'T	1	
3	277323	SHEET – SWATH COMPRESSOR	1	
4	128697	DISC – RETAINER	21	
5	128737	BUSHING – FLANGE	2	
6	128729	ARM – LOWER	2	
7	203350	BUMPER – RUBBER	2	
8	128740	ANGLE – REAR TOP	1	
9	247693	ASSEMBLY – HANDLE	2	
10	277405	SUPPORT – REAR DEFLECTOR	1	
	277414	SUPPORT – REAR DEFLECTOR, RH	1	
11	277409	STRAP – JOINING	2	

ILLUSTRATED PARTS LISTS

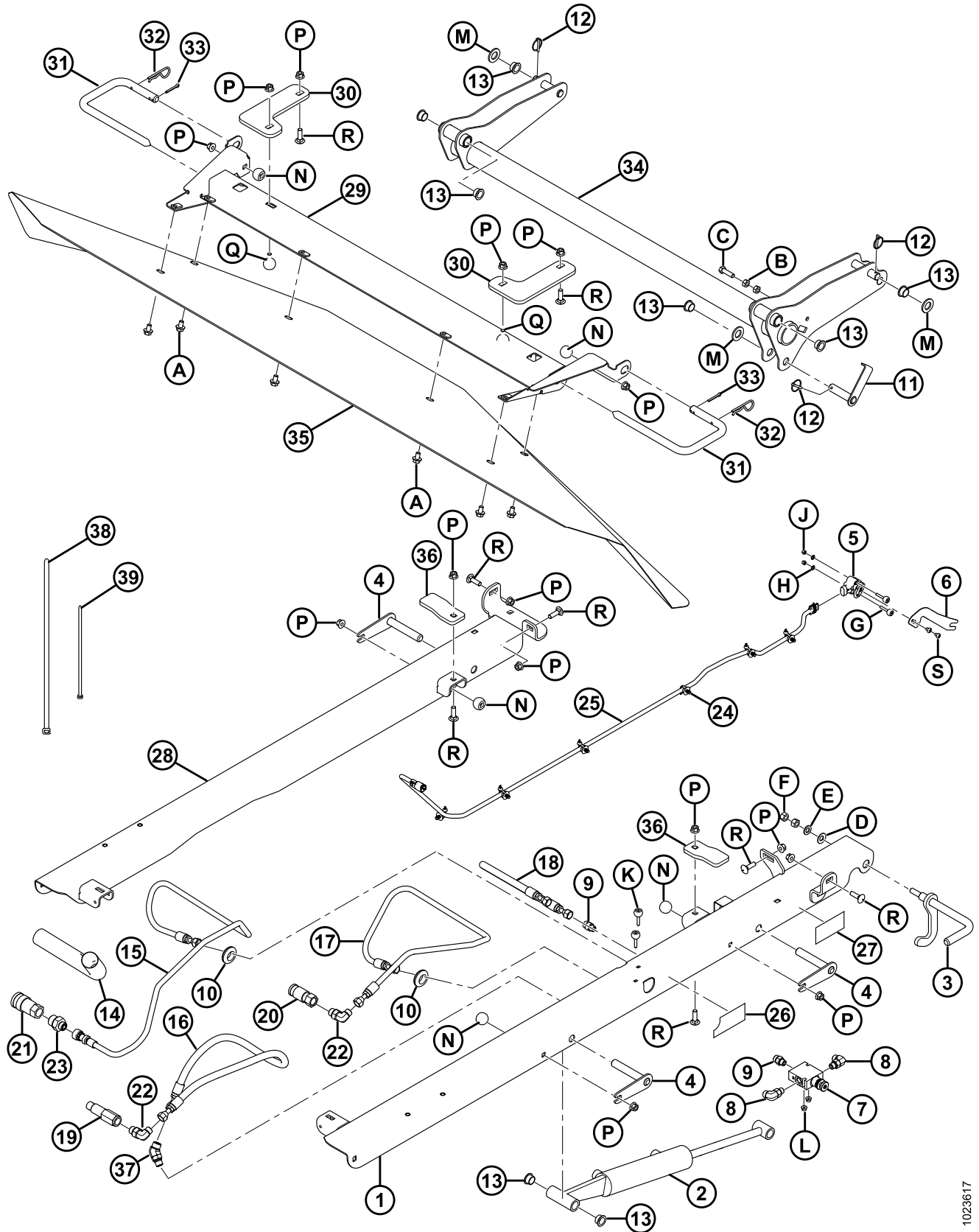


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ILLUSTRATED PARTS LISTS

Ref	Part Number	Description	Qty	Serial Number
		Swath Compressor Frame (continued)		
A	191393	BOLT – HEX SOC M6X1X20-12.9-AB0R	16	
B	152668	NUT – HEX FLG CTR LOC M6X1-8-A2L	16	
C	252872	SCR – FLG BTN HD M10X30-10.9-AA1J	49	
D	16652	WASHER – FLAT	31	
E	184692	NUT – HEX NYLOC M10X1.5-8-A3L	51	
F	184711	WASHER – FLAT REG M10-200HV-A3L	20	
G	152439	BOLT – RHSSN M12X1.75X25-8.8-A3L	2	
H	32247	WASHER – FLAT	2	
J	135337	NUT – HEX FLG CTR LOC M8X1.25-8-A2L	2	

