

R216 Rotary Disc Header

CUTTERBAR DISC KITS (MD #325735 and 325736)

INSTALLATION INSTRUCTIONS

The Clockwise Cutterbar Disc kit (MD #325735) and the Counterclockwise Cutterbar Disc kit (MD #325736) are used to replaced damaged discs at positions 2 or 9 [second disc from each end of the cutterbar as shown in the illustration below] on a MacDon R216 Rotary Disc Header. These discs require accelerators, unlike the discs in positions 3–8.

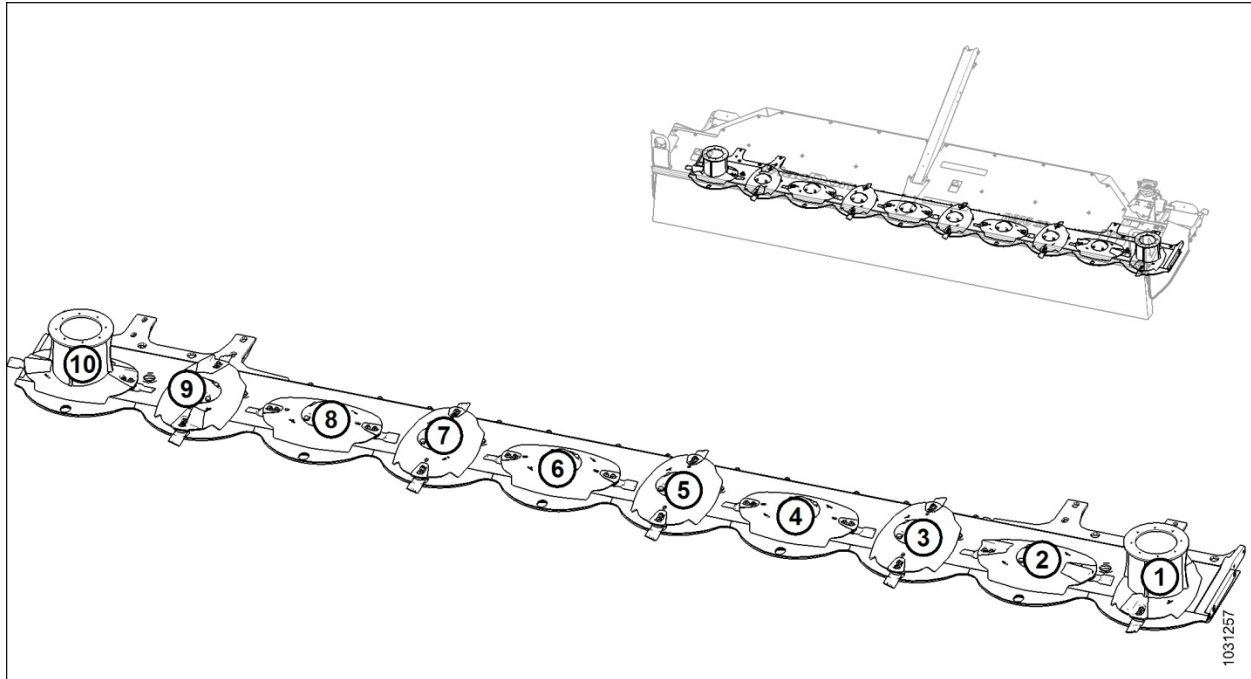


Figure 1: Cutterbar Disc Positions

This document explains how to install the kits. A list of parts included in the kits is provided.

NOTE: You will need to order two of blade nut (MD #246300) separately. It is not included in this kit.

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

NOTE: This document is currently available in English only.

Installation Time

Installation time is approximately 15 minutes per kit.

