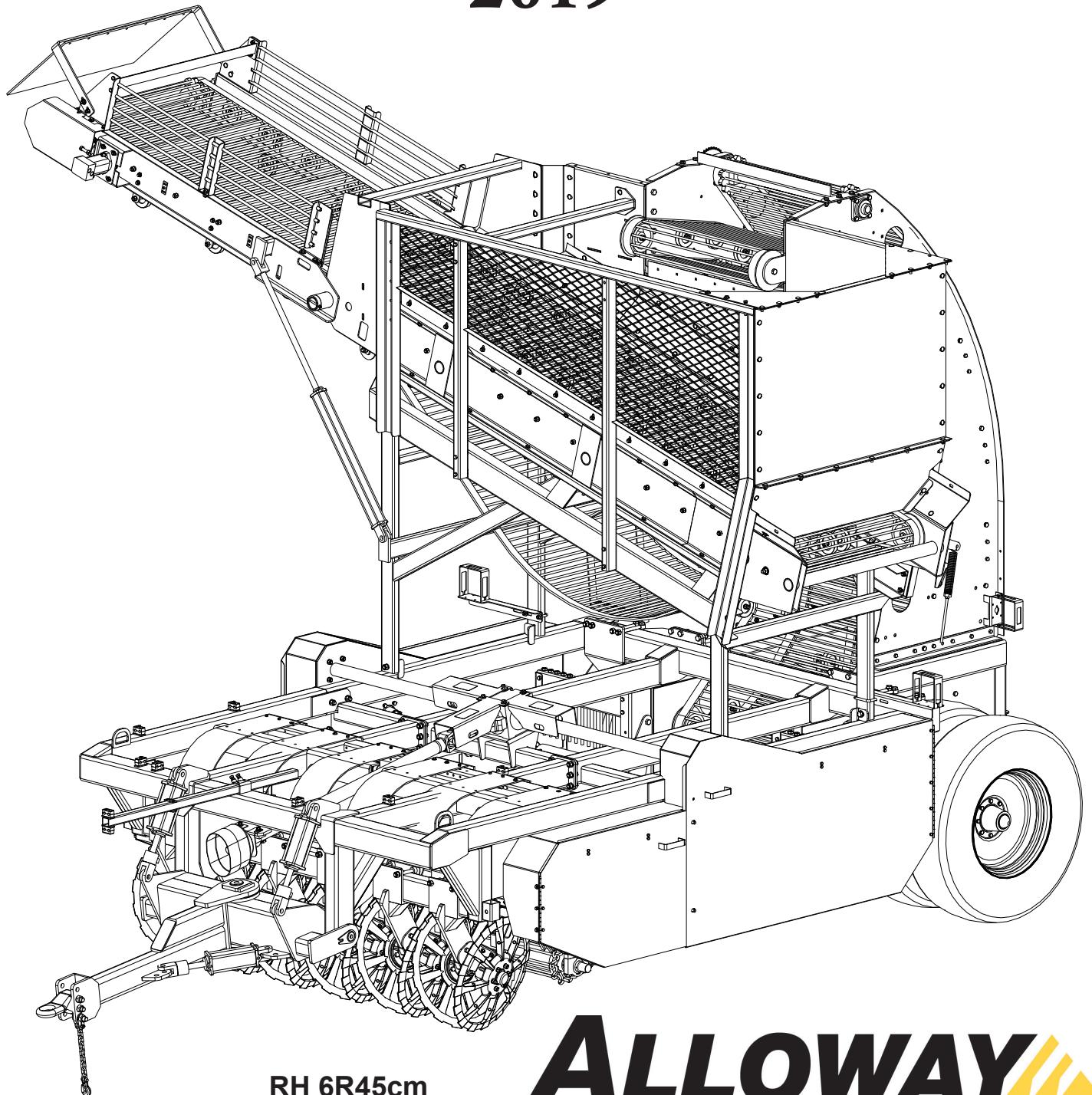


RIGID BEET HARVESTER 2019



RH 6R45cm

ALLOWAY 

OPERATOR'S MANUAL

TO THE DEALER:

Assembly and proper installation of this product is the responsibility of the Alloway dealer. Read manual instructions and safety rules. Make sure all items on the Dealer's Pre-Delivery and Delivery Check Lists in the Operator's Manual are completed before releasing equipment to the owner.

