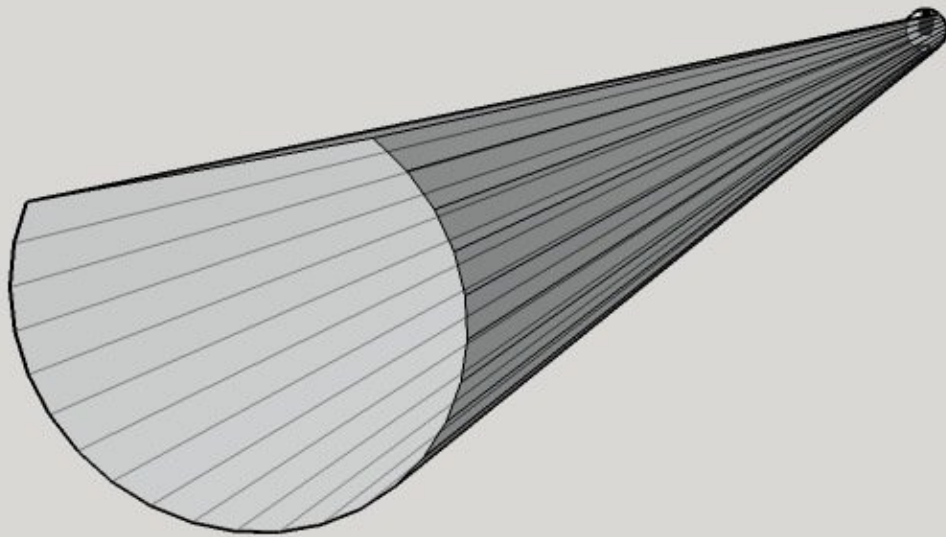


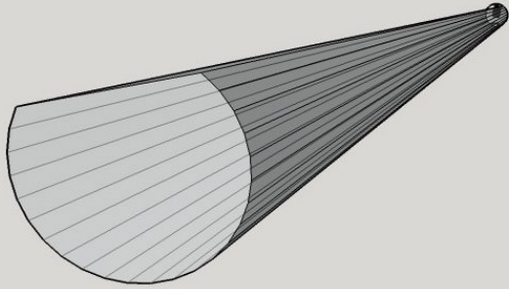


Shaft fabrication

Written By: Anthony Douglas

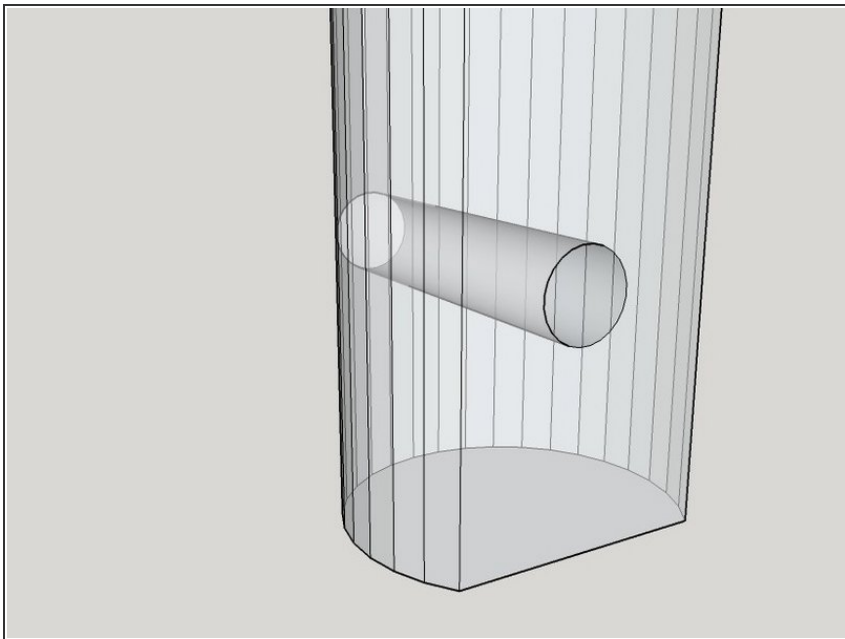


Step 1 — The main rotor shaft



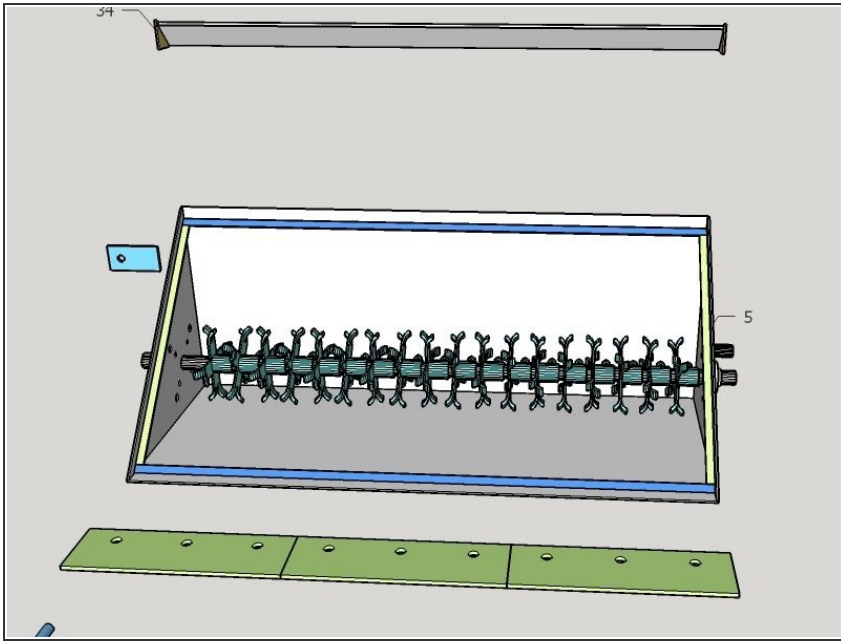
- Remove the shaft from the bucket bearings. Grind out a flat 1/4" deep on the shaft P21 in the section for the bolts in the tine modules to tighten against, from the stock cut previously.

Step 2



- Place the 6 spline coupler on the shaft, and use it as a guide to guide your drill bit. Start drilling the hole radially through the shaft for the bolt, starting from the flattened side of the shaft. After the hole is started, remove the coupler and continue, to avoid damaging the coupler.

Step 3



- Pass the shaft P21 through one bearing, with the drilled bolt hole on the right end. Place the tine modules onto the shaft as it is being passed through.
- The bolts on the tine modules can be tightened at the very end of the whole module fabrication. I suggest not doing it now as the shaft may need to be removed for some reason later.