



TO: All Bourgault Dealers
ATTN: Service Manager, Parts Manager, Sales Manager
SUBJECT: 7000 Series – Primary Elbow Alignment

Effective SN Range – ALL 7000 tanks – tow-behind configuration

BACKGROUND:

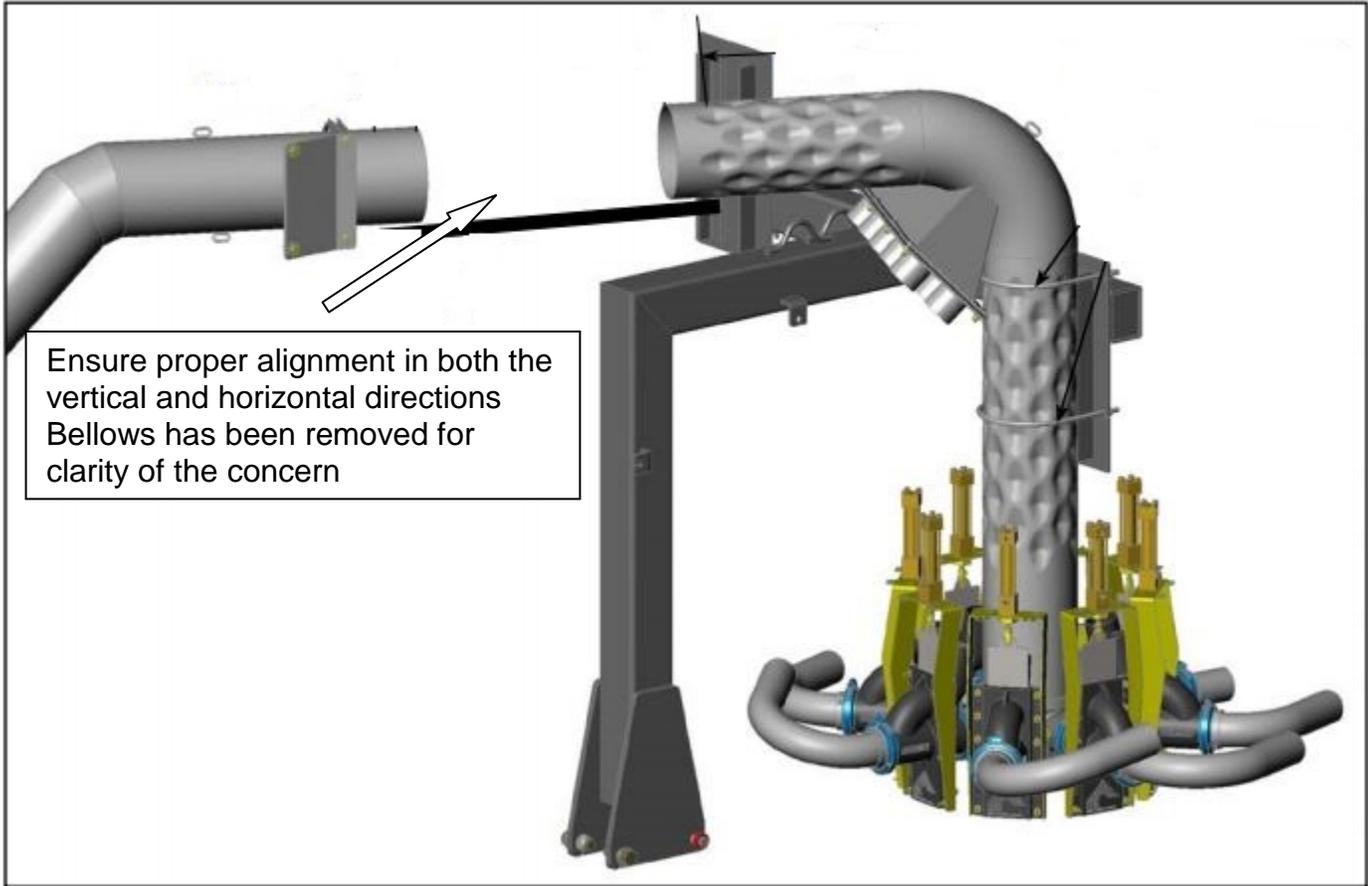
As everyone knows distribution accuracy is critical to the success of any seeding operation. There are many, many variables that go into the design, testing, manufacturing and assembling of these components. The Bourgault Service Team has been receiving reports of some mis-alignment between the primary elbow and the s-pipe. The one challenge here is the relative difficulty in performing a quick visual inspection as the two pipes are connected with a 7” bellows. Severe mis-alignment can be seen; but relatively minor mis-alignment is not so easy to see.

