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INSTALLATION OF THE PNEUMATIC ELEVATOR LINER KIT FOR AMADAS PULL TYPE PEANUT COMBINE

**PLEASE REFER TO THE OPERATORS MANUAL FOR YOUR
SPECIFIC COMBINE FOR PERTINENT SAFETY PRECAUTIONS**

THE TERMS "LEFT", "RIGHT", "FRONT", and "REAR " ARE DETERMINED BY
FACING IN THE DIRECTION THE COMBINE WILL TRAVEL WHEN IN USE.

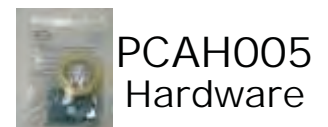
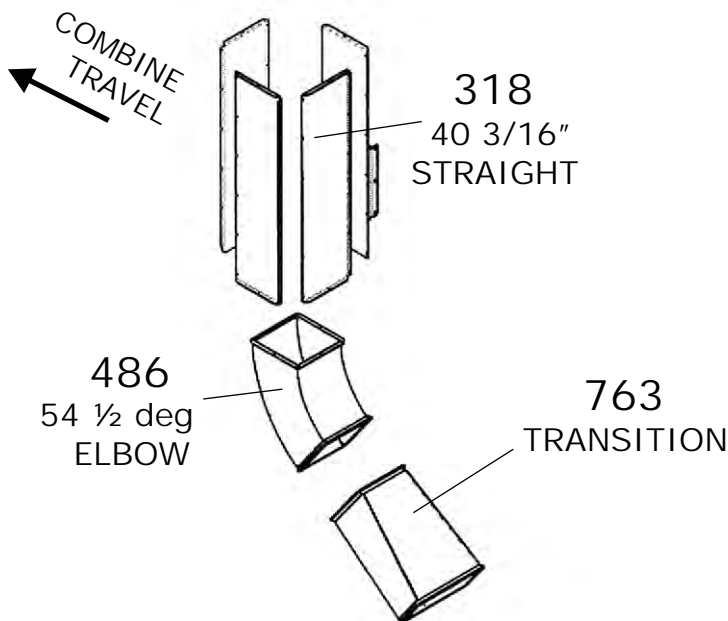
1. Compare the contents with the following parts list to confirm that you have received the correct panels and hardware package for your model combine.

KIT NO: PCAK005 for MODELS M2100D and M2100T
Beginning Serial # 440000

NOTE: Duct 318 is constructed
from 4ea bolt-together
walls or panels.

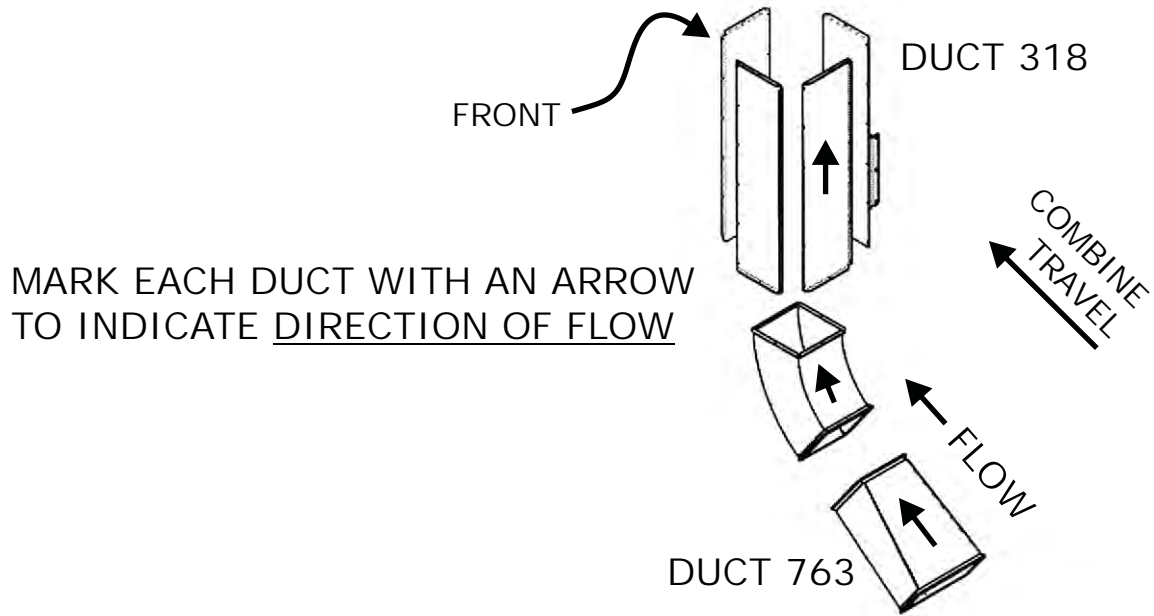
(If your duct is welded, you need kit PCAK004)

