



Flange Bushing Rebuild

Installation Instructions

No-Ream Arm Kits

John Deere

MaxEmerge XP Pro

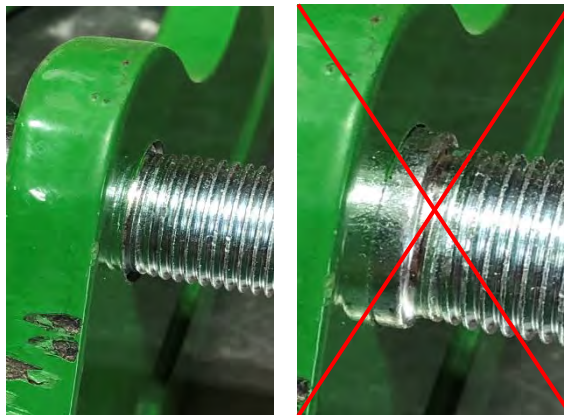
CCS Mini-Hopper

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.

PARALLEL ARM INSTALLATION

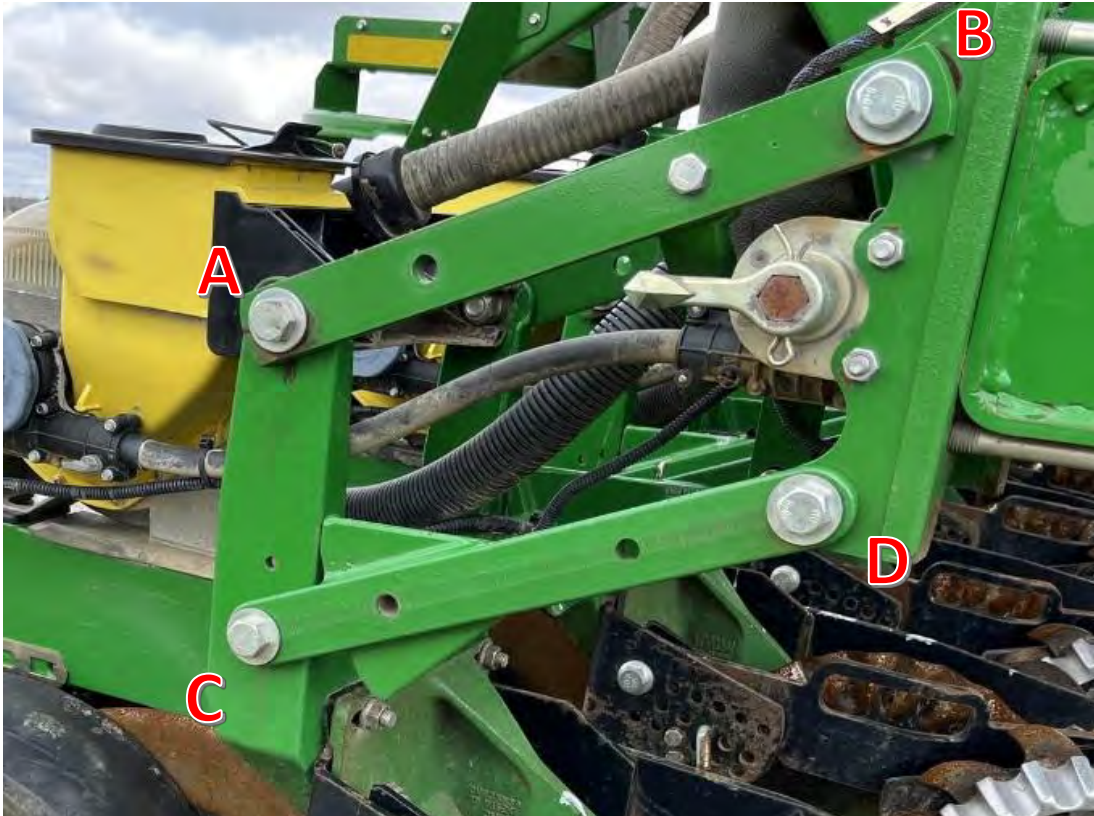
1. Check to make sure you have the correct bolts for each of the hole locations.
 - The shoulder on the bolts must be recessed and not protrude outside of the hole on the support plate/row unit. If the shoulder is too long, a washer can be placed under the head of the bolt to shim the shoulder back.
 - The hex bushing **MUST NOT** contact the bolt shoulder for proper fitment.



