R113 and R116 Rotary Disc Headers

Parts Catalog
215366 Revision A
Original Instruction

The Harvesting Specialists.
R113 and R116 Rotary Disc Headers

Published: July 2020

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Introduction

This Parts Catalog lists all the replacement parts that can be ordered for a MacDon R113 and R116 Rotary Disc Headers. When ordering, be sure to use the complete and proper part number. Some parts vary with header size; be sure you are ordering the correct part number for your unit.

Bold text is used to indicate updates made at the current revision level. With each new revision of the catalog, previous revisions are returned to regular text.

In this catalog, right-hand (RH) and left-hand (LH) are determined from the operator’s seated driving position in the windrower cab. An arrow is sometimes used in illustrations to indicate forward position as shown below.
## Abbreviations

<table>
<thead>
<tr>
<th>Abbreviation</th>
<th>Description</th>
</tr>
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<tbody>
<tr>
<td>A/R</td>
<td>as required (quantity varies)</td>
</tr>
<tr>
<td>BV</td>
<td>ball valve</td>
</tr>
<tr>
<td>CSK</td>
<td>countersink</td>
</tr>
<tr>
<td>DBLE</td>
<td>double</td>
</tr>
<tr>
<td>DT</td>
<td>distorted thread</td>
</tr>
<tr>
<td>GR</td>
<td>grade</td>
</tr>
<tr>
<td>HDR</td>
<td>header</td>
</tr>
<tr>
<td>HNBR</td>
<td>hydrogenated nitrile butadiene rubber</td>
</tr>
<tr>
<td>IP</td>
<td>internal plus (torx plus)</td>
</tr>
<tr>
<td>LG</td>
<td>long</td>
</tr>
<tr>
<td>MACH</td>
<td>machine</td>
</tr>
<tr>
<td>MY</td>
<td>model year</td>
</tr>
<tr>
<td>NSS</td>
<td>not sold separately</td>
</tr>
<tr>
<td>PO</td>
<td>pilot operated</td>
</tr>
<tr>
<td>REF</td>
<td>reference, part number called up elsewhere in catalog</td>
</tr>
<tr>
<td>RHSN</td>
<td>round head, square neck or square neck carriage bolt</td>
</tr>
<tr>
<td>SAE</td>
<td>Society of Automotive Engineers (part produced to comply with)</td>
</tr>
<tr>
<td>SK</td>
<td>single knife</td>
</tr>
<tr>
<td>SMV</td>
<td>slow moving vehicle</td>
</tr>
<tr>
<td>SPCL</td>
<td>special</td>
</tr>
<tr>
<td>SR</td>
<td>single reel</td>
</tr>
<tr>
<td>STVR</td>
<td>Stover</td>
</tr>
<tr>
<td>UCA</td>
<td>upper cross auger</td>
</tr>
<tr>
<td>UNEF</td>
<td>unified extra fine thread</td>
</tr>
<tr>
<td>VK</td>
<td>veritical knife</td>
</tr>
<tr>
<td>ASSY</td>
<td>assembly</td>
</tr>
<tr>
<td>CCW</td>
<td>counterclockwise</td>