5.2 Swath Compressor Hydraulics and Supports

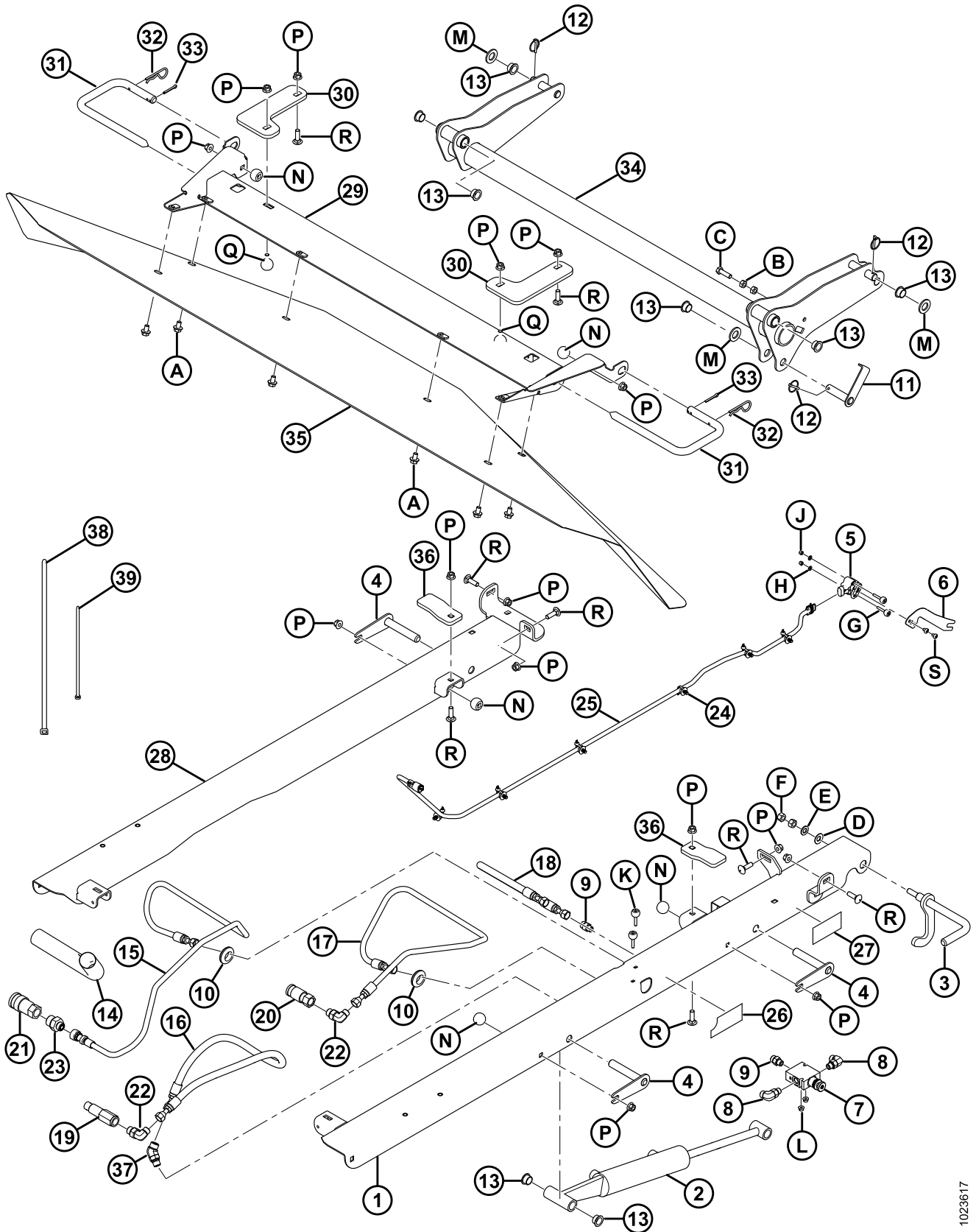


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ILLUSTRATED PARTS LISTS

Ref	Part Number	Description	Qty	Serial Number
		Hydraulics and Supports		
1	128780	SUPPORT – LH WELD'T	1	
2	128764	CYLINDER	1	
3	128768	LEVER – LOCK PIN WELD'T	1	
4	128788	PIN – PIVOT, WELD'T	3	
5	128994	ROTARY SENSOR HV	1	
6	128773	ARM – SENSOR	1	
7	128789	VALVE – PRESSURE REDUCING	1	
8	136095	FITTING – ELBOW 90° HYD	2	
9	135778	FITTING – ADAPTER	2	
10	42046	GROMMET	2	
11	277331	PIN – CYLINDER, WELD'T	1	
12	50193	PIN – LYNCH	3	
13	128737	BUSHING – FLANGE	10	
14	112940	SLEEVE	1	
15	277042	HOSE – HYD	1	
16	277041	HOSE – HYD	1	
17	277044	HOSE – HYD	1	
18	232597	HOSE – HYD	1	
19	135386	COUPLER – MALE HYD. 3/8 IN. FLAT FACE	1	
20	135312	COUPLER – FEMALE HYD. 3/8 IN. FLAT FACE	1	
21	135474	COUPLER – HYDRAULIC, 1/2 IN FEMALE FF	1	
22	136149	FITTING – ELBOW 90° HYD CW O-RING	2	
23	136194	FITTING – ADAPTER	1	
24	136655	FASTENER – FIR TREE MT W/ TIE	6	
25	209256	HARNESS – SWATH COMPRESSOR	1	
26	128973	DECAL – DOWN FORCE	1	
27	128974	DECAL – UP LOCK	1	
28	128781	SUPPORT – RH WELD'T	1	
29	128762	SUPPORT – FRONT PIVOT, WELD'T	1	

ILLUSTRATED PARTS LISTS



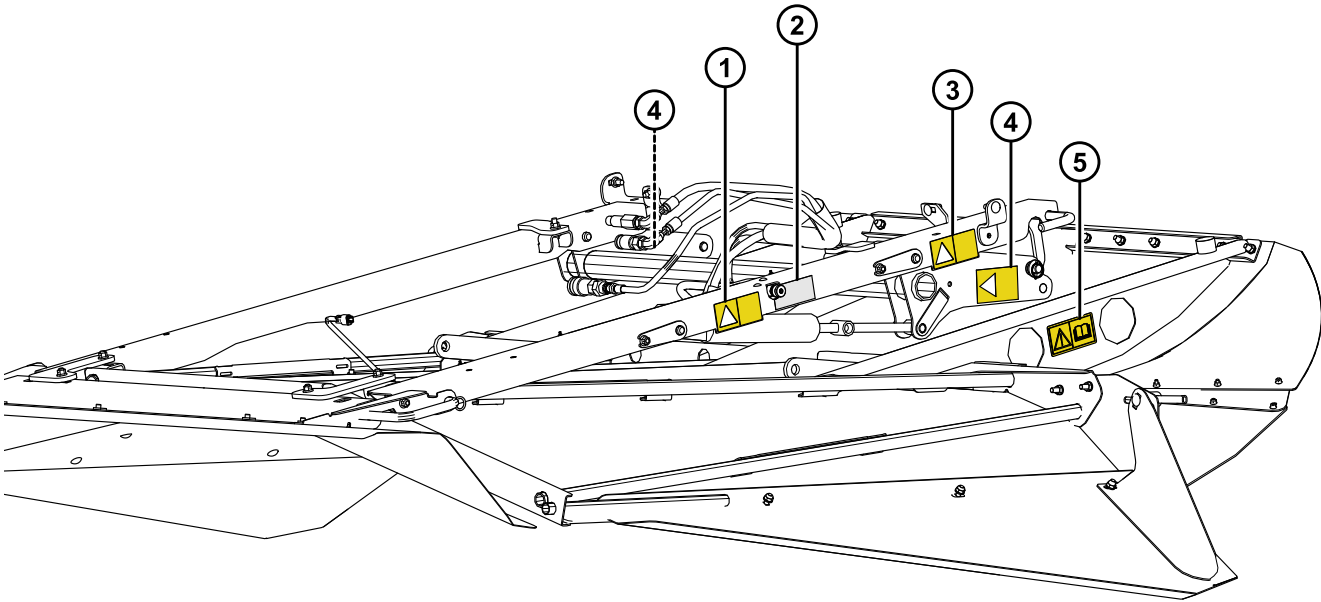
