

**MacDon**

# **R113 and R116 Rotary Disc Headers**

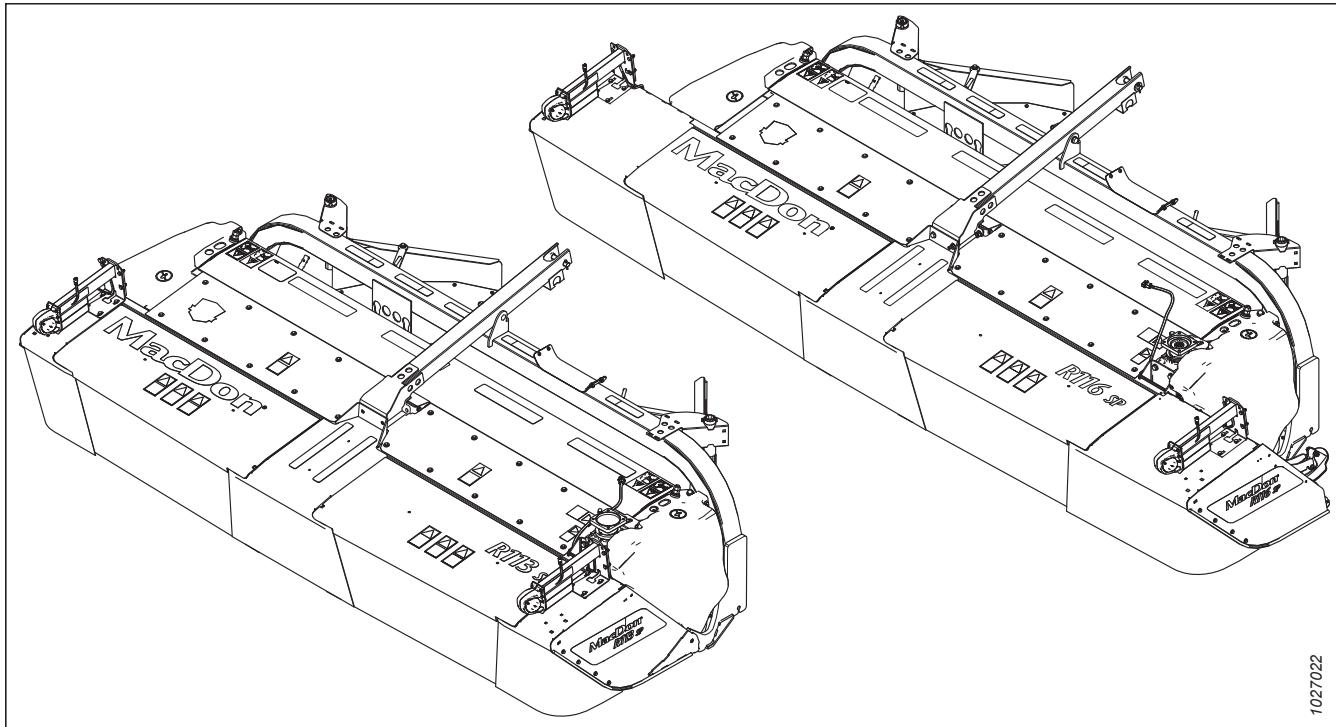
**Parts Catalog**

**262298 Revision A**

**Original Instruction**

***The Harvesting Specialists.***

## R113 and R116 Rotary Disc Headers



Published: September 2023

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## Introduction

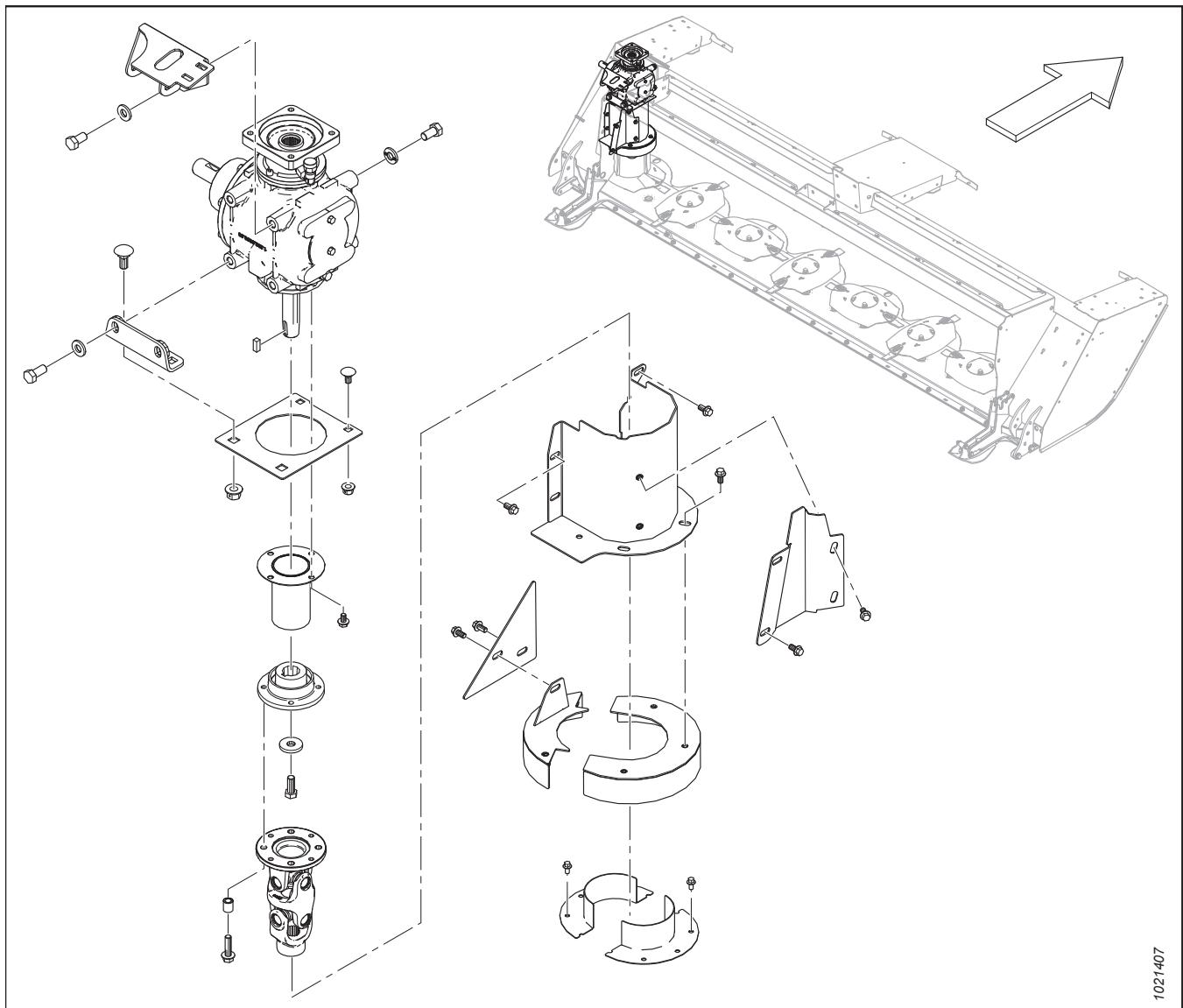
This Parts Catalog lists all the replacement parts that can be ordered for MacDon R113 and R116 Rotary Disc Headers.

When ordering, be sure to use the complete and proper part number. Some parts vary with header size; be sure you are ordering the correct part number for your unit.

**Bold text is used to indicate updates made at the current revision level.** With each new revision of the catalog, previous revisions are returned to regular text.

Electrical connectors used on MacDon products are available for sale but not listed in this catalog. For the list of available connectors, refer to the Electrical Connectors Parts Catalog (MD #169641).

In this catalog, right-hand (RH) and left-hand (LH) are determined from the operator's seated driving position in the windrower cab. An arrow is sometimes used in illustrations to indicate forward position as shown below.



## Abbreviations

A/R – as required (quantity varies)	ASSY – assembly	BHRN – button head rib neck
BV – ball valve	CCW – counterclockwise	CON – conical (spring washer)
CSK – countersink	C/W – complete with	CW – clockwise
DBLE – double	DK – double knife	DR – double reel
DT – distorted thread	FLG – flange	GA – gauge
GR – grade	GS – grass seed	HD – head
HDR – header	HFA – hydraulic fore-aft	HH – hex head
HNBR – hydrogenated nitrile butadiene rubber	HYD – hydraulic	I.D. – inside diameter
IP – internal plus (torx plus)	KP – knife pressure	KR – knife return
LG – long	LH – left hand (determined from Operator's position, facing forward)	LK – lock
MACH – machine	MD – MacDon	MFA – manual fore-aft
MY – model year	NC – national coarse thread	NF – national fine thread
NSS – not sold separately	NT – narrow transport	O.D. – outside diameter
OPT – optional	PO – pilot operated	PT – pull-type (mower conditioner)
RC – roller chain	REF – reference, part number called up elsewhere in catalog	REG – regular
RH – right hand (determined from Operator's position, facing forward)	RHSN – round head, square neck or square neck carriage bolt	RHSSN – round head, short, square neck
RTD – rotating tine drum	SAE – Society of Automotive Engineers (part produced to comply with)	SD – side draper
SER – serrated	SK – single knife	SKT HD – socket head
SMTH – smooth	SMV – slow moving vehicle	SOCK – socket
SP – self-propelled (windrower) header	SPCL – special	SPH – spherical
SPI – serrations per inch (knife Sections)	SR – single reel	STL – steel (stainless)
STR – standard	STVR – Stover	TFL – thread full length
THD – thread	TR – triple reel	UCA – upper cross auger
UDK – untimed double knife	UNC – unified coarse thread	UNEF – unified extra fine thread
UNF – unified fine thread	UNS – unified special thread series	VK – vertical knife
WF – wide frame	ZP – zinc plated	

## **Serial Number Breaks**

The side of the serial number on which the dash (–) appears determines whether the part is used "up to" or "after" the serial number given.

**Example:**

- –451189 Used on machines up to and including serial number 451189
- 451190– Used on machines including and after serial number 451190

## Summary of Changes – R1 SP Series (262298 Rev. A)

This list covers changes made since the last revision (262010 Rev. A).

Section	Summary of Change	Internal Use Only
Inside Front Cover	Added note about available translations.	Publications
• <i>1 Cutterbar – R113, page 1</i> • <i>2 Cutterbar – R116, page 5</i>	Drive spindle 246236 superseded by 359040.	ECN 62641
• <i>4 Cutterbar Components – R113, 2018 and Later, page 11</i> • <i>5 Cutterbar Components – R116, page 15</i>	Added Updated Blades kit 359122.	ECN 64004
<i>13 Roll Conditioner – Polyurethane/Steel, page 33</i>	Tolerance clip 135813 superseded by latch assembly 320524. Changed the clip to “REF” and added a footnote for clarity.	ECN 64457
	Roll stop 247259 made service-only for model year 2023 and prior. Added roll stop 259621 for model year 2024 and later. Roll arm 247828 superseded by 359253. Added roll stop kit 259622, which includes roll arm 359253 and roll stop 259621, for model year 2023 and prior headers. Updated illustration from 1036373 to 1042623.	ECN 64592
<i>14 Roll Conditioner – Roll Arms and Stops, page 39</i>	Added new section for roll stop kit 259622 to help customers identify which roll stops and roll arms their machine currently has installed; includes new illustration 1042651.	ECN 64592, Product Support
<i>15 Roll Conditioner – Gear Drive, page 41</i>	Removed M8 washers 247198 from parts list; they are no longer required for these gearboxes, as per the supplier. Updated illustration from 1011410 to 1030416.	Engineering
<i>16 Roll Conditioner – Shields, page 43</i>	Stud assembly 246266 superseded by weldment 246226. Changed quantity of rivet 113799 from 3 to 1. Removed clip 135813. Added latch assembly 320524. Updated illustration from 1027295 to 1042716.	ECN 64457
<i>17 Roll Conditioner – Header Attachment, page 47</i>	Eye bolt 224587 superseded by 281685. Revised footnotes to clarify that the belt tensioner kit comes with a 230 mm eye bolt, but you need to use 192 mm eye bolt 281986 on a roll conditioner.	ECN 55894
	Added footnote to use one or two washers 184717 as required to align the belt drive.	ECN 60990
	Revised the footnotes for shields 257093 and 224562; latch 135815 and washer 5113 are no longer part of the shield subassembly. Added footnote to order latch 135815 until stock is depleted, then order latch assembly 320524.	ECN 64457
<i>30 (Option) Blade Update, page 79</i>	Added new section for Updated Blades kit 359122, with new illustration 1042193.	ECN 63542 ECN 64004

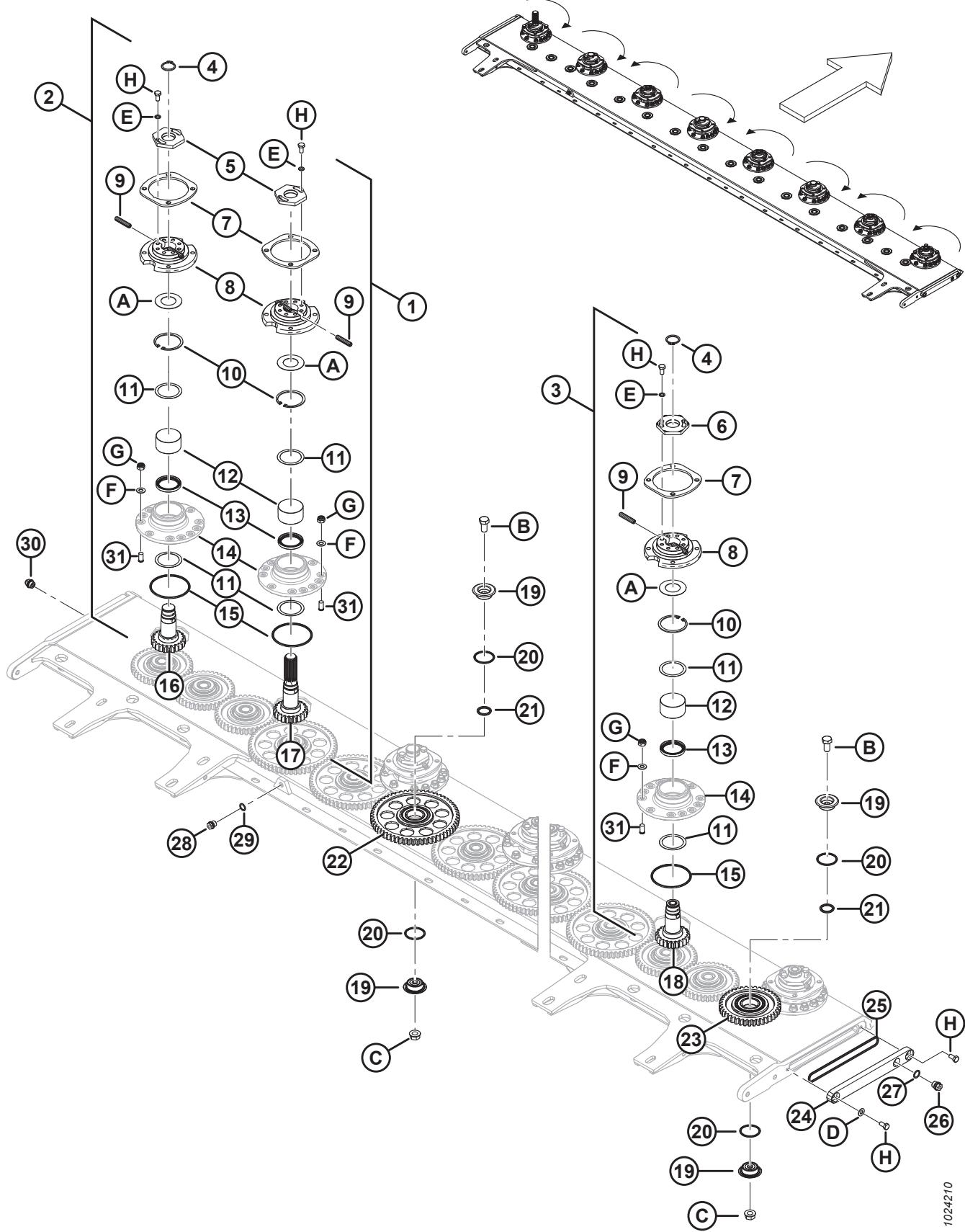
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# 1 Cutterbar – R113



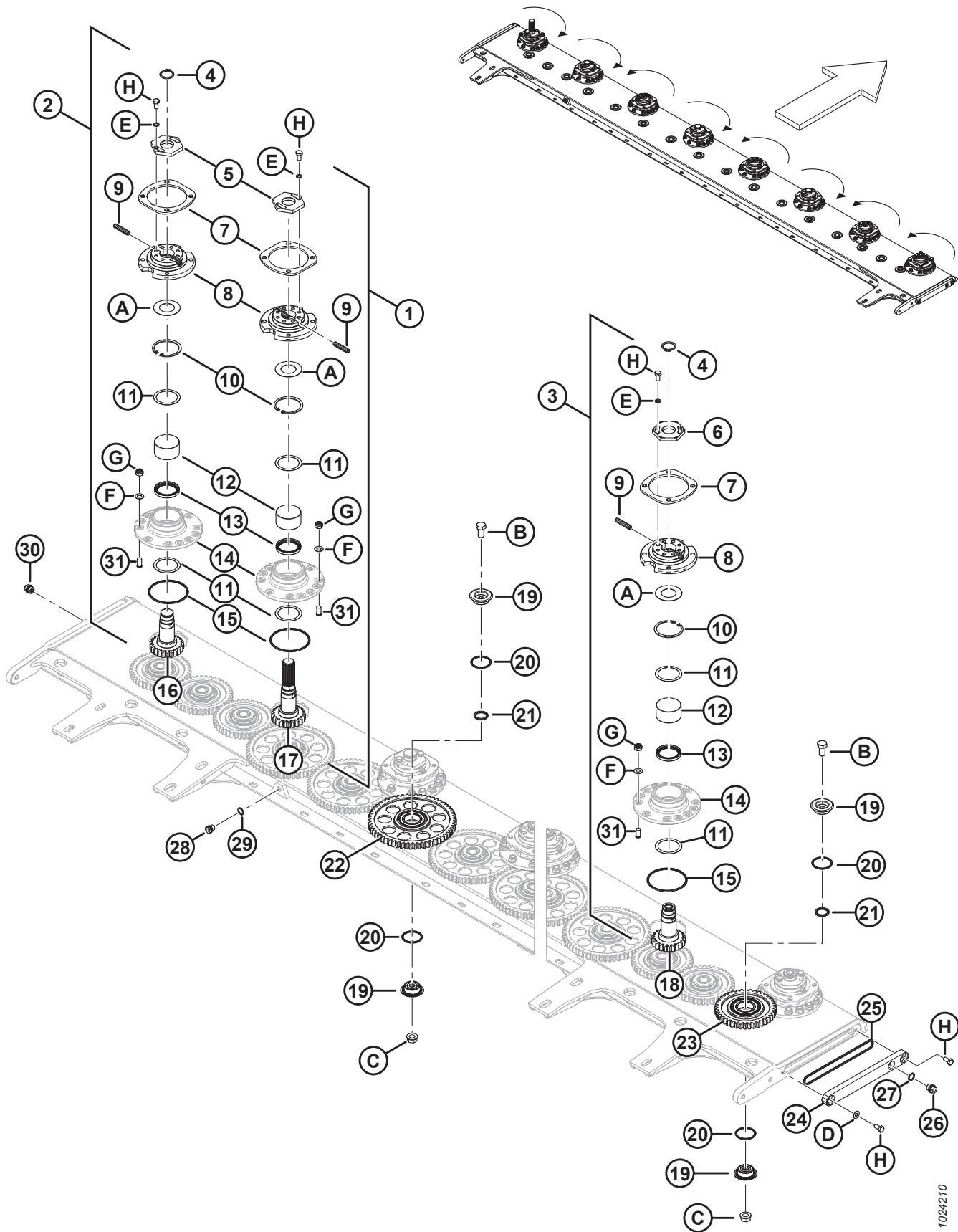
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## CUTTERBAR – R113

Ref	Part Number	Description	Qty	Serial Number
1	359040	SPINDLE – DRIVE <sup>1</sup>	1	
2	359026	SPINDLE – CLOCKWISE <sup>1</sup>	3	
3	359027	SPINDLE – COUNTER CLOCKWISE <sup>1</sup>	4	
4	259048	RING – RETAINING	7	
5	246612	NUT – SPECIAL (RH THREAD) <sup>2</sup>	4	
6	246613	NUT – SPECIAL (LH THREAD) <sup>2</sup>	4	
7	247923	PLATE – SPACER	8	285420–
	247616	PLATE – SPACER (2015 ONLY)	8	266820–285419
8	246614	HUB – SPINDLE	8	
9	246295	PIN – SHEAR	16	
10	246617	RING – SNAP	8	
11	247936	SHIM	8	
12	246328	BEARING – TAPER ROLLER	8	
13	247937	SEAL	8	
14	NSS	HOUSING – BEARING <sup>3</sup>		
15	246316	O-RING – SPINDLE	8	
16	246623	GEAR – CLOCKWISE (RH THREAD) <sup>4</sup>	3	
17	246622	GEAR – DRIVE, CLOCKWISE (RH THREAD) <sup>4</sup>	1	
18	246624	GEAR – COUNTER CLOCKWISE (LH THREAD) <sup>5</sup>	4	
19	246330	PIN – IDLER GEAR	32	
20	246315	O-RING – IDLER PIN	32	
21	246331	O-RING – IDLER PIN	16	
22	246308	GEAR – IDLER, LARGE, C/W BEARING <sup>6</sup>	10	
23	246307	GEAR – IDLER, SMALL, C/W BEARING <sup>6</sup>	6	
24	246309	CUTTERBAR – END CAP	2	-346189
	307175	CUTTERBAR – END CAP	2	346190–
25	247924	O-RING – END PLATE, 170 X 4.5 MM	2	
26	246631	PLUG – SIDE, M18 X 1.5	1	
27	246632	GASKET	1	
28	246627	PLUG	1	
29	246628	GASKET	1	
30	246318	BREATHER – CUTTERBAR	1	
31	246991	STUD – M12 X 25	88	
A	246615	WASHER – SPECIAL, BELLEVILLE		
B	246310	BOLT – M16, IDLER PIN		
C	246311	NUT – IDLER PIN		

1. Does not include spacer plate (MD #247616 or 247923), spindle O-ring (MD #246316), stud (MD #246991), or hardware F, G (MD #246630, 246332).
2. Wrench (MD #246314) is attached to header, and is used to loosen/tighten nut. For location of wrench, refer to Section *6 Cutterbar to Frame – R113, page 19*.
3. Not sold separately; included with spindles (MD #246236, 359040, 359026, and 359027).
4. Right-handed thread.
5. Left-handed thread.
6. Includes bearing and snap ring. Bearing and snap ring not sold separately.

CUTTERBAR – R113

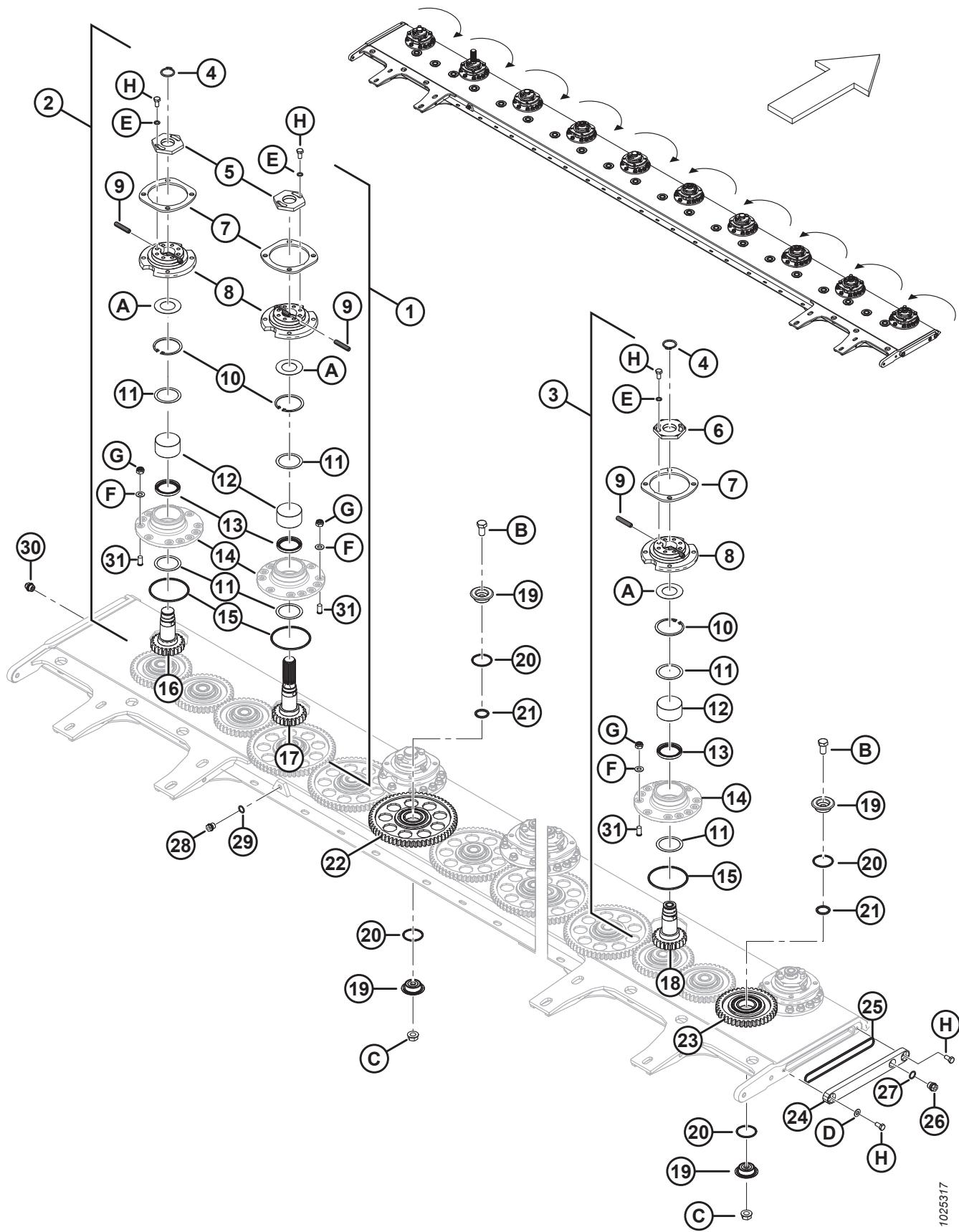


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**CUTTERBAR – R113**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
D	246313	WASHER – END CAP		-346189
	238016	WASHER – END CAP		346190–
E	246625	WASHER – SPECIAL		
F	246630	WASHER – SPECIAL		
G	246332	NUT – M12, LOCKING		
H	246872	BOLT – M10, SPECIAL		-346189
	238015	BOLT – M12, SPECIAL		346190–

## 2 Cutterbar – R116



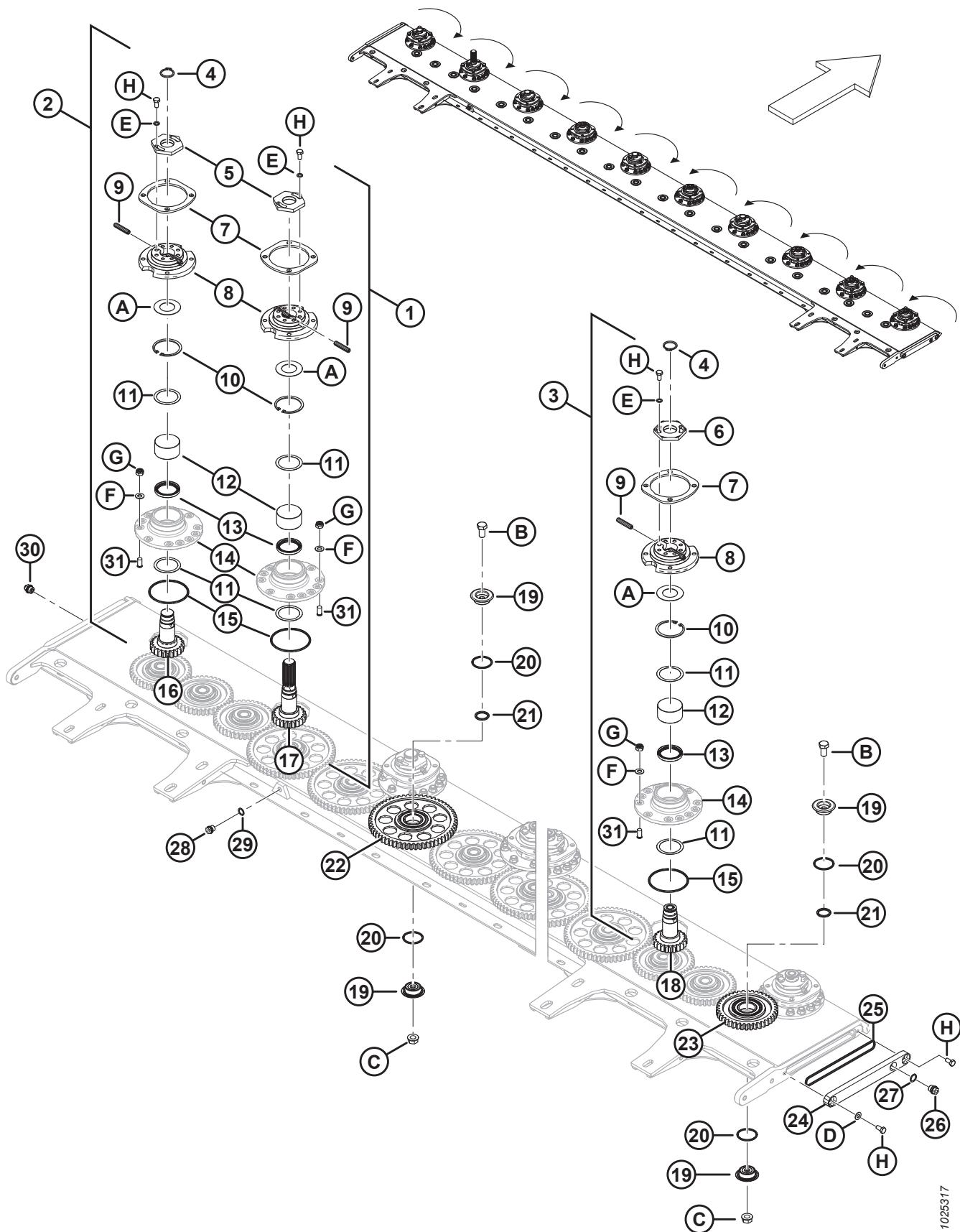
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## CUTTERBAR – R116

Ref	Part Number	Description	Qty	Serial Number
1	359040	SPINDLE – DRIVE <sup>7</sup>	1	
2	359026	SPINDLE – CLOCKWISE <sup>7</sup>	4	
3	359027	SPINDLE – COUNTER CLOCKWISE <sup>7</sup>	5	
4	259048	RING – RETAINING	9	
5	246612	NUT – SPECIAL (RH THREAD) <sup>8</sup>	5	
6	246613	NUT – SPECIAL (LH THREAD) <sup>8</sup>	5	
7	247923	PLATE – SPACER	10	285420–
	247616	PLATE – SPACER (2015 ONLY)	10	266820–285419
8	246614	HUB – SPINDLE	10	
9	246295	PIN – SHEAR	20	
10	246617	RING – SNAP	10	
11	247936	SHIM	10	
12	246328	BEARING – TAPER ROLLER	10	
13	247937	SEAL	10	
14	NSS	HOUSING – BEARING <sup>9</sup>		
15	246316	O-RING – SPINDLE	10	
16	246623	GEAR – CLOCKWISE (RH THREAD) <sup>10</sup>	4	
17	246622	GEAR – DRIVE, CLOCKWISE (RH THREAD) <sup>10</sup>	1	
18	246624	GEAR – COUNTER CLOCKWISE (LH THREAD) <sup>11</sup>	5	
19	246330	PIN – IDLER GEAR	40	
20	246315	O-RING – IDLER PIN	40	
21	246331	O-RING – IDLER PIN	20	
22	246308	GEAR – IDLER, LARGE, C/W BEARING <sup>12</sup>	14	
23	246307	GEAR – IDLER, SMALL, C/W BEARING <sup>12</sup>	6	
24	246309	CUTTERBAR – END CAP	2	-346189
	307175	CUTTERBAR – END CAP	2	346190–
25	247924	O-RING – END PLATE, 170 X 4.5 MM	2	
26	246631	PLUG – SIDE, M18 X 1.5	1	
27	246632	GASKET	1	
28	246627	PLUG	1	
29	246628	GASKET	1	
30	246318	BREATHER – CUTTERBAR	1	
31	246991	STUD – M12 X 25	110	
A	246615	WASHER – SPECIAL, BELLEVILLE		
B	246310	BOLT – M16, IDLER PIN		
C	246311	NUT – IDLER PIN		

- 7. Does not include spacer plate (MD #247616 or 247923), spindle O-ring (MD #246316), stud (MD #246991), or hardware (MD #246630, 246332).
- 8. Wrench (MD #246314) is attached to header, and is used to loosen/tighten nut. For location of wrench, refer to Section 7 Cutterbar to Frame – R116, page 21.
- 9. Not sold separately. Comes included with spindles (MD #359040, 359026, and 359027).
- 10. Right-handed thread.
- 11. Left-handed thread.
- 12. Includes bearing and snap ring. Bearing and snap ring not sold separately.