KIT SHOULD CONTAIN THE
FOLLOWING BUNDLES:



Questions or comments call
1-800-542-7659
IPCAK005_31JUL07

2. **IMPORTANT**: Before removing the ducts from the combine, mark each duct as shown below with the marker included in the hardware package.



LABEL THE FRONT SIDE OF DUCT 318

LABEL THE BOTTOM OF DUCT 763

3. Remove ducts and thoroughly clean both inside and out.

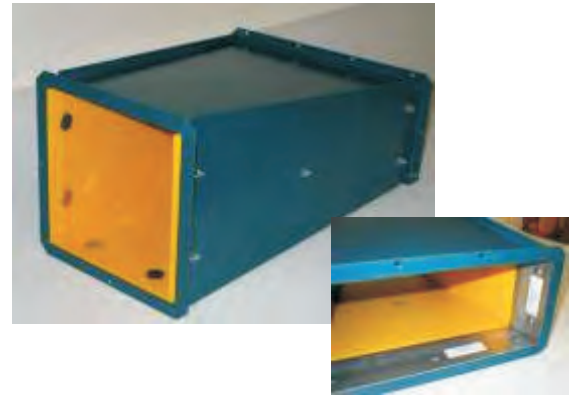


FLUSH OUT ALL SOIL AND CROP RESIDUE FROM INSIDE THE CIRCULAR OPENINGS.



SECTION I

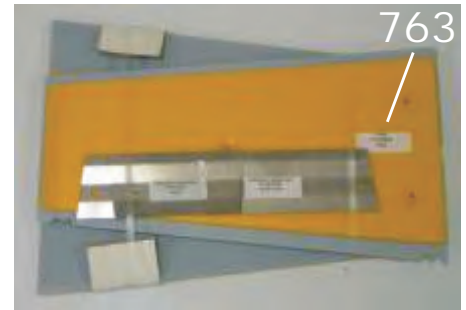
THE FIRST SECTION WILL DESCRIBE THE INSTALLATION OF THE BOTTOM AND TWO SIDE LINERS OF DUCT NUMBER 763. (SEE DRAWING ON FRONT PAGE)



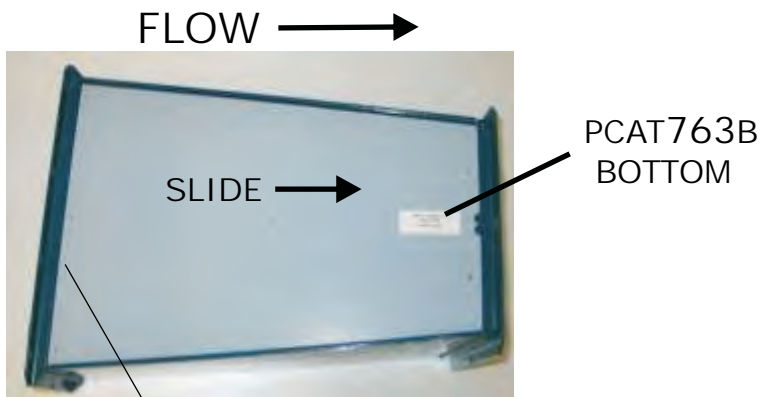
PLEASE READ THE ENTIRE SECTION BEFORE STARTING INSTALLATION.

- Starting with the bundle marked 763, place the drill guide marked DRILL TEMPLATE PCAT763B BOTTOM on the bottom of the duct as illustrated below.

NOTE: BOTTOM WAS MARKED IN STEP 2.

