SOP Name/Title:			
A9990 Shaker Arm or Peg Replacement			
Document Storage Location/Source:			SOP Document No.
R:\Standard Operating Procedures\Engineering\Published			SOP-ENG-00096
SOP Originator:	Jacob Handy		Effective Date:
Supervisor Approval:	Jonathan Graham		4/3/2025
Date Approved:	Last Edited By:	Last Edited Date:	Revision:
	Jacob Handy		-

1. **Purpose:**

   To assist the proper reassembly of the shaker arm and peg system post failure and reduce early repeat failures

2. **Scope:**

   Field service, engineering

3. **Responsibilities:**

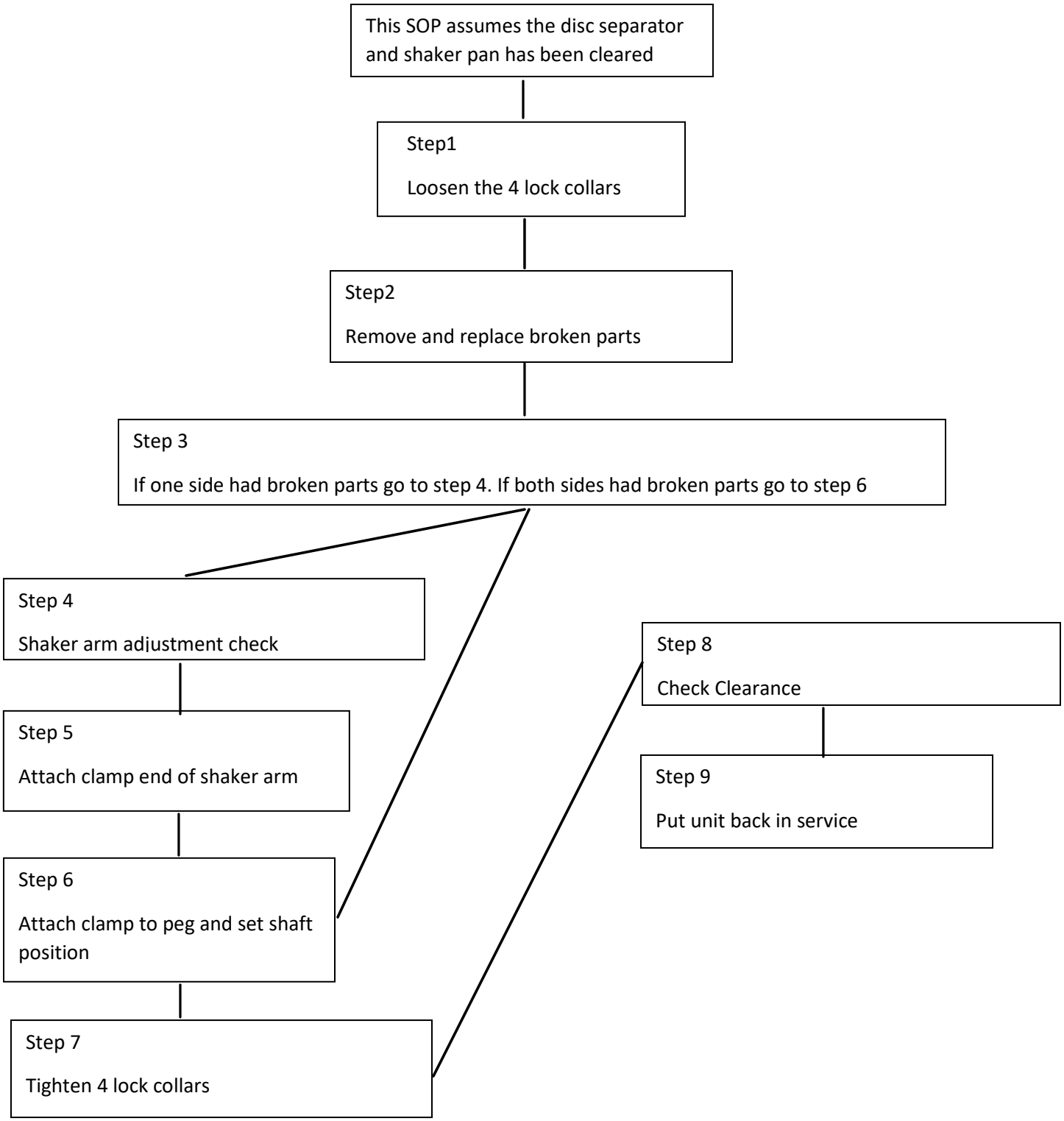