CUTTERBAR – R116

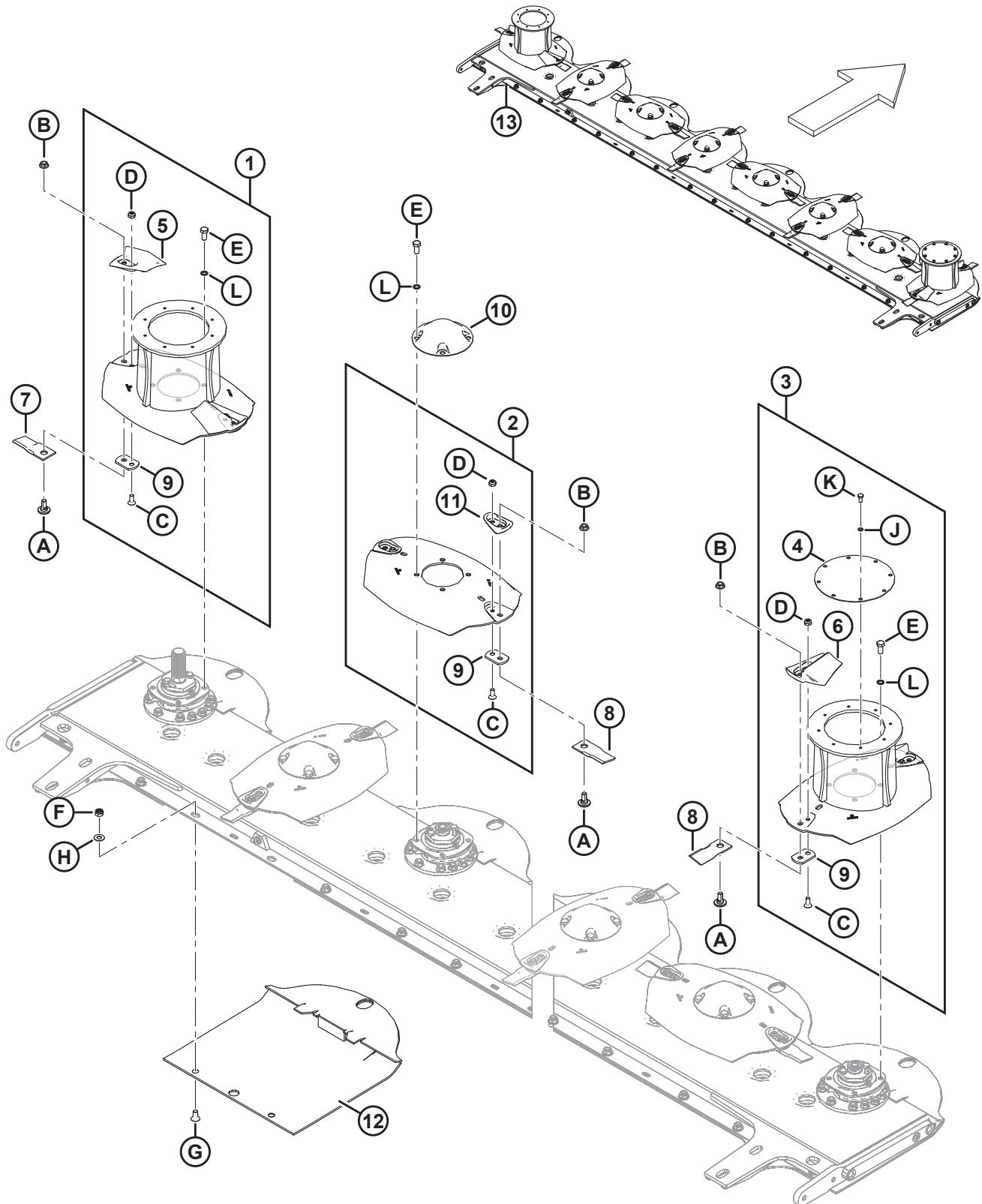


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**CUTTERBAR – R116**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
D	246313	WASHER – END CAP		–346189
	238016	WASHER – END CAP		346190–
E	246625	WASHER – SPECIAL		
F	246630	WASHER – SPECIAL		
G	246332	NUT – M12, LOCKING		
H	246872	BOLT – M10, SPECIAL		–346189
	238015	BOLT – M12, SPECIAL		346190–

### 3 Cutterbar Components – R113, 2017



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**CUTTERBAR COMPONENTS – R113, 2017**

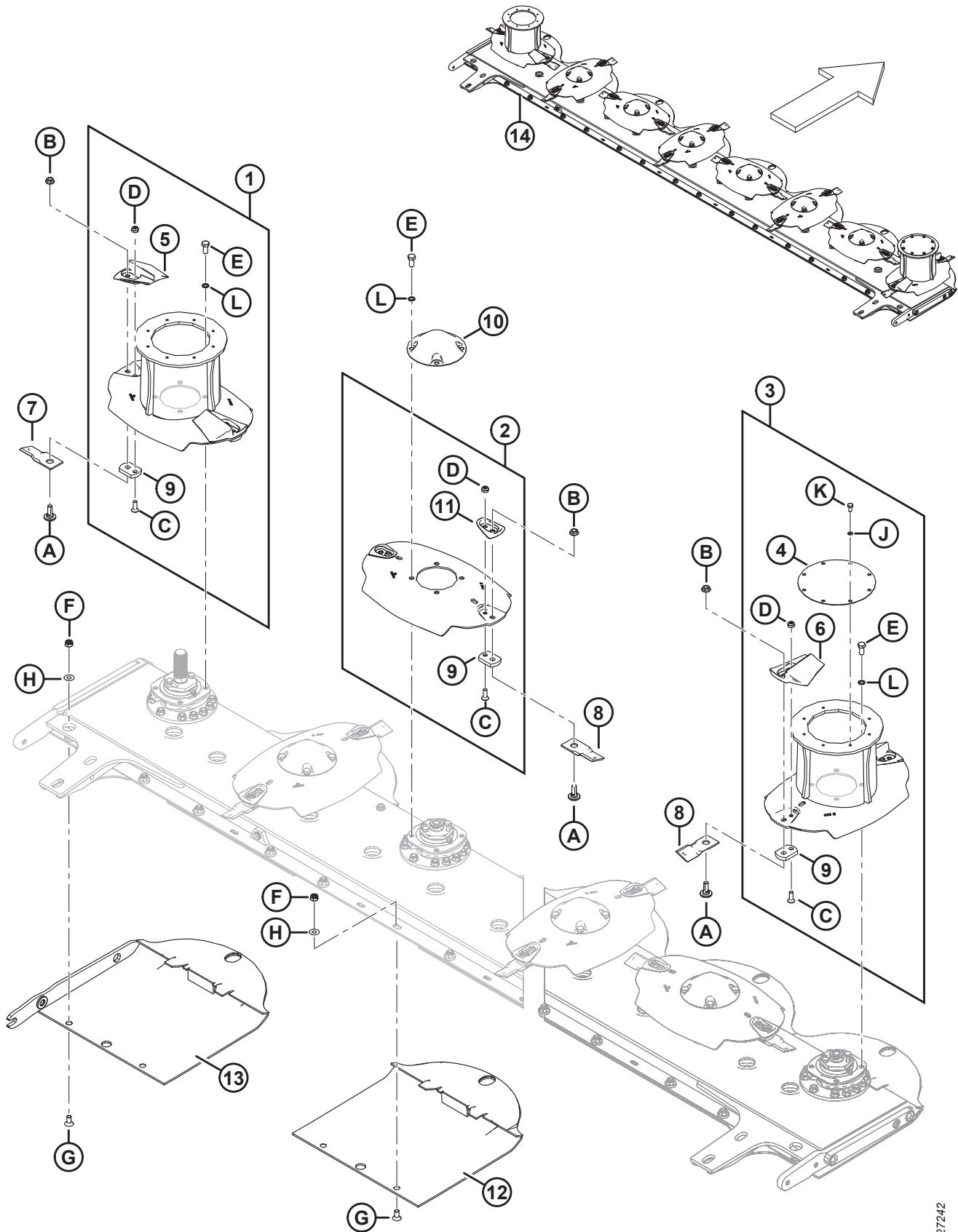
**IMPORTANT:**

All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 5 mm blade plate (MD #246301) requires accelerator bolt (MD #281965) and blade bolt (MD #246299).

Ref	Part Number	Description	Qty	Serial Number
1	247242	ASSEMBLY – CW DRUM, 402 MM (DRIVE) <sup>13</sup>	1	-321189
2	281753	ASSEMBLY – DISC, 425 MM <sup>14</sup>	6	-321189
3	247243	ASSEMBLY – CCW DRUM, 402 MM <sup>14</sup>	1	-321189
4	246291	PLATE – DRUM COVER	1	-321189
5	281966	ACCELERATOR – CW (PAIR)	1	-321189
6	281967	ACCELERATOR – CCW (PAIR)	1	-321189
7	281446	BLADE – 11° CW BEVEL DOWN (6 PACK) <sup>15</sup>	2	-321189
8	281447	BLADE – 11° CCW BEVEL DOWN (6 PACK) <sup>15</sup>	2	-321189
9	246301	PLATE – BLADE, 5 MM	16	-321189
10	246305	COVER – DISC	6	-321189
11	238227	KIT – 2 GUARDS CW HARDWARE <sup>16</sup>	6	
12	281609	ROCKGUARD	8	-321189
	359024	ROCKGUARD (LIGHT CROP – FLAT TOP) <sup>17</sup>	OPT	
13	259518	KIT – CUTTERBAR 8 DISC <sup>18</sup>	A/R	
A	246299	BOLT – BLADE		
B	246300	NUT – BLADE		
C	281965	BOLT – ACCELERATOR <sup>19</sup>		
	281605	BOLT – ACCELERATOR <sup>20</sup>		
D	246303	NUT – ACCELERATOR		
E	246312	BOLT – M12, DISC COVER		
F	246332	NUT – NYLON INSERT LOCK M12 X 1.75 ZN PL CL-10		
G	259099	BOLT – COUNTERSUNK, M12		
H	259100	WASHER – FLAT, M12		
J	246633	WASHER – SPECIAL, M8		
K	246882	BOLT – M8, SPECIAL		
L	246952	WASHER – M12, LOCKING, DISC		

- 
- 13. Assembly does not include blades (MD #281446, 281447) or blade hardware (MD #246299, 246300). It does include a top cover plate that will need to be removed before use.
  - 14. Assembly does not include blades (MD #281446, 281447) or blade hardware (MD #246299, 246300).
  - 15. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.
  - 16. This kit includes a matched pair of disc guards (NSS), two accelerator bolts (MD #281965) used with 5 mm shims, two accelerator nuts (MD #246303), and two accelerator bolts (MD #281605) used with 10 mm shims.
  - 17. The optional rockguard has a flat top, which improves header performance when cutting in lighter crop.
  - 18. Kit can be used to update or replace a complete 2017 cutterbar (except blades and blade hardware) to current standards. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).
  - 19. For use with 5 mm shims.
  - 20. For use with 10 mm shims.

## 4 Cutterbar Components – R113, 2018 and Later



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## CUTTERBAR COMPONENTS – R113, 2018 AND LATER

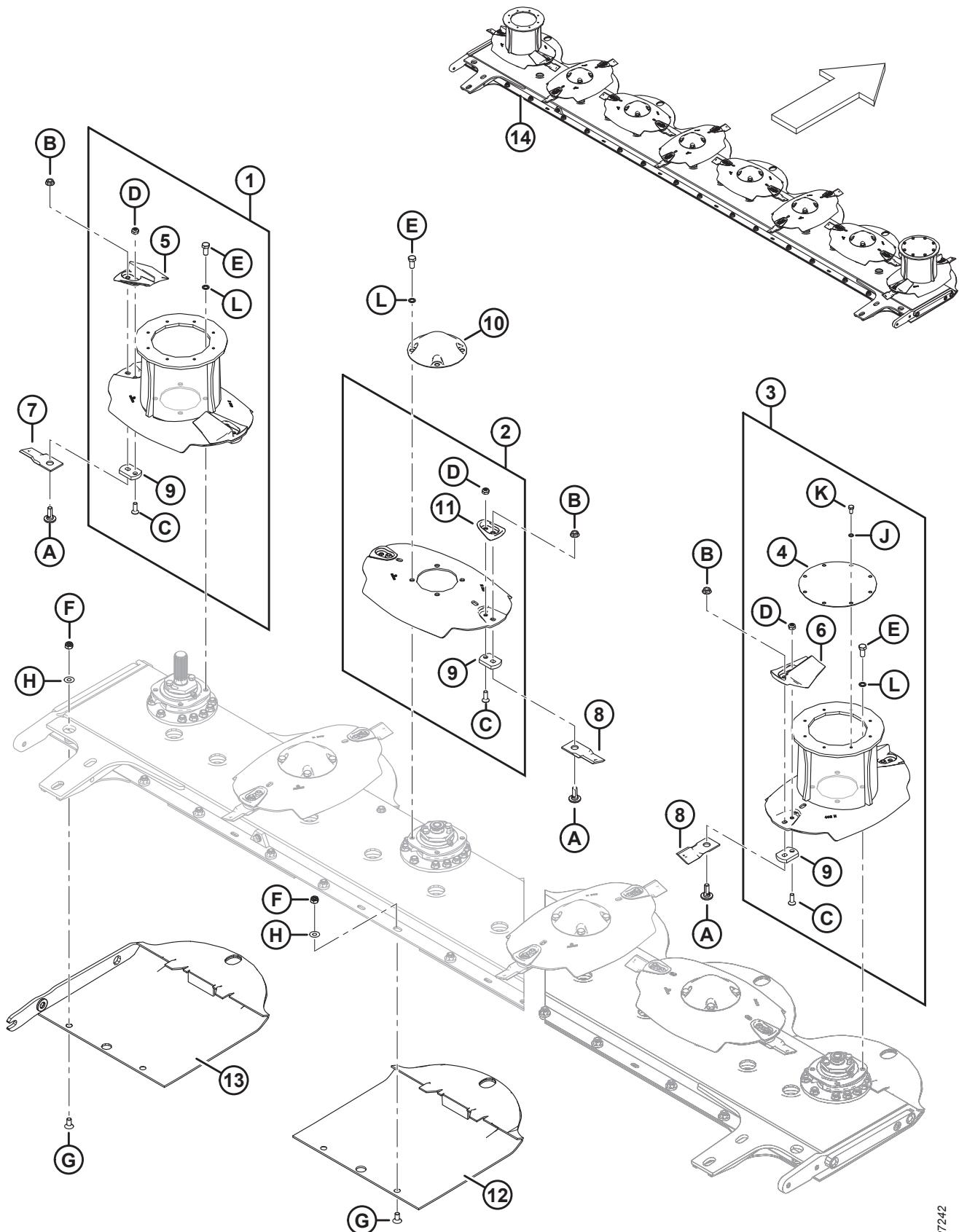
**IMPORTANT:**

All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 10 mm blade plate (MD #281606) requires accelerator bolt (MD #281605) and blade bolt (MD #281604).

Ref	Part Number	Description	Qty	Serial Number
1	281366	ASSEMBLY – CW DRUM, 402 MM (DRIVE) <sup>21</sup>	1	321190–
2	281370	ASSEMBLY – DISC, 425 MM <sup>22</sup>	6	321190–
3	281367	ASSEMBLY – CCW DRUM, 402 MM <sup>22</sup>	1	321190–
4	246291	PLATE – DRUM COVER	1	321190–
5	281966	ACCELERATOR – CW (PAIR)	1	321190–
6	281967	ACCELERATOR – CCW (PAIR)	1	321190–
7	259199	BLADE – 18° CW BEVEL DOWN (6 PACK) <sup>23</sup>	2	321190–
	<b>359122</b>	<b>KIT – UPDATED BLADES<sup>24</sup></b>	<b>OPT</b>	
8	259200	BLADE – 18° CCW BEVEL DOWN (6 PACK) <sup>23</sup>	2	321190–
	<b>359122</b>	<b>KIT – UPDATED BLADES<sup>24</sup></b>	<b>OPT</b>	
9	281606	PLATE – BLADE, 10 MM	16	321190–
10	246305	COVER – DISC	6	321190–
11	238227	KIT – 2 GUARDS CW HARDWARE <sup>25</sup>	6	
12	281609	ROCKGUARD	8	321190–
	359024	ROCKGUARD (LIGHT CROP – FLAT TOP) <sup>26</sup>	OPT	
13	238031	ROCKGUARD – REINFORCED, LH	1	346190–
	238032	ROCKGUARD – REINFORCED, RH	1	346190–
	238026	KIT – REINFORCED ROCKGUARD <sup>27</sup>	A/R	
14	259518	KIT – CUTTERBAR 8 DISC <sup>28</sup>	A/R	
A	281604	BOLT – BLADE		
B	246300	NUT – BLADE		

- 
- 21. Assembly does not include blades (MD #259199, 259200) or blade hardware (MD #281604, 246300). It does include a top cover plate that will need to be removed before use.
  - 22. Assembly does not include blades (MD #259199, 259200) or blade hardware (MD #281604, 246300).
  - 23. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.
  - 24. The blades included in this kit have a larger cut length, providing a cleaner cut in lighter crops. For service parts, refer to Section *30 (Option) Blade Update, page 79*.
  - 25. This kit includes a matched pair of disc guards (NSS), two accelerator bolts (MD #281965) used with 5 mm shims, two accelerator nuts (MD #246303), and two accelerator bolts (MD #281605) used with 10 mm shims.
  - 26. The optional rockguard has a flat top, which improves header performance when cutting in lighter crop.
  - 27. Kit includes LH and RH reinforced rockguards (MD #238031 and 238032), lower gearbox mount bracket (MD #238054), and hardware (MD #184681 and 136141). Lower gearbox mount bracket required only on R113 to eliminate interference with conditioner.
  - 28. Kit used to replace or update complete cutterbar except blades and blade hardware. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).

CUTTERBAR COMPONENTS – R113, 2018 AND LATER



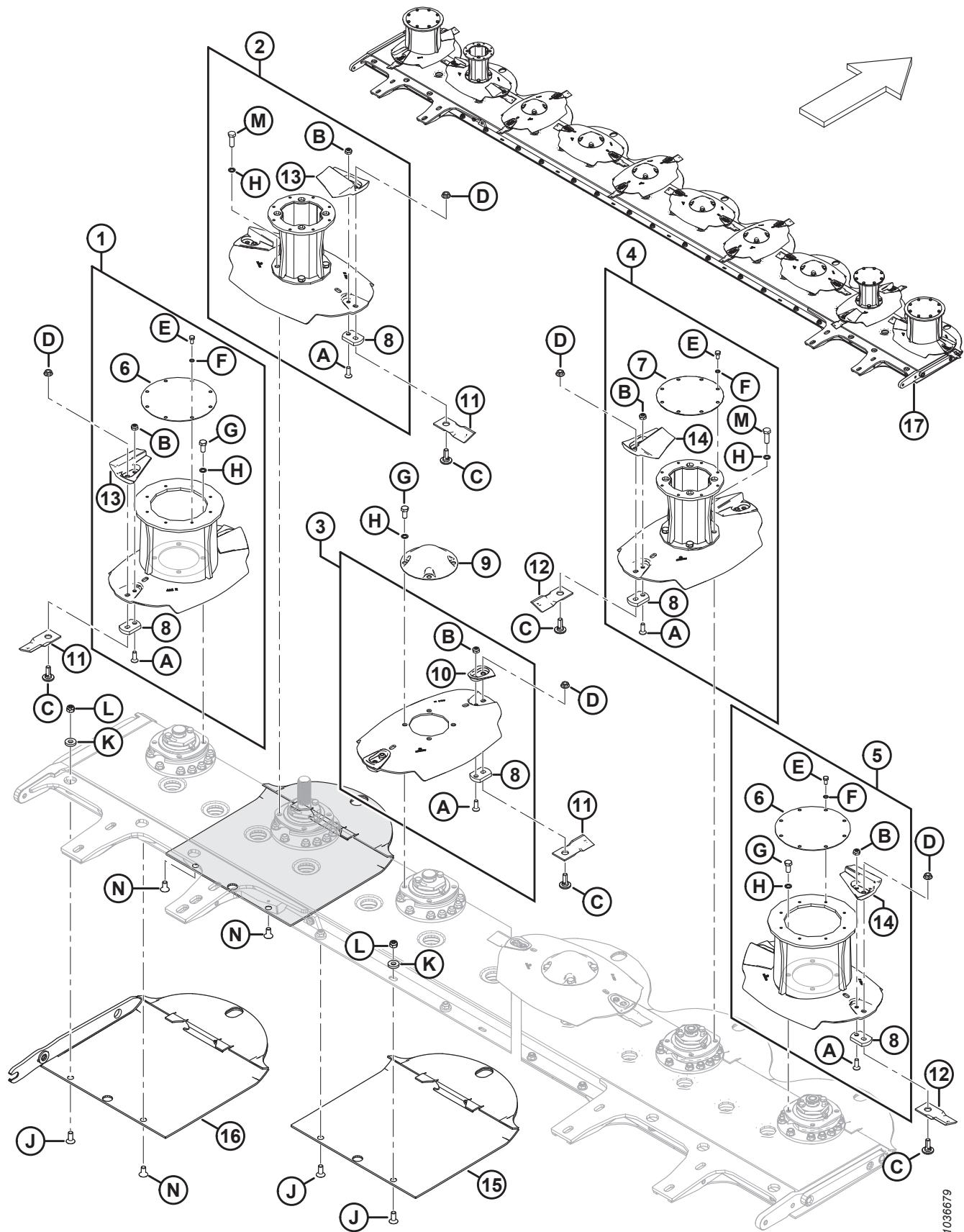
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**CUTTERBAR COMPONENTS – R113, 2018 AND LATER**

Ref	Part Number	Description	Qty	Serial Number
C	281605	BOLT – ACCELERATOR <sup>29</sup>		
	281965	BOLT – ACCELERATOR <sup>30</sup>		
D	246303	NUT – ACCELERATOR		
E	246312	BOLT – M12, DISC COVER		
F	246332	NUT – NYLON INSERT LOCK M12 X 1.75 ZN PL CL-10		
G	259099	BOLT – COUNTERSUNK, M12		
H	259100	WASHER – FLAT, M12		
J	246633	WASHER – SPECIAL, M8		
K	246882	BOLT – M8, SPECIAL		
L	246952	WASHER – M12, LOCKING, DISC		

- 
29. For use with 10 mm shims.  
30. For use with 5 mm shims.

## 5 Cutterbar Components – R116



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## CUTTERBAR COMPONENTS – R116

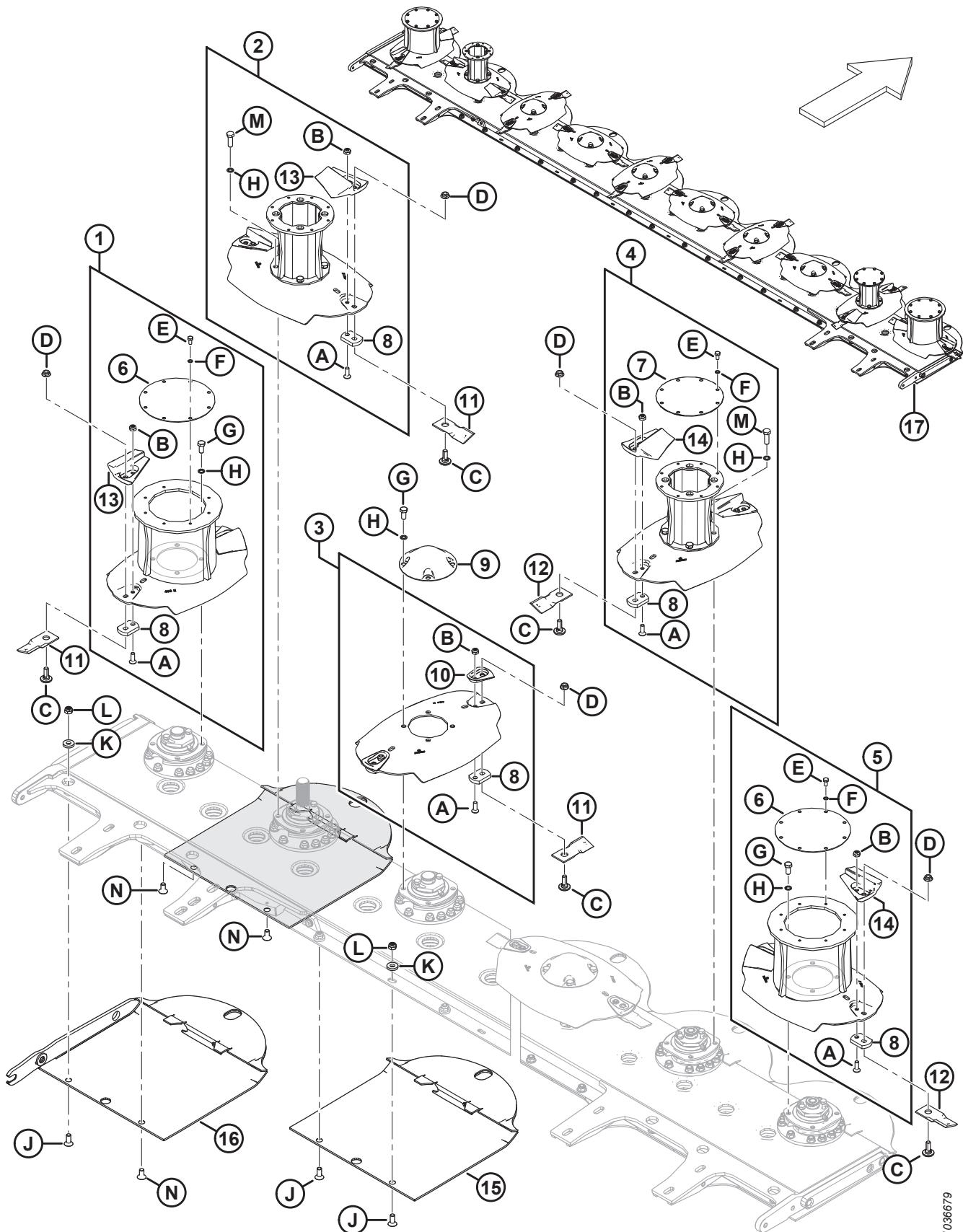
**IMPORTANT:**

All cutting components, blades, and hardware should be replaced in pairs to maintain balance. Avoid mixing blades from different model years. 10 mm blade plate (MD #281606) requires accelerator bolt (MD #281605) and blade bolt (MD #281604).