</tr>
<tr>
<td>C/W</td>
<td>complete with</td>
</tr>
<tr>
<td>DK</td>
<td>double knife</td>
</tr>
<tr>
<td>FLG</td>
<td>flange</td>
</tr>
<tr>
<td>GS</td>
<td>grass seed</td>
</tr>
<tr>
<td>HFA</td>
<td>hydraulic fore-aft</td>
</tr>
<tr>
<td>HYD</td>
<td>hydraulic</td>
</tr>
<tr>
<td>KP</td>
<td>knife pressure</td>
</tr>
<tr>
<td>LH</td>
<td>left hand (determined from Operator's position, facing forward)</td>
</tr>
<tr>
<td>MD</td>
<td>MacDon</td>
</tr>
<tr>
<td>NC</td>
<td>national coarse thread</td>
</tr>
<tr>
<td>O.D.</td>
<td>outside diameter</td>
</tr>
<tr>
<td>PT</td>
<td>pull-type (mower conditioner)</td>
</tr>
<tr>
<td>REG</td>
<td>regular</td>
</tr>
<tr>
<td>RHSSN</td>
<td>round head, short, square neck</td>
</tr>
<tr>
<td>SD</td>
<td>side draper</td>
</tr>
<tr>
<td>SKT HD</td>
<td>socket head</td>
</tr>
<tr>
<td>SOCK</td>
<td>socket</td>
</tr>
<tr>
<td>SPH</td>
<td>spherical</td>
</tr>
<tr>
<td>STFL</td>
<td>steel (stainless)</td>
</tr>
<tr>
<td>TFL</td>
<td>thread full length</td>
</tr>
<tr>
<td>UDK</td>
<td>untimed double knife</td>
</tr>
<tr>
<td>UNF</td>
<td>unified fine thread</td>
</tr>
<tr>
<td>ZP</td>
<td>zinc plated</td>
</tr>
<tr>
<td>BHRN</td>
<td>button head rib neck</td>
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<tr>
<td>CON</td>
<td>conical (spring washer)</td>
</tr>
<tr>
<td>CW</td>
<td>clockwise</td>
</tr>
<tr>
<td>DR</td>
<td>double reel</td>
</tr>
<tr>
<td>GA</td>
<td>gauge</td>
</tr>
<tr>
<td>HD</td>
<td>head</td>
</tr>
<tr>
<td>HH</td>
<td>hex head</td>
</tr>
<tr>
<td>I.D.</td>
<td>inside diameter</td>
</tr>
<tr>
<td>KR</td>
<td>knife return</td>
</tr>
<tr>
<td>LK</td>
<td>lock</td>
</tr>
<tr>
<td>MFA</td>
<td>manual fore-aft</td>
</tr>
<tr>
<td>NF</td>
<td>national fine thread</td>
</tr>
<tr>
<td>OPT</td>
<td>optional</td>
</tr>
<tr>
<td>RC</td>
<td>roller chain</td>
</tr>
<tr>
<td>RH</td>
<td>right hand (determined from Operator's position, facing forward)</td>
</tr>
<tr>
<td>RTD</td>
<td>rotating tine drum</td>
</tr>
<tr>
<td>SER</td>
<td>serrated</td>
</tr>
<tr>
<td>SMTH</td>
<td>smooth</td>
</tr>
<tr>
<td>SP</td>
<td>self-propelled (windrower) header</td>
</tr>
<tr>
<td>SPI</td>
<td>serrations per inch (knife sections)</td>
</tr>
<tr>
<td>STR</td>
<td>standard</td>
</tr>
<tr>
<td>THD</td>
<td>thread</td>
</tr>
<tr>
<td>UNC</td>
<td>unified coarse thread</td>
</tr>
<tr>
<td>UNS</td>
<td>unified special thread series</td>
</tr>
</tbody>
</table>
Serial Number Breaks