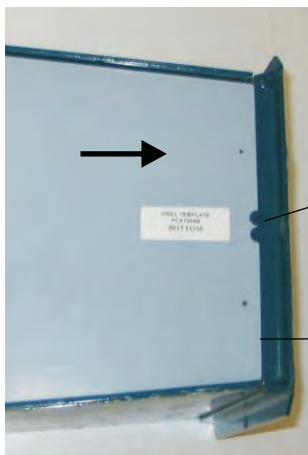
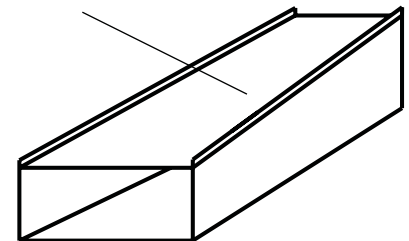


Contains: Bottom - Left and Right liners
2- Templates 3- Stainless Transitions



MAY HAVE GAP AT THIS END

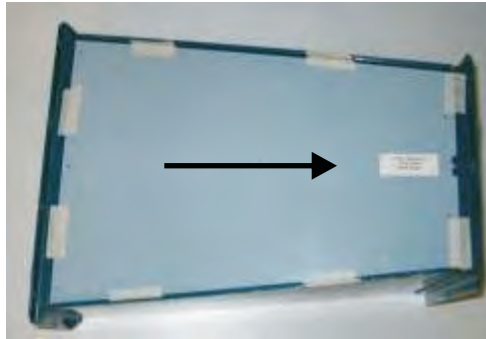
CENTER TEMPLATE BETWEEN FLANGES



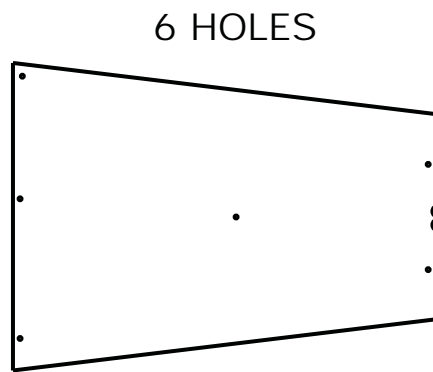
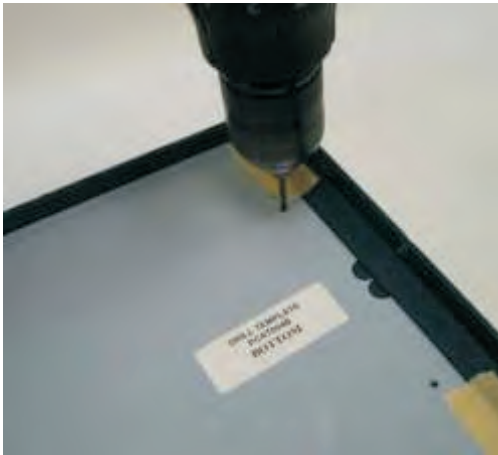
POSITION TEMPLATE SO THAT POINTER ON END OF TEMPLATE POINTS IN DIRECTION OF FLOW.

SLIDE TEMPLATE AGAINST THE EDGE OF THE ANGLE FLANGE

5. With the drill template held against the angle flange, secure template with the masking tape supplied.



6. Spot drill at each of the 6 hole locations with the 1/8 inch drill bit supplied.
DO NOT DRILL THRU.



7. Remove the drill template and drill thru with the 1/8 inch drill bit.....

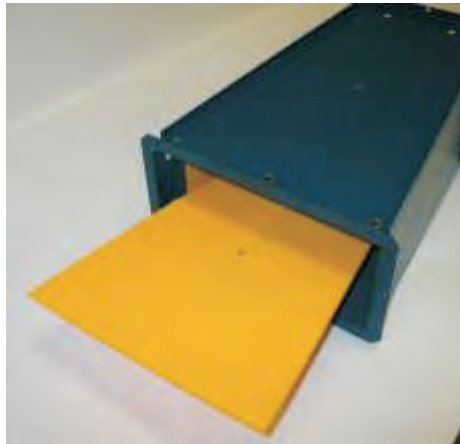
then enlarge all holes with the 7/16 inch drill bit supplied.



