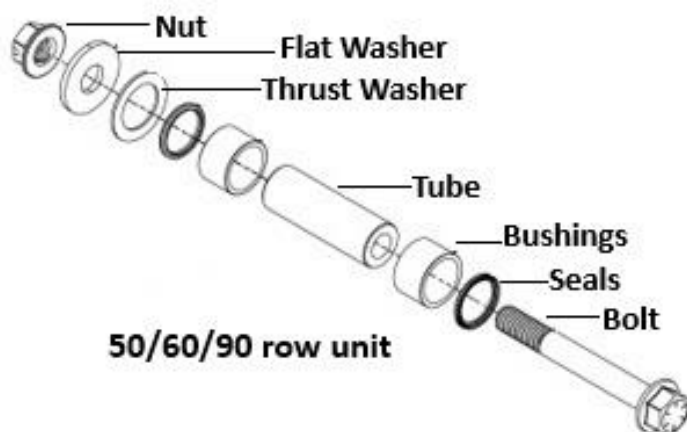


INSTALLATION of Exapta's Closing Arm Pivots

on JD 50/60/90/Pro series row units



Tools Needed:

- 15/16" short well socket
- 15/16" wrench
- ½" Air Hammer
- Manual Hammer
- Exapta removal/install tools

Disassembly:

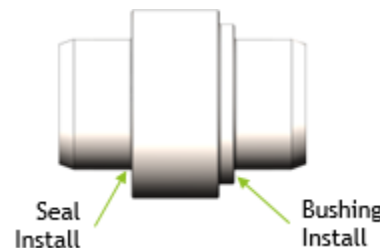
1. It's helpful to use a floor jack to raise the row unit up for easier access to the bushing points for install/removal.
2. Using 15/16" socket and wrench, loosen the nut to remove the bolt and allow the entire arm to be laid aside.
3. With the arm off, the down pressure spring will be loose to take off row unit.
4. Use hammer to tap the chrome tube out of bore. If tube is 1 1/8" diameter & doesn't show any wear marks this can be re-used with new bushings.
5. Prying out the seals first will make the bushings come out easier. Some air hammers have enough punch to knock seals & bushings all out from one side.
6. Use Exapta removal tool to punch out bushings. The **shorter end of the tool is for 50/60/90 series openers**. The longer side in image to the right marked Pro is for use on Pro series openers.
7. Clean bore thoroughly with wire brush included.

Prior to maintenance or repair, read and understand all applicable operating manuals. Park the machine on level ground, shut down all power sources, and secure the equipment to prevent unintended movement. When servicing raised machinery, use approved lockout devices. Identify and mitigate hazards including pinch points, shear zones, cutting surfaces, and rotating components. Wear appropriate personal protective equipment (PPE). Reinstall all safety guards before returning the machine to service



Assembly:

8. Install bushings using air hammer with Exapta bushing install side of tool shown in the image to the right. It has a step to leave room for the seal.
9. Use air hammer or manual hammer to install seal on one side of unit, using seal install side of tool shown in image to the right.
10. Slide in chrome tube from the side **without** the seal installed yet. Pushing tube through seal increase's chance of damaging seal.
11. Install remaining seal with tool. Ensuring tube is centered in bore.
12. Replace any grease zerks with plugs provided.
13. Reattach down pressure spring
14. **Install closing arms with bolt head on arm side**, thrust washer, flat washer, then nut
15. Torque bolt to 110 ft/lbs.
16. Pro series row unit kits replace closing arm dust cap with larger one included for clearance over nut.

**Information:**

50/60/90 series once the Exapta kit is installed, unless the tube is damaged, it can be re-used in the future. This allows just bushing & hardware replacement saving money in the future.

Note: Adding more shims to take up play in the closing arms after new bushing install, indicates the outside of the casting is worn. More shims will move the wear point onto the washers instead of the bushings. The rubbing action against the casting will wear out the housing faster.