The dealer must complete the Warranty Registration included in this manual. Both dealer and customer must sign the registration which certifies that all Dealer Check List items have been completed. The dealer is to return the prepaid postage portion to Alloway, give one copy to the customer, and retain one copy.

Note: Warranty credit is subject to this form being completed and returned.

TO THE OWNER:

Read this manual before operating your Alloway equipment. The information presented will prepare you to do a better and safer job. Keep this manual handy for ready reference. Require all operators to read this manual carefully and become acquainted with all the adjustment and operating procedures before attempting to operate. Replacement manuals can be obtained from your dealer.

The equipment you have purchased has been carefully engineered and manufactured to provide dependable and satisfactory use. Like all mechanical products, it will require cleaning and upkeep. Lubricate the unit as specified. Observe all safety information in this manual and safety decals on the equipment.

For service, your authorized Alloway dealer has trained mechanics, genuine Alloway service parts, and the necessary tools and equipment to handle all your needs.

Use only genuine Alloway service parts. Substitute parts will void the warranty and may not meet standards required for safe and satisfactory operation. Record the model number and serial number of your equipment in the spaces provided:

Model: _____ **Date of Purchase** _____

Serial Number: (see Safety Decal section for location) _____

Provide this information to your dealer to obtain correct repair parts.

Throughout this manual, the term **IMPORTANT** is used to indicate that failure to observe can cause damage to equipment. The terms **CAUTION**, **WARNING** and **DANGER** are used in conjunction with the Safety-Alert Symbol, (a triangle with an exclamation mark), to indicate the degree of hazard for items of personal safety.



This Safety-Alert Symbol indicates a hazard and means
ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.



WARNING

Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed



CAUTION

Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury.

IMPORTANT

Indicates that failure to observe can cause damage to equipment.

NOTE

Indicates helpful information.

ALLOWAY

TABLE OF CONTENTS

INTRODUCTION	Inside Front Cover
GENERAL INFORMATION	1
SPECIFICATIONS	2
SAFETY RULES	3 - 7
SAFETY DECALS	10 - 11
OPERATOR SIGN-OFF RECORD	12
OPERATION	13
FIELD OPERATION	19
ADDITIONAL EQUIPMENT	26
SHREDDER STORAGE	27
SERVICE & MAINTENANCE	28
TROUBLE SHOOTING	39
CONTOUR FLAIL PATTERN WORKSHEETS	40
ASSEMBLY	42
INDEX TO PARTS LISTS	47
BOLT TORQUE CHART	68
ABBREVIATIONS	69
INDEX	70
REPLACEMENT PARTS WARRANTY	72
PRODUCT WARRANTY	Inside Back Cover

GENERAL INFORMATION

The purpose of this manual is to assist you in operating and maintaining your Beet Harvester. Read it carefully. It furnishes information and instructions that will help you achieve years of dependable performance. These instructions have been compiled from extensive field experience and engineering data. Some information may be general in nature due to unknown and varying operating conditions. However, through experience and these instructions, you should be able to develop procedures suitable to your particular situation.

The illustrations and data used in this manual were current at the time of printing, but due to possible inline production changes, your machine may vary slightly in detail. We reserve the right

to redesign and change the machines as may be necessary without notification.



WARNING

- Some illustrations in this manual show the Beet Harvester with safety shields removed to provide a better view. The Beet Harvester should never be operated with any safety shielding removed.

Throughout this manual, references are made to right and left direction. These are determined by standing behind the equipment facing the direction of forward travel.

