

**12- to 24-Blade Fan
Conversion
Kits #70660 & #70665**

AMADAS

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*Fan Conversion Kits are manufactured
by Amadas Industries.*

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How to Replace a 12-Blade Fan with a 24-Blade Fan

This form provides you with the instructions for replacing the 12-blade fan in your combine with a 24-blade fan.

The fan installation kit includes air strippers and deflectors to ensure proper direction and stability of airflow. If you have replaced the fan without adding these items, you may have noticed that the fan does not always work properly. Re-installing the fan and adding the strippers and deflectors should eliminate any problems you are having with the fan.

Kit #70660 contains the strippers and deflectors, fan, and sheave for the 12-blade to 24-blade fan conversion. Kit #70665 contains the strippers and deflectors only. Make sure you have the correct kit before beginning.

Please read these instructions carefully before replacing your fan blade. Pay close attention to the safety information and warnings provided.

Safety



It is essential to your safety and the safety of others that you read and follow all safety information!!

- Do **NOT** perform this fan change with the combine operating ***under any circumstances.***

- Follow all instructions for immobilizing the combine before beginning.
- Space is very limited in the area in which the fan blade is changed. Please consider the size of the space and the worker before anyone enters this area.
- If the machine makes any unusual noises or operates improperly after the fan is replaced, shut off the machine ***immediately.*** Make all necessary adjustments before operating the combine.
- Follow procedures for safe lifting. Use a helper when needed.
- This procedure involves sharp edges; wear work gloves to protect hands as appropriate.

Before Beginning

Please check to make sure you have all parts listed on the packing sheet. If anything is missing or damaged, please contact your dealer. In addition, you will need the following:

- A 20-ton minimum jack or other suitable lifting device.
- Blocks to stabilize the combine.
- Anti-seize lubricant.
- Mechanical Fingers or other mechanical retrieval/position tool.

Position the Combine

**DANGER!**

It is **crucial** that you follow the instructions for positioning and immobilizing the combine before replacing the fan. Failure to do so could result in serious injury or death.

1. Position the combine or combine/tractor combination on firm, level ground.

If the tractor remains connected to the combine:

- Make sure the tractor is in the PARK gear.
- Apply parking brake.
- Chock wheels.
- Shut off the engine and remove keys from tractor ignition.

