

# Tuning Singulators

## Parts List

1. Singulator Check Gauge (720271)
2. Standard eSet corn plate
3. Singulator Assembly (to be tested)

### Singulator Gauge Test

The singulator check gauge is designed to test the singulator assembly on eSets for the correct tolerance of the last lobe. You will use the check gauge and a standard corn disk to determine if the singulator has a tight enough tolerance to be effective.

### If Singulator fails Gauge Test:

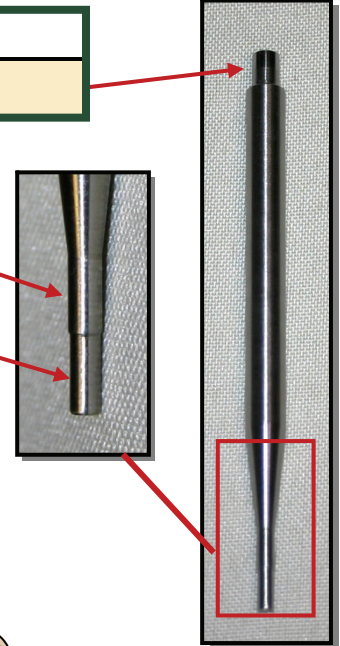
Singulators that do not pass the Gauge Test, as illustrated in Step 3, should be filed down slightly as illustrated in Step 4. For singulators that continue to fail, you can repeat Step 4 till it passes Step 3.



**\*NOTE\*** If you file away to much of the singulator lobe and it is able to pass the "No-Go" section of the gauge, you may need to replace the singulator.

**TOP END**  
.176" diameter hole check

**BOTTOM END**  
"No-Go" Section is the wider top part .117".  
"Go" section is the narrow end part .095".



Step 2

**Position the last singulator lobe over the hole as shown below.**



Step 3

Determine the Singulator's Tolerance by placing **BOTTOM END** of gauge in hole at 90 Degrees. If the singulator fails the gauge, continue to Step 4.

Step 1

### Verify Proper Hole Size

Verify your corn disk holes are near size. Insert the **TOP END** of the check gauge into the corn hole at a 90 degree angle. The correct fit will be tight to slightly loose.



"No Go" Section should not clear.

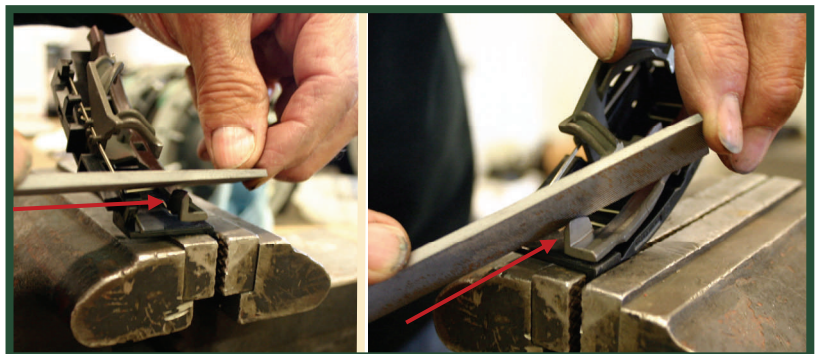


"Go" Section should clear.



Step 4

With singulator in vice, file last lobe down slightly and slightly upward to make it tapered again. Recheck with gauge in Step 3.



Questions? Check the website: [www.precisionplanting.com](http://www.precisionplanting.com) or call us at 309-925-5050.

