



Park the CFR650 on level ground.

Lower the forks to the ground for additional stability.

Disconnect the drive shaft and hydraulic lines from the tractor before beginning any work.

Disconnect the CFR650 from the tractor hitch.

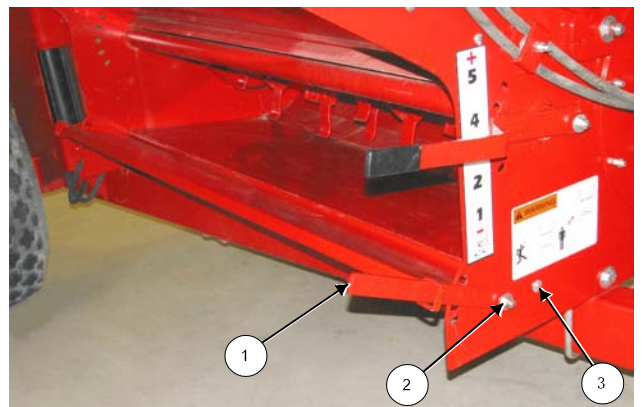
1. Ensure the CFR650 upper discharge door is locked in the upright position.



Raise Upper Discharge Door

201198

2. Remove the lower discharge door from the CFR650.
 - Remove the door handle (1) by removing the bolt and nut (2).
 - Remove the lower door by removing both bolts and nuts (3) holding the door.
 - Discard the door and fasteners.



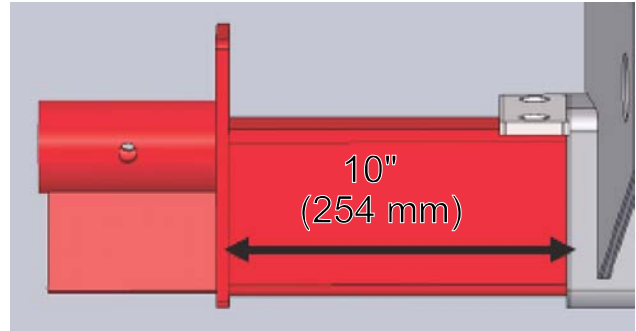
Remove the Lower Discharge Door

201208C

Assembly Instructions for the Feed Chopper on the CFR650

3. Extend the right axle.

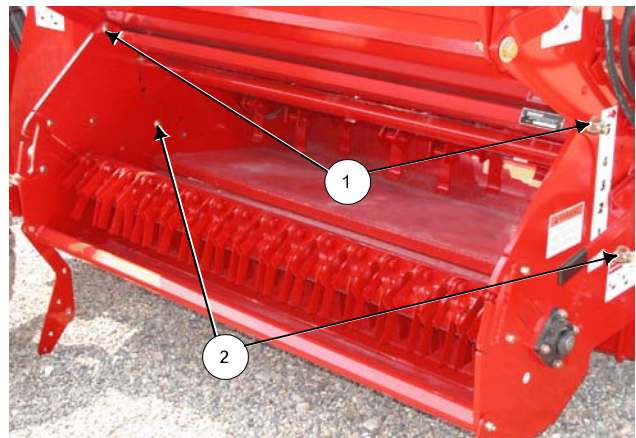
- Jack up the right wheel.
 - Place the jack under the cylinder mount and support.
- Loosen the right axle u-bolt.
- Slide the axle to be 10" from the frame to the axle plate.
- Tighten the u-bolt to 250 ft-lb (340 Nm).