Conventions

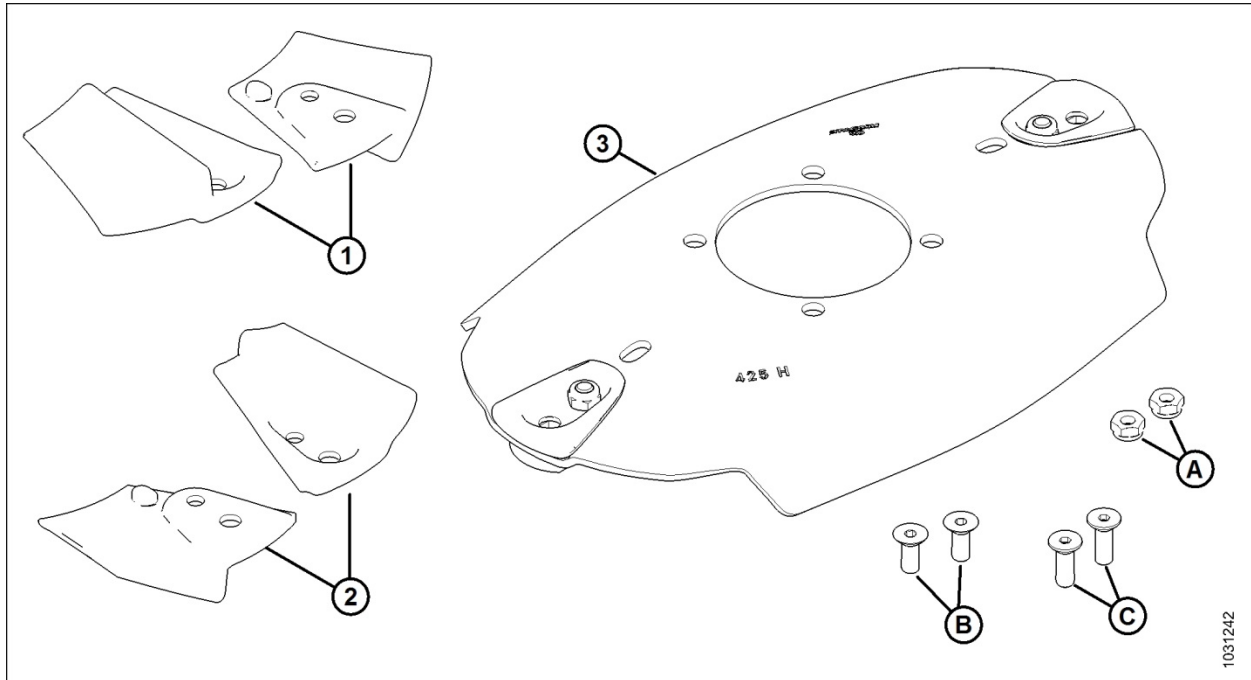
The following conventions are used in this document:

- Right and left are determined from the operator's position. The front of the header is the side that faces the crop; the back of the header is the side that connects to the windrower.
- Unless otherwise noted, use the standard torque values provided in the header operator's manual and technical manual.

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Parts List

These kits include the following parts:



Ref	Part Number	Description	Quantity	
			MD #325735 Clockwise	MD #325736 Counterclockwise
1	281966	ACCELERATOR, CLOCKWISE, PAIR	1	
2	281967	ACCELERATOR, COUNTERCLOCKWISE, PAIR		1
3	281370	ASSEMBLY – DISC, 425 MM	1	1
A	246303	NUT – ACCELERATOR	2	2
B	281965	BOLT – ACCELERATOR ¹	2	2
C	281605	BOLT – ACCELERATOR	2	2

¹ Bolts (MD #281965) are shipped with the accelerators, but are not required in these kits.

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To install the Cutterbar Disc kits, follow these steps:



DANGER

To avoid bodily injury or death from unexpected start-up or fall of a raised machine, stop the engine, remove the key, and engage the windrower lift cylinder safety props before going under a machine for any reason.



WARNING

Disc blades have two sharp cutting edges that can cause serious injury. Be careful and wear gloves when working around the blades.

NOTE: All parts are provided in the kit unless otherwise specified.

NOTE: You will need to order two of blade nut (MD #246300) separately. It is not included in this kit.

1. Remove the parts from the kit and compare them with the parts list provided in this instruction to ensure that nothing is missing.
2. Raise the header.
3. Shut off the engine, and remove the key from the ignition.
4. Engage the safety props on both lift cylinders as follows:
 - a. Pull lever (A) toward you to release, and then rotate it toward the header to lower the safety prop onto the cylinder.
 - b. Repeat for opposite lift cylinder.

IMPORTANT: Ensure the safety props engage over the cylinder piston rods. If a safety prop does not engage properly, raise the header until the safety prop fits over the rod.

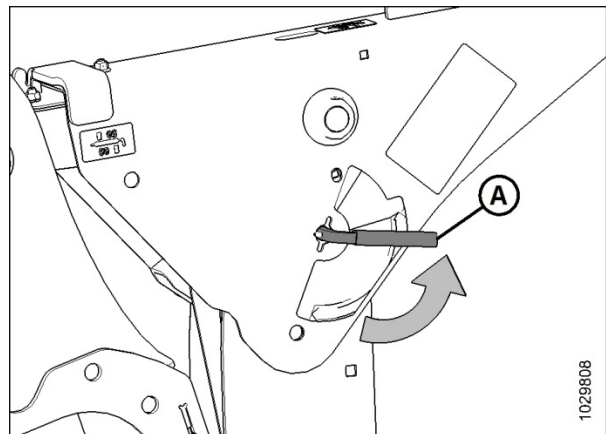


Figure 2: Windrower Safety Prop Lever

5. Open the cutterbar curtain. For instructions, refer to the header operator's or technical manual.

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Remove existing disc and blades

6. Locate the disc to be replaced (at position 2 or position 9 on the cutterbar).
7. Rotate disc (A) so blade (B) faces forward and lines up with hole (C) in the rock guard.
8. Place a pin (or equivalent) in the front hole of the neighboring rock guard to prevent disc rotation while loosening bolts.