The side of the serial number on which the dash (=) appears determines whether the part is used "up to" or "after" the serial number given.

Example:

- 162249 Used on machines up to and including serial number 166249
- 166250– Used on machines including and after serial number 166250
### Summary of Changes – R1 SP Series (215366 Rev. A)

This list covers changes made since the last revision (215011 Rev. A).

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<tr>
<th>Section</th>
<th>Summary of Change</th>
<th>Internal Use Only</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1 Cutterbar – R113, page 1</strong></td>
<td>Added spacer plate MD #247616 to list for 2015, previously only listed in the footnote. Added serial number breaks to clarify models affected.</td>
<td>Tech Pubs</td>
</tr>
<tr>
<td><strong>2 Cutterbar – R116, page 5</strong></td>
<td>Added spacer plate MD #247616 to list for 2015, previously only listed in the footnote. Added serial number breaks to clarify models affected.</td>
<td>Tech Pubs</td>
</tr>
<tr>
<td><strong>3 Cutterbar Components – R113, 2017, page 9</strong></td>
<td>8 disc cutterbar kit (MD #259416) superseded by MD #259518. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683. Stock available for part numbers 247242, 247243, 247950, 281446, and 281447. Superseding part numbers 281865, 281866, 281753, 281822, and 281821 on ECN 55523 not introduced into this catalog revision.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>4 Cutterbar Components – R113, 2018 and Later, page 11</strong></td>
<td>8 disc cutterbar kit (MD #259416) superseded by MD #259518. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683. Stock available for blades 257083 and 257084. Superseding blades (259199 and 259200) on ECN 56808 were not introduced into this catalog revision.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>5 Cutterbar Components – R116, page 15</strong></td>
<td>10 disc cutterbar kit (MD #259415) superseded by 259517. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683. 10 disc cutterbar kit (MD #259517) superseded by MD #238195. Stock available for blades 257083 and 257084. Superseding blades (259199 and 259200) on ECN 56808 were not introduced into this catalog revision.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>6 Cutterbar to Frame – R113, page 19</strong></td>
<td>Drive alignment tool assembly (MD #307769) superseded by MD #325683. Updated illustration from 1027262 to 1033366 to show changes. Cast link (MD #246700) superseded by MD #238147.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>7 Cutterbar to Frame – R116, page 21</strong></td>
<td>Drive alignment tool assembly (MD #307769) superseded by MD #325683. Updated illustration from 1027249 to 1033367 to show changes. Cast link (MD #246700) superseded by MD #238147.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>8 Mechanical Drives – R113, page 23</strong></td>
<td>Gearbox kit (MD #257173) superseded by MD #257187. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>9 Mechanical Drives – R116, page 25</strong></td>
<td>Gearbox kit (MD #257173) superseded by MD #257187. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td>Section</td>
<td>Summary of Change</td>
<td>Internal Use Only</td>
</tr>
<tr>
<td>---------</td>
<td>------------------</td>
<td>------------------</td>
</tr>
<tr>
<td><strong>10 90° Drive Gearbox – Internal Components, page 27</strong></td>
<td>Gearbox kit (MD #257173) superseded by MD #257187. Updated footnote with drive alignment tool assembly (MD #307769) superseded by MD #325683.</td>
<td>ECN 58773</td>
</tr>
<tr>
<td><strong>16 Roll Conditioner – Header Attachment, page 43</strong></td>
<td>Washer (MD #184717) quantity for the belt tensioner was changed from 1 to 2. Added washer to prevent possible idler pulley rubbing against the header frame. Updated illustration from 1027294 to 1033404 to show changes.</td>
<td>ECN 60063</td>
</tr>
<tr>
<td></td>
<td>Added deflector plates (MD #256640 and 256641) to list for R116. New design does not interfere with cutterbar housing.</td>
<td>ECN 59346</td>
</tr>
<tr>
<td><strong>18 Adapter Frame, page 49</strong></td>
<td>Removed location callout (LH/RH) from description of shields MD #224761 and 224762 and corrected the order in the list. Installation location of shields 224761/224762 alternates depending on whether they are being installed on PT or SP rotary headers. Since shield drawings have RH/LH callouts associated with their descriptions, it lead to confusion when ordering shields for the SP model. Thus location callouts were removed.</td>