Ref	Part Number	Description	Qty	Serial Number
1	281366	ASSEMBLY – CW DRUM, 402 MM <sup>31</sup>	1	
2	257085	ASSEMBLY – CW DRUM, 425 MM DRIVE <sup>31</sup>	1	
3	281370	ASSEMBLY – DISC, 425 MM <sup>32</sup>	6	
4	257086	ASSEMBLY – CCW DRUM, 425 MM <sup>31</sup>	1	
5	281367	ASSEMBLY – CCW DRUM, 402 MM <sup>31</sup>	1	
6	246291	PLATE – DRUM COVER	2	
7	280504	PLATE – DRUM COVER	1	
8	281606	PLATE – BLADE, 10 MM	20	
9	246305	COVER – DISC	6	
10	238227	KIT – 2 GUARDS CW HARDWARE <sup>33</sup>	6	
11	259199	BLADE – 18° CW BEVEL DOWN (6 PACK) <sup>34</sup>	2	
	<b>359122</b>	<b>KIT – UPDATED BLADES <sup>35</sup></b>	<b>OPT</b>	
12	259200	BLADE – 18° CCW BEVEL DOWN (6 PACK) <sup>34</sup>	2	
	<b>359122</b>	<b>KIT – UPDATED BLADES <sup>35</sup></b>	<b>OPT</b>	
13	281966	ACCELERATOR – CW (PAIR)	4	
14	281967	ACCELERATOR – CCW (PAIR)	4	
15	281609	ROCKGUARD	10	
	359024	ROCKGUARD (LIGHT CROP – FLAT TOP) <sup>36</sup>	OPT	
16	238031	ROCKGUARD – REINFORCED, LH	1	346190–
	238032	ROCKGUARD – REINFORCED, RH	1	346190–
	238026	KIT – REINFORCED ROCKGUARD <sup>37</sup>	A/R	
17	238195	KIT – CUTTERBAR 10 DISC <sup>38, 39</sup>	A/R	

- 
- 31. Assembly does not include blades (MD #259199, 259200) or blade hardware (MD #281604, 246300).
  - 32. Assembly does not include blades (MD #259199, 259200), blade hardware (MD #281604, 246300), disc cover (MD #246305), or disc hardware (MD #246312, 246952).
  - 33. This kit includes a matched pair of disc guards (NSS), two accelerator bolts (MD #281965) used with 5 mm shims, two accelerator nuts (MD #246303), and two accelerator bolts (MD #281605) used with 10 mm shims.
  - 34. Replacement blades are sold in packages of six. To replace all blades, two packages of each clockwise (CW) and counterclockwise (CCW) blades are required.
  - 35. The blades included in this kit have a larger cut length, providing a cleaner cut in lighter crops. For service parts, refer to Section *30 (Option) Blade Update, page 79*.
  - 36. The optional rockguard has a flat top, which improves header performance when cutting in lighter crop.
  - 37. Kit includes LH and RH reinforced rockguards (MD #238031 and 238032), lower gearbox mount bracket (MD #238054), and hardware (MD #184681 and 136141). Lower gearbox mount bracket required only on R113 to eliminate interference with conditioner.
  - 38. The 10-disc cutterbar kit has small drums installed. If replacing a cutterbar with large drums currently installed, the following small drum shielding parts are also required: MD #281497 (x2), 281981, 281493, 281500, 281501, and 281489.
  - 39. Kit used to replace or update complete cutterbar except blades and blade hardware. Kit includes reinforced cutterbar endcaps (MD #307175), hardware (MD #238015 and 238016), reinforced rockguards (MD #238031 and 238032), and drive alignment tool (MD #325683).

CUTTERBAR COMPONENTS – R116



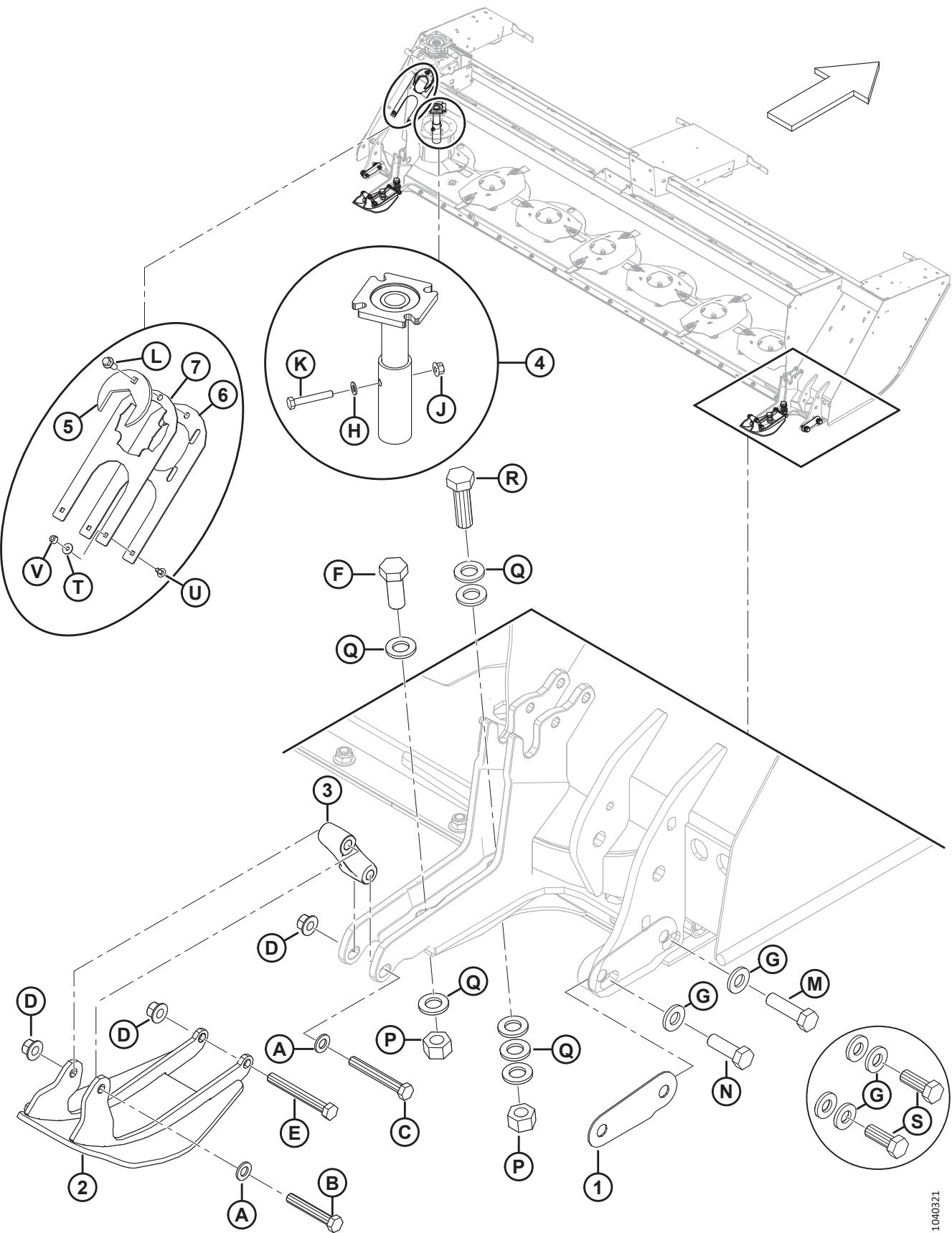
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**CUTTERBAR COMPONENTS – R116**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
A	281605	BOLT – ACCELERATOR <sup>40</sup>		
	281965	BOLT – ACCELERATOR <sup>41</sup>		
B	246303	NUT – ACCELERATOR		
C	281604	BOLT – BLADE		
D	246300	NUT – BLADE		
E	246882	BOLT – HEX HEAD M8 SPECIAL		
F	246633	WASHER – SPECIAL M8 ZN PL		
G	246312	BOLT – M12 DISC COVER		
H	246952	WASHER – M12 LOCKING DISC		
J	259099	BOLT – COUNTERSUNK, M12		
K	259100	WASHER – FLAT, M12		
L	246332	NUT – NYLON INSERT LOCK M12 X 1.75 ZN PL CL-10		
M	281697	BOLT – M12 DISC		
N	338800	BOLT – FLAT CSK		

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40. For use with 10 mm shims.  
41. For use with 5 mm shims.

## 6 Cutterbar to Frame – R113



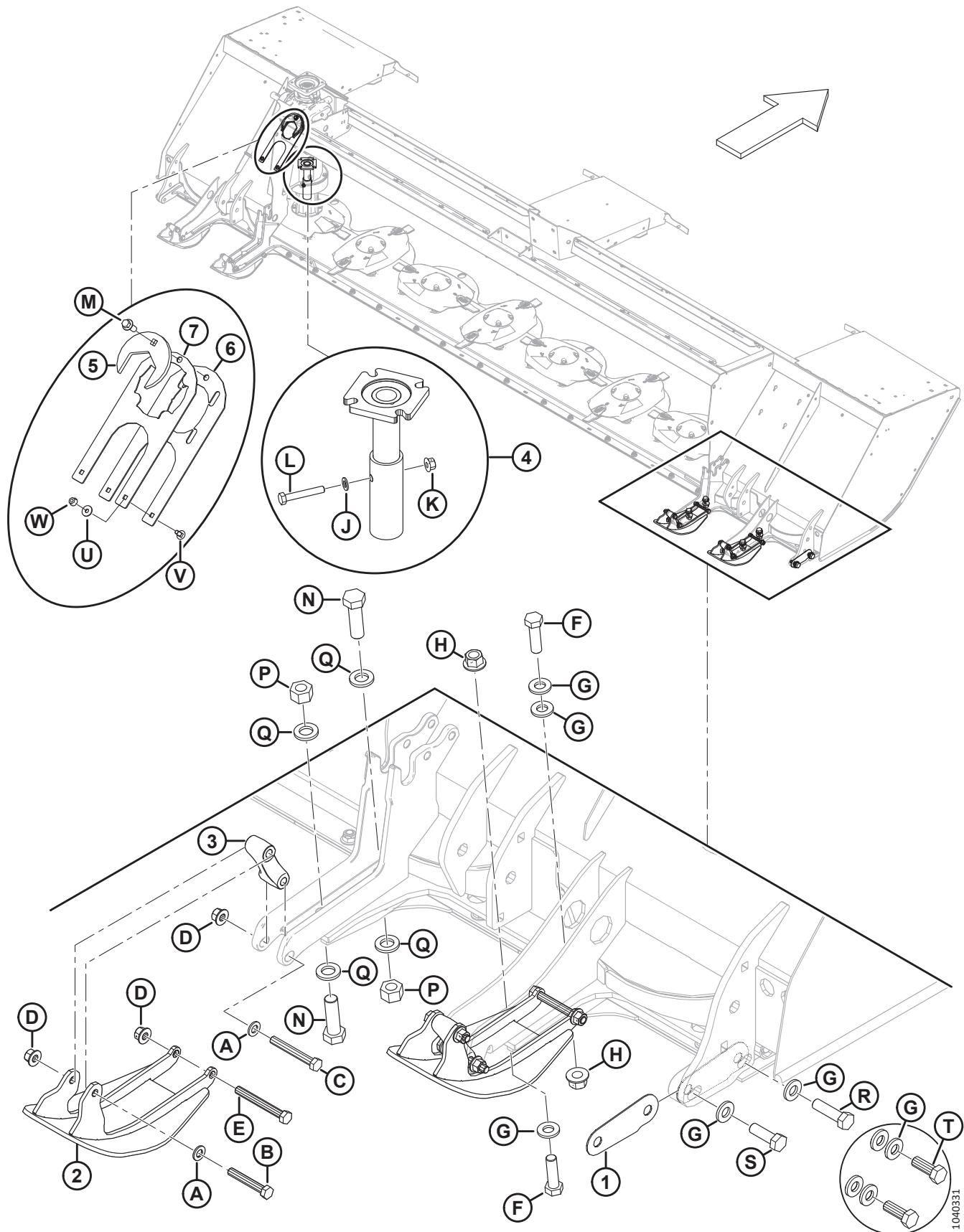
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## CUTTERBAR TO FRAME – R113

Ref	Part Number	Description	Qty	Serial Number
1	247206	SHIM – CUTTERBAR <sup>42</sup>	A/R	
2	257096	SHOE – WELDMENT	2	
3	238147	LINK – CAST	2	
4	325683	ASSEMBLY – TOOL, DRIVE ALIGNMENT <sup>43</sup>	A/R	
5	246314	WRENCH – SAFECUT NUT <sup>44</sup>	1	
6	239049	TOOL – DISC TIMING 1	1	
7	338995	TOOL – DISC TIMING 2	1	
A	184714	WASHER – FLAT REG M12-300HV-A3L		
B	135155	BOLT – HEX HD M12 X 1.75 X 75-8.8-A3L		
C	184673	BOLT – HEX HD M12 X 1.75 X 90-10.9-A3L		
D	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
E	184672	BOLT – HEX HD M12 X 1.75 X 100-10.9-A3L		
F	136082	BOLT – HEX HD TFL M20 X 2.5 X 50-8.8-AA3L		
G	320226	WASHER – HARD M16-300HV-ZINC <sup>45</sup>		
H	184711	WASHER – FLAT REG M10-200HV-A3L		
J	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
K	108172	BOLT – HEX HD M10 X 1.5 X 65-8.8-A3L		
L	148798	BOLT – HEX FLG HD M12 X 1.75 X 30-10.9-A3L		
M	136141	BOLT – HEX HD M16 X 2 X 60-8.8-AA1J <sup>46</sup>		346190–
N	184681	BOLT – HEX HD M16 X 2 X 50-8.8-AA1J <sup>46</sup>		346190–
P	136124	NUT – HEX M20 X 2.5-10-A3L		
Q	320225	WASHER – HARD M20-300HV-ZINC		
R	136157	BOLT – HEX HD M20 X 2.5 X 65-10.9-A3L		
S	136132	BOLT – HEX HD TFL M16 X 2 X 45-8.8-A3L <sup>47</sup>		–346189
T	184709	WASHER – FLAT LARGE M8-200HV		
U	197171	BOLT – RHSN M8 X 1.25 X 20-8.8 ZINC		
V	135337	NUT – HEX FLG CTR LK M8 X 1.25-8-AA1J		

- 
42. Shim both sides of the header evenly as required to a maximum gap of 2 mm per side before tightening bolts.
43. Use drive alignment tool to achieve proper alignment (+/- 3.2 mm or 1/8 in.) between 90° drive gearbox hub and cutterbar driveshaft. Tool not supplied with header; includes hardware (MD #184711, 135799, and 108172).
44. Wrench is attached to header. Used to loosen/tighten special nuts (MD #246612 and 246613). Refer to Section [1 Cutterbar – R113, page 1](#).
45. If reinforced outboard rock guards (MD #238031 and 238032) are installed, use one washer per bolt at the ends of the cutterbar. If reinforced outboard rock guards are not installed, use two washers per bolt.
46. Used on model year 2019 and later headers, and model year 2018 and prior headers that have the Reinforced Rock Guard kit (MD #238026) installed.
47. Used on model year 2018 and prior headers without the Reinforced Rock Guard kit (MD #238026) installed.

## 7 Cutterbar to Frame – R116

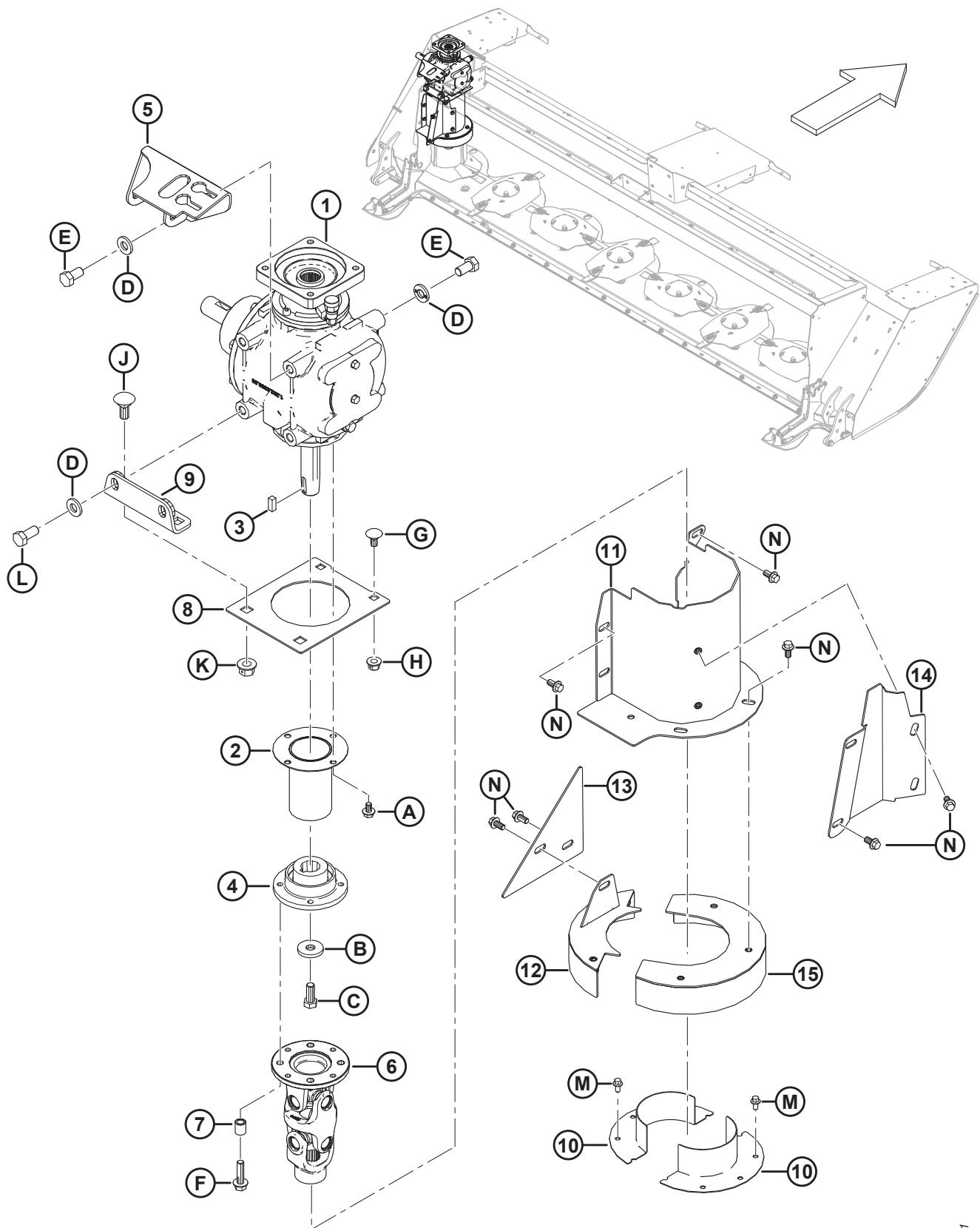


**CUTTERBAR TO FRAME – R116**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	247206	SHIM – CUTTERBAR <sup>48</sup>	A/R	
2	257096	SHOE – WELDMENT	4	
3	238147	LINK – CAST	4	
4	325683	ASSEMBLY – TOOL, DRIVE ALIGNMENT <sup>49</sup>	A/R	
5	246314	WRENCH – SAFECUT NUT <sup>50</sup>	1	
6	239049	TOOL – DISC TIMING 1	1	
7	338995	TOOL – DISC TIMING 2	1	
A	184714	WASHER – FLAT REG M12-300HV-A3L		
B	135155	BOLT – HEX HD M12 X 1.75 X 75-8.8-A3L		
C	184673	BOLT – HEX HD M12 X 1.75 X 90-10.9-A3L		
D	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
E	184672	BOLT – HEX HD M12 X 1.75 X 100-10.9-A3L		
F	136717	BOLT – HEX HD TFL M16 X 2 X 45-8.8-A3L		
G	320226	WASHER – HARD M16-300HV-ZINC <sup>51</sup>		
H	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
J	184711	WASHER – FLAT REG M10-200HV-A3L		
K	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
L	108172	BOLT – HEX HD M10 X 1.5 X 65-8.8-A3L		
M	148798	BOLT – HEX FLG HD M12 X 1.75 X 30-10.9-A3L		
N	136157	BOLT – HEX HD M20 X 2.5 X 65-10.9-AA1J		
P	136124	NUT – HEX M20 X 2.5-10-A3L		
Q	320225	WASHER – HARD M20-300HV-ZINC		
R	136141	BOLT – HEX HD M16 X 2 X 60-8.8-AA1J <sup>52</sup>		346190–
S	184681	BOLT – HEX HD M16 X 2 X 50-8.8-AA1J <sup>52</sup>		346190–
T	136132	BOLT – HEX HD TFL M16 X 2 X 45-8.8-A3L <sup>53</sup>		–346189
U	184709	WASHER – FLAT LARGE M8-200HV		
V	197171	BOLT – RHSN M8 X 1.25 X 20-8.8 ZINC		
W	135337	NUT – HEX FLG CTR LK M8 X 1.25-8-AA1J		

- 
48. Shim both sides of the header evenly as required to a maximum gap of 2 mm per side before tightening bolts.
49. Use drive alignment tool to achieve proper alignment (+/- 3.2 mm or 1/8 in.) between 90° drive gearbox hub and cutterbar driveshaft. Tool not supplied with header; includes hardware (MD #184711, 135799, and 108172).
50. Wrench is attached to header. Used to loosen/tighten special nuts (MD #246612, 246613). Refer to Section 2 *Cutterbar – R116, page 5*.
51. If reinforced outboard rock guards (MD #238031 and 238032) are installed, use one washer per bolt at the ends of the cutterbar. If reinforced outboard rock guards are not installed, use two washers per bolt.
52. Used on model year 2019 and later headers, and model year 2018 and prior headers that have the Reinforced Rock Guard kit (MD #238026) installed.
53. Used on model year 2018 and prior headers without the Reinforced Rock Guard kit (MD #238026) installed.

## 8 Mechanical Drives – R113



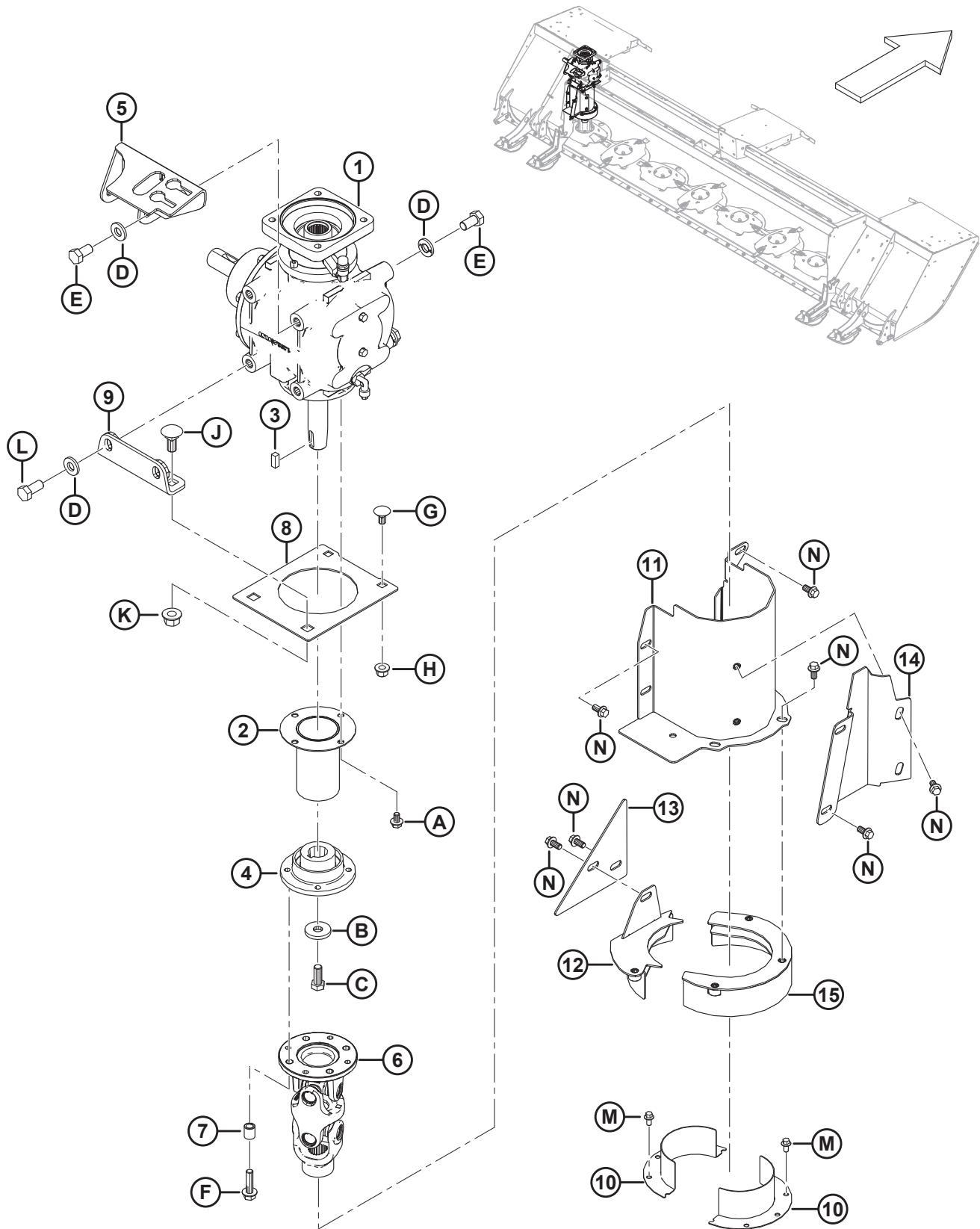
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## MECHANICAL DRIVES – R113

Ref	Part Number	Description	Qty	Serial Number
1	257187	KIT – GEARBOX <sup>54</sup>	1	321190–
	257174	KIT – GEARBOX <sup>55</sup>	1	–321189
2	256372	SHIELD – WELDMENT	1	
3	222269	KEY	1	
4	247103	HUB – DRIVE	1	
5	256582	SUPPORT – TENSIONER WELDT	1	
6	259139	ASSEMBLY – DRIVELINE	1	
	259142	ASSEMBLY – CROSS JOURNAL, CENTER ZERK <sup>56</sup>		
	247120	ASSEMBLY – CROSS JOURNAL, CAP ZERK <sup>57</sup>		
	247121	YOKE		
	247122	YOKE – FLANGE		
7	222291	SPACER	4	
8	256352	PLATE – COVER	1	
9	256371	BRACKET	1	
10	246691	SHIELD WELD'T – DRUM	2	
11	256416	SHIELD – VERTICAL WELD'T	1	
12	246687	PLATE WELDMENT – BACK	1	
13	246770	PLATE – COVER	1	
14	256408	PLATE – SHIELD	1	
15	281378	DRUM – TOP	1	
A	136151	BOLT – HEX FLG HD TFL M10 X 1.5 X 16-8.8-A3L		
B	4762	WASHER – FLAT		
C	135491	BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L		
D	320226	WASHER – HARD M16-360HV-ZINC		
E	136143	BOLT – HEX HD TFL M16 X 2 X 30-10.9-A3L		
F	148799	BOLT – HEX FLG HD M12 X 1.75 X 45-10.9-A3L		
G	135903	BOLT – RHSN M12 X 1.75 X 25-8.8-A3L		
H	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
J	152685	BOLT – RHSN M16 X 2 X 40-10.9-A3L		
K	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
L	136137	BOLT – HEX HD TFL M16 X 2 X 35-8.8-A3L		
M	136485	BOLT – HEX FLG HD TFL M8 X 1.25 X 16-8.8-A3L		
N	152655	BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L		

54. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction. For 90° drive gearbox serviceable components, refer to Section [10 90° Drive Gearbox – Internal Components, page 27](#).
55. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction. For 90° drive gearbox serviceable components, refer to Section [10 90° Drive Gearbox – Internal Components, page 27](#).
56. The grease zerk is located in the center of the cross.
57. The grease zerk is located in the cap.