2. Install the bolts through the row unit/support plate holes then through the flange bushings in the parallel arms.

3. Add spacer washers to hex bushings according to diagram.
 - Locations “A”, “B”, & “D” in diagram below, front support plate and upper row unit locations, will use two 1/8” (thick) spacer washers and one 1/16” (thin) spacer washer.
 - Location “C” in diagram below, lower rear row unit, will use up to three 1/16” (thin) spacer washers.

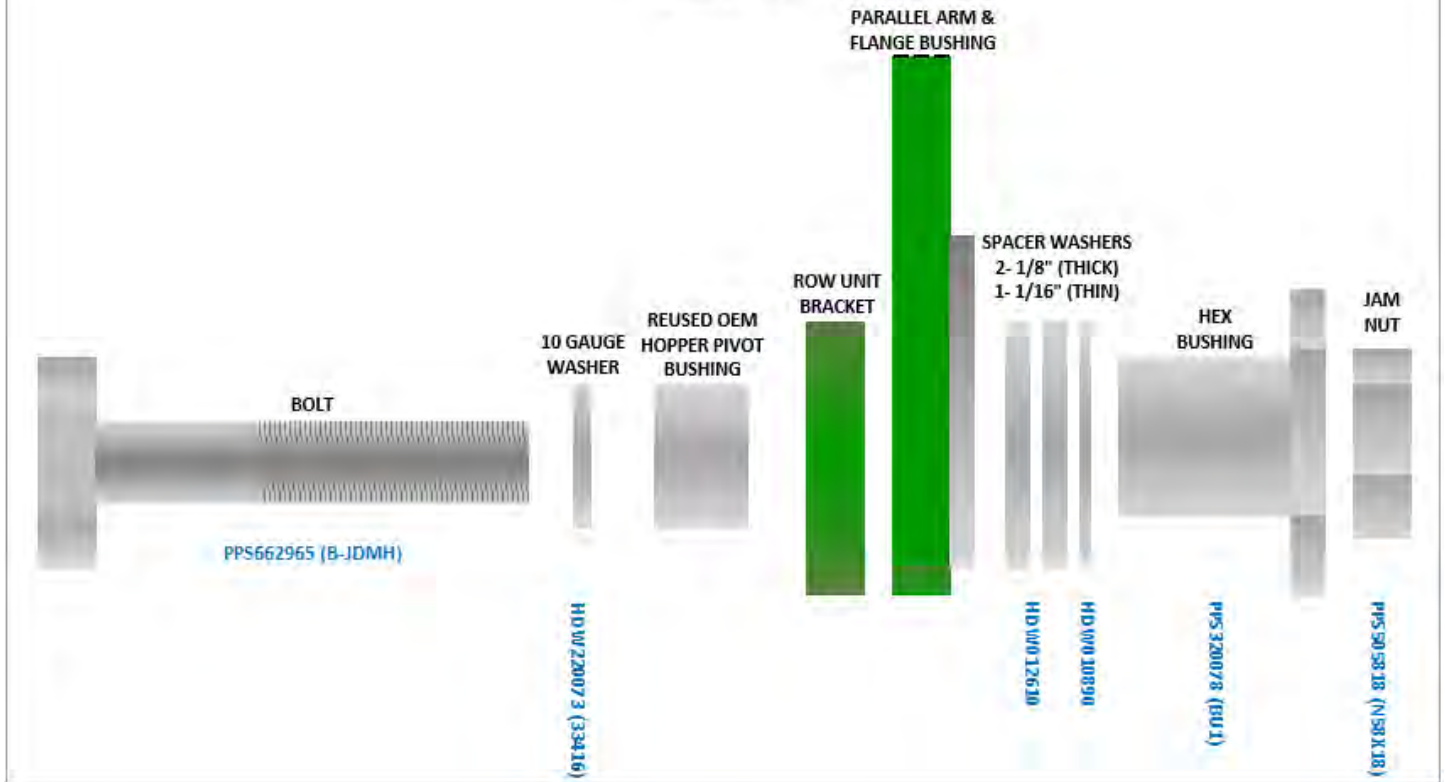
Washers must be free to turn on the top parallel arm holes and at least one side of the bottom parallel arm holes. Remove washers if necessary.