We have found this alignment to be an important factor in ensuring distribution accuracy. Therefore we feel it is important to perform a periodic visual inspection on all your 7000 series tanks to ensure proper alignment is maintained.

CORRECTIVE ACTION:

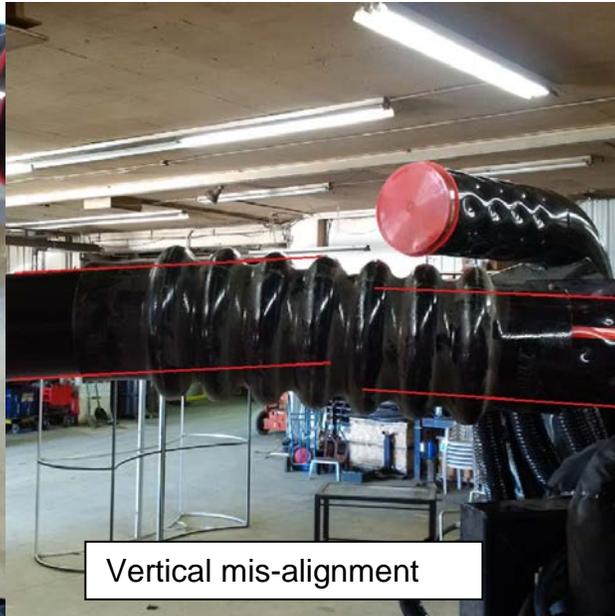
- **Ensure all owners and operators are aware of this potential concern.**
 - **Both ASC and non-ASC units are affected.**
- **For any machines showing visual signs of mis-alignment - please follow the re-alignment procedure documented with this TSB or view the video procedure or follow the you-tube link https://youtu.be/MTUz_vV_SmM**

Primary / S-pipe Alignment



The following photos show “extreme” examples of misalignment however they are provided here to hopefully give some clarity to what is to look for in the visual inspection. The human eye is capable of detecting very small mis-alignments. If you are unable to detect significant mis-alignment with your visual inspection we are certain the alignment of the pipes is within tolerance.

If there is noticeable and distinct mis-alignment it is strongly suggested to perform the re-alignment procedures documented on the following pages and in the video.





PRIMARY MANIFOLD TO S-PIPE ALIGNMENT

ALIGNMENT PROCEDURE **Trailing 7000 Series Air Seeders**

It is recommended to carefully follow the detailed steps of the instructions.

On all Bourgault equipment, left and right are determined by standing behind the machine and looking forward. For this manual the drawings and instructions are given for the assembly.

For safety, maintenance, warranty policy, and operating instruction of the unit, refer to the operators manual.

All information, illustrations and specifications in this manual are based on the latest product information. Bourgault updates products continually to improve quality. We reserve the right to make changes at any time.

These written instructions will show how to align primary manifold components on your air seeder.

Tool required:

- Digital level
- Ratchet strap
- Typical hand tools

1. Position Air Seeder.

- Verify the front hitch is centered (straight) and front axle is level, (unit is parked on level ground). See *Figure 1*.