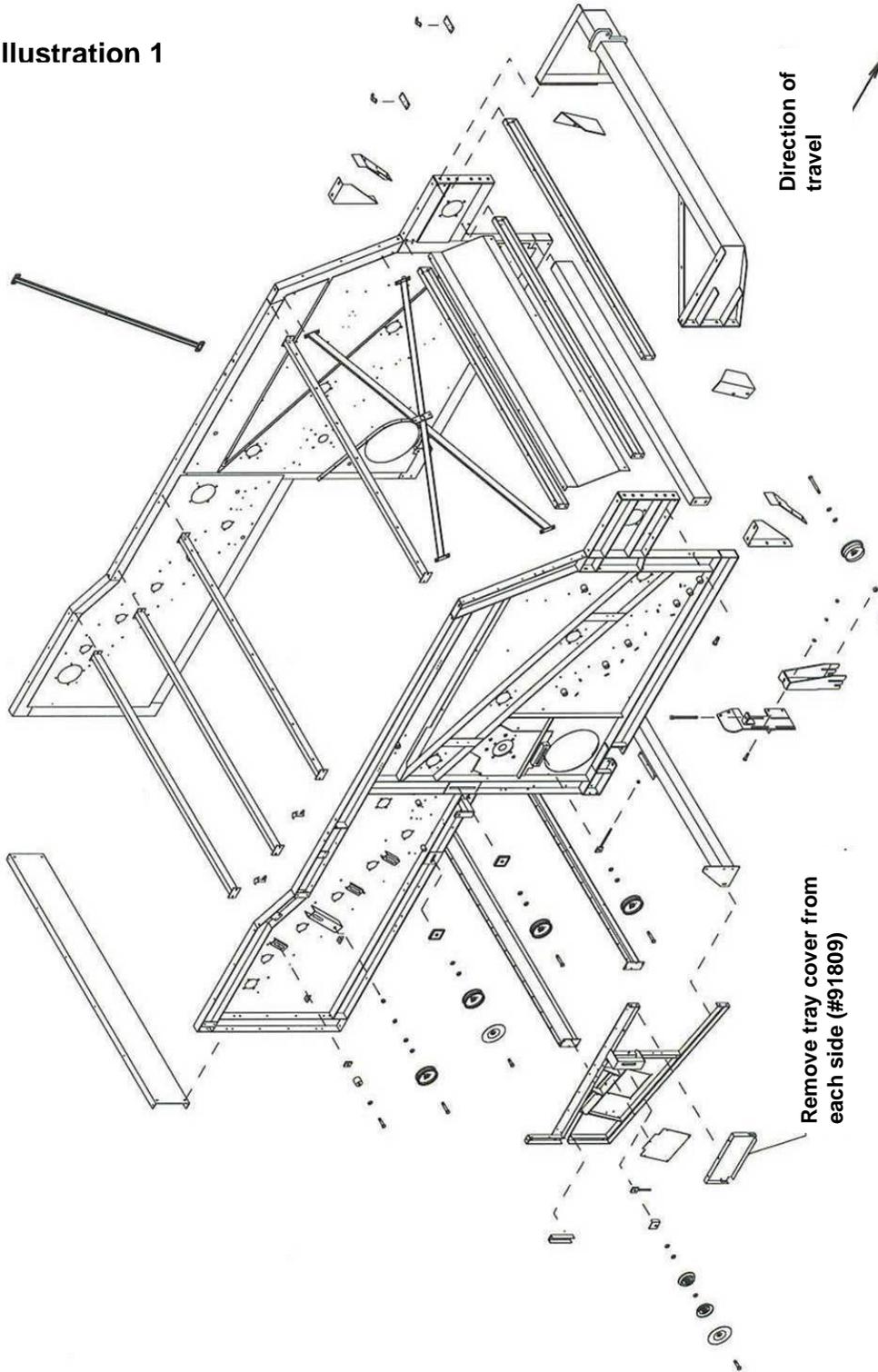
- Disconnect the PTO from the tractor to the combine.
2. Using a 20-ton minimum jack or other suitable lifting device, raise the combine so that the wheels clear the ground.
 3. Place blocks beneath the combine. Pay close attention to the position of the blocks relative to the combine tongue. If the blocks are not positioned properly, the combine could become unstable.
 4. Once you are satisfied that the combine is safely blocked, remove the wheels.

Remove the 12-Blade Fan

1. Remove the Tray Cover Panel (part #91809) (see *Illustration 1*) from

each side. This allows you to access the Lower Fan Discharge Panel or "A" board (part # 122543).

