Dear Customer,

The following is some useful information provided to help ensure efficient and safe operation of this corn head.

This manual gives some information regarding the C-series corn heads.

**Read this manual** carefully to learn how to operate and service your machine correctly. Failure to do so could result in personal injury or equipment damage.

**This manual should be considered** a permanent part of your machine and should remain with the machine when you sell it.

**Since the corn head can be mounted to many models of combines,** carefully read your combine specifications and follow the combine manufacturer’s recommendations for usage, set-up and operation of the combine.
# TABLE OF CONTENTS

## 1. SAFETY

1.1 Recognize Safety Information .................................................. 6
1.2 Safety Label Meanings .......................................................... 7

## 2. OPERATION AND FUNCTION

## 3. IDENTIFICATION AND SPECIFICATIONS

3.1. Identification ........................................................................ 17
3.2. Specifications ....................................................................... 18
   3.2.1. Dimensions .................................................................. 18
   3.2.2. Gearbox Lubricant: EP-00 (liquid) grease, and SAE 80W-140 standard lubricating oil .......... 18
   3.2.3. Pitch of the gathering auger: 560 mm (22") ................................................................. 18
   3.2.4. Input shaft speed of the snapping unit drive: 550 rpm ......................................................... 18
   3.2.5. Length of chopped stalk: average 50 mm, depending on crop conditions ........................................ 19
   3.2.6. Adjustment of the snapping plate: central in-cab control switch ........................................ 19
   3.2.7. Available row spacing: 20” – 22” – 30” (50.8 cm – 56 cm – 76.2 cm) with addition of specified snouts and dividers. ................................................................. 19

## 4. SHIPPING CONDITIONS

## 5. MOUNTING THE CORN HEAD ON THE COMBINE

5.1. Mounting the Corn Heads on the Combine ........................................ 22
   5.1.1. John Deere 60, 70 and s series ............................................ 22
   5.1.2. Case IH 1000-2000 .......................................................... 23
   5.1.3. CIH Flagship & Legacy: NH CR & CX; similarly MF 9000, & 9500 Series; R55/65/75, R66/76, & S Series ................................................................. 23
   5.1.4. MF 8500 Series .............................................................. 24
   5.1.5. Claas Lexion 500, 600 and 700 series ................................. 24
   5.2. Other steps following the securing of the adapter on the combine .......... 25

## 6. RUN-IN PROCEDURE ................................................................. 30

## 7. SETUP PROCEDURE AND ADJUSTMENT OF THE CORN HEAD

7.1. Frame ................................................................................. 31
7.2. Auger ................................................................................ 32
    7.3. Timings of the auger: ......................................................... 33
7.3. Input Gearbox Drive .............................................................. 35
    7.4. Snapping Units ................................................................ 35
       7.4.1. Snapping rolls adjustment ............................................. 36
       7.4.1.1. Distance between snapping roll shafts ....................... 36
       7.4.1.2. Labyrinth ................................................................ 36
       7.4.2. Snapping plate adjustment ........................................... 37
       7.4.3. Vine knife adjustment .................................................. 39
       7.4.4. Gathering chain adjustment ........................................... 40
       7.4.5. Gearbox timing and backlash adjustment ....................... 41
7.5. Header Drive Shafts ............................................................ 42
TABLE OF CONTENTS

7.6. CLEARANCE LIGHTS ........................................................................................................................................... 42
7.7. PLASTIC SNOT ADJUSTMENT .......................................................................................................................... 43

8. HARVESTING ........................................................................................................................................................ 44
  8.1. STALK CHOPPER ............................................................................................................................................ 45

9. ROW SPACING ADJUSTMENT ............................................................................................................................... 46

10. MOUNTING TO ANOTHER TYPE OF COMBINE ................................................................................................. 46

11. MAINTENANCE AND LUBRICATION .................................................................................................................. 47
  11.1. FRAME .......................................................................................................................................................... 47
  11.2. AUGER ........................................................................................................................................................ 47
     11.2.1. Folding corn head - snapping unit connecting clutches ................................................................. 48
     11.2.2. Folding corn head - auger connecting clutches .............................................................................. 48
  11.3. INPUT GEARBOXES ..................................................................................................................................... 49
  11.4. DRIVE COMPONENTS ................................................................................................................................. 50
     11.4.1. U-joint shafts: ....................................................................................................................................... 50
     11.4.2. Chain couplings ................................................................................................................................... 50
  11.5. SNAPPING UNIT .......................................................................................................................................... 51
     11.5.1. Gearboxes ............................................................................................................................................ 51
     11.5.2. Snapping roll....................................................................................................................................... 54
     11.5.3. Gathering chain .................................................................................................................................. 55

12. ELECTRICAL SCHEMATICS ............................................................................................................................... 56
  12.1. JD ELECTRICAL SCHEMATIC .................................................................................................................... 56
  12.2. CNH ELECTRICAL SCHEMATIC ................................................................................................................ 57
  12.3. AGCO ELECTRICAL SCHEMATIC ............................................................................................................. 58
  13.4. CLAAS LEXION ELECTRICAL SCHEMATIC ............................................................................................ 59
  13.5. CIH 1000 AND 2000 SERIES ...................................................................................................................... 60

14. TROUBLE SHOOTING ......................................................................................................................................... 61
  14.1. A LARGE QUANTITY OF EARS BUILDS UP BETWEEN THE AUGER AND FEEDER .......................... 61
  14.2. IN LAID OR LODGED CORN STALKS, THE STALKS DO NOT FEED PROPERLY INTO THE SNAPPING ROLLS ........................................................................................................................................... 61
  14.3. ROW UNIT BECOMES PLUGGED WHILE HARVESTING LAID OR LODGED CORNSTALKS ............... 61
  14.4. STALKS, GRASS OR WEEDS WRAP ON THE SNAPPING ROLL ......................................................... 61
  14.5. AUGER DOES NOT ROTATE ....................................................................................................................... 61
  14.6. EARS ARE BROKEN OR SPLIT IN THE AUGER ....................................................................................... 61
  14.7. DIFFICULTY IN KEEPING THE CORN HEAD PROPERLY ON THE ROW ................................................ 61

15. OFF-SEASON STORAGE OF YOUR CORN HEAD ............................................................................................. 62

16. WARRANTY, SERVICE, SPARE PARTS ORDERING ............................................................................................ 62

17. LUBRICATION CHART ....................................................................................................................................... 63

18. PRE-DELIVERY & PRE-HARVESTING INSTRUCTIONS ..................................................................................... 65
  18.1 PRE-DELIVERY INSPECTION ....................................................................................................................... 65
  18.1 PRE-HARVESTING INSPECTION .................................................................................................................... 66
1. SAFETY

This is the safety-alert symbol. When you see this symbol on your machine or in this manual carefully read the message that follows, and be alert to the possibility of personal injury or death.

