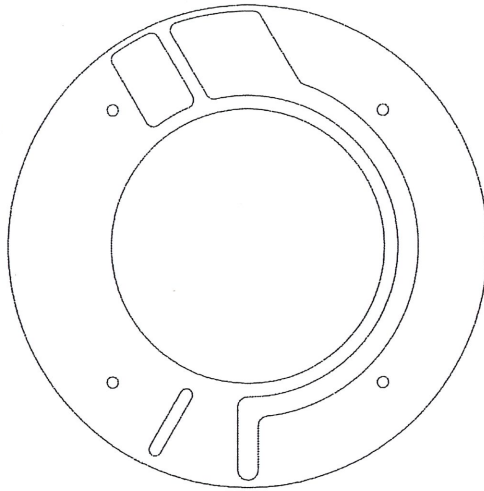


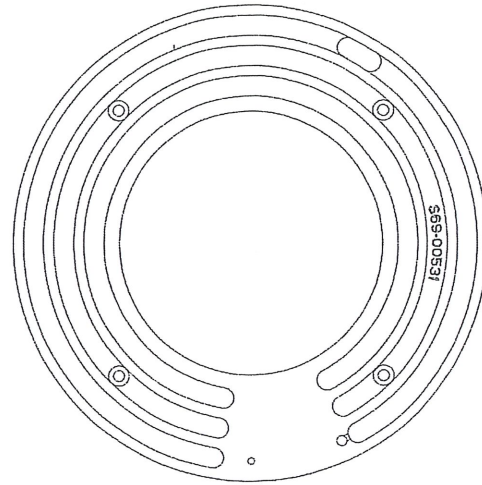


ProAir – Converting to Single Line Spec

1. Gallery Block Fitment



S69-00434 Paper Gasket



S69-00531 Single Line Gallery Block

- The existing gallery block in the ProAir metering unit will need to be removed and the casting thoroughly cleaned of gasket compound.
- The single line gallery block now uses a paper gasket (S69-00434) rather than the gasket sealant for sealing the vacuum and pressure routings. **Note:** the gasket must line up with the channel routing on the reverse of the gallery block.
- Ensure the gasket seats flat against the casting and then fit the new single line gallery block (S69-00531) using the 4 slotted screws and nuts.