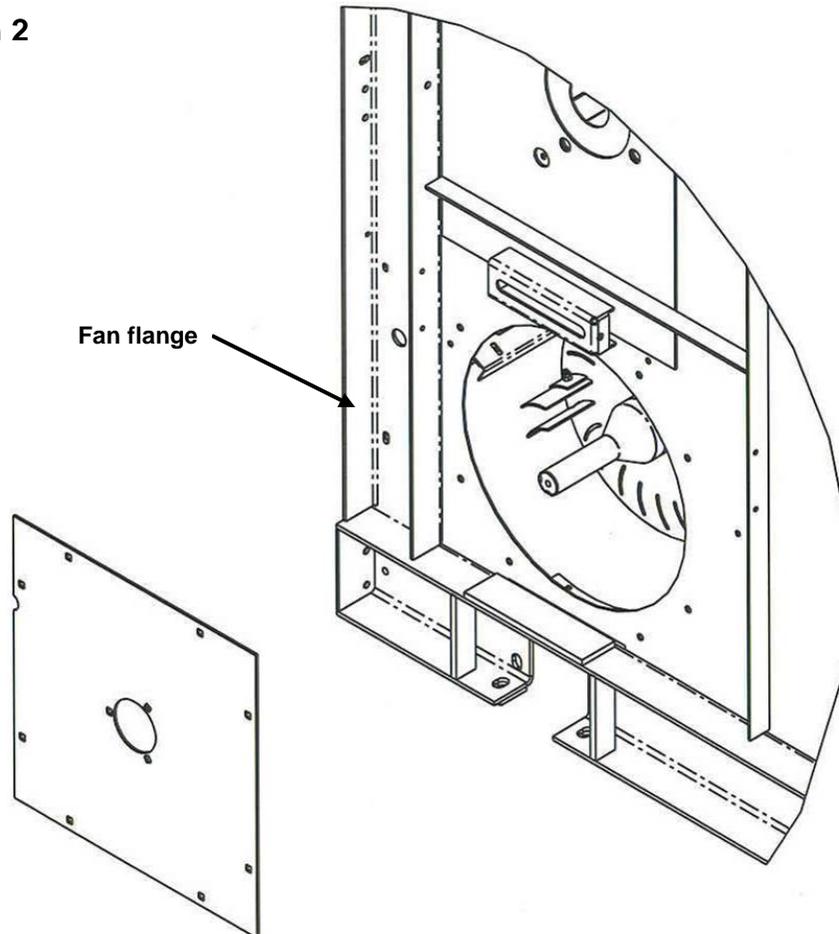
Illustration 1



2. Remove the sheave, bushings, bearings and Fan Flange (part #122503) from the sides of the combine to release the fan assembly

(see *Illustration 2*). Take care not to drop or lose bolts.

Illustration 2



3. Remove the fan. An approximately 2 ft. long pipe that fits on the shaft may be used to lift and pull the fan out of one side of the combine.
4. Clear any debris out of the empty fan cavity.

space is very tight. If not possible, double check the blocks for stability and enter the combine from underneath.

2. Attach part #123788 to the front lower lip of the "A" board. Drill if necessary. Leave 3/16" from the edge of the bend (see *Illustrations 3 and 4*).