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ILLUSTRATED PARTS LISTS

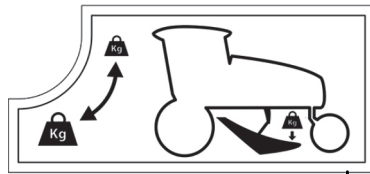
Ref	Part Number	Description	Qty	Serial Number
		Hydraulics and Supports (continued)		
30	128776	BAR – CLAMP	2	
31	128756	PIN – PIVOT	2	
32	13125	PIN – HAIR	2	
33	18648	PIN – COTTER 3/16 DIA X 1.25 ZP	2	
34	128770	ROCKSHAFT – LIFT, WELD'T	1	
35	128699	DEFLECTOR – FRONT	1	
36	277435	BAR – CLAMP	2	
37	136144	FITTING – ELBOW 45° HYD	1	
38	30753 ¹	FASTENER – CABLE TIE BLACK	2	
39	21763 ¹	FASTENER – CABLE TIE BLACK	1	
A	136151	BOLT – HEX FLG HD TFL M10X1.5X16-8.8-A3L	6	
B	30505	NUT – HEX M10X1.5-10-A3L	2	
C	30628	BOLT – HEX HD M10X1.5X35-8.8-A3L	1	
D	184595	WASHER – CONICAL SPRING 1/2"	1	
E	184714	WASHER – FLAT REG M12-300HV-A3L	1	
F	184694	NUT – HEX M12X1.75-8-A3L	2	
G	136604	BOLT – RHSN TFL M5X0.8X40-8.8-AA2L	2	
H	18798	WASHER – FLAT SAE 7/32 ID X 7/16 IN OD ZP	2	
J	197230	NUT – HEX NYLOC M5X0.8-8-A2L	2	
K	136731	BOLT – RHSN M6X1X45-8.8-A2L	2	
L	152668	NUT – HEX FLG CTR LOC M6X1-8-A2L	2	
M	18601	WASHER – SAE FLAT 13/16 ID X 1.5 IN OD ZP	3	
N	136178	BOLT – RHSN M10X1.5X20-8.8-A3L	4	
P	135799	NUT – HEX FLG CTR LOC M10X1.5-10-A3L	12	
Q	152732	BOLT – RHSN M10X1.5X40-8.8-A3L	2	
R	135691	BOLT – RHSN TFL M10X1.5X35-8.8-A3L	8	
S	252291	SCR – PAN HD M6X1X8-8.8-A2L	2	