SPECIFICATIONS

Model	H132	H144	H180
Overall Width	189 in. (480 cm)	197 in. (500 cm)	197 in. (500 cm)
Overall Length	280 in. (711 cm)	280 in. (711 cm)	280 in. (711 cm)
Overall Height	164 in. (417 cm)	164 in. (417 cm)	164 in. (417 cm)
Gearbox	160 HP	180 HP	180 HP
Belt Elevator Chain	42 in. (107 cm)	42 in. (107 cm)	42 in. (107 cm)
1/2" Elevator Chain Rods	56mm Pitch	56mm Pitch	56mm Pitch
Tank Capacity	3-1/2 Tons	3-1/2 Tons	3-1/2 Tons
Tractor PTO Speed	1000 RPM	1000 RPM	1000 RPM
Belt System	4B Power Band	4B Power Band	4B Power Band
Elevator Drive	Hydraulic	Hydraulic	Hydraulic
Wheel Struts	2 Adjustable	2 Adjustable	2 Adjustable
Number of Tires	4	4	4
Tire Type	12.4 X 24 Traction	12.4 X 24 Traction	12.4 X 24 Traction
Tire Pressure	32 psi (220 kPa)	32 psi (220 kPa)	32 psi (220 kPa)
Tire Ply Rating	8	8	8
Tire Load Capacity	11,300 lbs (5125 kg)	11,300 lbs (5125 kg)	11,300 lbs (5125 kg)
Grab Roll Bed	Rock Protected	Rock Protected	Rock Protected
Grab Rolls Adjustable	7 Full Length	7 Full Length	7 Full Length
Grab Roll Option	2 Stub Rollers	2 Stub Rollers	2 Stub Rollers
Grab Roll Composition	Steel or Plastic Covered	Steel or Plastic Covered	Steel or Plastic Covered
Digger Struts	Fixed or Flexible	Fixed or Flexible	Fixed or Flexible
Tongue Weight (Drawbar)	6500 lbs (2950 kg)	6650 lbs (3020 kg)	7000 lbs (3175 kg)
Weight Empty	18,500 lbs (8400 kg)	18,800 lbs (8525 kg)	19,500 lbs (8850 kg)

CHECK LISTS

PRE-DELIVERY CHECK LIST (DEALER'S RESPONSIBILITY)

Inspect the equipment thoroughly after assembly to ensure it is set up properly before delivering it to the customer.

The following check lists are a reminder of points to inspect. Check off each item as it is found satisfactory or after proper adjustment is made.

- Check that all safety decals are installed and in good condition. Replace if damaged.
- Check that shields and guards are properly installed and in good condition. Replace if damaged.
- Check that PTO shaft is properly installed.
- Properly attach implement to tractor and make all necessary adjustments.
- Check all bolts to be sure they are tight.
- Check wheel bolts for proper torque.
- Check that all cotter pins and safety pins are properly installed. Replace if damaged.
- Check and grease all lubrication points as identified in "Service, lubrication information."
- Check the level of gearbox fluids before delivery. Service, if required, as specified in the "Service, lubrication information."
- Check that tractor hydraulic reservoir has been serviced and that hydraulic system and all functions have been operated through full cylinder stroke to purge air from system.
- After pressurizing and operating all harvester functions, stop tractor and make sure there are no leaks in the hydraulic system. Follow all safety rules when checking for leaks.

DELIVERY CHECK LIST (DEALER'S RESPONSIBILITY)

- Show customer how to make adjustments and select proper PTO speed.
- Show customer how to make adjustments.
- Instruct customer how to lubricate and explain importance of lubrication.
- Point out the safety decals. Explain their meaning and the need to keep them in place and in good condition. Emphasize the increased safety hazards when instructions are not followed.
- Present Operator's Manual and request that customer and all operators read it before operating equipment. Point out the manual safety rules, explain their meanings and emphasize the increased safety hazards that exist when safety rules are not followed.
- Show customer how to make sure driveline is properly installed and that spring-activated locking pin or collar slides freely and is seated in groove on tractor PTO shaft.
- Show customer the safe, proper procedures to be used when mounting, dismounting, and storing equipment.
- Explain to customer that when equipment is transported on a road or highway, safety devices should be used to give adequate warning to operators of other vehicles.
- Explain to customer that when equipment is transported on a road or highway, a Slow Moving Vehicle (SMV) sign should be used to provide adequate warning to operators of other vehicles.
- Explain to customer that when towing on a public road to comply with all state and local lighting/ marking laws and to use a safety tow chain.
- Make customer aware of optional equipment available so that customer can make proper choices as required.
- Point out all guards and shields. Explain their importance and the safety hazards that exist when not kept in place and in good condition.



SAFETY RULES

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator.

In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel involved in the operation, transport, maintenance and storage of equipment.

It has been said "*The best safety device is an informed, careful operator.*" We ask you to be that kind of an operator.

The designed and tested safety of this equipment depends on it being operated within the limitations as explained in this manual.