NUMBER – SWP00005

DESCRIPTION – CONVERTING PROAIR TO SINGLE LINE SPECIFICATION

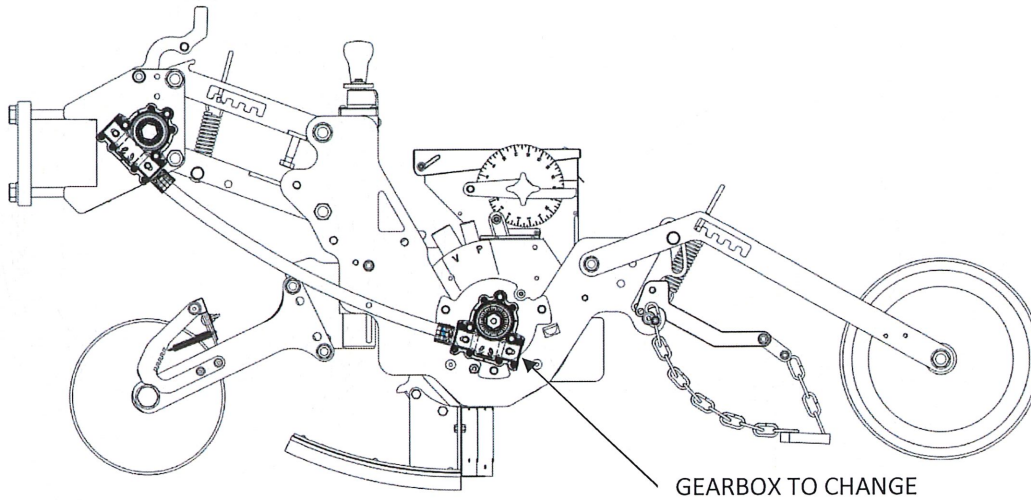
DATE – 09/06/2020

ISSUE - 1

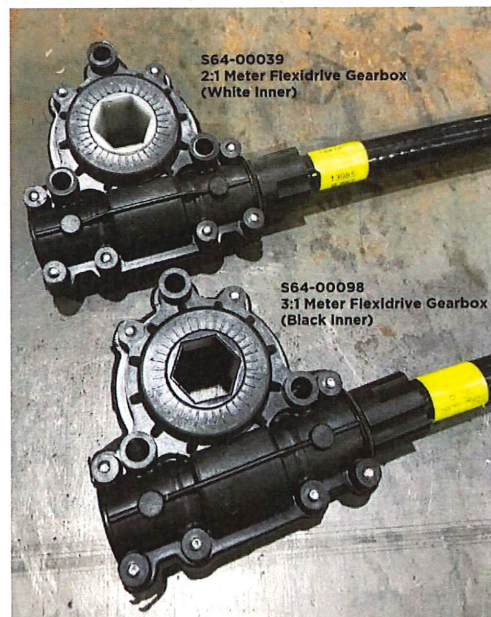
STANHAY WORKING PROCEDURE



2. Flexidrive Gearbox Replacement



- The single line spec ProAir now uses a 3:1 gearbox (S64-00098) at the metering unit end of the flexi drive, distinguishable by the black hex insert – see image above.
- Undo the three bolts holding the flexidrive gearbox onto the ProAir chassis.
- Whilst holding the shaft turn the gearbox clockwise to 'unlock' it.
- Fit the new gearbox and turn anticlockwise to lock in place.
- Bolt the gearbox back into place ensuring the three standoff spacers are in place.
- Rotate landwheel to ensure the hex shaft is fitted correctly and the new gearbox is working.