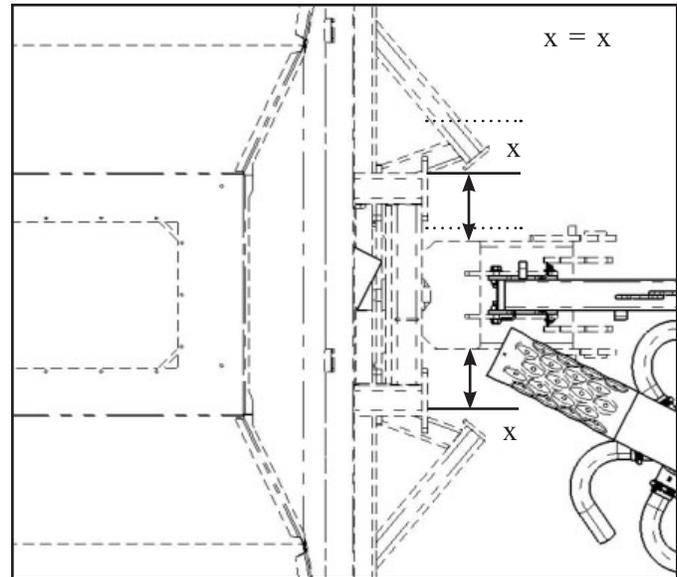


Figure 1

INSTRUCTIONS

- Record present position of components.

See *Figure 2*.

- Scribe the current location of the bellows on the S-pipe and on the primary manifold.
 - Scribe the location of the mount bolts on the bottom of the primary stand.
 - Install ratchet strap to tie primary manifold to air seeder frame.
 - Loosen the clamps on the bellows.
 - Loosen the fasteners on the bottom of the primary stand to tilt the top primary manifold away from the tank to allow for removal of bellows.
- Remove the bellows.
 - Tilt the primary manifold back to the scribe marks in step 2 and snug the mount bolts on the bottom of the primary stand.