Extend the Right Axle (Shown - Spindle Removed) 212030C

4. Lift the feed chopper and slide the housing into the CFR650.

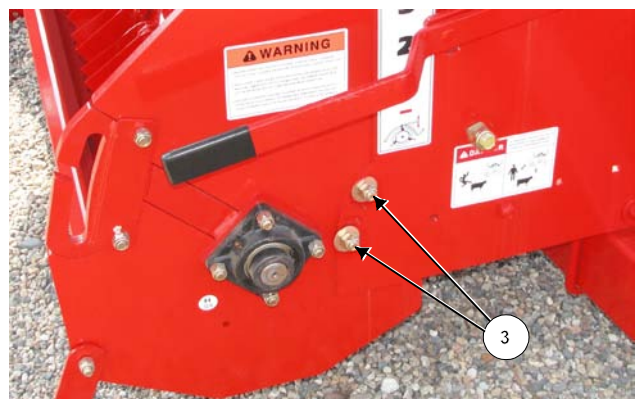
- Place the chopper between the tub walls.
- Align the upper mounting holes of the chopper housing with the mount holes in the tub wall.
 - Fasten both sides with 3/4" x 2 1/2" carriage bolts and locking nuts (1).
- Align the lower mounting holes of the chopper housing with the mount holes in the tub wall.
 - Fasten with both sides with 3/4" x 2 1/2" carriage bolts and locking nuts (2).



Slide Housing into Tub Walls 212022C

5. Align the lower portion of the chopper housing into the upper and lower mounting slots in the tub wall.

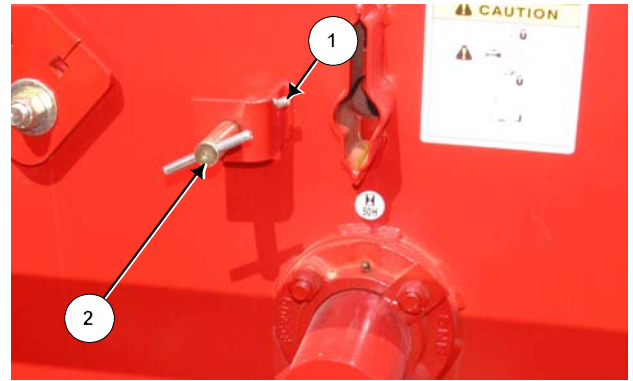
- Fasten both sides with 2 of 1/2" x 1 3/4" carriage bolts, flatwashers against the slots and locknuts (3).



Fasten Lower Portion of the Housing 212023C

6. Remove the flail drum lock mechanism from the back tub wall.

- Remove the inner roll pin (1).
- Remove the spring.
- Remove the large lock pin (2) from the tab.

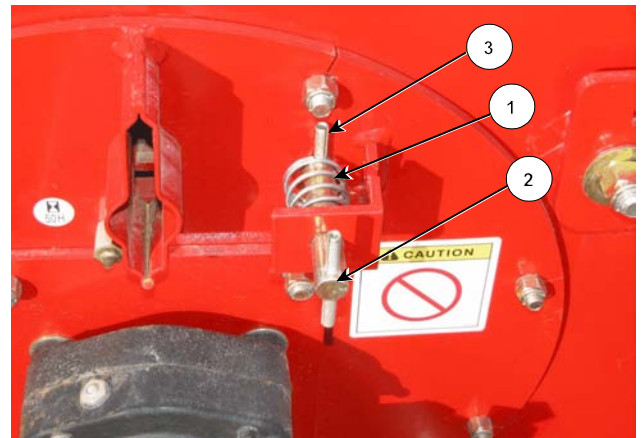


Remove Flail Drum Lock From Back Wall

212024C

7. Install the flail drum lock mechanism on the front tub wall.

- Place the spring (1) between the tab and the front tub wall.
- Insert the large pin (2) into the tab and through the spring and into the hole in the tub wall.
- Insert the roll pin (3) into the pin hole to keep pressure on the spring.



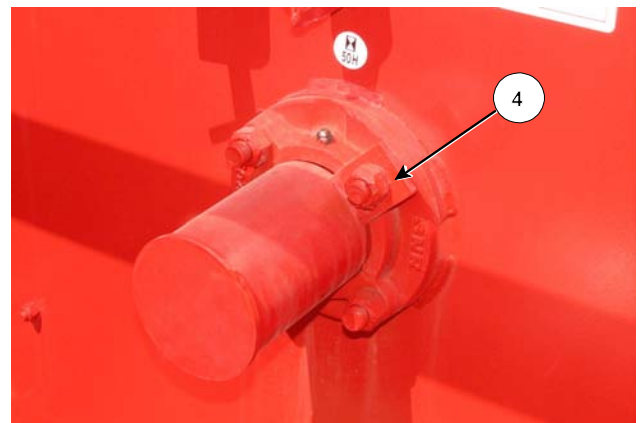
Install Flail Drum Lock On Front Wall

201233C

8. Lock the flail drum.

9. Remove the rear flail drum shaft cover located on the back tub wall.

- Remove the 2 nuts holding the cover tabs (4) onto the bearing bolts.
- Replace the nuts onto the bearing bolts.