8. IMPORTANT - Remove all burrs from inside the duct.



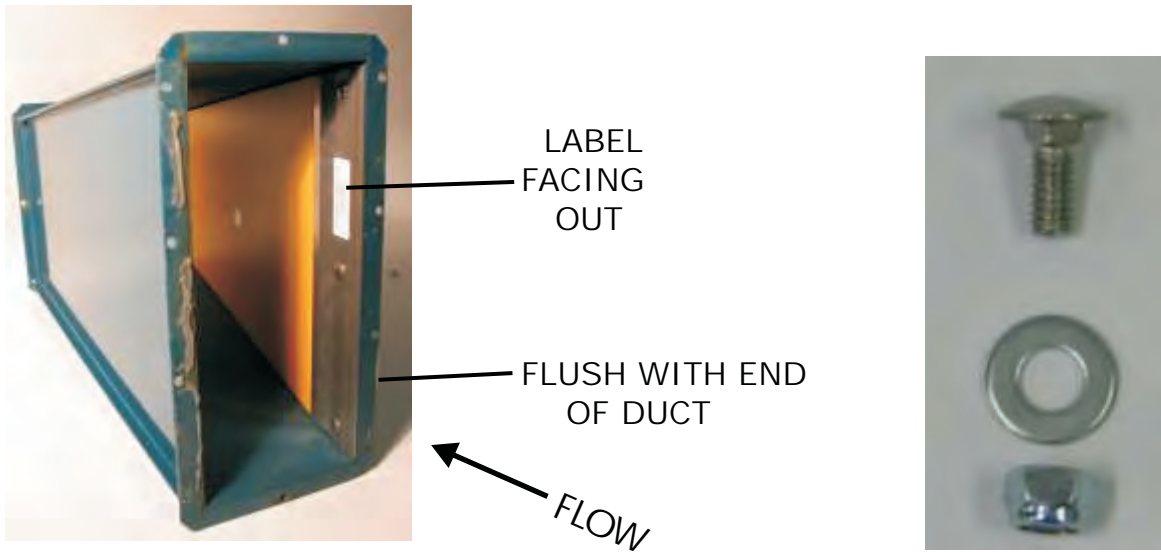
9. Insert the liner labeled LINER PCAL763B BOTTOM as illustrated below.



10. Loosely secure liner with three 1/4-20 x 3/4 elevator bolts, washers, and lock nuts.
DO NOT TIGHTEN AT THIS TIME.



11. Install the stainless steel transition labeled PCAST763B as shown below and secure with the 1/4-20 x 5/8 carriage bolts.



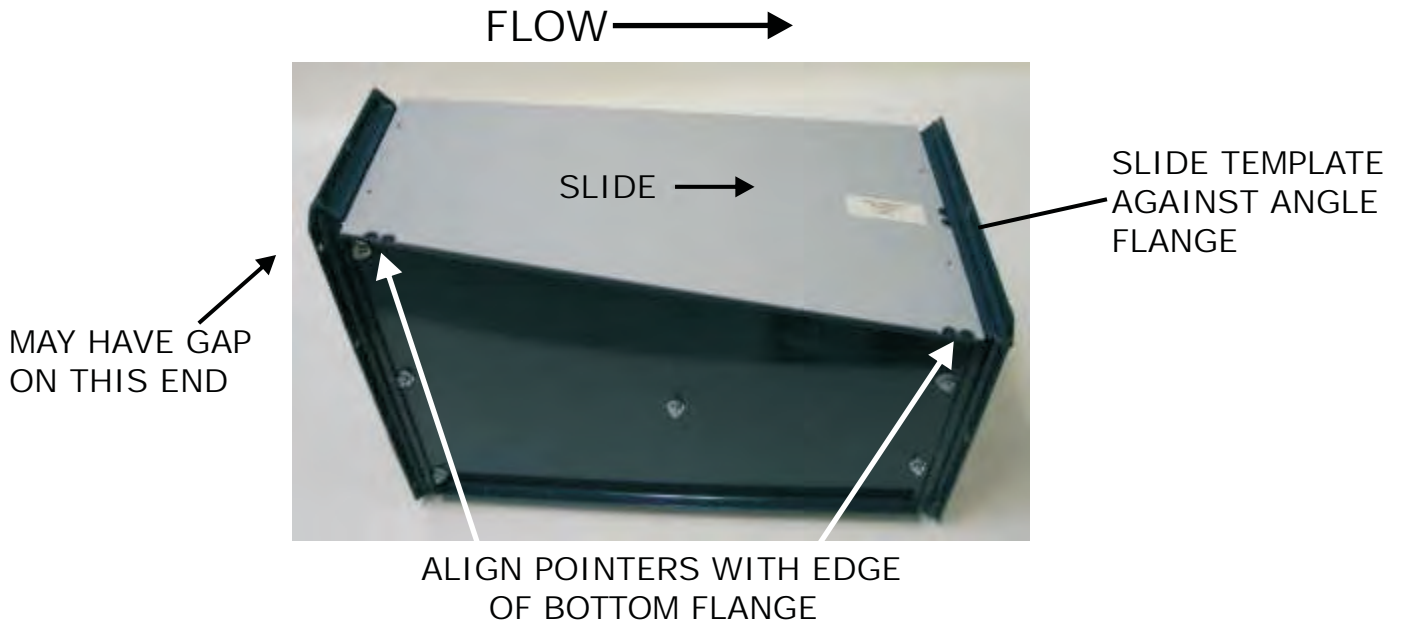
IMPORTANT:

12. Tighten the three elevator bolts to firmly seat the head of the bolt, then **loosen the nut 3/4 TURN.**

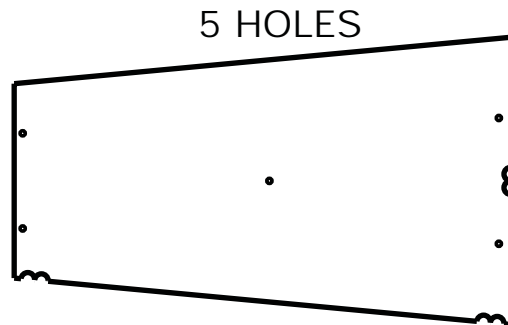


INSTALLATION OF 763 SIDE LINERS

13. Position the template labeled DRILL TEMPLATE PCAT763S SIDE as shown below.



14. Secure template with masking tape and spot drill the 5 hole locations with the 1/8 inch drill bit.



15. Remove the drill template and drill thru with the 1/8 inch drill bit.....

then enlarge all holes with the 7/16 inch drill bit supplied. Remove burrs.



16. Insert one of the side liners labeled LINER PCAL763S SIDE and loosely bolt in place with the elevator bolts. **DO NOT TIGHTEN AT THIS TIME.**



17. Apply a generous (1/4") bead of silicone sealant in the bottom right corner of the duct as shown below.



18. Install the stainless steel transition labeled PCAST004R as shown below and secure with 1/4-20 x 5/8 carriage bolts.



← FLOW

REMOVE EXCESS SEALANT.



19. Tighten the three elevator bolts to firmly seat the head of the bolt, then **loosen the nut 3/4 TURN.**

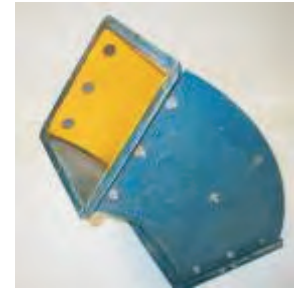


20. Repeat Steps 13 thru 19 to install left side liner using the opposite side of the same drill template.

SECTION II

DUCT 486 ELBOW

PLEASE READ ENTIRE SECTION BEFORE STARTING INSTALLATION



Contains: Center - 2 Sides 2 - Templates



486

21. Position the DRILL TEMPLATE 486 CENTER on the elbow as illustrated below.

FLOW →

MAY HAVE GAP THIS END

POINTER IN DIRECTION OF FLOW

SLIDE TEMPLATE AGAINST ANGLE 6 HOLES

22. Secure with masking tape and spot drill the 6 hole locations.



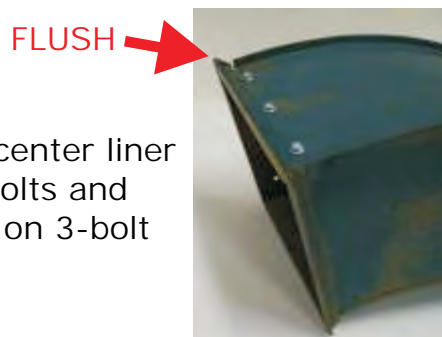
Remove template and drill thru with 1/8 inch drill bit...



then enlarge all holes with 7/16 inch bit.