Install the 24-Blade Fan and Air Strippers

1. Enter combine through hole left by fan removal. Keep in mind the

Illustration 3

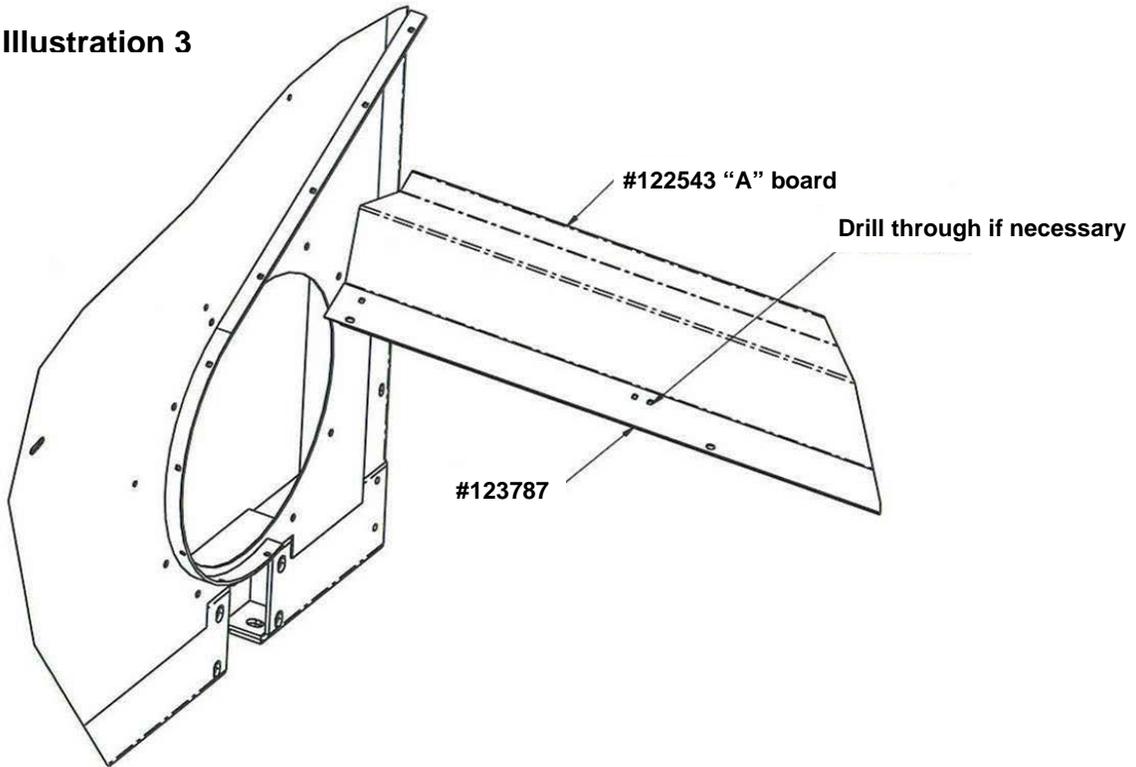
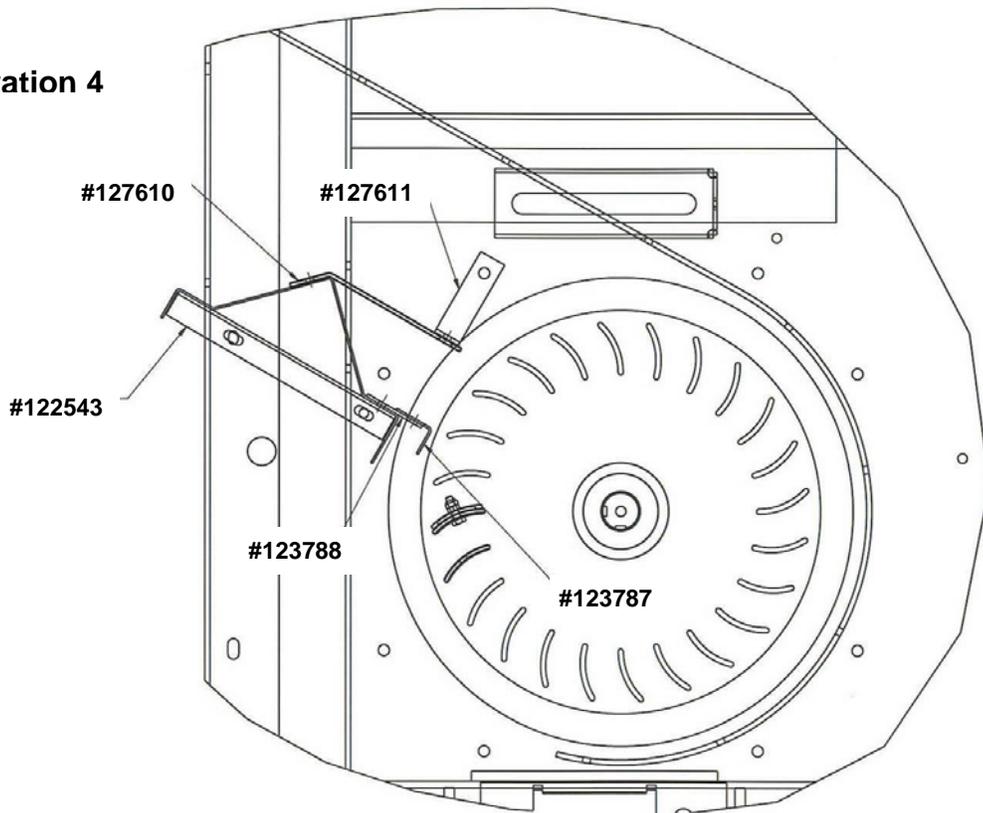