<td>ECN 58849</td>
</tr>
<tr>
<td></td>
<td>Added lube fitting (MD #18671) to list and illustration. Added to adapter frame for forming shield pivot tube. Added to prevent forming shield seizing after 500 hours. Updated illustration from 1021163 to 1033405 to show changes.</td>
<td>ECN 60028</td>
</tr>
<tr>
<td><strong>20 Lift Assembly, page 53</strong></td>
<td>Machined spacer (MD #257026) superseded by MD #257186.</td>
<td>ECN 58730</td>
</tr>
<tr>
<td><strong>24 Decals – Information and Reflectors, page 65</strong></td>
<td>Tipping only decal (MD #304464) superseded by no lift decal MD #304865. Updated illustration from 1029721 to 1033396 to show changes.</td>
<td>ECN 58722</td>
</tr>
<tr>
<td></td>
<td>Added 100 hour lube decal (MD #257190) for adapter frame forming shield pivot tube.</td>
<td>ECN 60028</td>
</tr>
<tr>
<td><strong>29 (Option) R113 SP to M205 Compatibility Kit, page 75</strong></td>
<td>Added new section with new illustration 1033496.</td>
<td>ECN 59429</td>
</tr>
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<th>Part Number</th>
<th>Description</th>
<th>Qty</th>
<th>Serial Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>246236</td>
<td>SPINDLE – DRIVE ¹</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>246293</td>
<td>SPINDLE – CLOCKWISE ²</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>246294</td>
<td>SPINDLE – COUNTER CLOCKWISE ²</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>259048</td>
<td>RING – RETAINING</td>
<td>7</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>246612</td>
<td>NUT – SPECIAL (RH THREAD)</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>246613</td>
<td>NUT – SPECIAL (LH THREAD)</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>247923</td>
<td>PLATE – SPACER</td>
<td>8</td>
<td>285420–</td>
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<tr>
<td>8</td>
<td>247616</td>
<td>PLATE – SPACER (2015 ONLY)</td>
<td>8</td>
<td>266820–285419</td>
</tr>
<tr>
<td>9</td>
<td>246295</td>
<td>PIN – SHEAR</td>
<td>16</td>
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<td>10</td>
<td>246617</td>
<td>RING – SNAP</td>
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<td>11</td>
<td>247936</td>
<td>SHIM</td>
<td>8</td>
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<td>12</td>
<td>246328</td>
<td>BEARING – TAPER ROLLER</td>
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<td>13</td>
<td>247937</td>
<td>SEAL</td>
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<td>14</td>
<td>246316</td>
<td>O-RING – SPINDLE</td>
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<td>15</td>
<td>246623</td>
<td>GEAR – CLOCKWISE (RH THREAD)</td>
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<td>GEAR – DRIVE, CLOCKWISE (RH THREAD)</td>
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<td>17</td>
<td>246624</td>
<td>GEAR – COUNTER CLOCKWISE (LH THREAD)</td>
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<td>18</td>
<td>246330</td>
<td>PIN – IDLER GEAR</td>
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<td>19</td>
<td>246315</td>
<td>O-RING – IDLER PIN</td>
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<td>20</td>
<td>246331</td>
<td>O-RING – IDLER PIN</td>
<td>16</td>
<td></td>
</tr>
<tr>
<td>21</td>
<td>246308</td>
<td>GEAR – IDLER, LARGE, C/W BEARING ⁴</td>
<td>10</td>
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<tr>
<td>22</td>
<td>246307</td>
<td>GEAR – IDLER, SMALL, C/W BEARING ⁴</td>
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<tr>
<td>23</td>
<td>246309</td>
<td>CUTTERBAR – END CAP</td>
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<td>-346189</td>
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<td></td>
<td>307175</td>
<td>CUTTERBAR – END CAP</td>
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<td>346190–</td>
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<td>24</td>
<td>247924</td>
<td>O-RING – END PLATE, 170 X 4.5 MM</td>
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<tr>
<td>25</td>
<td>246631</td>
<td>PLUG – SIDE, M18 X 1.5</td>
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<td>26</td>
<td>246632</td>
<td>GASKET</td>
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<td>27</td>
<td>246627</td>
<td>PLUG</td>
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<td>28</td>
<td>246628</td>
<td>GASKET</td>
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<td>29</td>
<td>246318</td>
<td>BREATHER – CUTTERBAR</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>246991</td>
<td>STUD – M12 X 25</td>
<td>88</td>
<td></td>
</tr>
</tbody>
</table>