TRAINING

- Safety instructions are important! Read all attachment and power unit manuals; follow all safety rules and safety decal information. (Replacement manuals are available from dealer or, in the United States. Failure to follow instructions or safety rules can result in serious injury or death.
- If you do not understand any part of this manual and need assistance, see your dealer.
- Know your controls and how to stop engine and attachment quickly in an emergency.
- Operators must be instructed in and be capable of the safe operation of the equipment, its attachments and all controls. Do not allow anyone to operate this equipment without proper instructions.
- Keep hands and body away from pressurized lines. Use paper or cardboard, not body parts to check for leaks. Wear safety goggles. Hydraulic fluid under pressure can easily penetrate skin and will cause serious injury or death.
- Make sure that all operating and service personnel know that in the event hydraulic fluid penetrates skin, it must be surgically removed as soon as possible by a doctor familiar with this form of injury, or gangrene, serious injury or death will result. **CONTACT A PHYSICIAN IMMEDIATELY IF FLUID ENTERS SKIN OR EYES. DO NOT DELAY.**

- Do not allow children or untrained persons to operate equipment.

PREPARATION

- Check that all hardware is tight and properly installed. Always tighten to torque chart specifications.
- Air in hydraulic systems can cause erratic operation and allows loads or equipment components to drop unexpectedly. Before operating or allowing anyone to approach the equipment, purge any air in the system by operating all hydraulic functions several times after connecting equipment, connecting hoses, or doing any hydraulic maintenance.
- Make sure all hydraulic hoses, fittings and valves are in good condition and not leaking before starting power unit or using equipment. Check and route hoses carefully to prevent damage. Hoses must not be twisted, bent sharply, kinked, frayed, pinched, or come into contact with any moving parts. Operate moveable components through full operational range to check clearances. Replace any damaged hoses immediately.
- Always wear relatively tight and belted clothing to avoid entanglement in moving parts. Wear sturdy, rough-soled work shoes and protective equipment for eyes, hair, hands, hearing and head.
- Ensure implement is properly attached, adjusted and in good operating condition.
- Make sure spring-activated locking pin or collar slides freely and is seated firmly in tractor PTO spline groove.
- Before starting tractor, check all equipment driveline guards for damage and make sure they rotate freely on all drivelines. Replace any damaged guards. If guards do not rotate freely on drivelines, repair and replace bearings before operating.

(Safety Rules continued on next page)



SAFETY RULES

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



(Safety Rules continued from previous page)

- Power unit must be equipped with ROPS or ROPS CAB and seat belt. Keep seat belt securely fastened. Falling off power unit can result in death from being run over or crushed. Keep foldable ROPS systems in "locked up" position at all times.
- Connect PTO driveline directly to tractor PTO shaft. Never use adapter sleeves or adapter shafts. Adapters can cause driveline failures due to incorrect spline or incorrect operating length and result in personal injury or death.
- Remove accumulated debris from this equipment, tractor and engine to avoid fire hazard.
- Ensure all safety decals are installed. Replace if damaged. (See Safety Decals section for location.)
- Ensure shields and guards are properly installed and in good condition. Replace if damaged.
- A minimum 20% of tractor and equipment weight must be on tractor front wheels with attachments in transport position. Without this weight, tractor could tip over causing personal injury or death. The weight may be attained with a loader, front wheel weights, ballast in tires or front tractor weights. When attaining the minimum 20% weight on the front wheels, you must not exceed the Roll Over Protection Structure (ROPS) weight certification. Weigh the tractor and equipment. Do not estimate.
- Make sure hydraulic hoses and cylinders are fully purged of air before operating. Keep all persons away and fill the system by raising and lowering all functions several times. Air in the system can allow components to fall unexpectedly.
- Never go underneath equipment lowered to the ground or raised, unless it is properly blocked and secured. Never place any part of the body underneath equipment or between moveable parts even when the engine has been turned off. Hydraulic system leak down, hydraulic system failures, mechanical failures or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death. Follow Operator's Manual instructions for working underneath and blocking requirements, or have work done by a qualified dealer.
- Do not operate equipment while under the influence of alcohol or drugs.
- Operate only in daylight or good artificial light.
- Avoid contact with electrical wires.
- Keep hands, feet, hair and clothing away from equipment while engine is running. Stay clear of all moving parts.
- Always comply with all state and local lighting and marking requirements.
- No riders are allowed on equipment.
- Power unit must be equipped with ROPS or ROPS CAB and seat belt. Keep seat belt securely fastened. Falling off power unit can result in death from being run over or crushed. Keep foldable ROPS systems in "locked up" position at all times.
- Always sit in tractor seat when operating controls or starting engine. Securely fasten seat belt, place transmission in neutral, engage brake and ensure all other controls are disengaged before starting tractor engine.
- Operate tractor PTO at RPM speed stated in "Specifications" section.