1. Shipped in manual bag.

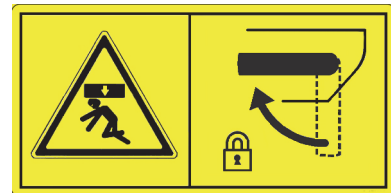
5.3 Decals



1



2



3



4 x2



5

1022127

ILLUSTRATED PARTS LISTS

Ref	Part Number	Description	Qty	Serial Number
1	166466	DECAL – HIGH PRESSURE FLUID	1	
2	128973	DECAL – DOWN FORCE	1	
3	291638	DECAL – DECK LOWER LOCK (may not be exactly as shown)	1	
4	174683	DECAL – PINCH POINT	2	
5	184372	DECAL – READ MANUAL	1	

6 Reference

6.1 Torque Specifications

The following tables provide correct torque values for various bolts, cap screws, and hydraulic fittings.

- Tighten all bolts to torque values specified in charts (unless otherwise noted throughout this manual).
- Replace hardware with same strength and grade of bolt.
- Use torque value tables as a guide and periodically check tightness of bolts.
- Understand torque categories for bolts and cap screws by using their identifying head markings.

Jam nuts

When applying torque to finished jam nuts, multiply the torque applied to regular nuts by $f=0.65$.

Self-tapping screws

Standard torque is to be used (not to be used on critical or structurally important joints).

6.1.1 Metric Bolt Specifications

Table 6.1 Metric Class 8.8 Bolts and Class 9 Free Spinning Nut

Nominal Size (A)	Torque (Nm)		Torque (lbf·ft) (*lbf·in)	
	Min.	Max.	Min.	Max.
3-0.5	1.4	1.6	*13	*14
3.5-0.6	2.2	2.5	*20	*22
4-0.7	3.3	3.7	*29	*32
5-0.8	6.7	7.4	*59	*66
6-1.0	11.4	12.6	*101	*112
8-1.25	28	30	20	23
10-1.5	55	60	40	45
12-1.75	95	105	70	78
14-2.0	152	168	113	124
16-2.0	236	261	175	193
20-2.5	460	509	341	377
24-3.0	796	879	589	651

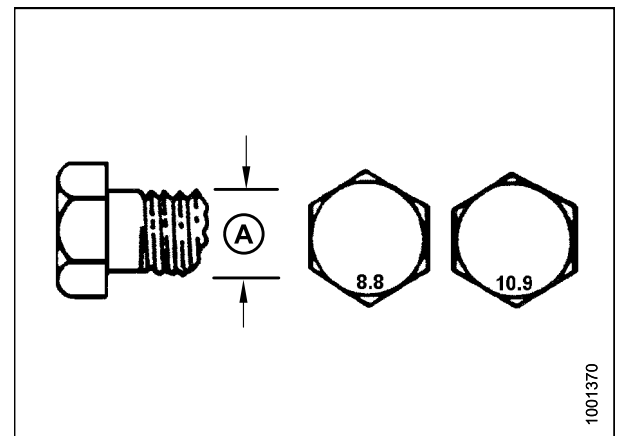


Figure 6.1: Bolt Grades

REFERENCE

Table 6.2 Metric Class 8.8 Bolts and Class 9 Distorted Thread Nut

Nominal Size (A)	Torque (Nm)		Torque (lbf-ft) (*lbf-in)	
	Min.	Max.	Min.	Max.
3-0.5	1	1.1	*9	*10
3.5-0.6	1.5	1.7	*14	*15
4-0.7	2.3	2.5	*20	*22
5-0.8	4.5	5	*40	*45
6-1.0	7.7	8.6	*69	*76
8-1.25	18.8	20.8	*167	*185
10-1.5	37	41	28	30
12-1.75	65	72	48	53
14-2.0	104	115	77	85
16-2.0	161	178	119	132
20-2.5	314	347	233	257
24-3.0	543	600	402	444

