

Congratulations of your purchase of Exact Align Pro Ball Bearing parallel arm kit for John Deere ME2, ME+, XP, XP Pro, ME5, and Exact Emerge planter row units. This kit is intended to provide years of maintenance free performance on your planter by employing sealed ball bearings at all connection points to replace the OEM design dry bushings.

Each Exact Align Pro parallel arm kit includes the following:

	
EA16PAK (short arms) <ul style="list-style-type: none"> • F00-028 upper arms with bearings • C76223 lower arm with bearings • Hardware kit 	EA23PAK (long arms) <ul style="list-style-type: none"> • F00-032 upper arms with bearings • C65304 lower arm with bearings • Hardware kit

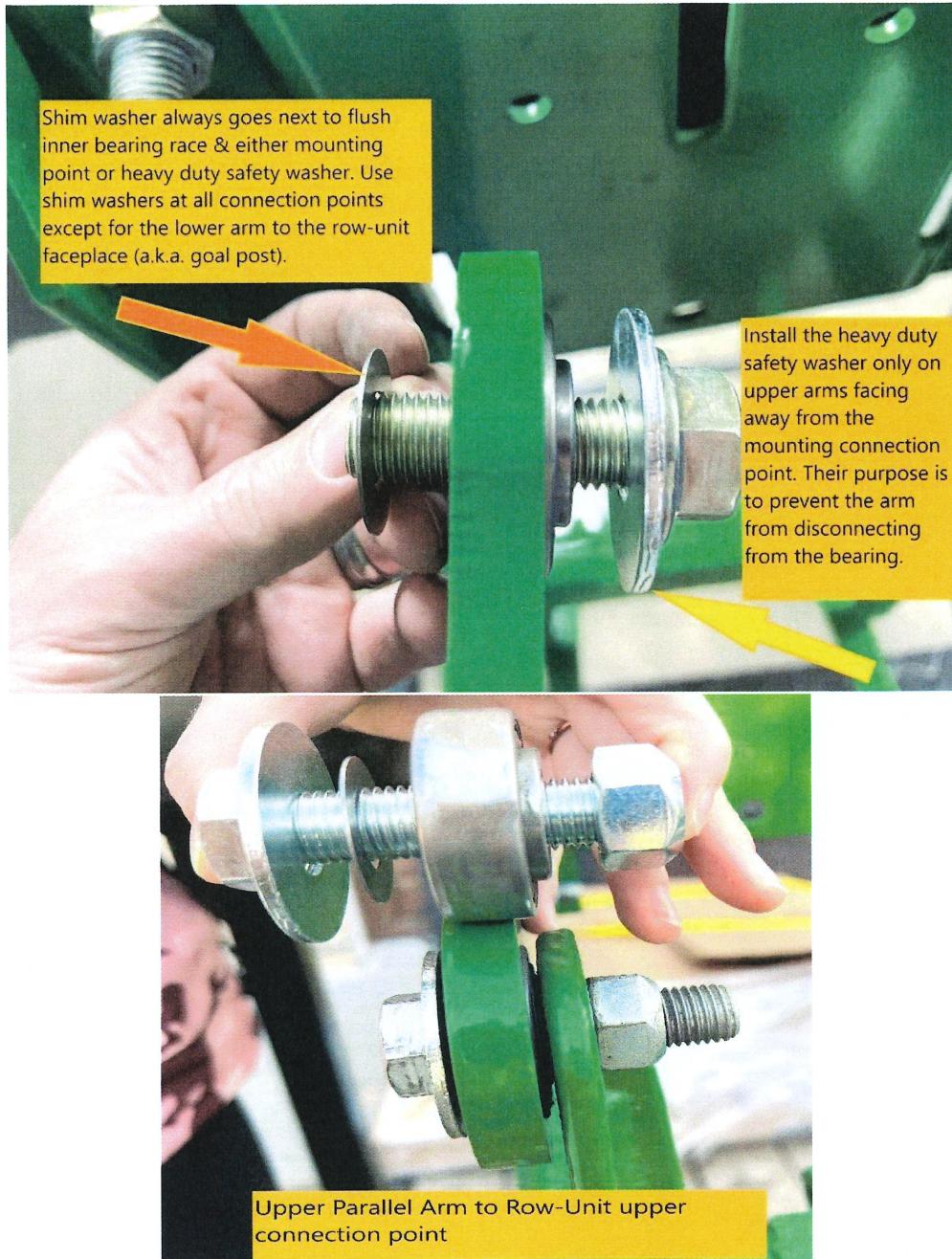
There are many different strategies of removal of original parallel arms and installation of the Exact Align arm kits. It makes little difference in the order of installing the new parallel arms, but the additional hardware such as downforce brackets, unit mounted row-cleaners, and other accessories must be taken into consideration to avoid frustration.

A very important feature of our parallel arms is that the B204PY3 series bearings feature an inner race that is flush with the outer race on one side while the opposite side protrudes well past the outer race. When we assemble the bearings into the lower cast arms, we orient them for use with the most found toolbar mounting bracket, the wide or outside of the arm design. This means that the flush inner race is facing toward the mounting surface on the end that connects to the toolbar mounting plate. It is necessary for the bearing to be slightly inset from the side surface of the arm to allow for installation of one thin shim between each bearing and the mounting bracket.