Remove Rear Flail Shaft Cover

212025C

Assembly Instructions for the Feed Chopper on the CFR650

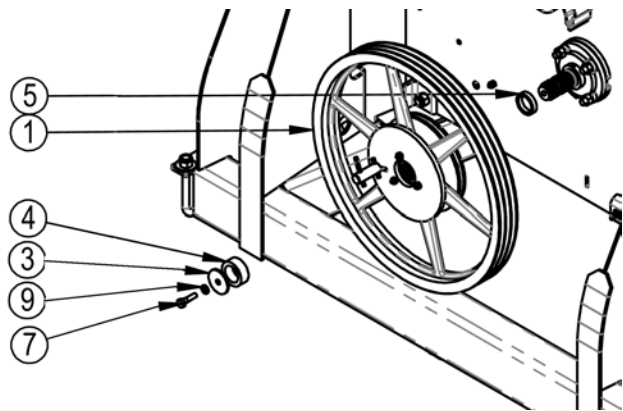
10. Engage the clutch lock on the large feed chopper sheave.
- Rotate the clutch pin until the roll pins go into the slots.
 - Push the clutch pin in and rotate until the middle roll pin (5) is behind the front plate.



Engage Clutch Lock

201256C

ITEM	DESCRIPTION	QTY.
1	ASSY,CLUTCH FC 650	1
3	PLT,FC SHEAVE	1
4	TUBE,BUSHING	1
5	SPACER,FC650	1
7	BOLT,HEX,1/2X1-3/4,UNC,GR	1
9	WASHER,LOCK,1/2,ZP	1



Components For Sheave Installation

11. Slide the spacer (5) onto the rear flail drum shaft.
12. Position the sheave so that the twine cutter opening (1) on the rear tub wall is between spokes.
13. Slide the sheave onto the splines of the rear flail drum shaft.

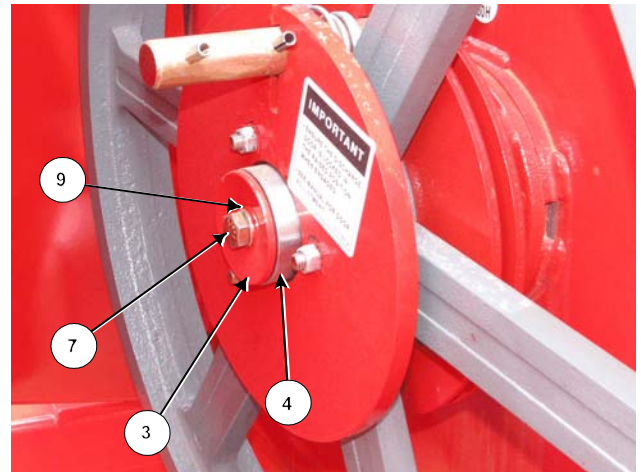


Align Sheave Spokes for Twine Cutter

212026C

Assembly Instructions for the Feed Chopper on the CFR650

14. Slide the bushing tube (4) over the spline and into the clutch.
15. Place the sheave plate (3) on the end of the drum shaft.
16. Place Loctite Blue onto the 1/2" x 1 3/4" bolt (7).
17. Fasten the sheave to the shaft with the bolt (7) and lockwasher (9).
 - Torque to 78 ft-lb (106 Nm).

