

# SERVICE INFORMATION

## Service Information Bulletin

**BULLETIN NO:** 01.10/05

**DATE:** June 28, 2005

**TO:** **LEXION** Combine Dealers  
**FROM:** CLAAS Omaha LLC Product Support Department  
**SUBJECT:** Gib Head Key Installation  
**EFFECTIVE DATE:** June 28, 2005

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**NOTE:** Service Information bulletins Do Not constitute warranty authorization to update units.

**MACHINES AFFECTED:** Lexion 400 Series Combines  
Lexion 500 Series Combines  
Lexion Flex Heads  
Lexion Grain Heads

**PARTS AFFECTED:**

Quantity	CLAAS #	Description
1	007 614.0 for example	Gib Head Key, 10x8x45 mm

**INFORMATION:** During reassembly of a pulley or sprocket to a mating shaft, it is recommended to replace the gib head key that was removed during disassembly. The existing gib head key may have been damaged during disassembly and not provide a suitable fit when reassembled. The various size gib head keys have fitting material on the bottom of the key. This Service Information bulletin provides details in the proper fitting of any of the various size gib head keys used on all Lexion products.

**Installation Instructions**  
**Gib Head Key, Shaft and Pulley Assembly**

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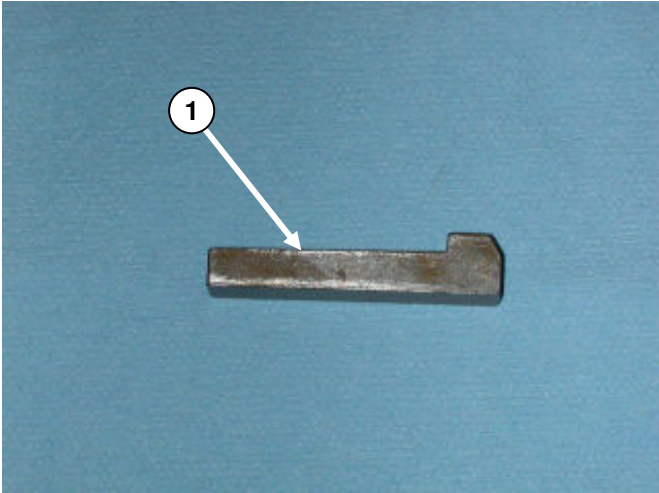
**LABOR ALLOWED:** N/A

**TRAVEL ALLOWANCE:** N/A

**REIMBURSEMENT:** N/A

**PARTS REQUIRED:**

Item	Quantity	CLAAS #	Description
1	1	007 614.0	Gib Head Key, 10x8x45 mm



## Installation Instructions

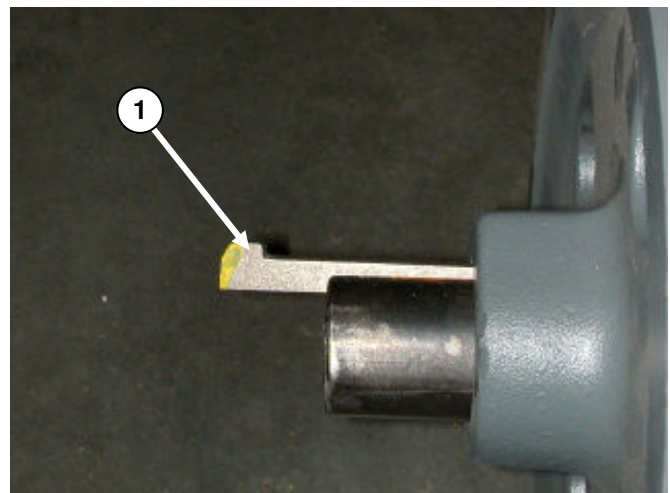
### Gib Head Key, Shaft and Pulley Assembly

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- Switch off machine, switch off battery disconnect switch. Secure machine so that it cannot move.
  
- Remove the existing gib key from the sprocket and shaft assembly. It is recommended to drive the sprocket or gear using a suitable tool or driver away from the gib head key. Then use the gib key wedge tool to remove the key.

- Prior to installing gib head key in shaft and pulley or sprocket, align the pulleys or sprocket to prevent premature wear to the chain or belt.

- Insert the gib key (1) into the key way and slightly tap in the key. Note the distance the key head is from the sprocket or pulley hub.