   Service manager, Engineering manager

4. **Materials/Equipment/Access:**

   1. List what is needed to complete this SOP.

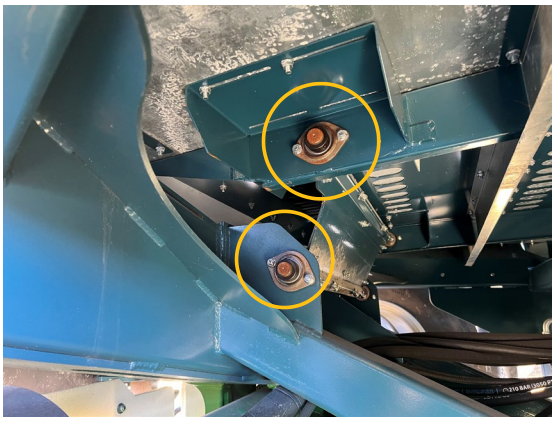
5. **Process:**

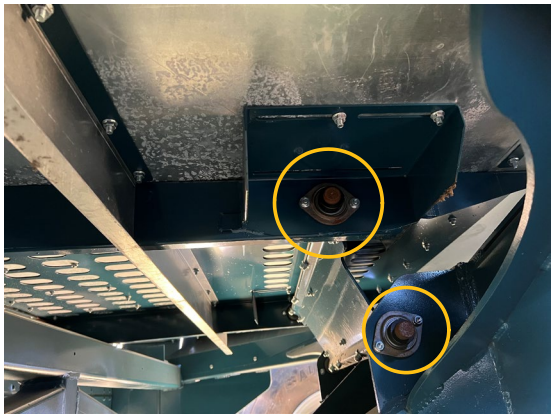
Shaker Arm or Peg replacement



Step 1

Loosen and inspect the 4 lock collars and bearings under shaker pan.

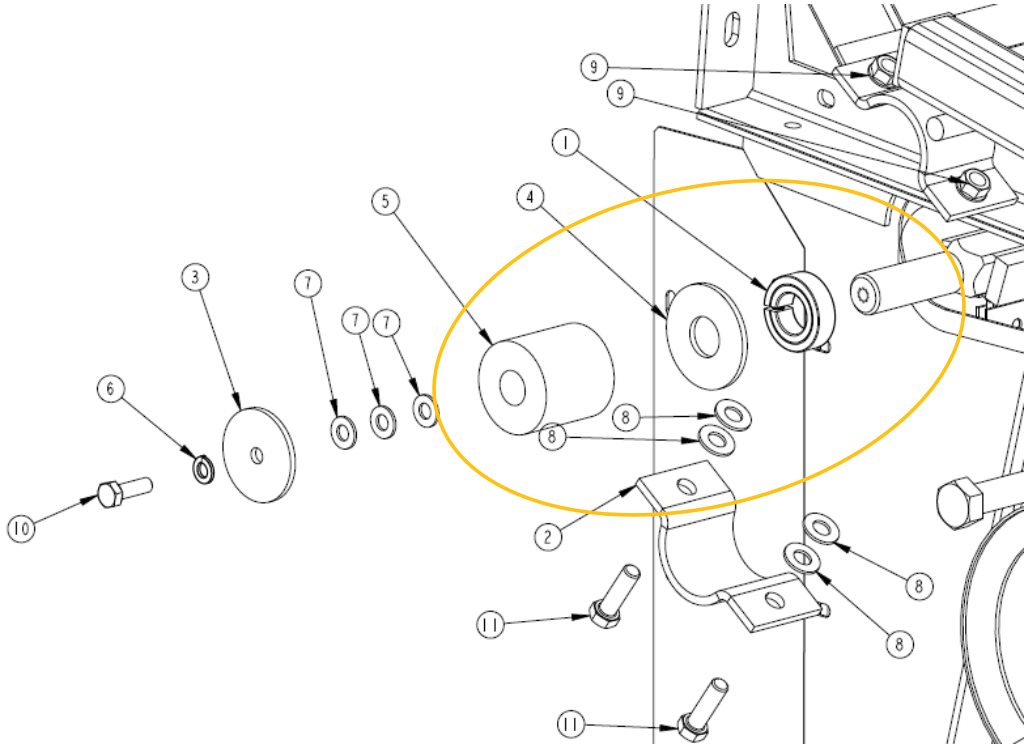




Go to step 2

Step 2

If broken, remove and replace stemmer peg in shaker pan. If arm is broken remove it and inspect stemmer peg for cracks. Ensure that the correct hardware is installed on the peg up to the rubber isolator.