When installing the lower cast arm onto a narrow mounting bracket (arm ends go outside of the mounting bracket), it is necessary to remove and reinstall the bearings such that the flush inner mount of the bearings is toward the mounting bracket. When performing this task take care not to damage the bearing seals and to contact only the outer bearing race. An arbor press is preferred for this operation; however, it may be done manually as needed.

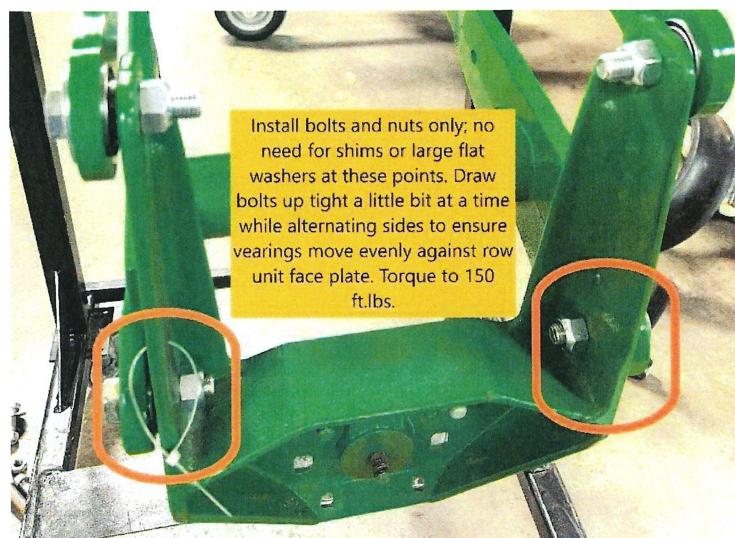
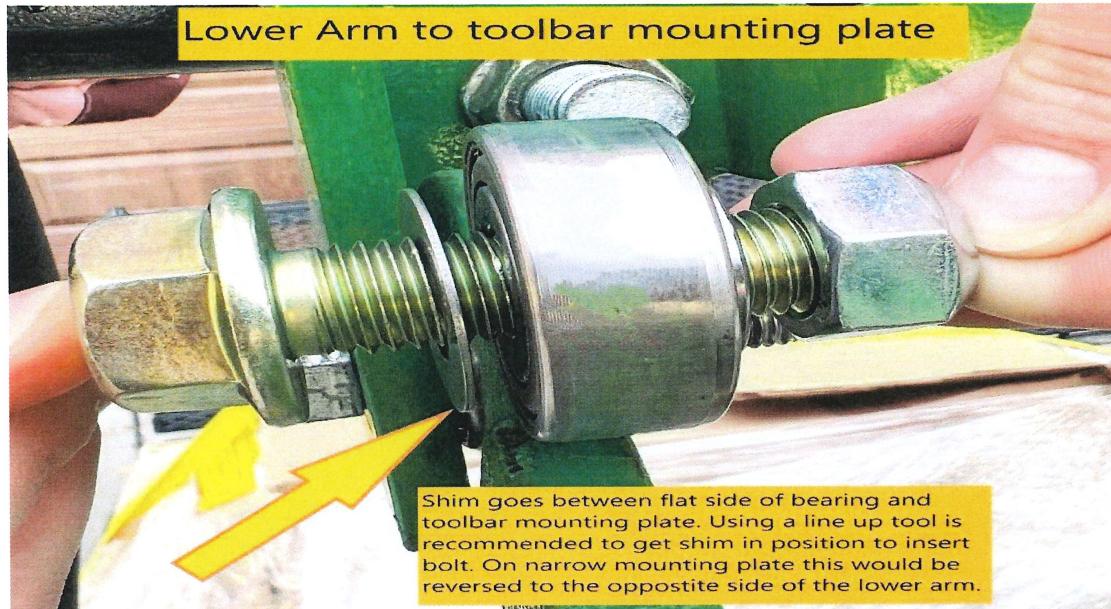
- An installation tip for placement of the thin shim washer on the front ends (closest to toolbar) of the lower parallel arm is to smear a dab of gun grease on the inner race which will allow the shim to stick in place during installation.
- It is helpful to use a tapered line-up punch to ensure correct hole alignment to install bolt.

For wide (parallel arms attach inside of the bracket) mounting plates, simply install the arms as provided using a shim washer between flush side of bearing to the mounting point. Install the large flat washer on upper arms on side of arm away from mounting point. This is to act as a fail-safe to prevent arm from disconnecting. Direction of bolt is not important for any of these connections.



The hardware used on the lower parallel arms is the same for all four bearing connections. It is normal for the bearings at the row-unit face plate to pull into place inside the arm when tightening to the row-unit. Torque all hardware to 150 foot-pounds.

**Note about bearings. They are press fit into the arms and may sometimes be stiff to turn by hand. This is normal and there is to be expected that some bearings will turn with less resistance than others.



Note that the bearings used in the arms can tolerate misalignment of up to 7 degrees and are quite forgiving in that respect. For best service life, take care not to aggressively pressure wash / steam clean too near bearing seals.

For further technical assistance please contact us at 800-548-6633.

