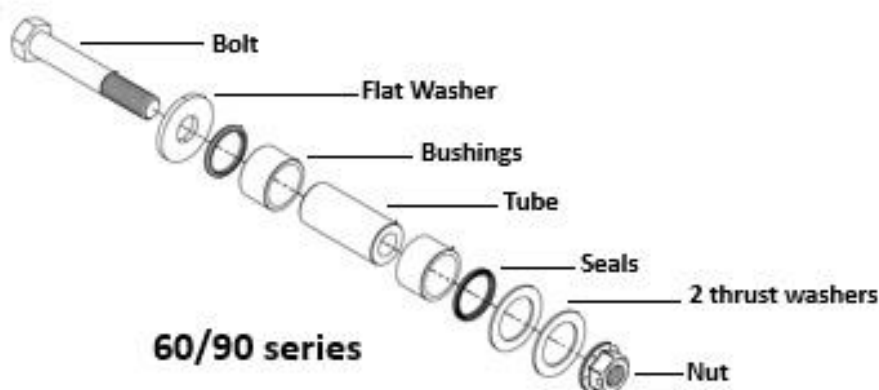


INSTALLATION of Exapta's Firming Arm Pivots

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

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

Disassembly:

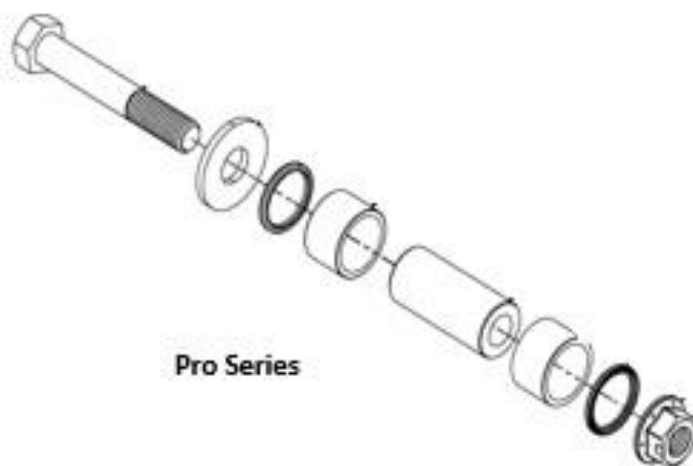
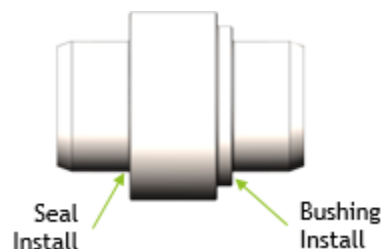
1. It's helpful to use a floor jack to raise the row unit up for easier access to the bushing points for install/removal. Move the depth adjust T-Handle down to lowest position for better access to bushings. Firming bushings are easier to replace with opener blades off, for access to both sides of pivot.
2. Using 15/16" socket and wrench, loosen the nut to remove the bolt and allow the entire arm to be laid aside. With the arm off, the down pressure spring will be loose to take off row unit.
3. Use hammer to tap the chrome pin out. If chrome pin is 1-1/8" diameter & doesn't show any wear marks this can be re-used with new replacement bushings.
4. Prying out the seals first will make bushings come out easier. Some air hammers have enough punch to knock seals and bushings all out from one side.

5. 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 the image to the right marked Pro is for use on Pro series openers.
6. Clean bore thoroughly with wire brush included.



Assembly:

7. 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.
8. Use air hammer or manual hammer to install seal on one side of unit, using seal install side of tool in the image to the right.
9. Slide in pin from the side **without** the seal installed yet. Pushing the tube from the outside after seal is installed is more likely to damage seal.
10. Install remaining seal using same process as first seal. Ensure tube is centered in bore.
11. Replace any grease zerks with plugs provided
12. Reattach down pressure spring
13. **Install firming arms with bolt head toward depth adjustment plate.** See diagrams for assembly order. 60/90 series have 2 thrust washers added on the arm side of pivot to keep bolt head away from depth arm.
14. **Torque bolt to 110 ft/lbs**



Information:

Adding more shims to take up play in the firming/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.