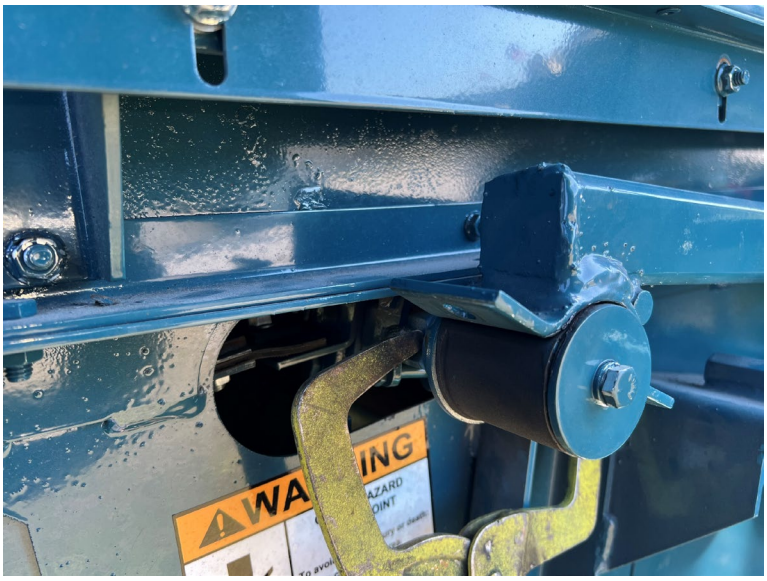
Go to step 3

Step 3

If only one side had broken parts go to step 4 If both sides had broken parts go to step 6

Step4

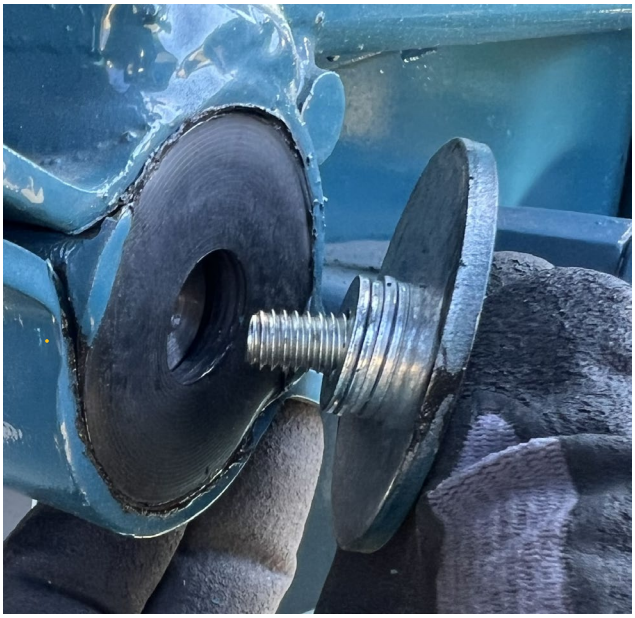
Check the adjustment of the shaker arm. Remove the bearing end bolt if not already removed. Place the clamp end of the arm on the rubber isolator. Check if the bearing end bolt will go into the hole without forcing it to do so. If the bolt threads in, tighten the bearing end bolt. If the bolt doesn't line up with the hole, the arm must be adjusted. To adjust, loosen the bearing end jamb nut and adjust bearing end in or out until the hole lines up with the bearing end.