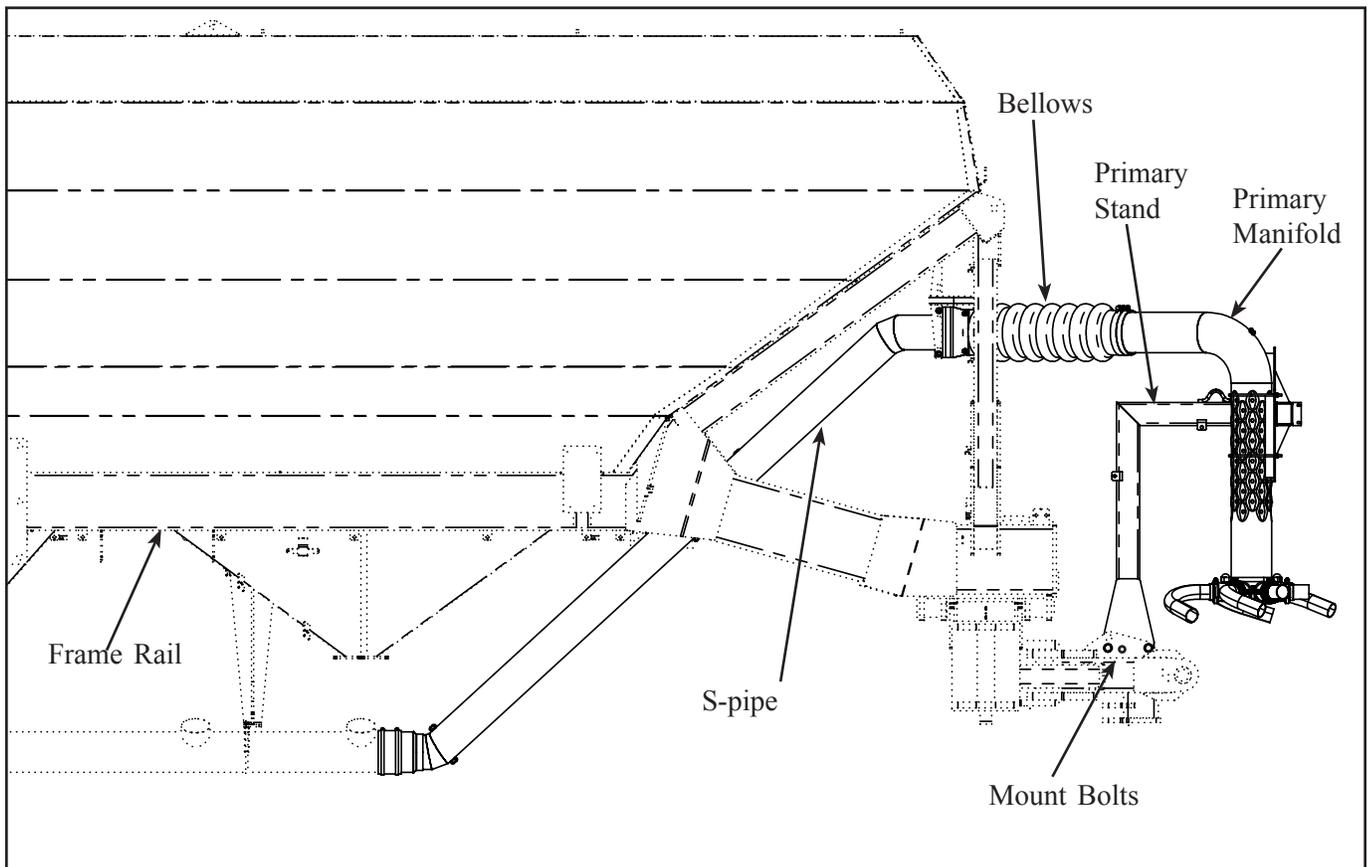


Figure 2

5. Primary Stand alignment.

- Zero digital level to frame rail or top of steering box, refer to *Figure 2*.
- Verify that primary stand is vertical in both directions. Adjust as required. Refer to *Figure 3*.
- Snug primary stand mount bolts.
- Check alignment of primary elbows to S-pipe using straight edge. Adjust height and angle by loosening u-bolts holding primary elbow to stand. Refer to *Figure 4*.



