



# **Flange Bushing Rebuild**

## **Installation Instructions**

**Premium Arm Kit**

**CIH/New Holland**

## BITS REQUIRED FOR INSTALLATION

Verify appropriately sized reamer has been sourced, all reamers and bits are available through SI Distributing and should have been recommended at the time of purchase.

1. Lower row unit and support plate reamer: 11/16"
  - The bolts used on the lower pivot locations are a 5/8" fine threaded bolt with an 11/16" shoulder.
  - This reamer will allow the lower holes to accommodate the 11/16" shoulder.

## PRE-INSTALLATION PREPARATION

1. Sort and lay out packaged components by part number. Each bag should be labeled with S.I. Distributing's part number which is helpful for reference.
  - The diagrams within these instructions will be used to reference to understand the placement of the various bolts you have in your kit.
2. Check each row for clearance issues with either the bolt and/or hex bushing.
  - If you have any of the following call S.I. Distributing for alternative solutions.
    - A location that may not allow fitment of either the bolt or hex bushing.
    - Row unit has attachments to support plate (row cleaner mount, down pressure spring bracket) inhibiting the use of either the bolt or hex bushing.
    - Any clearance issue that inhibits the installation or functionality of these kits.

## SAFETY REMINDER

**Always wear proper safety equipment when using power tools.**

**SAFETY GLASSES, HEARING PROTECTION, AND GLOVES ARE A MUST WHEN WORKING WITH REAMERS AND METAL SHAVINGS!**



## UPPER PARALLEL ARM INSTALLATION

1. Check to make sure you have the correct bolts for each of the hole locations.
  - Some planters will use 4 carriage bolts for the upper arms, some will use 2 carriage bolts and 2 hex bolts. Both are included in this kit.
2. Make sure carriage bolt shoulder does not protrude outside of the hole.
  - If the shoulder is too long a washer can be placed under bolt head to shim the shoulder back. The hex bushings **must not** contact the bolt shoulder.
3. Install the bolts through the row unit/support plate holes then through the flange bushings in the parallel arms.
4. Place red thread locker starting ½” from the end of the bolt.
5. Locations “A” and “B”, install one 1/8” shim washer on each hex bushing then thread the hex bushing onto the bolt.”



6. Tighten hex bushing to torque value of 80 ft. lbs.
7. Apply one drop of red thread locker to end of bolt threads.
8. Install jam nut, torque to value of 65 ft. lbs.

## LOWER PARALLEL ARM INSTALLATION

1. Due to extensive force applied by hydraulic down pressure systems. A 5/8" bolt with an 11/16" shoulder will now be used with the lower parallel arms.
2. Using 11/16" reamer, ream square carriage holes on the lower support plate and row unit.
  - Use plenty of cutting fluid/oil to maintain the lifespan of your reamer.
  - A right angle drill may be needed for better access to holes.
3. Install the bolts through the row unit/support plate holes then through the flange bushings in the parallel arms.
4. Place red thread locker starting 1/2" from the end of the bolt.
5. Location "C", install two 1/8" shim washers on the hex bushing then thread the hex bushing onto the bolt.
6. Location "D", install one 1/16" and one 1/8" shim washers on the hex bushing then thread the hex bushing onto the bolt.



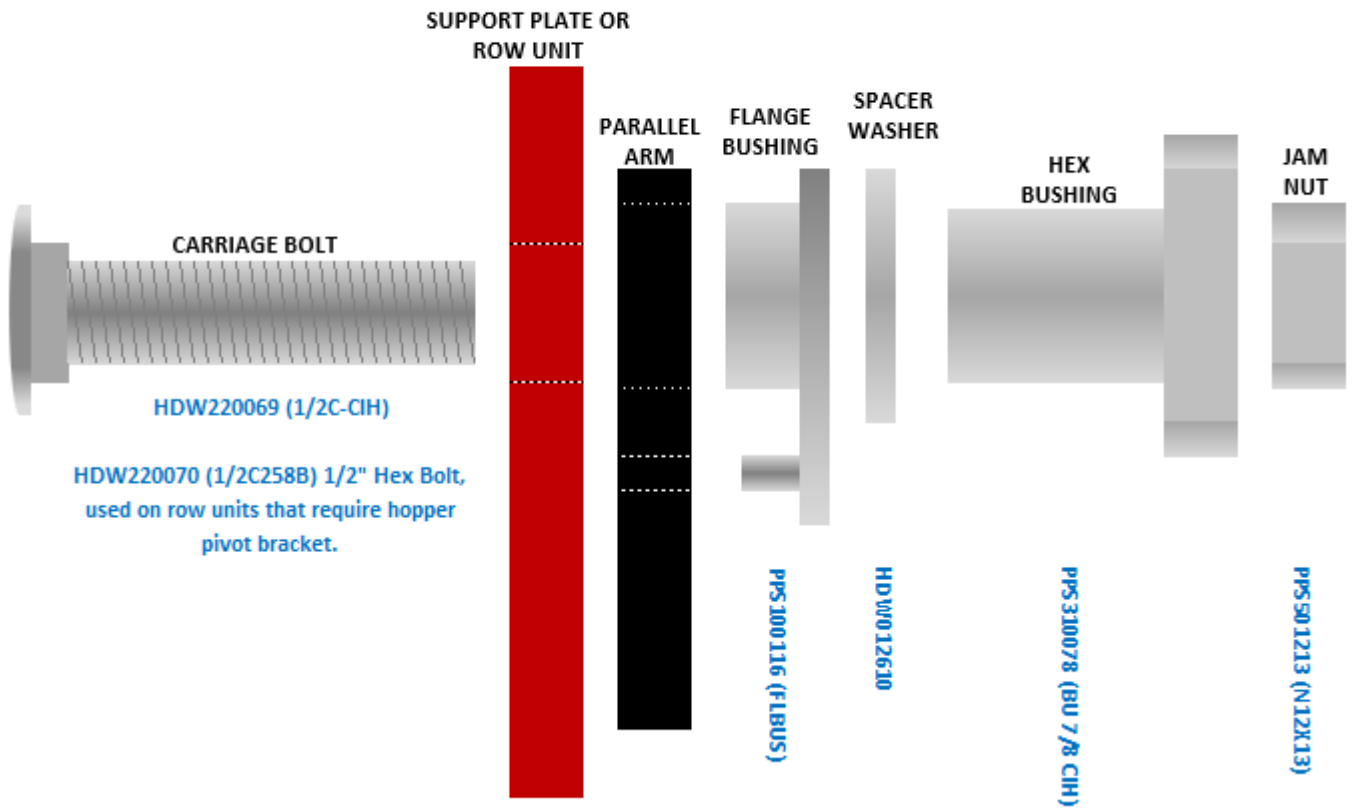
7. Tighten to torque value of 145 ft. lbs.
8. Apply one drop of red thread locker to end of bolt threads.
9. Install jam nut, torque to value of 100 ft. lbs.