	24T		20T		18T		17T		16T		15T		MM. INS.		MM. INS.		FORWARD SPEED TO ROTATE UNIT AT 25 RPM	
	24T	17T	13T	11T	12	24	48	72	96	120	144	MAX KPH	MAX MPH					
24/15	215.21	8.47	107.61	4.24	53.80	2.12	35.87	1.41	26.90	1.06	21.52	0.85	17.93	0.71	3.87	2.41		
24/16	229.56	9.04	114.78	4.52	57.39	2.26	38.26	1.51	28.69	1.13	22.96	0.90	19.13	0.75	4.13	2.57		
24/17	243.91	9.60	121.95	4.80	60.98	2.40	40.65	1.60	30.49	1.20	24.39	0.96	20.33	0.80	4.39	2.73		
24/18	258.25	10.17	129.13	5.08	64.56	2.54	43.04	1.69	32.28	1.27	25.83	1.02	21.52	0.85	4.65	2.89		
24/19	272.60	10.73	136.30	5.37	68.15	2.68	45.43	1.79	34.08	1.34	27.26	1.07	22.72	0.89	4.91	3.05		
24/20	286.95	11.30	143.47	5.65	71.74	2.82	47.82	1.88	35.87	1.41	28.69	1.13	23.91	0.94	5.16	3.21		
24/21	301.30	11.86	150.65	5.93	75.32	2.97	50.22	1.98	37.66	1.48	30.13	1.19	25.11	0.99	5.42	3.37		
24/22	315.64	12.43	157.82	6.21	78.91	3.11	52.61	2.07	39.46	1.55	31.56	1.24	26.30	1.04	5.68	3.53		
17/16	324.08	12.76	162.04	6.38	81.02	3.19	54.01	2.13	40.51	1.59	32.41	1.28	27.01	1.06	5.83	3.62		
17/17	344.34	13.56	172.17	6.78	86.08	3.39	57.39	2.26	43.04	1.69	34.43	1.36	28.69	1.13	6.20	3.85		
17/18	364.59	14.35	182.30	7.18	91.15	3.59	60.77	2.39	45.57	1.79	36.46	1.44	30.38	1.20	6.56	4.08		
17/19	384.85	15.15	192.42	7.58	96.21	3.79	64.14	2.53	48.11	1.89	38.48	1.52	32.07	1.26	6.93	4.30		
17/20	405.10	15.95	202.55	7.97	101.28	3.99	67.52	2.66	50.64	1.99	40.51	1.59	33.76	1.33	7.29	4.53		
17/21	425.36	16.75	212.68	8.37	106.34	4.19	70.89	2.79	53.17	2.09	42.54	1.67	35.45	1.40	7.66	4.76		
17/22	445.61	17.54	222.81	8.77	111.40	4.39	74.27	2.92	55.70	2.19	44.56	1.75	37.13	1.46	8.02	4.98		
13/15	397.31	15.64	198.66	7.82	99.33	3.91	66.22	2.61	49.66	1.96	39.73	1.56	33.11	1.30	7.15	4.44		
13/17	450.29	17.73	225.14	8.86	112.57	4.43	75.05	2.95	56.29	2.22	45.03	1.77	37.52	1.48	8.10	5.04		
13/18	476.78	18.77	238.39	9.39	119.19	4.69	79.46	3.13	59.60	2.35	47.88	1.88	39.73	1.56	8.58	5.33		
13/19	503.26	19.81	251.63	9.91	125.82	4.95	83.88	3.30	62.91	2.48	50.33	1.98	41.94	1.65	9.06	5.63		
13/20	529.75	20.86	264.88	10.43	132.44	5.21	88.29	3.48	66.22	2.61	52.98	2.09	44.15	1.74	9.53	5.92		
13/21	556.24	21.90	278.12	10.95	139.06	5.47	92.71	3.65	69.53	2.74	55.62	2.19	46.35	1.82	10.01	6.22		
13/22	582.73	22.94	291.36	11.47	145.68	5.74	97.12	3.82	72.84	2.87	58.27	2.29	48.56	1.91	10.49	6.52		
11/15	469.55	18.49	234.78	9.24	117.39	4.62	78.26	3.08	58.69	2.31	46.96	1.85	39.13	1.54	8.45	5.25		
11/18	563.46	22.18	281.73	11.09	140.87	5.55	93.91	3.70	70.43	2.77	58.35	2.22	46.96	1.85	10.14	6.30		
11/19	594.77	23.42	297.38	11.71	148.69	5.85	99.13	3.90	74.35	2.93	59.48	2.34	49.56	1.95	10.70	6.65		
11/20	626.07	24.65	313.03	12.32	156.52	6.16	104.34	4.11	78.26	3.08	62.61	2.46	52.17	2.05	11.27	7.00		
11/21	657.37	25.88	328.69	12.94	164.34	6.47	109.56	4.31	82.17	3.24	65.74	2.59	54.78	2.16	11.83	7.35		
11/22	688.68	27.11	344.34	13.56	172.17	6.78	114.78	4.52	86.08	3.39	68.87	2.71	57.39	2.26	12.39	7.70		

(1.15 Flexdrive) Seed Spacing / Gear Chart - Adjustable Height Chain Drive Land/wheel
 19-24 Primary Drive