## 9 Mechanical Drives – R116



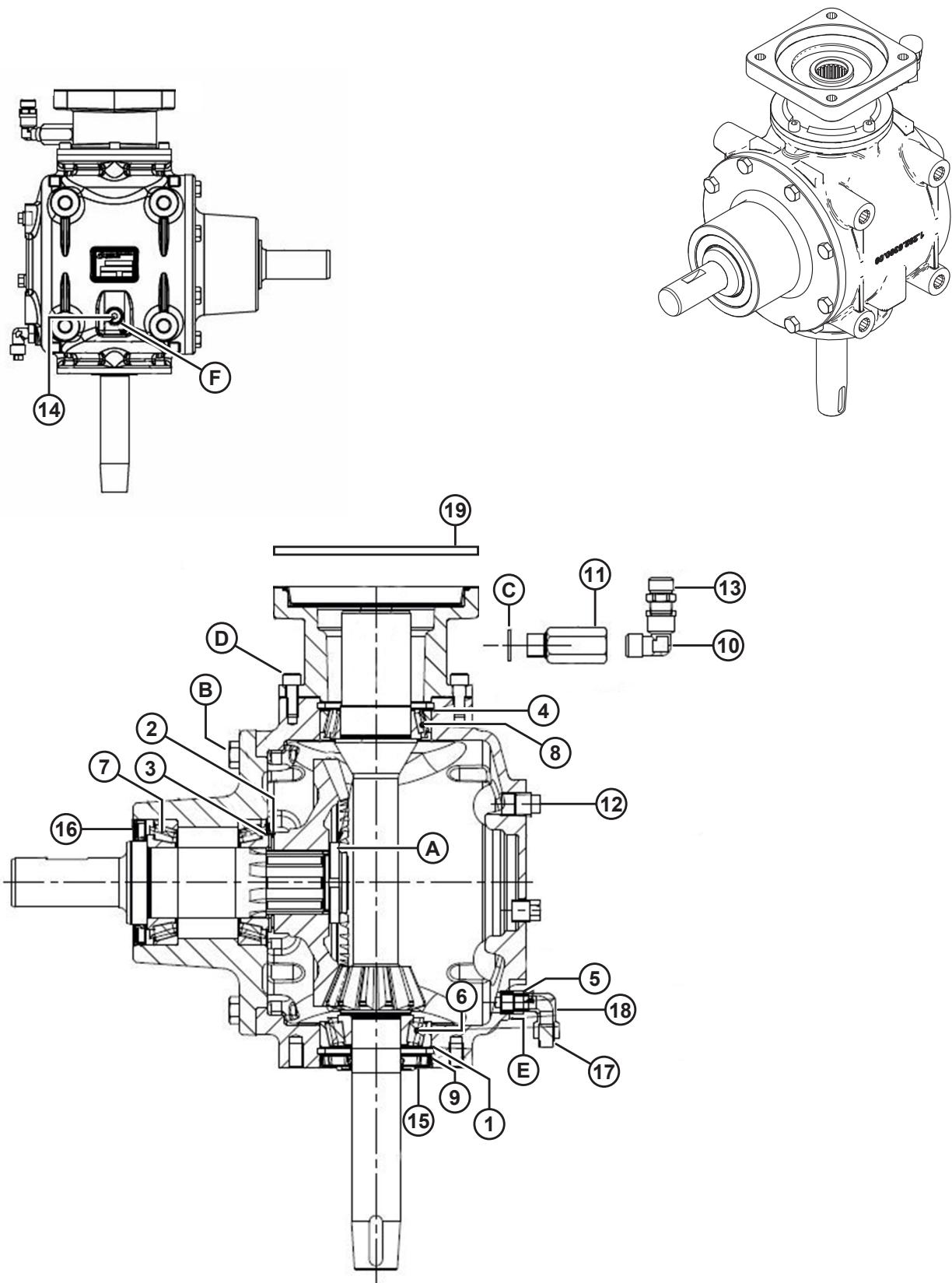
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**MECHANICAL DRIVES – R116**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	257187	KIT – GEARBOX <sup>58</sup>	1	321190–
	257174	KIT – GEARBOX <sup>59</sup>	1	–321189
2	256372	SHIELD – WELDMENT	1	
3	222269	KEY	1	
4	247103	HUB – DRIVE	1	
5	256582	SUPPORT – TENSIONER WELDT	1	
6	259139	ASSEMBLY – DRIVELINE	1	
	259142	ASSEMBLY – CROSS JOURNAL, CENTER ZERK <sup>60</sup>		
	247120	ASSEMBLY – CROSS JOURNAL, CAP ZERK <sup>61</sup>		
	247121	YOKE		
	247122	YOKE – FLANGE		
7	222291	SPACER	4	
8	256352	PLATE – COVER	1	
9	256371	BRACKET	1	
10	281497	SHIELD WELD'T – DRUM	2	
11	259115	SHIELD – VERTICAL WELD'T	1	
12	281493	PLATE WELDMENT – BACK	1	
13	281500	PLATE – COVER	1	
14	259116	PLATE – SHIELD	1	
15	281489	DRUM – TOP	1	
A	136151	BOLT – HEX FLG HD TFL M10 X 1.5 X 16-8.8-A3L		
B	4762	WASHER – FLAT		
C	135491	BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L		
D	320226	WASHER – HARD M16-360HV-ZINC		
E	136143	BOLT – HEX HD TFL M16 X 2 X 30-10.9-A3L		
F	148799	BOLT – HEX FLG HD M12 X 1.75 X 45-10.9-A3L		
G	135903	BOLT – RHSN M12 X 1.75 X 25-8.8-A3L		
H	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
J	152685	BOLT – RHSN M16 X 2 X 40-10.9-A3L		
K	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
L	136137	BOLT – HEX HD TFL M16 X 2 X 35-8.8-A3L		
M	136485	BOLT – HEX FLG HD TFL M8 X 1.25 X 16-8.8-A3L		
N	152655	BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L		

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58. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction. For 90° drive gearbox serviceable components, refer to Section [10 90° Drive Gearbox – Internal Components, page 27](#).
59. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction. For 90° drive gearbox serviceable components, refer to Section [10 90° Drive Gearbox – Internal Components, page 27](#).
60. The grease zerk is located in the center of the cross.
61. The grease zerk is located in the cap.

## 10 90° Drive Gearbox – Internal Components



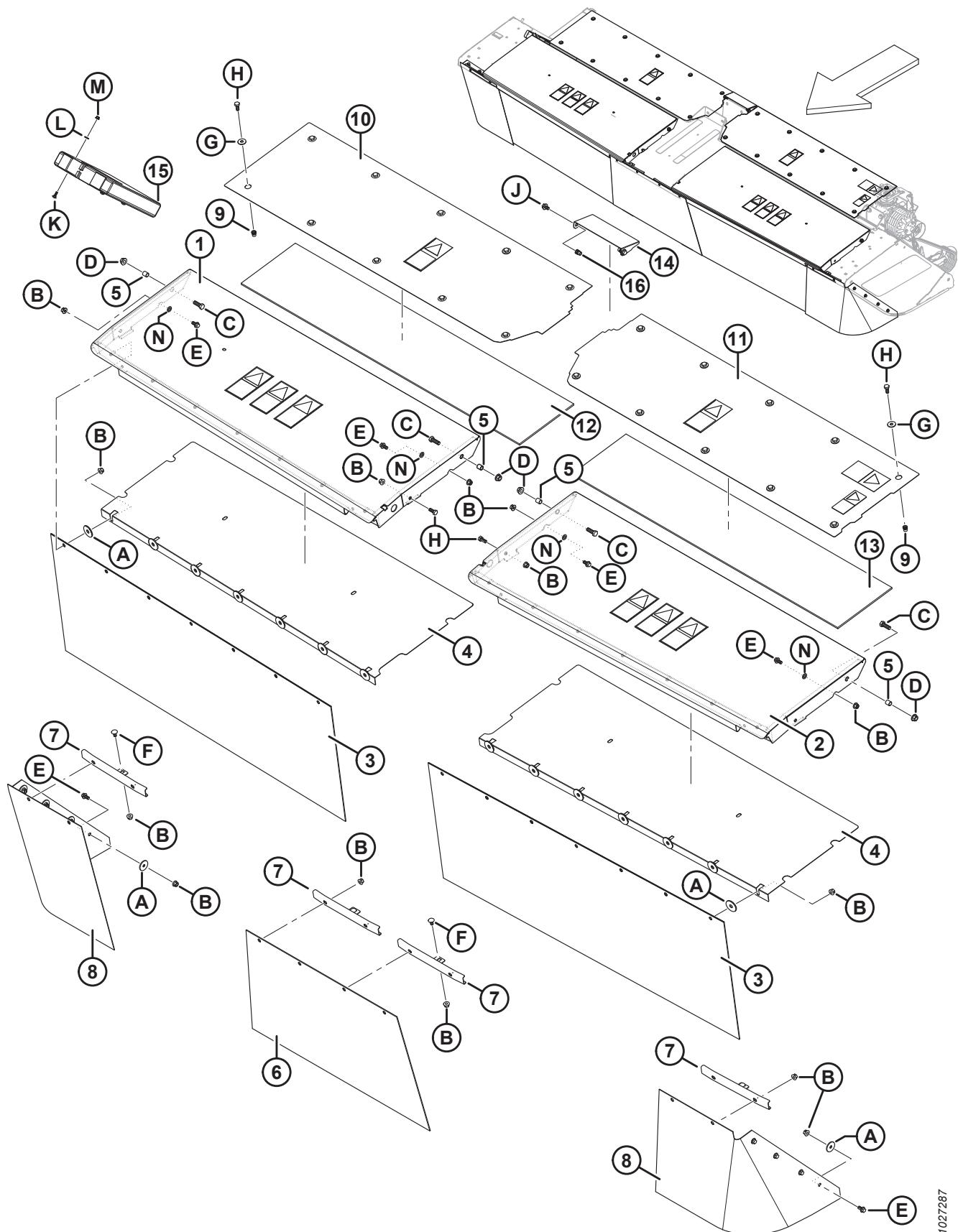
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**90° DRIVE GEARBOX – INTERNAL COMPONENTS**

Ref	Part Number	Description	Qty	Serial Number
	257187	KIT – GEARBOX <sup>62</sup>	1	321190–
	257174	KIT – GEARBOX <sup>63</sup>	1	–321189
1	257033	SHIM KIT		
2	257042	SHIM		
3	257043	SHIM		
4	257044	SHIM		
5	257162	REDUCER		
6	257049	BEARING – TAPERED ROLLER		
7	150871	BEARING – TAPERED ROLLER		
8	257052	BEARING – TAPERED ROLLER		
9	257055	RING – SNAP		
10	257056	ELBOW – 90°		
11	257089	EXTENSION		
12	257058	PLUG – EXTERNAL		
13	236994	PLUG – BREATHER		
14	257125	PLUG – MAGNETIC		
15	257062	SEAL – DOUBLE LIP		
16	257063	SEAL – OIL		
17	257128	PLUG – MAGNETIC		
18	257090	ELBOW		
19	257061	SEAL – DOUBLE LIP <sup>64</sup>		321190–
	257150	O-RING <sup>65</sup>		–321189
A	100709	NUT – SPECIAL M40 X 1.5 CLASS 8.8		
B	257053	BOLT		
C	257054	WASHER – COPPER		
D	257064	BOLT		
E	257126	WASHER – COPPER		
F	257127	WASHER – COPPER		

- 
- 62. Kit applies to 2018 and later model year units and is used to replace a damaged or faulty 90° drive gearbox. Kit includes 90° drive gearbox, drive alignment tool assembly (MD #325683), and R1 SP installation instruction.
  - 63. Kit applies to 2017 model year units only and is used to replace a damaged or faulty 90° drive gearbox. Kit includes Gearbox kit (MD #257187), magnetic plug (MD #257060), and R1 gearbox service instruction.
  - 64. Service part for Gearbox kit (MD #257187). Ensure the correct part is used. Seal (MD #257061) and O-ring (MD #257150) are **NOT** interchangeable.
  - 65. Service part for Gearbox kit (MD #257174). Ensure the correct part is used. O-ring (MD #257150) and seal (MD #257061) are **NOT** interchangeable.

## 11 Header Shields – R113



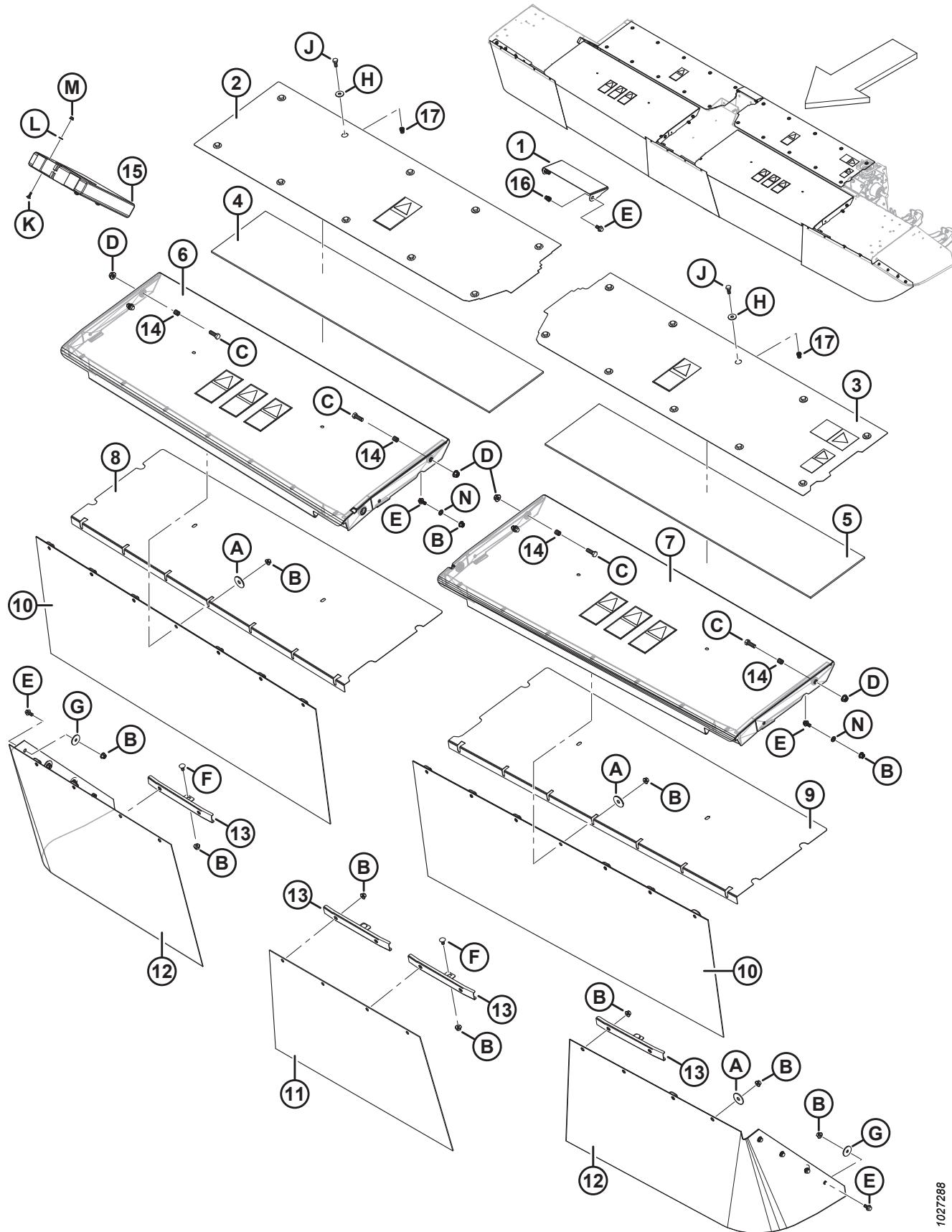
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**HEADER SHIELDS – R113**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	246876	ASSEMBLY – RH COVER C/W DECALS <sup>66</sup>	1	
2	246874	ASSEMBLY – LH COVER C/W DECALS <sup>67</sup>	1	
3	256507	SHIELD – DOOR	2	
4	246388	LINER – COVER	2	
5	224313	SPACER	4	
6	256504	SHIELD – CENTER	1	
7	224686	SUPPORT – FRONT SHIELD	4	
8	256503	SHIELD – CORNER	2	
9	136843	RIVNUT – M10 X 1.5 HEX M10 0.7-3.8	20	
10	256412	ASSEMBLY – RH TOP SHIELD C/W DECALS <sup>68</sup>	1	
11	256633	ASSEMBLY – LH TOP SHIELD C/W DECALS <sup>68</sup>	1	
12	246346	LINER – RH FRAME	1	
13	256409	LINER – LH FRAME	1	
14	246413	SHIELD – REAR	1	
15	118234	CASE – MANUALS	1	
16	136876	RIVNUT – M10 X 1.5 HEX M10 3.8-7.9	2	
A	42592	WASHER – FLAT		
B	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
C	152730	BOLT – HEX HD TFL M12 X 1.75 X 35-10.9-A3L		
D	148645	NUT – HEX FLG STVR LOC M12 X 1.75-10-A3L		
E	152655	BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L		
F	184657	BOLT – RHSSN M10 X 1.5 X 20-8.8-A3L		
G	184712	WASHER – FLAT LARGE M10-200HV-A3L		
H	30627	BOLT – HEX HD TFL M10 X 1.5 X 25-8.8-A3L		
J	136151	BOLT – HEX FLG HD TFL M10 X 1.5 X 16-8.8-A3L		
K	184641	BOLT – RHSN M6 X 1 X 20-8.8-A2L		
L	18596	WASHER – SAE FLAT 9/32 ID X 5/8 IN OD ZP		
M	152668	NUT – HEX FLG CTR LOC M6 X 1-8-A2L		
N	184711	WASHER – FLAT REG M10-200HV-AA1J		

- 
66. Includes information decals (MD #194465, 247167, and 194466) and MacDon top decal (MD #246997).  
 67. Includes information decals (MD #194465, 247167, and 194466) and R113 SP top decal (MD #256333).  
 68. Includes information decal (MD #190546).

## 12 Header Shields – R116



1027288

## HEADER SHIELDS – R116

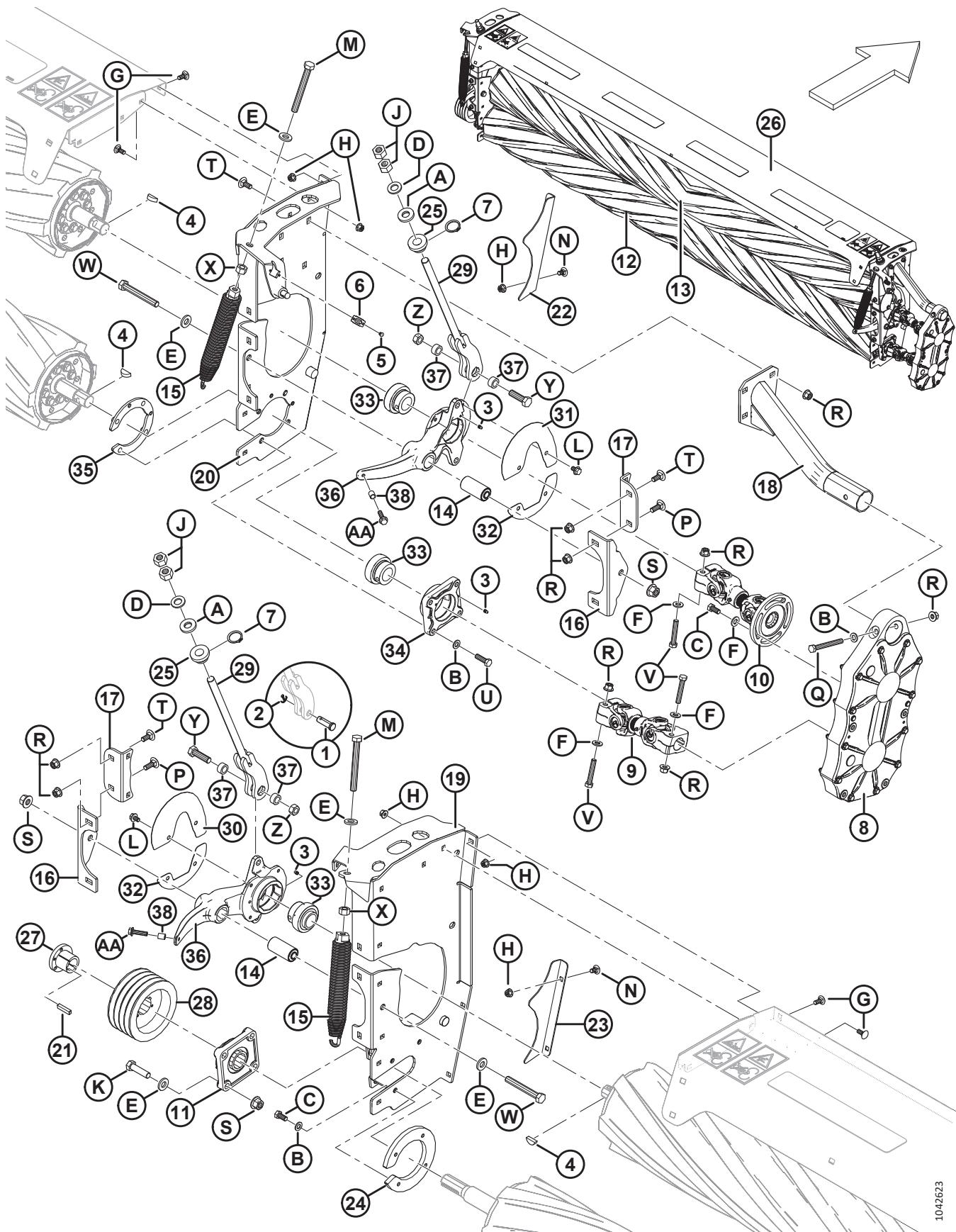
Ref	Part Number	Description	Qty	Serial Number
1	246413	SHIELD – REAR	1	
2	256412	ASSY – TOP SHIELD C/W DECALS, RH <sup>69</sup>	1	
3	256633	ASSY – TOP SHIELD C/W DECALS, LH <sup>69</sup>	1	
4	246346	LINER – FRAME, RH	1	
5	256409	LINER – FRAME, LH	1	
6	246876	ASSEMBLY – RH COVER C/W DECALS <sup>70</sup>	1	
7	246874	ASSEMBLY – LH COVER C/W DECALS <sup>71</sup>	1	
8	224471	LINER – COVER, RH	1	
9	246388	LINER – COVER, LH	1	
10	256507	SHIELD – DOOR	2	
11	256504	SHIELD – CENTER	1	
12	256508	SHIELD – CORNER 16 FT	2	
13	224686	SUPPORT – FRONT SHIELD	4	
14	224313	SPACER	4	
15	118234	CASE – MANUALS	1	
16	136876	RIVNUT – M10 X 1.5 HEX M10 3.8-7.9	2	
17	136843	RIVNUT – M10 X 1.5 HEX M10 0.7-3.8	20	
A	42592	WASHER – FLAT		
B	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
C	152730	BOLT – HEX HD TFL M12 X 1.75 X 35-10.9-A3L		
D	148645	NUT – HEX FLG STVR LOC M12 X 1.75-10-A3L		
E	152655	BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L		
F	184657	BOLT – RHSSN M10 X 1.5 X 20-8.8-A3L		
G	136428	WASHER – FLAT LARGE M10-200HV-A3L		
H	184712	WASHER – FLAT LARGE M10-200HV-A3L		
J	30627	BOLT – HEX HD TFL M10 X 1.5 X 25-8.8-A3L		
K	184641	BOLT – RHSN M6 X 1 X 20-8.8-A2L		
L	18596	WASHER – SAE FLAT 9/32 ID X 5/8 IN OD ZP		
M	152668	NUT – HEX FLG CTR LOC M6 X 1-8-A2L		
N	184711	WASHER – FLAT REG M10-200HV-AA1J		

69. Includes information decal (MD #190546).

70. Includes information decals (MD #194465, 247167, and 194466) and MacDon top decal (MD #246997).

71. Includes information decals (MD #194465, 247167, and 194466) and R116 SP top decal (MD #256334).

## 13 Roll Conditioner – Polyurethane/Steel



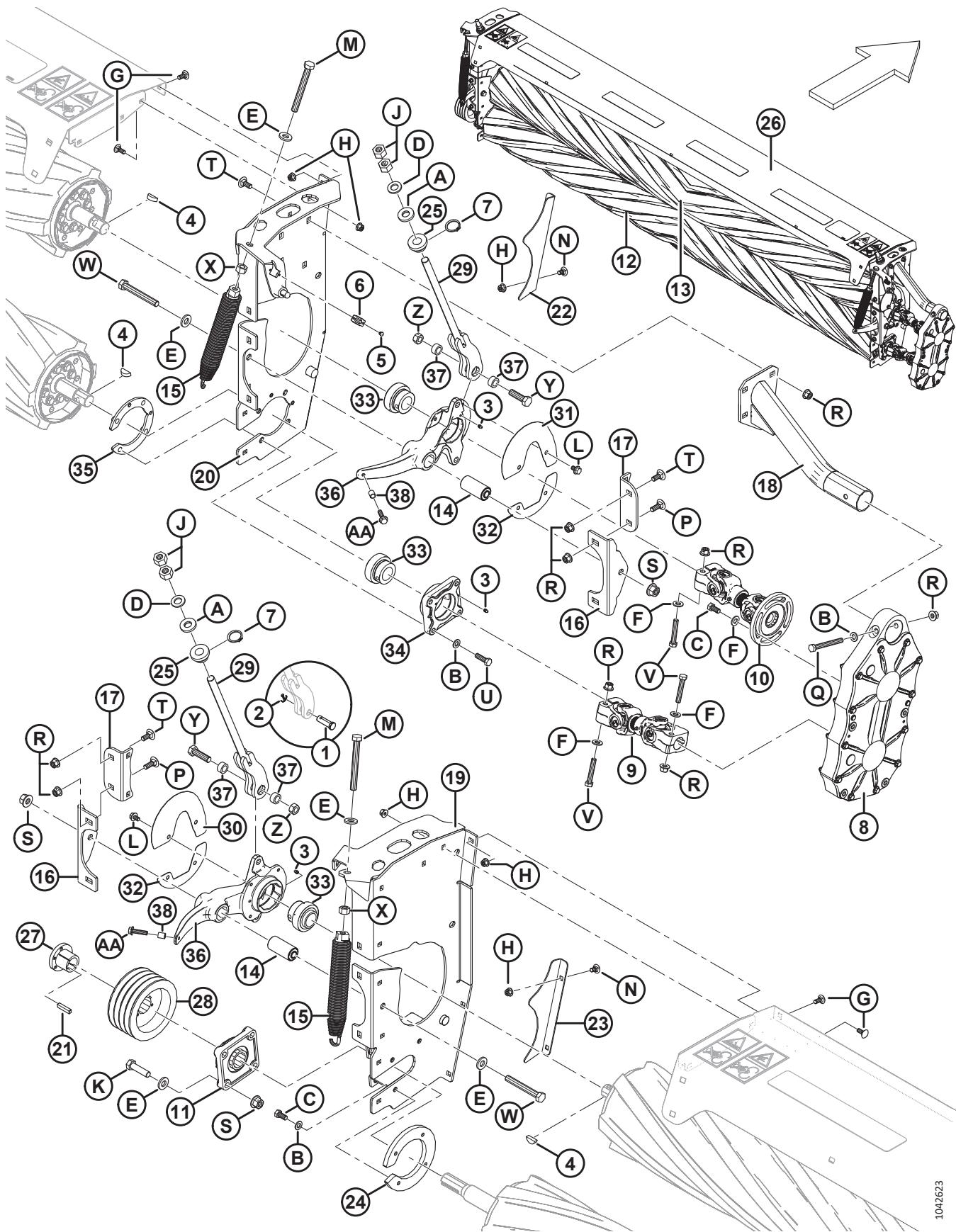
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**ROLL CONDITIONER – POLYURETHANE/STEEL**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
	B6557	KIT – POLY ROLLER CONDITIONER, SP <sup>72</sup>		
	B6558	KIT – STEEL ROLLER CONDITIONER, SP <sup>72</sup>		
1	18620	PIN – CLEVIS <sup>73</sup>	2	<b>-486189</b>
2	18648	PIN – COTTER 3/16 DIA X 1.25 ZP <sup>73</sup>	2	<b>-486189</b>
3	18671	FITTING – LUBE 1/4, 28 UNF	3	
4	30836	KEY – WOODRUFF (3/8 X 1 1/4 NOM.)	3	
5	113799	RIVET – POP	2	
6	<b>REF</b>	<b>CLIP – TOLERANCE</b> <sup>74</sup>	<b>1</b>	
7	136832	RING – EXT RETAINING HEAVY DUTY	2	
8	307211	DRIVE – GEAR (CONDITIONER ROLL TIMING) <sup>75</sup>	1	
9	221765	DRIVELINE – LOWER	1	
	198329	YOKE		
	124541	CROSS JOURNAL KIT		
10	221768	DRIVELINE – UPPER	1	
	149399	YOKE – FLANGE		
	198329	YOKE		
	124541	CROSS JOURNAL KIT		
11	221769	HOUSING – FLANGED	1	
12	221937	ROLL – LOWER POLY	1	
	307889	ROLL – LOWER STEEL	1	
13	221938	ROLL – UPPER POLY	1	
	247832	ROLL – UPPER STEEL	1	
14	222658	BUSHING – RUBBER	2	
15	222664	ASSEMBLY – SPRING	2	
16	222988	BRACKET – PIVOT	2	
17	223406	ANGLE – COND PANEL	2	
18	223467	SUPPORT – WELDMENT	1	
19	256580	LH PANEL – C/W DECALS	1	
20	247856	RH PANEL – C/W DECALS	1	
21	246424	KEY – 10 MM X 8 MM X 45 MM	1	
22	246751	GUARD – RH POLY ROLL <sup>76</sup>	1	
	246747	GUARD – RH STEEL ROLL <sup>77</sup>	1	
23	246752	GUARD – LH POLY ROLL <sup>76</sup>	1	
	246748	GUARD – LH STEEL ROLL <sup>77</sup>	1	
24	281325	PLATE – CLAMP, POLY ROLL <sup>76</sup>	1	
	281324	PLATE – CLAMP, STEEL ROLL <sup>77</sup>	1	
25	246799	STOP – PLASTIC	2	

- 
72. Kits available through Whole Goods only.  
 73. Used on the model year 2023 and prior roll stop (MD #247259).  
 74. Tolerance clip (MD #135813) is superseded by latch assembly (MD #320524), which includes latch (NSS), tolerance clip (NSS), and latch nut (NSS).  
 75. For service parts, refer to Section *15 Roll Conditioner – Gear Drive, page 41*.  
 76. For polyurethane roll only.  
 77. For steel roll only.