## **FINAL CHECK**

1. Spray each hex bushing on top and bottom with small amount of penetrating spray.
2. Make sure row unit moves freely.

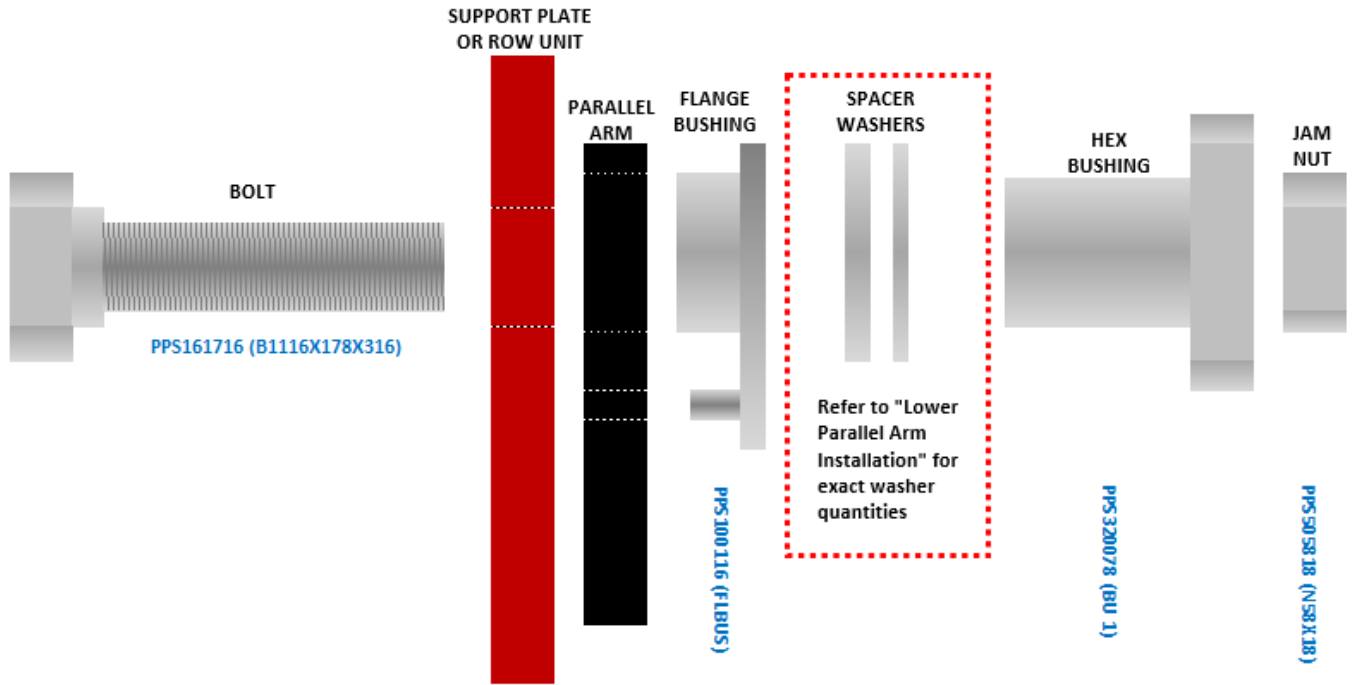
# Installation Diagram

Locations "A" & "B"



# Installation Diagram

Locations "C" & "D"







# S.I. DISTRIBUTING

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