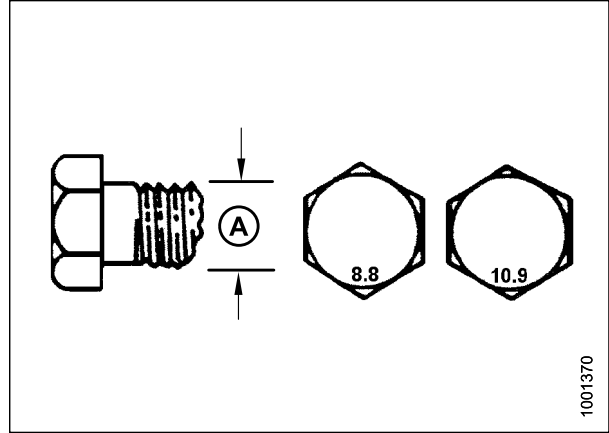


Figure 6.2: Bolt Grades

Table 6.3 Metric Class 10.9 Bolts and Class 10 Free Spinning Nut

Nominal Size (A)	Torque (Nm)		Torque (lbf-ft) (*lbf-in)	
	Min.	Max.	Min.	Max.
3-0.5	1.8	2	*18	*19
3.5-0.6	2.8	3.1	*27	*30
4-0.7	4.2	4.6	*41	*45
5-0.8	8.4	9.3	*82	*91
6-1.0	14.3	15.8	*140	*154
8-1.25	38	42	28	31
10-1.5	75	83	56	62
12-1.75	132	145	97	108
14-2.0	210	232	156	172
16-2.0	326	360	242	267
20-2.5	637	704	472	521
24-3.0	1101	1217	815	901

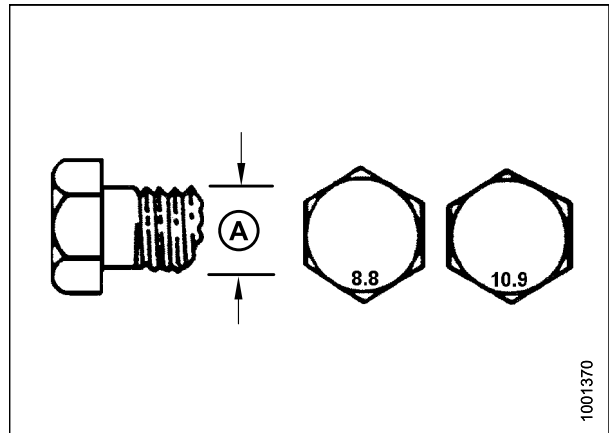


Figure 6.3: Bolt Grades

REFERENCE

Table 6.4 Metric Class 10.9 Bolts and Class 10 Distorted Thread Nut

Nominal Size (A)	Torque (Nm)		Torque (lbf-ft) (*lbf-in)	
	Min.	Max.	Min.	Max.
3-0.5	1.3	1.5	*12	*13
3.5-0.6	2.1	2.3	*19	*21
4-0.7	3.1	3.4	*28	*31
5-0.8	6.3	7	*56	*62
6-1.0	10.7	11.8	*95	*105
8-1.25	26	29	19	21
10-1.5	51	57	38	42
12-1.75	90	99	66	73
14-2.0	143	158	106	117
16-2.0	222	246	165	182
20-2.5	434	480	322	356
24-3.0	750	829	556	614

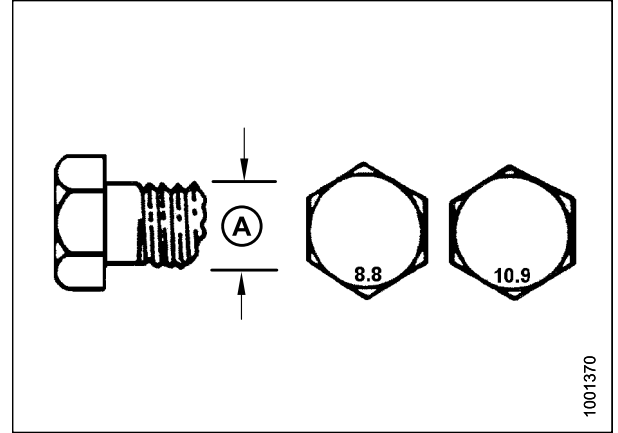


Figure 6.4: Bolt Grades

6.1.2 Metric Bolt Specifications Bolting into Cast Aluminum

Table 6.5 Metric Bolt Bolting into Cast Aluminum

Nominal Size (A)	Bolt Torque			
	8.8 (Cast Aluminum)		10.9 (Cast Aluminum)	
	Nm	lbf-ft	Nm	lbf-ft
M3	–	–	–	1
M4	–	–	4	2.6
M5	–	–	8	5.5
M6	9	6	12	9
M8	20	14	28	20
M10	40	28	55	40
M12	70	52	100	73
M14	–	–	–	–
M16	–	–	–	–