## **ROLL CONDITIONER – POLYURETHANE/STEEL**



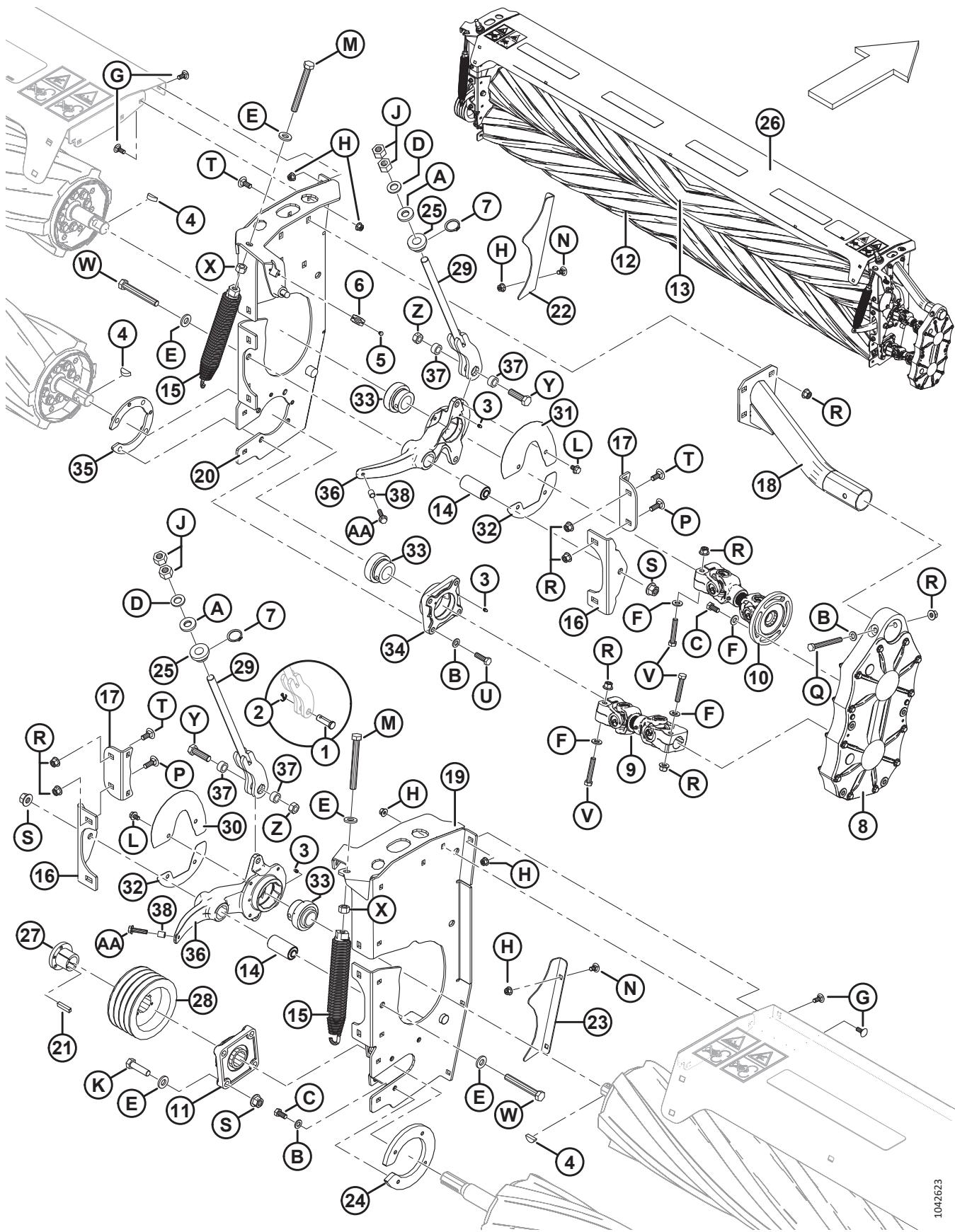
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**ROLL CONDITIONER – POLYURETHANE/STEEL**

Ref	Part Number	Description	Qty	Serial Number
26	256581	COVER – ROLL COND, C/W ANTI-SLIPS	1	
27	246844	BUSHING	1	
28	246847	PULLEY – 4 HB	1	
29	247259	STOP – WELDT <sup>78</sup>	2	<b>-486189</b>
	<b>259621</b>	<b>STOP – WELDT <sup>79</sup></b>	<b>2</b>	<b>486190–</b>
30	256574	SHIELD – LH, C/W DECAL	1	
31	256573	SHIELD – RH, C/W DECAL	1	
32	256497	SHIELD – ROLL ARM, LOWER	2	
33	247307	BEARING – SPH OD C/W COLLAR 1.5 IN BORE	3	
34	247309	HOUSING – MACHINED	1	
35	247420	PLATE – BRG HSG, FLOW DRILLED	1	
36	<b>259622</b>	<b>KIT – ROLL STOP W/ BUSHING R1 <sup>80</sup></b>	<b>2</b>	<b>-486189</b>
	<b>359253</b>	<b>ARM – ROLL - C/W BUSHING <sup>81</sup></b>	<b>2</b>	<b>486190–</b>
37	<b>325857</b>	<b>TUBE – PIVOT</b>	<b>4</b>	<b>486190–</b>
38	<b>338003</b>	<b>SPACER – ROLL ARM</b>	<b>2</b>	<b>486190–</b>
A	16235	WASHER – FLAT		
B	184714	WASHER – FLAT REG M12-300HV-A3L		
C	50155	BOLT – HEX HD TFL M12 X 1.75 X 25-8.8-A3L		
D	320225	WASHER – HARD M20-300HV-ZINC		
E	320226	WASHER – HARD M16-300HV-ZINC		
F	135369	WASHER – HARDENED		
G	135785	BOLT – RHSN M10 X 1.5 X 25-8.8-A3L		
H	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
J	136124	NUT – HEX M20 X 2.5-10-A3L		
K	184681	BOLT – HEX HD M16 X 2 X 50-8.8-AA1JL		
L	136151	BOLT – HEX FLG HD TFL M10 X 1.5 X 16-8.8-A3L		
M	136172	BOLT – HEX HD TFL M16 X 2 X 140-8.8-A3L		
N	136178	BOLT – RHSN M10 X 1.5 X 20-8.8-A3L		
P	136291	BOLT – RHSN TFL M12 X 1.75 X 35-8.8-A3L		
Q	136423	BOLT – HEX HD M12 X 1.75 X 110-8.8-A3L		
R	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
S	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
T	184667	BOLT – RHSN M12 X 1.75 X 30-8.8-A3L		
U	184669	BOLT – HEX HD M12 X 1.75 X 40-8.8-A3L		
V	184675	BOLT – HEX HD M12 X 1.75 X 70-8.8-A3L		
W	184678	BOLT – HEX HD M16 X 2 X 120-8.8-A3L		

- 
78. Service part for model year 2023 and prior headers that haven't already been updated with roll stop kit (MD #259622). For information on the roll stop kit, refer to Section [14 Roll Conditioner – Roll Arms and Stops, page 39](#)
79. Used on model year 2024 and later headers.
80. If you are replacing the superseded roll arm (MD #247828) on model year 2023 and prior headers, you need to order Roll Stop kit (MD #259622), which includes roll arm (MD #359253), roll stop (MD #259621), and hardware. Roll stop (MD #247259) is **NOT** compatible with roll arm (MD #359253). For more information to identify which roll arm and roll stop your header currently has installed, refer to Section [14 Roll Conditioner – Roll Arms and Stops, page 39](#)
81. Includes roll arm (NSS), bolt (MD #152947), spacer (MD #338003), and two bushings (MD #222658).

## **ROLL CONDITIONER – POLYURETHANE/STEEL**

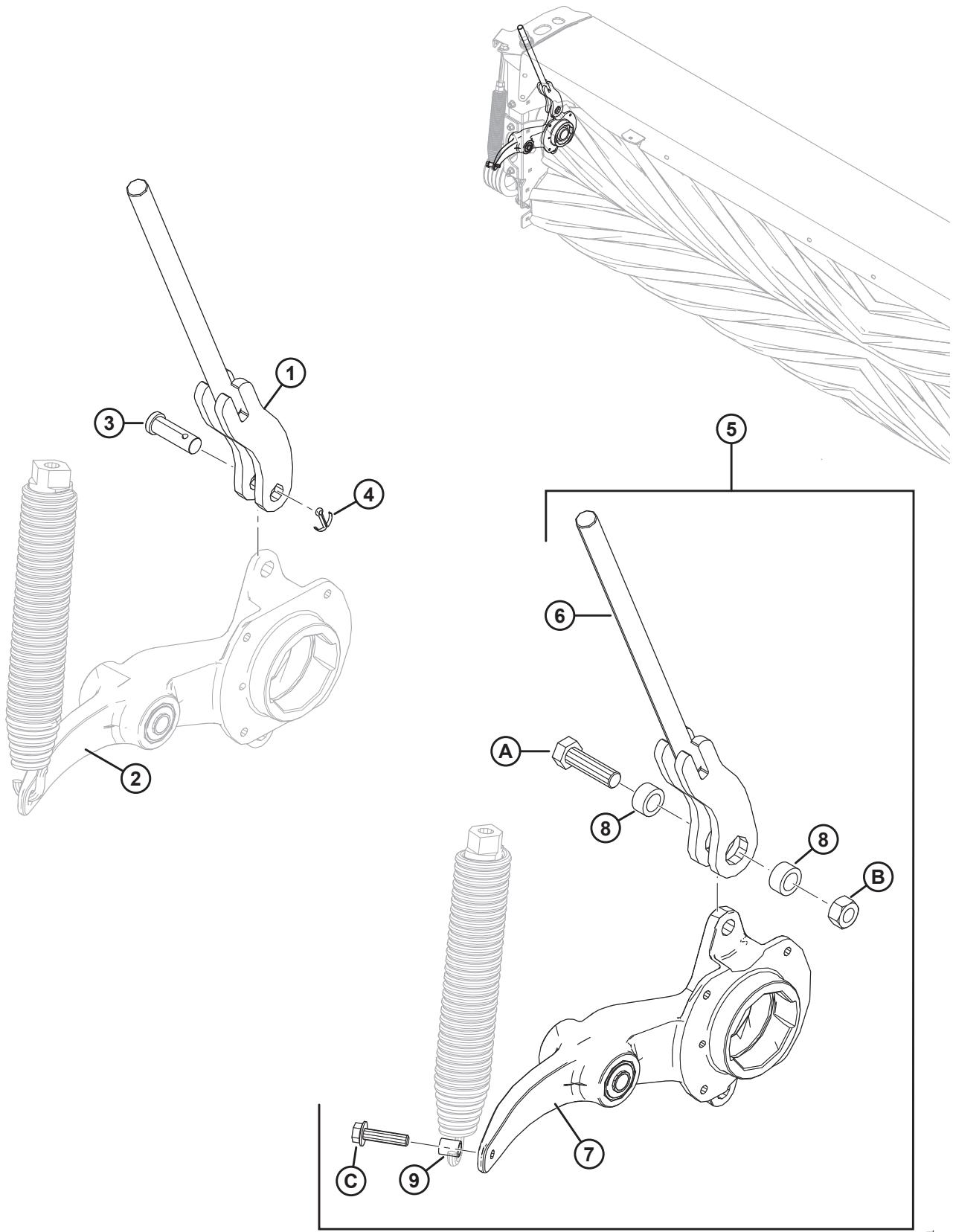


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**ROLL CONDITIONER – POLYURETHANE/STEEL**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
X	184699	NUT – HEX M16 X 2-8-A3L		
Y	<b>136717</b>	<b>BOLT – HEX HD M16 X 2 X 55-10.9</b>		<b>486190–</b>
Z	320208	NUT – HEX CTR LOCK M16 X 2-12-ZINC		486190–
AA	152947	BOLT – HEX FLG HD TFL M10 X 1.5 X 40-10.9-AA1J		486190–

## 14 Roll Conditioner – Roll Arms and Stops



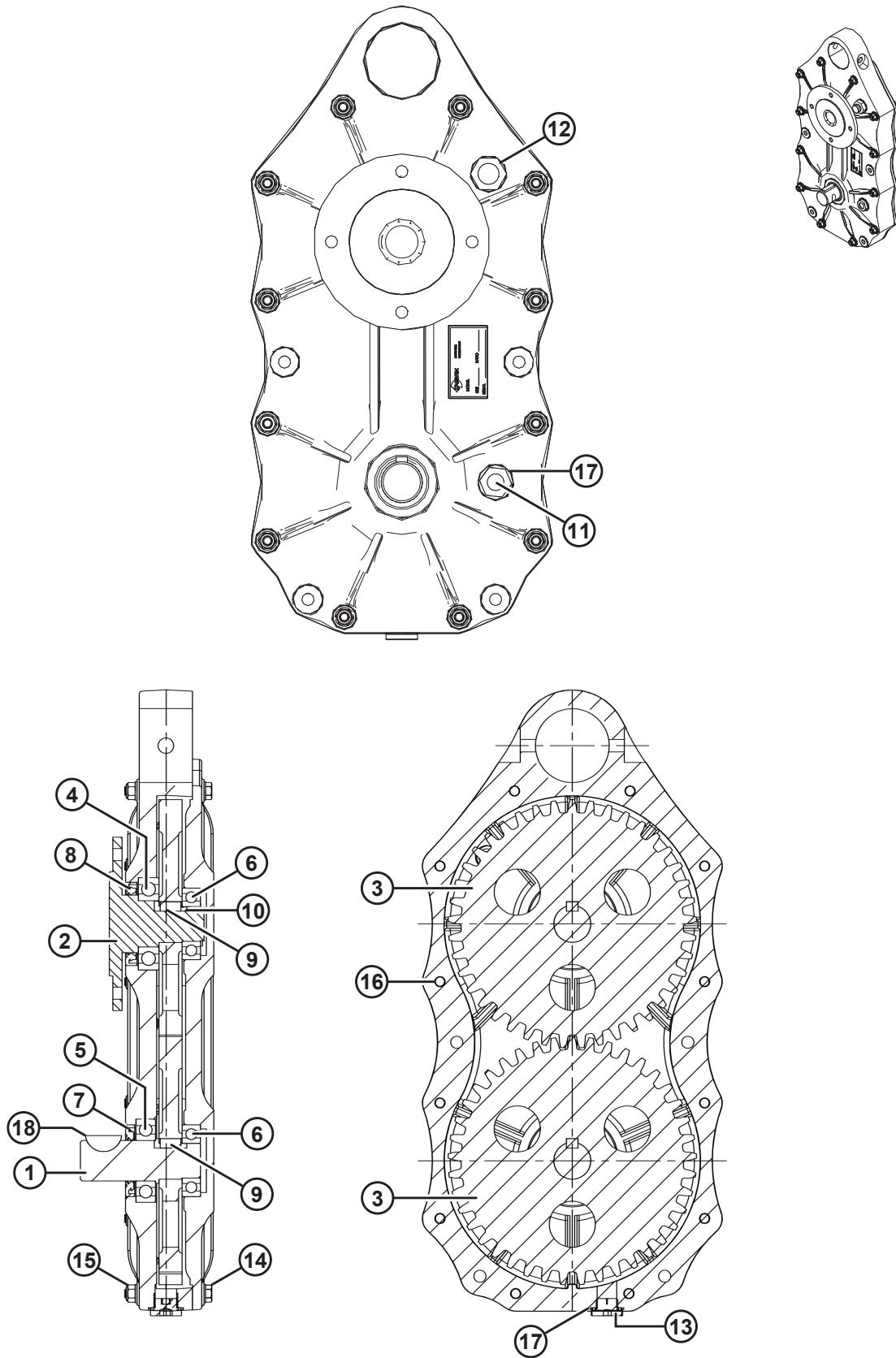
1042651

## ROLL CONDITIONER – ROLL ARMS AND STOPS

Ref	Part Number	Description	Qty	Serial Number
1	247259	STOP – WELDT <sup>82</sup>	1	285420-486189
2	REF	ARM – ROLL, C/W BUSHING <sup>83</sup>	1	285420-486189
3	18620	PIN – CLEVIS <sup>84</sup>	1	285420-486189
4	18648	PIN – COTTER 3/16 DIA X 1.25 ZP <sup>84</sup>	1	285420-486189
5	259622	KIT – ROLL STOP W/ BUSHING R1 <sup>83</sup>	1	285420-486189
6	259621	STOP – WELDT <sup>85</sup>	1	486190-
7	359253	ARM – ROLL - C/W BUSHING <sup>86</sup>	1	486190-
8	325857	TUBE – PIVOT	2	486190-
9	338003	SPACER – ROLL ARM	1	486190-
A	136717	BOLT – HEX HD M16 X 2 X 55-10.9		486190-
B	320208	NUT – HEX CTR LOCK M16 X 2-12-ZINC		486190-
C	152947	BOLT – HEX FLG HD TFL M10 X 1.5 X 40-10.9-AA1J		486190-

- 
82. Service part for model year 2023 and prior headers that haven't already been updated with roll stop kit (MD #259622). Stop (MD #247259) is secured to the roll arm using a clevis pin.
83. If you are replacing the superseded roll arm (MD #247828) on model year 2023 and prior headers, you need to order Roll Stop kit (MD #259622), which includes roll arm (MD #359253), roll stop (MD #259621), and hardware. The superseded roll arm is identified by the spring hooking directly into the hole in the arm.
84. Used on the model year 2023 and prior roll stop (MD #247259).
85. Used on model year 2024 and later headers. Stop MD #259621 is secured to the arm using a bolt, nut, and two bushings.
86. Includes roll arm (NSS), bolt (MD #152947), spacer (MD #338003), and two bushings (MD #222658). This roll arm is identified by the spring hooking around the bolt and spacer.

## 15 Roll Conditioner – Gear Drive



1030416

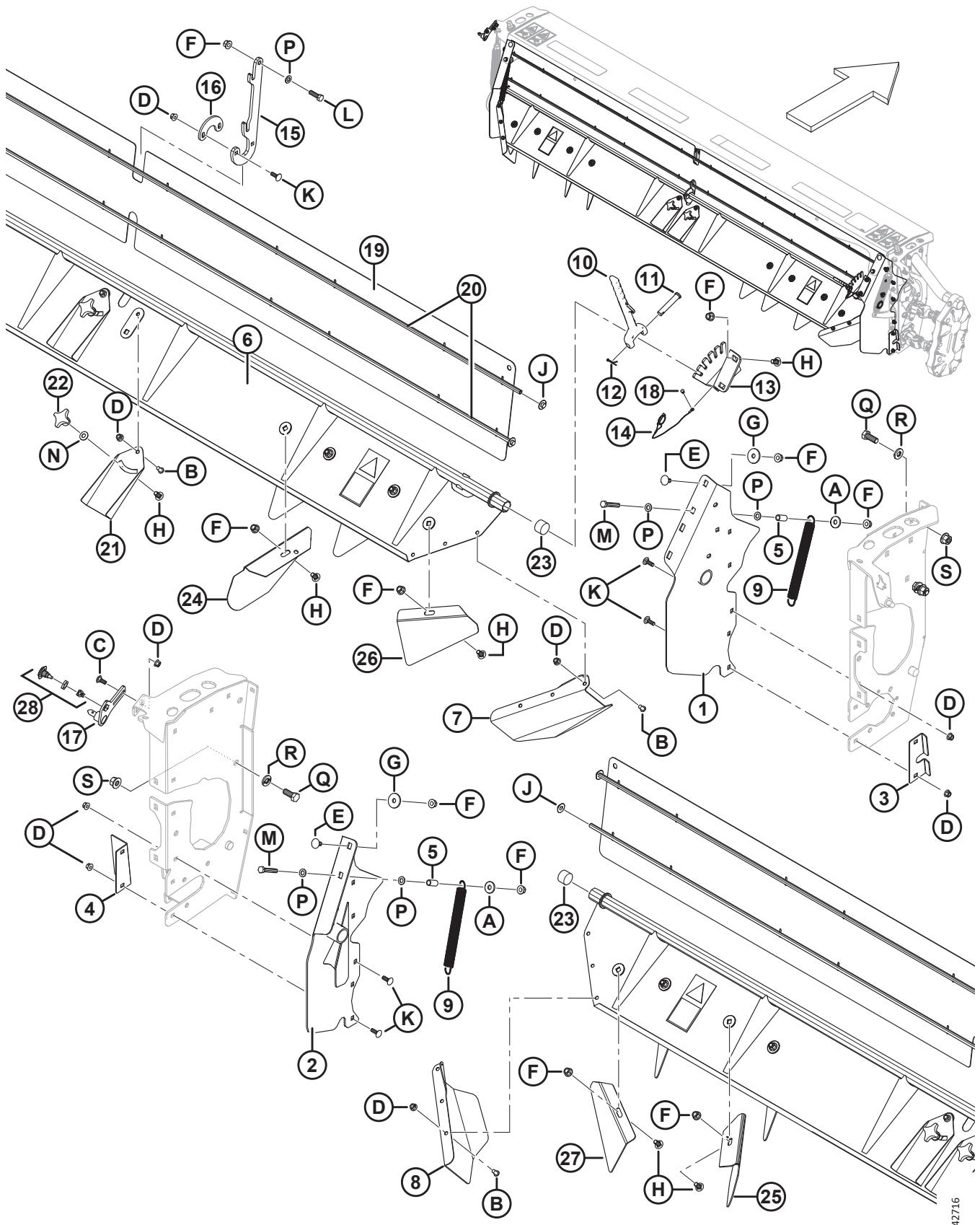
**ROLL CONDITIONER – GEAR DRIVE**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
	307211	DRIVE – GEAR (CONDITIONER ROLL TIMING) <sup>87</sup>		
1	247183	SHAFT – INPUT	1	
2	247184	SHAFT – OUTPUT, 4 BOLT FLANGE	1	
3	247185	GEAR – SPUR	2	
4	247186	BEARING – OUTPUT SHAFT	1	
5	247187	BEARING – INPUT SHAFT	1	
6	247188	BEARING	2	
7	247189	SEAL – INPUT SHAFT	1	
8	247190	SEAL – OUTPUT SHAFT	1	
9	247191	KEY – 10 X 8 X 18L, HARDENED	2	
10	247192	RING – SNAP	1	
11	247193	PLUG – OIL LEVEL, 1/2 BSPP	1	
12	247194	BREATHER – 1/2 BSPP	1	
13	247195	PLUG – DRAIN, 1/2 BSPP	1	
14	247196	BOLT – M8 X 70	12	
15	247197	NUT – M8	12	
16	247199	PIN – 6 X 12L	1	
17	247265	WASHER – 21.5 X 26 X 2T	1	
18	30836	KEY – WOODRUFF (3/8 X 1 1/4 NOM)	1	

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87. Refer to Section [13 Roll Conditioner – Polyurethane/Steel, page 33.](#)

## 16 Roll Conditioner – Shields



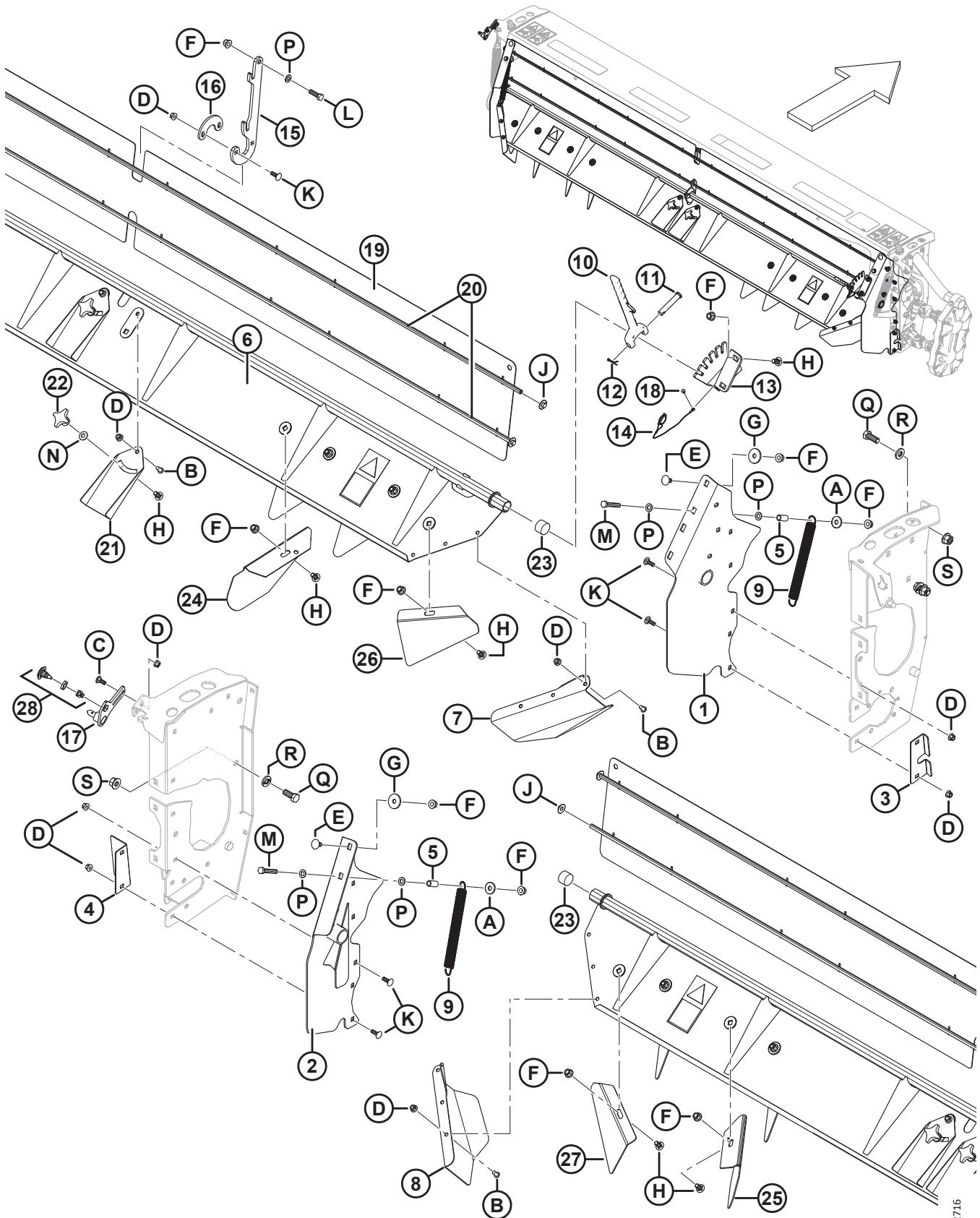
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**ROLL CONDITIONER – SHIELDS**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	281339	DEFLECTOR – RH WELDT	1	
2	281338	DEFLECTOR – LH WELDT	1	
3	223014	SHIELD – RH	1	
4	224039	SHIELD – LH	1	
5	17675	SPACER	2	
6	256612	BAFFLE – C/W DECALS, ROLL CONDITIONER	1	
7	281583	DEFLECTOR – RH	1	
8	281582	DEFLECTOR – LH	1	
9	246175	SPRING – EXTENSION	2	
10	281818	HANDLE – BAFFLE, MACHINED	1	
11	19958	PIN – CLEVIS	1	
12	18648	PIN – COTTER 3/16 DIA X 1.25 ZP	1	
13	246224	BRACKET	1	
14	135945	LYNCH PIN – C/W LANYARD 3/16 PIN	1	
15	247323	HOOK – BAFFLE SUPPORT	1	
16	224977	PLATE	1	
17	<b>246226</b>	<b>STUD – WELDMENT</b>	<b>1</b>	
18	113799	RIVET – POP	1	
19	247275	CURTAIN – CONDITIONER	1	
20	247433	LINE – HYDRAULIC, 1/2 IN DIA., 3315 MM LG	2	
21	224869	FIN – BAFFLE	2	
22	246355	KNOB – PLASTIC, M12	2	
23	137980	PLUG	2	
24	256547	DEFLECTOR – RH FIN	3	
25	256546	DEFLECTOR – LH FIN	3	
26	256405	DEFLECTOR – RH END FIN	1	
27	256404	DEFLECTOR – LH END FIN	1	
28	<b>320524</b>	<b>ASSY – LATCH 3MM SLOT<sup>88</sup></b>	<b>2</b>	
A	4761	WASHER – FLAT		
B	135723	BOLT – BUTTON HD HEX SOCKET ZP M10 X 20		
C	135785	BOLT – RHSN M10 X 1.5 X 25-8.8-A3L		
D	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
E	135903	BOLT – RHSN M12 X 1.75 X 25-8.8-A3L		
F	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
G	166747	WASHER – FLAT, 12.95 MM ID, 45 MM OD, 4.5 MM THK		
H	152439	BOLT – RHSSN M12 X 1.75 X 25-8.8-A3L		
J	252219	NUT – PUSH ON CAP 1/2 STUD		
K	184662	BOLT – RHSN TFL M10 X 1.5 X 30-8.8-A3L		
L	184669	BOLT – HEX HD M12 X 1.75 X 40-8.8-A3L		
M	184675	BOLT – HEX HD M12 X 1.75 X 70-8.8-A3L		
N	184596	WASHER – CON SPRING M12 A STL SAE 1050-1075		
P	184714	WASHER – FLAT REG M12-300HV-A3L		
Q	111528	BOLT – HEX HD TFL M16 X 2 X 40-8.8-A3L		

88. Includes latch (NSS), tolerance clip (NSS), and latch nut (NSS).

## ROLL CONDITIONER – SHIELDS

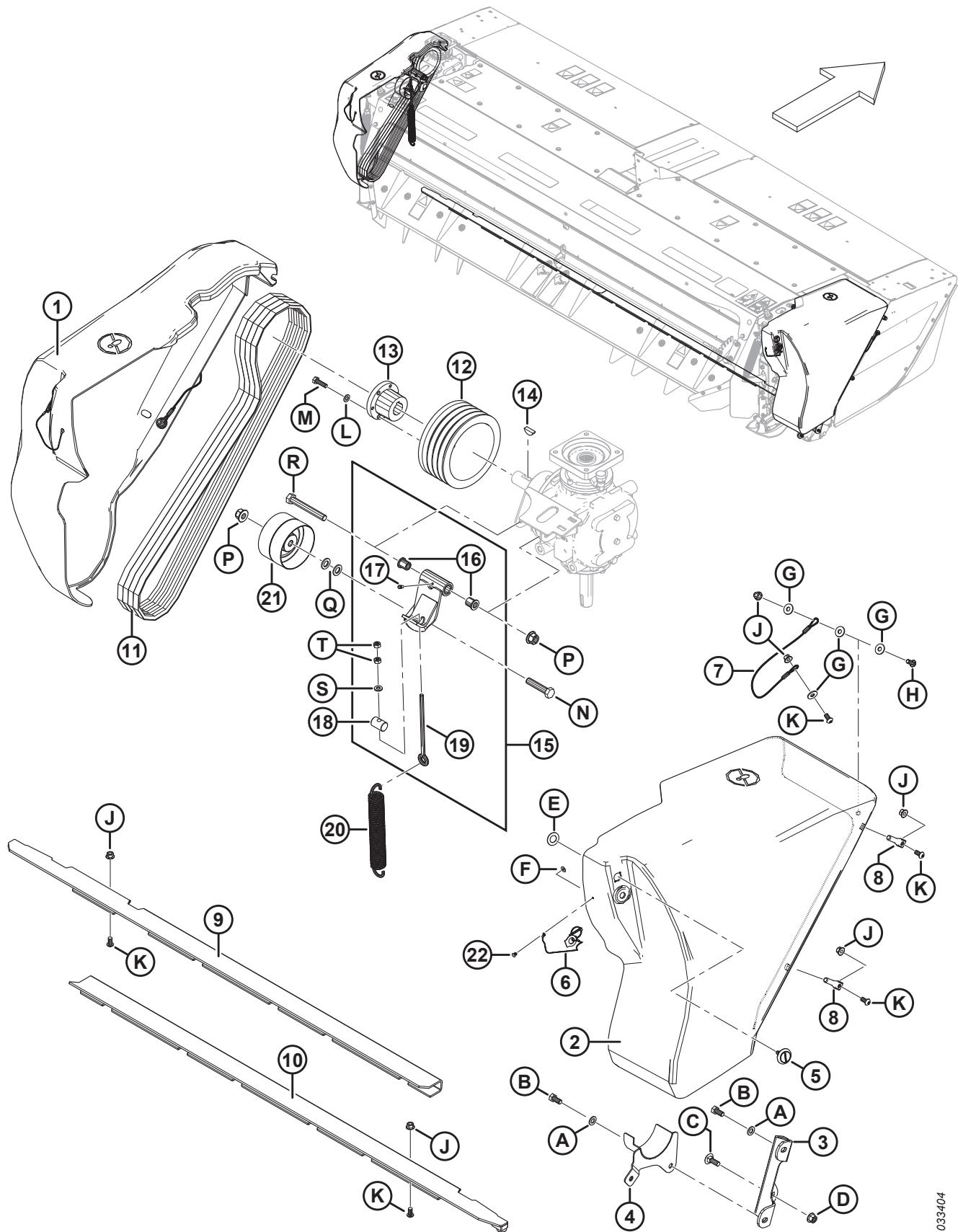


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**ROLL CONDITIONER – SHIELDS**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
R	320226	WASHER – HARD M16-360HV-ZINC		
S	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		