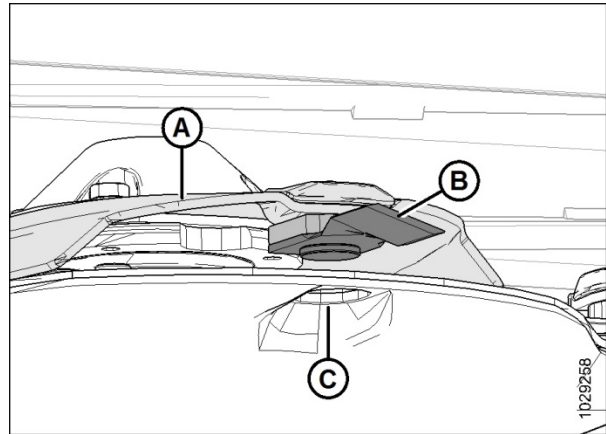


Figure 3: Disc Blade Aligned with Hole in Rock Guard

9. Clean debris from the blade attachment area.
10. Remove nut (A) and discard.

IMPORTANT: Nuts are one-time use only. When relocating or changing a blade, replace using a NEW nut only.

11. Remove shoulder bolt (B) and blade (C). Retain for reinstallation.
12. Repeat Steps 7–11 to remove second disc blade.

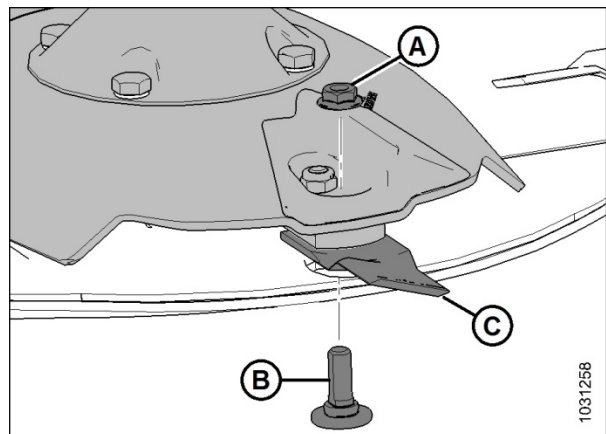


Figure 4: Removing Disc Blade

13. Remove four M12 bolts (A) and washers. Retain for reinstallation.
14. Remove cutterbar disc cap (B). Retain for reinstallation.
15. Remove cutterbar disc (C). Discard.

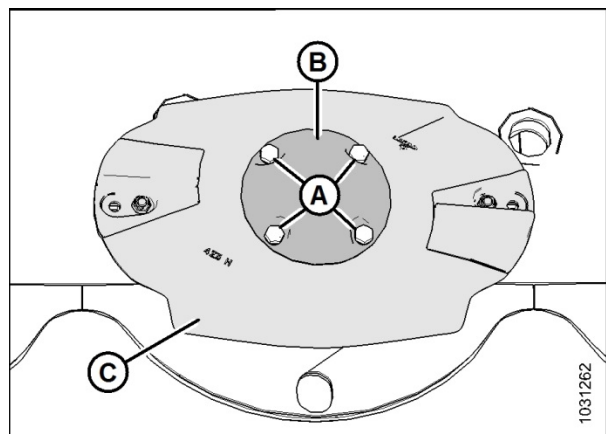


Figure 5: Existing Disc with Disc Blades Removed

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Install new disc and accelerators

16. Position new disc assembly (A) (MD #281370) on the spindle, ensuring that it is positioned at a 90° angle in relation to the adjacent discs.
17. Install retained cutterbar disc cap (B), and secure assembly with four retained M12 bolts and washers (C). Torque bolts to 85 Nm (63 lbf-ft).
18. Remove hardware (D) securing blade hardware guards (E) to new disc. Discard hardware and guards.

