



Rotalink Update Kit

For Procore® 440, 660 & 880 Aerators

Part No. 104-9910
Part No. 104-9911
Part No. 104-9912

Installation Instructions

Note: Use this chart as a checklist to ensure that all parts necessary for assembly have been received. Without these parts, total assembly cannot be completed.

Part Description	440	660	880
Rotalink arm assembly	4	6	8
Serrated flange bolt (M10-1.5)	8	12	16
Angle	1	1	1
Flat washer	4	6	8
Collar tube	0	3	4
Left hand hex head bolt (M12-1.7 x 30)	2	0	0
Hex head bolt (M16-2 x 35)	0	6	8
Hex head bolt (M12-1.75 x 30)	2	0	0
Flat washer	2	3	4
Hex head bolt (M12-1.75 x 25)	0	3	4
Assembly washer	1	1	1
Hex head bolt (M10-1.5 x 45)	1	1	1
Installation Instructions	1	1	1

Replace Rotalink Arm Assemblies

- Loosen bolt, spacer, and nut securing the center of bottom links together (Fig. 1).
- Remove bolt, flat washer, and lock washer securing bottom links to Rotalink arm (Fig. 1).
- Remove and discard 2 bolts, flat washers, and lock washers mounting the Rotalink brackets to frame (Fig. 2).
- Remove 2 bolts, flat washers, and nuts securing bracket to the Rotalink element (Fig. 2).
- Remove bolt, flat washer, and nut clamping the arm to the Rotalink element (Fig. 2). Remove and retain Rotalink element from Rotalink arm. Discard Rotalink arm.
- Insert Rotalink element into new Rotalink arm.

Note: Do not assemble the bolt, flat washer, and nut clamping the arm to the Rotalink element.

- Remount Rotalink element to bracket with 2 bolts, flat washers, and nuts previously removed (Fig. 2). Torque bolts to 66 ft.-lb. (89 N·m).

- Mount the Rotalink bracket and new angle bracket to the frame with 2 serrated flange bolts (M10-1.5) (Fig. 2). Torque bolts to 38 ft.-lb. (51 N·m).

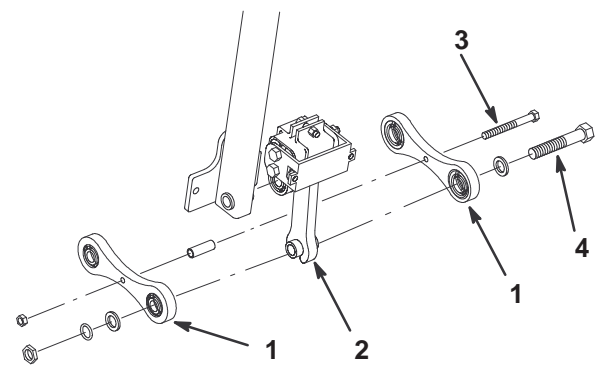


Figure 1

- Bottom links
- Rotalink arm
- Loosen these
- Remove these

- Repeat all procedures on remaining assemblies.

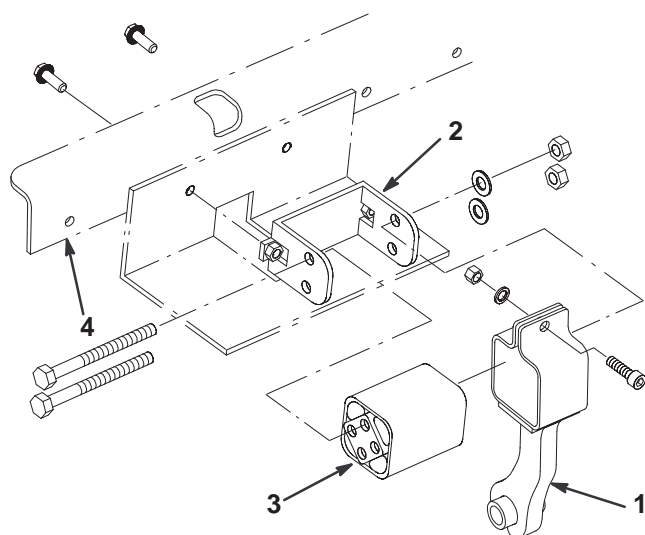


Figure 2

- | | |
|---------------------|---------------------|
| 1. Rotalink | 3. Rotalink element |
| 2. Rotalink bracket | 4. Angle bracket |

Update Tine Arm to Pulley Mounting Fasteners

(ProCore 660 and 880 Aerators only)

1. Remove the bolt, lock washer, and flat washer securing the tine arm to the pulley (Fig. 3).

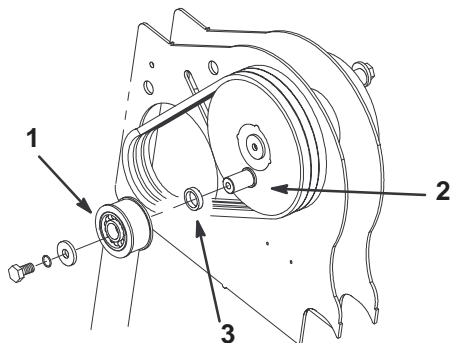


Figure 3

- | | |
|-------------|-------------------------------------|
| 1. Tine arm | 3. New tube collar (660 & 880 only) |
| 2. Pulley | |
2. Slide arm off pulley pin (Fig. 3).
 3. Install new tube collar onto pulley pin and over the shoulder (Fig. 3).
 4. Install tine arm onto pulley pin and secure with a new (10 mm thick) washer, old lock washer, and new bolt (M16-2 x 35) (Fig. 3). Torque bolt to 166 ft.-lb. (225 N·m).