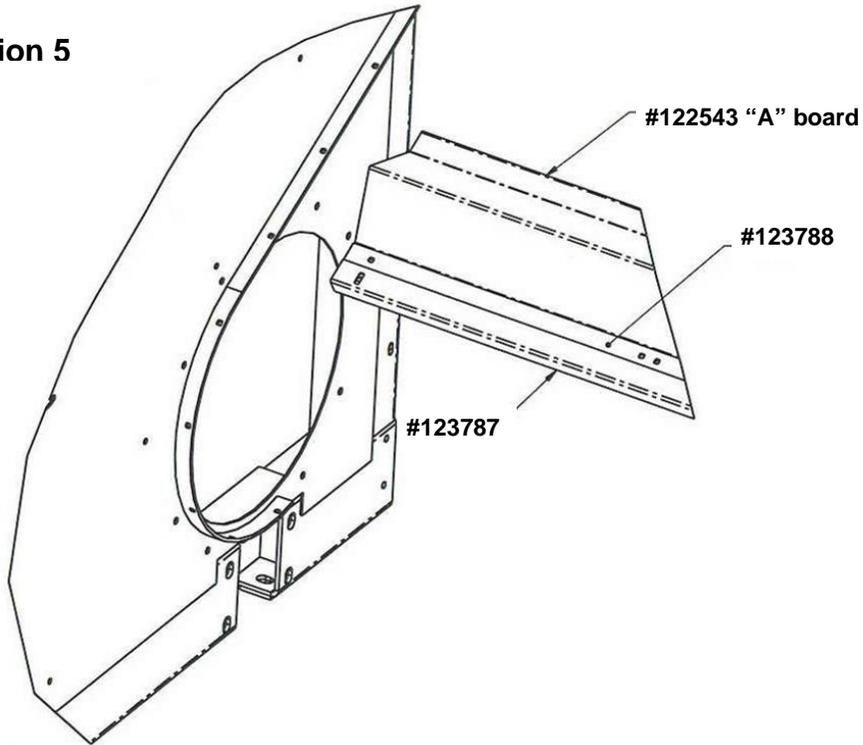
Illustration 4



3. Attach part #123787 to the lower edge of part #123788 (See

Illustration 4 on the previous page and *Illustration 5* below.)