Go to step 5

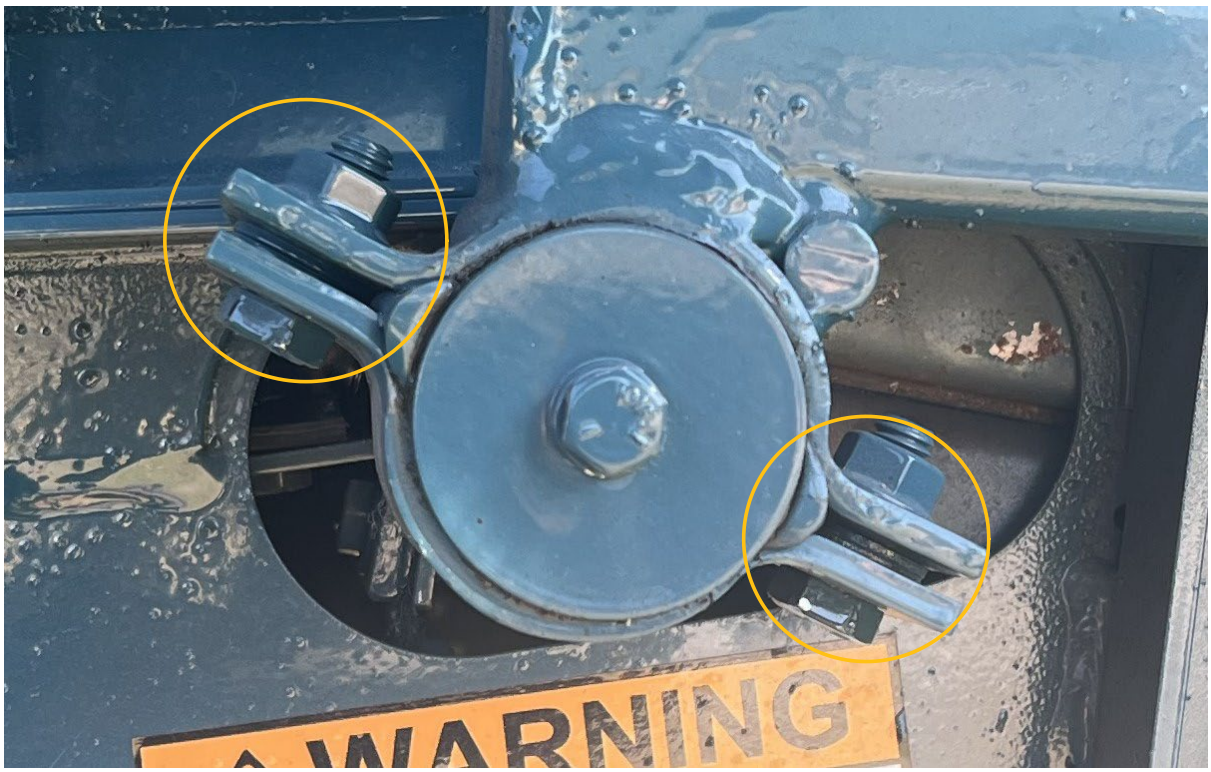
Step 5

Now that the arm has been adjusted and tightened on the bearing end, attach the shaker arm to the stemmer peg. Install the outside 5/16th bolt with the lock washer, big fender washer, and 3 5/16th flat washers



Step 5 cont.

Install bottom half of clamp around rubber isolator with the two 3/8th bolts and the two flat washers between the clamps



Go to step 7

Step 6

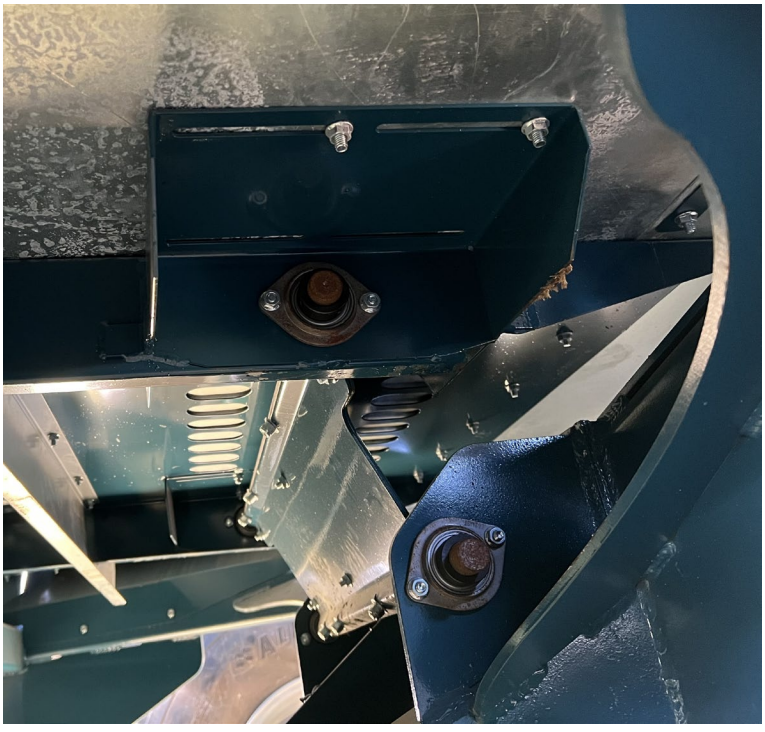
Rotate bearing end shaft so that the hole is in its furthest forward travel

Clamp the pegs to the chassis of the combine with ¾ in. keystock or similar

Go to steps 4, 5, 7

Step 7

Tighten the 4 lock collars under the shaker pan



Step 8

If used, remove the welding clamps from the stemmer peg. Manually rotate the combine a complete revolution to insure clearance between the arm and peg assembly from the chassis.