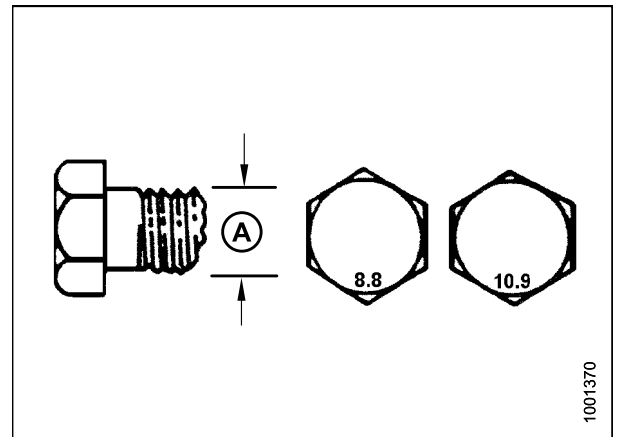


Figure 6.5: Bolt Grades

REFERENCE

6.1.3 O-Ring Boss (ORB) Hydraulic Fittings (Adjustable)

1. Inspect O-ring (A) and seat (B) for dirt or obvious defects.
2. Back off lock nut (C) as far as possible. Ensure that washer (D) is loose and is pushed toward lock nut (C) as far as possible.
3. Check that O-ring (A) is **NOT** on threads and adjust if necessary.
4. Apply hydraulic system oil to O-ring (A).

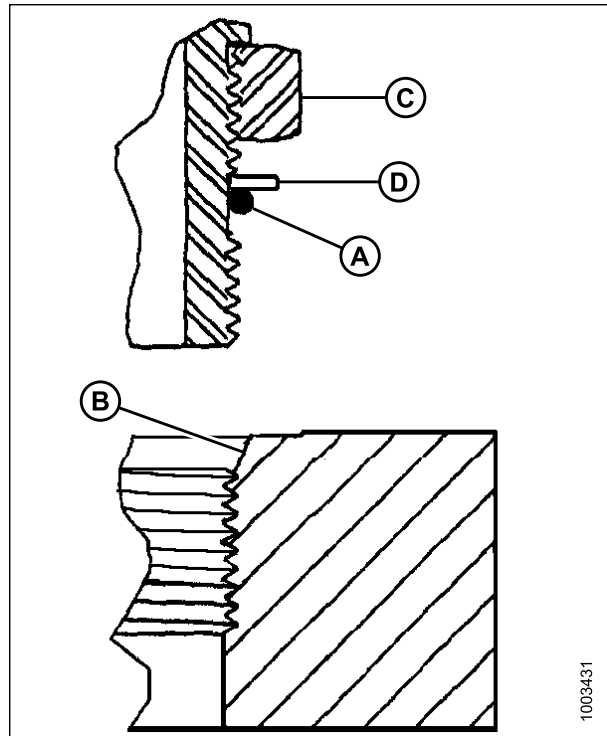


Figure 6.6: Hydraulic Fitting

5. Install fitting (B) into port until back up washer (D) and O-ring (A) contact part face (E).
6. Position angle fittings by unscrewing no more than one turn.
7. Turn lock nut (C) down to washer (D) and tighten to torque shown. Use two wrenches, one on fitting (B) and other on lock nut (C).
8. Check final condition of fitting.

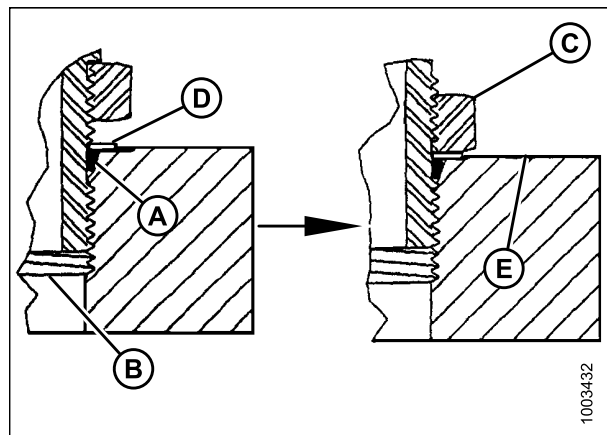


Figure 6.7: Hydraulic Fitting

REFERENCE

Table 6.6 O-Ring Boss (ORB) Hydraulic Fittings (Adjustable)

SAE Dash Size	Thread Size (in.)	Torque Value ²	
		Nm	lbf·ft (*lbf·in)
-2	5/16-24	6-7	*53-62
-3	3/8-24	12-13	*106-115
-4	7/16-20	19-21	14-15
-5	1/2-20	21-33	15-24
-6	9/16-18	26-29	19-21
-8	3/4-16	46-50	34-37
-10	7/8-14	75-82	55-60
-12	1-1/16-12	120-132	88-97
-14	1-3/8-12	153-168	113-124
-16	1-5/16-12	176-193	130-142
-20	1-5/8-12	221-243	163-179
-24	1-7/8-12	270-298	199-220
-32	2-1/2-12	332-365	245-269

2. Torque values shown are based on lubricated connections as in reassembly.

REFERENCE

6.1.4 O-Ring Boss (ORB) Hydraulic Fittings (Non-Adjustable)

1. Inspect O-ring (A) and seat (B) for dirt or obvious defects.
2. Check that O-ring (A) is **NOT** on threads and adjust if necessary.
3. Apply hydraulic system oil to O-ring.
4. Install fitting (C) into port until fitting is hand-tight.
5. Torque fitting (C) according to values in Table 6.7, page 58.
6. Check final condition of fitting.