1. Does not include spacer plate (MD #247616 or 247923), spindle O-ring (MD #246316), stud (MD #246991), or hardware F, G (MD #246630, 246332).
2. Wrench (MD #246314) is attached to header, and is used to loosen/tighten nut. For location of wrench, refer to Section 6 Cutterbar to Frame – R113, page 19.
3. Not sold separately. Comes included with spindles (MD #246236, 246293, and 246294).
4. Includes bearing and snap ring. Bearing and snap ring not sold separately.
### CUTTERBAR – R113

<table>
<thead>
<tr>
<th>Ref</th>
<th>Part Number</th>
<th>Description</th>
<th>Qty</th>
<th>Serial Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>246615</td>
<td>WASHER – SPECIAL, BELLEVILLE</td>
<td></td>
<td></td>
</tr>
<tr>
<td>B</td>
<td>246310</td>
<td>BOLT – M16, IDLER PIN</td>
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<td></td>
</tr>
<tr>
<td>C</td>
<td>246311</td>
<td>NUT – IDLER PIN</td>
<td></td>
<td></td>
</tr>
<tr>
<td>D</td>
<td>246313</td>
<td>WASHER – END CAP</td>
<td></td>
<td>–346189</td>
</tr>
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<td></td>
<td>238016</td>
<td>WASHER – END CAP</td>
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<td>346190–</td>
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<tr>
<td>E</td>
<td>246625</td>
<td>WASHER – SPECIAL</td>
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<tr>
<td>F</td>
<td>246630</td>
<td>WASHER – SPECIAL</td>
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</tr>
<tr>
<td>G</td>
<td>246332</td>
<td>NUT – M12, LOCKING</td>
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<td></td>
</tr>
<tr>
<td>H</td>
<td>246872</td>
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2 Cutterbar – R116
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<td>31</td>
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5. Does not include spacer plate (MD #247616 or 247923), spindle O-ring (MD #246316), stud (MD #246991), or hardware (MD #246630, 246332).
6. Wrench (MD #246314) is attached to header, and is used to loosen/tighten nut. For location of wrench, refer to Section 7 Cutterbar to Frame – R116, page 21.
7. Not sold separately. Comes included with spindles (MD #246236, 246293, and 246294).
8. Includes bearing and snap ring. Bearing and snap ring not sold separately.
## CUTTERBAR – R116

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3 Cutterbar Components – R113, 2017
**CUTTERBAR COMPONENTS – R113, 2017**

**IMPORTANT:**

All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 5 mm blade plate (MD #246301) requires accelerator bolt (MD #281965) and blade bolt (MD #246299).

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<td>BOLT – M12, DISC COVER</td>
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9. Assembly does not include blades (MD #281446, 281447) or blade hardware (MD #246299, 246300). It does include a top cover plate that will need to be removed before use.

10. Assembly does not include blades (MD #281446, 281447) or blade hardware (MD #246299, 246300).

11. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.

12. Kit can be used to update or replace a complete 2017 cutterbar (except blades and blade hardware) to current standards. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).
4  Cutterbar Components – R113, 2018 and Later
**CUTTERBAR COMPONENTS – R113, 2018 AND LATER**

**IMPORTANT:**
All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 10 mm blade plate (MD #281606) requires accelerator bolt (MD #281605) and blade bolt (MD #281604).

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| B   | 246300      | NUT – BLADE  |     |               |
| C   | 281605      | BOLT – ACCELERATOR  |     |               |
| D   | 246303      | NUT – ACCELERATOR  |     |               |
| E   | 246312      | BOLT – M12, DISC COVER  |     |               |
| F   | 246332      | NUT – NYLON INSERT LOCK M12 X 1.75 ZN PL CL-10 |     |               |
| G   | 259099      | BOLT – COUNTERSUNK, M12  |     |               |
| H   | 259100      | WASHER – FLAT, M12  |     |               |

---

13. Assembly does not include blades (MD #257083, 257084) or blade hardware (MD #281604, 246300). It does include a top cover plate that will need to be removed before use.
14. Assembly does not include blades (MD #257083, 257084) or blade hardware (MD #281604, 246300).
15. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.
16. Kit includes LH and RH reinforced rockguards (MD #238031 and 238032), lower gearbox mount bracket (MD #238054), and hardware (MD #184681 and 136141). Lower gearbox mount bracket required only on R113 to eliminate interference with conditioner.
17. Kit used to replace or update complete cutterbar except blades and blade hardware. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).
<table>
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<td>WASHER – M12, LOCKING, DISC</td>
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5 Cutterbar Components – R116
**IMPORTANT:**

All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 10 mm blade plate (MD #281606) requires accelerator bolt (MD #281605) and blade bolt (MD #281604).

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18. Assembly does not include blades (MD #257083, 257084) or blade hardware (MD #281604, 246300).
19. Assembly does not include blades (MD #257083, 257084), blade hardware (MD #281604, 246300), disc cover (MD #246305), or disc hardware (MD #246312, 246952).
20. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.
21. Kit includes LH and RH reinforced rockguards (MD #238031 and 238032), lower gearbox mount bracket (MD #238054), and hardware (MD #184681 and 136141). Lower gearbox mount bracket required only on R113 to eliminate interference with conditioner.
22. Kit used to replace or update complete cutterbar except blades and blade hardware. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).
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6 Cutterbar to Frame – R113
### CuttBar to Frame – R113

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23. Shim both sides of the header evenly as required to a maximum gap of 2 mm per side before tightening bolts.