Update Tine Arm to Flywheel Mounting Fasteners

(ProCore 660 and 880 Aerators only)

1. Remove the bolt, lock washer, and flat washer securing the tine arm to the flywheel.
2. Secure tine arm to the flywheel with new flat washer, old lock washer, and new bolt (M16-2 x 35). Torque bolt to 166 ft.-lb. (225 N·m).

Update Tine Arm Mounting Fasteners

(ProCore 440 Aerators only)

1. Remove the bolt, lock washer, and flat washer securing the tine arm to the pulley (Fig. 3).

Note: Position left and right-hand threaded bolts as shown in Figure 4.

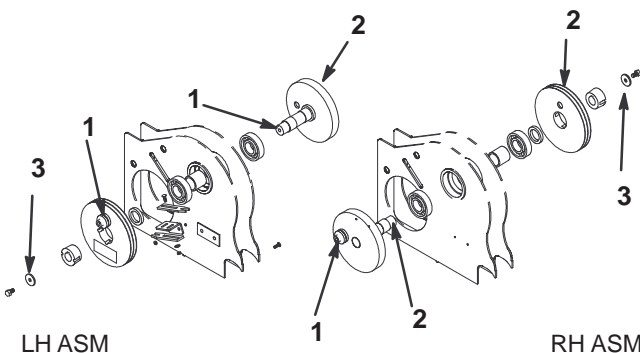


Figure 4

- | | |
|----------------------|----------------------|
| 1. Left hand thread | 3. Taper lock washer |
| 2. Right hand thread | |

2. Secure tine arm to pulley with a new (10 mm thick) washer, old lock washer, and new bolt (M16-2 x 35) (Fig. 3). Torque bolt to 66 ft.-lb. (89 N·m).
3. Repeat procedure on flywheel side.

Update Taper-Lock Mounting Fasteners

Note: Make sure taper-lock setscrews are fastened securely. The correct torquing procedure is in the Aerator Operators Manual.

1. Remove bolt and washer securing taper-lock washer to flywheel (Fig. 4).
2. Insert new (4 mm thick) washer onto shaft.
3. On 440 Aerators, secure washer to shaft with bolt previously removed. Torque bolt to 66 ft.-lb. (89 N·m).
4. On 660 & 880 Aerators, secure washer to shaft with a new bolt (M12-1.75 x 25). Torque bolt to 66 ft.-lb. (89 N·m).

Assemble Rotalinks to Bottom Links

1. Install bolt, flat washer, and lock washer securing bottom links to Rotalink arm (Fig. 1). Torque bolt to 150 ft.-lb. (203 N·m).
2. Install bolt, flat washer, and nut clamping the arm to the Rotalink element (Fig. 2). Torque bolt to 38 ft.-lb. (51 N·m).
3. Tighten the bolt securing the center of bottom links together. Torque bolt to 38 ft.-lb. (51 N·m).

Note: Arm should be centered between links.

Store Assembly Washer

1. Remove 1 of the R-clamp bolts, lock washers, and nuts securing manual tube to frame (Fig. 5).
2. Install R-clamp assembly washer to frame with new hex head bolt (M10-1.5 x 45), new assembly washer, old lock washer, and old nut (Fig. 5). Torque bolt to 38 ft.-lb. (51 N·m).

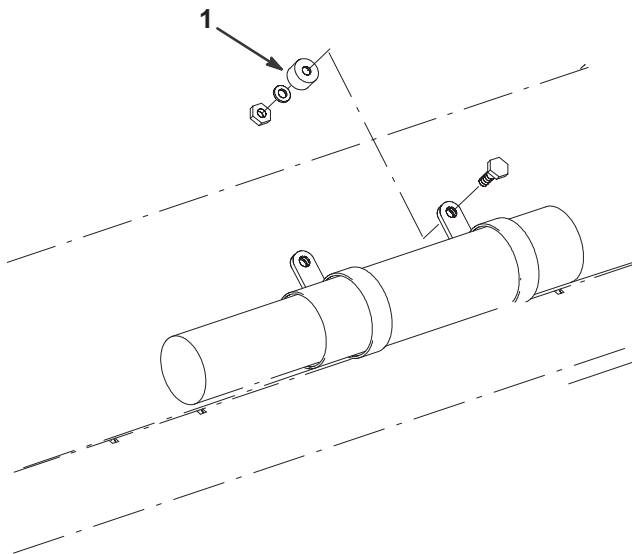


Figure 5

1. Assembly washer

Note: Assembly washer is used to ensure that the proper clamp load is achieved upon re-assembly of the pulley/flywheel when being serviced. The use of the existing washer and bolt is still required.