Follow recommended precautions and safe operating procedures.

UNDERSTAND SIGNAL WORDS
A signal word – DANGER, WARNING, or CAUTION – is used with the safety-alert symbol. DANGER identifies the most serious hazards. DANGER or WARNING safety decals are located near specific hazards. General precautions are listed on CAUTION safety decals. CAUTION also calls attention to safety messages in this manual.

FOLLOW SAFETY INSTRUCTIONS
Carefully read all safety messages in this manual and on your machine safety decals. Keep safety decals in good condition. Replace missing or damaged safety decals. Be sure new components and repair parts include current safety decals.
GENERAL SAFETY GUIDELINES

1. **ALLOW ONLY TRAINED AND EXPERIENCED OPERATORS TO OPERATE THIS MACHINE.** Operating this equipment safely requires the full attention of the operator. Do not wear entertainment headphones while operating this machine.
2. **ALWAYS DISENGAGE** header drive, shut off the engine and remove key before service, adjustment, maintenance and lubrication of the corn head.
3. **STAY CLEAR** of the header when it is in operation.
4. **DO NOT OPEN** safety shields or covers while the corn head is running.
5. **ENGAGE** the lock on the feeder lift cylinder before doing any work under or around the corn head.
6. **WORN OR DAMAGED CHOPPER KNIVES** must be replaced before operation of the corn head. Radial clearance between knife and bushing must be properly maintained. See details in this manual.
7. **NEVER** remove the warning labels from the machine. If they become damaged or illegible order replacement parts as shown in the Figures.
8. **NEVER** remove the safety hydraulic valve of the folding corn heads, located on the back of the corn head.
9. **NEVER** close or open the folding corn head when it is in operation.
1. SAFETY DECALS

1.1 Recognize safety information

Carefully read Operator’s Manual before operating the machine. When operating, always observe safety instructions.

WARNING!

This is the safety – alert symbol.

When you see this symbol on your machine or in this manual, be alert to the potential for personal injury. Carefully read all safety messages in this manual and on your machine safety signs, and respect them fully to avoid accidents leading to serious injury or death!

WARNING!

Keep safety signs in good condition. Replace missing or damaged safety signs. Replacement safety signs are available from the manufacturer. It is PROHIBITED to remove safety signs from your machine!

WARNING!

Before installing the machine read the operator’s manual carefully, learn how to operate, control and keep your machine in good condition. Do not let anyone operate it without instruction.

Keep your machine in proper working condition. Unauthorized and non-professional modifications to the machine may impair the function and safety and affect the machine life.
1.2  **Safety label meanings**
The function of the labels is to give, easy to understand safety instructions for those who are staying close to the machine, in order to minimize the risk of accidents. It is therefore important that these labels always be easy to read, and in complete condition.

a. Before beginning any maintenance or lubricating, stop the engine of the combine and remove the key!

b. If you stop the combine while the header is lifted, secure the loose working cylinder with the help of the device - dive inhibitor - fixed to the hydraulic working cylinder of the combine to avoid the accidental crash of the header.

c. Always stay clear of moving elements during operation!
   Always disengage header drive, shut off the engine and remove key before servicing or unclogging header.

d. Always keep your distance from the rotating parts of the machine. The header’s snapping rolls and other moving parts can’t be covered completely due to their functions. Do not feed crop material into machine by hand or attempt to manually unplug machine while it is running. The stalk rolls can feed the crop material in faster than you can release your grip on it. To avoid personal injury or mortal accident always stop engine before unclogging.
e. Never attempt to open or remove shield while the engine is running. Keep every shield in its place. Avoid direct contact of your hand, leg, any part of your body or cloth with rotating, moving machine parts, elements! Before approaching any moving parts wait for them to completely stop!

f. Avoid bruise!
   The loose and non-fixed header can unexpectedly crash down, so stay away from loose and non-fixed machine!

gh. If the engine is still operating, the combine can accidentally start. Never step between the header and the combine if the engine is not shut off!

h. Machines equipped with chopper are more dangerous because of objects thrown out unexpectedly. Do not stay close to operating machine. Follow the instructions on use and maintenance of chopper knives!

i. When we are talking about foldable machines there’s a possibility that the wing frames can suddenly fold. Do not stay under and around the wing frames!
j. On some types of corn heads you can find high-pressure hydraulic system. In case of a pressurized system, the piping system must not be disturbed or exposed to any external effects of the damage.

k. The drive shaft rotation.

l. To prevent injury from sharp cutting blades: Do NOT operate without shields in place. Disengage power take-off, stop engine and remove key before opening covers. Stop engine and remove key before opening shield. Blades may continue to rotate after power is shut off. Listen and look for evidence of rotation before opening shield.

m. To prevent injury from entanglement with rotating auger: Stand clear of auger while machine is running.

n. Before putting the machine into operation, please remove the screws which fasten the main frame and side frames on both sides at delivery.

o. Lifting points on the lifting bar.
SAFETY

p. Tie-down point locations.

q. Chopper knife covers are marked with safety decals. Do NOT operate without covers in place.

r. Operating the machine with feeder lateral tilt feature enabled may result in damage!