## 17 Roll Conditioner – Header Attachment



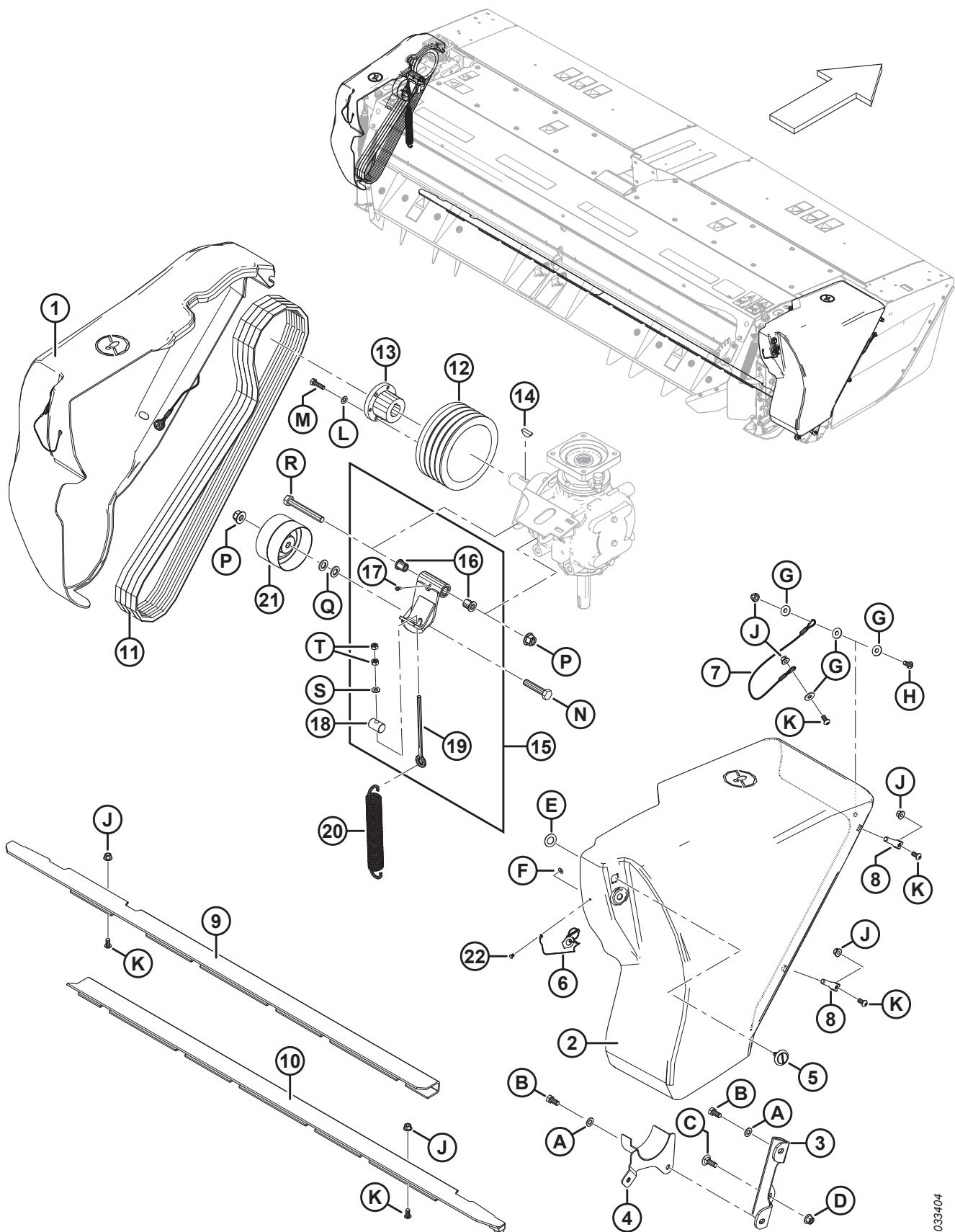
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**ROLL CONDITIONER – HEADER ATTACHMENT**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	257093	SHIELD ASSEMBLY – LH <sup>89</sup>	1	
2	224562	SHIELD ASSEMBLY – RH <sup>89</sup>	1	
3	238054	BRACKET – LOWER GEARBOX MOUNT	1	
4	256272	GUARD – DRIVELINE WELDT	1	
5	135815	LATCH – 3 MM SLOT <sup>90</sup>	2	
6	246583	LYNCH PIN – C/W LANYARD 3/16 PIN	2	
7	224605	CABLE – SHIELD ANCHOR	2	
8	112624	RETAINER – PIN	2	
9	256192	DEFLECTOR – WELDT, LH (R113) <sup>91</sup>	1	
	256640	PLATE – DEFLECTOR, LH (R116) <sup>92</sup>	1	
10	256199	DEFLECTOR – WELDT, RH (R113) <sup>91</sup>	1	
	256641	PLATE – DEFLECTOR, RH (R116) <sup>92</sup>	1	
11	222028	BELT – PU CONDITIONER DRIVE	1	
12	281073	PULLEY – 4 HB	1	
13	246845	BUSHING	1	
14	281315	KEY – WOODRUFF (10 X 32 NOM.)	1	
15	281695	KIT – BELT TENSIONER <sup>93</sup>	1	
16	221997	BUSHING – FLANGED 16 X 22 X 25L	2	
17	7782	FITTING – LUBRICATION 1/4-28 TAPER THD	1	
18	281644	PIN – STRAIGHT	1	
19	281986	BOLT – EYE <b>192 MM LG</b> <sup>94</sup>	1	
20	245966	SPRING – EXTENSION	1	
21	149183	PULLEY – IDLER	1	
22	113799	RIVET – POP	2	
A	184714	WASHER – FLAT REG M12-300HV-A3L		
B	50155	BOLT – HEX HD TFL M12 X 1.75 X 25-8.8-A3L		
C	136291	BOLT – RHSN TFL M12 X 1.75 X 35-8.8-A3L		
D	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
E	5113	WASHER – FLAT		
F	184701	WASHER – FLAT LARGE M5-200HV-A2L		
G	30635	WASHER – FLAT REG M10-STL-SOFT-A2L		
H	135852	SCREW – HEX SOC BTN HD M10 X 1.5 X 25-12.9-A3L		
J	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		

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89. The shield comes assembled with lynch pin (MD #246583), pop rivet (MD #113799), cable (MD #224605), and hardware.
90. Order latch (MD #135815) until stock is depleted; then order latch assembly (MD #320524), which includes latch (NSS), tolerance clip (NSS), and latch nut (NSS).
91. Used on R113 headers.
92. Used on R116 headers.
93. The kit includes tensioner weldment (NSS), two bushings (MD #221997), two hex nuts (MD #30505), washer (MD #30655), straight pin (MD #281644), grease fitting (MD #7782), grease decal (MD #23164), and 230 mm eye bolt (MD #281685). Use a 192 mm eye bolt (MD #281986) on a roll conditioner instead of the 230 mm eye bolt included in the kit.
94. Belt tensioner kit (MD #281695) includes a 230 mm eye bolt (MD #281685), but use the 192 mm eye bolt (MD #281986) on a roll conditioner.

ROLL CONDITIONER – HEADER ATTACHMENT



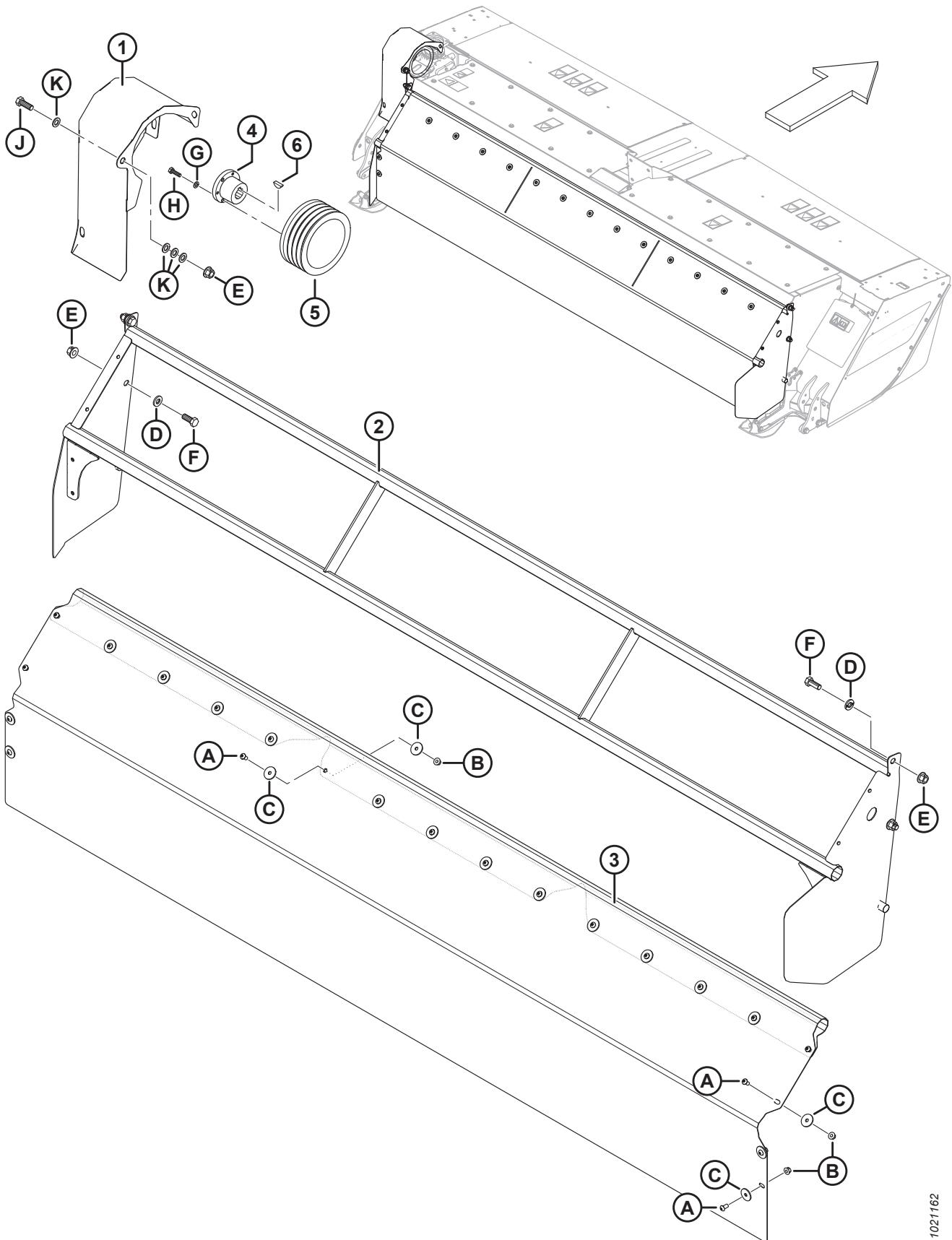
1033404

**ROLL CONDITIONER – HEADER ATTACHMENT**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
K	135723	SCREW – HEX SOC BTN HD M10 X 1.5 X 20-10.9-A3L		
L	184711	WASHER – FLAT REG M10-200HV-A3L		
M	30628	BOLT – HEX HD M10 X 1.5 X 35-8.8-A3L		
N	181511	BOLT – HEX HD M16 X 2 X 75-10.9-A3L		
P	152520	NUT – HEX FLG TECH LOC M16 X 2-10-A3L		
Q	184717	WASHER – FLAT REG M16-200HV-A3L <sup>95</sup>		
R	184678	BOLT – HEX HD M16 X 2 X 120-8.8-A3L		
S	30655	WASHER – HARD ASTM F436 M10-340HV-AB2C		
T	30505	NUT – HEX M10 X 1.5-10-A3L		

- 
95. Use one or two washers (MD #184717) between pulley (MD #149183) and tensioner weldment (NSS) as required to align the belt drive.

## 18 No Conditioner Option – Shields



1021162

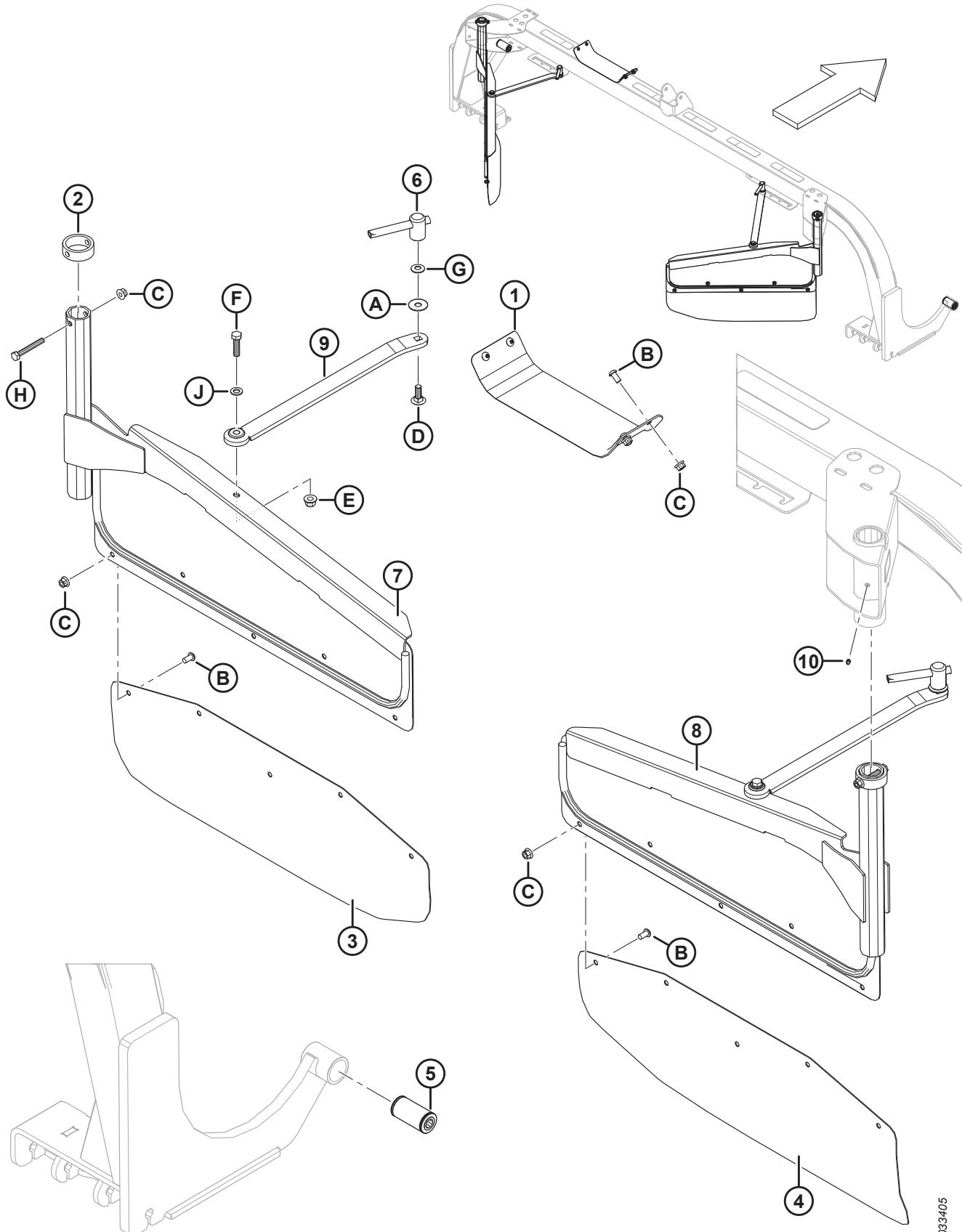
**NO CONDITIONER OPTION – SHIELDS**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
	B5818	KIT – NO CONDITIONER <sup>96</sup>		
1	256442	COVER – DRIVE, WELDT	1	
2	224327	FRAME – NO COND SHIELDS, WELDT	1	
3	224320	SHIELD – CURTAIN	1	
4	246845	BUSHING	1	
5	281073	PULLEY – 4 HB <sup>97</sup>	1	
6	281315	KEY – WOODRUFF (10 X 32 NOM.)	1	
A	135723	BOLT – BUTTON HD HEX SOCKET ZP M10 X 20		
B	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
C	136428	WASHER – FLAT LARGE M10-200HV-A3L		
D	320226	WASHER – HARD M16-360HV-ZINC		
E	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
F	111528	BOLT – HEX HD TFL M16 X 2 X 40-8.8-A3L		
G	184711	WASHER – FLAT REG M10-200HV-A3L		
H	30628	BOLT – HEX HD M10 X 1.5 X 35-8.8-A3L		
J	136132	BOLT – HEX HD TFL M16 X 2 X 45-8.8-A3L		
K	184717	WASHER – FLAT REG M16-200HV-A3L		

96. Kits available through Whole Goods only.

97. Pulley is factory-installed and not included in bundle B5818.

## 19 Adapter Frame

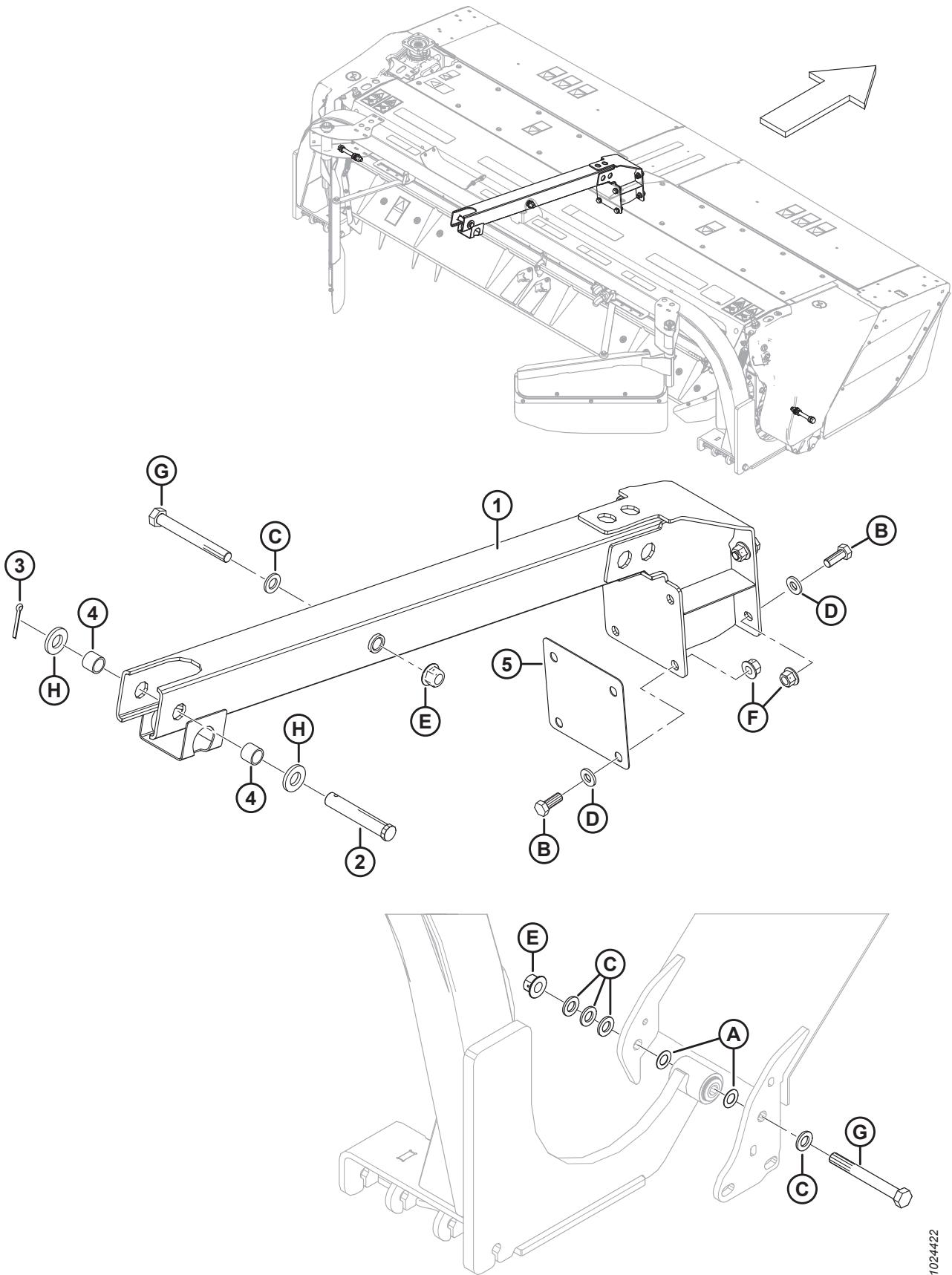


1033405

**ADAPTER FRAME**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	146474	SUPPORT – HOSE	1	
2	257112	TUBE – CAP	2	
3	224761	SHIELD	1	
4	224762	SHIELD	1	
5	246198	BUSHING – RUBBER	2	
6	247693	ASSEMBLY – HANDLE	2	
7	256024	DEFLECTOR – LH WELDT	1	
8	256029	DEFLECTOR – RH WELDT	1	
9	256054	BAR – ADJUSTMENT WELDT	2	
10	18671	FITTING – LUBE	2	
A	32247	WASHER – FLAT		
B	135723	SCREW – HEX SOC BTN HD M10 X 1.5 X 20-10.9-A3L		
C	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
D	136291	BOLT – RHSN TFL M12 X 1.75 X 35-8.8-A3L		
E	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
F	136881	BOLT – HEX HD M12 X 1.75 X 45-10.9-A3L		
G	184596	WASHER – CON SPRING M12A STL		
H	184659	BOLT – HEX HD M10 X 1.5 X 75-8.8-A3L		
J	184714	WASHER – FLAT REG M12-300HV-A3L		

## 20 Center-Link and Adapter to Header Connections



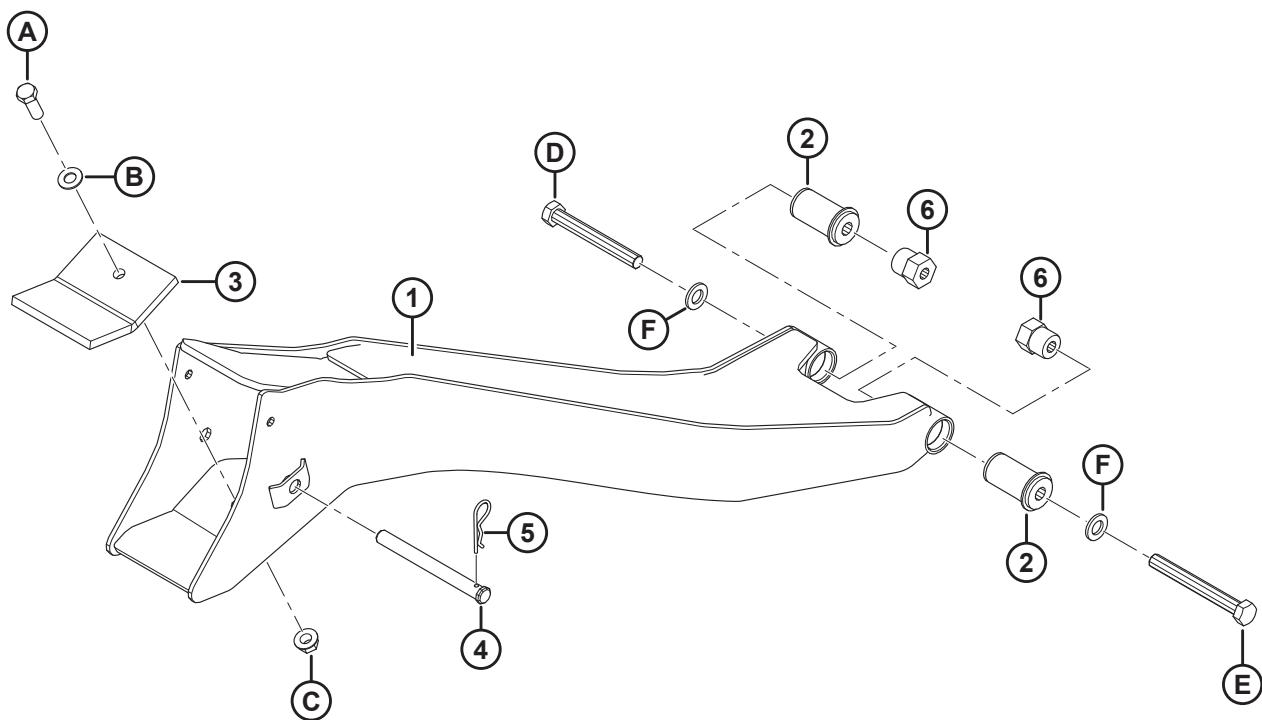
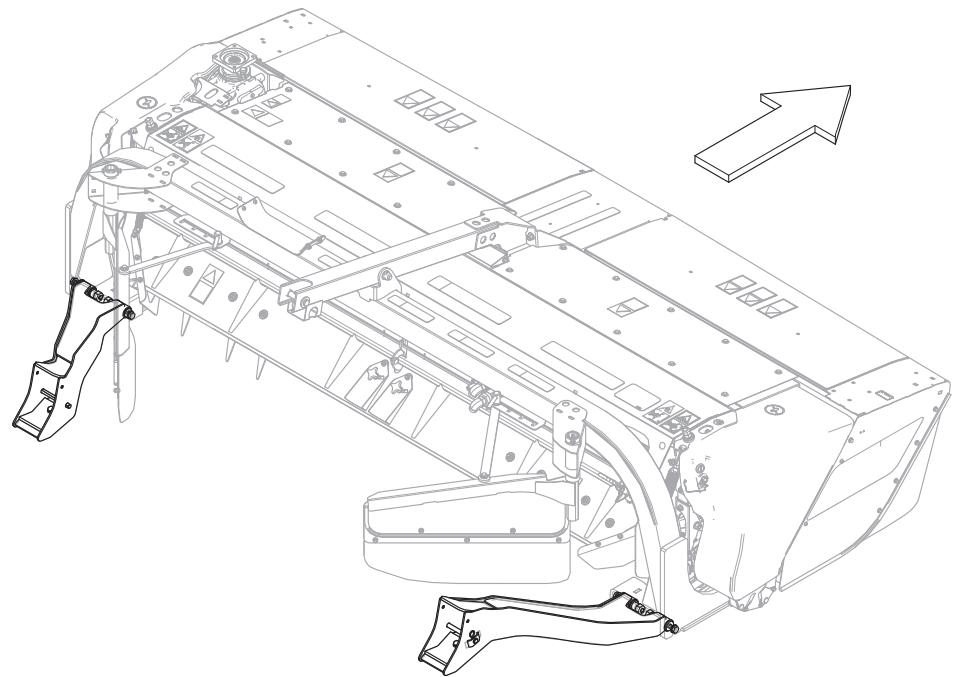
1024422

**CENTER-LINK AND ADAPTER TO HEADER CONNECTIONS**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	256246	ANCHOR – CENTER-LINK	1	
2	49341	PIN – CLEVIS	1	
3	18609	PIN – COTTER 1/4 DIA X 2 ZP	1	
4	136690	SPACER	2	
5	256516	PLATE – SHIM <sup>98</sup>	A/R	
A	5113	WASHER – FLAT <sup>99</sup>		
B	111528	BOLT – HEX HD TFL M16 X 2 X 40-8.8-A3L		
C	112130	WASHER – HARD ASTM F436 3/4-400HV-AB3C		
D	120901	WASHER – HARD L9 SPCL 5/8-82/85 HR15N-AB3C		
E	136122	NUT – HEX FLG CTR LOC M20 X 2.5-10-A3L		
F	136440	NUT – HEX FLG CTR LOC M16 X 2-10-A3L		
G	136650	BOLT – HEX HD M20 X 2.5 X 170-8.8-A3L		
H	174858	WASHER – FLAT		

- 
98. Shim as needed only at rear of center-link anchor (MD #256246), maximum 2 mm gap.  
 99. Washer (1.2 mm thick) used as a shim. Insert washers as required evenly on both sides of the header to minimize the gap on each side of the rubber bushings between frame plates before tightening bolts.