	24T		20T		18T		17T		16T		15T		MM. INS.		MM. INS.		FORWARD SPEED TO ROTATE UNIT AT 25 RPM	
	24T	17T	13T	11T	12	24	48	72	96	120	144	MAX KPH	MAX MPH					
24/15	358.69	14.12	179.34	7.06	89.67	3.53	59.78	2.35	44.84	1.77	35.87	1.41	29.89	1.18	6.46	4.01		
24/16	382.60	15.06	191.30	7.53	95.65	3.77	63.77	2.51	47.82	1.88	38.26	1.51	31.88	1.26	6.89	4.28		
24/17	406.51	16.00	203.26	8.00	101.63	4.00	67.75	2.67	50.71	2.00	40.65	1.60	33.88	1.33	7.32	4.55		
24/18	430.42	16.95	215.21	8.47	107.61	4.24	71.74	2.82	53.80	2.12	43.04	1.69	35.87	1.41	7.75	4.81		
24/19	454.34	17.89	227.17	8.94	113.58	4.47	75.72	2.98	56.79	2.24	45.43	1.79	37.86	1.49	8.18	5.08		
24/20	478.25	18.83	239.12	9.41	119.56	4.71	79.71	3.14	59.78	2.35	47.82	1.88	39.85	1.57	8.61	5.35		
24/21	502.16	19.77	251.08	9.89	125.54	4.94	83.69	3.30	62.77	2.47	50.22	1.98	41.85	1.65	9.04	5.62		
24/22	526.07	20.71	263.04	10.36	131.52	5.18	87.68	3.45	65.76	2.59	52.61	2.07	43.84	1.73	9.47	5.88		
17/16	540.14	21.27	270.07	10.63	135.03	5.32	90.02	3.54	67.52	2.66	54.01	2.13	45.01	1.77	9.72	6.04		
17/17	573.90	22.59	286.95	11.30	143.47	5.65	95.65	3.77	71.74	2.82	57.39	2.26	47.82	1.88	10.33	6.42		
17/18	607.66	23.92	303.83	11.96	151.91	5.98	101.28	3.99	75.96	2.99	60.77	2.39	50.64	1.99	10.94	6.80		
17/19	641.41	25.25	320.71	12.63	160.35	6.31	106.90	4.21	80.18	3.16	64.14	2.53	53.45	2.10	11.54	7.17		
17/20	675.17	26.58	337.59	13.29	168.79	6.65	112.53	4.43	84.40	3.32	67.52	2.66	56.26	2.22	12.15	7.55		
17/21	708.93	27.91	354.47	13.96	177.23	6.98	118.16	4.65	88.62	3.49	70.89	2.79	59.08	2.33	12.76	7.93		
17/22	742.69	29.24	371.35	14.62	185.67	7.31	123.78	4.87	92.84	3.65	74.27	2.92	61.89	2.44	13.37	8.31		
13/15	662.19	26.07	331.09	13.04	165.55	6.52	110.36	4.35	82.77	3.26	66.22	2.61	55.18	2.17	11.92	7.41		
13/17	750.48	29.55	375.24	14.77	187.62	7.39	125.08	4.92	93.81	3.69	75.05	2.95	62.54	2.46	13.51	8.39		
13/18	794.63	31.28	397.31	15.64	198.66	7.82	132.44	5.21	99.33	3.91	79.46	3.13	66.22	2.61	14.30	8.89		
13/19	838.77	33.02	419.39	16.51	209.69	8.26	139.80	5.50	104.85	4.13	83.88	3.30	69.90	2.75	15.10	9.38		
13/20	882.92	34.76	441.46	17.38	220.73	8.69	147.15	5.79	110.36	4.35	88.29	3.48	73.58	2.90	15.89	9.87		
13/21	927.06	36.50	463.53	18.25	231.77	9.12	154.51	6.08	115.88	4.56	92.71	3.65	77.26	3.04	16.69	10.37		
13/22	971.21	38.24	485.61	19.12	242.80	9.56	161.87	6.37	121.40	4.78	97.12	3.82	80.93	3.19	17.48	10.86		
11/15	782.59	30.81	391.29	15.41	195.65	7.70	130.43	5.14	97.82	3.85	78.26	3.08	65.22	2.57	14.08	8.75		
11/18	939.10	36.97	469.55	18.49	234.78	9.24	156.52	6.16	117.39	4.62	93.91	3.70	78.26	3.08	16.90	10.50		
11/19	991.28	39.03	495.64	19.51	247.82	9.76	165.21	6.50	123.91	4.88	99.13	3.90	82.61	3.25	17.84	11.09		
11/20	1043.45	41.08	521.72	20.54	260.86	10.27	173.91	6.85	130.43	5.14	104.34	4.11	86.95	3.42	18.78	11.67		
11/21	1095.62	43.13	547.81	21.57	273.91	10.78	182.60	7.19	136.95	5.39	109.56	4.31	91.30	3.59	19.72	12.25		
11/22	1147.79	45.19	573.90	22.59	286.95	11.30	191.30	7.53	143.47	5.65	114.78	4.52	95.65	3.77	20.66	12.84		

(1.15 Flexdrive) Seed Spacing / Gear Chart - Adjustable Height Chain Drive Land/wheel
 19-40 Primary Drive