s. QR code label leading to the C-series page.
# LIST OF ACTIVE MACHINE PARTS

<table>
<thead>
<tr>
<th>No.</th>
<th>Active machine part</th>
<th>Danger</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Snapping units, gathering chains</td>
<td>Snatch, entanglement</td>
</tr>
<tr>
<td>2.</td>
<td>Gathering auger</td>
<td>Cutting, entanglement</td>
</tr>
<tr>
<td>3.</td>
<td>Outside shields</td>
<td>Nip, bruise</td>
</tr>
<tr>
<td>4.</td>
<td>Side chain drive</td>
<td>Snatch, entanglement</td>
</tr>
<tr>
<td>5.</td>
<td>Drive shafts</td>
<td>Entanglement</td>
</tr>
<tr>
<td>6.</td>
<td>Inner space between combine and corn head</td>
<td>Crushing</td>
</tr>
<tr>
<td>7.</td>
<td>Stalk chopper</td>
<td>Cutting, impact from unexpected flying objects</td>
</tr>
<tr>
<td>8.</td>
<td>Shields, snouts</td>
<td>Slipping, stumbling</td>
</tr>
<tr>
<td>9.</td>
<td>Lifted machine</td>
<td>Crushing</td>
</tr>
<tr>
<td>10.</td>
<td>Hydraulics</td>
<td>High-pressure fluid injection</td>
</tr>
</tbody>
</table>

![Diagram of active machine parts]
The figure shows the placement of machine safety decals.

Attention! The figure shows only the labels on one side of the header, but in reality the decals must be placed symmetrically on both sides.

Type Numbers:
- C3006C
- C3008
- C3008C
- C3012C
- C3012CF
- C2212C
- C3006
- C2208
- C2208C
- C3008F
- C3008CF
- C2012
- C2012C
- C2212
- C3012
- C3012F
- C3808
- C3808C
Window frame decals:
- AGCO
- CLAAS/LEXION
- JOHN DEERE
- CASE IH
- CNH
- GLEANER RS
- AGCO, IDEAL

Additional decals for the Foldable header!

The view shows the header LH side!

The big arrow should point to the screw fixing the wing.

514.038.0 decal on the lifting bar!
2. **OPERATION AND FUNCTION**

The MacDon corn head can be mounted on most combines. Corn ears are detached from the corn stalks as is shown on the illustration below. The corn stalk enters the area between the snapping rolls (1,2) which counter-rotate relative to each other, and are pulled downwards between the snapping plates (3) by the rolls (1,2). This downward directing action causes the corn ears (5) to impact the snapping plates (3), detaching the ear from the stalk in the process. The detached ears are moved rearward by the gathering chains (6) into the auger trough (7) and are conveyed to the combine feeder house by the cross auger (8). Corn stalks are discharged downward by the snapping rolls (1,2).

If the corn head is equipped with optional stalk chopper, the stalks are chopped into small fragments by this chopper, located under the snapping rolls.

![Illustration of corn head operation](image)

**Attention!**

For safe corn head operation, it is essential to respect the instructions on the use of the corn head when mounted to the combine. Only qualified operators should operate the machine.
Operation
The corn head is driven from the combine feeder shaft through a universal drive shaft or chain shaft coupling. Power is transmitted from the drive shaft by gears encased in an oil bath to a shaft which passes through the snapping unit. Torque limiting clutches transmit power from the shaft to each snapping unit.

The auger is chain driven through a torque limiting clutch from the left side snapping unit drive (or from both sides of large corn heads).

Consider and follow each of the following sequence guidelines before starting operation of the corn head:

- after a sounding horn start the engine of the combine
- after ensuring that no one is close to the corn head and combine, lower the corn head into operation position using the combine “lower” function switch

1. Operate the corn head only in the specified harvesting position
2. Engage the combine feeder drive and begin harvesting.
3. Operate at a ground speed that does not exceed that suitable for the combine and corn head capacity and ground conditions.
4. Perform an emergency stop

During harvesting be aware of unexpected events that may take place requiring immediate shutdown of the forward movement or combine feeder drive.

Such events could be:

- accident
- foreign materials in the crop (irrigation pipe, gas tube, rocks etc.) which could enter the corn head
- excessive crop loading (action of torque limiting clutches)
- clogging or blockage
- other breakdown or fault
The corn head has no specific emergency stop system. The emergency stop is actuated using the combine systems located in the combine cab. Understand and respect the relevant instructions of the combine emergency stop procedures as related to the corn head.

Never leave the combine cab while corn head is in operation.

Non-conforming use:

The corn head is designed only for harvesting in the direction of planting (row dependant) and for the specified row widths. Harvesting performance can greatly deteriorate if the corn head is used in other conditions for which it is not intended. Deterioration in performance can result if:

- The corn head is positioned too high or too low during harvesting
- The corn head is used to harvest crops other than corn.
3. **IDENTIFICATION AND SPECIFICATIONS**

3.1. **Identification**

The universal mounting of the corn head permits it to be attached to specific combine types with the appropriate mounting kit. A mounting kit is assembled to the corn head at the factory as ordered.

A data plate is located on the left side of the corn head upper beam.

The model number refers to the following: for example:

- **C3012** 12-row fixed frame with 30” row spacing
- **C3012C** 12-row fixed frame with 30” row spacing and stalk chopper
- **C3012CF** 12-row folding frame with 30” row spacing and stalk chopper
### 3.2. Specifications

#### 3.2.1. Dimensions

<table>
<thead>
<tr>
<th>Row Spec</th>
<th>Model</th>
<th>Chopper</th>
<th>Weight</th>
<th>Width</th>
<th>Length</th>
<th>Height</th>
<th>Height in shipping condition</th>
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<td></td>
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<td>ft.</td>
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<th>Row Spec</th>
<th>Model</th>
<th>Chopper</th>
<th>Weight</th>
<th>Transport width</th>
<th>Width</th>
<th>Length</th>
<th>Length in shipping condition</th>
<th>Height</th>
<th>Height in shipping condition</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>Kg</td>
<td>Lbs</td>
<td>mm</td>
<td>ft.</td>
<td>(mm)</td>
<td>(mm)</td>
<td>(mm)</td>
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<td>10.6</td>
<td>6135</td>
<td>20.1</td>
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</tbody>
</table>

