

Assembly Instructions for "See Thru" Pipe Reel Conversion Kit

**** Be sure to wear safety glasses and proper headgear during assembly.**

** Two people can assemble a typical 20' reel in a forenoon.

6 bat/3 section reels will include the following parts:

- 6 left hand reel sections with tines installed and cam arms attached.
- 6 right hand reel sections with tines installed and cam arms attached.
- 6 center reel sections with tines and "joining pipes" installed.
- 12 cam arm drive bearing bases and caps (small hole) (CF2181).
- 24 spider arm bearing bases and caps (large hole) (CF21812).
- 72 hex bolts, 1/4" x 3 1/2" with serrated flange head.
- 72 lock nuts, 1/4".
- 12 hex bolts, 5/16" x 3/4" (for reel end shield assembly).
- 12 nut, 5/16" serrated flange.
- 12 reel end shield plates (also referred to as Crop Divider Plates).
- 4-5 cans of black spray paint.

* We do not paint these units prior to shipping as the shipping process and assembly would destroy the paint. When the reel is completed spray the pipe with a degreaser solution, wipe off the solution with a shop rag, and paint. Allow the paint to dry overnight if possible before using.

1. Remove all existing bearings, U-bolts, and pipes with bats attached from existing reel. When completed you should have the center tube with 3 sets of spider arms attached and 2 cam arm spider arm drives intact. Retain for use on the new reel, the bushings from the old cam drive bearings. If your old reel drove with a hex shaped drive bolt you will need to replace the hex shaped drive bolt with a standard hex cap bolt (not included in kit).
2. Install on the ends of all spider arms the new bearing base and cap units. The smaller ID bearings will be used on the outside cam arm drive spiders. Attach the bearing base and cap using the 1/4" x 3 1/2" hex bolt and the 1/4" locknut. Do **NOT** tighten these bolts at this time, merely finger tighten the locknuts. Attach the base first and then the cap, insert the bolts and finger tighten the nuts. The large ID bearings will be used on the interior spider arms.
3. Attach the 12 crop divider plates (end reel shield) to the outside set of spider arms (cam drive arms). The divider plates are to be installed by removing the bolts holding the bearing to the spider arm. The crop divider plate then is installed so that the tabs with the predrilled holes will be on top of the bearing cap. The plates are designed to overlap each other approximately half way down the outside of the spider arm. Be sure the overlap is installed so that the plate will not catch crop during operation. Repeat this process until all 12 divider plates are installed. Next, drill an 11/32" hole through the cam arm where the divider plates overlap and attach the divider plates to the cam arm by using the 5/16" x 3/4" hex bolt. The head

of the bolt should be on the outside of the divider plates, holding both plates to the spider arm through the slotted holes at the bottom of the plate.



Photos show divider plate installation.

4. Begin pipe assembly on a single pipe or bat. Remove all bearing caps on this one row or bat. Slide the center section of pipe into each of the outside sections of pipe. Lay the completed length of pipe onto the bearing bases. Attach the cam drive units to the cam drive spider arm bearing being careful to keep the large 1 1/8" diameter flat washer to the outside of the bearing. Reinstall all of the bearing caps to all of the bearing bases on this bat and "snug tighten" only. To keep the reel in balance, install pipes opposite to the first pipe installed so that the reel will not move during assembly. Repeat the pipe installation process until all 6 bats are completed.
5. With all 6 pipes installed check each center pipe section and be sure that you have the same amount of space on each side of the bearing. This will prevent putting a "side load" on the spider arms. Measure each of the new pipes overall length. The new pipes should be within 1/16" overall length of the old pipes you removed. Turn the reel over slowly by hand inspecting location of the cam drive in the cam track. Care should be taken to be sure all of the tines are "in line" on one single pipe, check again that the pipes have not moved and plug weld the holes on the top side of the pipe. Repeat this process until all 6 pipes have been plug welded on the top side.
6. Remove the cam drive bolts from each end section and turn the pipes over so you can plug weld the bottom set of holes on each pipe. Reattach the cam drive bolts when all of the plug welds are completed and tighten all bolts and nuts.
7. Apply a degreasing solution to the pipes and, using shop rags, dry the pipes removing all of the degreasing solution from the pipes. Paint all of the pipes with

the paint included and, if possible, allow the paint to dry overnight before using the reel.

Repair Parts:

- GF1038CFPR Replacement finger
- CF2181 Bearing for cam arm (small hole) →
- CF21812 Bearing for reel arm (lg. Hole)
- CF1510 Reel end shield (Sold by the piece)
- GF1038HB Metal bracket for reel finger
- KCF78532 Replacement bolt spacers for cam arms. (10/pkg)



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