24. Use drive alignment tool to achieve proper alignment (+/− 3.2 mm or 1/8 in.) between 90° drive gearbox hub and cutterbar driveshaft. Tool not supplied with header; includes hardware (MD #184711, 135799, and 108172).

25. Wrench is attached to header. Used to loosen/tighten special nuts (MD #246612 and 246613). Refer to Section 1 Cutterbar – R113, page 1.
7 Cutterbar to Frame – R116
### CUTTERBAR TO FRAME – R116

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26. Shim both sides of the header evenly as required to a maximum gap of 2 mm per side before tightening bolts.
27. Use drive alignment tool to achieve proper alignment (+/− 3.2 mm or 1/8 in.) between 90° drive gearbox hub and cutterbar driveshaft. Tool not supplied with header; includes hardware (MD #184711, 135799, and 108172).
28. Wrench is attached to header. Used to loosen/tighten special nuts (MD #246612, 246613). Refer to Section 2 Cutterbar – R116, page 5.
Ref | Part Number | Description | Qty | Serial Number
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 | 257174 | KIT – GEARBOX 30 | 1 | –321189
2 | 256372 | SHIELD – WELDMENT | 1 | 
3 | 222269 | KEY | 1 | 
4 | 247103 | HUB – DRIVE | 1 | 
5 | 256582 | SUPPORT – TENSIONER WELDT | 1 | 
6 | 259139 | ASSEMBLY – DRIVELINE | 1 | 
 | 259142 | ASSEMBLY – CROSS JOURNAL, CENTER ZERK | 
 | 247120 | ASSEMBLY – CROSS JOURNAL, CAP ZERK | 
 | 247121 | YOKE | 
 | 247122 | YOKE – FLANGE | 
7 | 222291 | SPACER | 4 | 
8 | 256352 | PLATE – COVER | 1 | 
9 | 256371 | BRACKET | 1 | 
10 | 246691 | SHIELD WELD’T – DRUM | 2 | 
11 | 256416 | SHIELD – VERTICAL WELD’T | 1 | 
12 | 246687 | PLATE WELDMENT – BACK | 1 | 
13 | 246770 | PLATE – COVER | 1 | 
14 | 256408 | PLATE – SHIELD | 1 | 
15 | 281378 | DRUM – TOP | 1 | 
A | 136151 | BOLT – HEX FLG HD TFL M10 X 1.5 X 16-8.8-A3L | 
B | 4762 | WASHER – FLAT | 
C | 135491 | BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L | 
D | 120901 | WASHER – HARD L9 5/8-82/85HR15N-AB3C | 
E | 136143 | BOLT – HEX HD TFL M16 X 2 X 30-10.9-A3L | 
F | 148799 | BOLT – HEX FLG HD M12 X 1.75 X 45-10.9-A3L | 
G | 135903 | BOLT – RHSN M12 X 1.75 X 25-8.8-A3L | 
H | 136431 | NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L | 
J | 152685 | BOLT – RHSN M16 X 2 X 40-10.9-A3L | 
K | 136440 | NUT – HEX FLG CTR LOC M16 X 2-10-A3L | 
L | 136137 | BOLT – HEX HD TFL M16 X 2 X 35-8.8-A3L | 
M | 136485 | BOLT – HEX FLG HD TFL M8 X 1.25 X 16-8.8-A3L | 
N | 152655 | BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L | 

29. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction. For 90° drive gearbox serviceable components, refer to Section 10 90° Drive Gearbox – Internal Components, page 27.

30. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction. For 90° drive gearbox serviceable components, refer to Section 10 90° Drive Gearbox – Internal Components, page 27.
9 Mechanical Drives – R116
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31. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction. For 90° drive gearbox serviceable components, refer to Section 10 90° Drive Gearbox – Internal Components, page 27.

32. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction. For 90° drive gearbox serviceable components, refer to Section 10 90° Drive Gearbox – Internal Components, page 27.
10 90° Drive Gearbox – Internal Components
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33. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction.

34. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction.
11 Header Shields – R113
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35. Includes information decals (MD #194465, 247167, and 194466) and MacDon top decal (MD #246997).
36. Includes information decals (MD #194465, 247167, and 194466) and R113 SP top decal (MD #256333).
37. Includes information decal (MD #190546).
12 Header Shields – R116
### HEADER SHIELDS – R116

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38. Includes information decal (MD #190546).
39. Includes information decals (MD #194465, 247167, and 194466) and MacDon top decal (MD #246997).
40. Includes information decals (MD #194465, 247167, and 194466) and R116 SP top decal (MD #256334).
13 Roll Conditioner – Polyurethane/Steel
### ROLL CONDITIONER – POLYURETHANE/STEEL

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41. Kits available through Whole Goods only.
42. For service parts, refer to Section 14 Roll Conditioner – Gear Drive, page 37.
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14 Roll Conditioner – Gear Drive
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43. Refer to Section 13 Roll Conditioner – Polyurethane/Steel, page 33.
15 Roll Conditioner – Shields
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44. Includes tolerance clip (MD #135813) and pop rivet (MD #113799).
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16 Roll Conditioner – Header Attachment
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45. Comes assembled with latch (MD #135815), lynch pin (MD #246583), shield anchor cable (MD #224605), and hardware.

46. Kit includes two bushings (MD #221997), lubrication fitting (MD #7782), straight pin (MD #281644), eye bolt (MD #224587), and hardware (MD #30655 and 30505).
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17 No Conditioner Option – Shields
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47. Kits available through Whole Goods only.
48. Pulley is factory installed and not included in bundle B5818.
18  Adapter Frame
## ADAPTER FRAME

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19 Center-Link and Adapter to Header Connections
### CENTER-LINK AND ADAPTER TO HEADER CONNECTIONS

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49. Shim as needed only at rear of center-link anchor (MD #256246), maximum 2 mm gap.

50. Washer (1.2 mm thick) used as a shim. Insert washers as required evenly on both sides of the header to minimize the gap on each side of the rubber bushings between frame plates before tightening bolts.
20 Lift Assembly
## LIFT ASSEMBLY

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21 Wiring Assembly
NOTE:
For electrical harness parts, refer to Electrical Connector Parts Catalog (MD #169641).

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51. Lamp mount assembly includes three reflectors (MD #115145, 115146, and 115147).
22 Hydraulic Drive – R113 and R116 to M1170
## HYDRAULIC DRIVE – R113 AND R116 TO M1170

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<td>VALVE – RELIEF</td>
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52. Kits available through Whole Goods only.
53. Manifold includes check valve (MD #236684), relief valve (MD #236538), and two O-rings (MD #150595).
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<td>FASTENER – CABLE TIE, BLACK</td>
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A 21567 BOLT – HEX HD .375-16 UNC X 0.75 LG
B 30228 NUT – FLANGE DT SMOOTH FACE 0.375-16 UNC
C 135976 BOLT – HH 1/2 NC X 8 LG GR5 ZP
D 50186 NUT – FLANGE LOCK SM FACE DT 0.500-13 UNC GR5
E 135491 BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L
F 136354 SCREW – HEX SOCS HD ISO 4762 M10
G 30632 WASHER – LOCK SPRING M10
H 136108 SCREW – HEX SOCS HD M10 X 1.5 X 80-12.9-BO

54. Kit includes motor (MD #198610), relief manifold (MD #236634), fittings (MD #135790 and 136258), and hardware (MD #136108, 30632, and 136354).
23 Hydraulic Drive – R113 and R116 to M155E4
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<td>FLANGE – HALF SPLIT 1 IN.</td>
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<td>WASHER – REG. LOCK 3/8 IN. NOM. ID ZP</td>
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<td>O-RING – 1.296 IN. ID X 0.139 IN. WALL</td>
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<td>LINE – HIGH PRESSURE</td>
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<td>SUPPORT – HYDRAULIC BRACKET</td>
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<td>O-RING – 2.50 X 134.00</td>
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55. Kits available through Whole Goods only.
HYDRAULIC DRIVE – R113 AND R116 TO M155E4
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<td>BOLT – HEX HD TFL M10 X 1.5 X 25-8.8-A3L</td>
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<td>E</td>
<td>135799</td>
<td>NUT – HEX FLG CTR LOC M10 X 1.5 X 10-A3L</td>
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<td>NUT – HEX FLG CTR LOC M12 X 1.75 X 10-A3L</td>
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<td>H</td>
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<td>WASHER – FLAT REG M10-200HV-A3L</td>
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24 Decals – Information and Reflectors