## 21 Lift Assembly

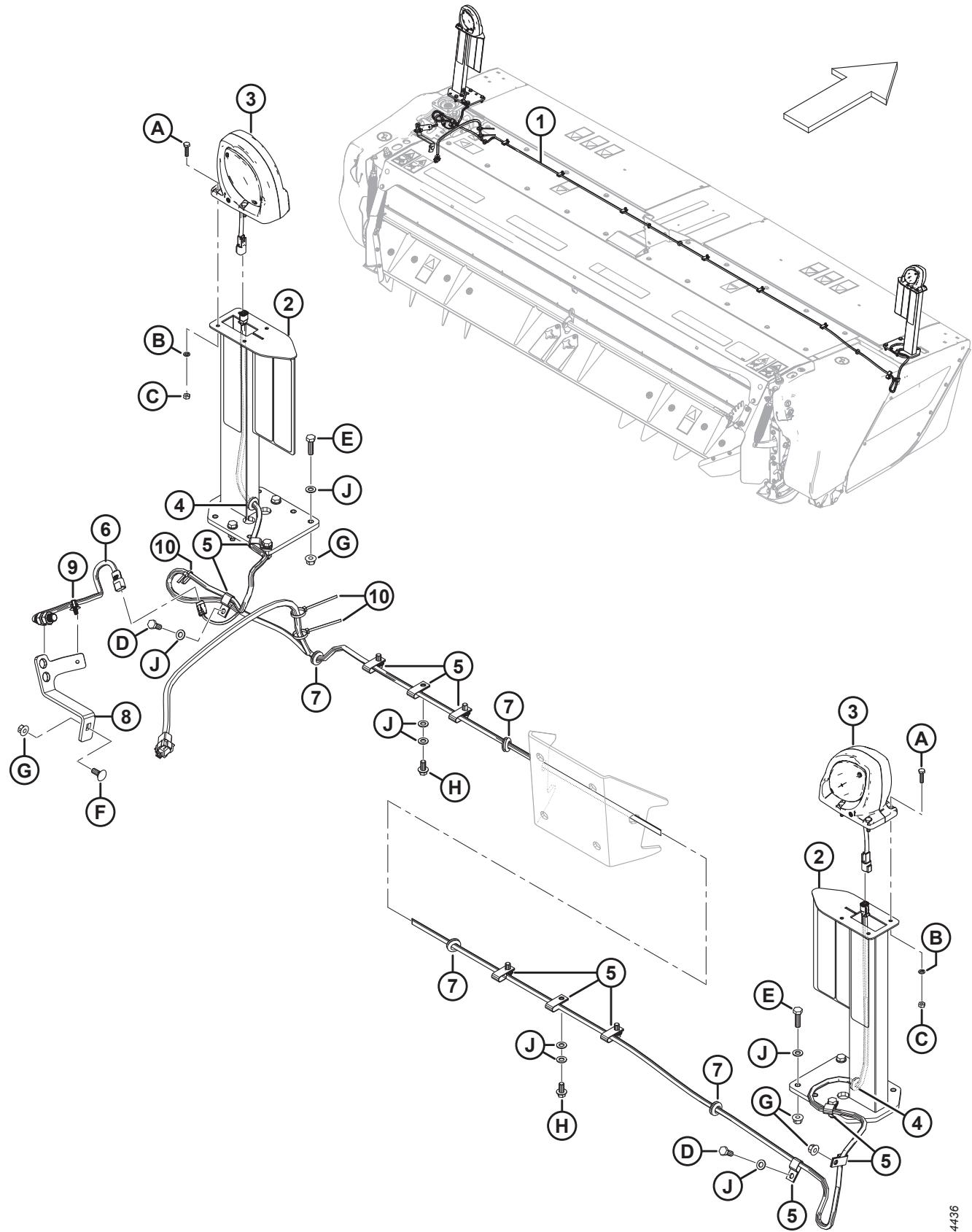


1024476

**LIFT ASSEMBLY**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	256047	MEMBER – BOOT C/W BUSHINGS, RH	1	
	256046	MEMBER – BOOT C/W BUSHINGS, LH	1	
2	149342	BUSHING – RUBBER	4	
3	150454	PAD – RUBBER	2	
4	135408	PIN – CLEVIS	2	
5	13125	PIN – HAIR	2	
6	257186	SPACER – MACHINED	4	
A	21582	BOLT – HH 5/8 NC X 1.75 LG GR5 ZP		
B	18600	WASHER – SAE FLAT 21/32 ID X 1 5/16 IN OD ZP		
C	50225	NUT – FLANGE DT SMOOTH FACE .625-11 UNC		
D	30743	BOLT – HH 3/4 NC X 6.0 LG GR 5 ZP		
E	30387	BOLT – HH 3/4 NC X 6.5 LG GR 5 ZP		
F	112130	WASHER – HARD ASTM F436 3/4-400HV-AB3C		

## 22 Wiring Assembly



1024436

## WIRING ASSEMBLY

**NOTE:**

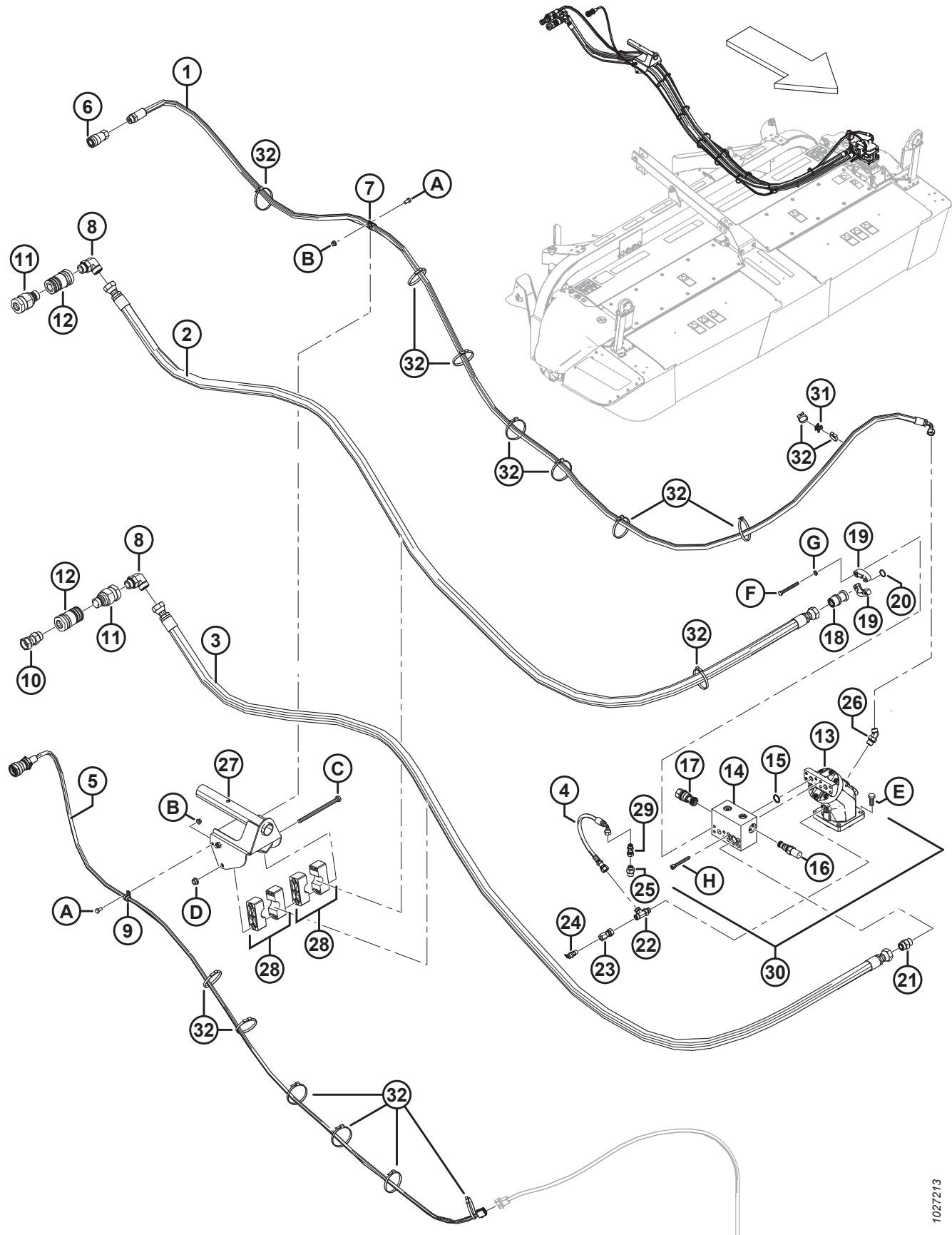
For electrical harness parts, refer to Electrical Connector Parts Catalog (MD #169641).

Ref	Part Number	Description	Qty	Serial Number
1	256584	HARNESS – R1 SP	1	
2	256338	ASSEMBLY – LAMP, MOUNT <sup>100</sup>	2	
3	203547	LAMP – CLEARANCE, DT CONNECTOR	2	
	139630	LENS – AMBER		
4	256545	GROMMET	2	
5	135233	CLAMP – DOUBLE HOSE INSULATED	11	
6	136167	SENDER – SPEED	1	
7	206482	GROMMET	4	
8	257028	BRACKET – SPEED SENSOR	1	
9	136655	FASTENER – FIR TREE MT C/W TIE	1	
10	21763	FASTENER – CABLE TIE, BLACK	3	
A	21573	BOLT – HEX HD 1/4 NC X 1.0 LG GR 5 ZP		
B	18635	WASHER – REG. LOCK 1/4 IN. NOM. ID ZP		
C	18588	NUT – HEX 1/4-20 UNC GR 5 ZP		
D	30627	BOLT – HEX HD TFL M10 X 1.5 X 25-8.8-A3L		
E	30628	BOLT – HEX HD M10 X 1.5 X 35-8.8-A3L		
F	135785	BOLT – RHSN M10 X 1.5 X 25-8.8-A3L		
G	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
H	152655	BOLT – HEX FLG HD M10 X 1.5 X 20-8.8-A3L		
J	184711	WASHER – FLAT REG M10-200HV-A3L		

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100. Lamp mount assembly includes three reflectors (MD #115145, 115146, and 115147).

## 23 Hydraulic Drive – R113 and R116 to M1170



1027213

**HYDRAULIC DRIVE – R113 AND R116 TO M1170**

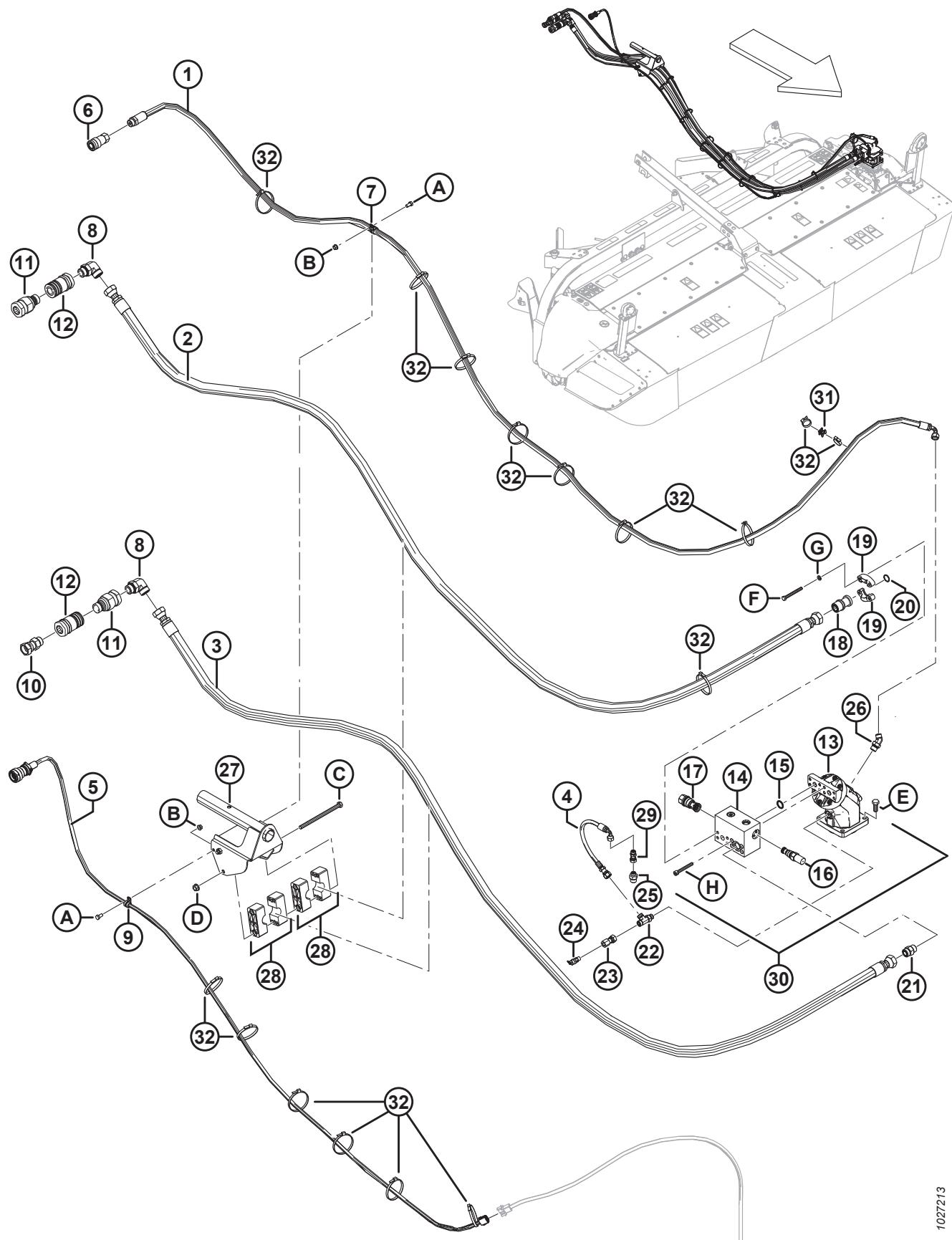
Ref	Part Number	Description	Qty	Serial Number
	B6621	KIT – R1 TO M1170 HYDRAULIC DRIVE <sup>101</sup>		
1	256110	HOSE – CASE DRAIN, 1/2 IN. DIA., 4660 MM LG	1	
2	256108	HOSE – HYD. HIGH PRESSURE, 1 IN. I.D., 4985 MM LG	1	
3	256109	HOSE – HYDRAULIC RETURN, 1 IN. I.D., 4130 MM LG	1	
4	256621	HOSE – DRAIN, 1/4 IN. DIA., 430 MM LG	1	
5	256586	HARNESS – M1 TO R1 DISC HEADER	1	
6	135474	COUPLER – HYDRAULIC, 1/2 IN. FEMALE FF	1	
7	135709	CLAMP – INSULATED 3/4 IN.	1	
8	135734	FITTING – ELBOW 90° HYD	2	
	50220	O-RING – #16 ORB		
	135554	O-RING – #16 ORFS		
9	135818	CLAMP – INSULATED 1/2 IN.	1	-421189
	135709	CLAMP – INSULATED 3/4 IN.	1	421190–
10	136362	FITTING – ADAPTER	1	
	50220	O-RING – #16 ORB		
11	136412	FITTING – COUPLING MALE 1 IN.	2	
12	136413	FITTING – COUPLING FEMALE 1 IN.	2	
13	198610	MOTOR – HYDRAULIC (BOSCH-REXROTH) <sup>102</sup>	1	
	236535	SEAL KIT		
14	236634	MANIFOLD – RELIEF <sup>103</sup>	1	
15	150595	O-RING – 0.984 IN. ID X 0.139 IN. WALL	2	
16	236538	VALVE – RELIEF	1	
17	236684	VALVE – CHECK	1	
18	135550	FITTING – 3/4 IN CD 62 X #16 MALE ORS C/W O-RING	1	
19	194026	FLANGE – HALF SPLIT 3/4 IN.-CODE 62	2	
20	150595	O-RING – 0.984 IN. ID X 0.139 IN. WALL	1	
21	135790	FITTING – ADAPTER	1	
	30971	O-RING – #12 ORB		
	135554	O-RING – #16 ORFS		
22	136258	FITTING – TEE HYD	1	
	44209	O-RING – #8 ORB		
	135866	O-RING – #8 ORFS		
23	252688	FITTING – ADAPTER	1	
24	120377	VALVE – RELIEF	1	
25	184462	FITTING – ADAPTER 6 MORFS X 10 MORB	1	
	44210	O-RING – #10 ORB		
	135865	O-RING – #6 ORFS		

101. Kits available through Whole Goods only.

102. If replacing the superseded Parker motor (MD #194100), order Motor kit (MD #257149), which includes motor (MD #198610), relief manifold (MD #236634), fittings (MD #135790 and 136258), and hardware (MD #136108, 30632, and 136354).

103. Manifold includes check valve (MD #236684), relief valve (MD #236538), and two O-rings (MD #150595).

**HYDRAULIC DRIVE – R113 AND R116 TO M1170**



1027213

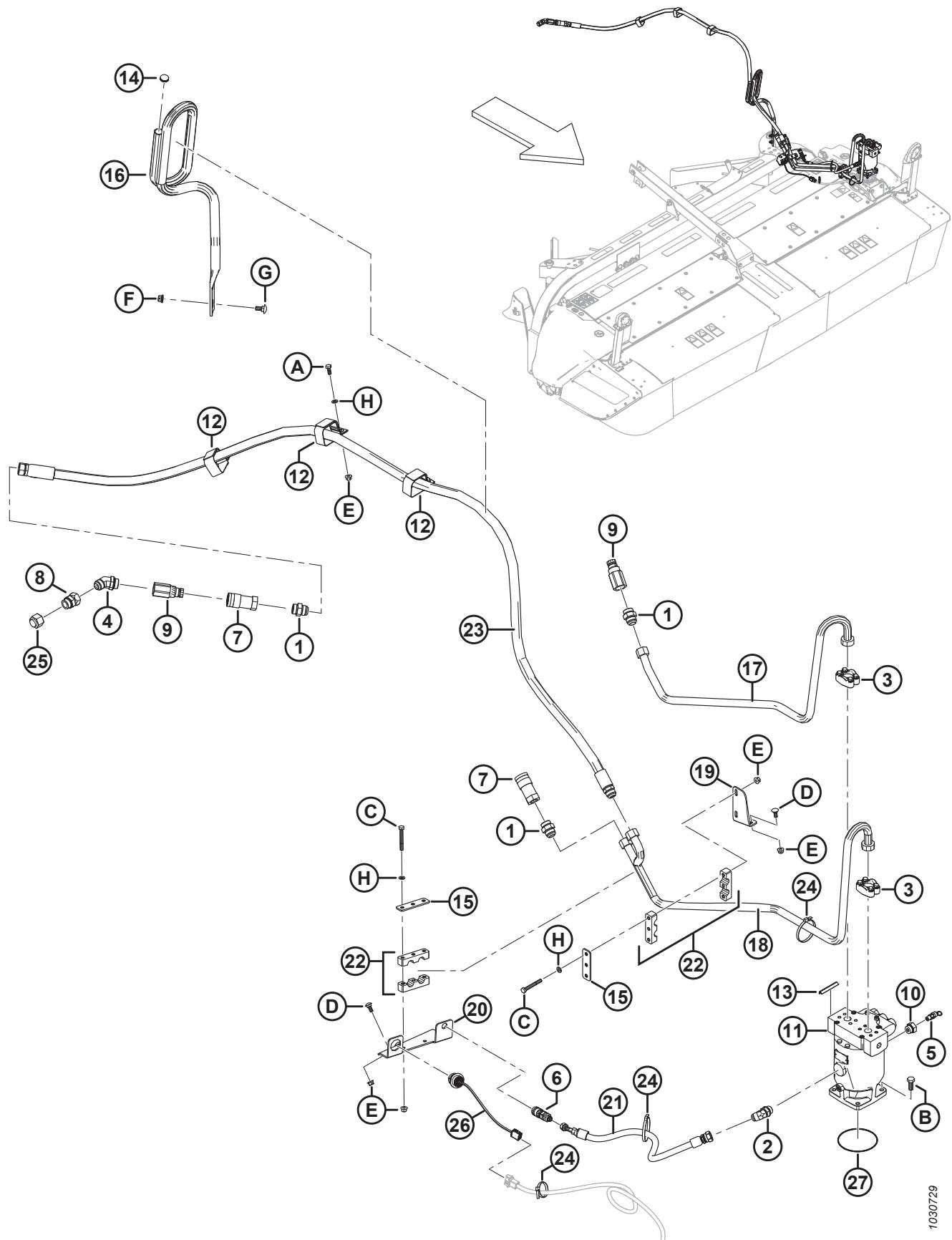
**HYDRAULIC DRIVE – R113 AND R116 TO M1170**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
26	136438	FITTING – ELBOW 45° HYD #8 ORFS/#8 ORB	1	
	44209	O-RING – #8 ORB		
	135866	O-RING – #8 ORFS		
27	272233	SUPPORT – WELDT	1	
28	272251	CLAMP – PAIR	2	
29	136226	FITTING – HYD 0.062 IN. ORIFICE	1	
	135865	O-RING – #6 ORFS		
30	257149	KIT – MOTOR, FITTINGS, AND HARDWARE <sup>104</sup>	A/R	
31	134442	SPACER – DUAL SWIVEL SADDLE	1	
32	30753	FASTENER – CABLE TIE, BLACK	18	
A	21567	BOLT – HEX HD .375-16 UNC X 0.75 LG		
B	30228	NUT – FLANGE DT SMOOTH FACE 0.375-16 UNC		
C	135976	BOLT – HH 1/2 NC X 8 LG GR5 ZP		
D	50186	NUT – FLANGE LOCK SM FACE DT 0.500-13 UNC GR5		
E	135491	BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L		
F	136354	SCREW – HEX SOC HD ISO 4762 M10		
G	30632	WASHER – LOCK SPRING M10		
H	136108	SCREW – HEX SOC HD M10 X 1.5 X 80-12.9-BO		

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104. This kit is required if replacing the superseded Parker motor (MD #194100). The kit includes motor (MD #198610), relief manifold (MD #236634), fittings (MD #135790 and 136258), and hardware (MD #136108, 30632, and 136354).

## 24 Hydraulic Drive – R113 and R116 to M155E4



1030729

**HYDRAULIC DRIVE – R113 AND R116 TO M155E4**

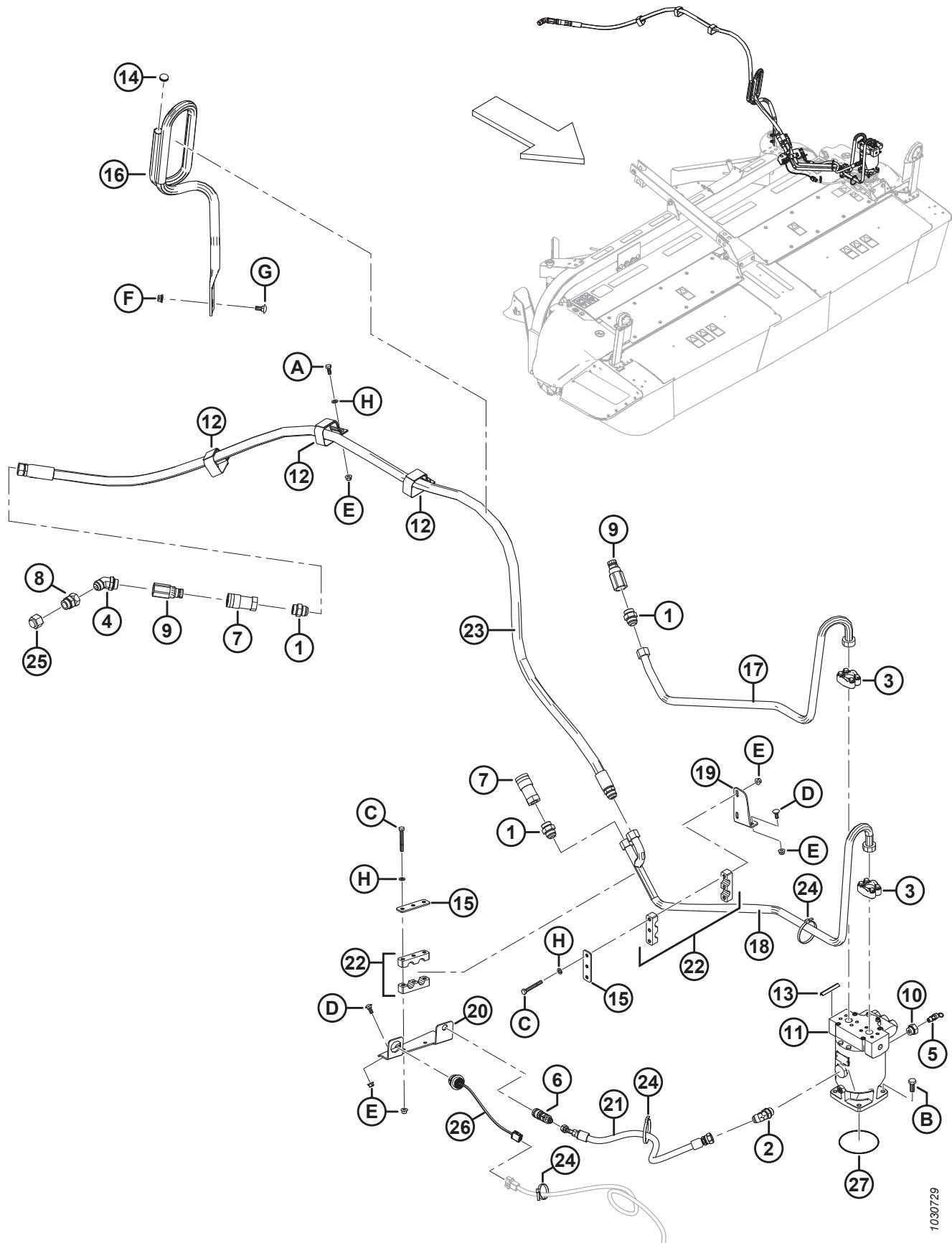
Ref	Part Number	Description	Qty	Serial Number
	B6272	KIT – R1 TO M155E4 HYDRAULIC DRIVE <sup>105</sup>		
1	21828	FITTING – ADAPTER HYD	3	
2	50098	FITTING – ELBOW 45° HYD, C/W O-RING	1	
3	112866	KIT – SPLIT FLANGE, 1 IN., C/W HARDWARE	2	
	194033	FLANGE – HALF SPLIT 1 IN.		
	30191	WASHER – HARDENED ASTM F436 3/8		
	252640	BOLT – HH 3/8-16 X 1.25-GR8-AA3L		
	112868	O-RING – 1.296 IN. ID X 0.139 IN. WALL		
4	112936	FITTING – ELBOW 45° HYD, C/W O-RING	1	
5	120377	VALVE – RELIEF	1	
6	135213	COUPLING – FEMALE HYD. 3/8 FLAT FACE BULKHEAD	1	
7	135313	COUPLER – FEMALE HYD. 3/4 IN. FLAT FACE	2	
8	135316	FITTING – ADAPTER HYD C/W O-RING	1	
9	135544	COUPLER – MALE HYD. 3/4 IN. FLAT FACE 1 IN THREAD	2	
	135479	SEAL KIT		
10	135560	FITTING – ADAPTER HYD C/W O-RING	1	
11	150487	MOTOR – HYD	1	
	150879	SHAFT SEAL		
12	163585	STRAP – VELCRO, HANGING	3	
13	194082	MOULDING	1	
14	194389	PLUG – TUBE FINISHING	1	
15	256203	PLATE – STAUFF CLAMP	2	
16	256204	GUIDE – HOSE SUPPORT	1	
17	256240	LINE – RETURN	1	
18	256241	LINE – HIGH PRESSURE	1	
19	256292	SUPPORT – TUBE	1	
20	256315	SUPPORT – HYDRAULIC BRACKET	1	
21	256324	HOSE – SP CASE DRAIN, 1/2 IN. I.D., 740 MM LG	1	
22	256335	CLAMP – HEAVY TWIN PROFILED PAIR	2	
23	256585	HOSE – PRESSURE, 3/4 IN. I.D., 3250 MM LG	1	
24	30753	FASTENER – CABLE TIE, BLACK	3	
25	30905	CAP NUT – 1 IN. TUBE 37° FLARE	1	
26	139071	HARNESS	1	
27	257150	O-RING – 2.50 X 134.00 <sup>106</sup>	1	-321189
	257061	SEAL – DOUBLE LIP <sup>107</sup>	1	321190–
A	30627	BOLT – HEX HD TFL M10 X 1.5 X 25-8.8-A3L		
B	135491	BOLT – HEX HD TFL M14 X 2 X 35-8.8-A3L		

105. Kits available through Whole Goods only.

106. Service part for Gearbox kit (MD #257174). Ensure the correct part is used. O-ring (MD #257150) and seal (MD #257061) are **NOT** interchangeable.

107. Service part for Gearbox kit (MD #257187). Ensure the correct part is used. O-ring (MD #257150) and seal (MD #257061) are **NOT** interchangeable.

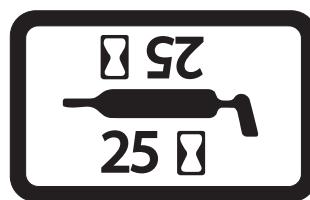
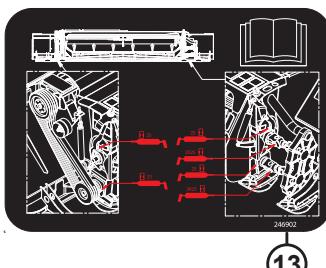
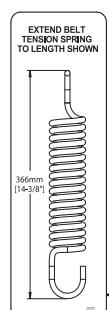
**HYDRAULIC DRIVE – R113 AND R116 TO M155E4**



**HYDRAULIC DRIVE – R113 AND R116 TO M155E4**

Ref	Part Number	Description	Qty	Serial Number
C	135657	BOLT – HEX HD M10 X 1.5 X 80-8.8-A3L		
D	135785	BOLT – RHSN M10 X 1.5 X 25-8.8-A3L		
E	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		
F	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
G	184667	BOLT – RHSN M12 X 1.75 X 30-8.8-A3L		
H	184711	WASHER – FLAT REG M10-200HV-A3L		

## 25 Decals – Information and Reflectors



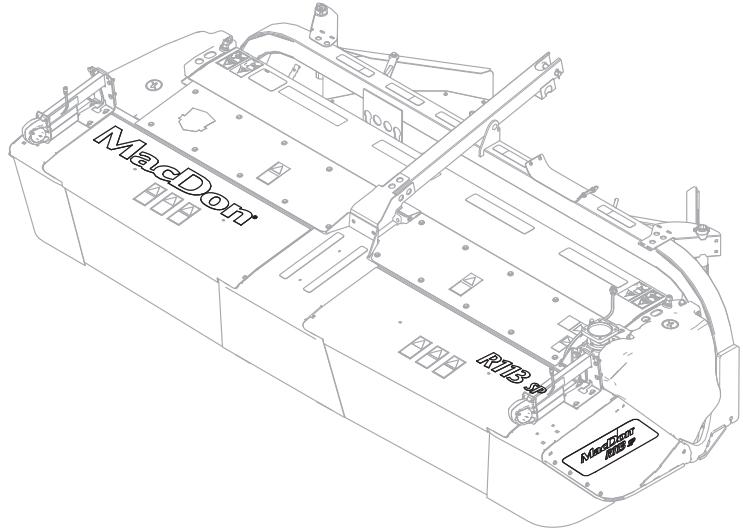
**DECALS – INFORMATION AND REFLECTORS**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	113482	DECAL – GENERAL HAZARD		
2	184372	DECAL – READ MANUAL		
3	184371	DECAL – CHAIN ENTANGLEMENT		
4	166466	DECAL – HIGH PRESSURE FLUID		
5	184385	DECAL – KEEP SHIELDS IN PLACE (SQUARE CORNERS)		
	246956	DECAL – KEEP SHIELDS IN PLACE (ROUND CORNERS)		
6	190546	DECAL – SLIPPERY SURFACE, 2 PANEL		
7	194465	DECAL – STAND CLEAR BLADES, 2 PANEL		
8	194466	DECAL – STAND CLEAR THROWN OBJECTS, 2 PANEL		
9	246959	DECAL – PINCH POINT		
10	247167	DECAL – STOP DRIVE		
11	304865	DECAL – NO LIFT		
12	247231	DECAL – SPRING TENSION		
13	246902	DECAL – GREASE, ROLLER CONDITIONER		
14	23164	DECAL – 25 HR LUBE		
	257190	DECAL – 100 HR LUBE		
15	302204	DECAL – CA PROPOSITION 65		
16	115145	REFLECTOR – FLUORESCENT RED-ORANGE		
	115146	REFLECTOR – AMBER		
	115147	REFLECTOR – RED		
17	132117	STRIP – ANTI SLIP (450 MM LG, 50 MM WIDE) <sup>108</sup>		
	132898	STRIP – ANTI SLIP (450 MM LG, 80 MM WIDE) <sup>109</sup>		

108. 450 mm x 50 mm; used on the header.