3.2.2. Gearbox Lubricant: EP-00 (liquid) grease, and SAE 80W-140 standard lubricating oil.

3.2.3. Pitch of the gathering auger: 560 mm (22”).

3.2.4. Input shaft speed of the snapping unit drive: 550 rpm

<table>
<thead>
<tr>
<th>Combine</th>
<th>Backshaft speed</th>
<th>Header Speed</th>
</tr>
</thead>
<tbody>
<tr>
<td>NH fixed drive</td>
<td>575 Range 550</td>
<td>11 tooth 575 12 tooth 402-575 15 tooth 673 18 tooth 405-650</td>
</tr>
<tr>
<td>NH variable drive</td>
<td>402-575 Range 550</td>
<td>-</td>
</tr>
<tr>
<td>AGCO fixed drive</td>
<td>617 Range 825</td>
<td>-</td>
</tr>
<tr>
<td>AGCO variable drive</td>
<td>608-975 Range 825</td>
<td>-</td>
</tr>
<tr>
<td>JD fixed drive</td>
<td>520 Range 688</td>
<td>- 567 416-628</td>
</tr>
<tr>
<td>JD variable drive</td>
<td>520-785 Range 688</td>
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<td>Case-1000-2000 series</td>
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<td>- 545</td>
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<td>Case AFX variable drive</td>
<td>460-690 Range 596</td>
<td>- 460-690</td>
</tr>
<tr>
<td>Lexion fixed drive</td>
<td>761 Range 688</td>
<td>-</td>
</tr>
<tr>
<td>Lexion variable drive</td>
<td>508-737 Range 688</td>
<td>- 406-590</td>
</tr>
</tbody>
</table>
3.2.5. Length of chopped stalk: average 50 mm, depending on crop conditions.

3.2.6. Adjustment of the snapping plate: central in-cab control switch.

3.2.7. Available row spacing: 20” – 22” – 30” – 38” (50.8 cm – 56 cm – 76.2 cm – 96.5 cm) with addition of specified snouts and dividers.
4. SHIPPING CONDITIONS
The corn head is delivered mounted on a shipping skid suitable for handling by forklift. Lifting rings are also provided suitable for overhead lifting.

Ensure that the lifting equipment is adequate for the weight indicated on the serial data plate. The weights of the different headers can be found in section 3.2 as well. When using a forklift under the skid, ensure that the forks are spaced evenly about the centerline of the corn head. Recommended position of the forks is indicated, as shown in the photo below.

When using a crane, the lifting cable is to be attached to the lifting rings on the bar which is attached to the upper end of the snapping units. The lift points are indicated with a label on the bar.

When lifting with a crane, the cables must be long enough such that the angle between them does not exceed 90°. The minimum cable length to meet this requirement is:

- the 12-row fixed and folding frame: 2500 mm (98”)

The cable length should be equal on both sides.
NOTE: Only use a cable with specified capacity that meets the weight of the machine.

max. 90°

When lifting a 12-row corn header use four cables as shown in the photo below.
5. **MOUNTING THE CORN HEAD ON THE COMBINE**

While the corn head is mounted on shipping stand
- Remove the parking stands and snouts from the shipping position and install parking stands in their retracted position
- Carefully lower the corn head to horizontal position with a cable attached to lifting hooks
- Remove the shipping skid after the machine is resting securely in horizontal position

The corn head is shipped from the factory with mounting kit installed as ordered. If the corn head will be mounted to a different combine than ordered, remove the factory installed mounting kit and install the required mounting kit as recommended for your combine with all the specified drive line shielding.

![Warning Symbol]

After the above operation and with the specified mounting kit securely attached to the Corn Head, engage and securely attach the Corn Head to the combine according to Combine Manufacturer’s instructions. Engage the feeder lift cylinder safety stop and secure the lower latches.

5.1. **Mounting the corn head on the combine**

5.1.1 John Deere 60, 70 and S series

Insert the spring pivot pin (2) of the feeder house into the hole of the retainer plate (1) which is assembled on the lower support. If required, adjust the pin alignment.
5.1.2. CASE IH 1000-2000

Adjust the nuts on the U-bolts (1) as required to provide adequate clamping force. Refer to the combine operator’s manual for the correct adjustments and latching methods.

5.1.3. CIH Flagship & Legacy; NH CR & CX; similarly Challenger MF 9000 Series; Gleaner N, A, R, & S Series

Adjust the position of the latch retainer (1) to ensure that the feeder lever is fully engaged. If the proper position is not attainable, change the original arm of the feeder with the arm supplied as an attachment.
5.1.4. MF 8500 Series

Adjust the nuts on the U-bolts (1&2) as required to provide adequate clamping force (3). Refer to the combine Operator’s Manual for the correct adjustments and latching methods.

5.1.5. Claas Lexion 500, 600, 700, 7000, & 8000 series; similarly IDEAL 7, 8, & 9
5.2. Other steps following the securing of the adapter on the combine

**Attach the Snouts**
Place the central snouts onto the rear divider pins (1). For easier mounting, first loosen the rear divider pin which is secured by a hex bolt (2), secure the central snouts from the outside with Torx-head bolts (3) and then tighten the loosened hex bolts. Refer to the parts manual.

Adjust the arm which is used for central snout support (4), to the desired height and then secure it with a hex bolt (5) and a lock nut (6). If finer adjustment is needed, this can be done with a nut in the back (7). The recommended settings can be found at chapter 7.7. The outer snouts are installed in a similar way. The outer LH and RH snout supports are unique and must be installed correctly to properly contact the underside of the snouts.

**Remove the Lifting Bar**
Remove the lifting bar from the snapping unit ONLY after the corn head is properly attached and secured to the combine, and the combine feeder lift cylinder stop is engaged.
**For folding headers only:**
Remove shipping bolt and plate securing each wing to the central frame so header will be allowed to fold.

**Connect Header Drive Shafts**

Connect the drive shafts and ensure that the protective shields are properly in place and that all rotating parts are adequately shielded. The shafts are installed at the factory with protective shielding as supplied by the shaft Manufacturer.
Position the protective shield of the drive shaft, according to the combine operator’s manual, after connecting to the feeder drive shaft.

To prevent the rotation of the header drive shaft shield, attach both original chain restraints to the corn head.

**Connect the electric snapping plate adjuster according to the following figure.**

The plug is connected to pin numbers 1 and 7.
**Connect the hydraulic system (for folding corn heads)**

The hydraulic source is typically the combine reel fore function.