Go to step 9

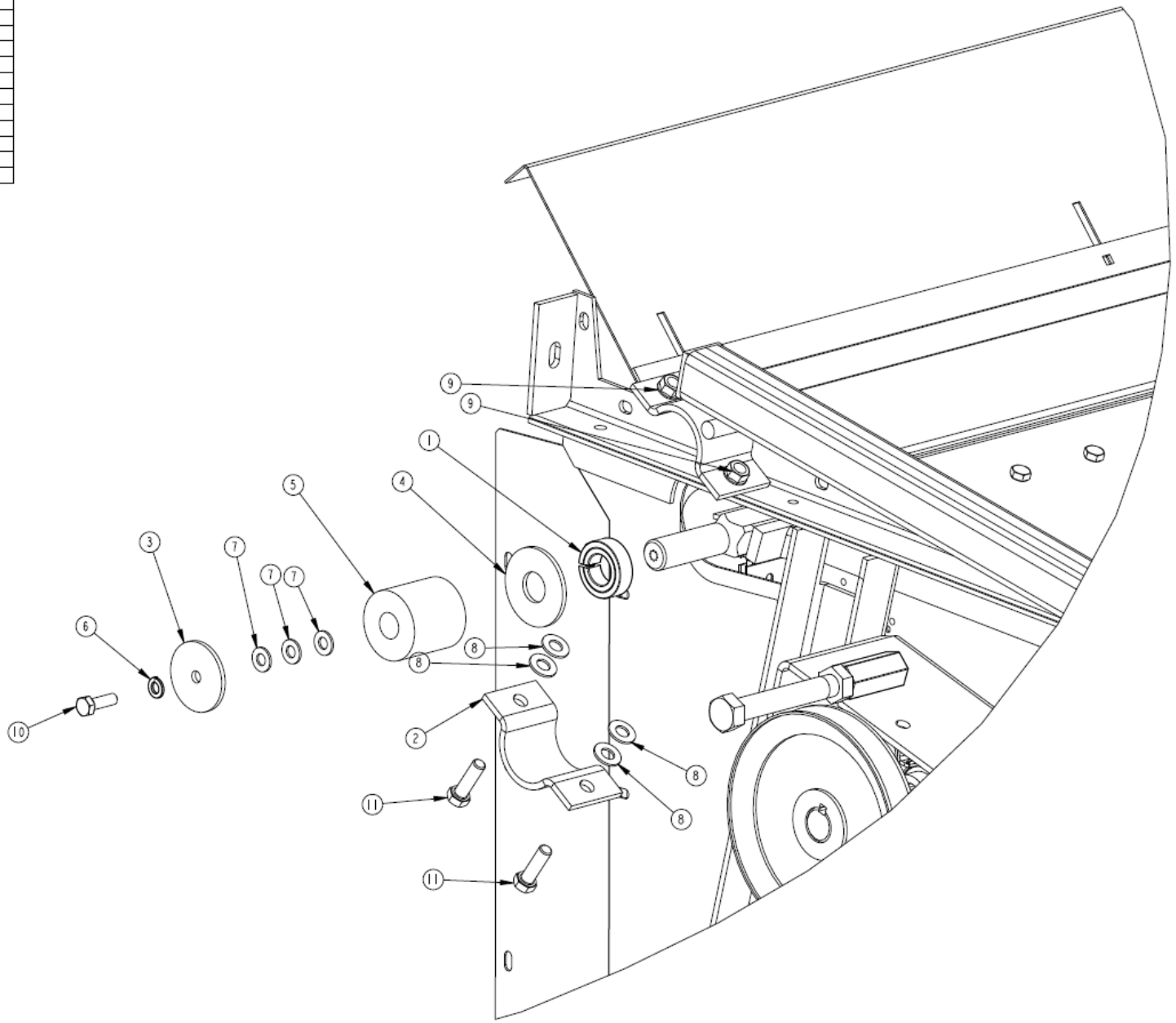
Step 9

Put unit back in service

SHAKER_ARM_PEG_ASSY

BILL OF MATERIALS

ITEM	PART NUMBER	QTY
1	3351	2
2	6677	2
3	126741	2
4	1202794	2
5	4283EP	2
6	G120214	2
7	G120393	6
8	G120394	8
9	G128002	4
10	G180080	2
11	G180124	4