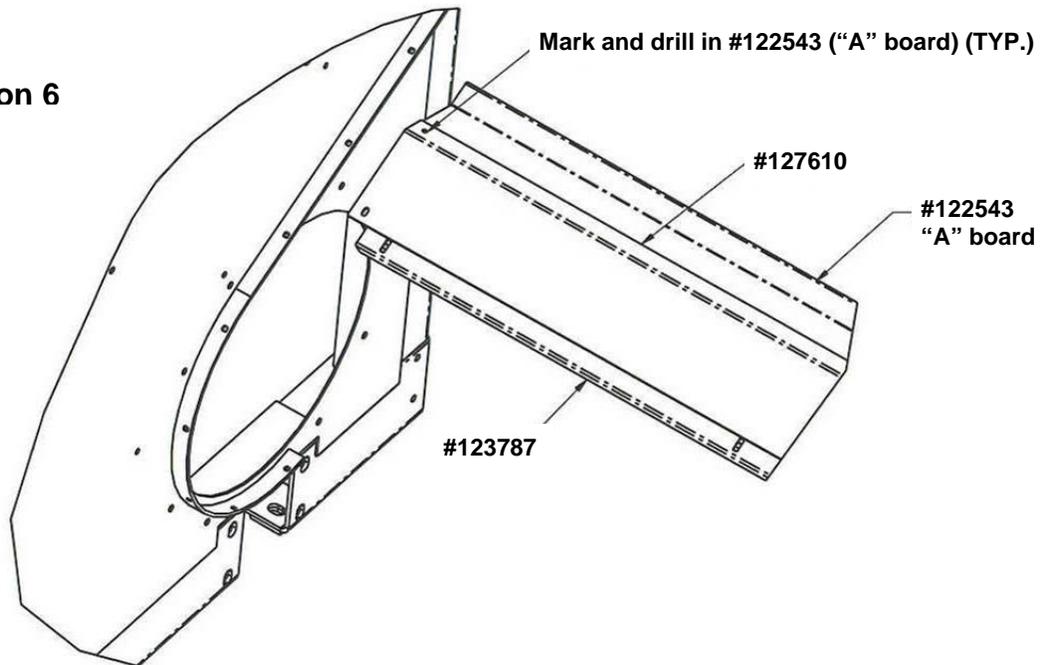
Illustration 5



4. Mark and drill holes in the "A" board. Attach part #127610 to the upper

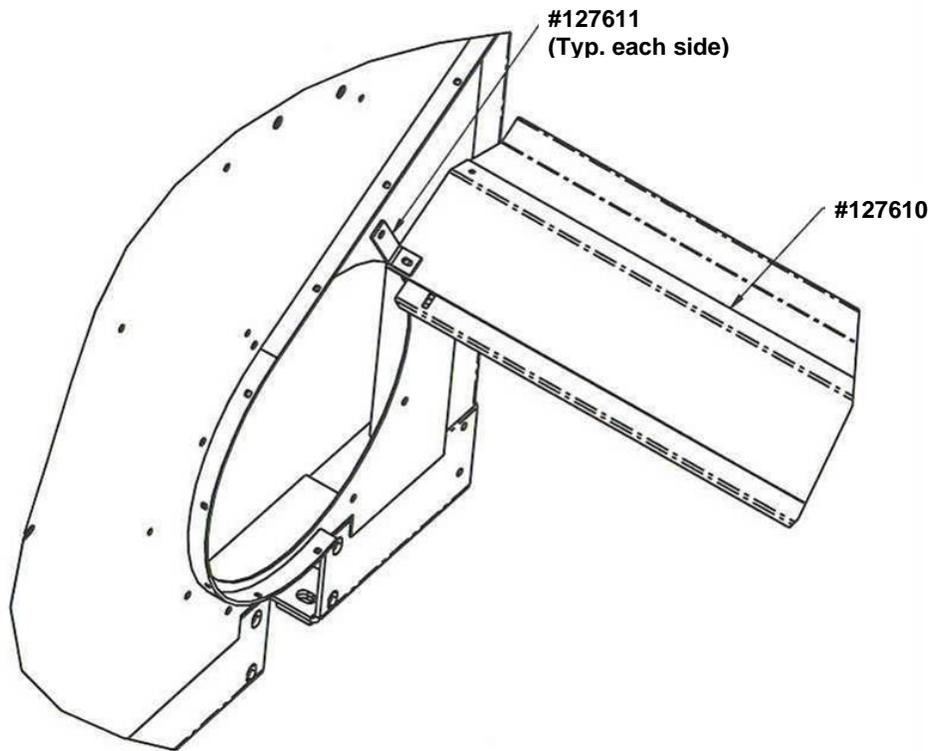
rear peak of the "A" board (see *Illustrations 4* and *6*).