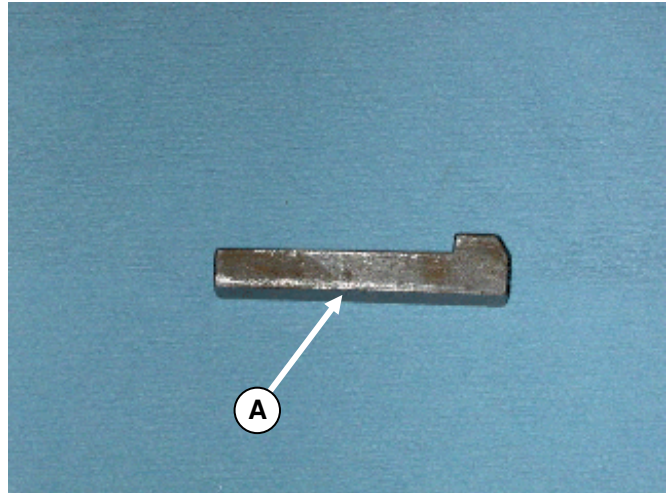


## Installation Instructions Gib Head Key, Shaft and Pulley Assembly

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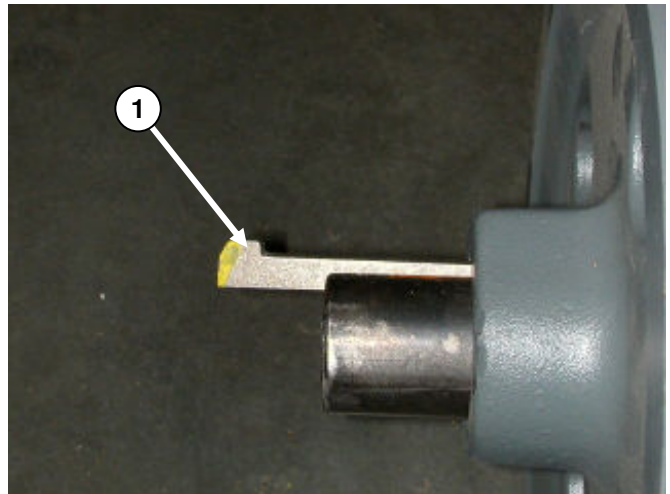
- Remove the gib key using the wedge tool.

- Then file or grind some material off of the bottom side (A) of the gib key. Do not remove an excessive amount of material.



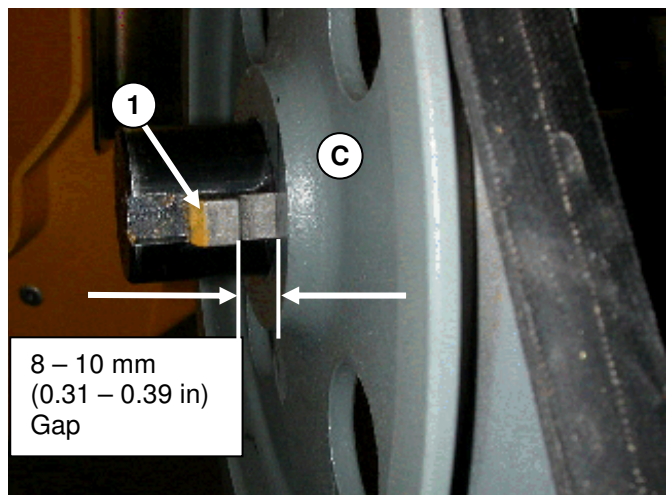
- Repeat installing the key in the key way.

- Insert the gib key (1) into the key way and slightly tap in the key. Note the distance the key head is from the sprocket or pulley hub.



- Continue the removal of material from the bottom of the key until there is a 12 – 14 mm (0.47 – 0.55 in) gap between the key head and the sprocket or pulley.

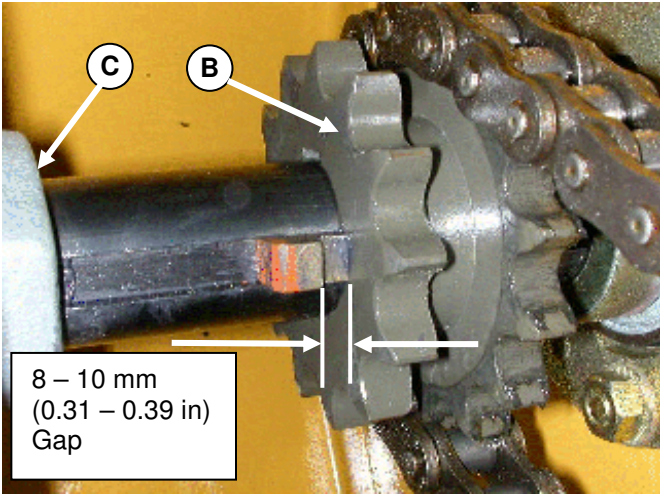
Then drive the gib key (1) into the key way to set the key. Try to maintain an 8 – 10 mm (0.31 – 0.39 in) gap between the key and sprocket or pulley (C). This will facilitate removal of the gib key using the wedge tool. Please note the following examples.



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**Gib Head Key, Shaft and Pulley Assembly**

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- Example #1- Sprocket (B) and Pulley (C) on same shaft.



- Example #2- Sprocket (D) on shaft. Also some gib keys must be installed with the head flush with the end of the shaft when the key is set.