4. Apply high strength threadlocker (Vibra-Tite 131) starting ½” from bolt end, then hand thread hex bushing with spacer washers onto bolt through the flange bushing in the parallel arm.
 - The hex bushing must “bottom out” against the row unit and support plate brackets.
 - **DO NOT** tighten with an impact as damage to bushings may occur.
5. Using torque wrench tighten hex bushing to 145 ft. lbs.
 - Make sure the spacer washers still turn after torqued.
6. Apply threadlocker to remaining threads on the bolt, then thread jam nut on by hand.
 - Torque jam nut to 100 ft. lbs.
7. When assembly is complete, spray each bushing with a small amount of penetrating oil and make sure row unit moves freely.

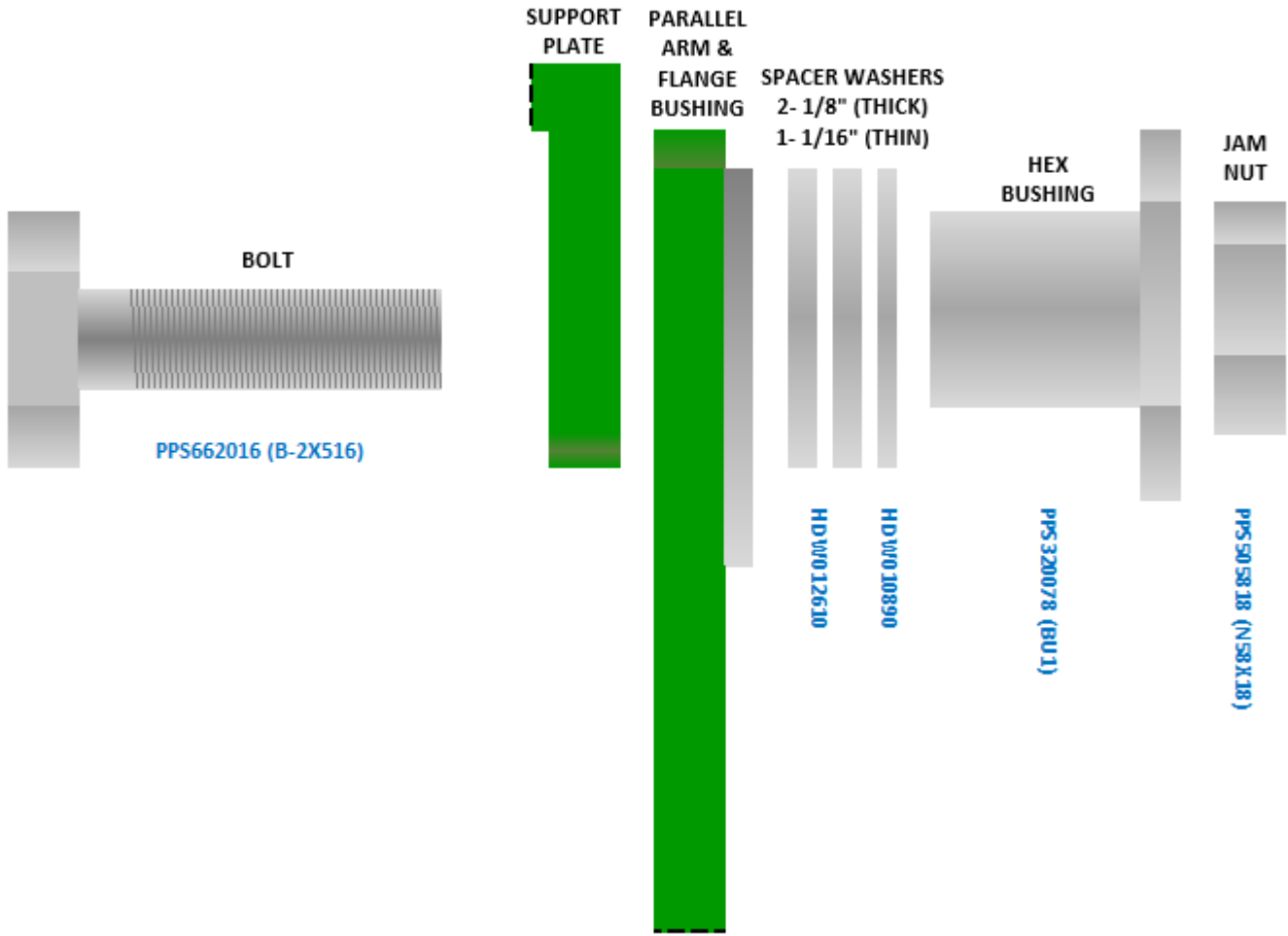
Installation Diagram

Location "A"