109. 450 mm x 80 mm; used on the roll conditioner.

## 26 Decals – Product Identification, R113



MacDon®

①

R113 SP-②

MacDon®-③

1027121

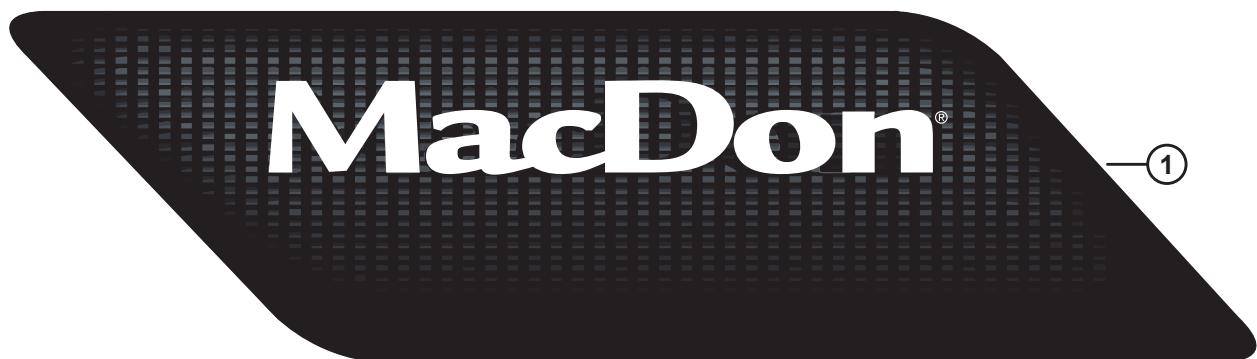
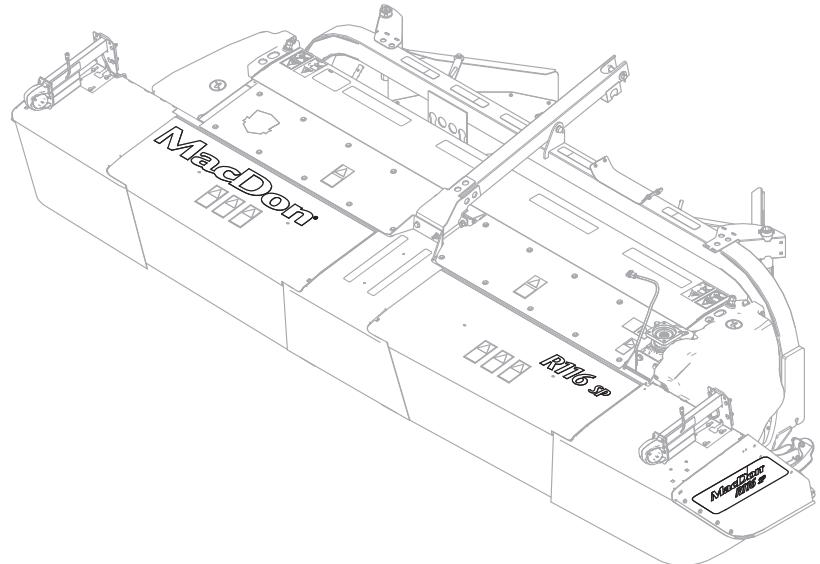
**DECALS – PRODUCT IDENTIFICATION, R113**

Ref	Part Number	Description	Qty	Serial Number
1	246896	DECAL – LH, END PANEL <sup>110</sup>	1	
	246897	DECAL – RH, END PANEL <sup>110</sup>	1	
2	256331	DECAL – END PANEL, R113 SP (WHITE, 221 MM LG)	2	
	256333	DECAL – TOP, R113 SP (WHITE, 468 MM LG)	1	
3	246997	DECAL – TOP, MACDON (WHITE, 1140 MM LG)	1	

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110. Requires R113 SP end panel decal (MD #256331).

## 27 Decals – Product Identification, R116



*R116 SP* -②

MacDon® -③

1027122

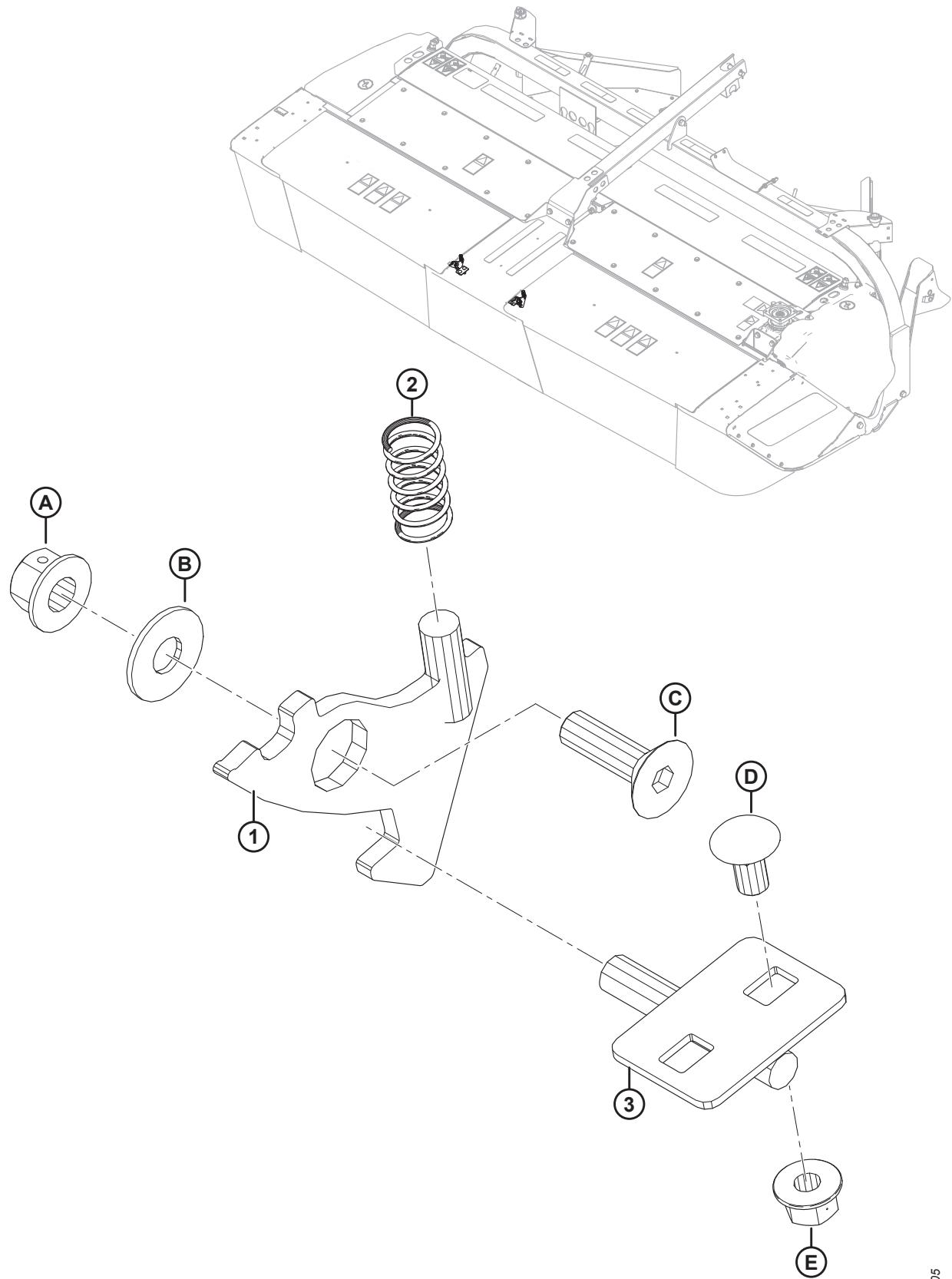
**DECALS – PRODUCT IDENTIFICATION, R116**

Ref	Part Number	Description	Qty	Serial Number
1	246896	DECAL – LH, END PANEL <sup>111</sup>	1	
	246897	DECAL – RH, END PANEL <sup>111</sup>	1	
2	256332	DECAL – END PANEL, R116 SP (WHITE, 221 MM LG)	2	
	256334	DECAL – TOP, R116 SP (WHITE, 468 MM LG)	1	
3	246997	DECAL – TOP, MACDON (WHITE, 1140 MM LG)	1	

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111. Requires R116 SP end panel decal (MD #256332).

## 28 Tool Operated Latches – Export Only

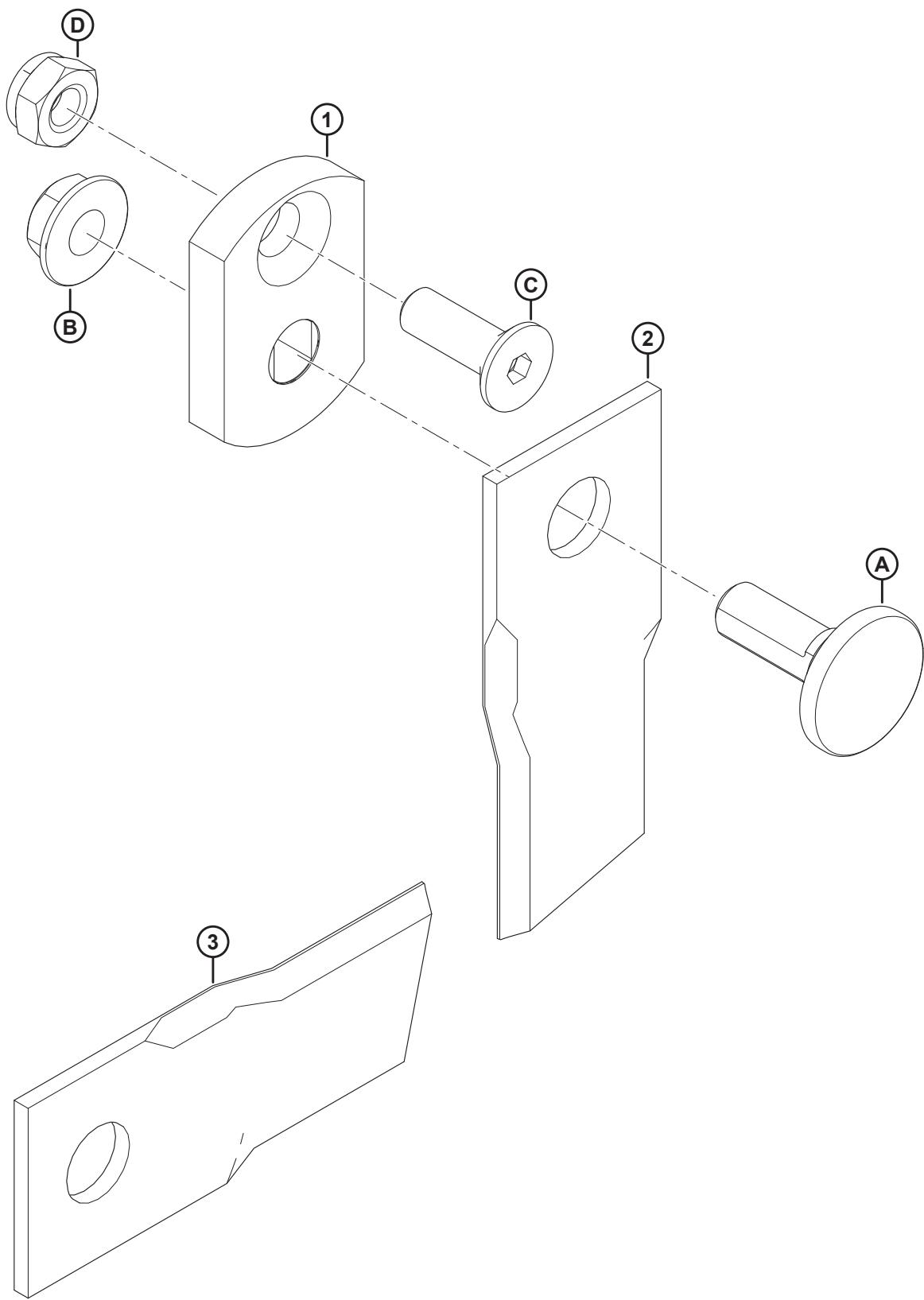


1021405

**TOOL OPERATED LATCHES – EXPORT ONLY**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
1	246352	PLATE	2	
2	35618	SPRING – COMPRESSION	2	
3	247315	LATCH – WELDMENT	2	
A	136431	NUT – HEX FLG CTR LOC M12 X 1.75-10-A3L		
B	184587	WASHER – FLAT, 0.5 IN ID, 1.25 IN OD, 0.109 IN THK		
C	136401	SCREW – HEX SOC CSK HD TFL M12 X 1.75 X 40-10.9-AA3L		
D	184657	BOLT – RHSSN M10 X 1.5 X 20-8.8-A3L		
E	135799	NUT – HEX FLG CTR LOC M10 X 1.5-10-A3L		

## 29 (Option) Blade Lowering Kit



1021518

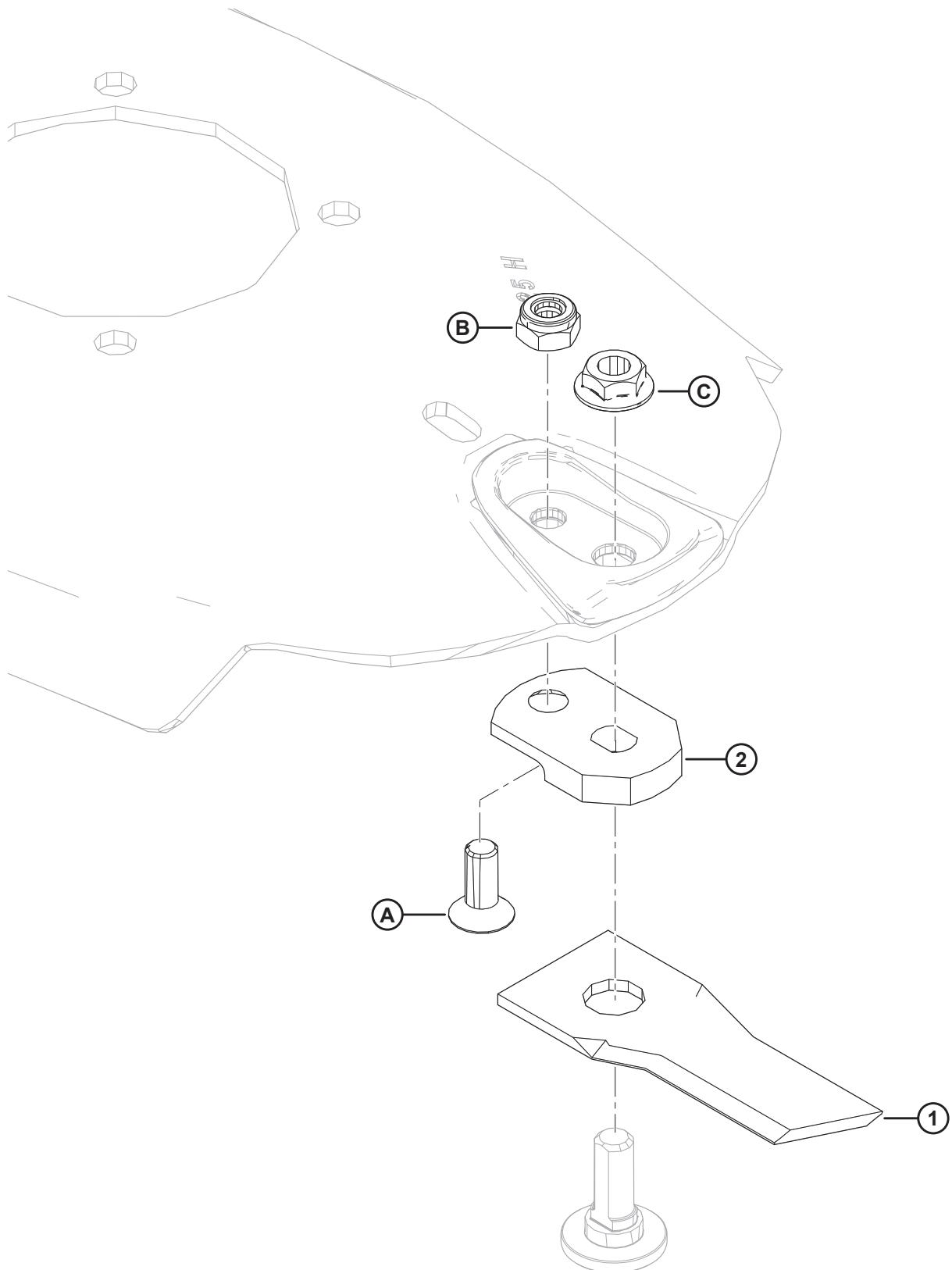
**(OPTION) BLADE LOWERING KIT**

Ref	Part Number	Description	Qty	Serial Number
	257123	KIT – 18° BLADE LOWERING <sup>112</sup>		
1	281606	PLATE – BLADE, 10 MM	24	
2	259200	BLADE – 18° CCW BEVEL DOWN, QTY 6	4	
3	259199	BLADE – 18° CW BEVEL DOWN, QTY 6	4	
A	281604	BOLT – BLADE		
B	246300	NUT – BLADE		
C	281605	BOLT – ACCELERATOR		
D	246303	NUT – ACCELERATOR		

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112. Kit includes all listed parts and hardware.

## 30 (Option) Blade Update



1042193

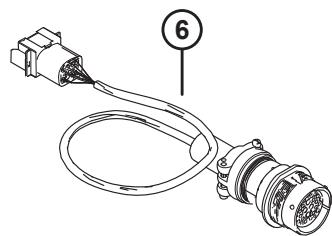
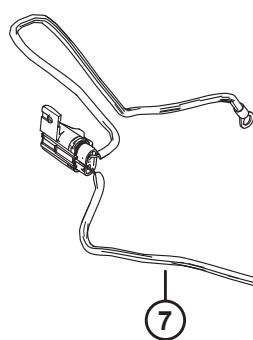
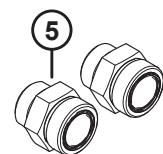
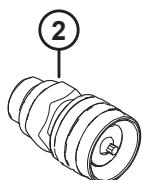
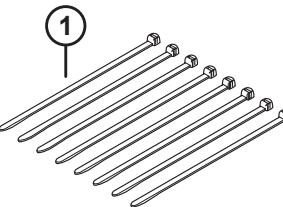
**(OPTION) BLADE UPDATE**

Ref	Part Number	Description	Qty	Serial Number
	359122	KIT – UPDATED BLADES <sup>113</sup>		
1	359066	BLADE – CCW 18° BEVEL DOWN QTY 6	4	
	359065	BLADE – CW 18° BEVEL DOWN QTY 6	4	
2	338956	PLATE – BLADE SPACER	20	
A	281965	BOLT – ACCELERATOR		
B	246303	NUT – ACCELERATOR		
C	246300	NUT – BLADE		

---

113. The blades included in this kit have a larger cut length, providing a cleaner cut in lighter crops. The kit includes all listed parts and instructions.

## 31 (Option) R113 SP to M205 Compatibility Kit



1033496

### (OPTION) R113 SP TO M205 COMPATIBILITY KIT

**NOTE:**

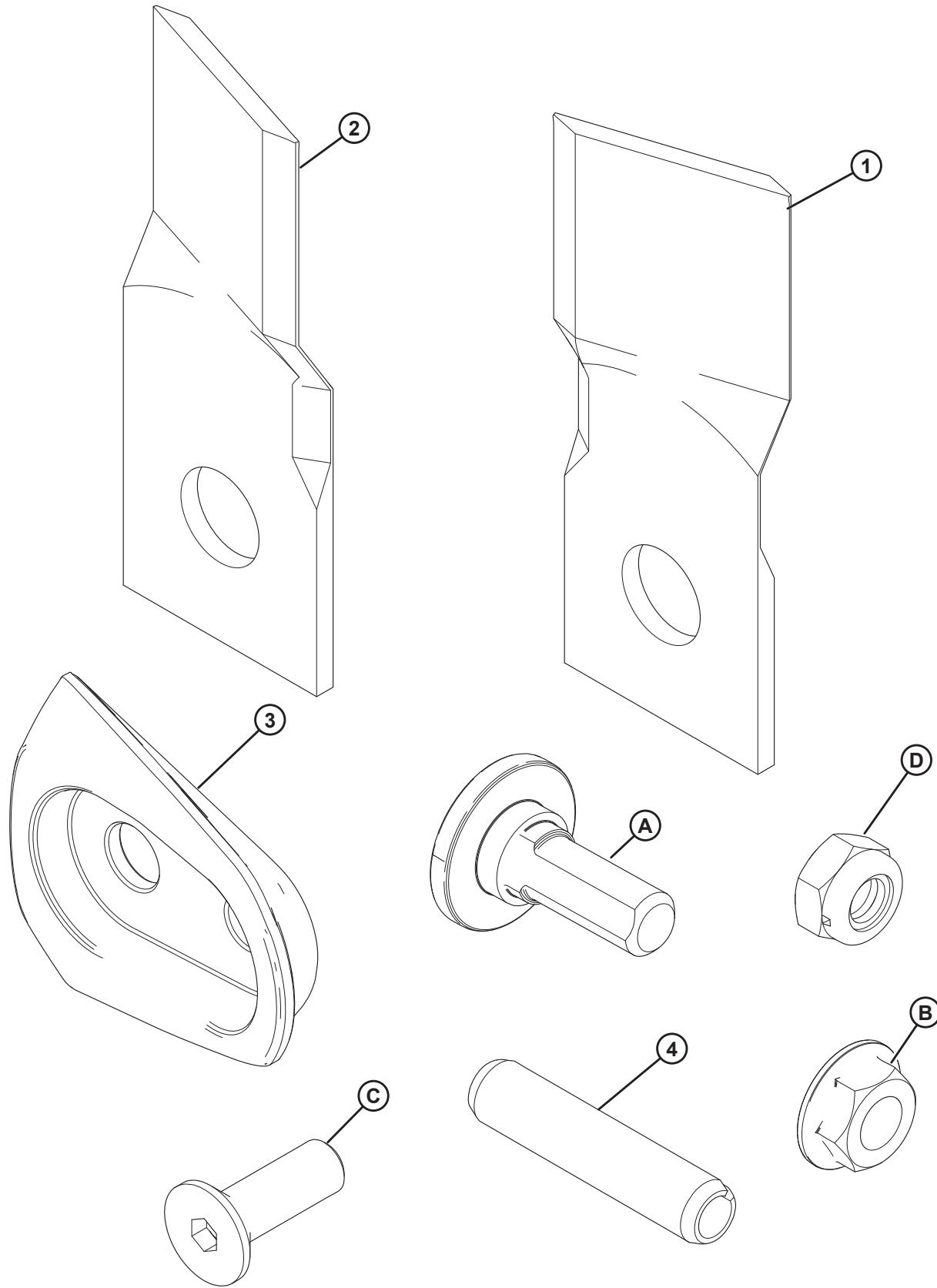
The R113 SP to M205 Compatibility kit is required for R113 Rotary Disc Headers that were originally configured for an M1170 Windrower to operate on an M205 Self-Propelled Windrower.

Ref	Part Number	Description	Qty	Serial Number
	257188	KIT – R113 SP TO M205 CONNECTION <sup>114</sup>		
1	21763	FASTENER – CABLE TIE, BLACK	8	
2	138344	COUPLER – HYDRAULIC	1	
	135554	O-RING		
3	138345	COUPLER – HYDRAULIC	1	
	138344	O-RING		
4	159635	VALVE – RELIEF, 75 PSI	1	
5	252232	FITTING – UNION HYD	2	
	135867	O-RING		
	135869	O-RING		
6	256650	HARNESS – R113 TO M205	1	
7	256651	ASSY – PWM MODULE AND POWER	1	

---

114. Kit includes all listed parts and instructions.

## 32 (Option) R1 Service Kit



1023715

**(OPTION) R1 SERVICE KIT**

<b>Ref</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>	<b>Serial Number</b>
	259053	KIT – SERVICE R1 <sup>115</sup>		
1	259199	BLADE – CW 18° BEVEL DOWN (6 PACK)	4	
2	259200	BLADE – CCW 18° BEVEL DOWN (6 PACK)	4	
3	238227	KIT – 2 GUARDS CW HARDWARE <sup>116</sup>	4	
4	246295	PIN – SHEAR	2	
A	281604	BOLT – BLADE		
B	246300	NUT – BLADE		
C	281605	BOLT – ACCELERATOR <sup>117</sup>		
	281965	BOLT – ACCELERATOR <sup>118</sup>		
D	246303	NUT – ACCELERATOR		

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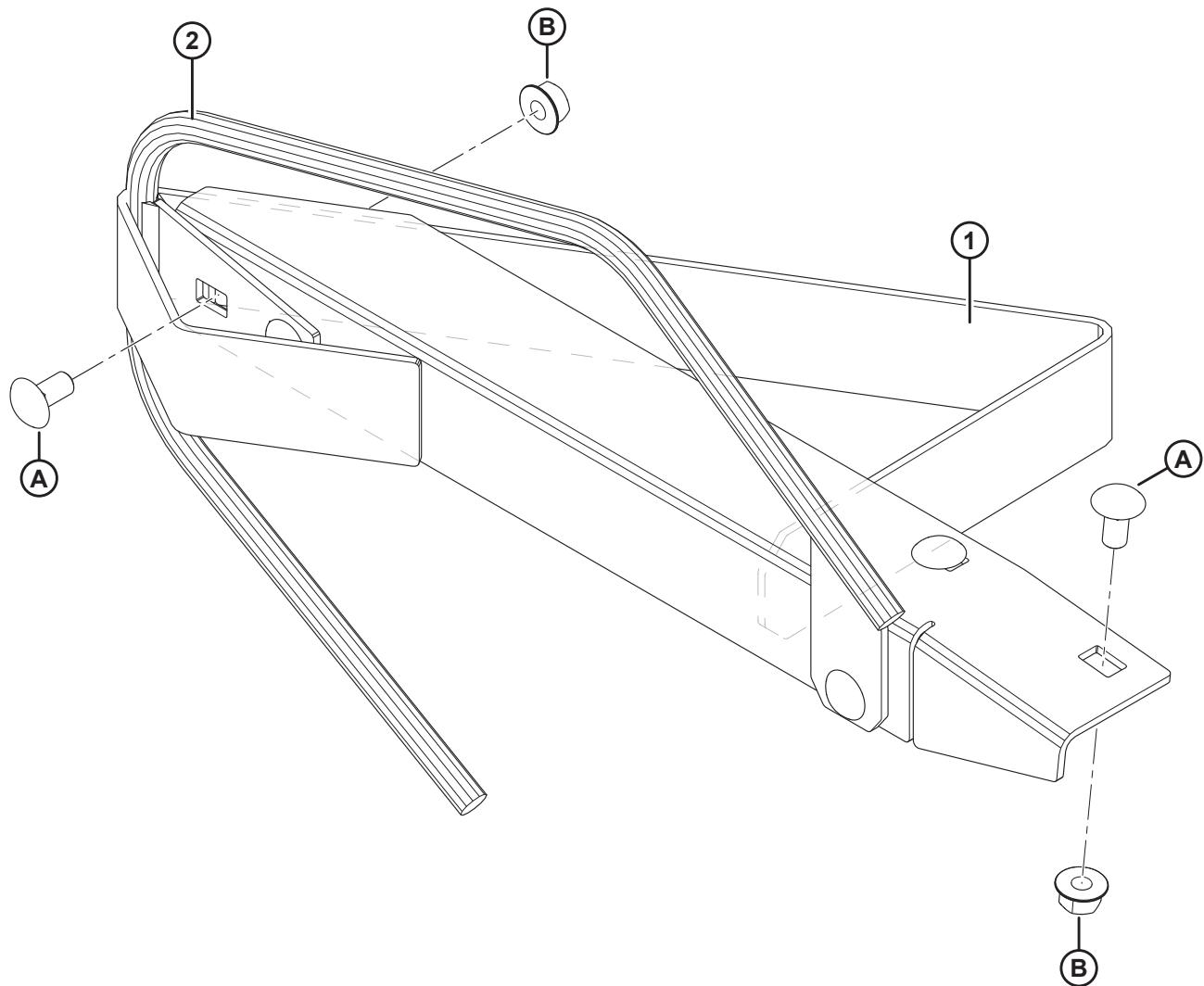
115. Kit is intended to replace all blades and hardware on an R1 Series Rotary Disc Header.

116. This kit includes a matched pair of disc guards (NSS), two accelerator bolts (MD #281965) used with 5 mm shims, two accelerator nuts (MD #246303), and two accelerator bolts (MD #281605) used with 10 mm shims.

117. For use with 10 mm shims.

118. For use with 5 mm shims.

### 33 (Option) Tall Crop Dividers



**(OPTION) TALL CROP DIVIDERS**

Ref	Part Number	Description	Qty	Serial Number
	B5800	KIT – TALL CROP DIVIDERS <sup>119</sup>		
1	223236	DIVIDER WELDMENT – LH	1	
	223248	DIVIDER WELDMENT – RH	1	
2	223232	ROD WELDMENT – CROP DIVIDER	2	
A	152439	BOLT – RHSSN M12 X 1.75 X 25-8.8-A3L		
B	184697	NUT – HEX SER FLG M12 X 1.75-8-A3L		

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119. Kits are available through Whole Goods only.



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