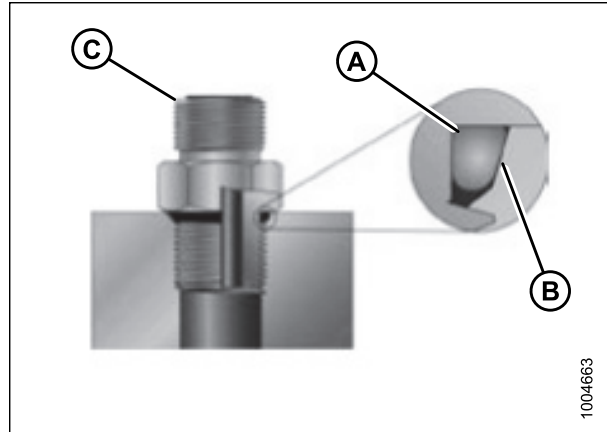


Figure 6.8: Hydraulic Fitting

Table 6.7 O-Ring Boss (ORB) Hydraulic Fittings (Non-Adjustable)

SAE Dash Size	Thread Size (in.)	Torque Value ³	
		Nm	lbf·ft (*lbf·in)
-2	5/16–24	6–7	*53–62
-3	3/8–24	12–13	*106–115
-4	7/16–20	19–21	14–15
-5	1/2–20	21–33	15–24
-6	9/16–18	26–29	19–21
-8	3/4–16	46–50	34–37
-10	7/8–14	75–82	55–60
-12	1-1/16–12	120–132	88–97
-14	1-3/8–12	153–168	113–124
-16	1-5/16–12	176–193	130–142
-20	1-5/8–12	221–243	163–179
-24	1-7/8–12	270–298	199–220
-32	2-1/2–12	332–365	245–269

3. Torque values shown are based on lubricated connections as in reassembly.

REFERENCE

6.1.5 O-Ring Face Seal (ORFS) Hydraulic Fittings

1. Check components to ensure that sealing surfaces and fitting threads are free of burrs, nicks, scratches, or any foreign material.



Figure 6.9: Hydraulic Fitting

2. Apply hydraulic system oil to O-ring (B).
3. Align tube or hose assembly so that flat face of sleeve (A) or (C) comes in full contact with O-ring (B).
4. Thread tube or hose nut (D) until hand-tight. The nut should turn freely until it is bottomed out.
5. Torque fittings according to values in Table 6.8, page 59.

NOTE:

If applicable, hold hex on fitting body (E) to prevent rotation of fitting body and hose when tightening fitting nut (D).

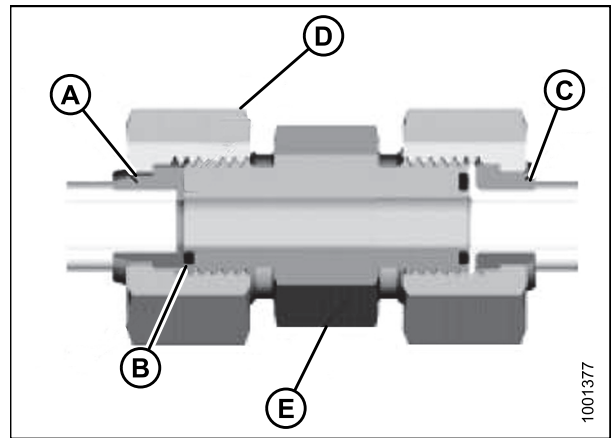


Figure 6.10: Hydraulic Fitting

6. Use three wrenches when assembling unions or joining two hoses together.
7. Check final condition of fitting.

Table 6.8 O-Ring Face Seal (ORFS) Hydraulic Fittings

SAE Dash Size	Thread Size (in.)	Tube O.D. (in.)	Torque Value ⁴	
			Nm	lbf-ft
-3	Note ⁵	3/16	–	–
-4	9/16	1/4	25–28	18–21
-5	Note ⁵	5/16	–	–
-6	11/16	3/8	40–44	29–32
-8	13/16	1/2	55–61	41–45
-10	1	5/8	80–88	59–65
-12	1-3/16	3/4	115–127	85–94

4. Torque values and angles shown are based on lubricated connection as in reassembly.
5. O-ring face seal type end not defined for this tube size.