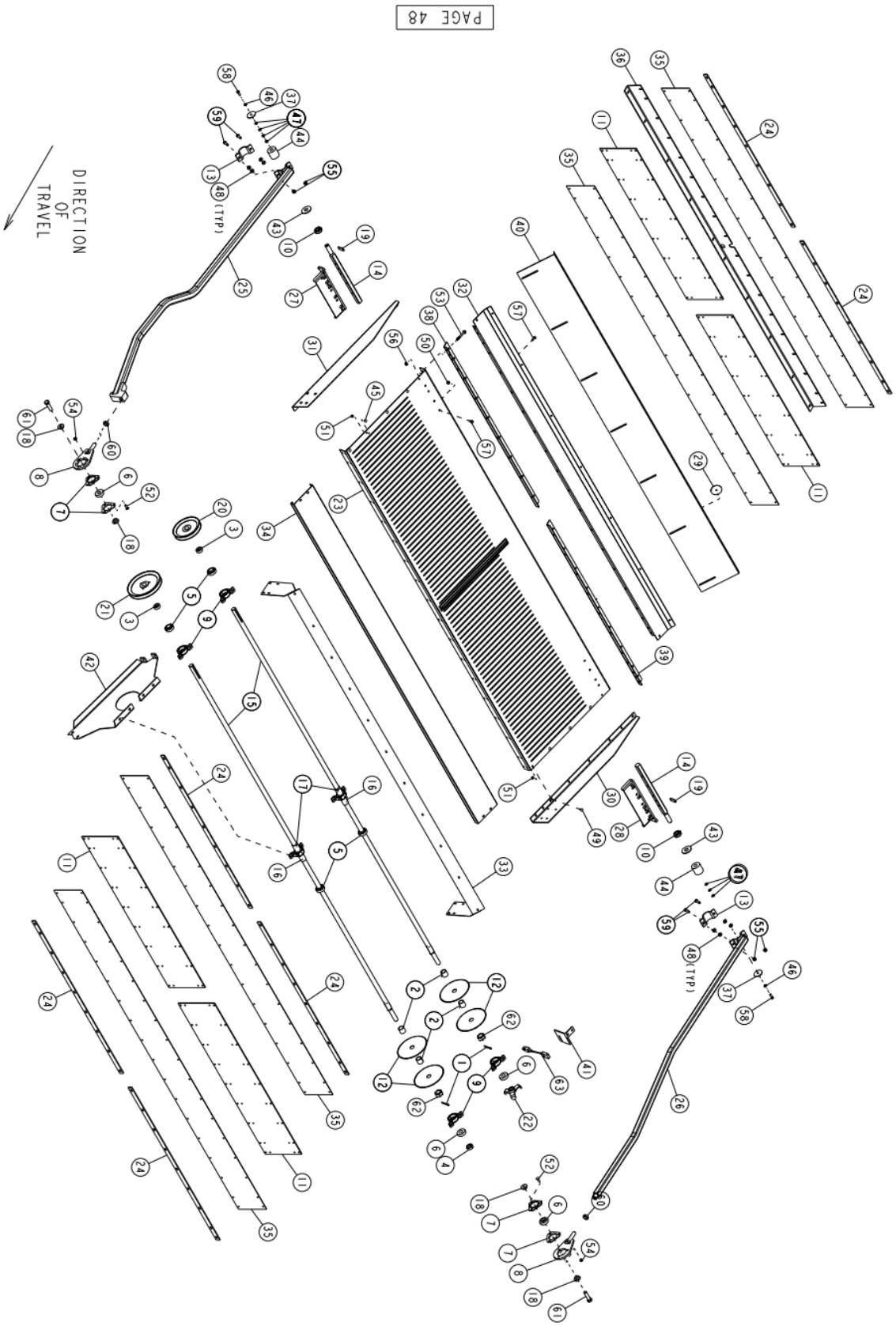
SCALE 0.500

SCALE 0.032		REVISIONS	BY	DATE
DATE 2024-04-02				
DRAWN BY STL				
DESIGN BY				

AMADAS INDUSTRIES

TOLERANCE ±.59° OR .001" UNLESS OTHERWISE NOTED

