



# **Flange Bushing Rebuild**

## **Installation Instructions**

**Premium Arm Kits**

**John Deere**

**MaxEmerge XP Pro**

**CCS Mini-Hoppers**

## BIT REQUIRED FOR INSTALLATION

Verify 11/16” reamer bit has been sourced, all reamers and bits are available through SI Distributing and should have been recommended at the time of purchase.

1. Row unit and support plate reamer: 11/16”
  - The bolts included in this kit are a 5/8” fine threaded bolt with an 11/16” shoulder. Once reamed the shoulder is designed to fit snugly into the row unit and support plate holes filling any gaps caused by wear or oversized holes from manufacturing.

## 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!**

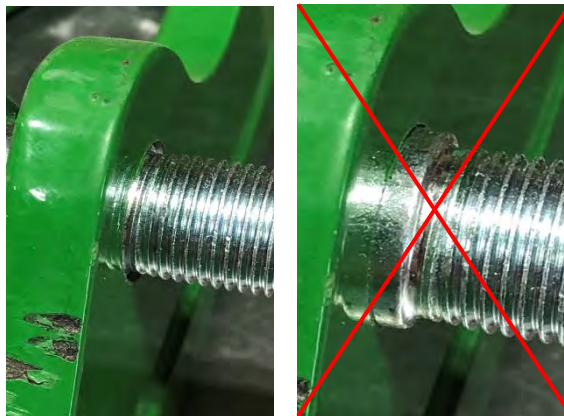


# SUPPORT PLATE/ROW UNIT REAMING

1. Begin reaming the support plate and row unit holes with the 11/16" reamer.
  - Use plenty of cutting fluid to extend the life of the bit.
  - Do not pull reamer back through the hole while it is turning.
  - The "cup" or "puck" bracket (if applicable) used for the hopper hooks on box planters will also need to be reamed out to 11/16".
2. Tips for tight clearance areas.
  - A 12" long 1/2" bit extension can be used to reach from one side of the support plate to the other.
  - A right-angle chuck/drill may be necessary in hard-to-reach areas.
  - Longer reamers can be modified with a chop saw to shorten.
  - Some situations may require the removal of the support plate.

## PARALLEL ARM INSTALLATION

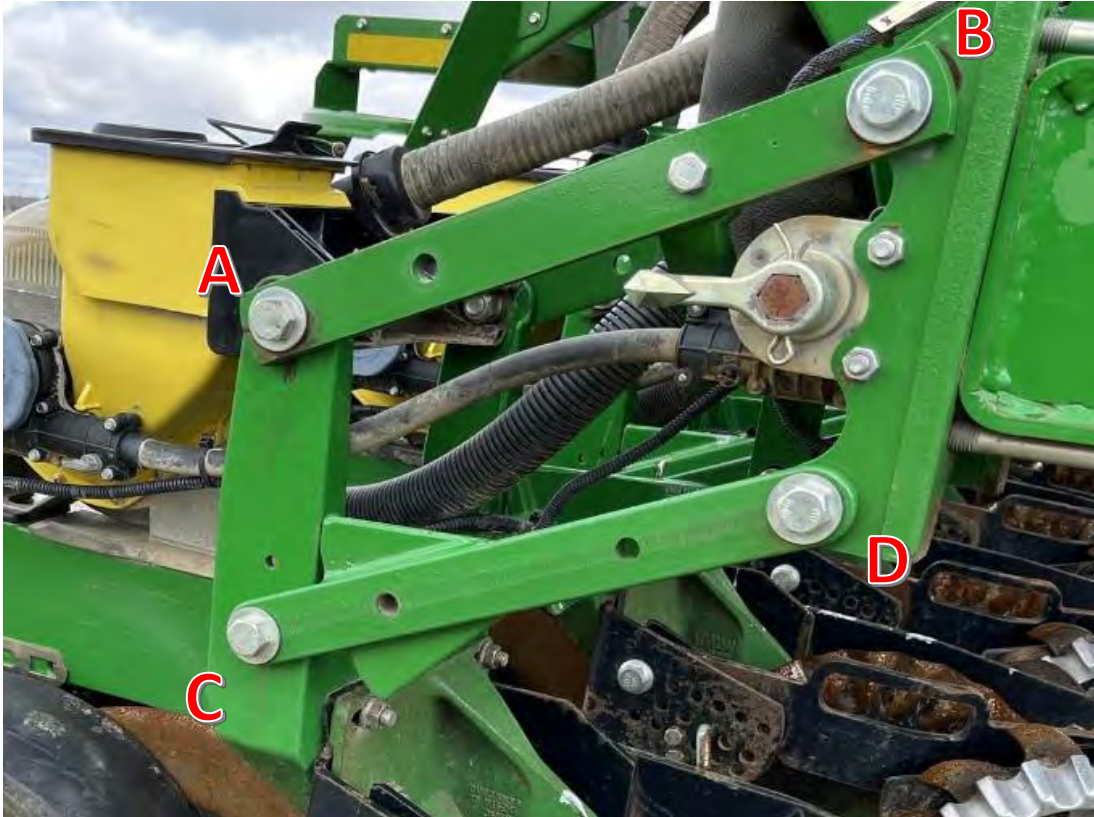
1. Check to make sure you have the correct bolts for each of the hole locations.
  - The shoulder on the bolts must be recessed and not protrude outside of the hole on the support plate/row unit. If the shoulder is too long, a washer can be placed under the head of the bolt to shim the shoulder back.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