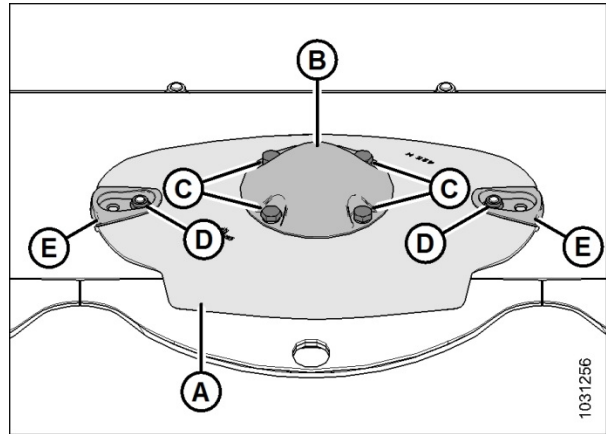


Figure 6: New Disc Installed

19. Position accelerator (B) (disc 2 clockwise: MD #281966; disc 9 counterclockwise: MD #281967) on the disc, and secure it to the disc and blade holder (C) with accelerator nut (A) (MD #246303) and accelerator bolt (D) (MD #281605). Do **NOT** tighten at this time.

NOTE: Accelerators are matched by weight and sold in pairs to eliminate imbalance issues. Only install matched sets of accelerators.

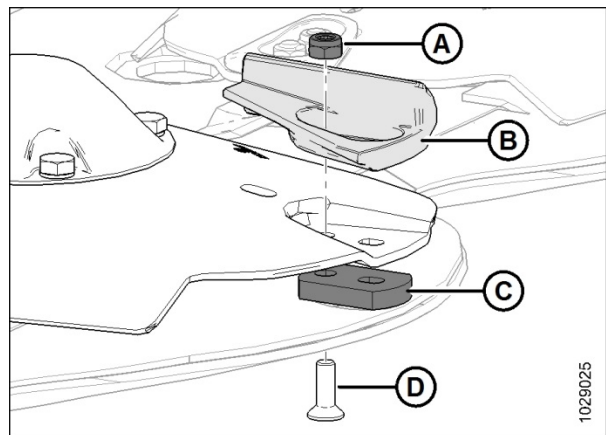


Figure 7: Installing New Accelerator

20. Install retained blade (C) with retained bolt (B) and purchased blade nut (A) (MD #246300).

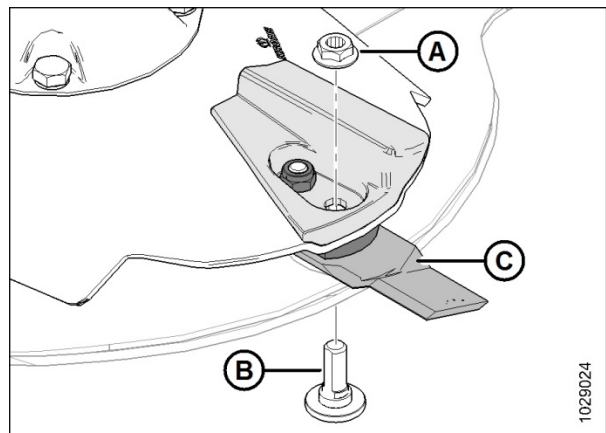


Figure 8: Installing Retained Disc Blade

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21. Torque interior nut (A) to 58 Nm (43 lbf-ft).
22. Torque exterior nut (B) (closest to blade) to 125 Nm (92 lbf-ft).
23. Repeat Steps 19–22 for the second accelerator and blade.

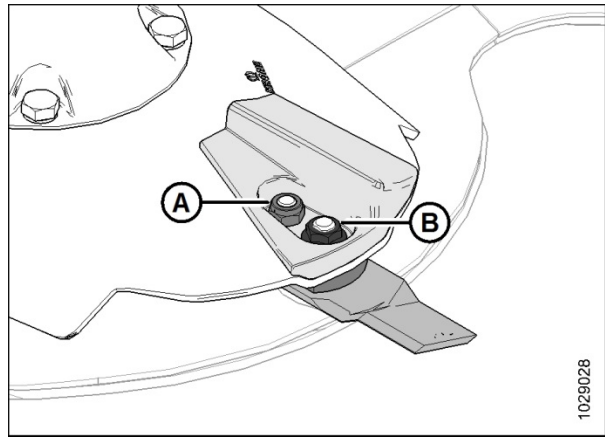


Figure 9: Hardware Securing Accelerator and Disc Blade



WARNING

Ensure the cutterbar is completely clear of foreign objects. Foreign objects can be ejected with considerable force when the machine is started and may result in serious injury or machine damage.

24. Remove the pin (or equivalent) from the front hole of the rock guard.
25. Close the cutterbar curtain. For instructions, refer to the header operator's manual or technical manual.

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