REFERENCE

Table 6.8 O-Ring Face Seal (ORFS) Hydraulic Fittings (continued)

SAE Dash Size	Thread Size (in.)	Tube O.D. (in.)	Torque Value ⁶	
			Nm	lbf-ft
-14	Note ⁵	7/8	–	–
-16	1-7/16	1	150–165	111–122
-20	1-11/16	1-1/4	205–226	151–167
-24	1–2	1-1/2	315–347	232–256
-32	2-1/2	2	510–561	376–414

6.1.6 Tapered Pipe Thread Fittings

Assemble pipe fittings as follows:

1. Check components to ensure that fitting and port threads are free of burrs, nicks and scratches, or any form of contamination.
2. Apply pipe thread sealant (paste type) to external pipe threads.
3. Thread fitting into port until hand-tight.
4. Torque connector to appropriate torque angle. The Turns From Finger Tight (T.F.F.T.) values are shown in Table 6.9, page 60. Make sure that tube end of a shaped connector (typically 45° or 90°) is aligned to receive incoming tube or hose assembly. Always finish alignment of fitting in tightening direction. Never back off (loosen) pipe threaded connectors to achieve alignment.
5. Clean all residue and any excess thread conditioner with appropriate cleaner.
6. Assess final condition of fitting. Pay special attention to possibility of cracks to port opening.
7. Mark final position of fitting. If a fitting leaks, disassemble fitting and check for damage.

NOTE:

Overtorque failure of fittings may not be evident until fittings are disassembled.

Table 6.9 Hydraulic Fitting Pipe Thread

Tapered Pipe Thread Size	Recommended T.F.F.T.	Recommended F.F.F.T.
1/8–27	2–3	12–18
1/4–18	2–3	12–18
3/8–18	2–3	12–18
1/2–14	2–3	12–18
3/4–14	1.5–2.5	12–18
1–11 1/2	1.5–2.5	9–15
1 1/4–11 1/2	1.5–2.5	9–15
1 1/2–11 1/2	1.5–2.5	9–15
2–11 1/2	1.5–2.5	9–15

6. Torque values and angles shown are based on lubricated connection as in reassembly.

REFERENCE

6.2 Conversion Chart

Table 6.10 Conversion Chart

Quantity	SI Units (Metric)		Factor	Inch-Pound Units (Imperial)	
	Unit Name	Abbreviation		Unit Name	Abbreviation
Area	hectare	ha	$\times 2.4710 =$	acre	acres
Flow	liters per minute	L/min	$\times 0.2642 =$	US gallons per minute	gpm
Force	Newton	N	$\times 0.2248 =$	pound force	lbf
Length	millimeter	mm	$\times 0.0394 =$	inch	in.
Length	meter	m	$\times 3.2808 =$	foot	ft.
Power	kilowatt	kW	$\times 1.341 =$	horsepower	hp
Pressure	kilopascal	kPa	$\times 0.145 =$	pounds per square inch	psi
Pressure	megapascal	MPa	$\times 145.038 =$	pounds per square inch	psi
Pressure	bar (Non-SI)	bar	$\times 14.5038 =$	pounds per square inch	psi
Torque	Newton meter	Nm	$\times 0.7376 =$	pound feet or foot pounds	lbf-ft
Torque	Newton meter	Nm	$\times 8.8507 =$	pound inches or inch pounds	lbf-in
Temperature	degrees Celsius	°C	$(^{\circ}\text{C} \times 1.8) + 32 =$	degrees Fahrenheit	°F
Velocity	meters per minute	m/min	$\times 3.2808 =$	feet per minute	ft/min
Velocity	meters per second	m/s	$\times 3.2808 =$	feet per second	ft/s
Velocity	kilometers per hour	km/h	$\times 0.6214 =$	miles per hour	mph
Volume	liter	L	$\times 0.2642 =$	US gallon	US gal
Volume	milliliter	ml	$\times 0.0338 =$	ounce	oz.
Volume	cubic centimeter	cm ³ or cc	$\times 0.061 =$	cubic inch	in. ³
Weight	kilogram	kg	$\times 2.2046 =$	pound	lb.

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Predelivery Checklist

Perform these checks and adjustments prior to delivery to your Customer. The completed checklist should be retained by either the Operator or the Dealer.

CAUTION

Follow the instructions carefully. Pay attention to safety-related messages, and avoid unsafe practices.

✓	Item	Reference
	Check for shipping damage or missing parts. Be sure all shipping dunnage is removed.	—
	Check for loose hardware. Tighten to required torque.	<i>6.1 Torque Specifications, page 53</i>
	Raise and lower swath compressor to check for linkage binding. Rubber bumpers at rear should contact windrower frame when fully raised. If binding occurs, adjust by adding washers (MD #30635) where rear supports are fastened to the outside of frame.	<i>2.2.1 Installing Frame, page 14</i>
	Ensure sensor arm does not bind when raising or lowering the swath compressor.	<i>2.2.1 Installing Frame, page 14</i>
	Ensure fuel filter sensor wire does not contact swath compressor frame when fully raised.	<i>2.2.1 Installing Frame, page 14</i>
	Check hydraulic hose routing for clearance when raising or lowering swath compressor. Adjust as necessary.	<i>2.2.3 Connecting Hydraulics, page 20</i>
	Ensure hydraulic hoses are secured in place with cable ties.	<i>2.2.3 Connecting Hydraulics, page 20</i>
	Ensure swath compressor lock is functioning properly.	<i>3.3.6 Locking the Swath Compressor, page 37</i>
	Check for hydraulic leaks.	—
	Ensure side deflectors are set evenly to desired position.	<i>3.3.5 Adjusting Side Deflectors, page 37</i>
	Ensure latest software version is installed in windrower	—

Date checked: _____ Checked by: _____

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