PARALLEL ARM &  
FLANGE BUSHING

ROW UNIT  
BRACKET

SPACER WASHERS  
2- 1/8" (THICK)  
1-1/16" (THIN)

HEX  
BUSHING

JAM  
NUT

BOLT

PPS162965 (B1116XJDMH)

HDVW012610

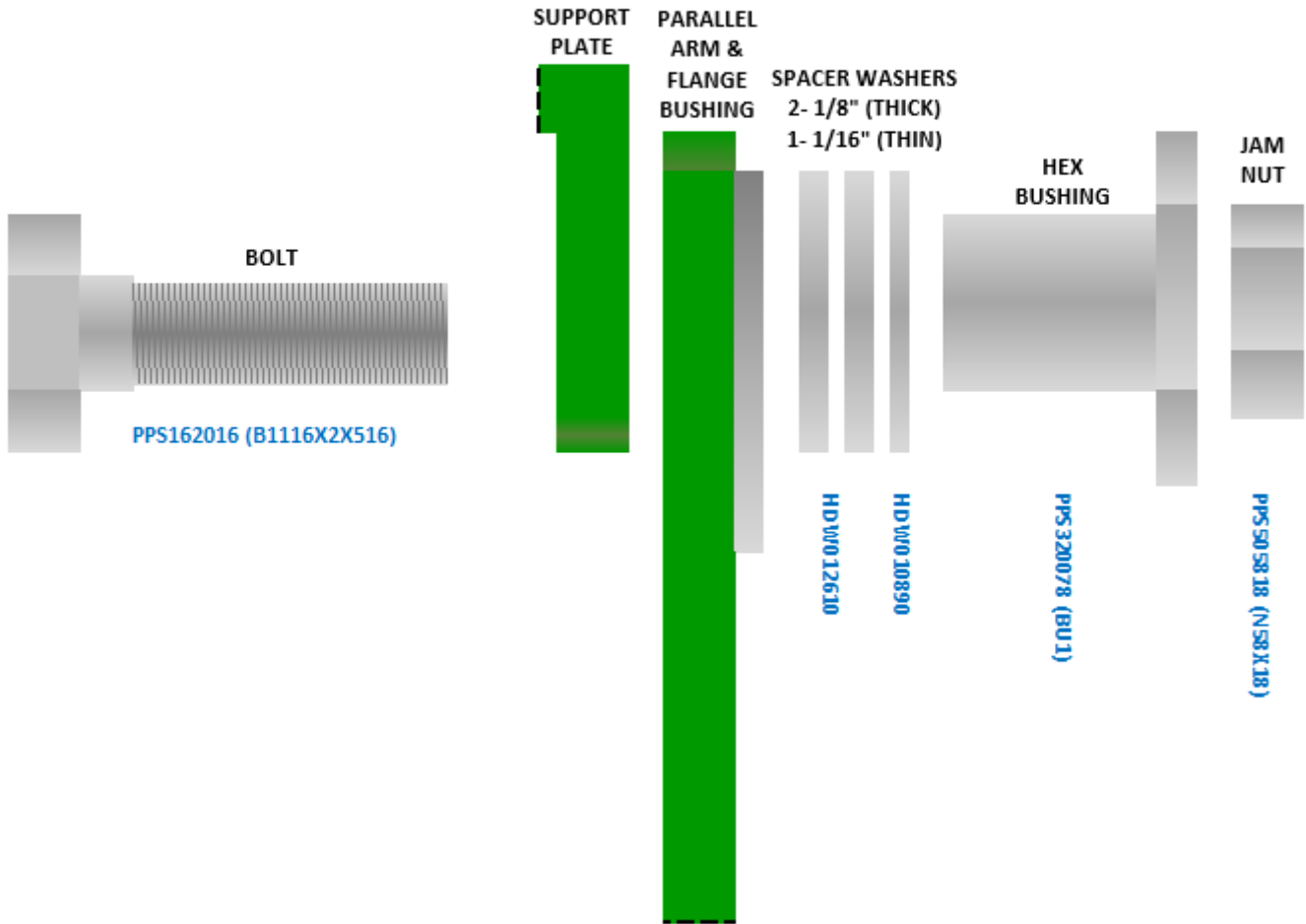
HDVW010890