Figure 3

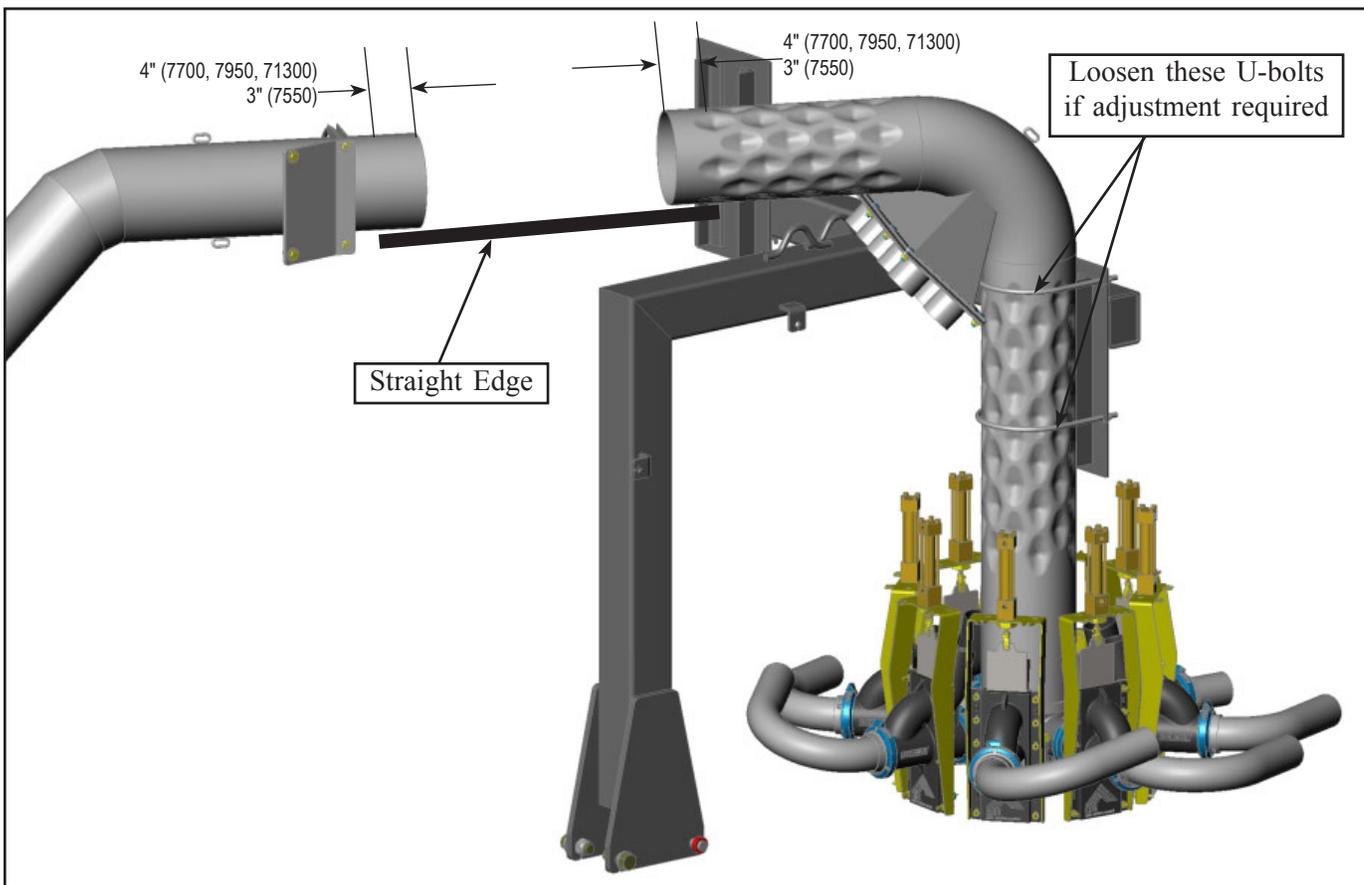


Figure 4

INSTRUCTIONS

6. Bellows Preload

- Loosen primary stand mounting hardware and tip stand forward.
- Verify scribe mark from the end of the S-pipe:
4"(100 mm) for 7700, 7950, 71300;
3"(76 mm) for 7550.
- Verify scribe marks on horizontal section of primary elbows back from the inlet:
4"(100 mm) for 7700, 7950, 71300;
3"(76 mm) for 7550.
- Install bellows onto primary elbow up to mark and tighten clamp until it starts to sink into bellows (20 ft-lbs).
- Begin to winch/ratchet primary stand back and at the same time inserting s-pipe into bellows until bellows reach the mark on s-pipe.
- Tighten clamp to secure bellows to the elbow.

NOTE

ENSURE BELLOWS IS MOUNTED IN-LINE WITH PRIMARY ELBOW AND S-PIPE (AND NOT BINDING AND KINKED). THE BELLOWS MAY NEED TO BE LUBRICATED AND "WALKED ON". THIS WILL ENABLE STRAIT TRANSITION FROM S-PIPE TO PRIMARY.

- Continue winching the stand forward until the stand is $\frac{1}{2}^{\circ}$ past vertical to allow for settle back to vertical (back to point established in step 5).
- Tighten primary stand hardware. Torque to 200 Ft-Lbs.
- Remove winch/ratchet and check that the primary elbow is vertical relative to the air seeder frame within ± 0.5 degrees. Adjust primary bracket if necessary to achieve this tolerance.