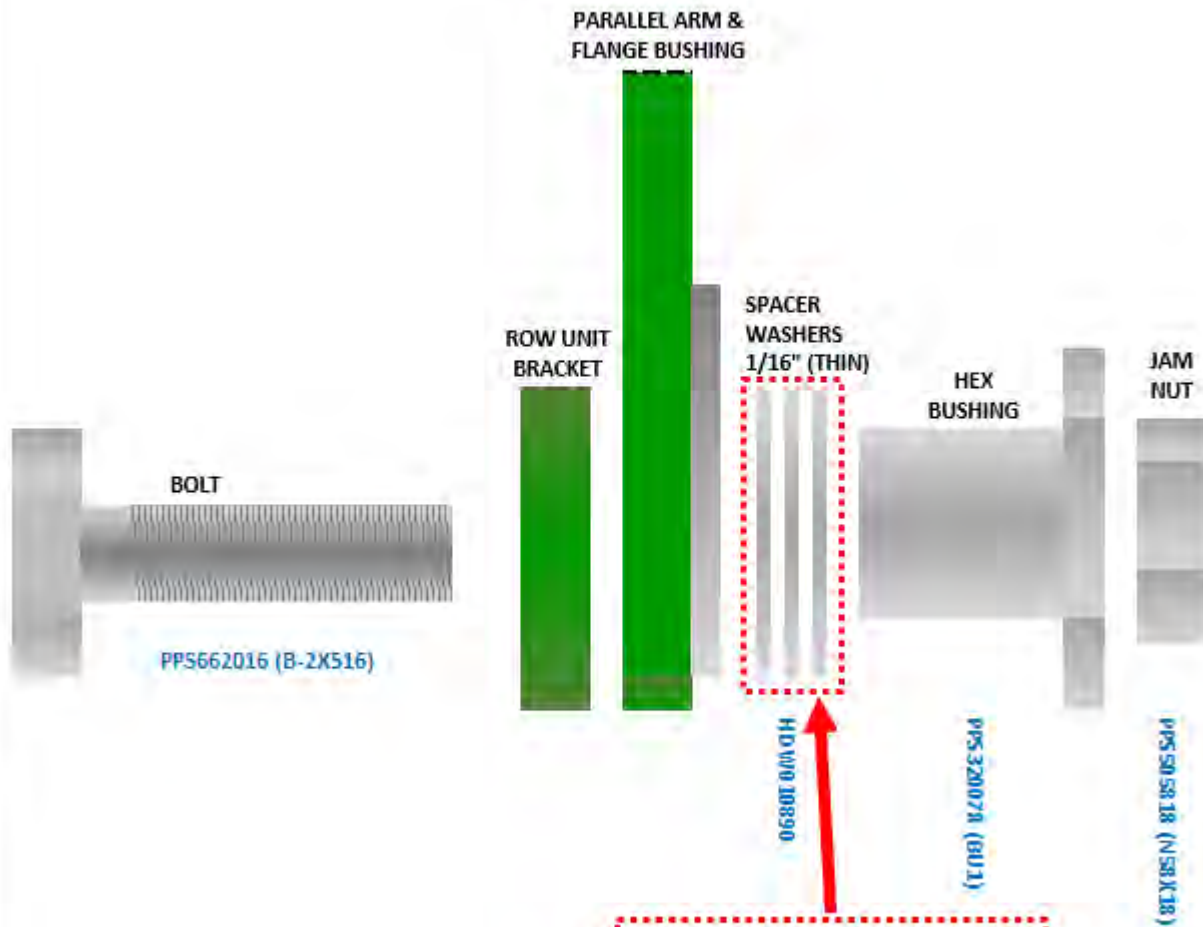
Installation Diagram

Locations "B" & "D"



Installation Diagram

Location "C"



KITS INCLUDE THREE 1/16" (THIN) SPACER WASHERS PER SETUP. MOST CASES ONLY ONE OR TWO WILL BE USED ON LOCATION "C". THESE CANNOT BE SQUEEZED TIGHT!



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