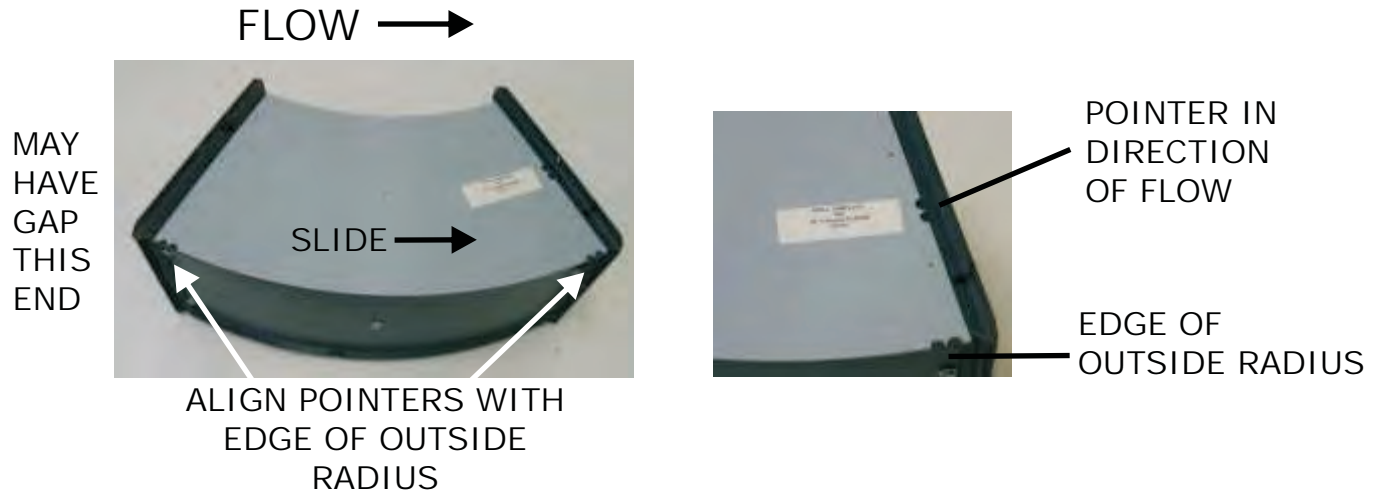
23. Loosely install the center liner with the elevator bolts and position liner flush on 3-bolt end.



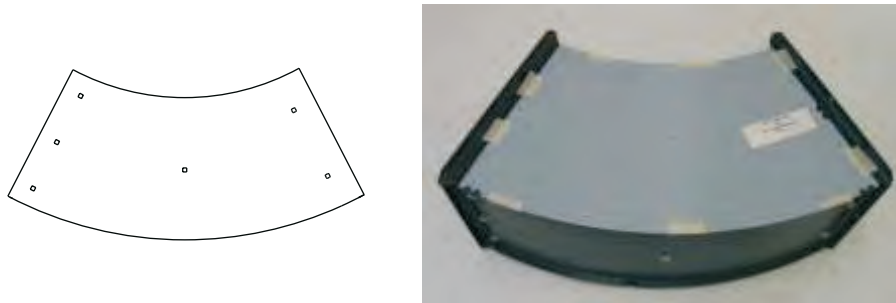
Starting on the 3-bolt end, tighten the bolts then loosen nut **3/4 turn.**

INSTALLATION OF 486 SIDE LINERS

24. Position the drill guide labeled DRILL TEMPLATE 486 SIDE on the elbow as illustrated below.



25. Secure with tape and spot drill the 6 hole locations.



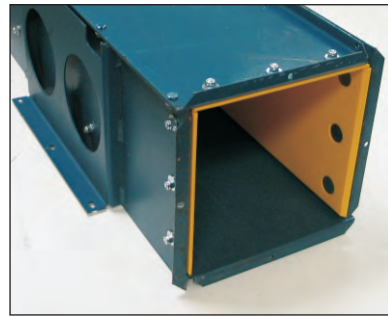
26. Remove template and drill thru with 1/8 inch drill bit then enlarge all holes to 7/16".