The schematic below illustrates the hydraulic system of the folding corn head.
The folding corn head hydraulic cylinders should operate in the following sequence:

1. The locking cylinders (D1, D2) must retract fully.
2. The rear divider cylinders (B1, B2) must extend fully.
3. The wing cylinders then fold the wings.

If the wing cylinders start before the other cylinders (D1, D2, B1, B2) reach the end positions, then the pressure relief valve adjuster screw should be turned a half turn clockwise. After this, re-attempt folding the header to check for proper operation. Repeat these steps as necessary until the headers folds correctly.
6. **RUN-IN PROCEDURE**

A 30 minute “trial run” is suggested after the initial mounting.

Prior to the trial run, perform a full lubrication procedure as described in Section 11 "Maintenance and Lubrication". Gearboxes are filled with lubricant at the factory but levels should be checked before beginning the trial run.

Start the combine and momentarily engage the drive with the engine speed at low idle. If all sounds well, run the corn head slowly. Avoid starting the drive at high engine speed as the inertia load from acceleration can be 8-10 times more than the load from steady speed operation. High-speed start-up may cause damage to the drive system and safety clutches.

After the slow speed start, increase the engine speed to a medium level and listen for abnormal sounds. If no irregularity is observed, the engine speed can be increased to maximum level for about 10 minutes.

When the trial run has been completed, shut off the engine, remove the key and check the temperature of the gearboxes, bearings and drive units. No irregular overheating should occur.
7. **SETUP PROCEDURE AND ADJUSTMENT OF THE CORN HEAD**

7.1. **Frame**
The corn head is provided with parking stands which must always be used when it is to be disconnected from the combine. Before detaching the corn head from the combine, adjust the parking stand position such that the distance between the ground and the lower support of the corn head is about 30 cm (12 inches).

Adjust the stand position by removing and replacing the retaining pin, and re-installing the hairpin.
7.2. Auger

The auger is driven through a torque-limiting clutch that can disengage excessive loads on the drive. This clutch is located on the left-hand side, but an additional clutch is located on the right hand side on larger corn heads.

In some conditions it may be necessary to change the speed of the auger. The driver sprocket can be reversed to provide an alternate speed to suit field conditions.

- High speed - 16 tooth (factory)
- Low speed - 14 tooth (alternate for lodged corn)

Rigid frame header: for adjusting the auger use the following screws - no. 3 and no. 6.

- Gap between flighting and auger pan at minimum clearance
- Check factory setting 1.0” – 1.25” (25 mm – 32 mm)
- Check clearance at both ends of auger and adjust if necessary
• Augers will come standard from factory with full flighting installed
• Options include fingers and paddles in place of full flighting
• Fingers are recommended in very dry, fluffy corn where positive conveyance to the feederhouse is needed
• Paddles can be installed over the fingers if wrapping becomes problematic

<table>
<thead>
<tr>
<th>Finger Type</th>
<th>Full Flighting Type</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

7.3. Auger Timing:

7.3.1. Dual Auger Drive Time (Double Auger)

• Flighting should be offset by 180° for paddles and fingers
• To adjust:
  Remove, rotate, and reinstall the RH drive shaft from the combine backshaft to the desired position. Alternatively, remove auger drive chain and rotate auger to desired position and reinstall chain.
7.3.2. Folding Corn Head Wing Auger Timing

- Distance between flighting should be properly maintained to optimize feeding across the wing joint.
- The distance between the flighting should be 18”-20”.
- Ensure the wing is engaging the center section when checking timing.
- To adjust timing, remove the jaw coupler on wing and rotate it in the appropriate direction in the hex bore and reinstall.
7.3. **Input Gearbox Drive**

The input gearboxes are connected by a double joint coupling drive or shaft (1) depending on the combine. The gearbox assemblies (2) are selected to provide a nominal snapping unit input speed of 550 rpm for each combine. Gearboxes can be exchanged as necessary.

See appropriate combine conversion document for complete instructions.

The input gearbox drive does not require any additional adjustment.
7.4. Snapping units

7.4.1. Snapping rolls adjustment

Three important settings must be observed when installing or adjusting the snapping rolls.

7.4.1.1. Distance between snapping roll shafts

Adjust the shafts parallel to each other by setting 62 mm (2.45”) between the two bearing housings as shown in the illustration below.

7.4.1.2. Labyrinth

Two sealed double ball bearings are used to support the spiral end of the snapping roll. The bearings are protected by a labyrinth filled with grease. The labyrinth can be flushed by adding grease through the grease nipple. The distance (0.5-1mm) is for reference only, because design dimensions of the parts ensure the correct gap.
7.4.2. Snapping plate adjustment

The nominal factory setting is 27 mm (1-1/16”) at the front and 32 mm (1-1/4”) at the rear. For proper operation, the snapping plate gap should be 5 mm (3/16”) tighter at the front than at the rear. The in-cab snapping plate adjusting mechanism can change the gap to 9 mm (5/16”) tighter and 10 mm (3/8”) wider than the nominal position. Set the mechanism as follows:

- Set the in-cab snapping plate adjusting mechanism to the minimum snapping plate gap.
- Refer to the figure below. Adjust the fixed snapping plate (2) relative to the movable snapping plate (1) to provide a gap of 18 mm (3/4”) at the front (dimension A) and 23 mm (15/16”) at the rear (dimension B) by loosening the retaining bolts (3). When the adjustment is correct retighten the bolts. Repeat for all remaining row units.
- In-cab operation should result in the nominal gap of 27 mm (1-1/16”) at the front and 32 mm (1-1/4”) at the rear in the mid-range of travel.

There is a tool (Snapping Plate Tool - PN 324048) to help set the snapping plate clearance. This tool can be ordered from your dealer. The Snapping Plate Tool’s application is shown on the picture. When adjusting the snapping plates, the brackets that the snouts seat on can come out of alignment.
There is a tool (Snout Seating Tool – PN 324144) that can be placed between the two brackets while setting the snapping plate clearance so the snouts align with the brackets after they are tightened down. This tool can be ordered from your dealer.