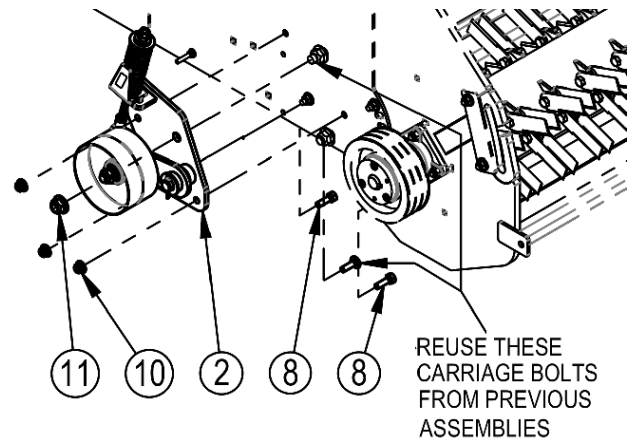


Install the Sheave on the Drum Shaft

212027C

18. Mount the spring belt tensioner onto the rear tub wall.

Item	Description	Qty
2	ASSY,TENSIONER,SPRING,FC	1
8	BOLT,HEX,1/2X1-1/2,UNC,GR5	2
10	NUT,FLG,LOCK,1/2,UNC,GR5,ZP	3
11	NUT,FLG,LOCK,3/4,UNC,GR5,ZP	1



Mount Belt Spring Tensioner

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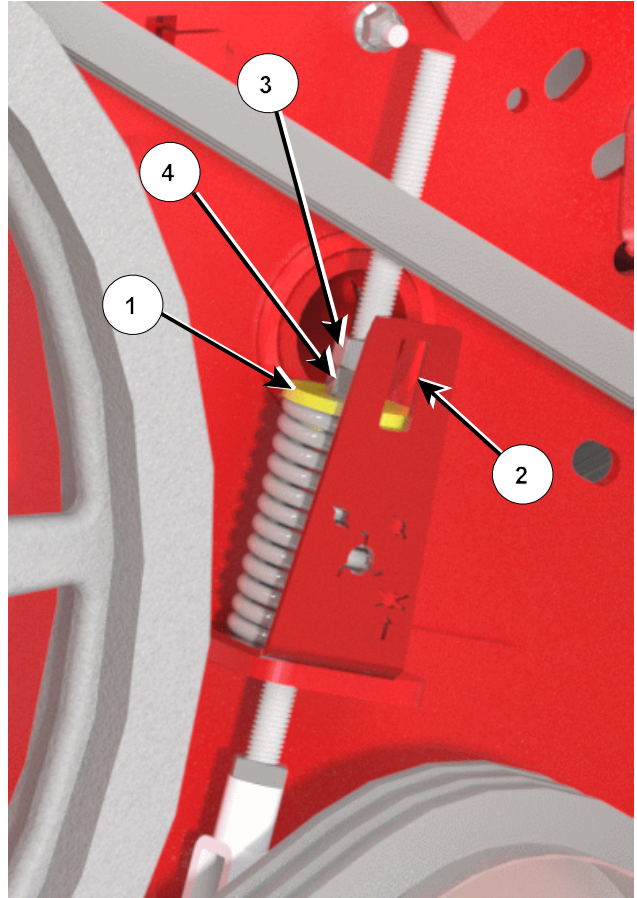
19. Install the drive belt around the large sheave, over the tensioner and around the small chopper sheave.



Install The Drive Belt

219060

20. Tighten the belt tensioner.
- Turn the nut (4) next to the spring washer to adjust the spring.
 - Tighten until the bottom of the spring washer (1) is flush with the bottom of the tension gauge window (2).
 - Tighten the jam nut (3).