27. Remove burrs and install side liner FLUSH WITH 3-BOLT END.
TIGHTEN BOLTS THEN LOOSEN NUT 3/4 TURN.

28. Repeat process for the other side using the opposite side of the same template.

SECTION III

DUCT 318



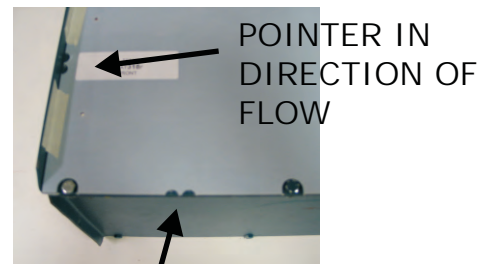
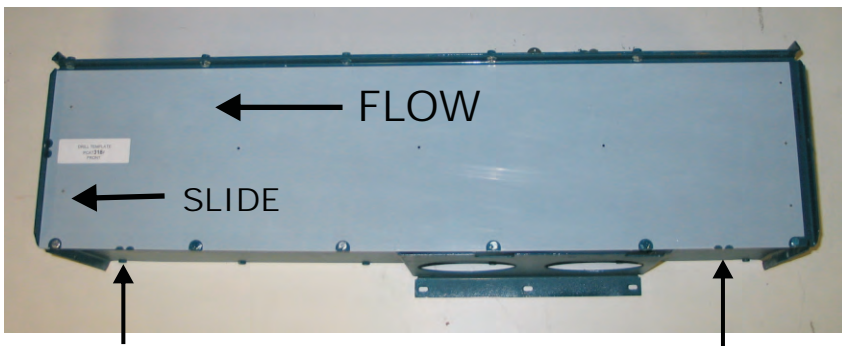
FRONT

Contains: Front & 2 Sides
5 - Templates



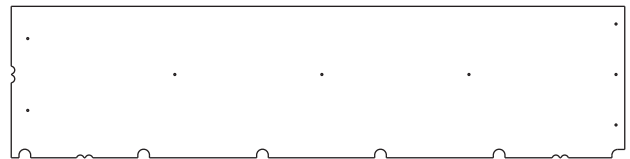
318

29. Position DRILL TEMPLATE PCAT318F FRONT on the side of the duct labeled "**FRONT**" as illustrated below. (SEE STEP 2 on PAGE 2)



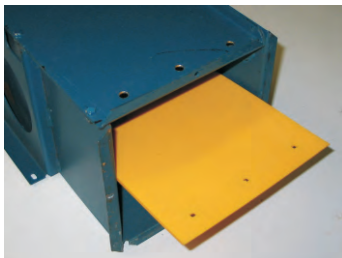
FLUSH WITH OUTSIDE EDGE

30. Slide template in direction of FLOW until pointer is against end flange. Position side pointers flush with edge of duct. Secure with tape.



8 HOLES

31. Spot drill the 8 hole locations.
32. Remove the template and drill thru with the 1/8" bit then enlarge all holes to 7/16".
33. Remove all burrs and loosely install liner labeled PCAL764F FRONT.

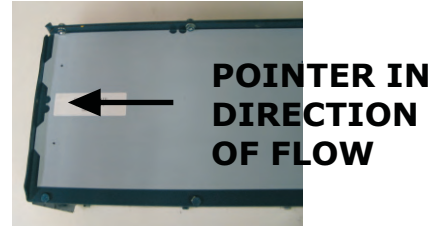


34. Position liner **FLUSH WITH 3 BOLT END**. Tighten bolts then loosen nut 3/4 turn.

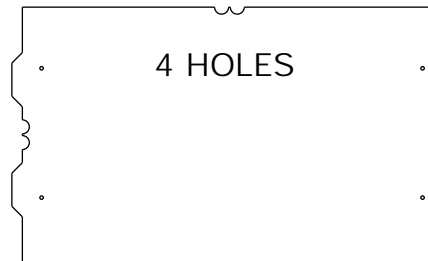
DUCT 318 RIGHT SIDE

35. Position DRILL TEMPLATE PCAT318SR-1 as shown below.

← FLOW



36. Secure the template and spot drill the 4 hole locations.



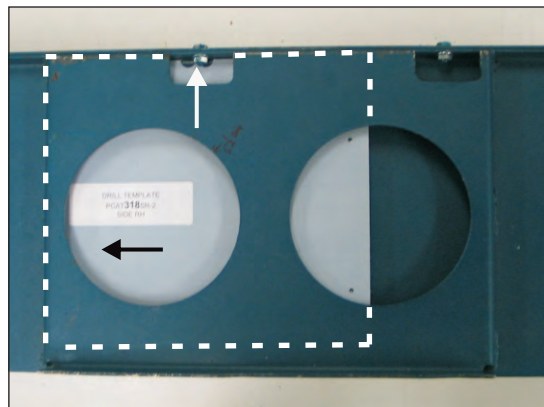
37. Remove the template. Drill thru with 1/8 " bit then enlarge holes to 7/16 " .