ROUTING ASSY	WEIGHT 820.740 LBS	PAINT:
TITLE		SHAKER_ARM_PEG_ASSY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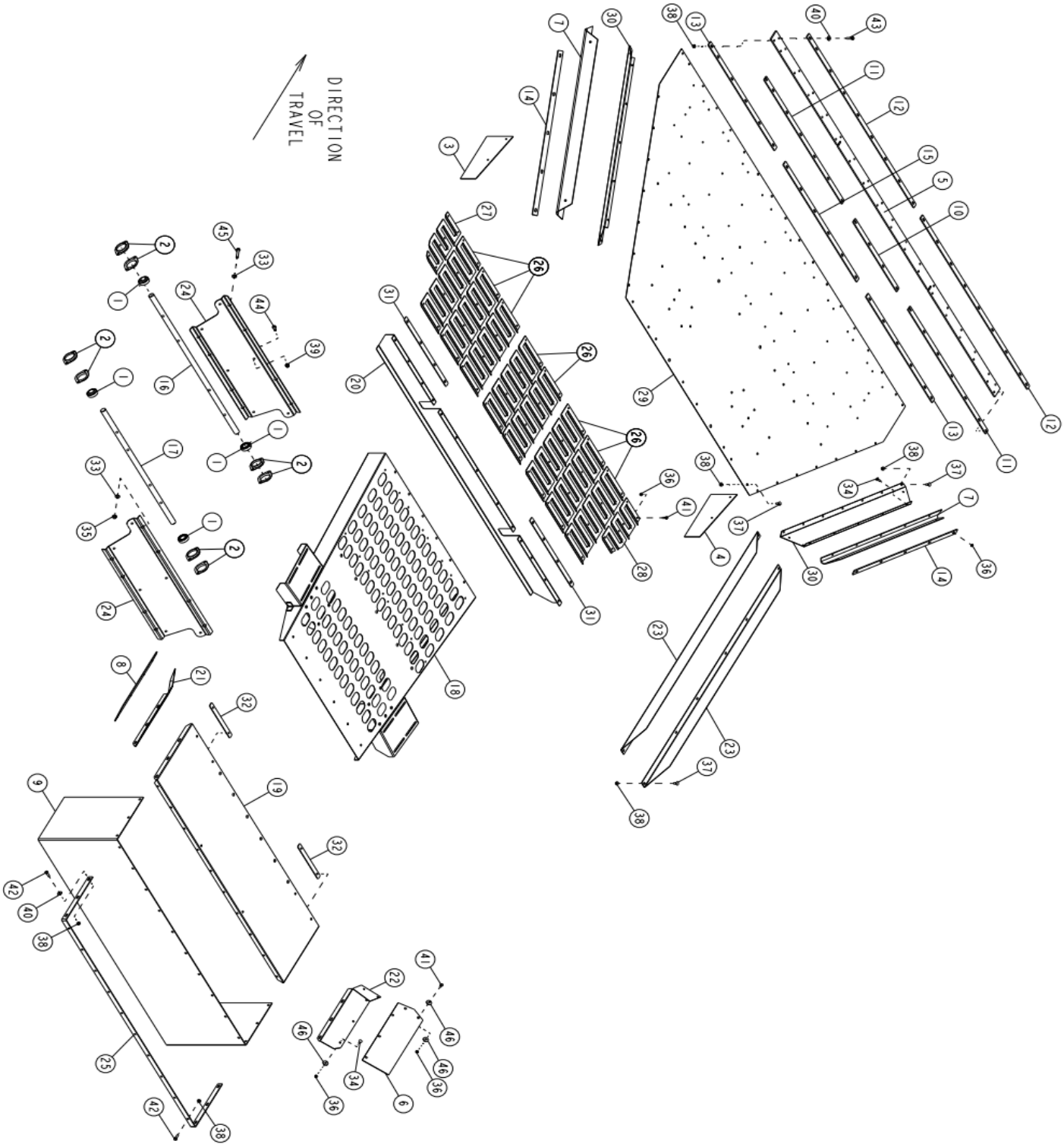
DIRECTION OF TRAVEL
48 (TYP)