Periodically lubricate the top of the snapping plate indicator cable to prevent off-season seizing of the cable.
7.4.3. Vine knife adjustment

The gap between the vine knives and the stalk rolls should not exceed 1 mm (.04”). This gap should be set on one rib and all rib clearances should be checked by rotating the rolls to ensure there is no interference. Adjustment is made by loosening the M-8 screws (3). Relief holes are provided to make a fine adjustment.

There is a tool (Snapping Gauge Tool - PN 324124) to help set new knives on the snapping roll. This tool can be ordered from your dealer. The Snapping Gauge Tool’s application is shown on the picture below.
7.4.4. Gathering chain adjustment

The gathering chain tension is maintained automatically by an enclosed spring on the front idler. A tool is provided to compress the spring for service.

How to use the gathering chain removal tool:
1. Install the gathering chain removal tool and attach it in the holes on the bottom of the snapping unit frame.
2. Position the arm of the gathering chain removal tool into the carriage (circled lower left).
3. Rotate the handle of the removal tool and lock it in place once tension on the gathering chain is relieved.
4. Remove the gathering chain.
Gathering Chain Lug Timing:

<table>
<thead>
<tr>
<th>Fully Staggered</th>
<th>Fully In-Phase (lugs lined up)</th>
<th>One lug staggered</th>
</tr>
</thead>
<tbody>
<tr>
<td>Least aggressive</td>
<td>Most aggressive</td>
<td>Good compromise</td>
</tr>
<tr>
<td>Good conveyance</td>
<td>Brings in most trash/debris</td>
<td>Factory setting</td>
</tr>
<tr>
<td></td>
<td>Good for lodged corn</td>
<td></td>
</tr>
</tbody>
</table>

7.4.5. Gearbox timing and backlash adjustment

Snapping roll gear timing is done by visually aligning the hex shafts as shown below. The backlash can be determined by rotating one gear relative to the other. There should be 1° of free rotation between the gears. The backlash can be increased by adding gasket shims as shown in the Parts Catalog.
7.5. **Header Drive Shafts**

The Walterscheid brand drive shafts require lubrication every 250 operating hours. Remove the shaft annually and grease it according to the label instructions provided by the shaft manufacturer on the shaft cover.

7.6. **Clearance lights**

Clearance lights must be changed from shipping to field position. Simply remove four nuts on U-bolt clamps securing tube and rotate light 90 degrees.
7.7. **Plastic snout adjustment**

- Lower the combine feeder until the distance between the skid shoe of the snapping unit and the ground is 8 cm (3-1/4”)

- Snout support arms must be changed from shipping to field position. Remove the cross bolt and reinstall in the desired position
- Ensure bolt head is facing gathering chain
- Fine tune snout adjustment with eye bolt until front of snout just touches the ground

Manufacturer and Distributor are not responsible for incorrect snout adjustment.
8. **HARVESTING**

The corn head is ready for harvesting after completing the preceding instructions in this manual, which refer to Mounting, Run-in, and Set-up and Adjustment Procedure.

- Always be aware of the presence of the stalk chopper, if fitted, when harvesting.
- The corn head should be operated only when in harvesting position and in proper working condition.

Specify daily maintenance, correct settings and safe operation are required to ensure that the stalk choppers operate properly and safely. Always consider possible circumstances where the knife can impact stones or other foreign objects laying on the ground. Any such impact can result in pieces separating from the hardened knife blade.

**ALWAYS STAY CLEAR** of the corn head while in operation. Bystanders should always be at least 30 m (100 ft.) from the corn head while in operation.

1. After 1 hour of initial operation, stop the machine, remove the combine key, and check the following:
   a. Temperature of all gearboxes (maximum 60 degrees C or 170 F)
   b. Loose parts or hardware
   c. Tension of all chains
   d. General visual inspection

   If this inspection reveals any abnormality, determine the cause of the abnormality or contact your dealer for assistance.

   If the crop is severely laid or lodged it may be necessary to remove one or both of the rubber ear savers from the rear of the snouts to improve feeding to the row units.
8.1. Stalk chopper

The stalk chopper (1) cuts the stalks directly under the snapping rolls (2) with special knives. The stalk chopper drive can be disengaged by turning the hex knob (3) 180 degrees.

Then chopper knives can be reversed when worn. When knife replacement is necessary replace the bushings, bolts and nuts. Consult the parts manual for further information.
9. **ROW SPACING ADJUSTMENT**

The row unit spacing must match the corn row spacing for optimum performance. This is of greater importance with wider corn heads. Improper matching can result in premature wear of the snapping roll front supports and the leading edge of the snapping plates. The row unit spacing is set from the factory and is not designed to be adjusted afterwards.

10. **MOUNTING TO ANOTHER TYPE OF COMBINE**

The mounting kits for various combines are shown in the parts manual. Order the relevant mounting kit from your dealer.

> When mounting the corn head to another type of combine always use all of the protective shields. Ensure that the lower latch attachment and drive connections are secure.
11. **MAINTENANCE AND LUBRICATION**

11.1. **Frame**

The frame of rigid corn headers does not require any special maintenance. The folding mechanism of the folding corn head should be lubricated with EP NLGI Grade 2 or equivalent quality grease once a season or every 250 hours. Grease the fitting until grease extrudes from the sides of the parts shown on the picture (marked with “A”).

11.2. **Auger**

The auger drive chain(s) should be lubricated every 50 hours, and the chain tension should be checked daily. The chain tension is correct if the chain deflects 13-19 mm (0.5” – 0.75”) at the position shown (“A”).

Clean debris under shielding every day!
11.2.1. Folding corn head - snapping unit connecting clutches

The clutch jaws should be greased every 50 hours with EP NLGI Grade 2.

11.2.2. Folding corn head - auger connecting clutches

Grease the surfaces of the clutch jaws every 50 hours with EP NLGI Grade 2. Before unfolding the corn head into the harvesting position ensure that the auger connecting clutch drive jaws are as shown below.
11.3. INPUT GEARBOXES

SAE 80W-140 oil (0.9l) is used for lubrication. To check the oil level, remove the level plug (1) with the corn head in harvesting position. Check the oil level annually or every 250 hours, more often if leakage is detected. The drain and filling plugs (2) are on the main casting of the gearbox, but filling can also be done through the level plug or breather ports.