38. Insert DRILL TEMPLATE PCAT318SR-2 inside the metal housing.



39. Slide the template to the corner of the pocket as illustrated below.

NOTE: POCKET INSIDE OPENING MUST BE CLEAR OF ALL SOIL AND CROP RESIDUE.



40. Secure template then spot drill the two hole locations.



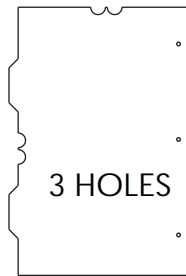
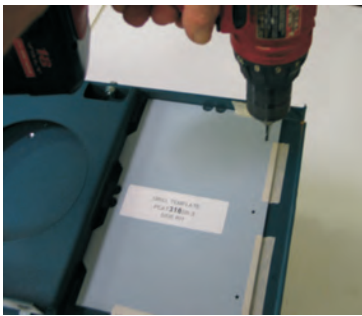
41. Remove template, drill thru and then enlarge both holes.

42. Position DRILL TEMPLATE PCAT318SR-3 as shown below.

← FLOW



43. Secure template, spot drill, remove template, drill thru, then enlarge holes.



44. Remove burrs and install liner PCAL318SR FLUSH WITH THE THREE BOLT END.

TIGHTEN THE BOLTS TO SEAT THE HEAD OF THE BOLT THEN LOOSEN NUT 3/4 TURN.



FLUSH



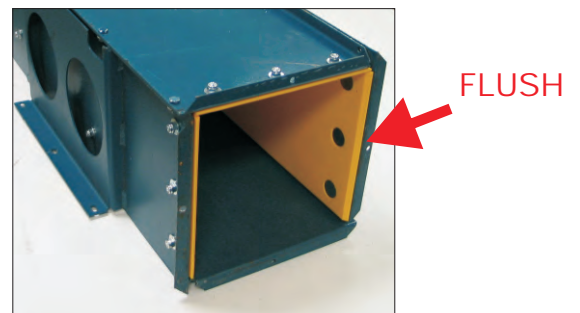
DUCT 764 LEFT SIDE

45. Drill the left side of the duct using DRILL TEMPLATE PCAT318SL.

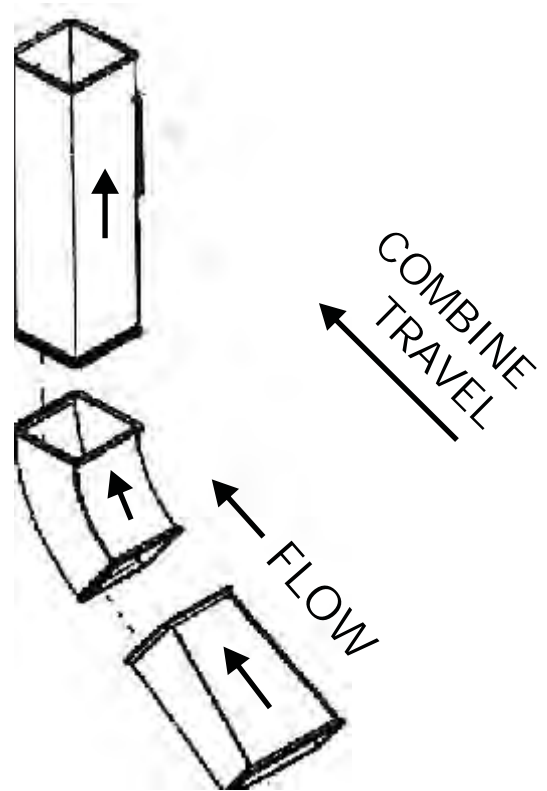
← FLOW



46. Install the remaining liner PCAL764S as described in previous steps.



47. Re-install the ducts in their original location with the 1/4-20 x 3/4 hex head bolts supplied.



SEAL EACH JOINT WITH SILICONE SEALANT AS YOU RE-INSTALL THE DUCTS