STEMMER/SHAKER ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY SHOWN	QTY REQ'D	COMMENTS
1	2193	PIN, COTTER 3/16 X 1-3/4	2		
2	2797	SPACER, 1.215 LONG	4	148	
3	3030	COLLAR, 2-3/16 ECCENTRIC LOCKING	2	A/R	INCLUDED WITH BEARING
4	3074	COLLAR, 7/8 ECCENTRIC LOCKING	1	A/R	INCLUDED WITH BEARING
5	3095	INSERT, 1" SPHERICAL NON-RELUB.	4		
6	3102	INSERT, 7/8 REPLACEMENT BEARING	4		
7	3165	FLANGETTE, 52MM 3-HOLE; TRIANGULAR	4		
8	3282	MOUNT, SHAKER ARM BEARING; HD	2		
9	3288	MOUNT, BEARING 1" PB	6		
10	3351	COLLAR, 7/8" ID SPLIT LOCKING	2		
11	4840	BELTING, SHAKER/STEMMER STRIP	4		
12	5150	BLADE, 72 TOOTH STEMMER SAW	4	152	
13	6677	CLAMP, LARGE GROMMET	2		
14	10641	PEG,STEMMER BOTTOM; 1"	2		
15	10642	SHAFT, STEMMER SAW	2		
16	20130	SPACER, 2.196 LG (STEMMER SAW)	2		
17	20131	SPACER, 1.945 LG (STEMMER SAW)	2		
18	20187	BUSHING, 7/8 BEARING TO 5/8	4		
19	21333	CLAMP, SHAKER PAN PEG	2		
20	51392	PULLEY, 1B X 6.5 OD X 1" BORE	1		
21	51393	PULLEY, 1B X 8.0 OD X 1" BORE	1		
22	51993	TARGET, TONE WHEEL 3	1		
23	63525	SLIDE, STEMMER SAW BOTTOM	1		
24	92792	CLAMP, BELTING; 48-1/2 LG	6		
25	96277	ARM, STEMMER PITTMAN; RIGHT; HD	1		
26	97514	ARM, STEMMER PITTMAN; LH; HYB	1		
27	97603	PEG, STEMMER PIVOT; RIGHT	1		
28	97604	PEG, STEMMER PIVOT; LEFT	1		
29	123976	WASHER, TAIL BOARD	1	7	
30	124189	STIFFENER, STEMMER PLATE; LEFT	1		
31	124191	STIFFENER, STEMMER PLATE; RIGHT	1		
32	124209	PLATE, SLIDER PAN REAR LIP MOUNT	1		
33	124216	MOUNT, AIR DEFLECTOR PLATE	1		
34	124221	PLATE, STEMMER EXTENSION	1		
35	124222	PLATE, BELTING	4		
36	124690	CLAMP, REAR STEMMER	1		
37	126741	WASHER, GROMMET	2		
38	129375	MOUNT, REAR SHAKER PAN HINGE; RT	1		
39	129376	MOUNT, REAR SHAKER PAN HINGE; LEFT	1		
40	1200846	PLATE, ADJUSTABLE SLIDER PAN	1		
41	1201771	MOUNT,SPEED SENSOR	1		
42	1201775	MOUNT. STEMMER SAW BEARING	1		
43	1202794	WASHER, GROMMET	2		
44	4283EP	GROMMET, 2 OD X 3/4 ID X 2 LG; EP688	2		
45	G110357	BOLT, 1/4-20 X 3/4 CARRIAGE	6	A/R	
46	G120214	LOCKWASHER, 5/16	2		
47	G120393	WASHER, 5/16 SAE FLAT	7	A/R	
48	G120394	WASHER, 3/8 SAE FLAT	8		
49	G120522	BOLT, 1/4-20 X 3/4 CARRIAGE	2	A/R	
50	G124822	NUT, 5/16-18 LOCK FLANGE (STOVER)	1	A/R	
51	G126178	NUT,1/4-20 SERRATED FLANGE	8	A/R	
52	G126358	BOLT, 5/16-18 X 1 CARRIAGE; GRADE 5	2	A/R	
53	G126374	SCREW, 5/16-18 X 2-1/2 GR8 FLNGE	1		
54	G128001	NUT, 5/16-18 SERRATED FLANGE	2	A/R	
55	G128002	NUT, 3/8-16 SERRATED FLANGE	4		
56	G128007	NUT, 5/16-18 GRD 8 FLANGE	1	A/R	
57	G180077-8	SCREW, 5/16-18 X 3/4 USS CAP, GRADE 8	2	A/R	
58	G180080	SCREW, 5/16-18 X 1 USS CAP, GRADE 8	2		
59	G180124	SCREW, 3/8-16 X 1-1/4 USS CAP	4		
60	G219758-8	NUT, 3/4-16 SAE JAM, GR 8	2		
61	G271751	SCREW, 5/8-18 X 2-1/4 SAE CAP; GRADE 8	2		
62	G272324	NUT, 1-14 SAE HEX CASTLE	2		
63	JAH221249	SENSOR, SPEED & PROX	1		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