Location of the oil checking bolts on the gearbox.
The location of the breather depends on the final position of the gearbox. The breather should be placed in the cover hole above the oil level plug.

11.4. DRIVE COMPONENTS

11.4.1. U-joint shafts:

- The U-joints should be greased every 250 hours.
- Grease the sliding surfaces of the U-joint shafts and cross shafts annually.

11.4.2. Chain couplings, Slip clutches

- Grease the Chain couplings every 250 hours
- Grease the Slip clutches every 250 hours
11.5. SNAPPING UNIT

11.5.1. Gearboxes

<table>
<thead>
<tr>
<th>Lubricant</th>
<th>Main gearbox</th>
<th>Chopper gearbox</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAE 80W-140 oil</td>
<td>-</td>
<td>0.26 kg (0.3 l)</td>
</tr>
<tr>
<td>EP-00 liquid grease</td>
<td>2.5 kg (2.5 l)</td>
<td>-</td>
</tr>
<tr>
<td>Check frequency</td>
<td>Annually or every 250 hours whichever comes first, or when leakage detected</td>
<td>50 hours, or when leakage detected</td>
</tr>
</tbody>
</table>

Inspect gearboxes daily to detect any leakage which may cause failure.

Snapping unit main gearbox:
Stalk chopper gearbox:

To check lubricant levels:
- Lower corn head to the ground
- Unscrew the dipstick
- Wipe the dipstick, then replace it but do not screw it back in
- Wait, then remove the dipstick
- The lubricant level should be midway between the minimum and maximum warning lines.

Snapping unit main gearbox

Chopper gearbox
Chopper knives

- Check knife condition daily.
- Never operate with damaged knives.
- The radial clearance between the knife and bushing should not exceed 1 mm (.04”). If clearance exceeds 1 mm (.04”), change both the knife and bushing.
- Knives must be changed only in pairs because of the high rotational speed and balance requirements.
- The knife support bolts should be checked daily and kept tight.

Neither the Manufacturer nor Distributor assumes any responsibility for wear or failure resulting from improper maintenance or lubrication.
11.5.2. Snapping roll

The front bearings are lubricated with EP NLGI Grade 2 and sealed on both sides by the bearing manufacturer. A greased labyrinth is provided to protect the bearings. Grease the front fitting every 250 operating hours, or once a season until grease extrudes from the labyrinth. This will ensure flushing of the old grease and fully replacing it with new grease.

Ensure that the snapping roll knife retaining bolts are kept tight at all times.

- Check the clearance between snapping rolls knife edges
- Factory setting (1 mm)
11.5.3. Gathering chain

- Lubricate every 10 hours using synthetic or vegetable grease or oil.
- Check daily for abnormal wear.

The corn head Pre-harvesting and Pre-delivery inspection checklists are at the end of the operator’s manual.
Please verify the corn heads condition before the first running procedure following the Pre-delivery inspection.
Please verify the corn heads condition before each harvesting following the Pre-harvesting inspection.
12. ELECTRICAL SCHEMATICS

12.1. JD electrical schematic
12.2. CNH electrical schematic
12.3. AGCO electrical schematic
13.4. CLAAS Lexion electrical schematic
13.5. CIH 1000 and 2000 series
14. **TROUBLE SHOOTING**

14.1. **A large quantity of ears builds up between the auger and feeder.**

This can result from improper adjustment of the combine for corn harvesting operation, including front feeder drum (rock retarder drum) position too low, threshing component speed, concave clearance or angle of the feeder front face. Ensure that the combine is adjusted for corn harvesting in accordance with the instructions and settings as recommended in the combine operator’s manual.

14.2. **In laid or lodged corn stalks, the stalks do not feed properly into the snapping rolls.**

Remove only 1 ear saver per row initially, then second ear saver only if necessary.

14.3. **Row unit becomes plugged while harvesting laid or lodged cornstalks.**

Check the tension of the gathering chain.

14.4. **Stalks, grass or weeds wrap on the snapping roll.**

Reduce gap of vine knives.

See “Set-up and Adjustment procedure” section 4.3.

14.5. **Auger does not rotate.**

Check setting of the auger drive torque limiting clutch.

See “Set-up and Adjustment procedure” section 4.2.

14.6. **Ears are broken or split in the auger.**

Reduce the rotational speed of the auger using the optional sprocket.

See “Set-up and Adjustment Procedure”, section 4.2.

14.7. **Difficulty in keeping the corn head properly on the row.**

Check that corn head row spacing matches the corn row spacing.
15. **OFF-SEASON STORAGE OF YOUR CORN HEAD**

When harvesting is completed, thoroughly clean the corn head and remove all remaining debris. Carefully inspect the corn head to ensure it will be in proper operating condition for the next season. Repaint any paint-damaged area to prevent rusting. If this is not possible, coat the unpainted area with rust protector. Repair or replace any damaged or missing parts, including safety labels.

Lubricate the slides on the gathering chain front idlers. If possible, store the corn head in a covered place. If this is not possible, remove the gathering chains, lubricate them and store in a dry, covered area.

16. **WARRANTY, SERVICE, SPARE PARTS ORDERING**

Contact your dealer or distributor about issues concerning warranty or service.

The Manufacturer and Distributor assume no responsibility for failures, wear, or poor performance resulting from improper maintenance, setting, storage or incorrect usage of the corn head.

The warranty does not apply to wear items.