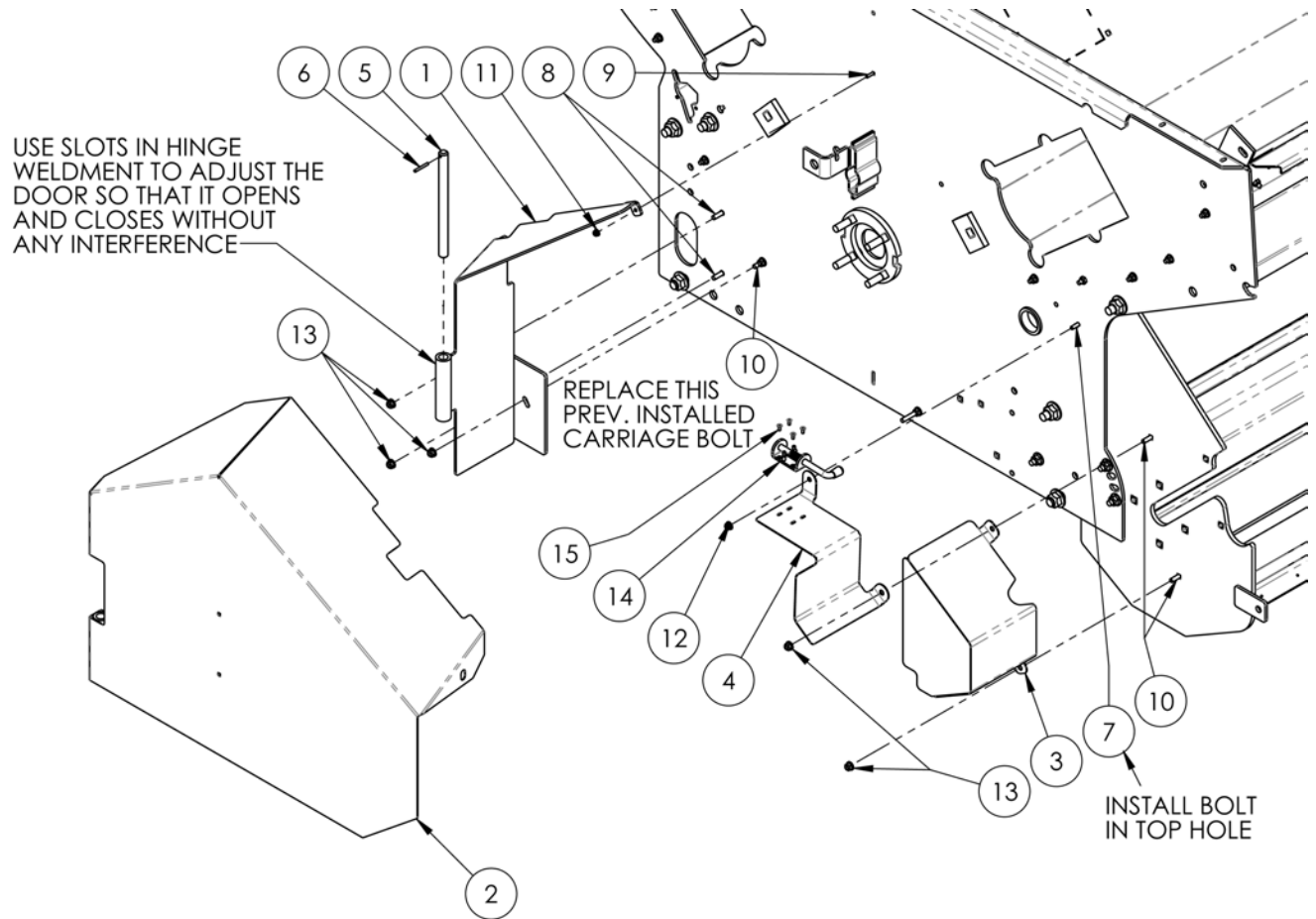


Belt Tension Spring Adjustment

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21. Install the feed chopper shields using the diagram below.