Illustration 6



5. Attach one part #127611 to each end of part #127610 in the existing holes (see *Illustrations 4 and 7*).

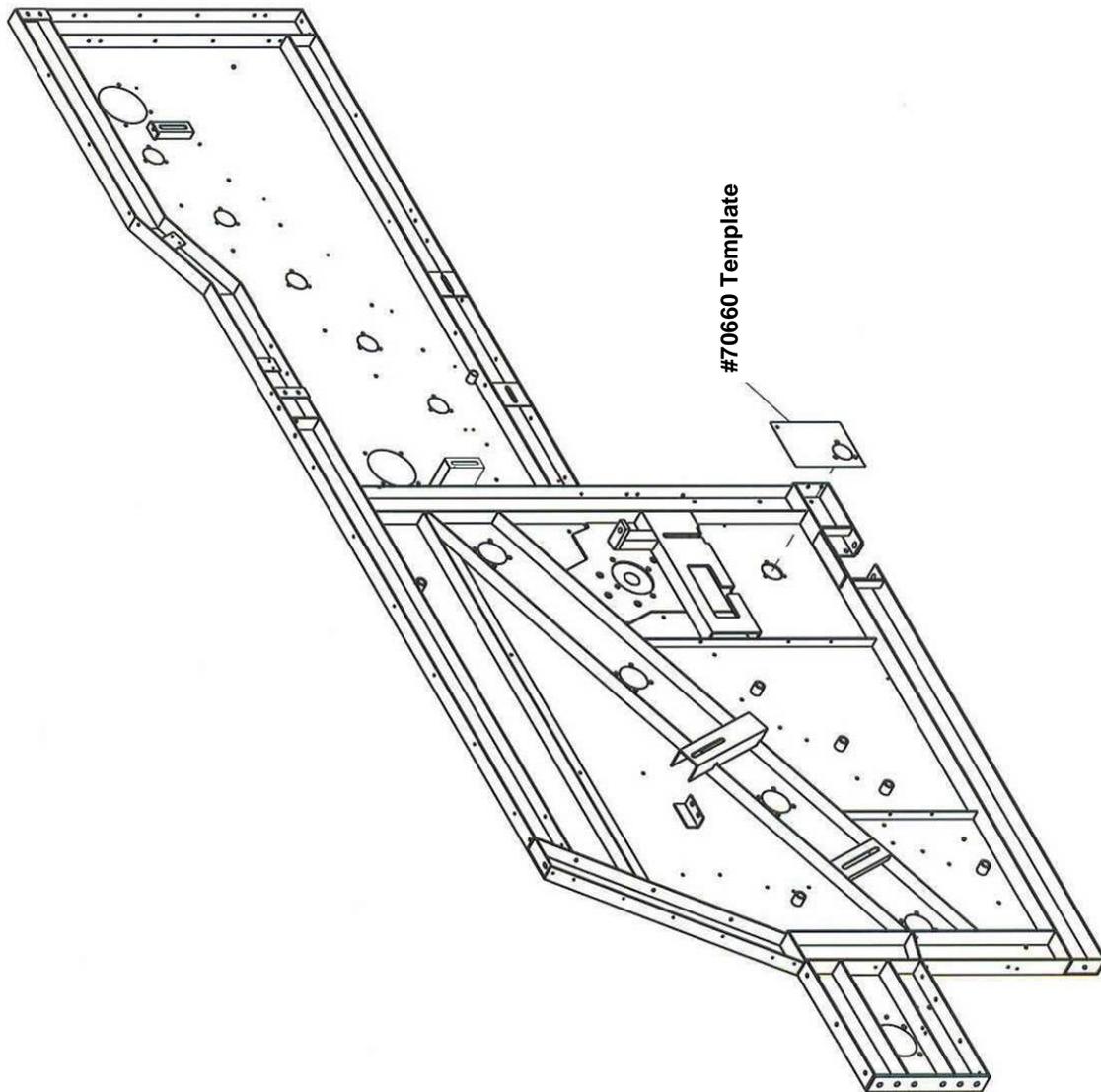
Illustration 7



- Using the existing hole in the right side of the combine, attach the uppermost portion of part #127611. If necessary, use template

#70660 template to drill a $\frac{13}{32}$ " diameter hole in the left side of the combine (*Illustration 8*).

Illustration 8



7. Place the new fan assembly in the combine. Pay close attention to the direction of the fan rotation (see *Illustration 4*).
 8. Replace the fan flanges, bearings, and bushings. After the bearings are in place, center the fan across the combine.
- NOTES:**

 - Upper bolts in the fan flange are difficult to replace. It may require the use of a mechanical retrieval/positioning tool (Mechanical Fingers) to hold the bolts in place while being reattached.
 - Use Antiseize Lubricant on the shaft before replacing the bearings.
9. Spin the fan to check clearance.
 10. Lock collars in the direction that the fan turns – towards the rear of the combine.

Complete the Installation

1. Replace the sheave on the right side and replace the belt.
2. Replace the Tray Cover Panels.
3. Replace the wheels.

NOTE: Following the specifications on the decal located above the wheel on the right side of the combine, tighten the wheel nuts to the appropriate torque.

4. Using a 20-ton minimum jack or other suitable lifting device, raise the

combine just enough to remove the blocks supporting the combine.

5. Once the blocks are removed, lower the combine.
6. Reconnect the tractor to the PTO. Make sure that all safety features are in place
7. Restart the combine as follows:
 - Clear everyone away from the combine.
 - With a helper to assist you, engage the PTO shaft at a low RPM.
 - Observe the combine. If the combine is operating improperly or making unusual noises, shut the machine off immediately and make all necessary adjustments.

 **WARNING!**

Do **NOT** continue running the combine if it is not operating properly or making unusual noises. To do so can cause serious damage to the machine or injury to personnel.

8. When the combine is operating properly, tow over rough ground at slow speeds then recheck the torque on the wheel nuts. Make any necessary adjustments.