When ordering spare parts, always identify the corn head by:

- type
- serial number
- part number as shown in the parts manual.
### LUBRICATION CHART

<table>
<thead>
<tr>
<th>#</th>
<th>type</th>
<th>period</th>
<th>qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>EP NLGI Grade 2*</td>
<td>250 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>2</td>
<td>EP-00 grease</td>
<td>250 [h]</td>
<td>5.5 [pounds]</td>
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<tr>
<td>3</td>
<td>EP NLGI Grade 2*</td>
<td>250 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>4</td>
<td>EP NLGI Grade 2*</td>
<td>50 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>5</td>
<td>EP NLGI Grade 2*</td>
<td>50 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>6</td>
<td>EP NLGI Grade 2*</td>
<td>250 [h]</td>
<td>look at operator’s manual</td>
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<tr>
<td>7</td>
<td>EP NLGI Grade 2*</td>
<td>250 [h]</td>
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</tr>
<tr>
<td>8</td>
<td>Gearbox oil</td>
<td>50 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>9</td>
<td>Gearbox oil</td>
<td>10 [h]</td>
<td>look at operator’s manual</td>
</tr>
<tr>
<td>10</td>
<td>SAE 80W-140**</td>
<td>50 [h]</td>
<td>10.15 [fl. oz.]</td>
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<td></td>
<td></td>
<td></td>
<td>0.3 [l]</td>
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<tr>
<td>11</td>
<td>SAE 80W-140**</td>
<td>250 [h]</td>
<td>30.45 [fl. oz.]</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>0.9 [l]</td>
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</table>

*high temperature, 1% max molybdenum disulphide, lithium base
**SAE 85W-140 can be used as an alternative
<table>
<thead>
<tr>
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<tbody>
<tr>
<td>1</td>
<td>EP NLGI Grade 2*</td>
<td>250 [h]</td>
<td>look at operator's manual</td>
</tr>
<tr>
<td>2</td>
<td>EP NLGI Grade 2*</td>
<td>50 [h]</td>
<td>look at operator's manual</td>
</tr>
</tbody>
</table>

*high temperature, 1% max molybdenum disulphide, lithium base
18. **PRE-DELIVERY & PRE-HARVESTING INSTRUCTIONS**

18.1 Pre-delivery inspection

Please verify using the checkboxes below that the corn head is properly set up for harvesting. Check the following and adjust if necessary.

<table>
<thead>
<tr>
<th>✔</th>
<th>Item</th>
<th>Reference</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>LIFTING BAR AND OTHER PACKAGING ARE REMOVED</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td></td>
<td></td>
<td>7. SETUP PROCEDURE AND ADJUSTMENT OF THE CORN HEAD</td>
</tr>
<tr>
<td></td>
<td>LOWER LATCHES PROPERLY CONNECTED TO COMBINE FEEDER</td>
<td>5.1. Mounting the corn heads on the combine</td>
</tr>
<tr>
<td></td>
<td>CORN HEAD IS LEVEL</td>
<td>7.7. Plastic snout adjustment</td>
</tr>
<tr>
<td></td>
<td>DRIVE SHAFTS PROPERLY CONNECTED TO COMBINE FEEDER</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td></td>
<td>ELECTRIC AND HYDRAULICS PROPERLY CONNECTED</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td></td>
<td></td>
<td>15. Electrical schematics</td>
</tr>
<tr>
<td></td>
<td>SNAPPING PLATE ADJUSTMENT</td>
<td>7.4.2. Snapping plate adjustment</td>
</tr>
<tr>
<td></td>
<td>GATHERING CHAIN PROPERLY TENSIONED</td>
<td>7.4.4. Gathering chain adjustment</td>
</tr>
<tr>
<td></td>
<td>DRIVE CHAINS PROPERLY TENSIONED</td>
<td>11.2. Auger</td>
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<td></td>
<td>SNOUTS AND DIVIDERS ADJUSTED AND SECURED</td>
<td>7.7. Plastic snout adjustment</td>
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<tr>
<td></td>
<td>SAFETY SHIELDS SECURED</td>
<td>-</td>
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<tr>
<td></td>
<td>GEARBOX LUBRICANT TO PROPER LEVELS</td>
<td>12. INPUT GEARBOXES</td>
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<td>14. SNAPPING UNIT</td>
</tr>
<tr>
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<td>FOLDING/UNFOLDING OPERATION (IF APPLICABLE)</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
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<td></td>
<td>SNAPPING ROLL CLEARANCES</td>
<td>7.4.1. Snapping rolls adjustment</td>
</tr>
<tr>
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<td></td>
<td>14.1.1. Snapping roll</td>
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<tr>
<td></td>
<td>ALL NUTS AND BOLTS ARE SECURED</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>FREE ROTATION OF CHOPPERKNIVES (IF APPLICABLE)</td>
<td>14.1. Gearboxes - Chopper knives</td>
</tr>
<tr>
<td></td>
<td>TEST RUN FOR 30 MINUTES</td>
<td>-</td>
</tr>
</tbody>
</table>
18.1 Pre-Harvesting inspection

Please verify using the checkboxes below that the corn head is properly set up for harvesting. Check the following and adjust if necessary.

<table>
<thead>
<tr>
<th>Item</th>
<th>Reference</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOWER LATCHES PROPERLY CONNECTED TO COMBINE FEEDER</td>
<td>5.1. Mounting the corn heads on the combine</td>
</tr>
<tr>
<td>CORN HEAD IS LEVEL</td>
<td>7.7. Plastic snout adjustment</td>
</tr>
<tr>
<td>DRIVE SHAFTS PROPERLY CONNECTED TO COMBINE FEEDER</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td>ELECTRIC AND HYDRAULICS PROPERLY CONNECTED</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td></td>
<td>15. Electrical schematics</td>
</tr>
<tr>
<td>SNAPPING PLATE ADJUSTMENT, IF NEEDED CLEANING</td>
<td>7.4.2. Snapping plate adjustment</td>
</tr>
<tr>
<td>SNOUTS AND DIVIDERS ADJUSTED AND SECURED</td>
<td>7.7. Plastic snout adjustment</td>
</tr>
<tr>
<td>FOLDING/UNFOLDING OPERATION (IF APPLICABLE)</td>
<td>5.2. Other steps following the securing of the adapter on the combine</td>
</tr>
<tr>
<td>ALL LUBRICANTS HAVE BEEN CHECKED</td>
<td>11. MAINTENANCE AND LUBRICATION</td>
</tr>
<tr>
<td></td>
<td>12. INPUT GEARBOXES</td>
</tr>
<tr>
<td></td>
<td>13. DRIVE COMPONENTS</td>
</tr>
<tr>
<td></td>
<td>14. SNAPPING UNIT</td>
</tr>
<tr>
<td>TEST RUN (30 MINS)</td>
<td>-</td>
</tr>
</tbody>
</table>