Assembly Instructions for the Feed Chopper on the CFR650



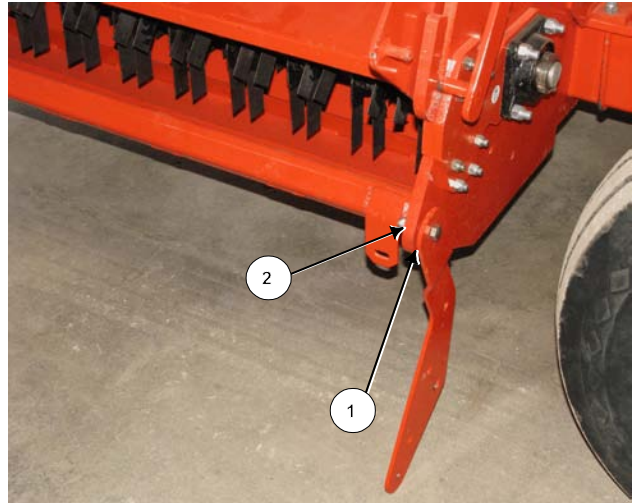
Install Shields

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ITEM	DESCRIPTION	QTY.
1	FC DOORMOUNT, SLOPED	1
2	FC, GUARDING, DOOR, SLOPED	1
3	LOWER GAURDING	1
4	PC, FC, GUARD, FILLER	1
5	SHAFT, FC GUARD DOOR HINGEPIN	1
6	PIN, SPRING, 3/16X1-1/2	1
7	BOLT, HEX, 5/16X1, UNC, GR5, ZP	1
8	BOLT, HEX, 3/8X1-1/4, UNC, GR5, ZP	2
9	BOLT, CARR, 1/4X1, UNC, GR5, ZP	1
10	BOLT, CARR, 3/8X1-1/4, GR5, ZP	3
11	NUT, FLG, LOCK, 1/4, UNC, GR5, ZP	1
12	NUT, FLG, LOCK, 5/16, UNC, GR5, ZP	1
13	NUT, FLG, LOCK, 3/8, UNC, GR5, ZP	5
14	LATCH, BOLT, SPRING	1
15	RIVET, ST, 3/16X.440, .375 HEAD	4

Assembly Instructions for the Feed Chopper on the CFR650

22. Install the left and right door support brackets.
- Set the brackets on the outside of the chopper housing.
 - Position them to have the offset bend toward the center of the chopper.
 - Place 2 flat washers (1) between the bracket and the chopper housing.
 - Insert a $\frac{1}{2}$ " x $1 \frac{3}{4}$ " bolt.
 - Place 1 flat washer (2) on the bolt next to the locknut.
 - Tighten the locknut but allow the bracket to freely move around the bolt.
23. Slide the chopper door into the housing.
- Place the rods of the door handles (1) into the slots.
 - Allow the door to go to the bottom of the slots.



Install Door Support Brackets

109126C

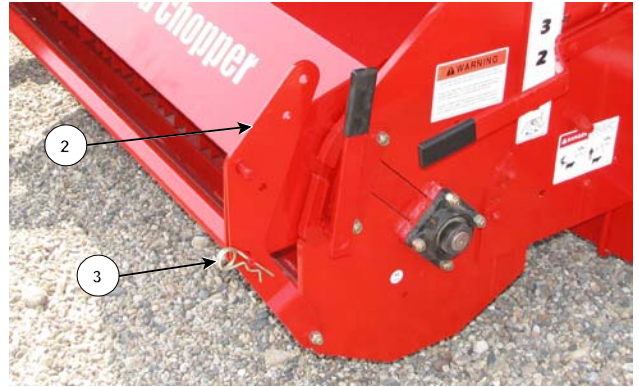


Install the Feed Chopper Door

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Assembly Instructions for the Feed Chopper on the CFR650

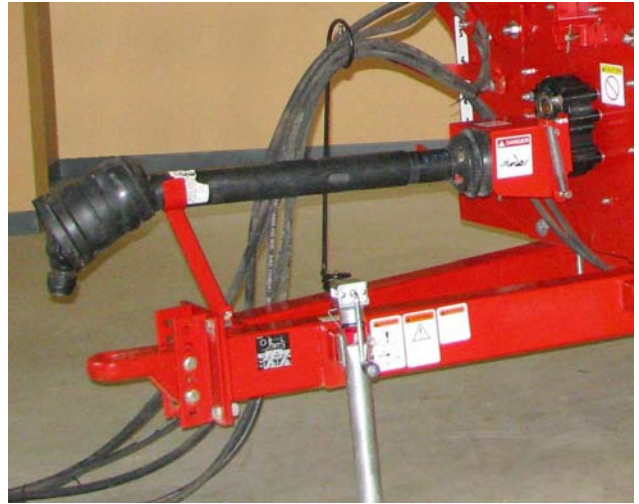
24. Rotate the chopper door to the Feed Chopper operating position
- Fasten with the door support brackets (2).
 - Secure in place with the hairpins (3).



Rotate the Door to the Operating Position

212038

25. Remove the Category 4 driveline from the flail drum drive box.
- Install the new Category 6 driveline that is required when a feed chopper is installed.



Install Category 6 Driveline

211204