1 2 3 4
5 6 7 8
9 10 11

12 13 14

15

16 17

WARNING
Cancer and Reproductive Harm
www.P65warnings.ca.gov.
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<td>DECAL – READ MANUAL</td>
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<td>DECAL – CHAIN ENTANGLEMENT</td>
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<td>DECAL – KEEP SHIELDS IN PLACE (SQUARE CORNERS)</td>
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<td>DECAL – KEEP SHIELDS IN PLACE (ROUND CORNERS)</td>
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<td>DECAL – SLIPPERY SURFACE, 2 PANEL</td>
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<td>DECAL – STAND CLEAR BLADES, 2 PANEL</td>
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<td>DECAL – STAND CLEAR THROWN OBJECTS, 2 PANEL</td>
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<td>DECAL – STOP DRIVE</td>
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<td>DECAL – GREASE, ROLLER CONDITIONER</td>
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<td>14</td>
<td>23164</td>
<td>DECAL – 25 HR LUBE</td>
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<td>DECAL – 100 HR LUBE</td>
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<td>115145</td>
<td>REFLECTOR – FLUORESCENT RED-ORANGE</td>
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<td>REFLECTOR – AMBER</td>
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<td>REFLECTOR – RED</td>
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<td>132117</td>
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<td>STRIP – ANTI SLIP (450 MM LG, 80 MM WIDE)</td>
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25  Decals – Product Identification, R113
### DECALS – PRODUCT IDENTIFICATION, R113

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<td>DECAL – RH, END PANEL 56</td>
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<td>DECAL – TOP, R113 SP (WHITE, 468 MM LG)</td>
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<td>246997</td>
<td>DECAL – TOP, MACDON (WHITE, 1140 MM LG)</td>
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56. Requires R113 SP end panel decal (MD #256331).
Decals – Product Identification, R116
### DECALS – PRODUCT IDENTIFICATION, R116

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57. Requires R116 SP end panel decal (MD #256332).
Tool Operated Latches – Export Only
## TOOL OPERATED LATCHES – EXPORT ONLY

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<td>SPRING – COMPRESSION</td>
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<td>LATCH – WELDMENT</td>
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<td>A</td>
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<td>NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L</td>
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<td>B</td>
<td>184587</td>
<td>WASHER – FLAT, 0.5 IN ID, 1.25 IN OD, 0.109 IN THK</td>
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<td>C</td>
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<td>SCREW – HEX SOC CSK HD TFL M12 X 1.75 X 40-10.9-AA3L</td>
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(Option) Blade Lowering Kit
## (OPTION) BLADE LOWERING KIT

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<td>259200</td>
<td>BLADE – 18° CCW BEVEL DOWN (6 PACK)</td>
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58. Kit includes all listed parts and hardware.
29  (Option) R113 SP to M205 Compatibility Kit
NOTE:
The R113 SP to M205 Compatibility kit is required for R113 Rotary Disc Headers that were originally configured for an M1170 Windrower to operate on an M205 Self-Propelled Windrower.

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59. Kit includes all listed parts and instruction.
30 (Option) R1 Service Kit

Diagram showing the components of the R1 Service Kit, labeled as follows:

- 1
- 2
- 3
- A
- B
- C
- D

Numbered components correspond to parts of the service kit, indicating their positions and roles in the kit's assembly.
### (OPTION) R1 SERVICE KIT

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60. Kit intended to replace all blades and hardware on an R1 Series disc header.
31 (Option) Tall Crop Dividers
### (OPTION) TALL CROP DIVIDERS

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61. Kits available through Whole Goods only.
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