PPS320078 (BU1)

PPS505818 (N58X18)  
(88X18)

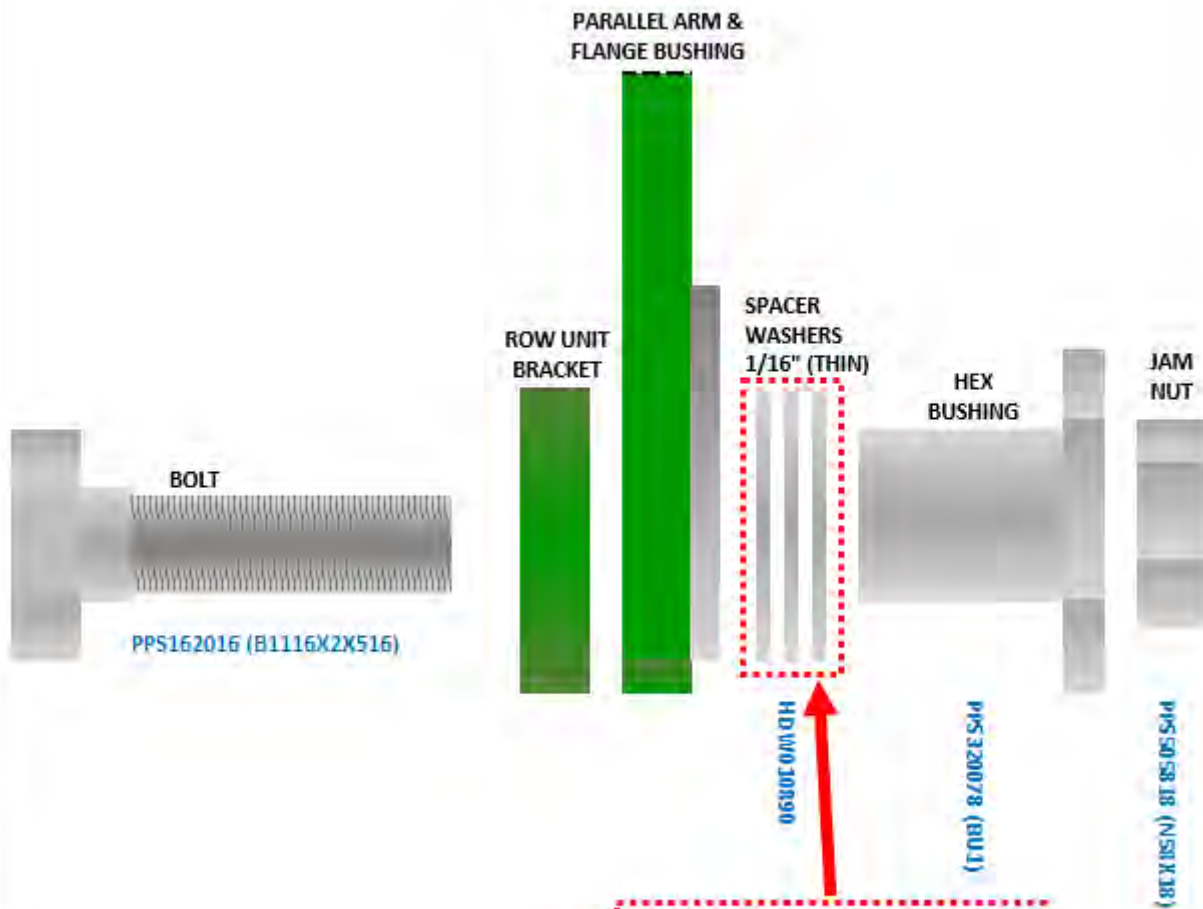
# Installation Diagram

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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