OPERATIONAL SAFETY

- Do not allow other people in the area when operating, attaching, removing, assembling or servicing equipment.
- Keep bystanders away from equipment.

(Safety Rules continued on next page)



SAFETY RULES

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



(Safety Rules continued from previous page)

- Do not stop, start or change directions suddenly on slopes.
- Watch for hidden hazards on the terrain during operation.
- Stop tractor and implement immediately upon striking an obstruction. Turn off engine, remove key, inspect and repair any damage before resuming operation.
- Truck boom lock must be engaged when truck boom is in operating position. Do not operate unloader conveyor unless boom lock is engaged and in good repair. Hydraulic system leak down, hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.
- Always connect safety chain from implement to towing vehicle when transporting.
- **AVOID INJURY OR DEATH FROM POWER LINES:**
 - Stay away from power lines.
 - Electrocution can occur without direct contact.
 - Check clearances before raising implement.
 - Do not leave the operator's seat if any part of the tractor or implement contacts electric lines.
- Before dismounting tractor, disengage tractor PTO power to implement, lower front lift cylinders so that lifter wheels are on the ground. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt.
- Before performing any service or maintenance, disengage power to implement, lower front lift cylinders so that lifter wheels are on the ground, lower truck boom, lower 3-point hitch. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt. Disconnect driveline from tractor PTO. Chock (block) front and rear of implement wheels.
- Before working underneath a raised implement, read and follow all operator's manual instructions and safety rules. Implement must be attached to tractor, lift cylinder locks must be installed, and lift cylinders lowered against locks. Hydraulic system leak down, hydraulic system failures, or movement of control levers can cause equipment to drop unexpectedly and cause severe injury or death.
- Before working underneath a raised implement, read and follow all operator's manual instructions and safety rules. Implement must be attached to tractor, lift cylinder locks must be installed, and lift cylinders lowered against locks. Hydraulic system leak down, hydraulic system failures, or movement of control levers can cause equipment to drop unexpectedly and cause severe injury or death.
- Do not modify or alter or permit anyone else to modify or alter the equipment or any of its components in any way.
- Before performing any maintenance on the beet harvester. Do not work in or under the holding tank with the tank bottom in the raised (unload) position. Hydraulic system leak down,

instructions and safety rules. Implement must be attached to tractor, lift cylinder locks must be installed, and lift cylinders lowered against locks. Hydraulic system leak down, hydraulic system failures, or movement of control levers can cause equipment to drop unexpectedly and cause severe injury or death.

MAINTENANCE SAFETY

- Service and maintenance work not covered in OWNER SERVICE must be done by a qualified dealership. Special skills, tools and safety procedures may be required. Failure to follow these instructions can result in serious injury or death.
- Before dismounting tractor, disengage tractor PTO power to implement, lower front lift cylinders so that lifter wheels are on the ground. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt.
- Before performing any service or maintenance, disengage power to implement, lower front lift cylinders so that lifter wheels are on the ground, lower truck boom, lower 3-point hitch. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt. Disconnect driveline from tractor PTO. Chock (block) front and rear of implement wheels.
- Before working underneath a raised implement, read and follow all operator's manual instructions and safety rules. Implement must be attached to tractor, lift cylinder locks must be installed, and lift cylinders lowered against locks. Hydraulic system leak down, hydraulic system failures, or movement of control levers can cause equipment to drop unexpectedly and cause severe injury or death.
- Do not modify or alter or permit anyone else to modify or alter the equipment or any of its components in any way.
- Before performing any maintenance on the beet harvester. Do not work in or under the holding tank with the tank bottom in the raised (unload) position. Hydraulic system leak down,

(Safety Rules continued on next page)



SAFETY RULES

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



(Safety Rules continued from previous page)

hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.

- Before performing any maintenance on the beet harvester, the truck boom must be fully lowered into the transport position. Do not work on harvester with truck boom in any intermediate position. Hydraulic system leak down, hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.
- Your dealer can supply original equipment hydraulic accessories and repair parts. Substitute parts may not meet original equipment specifications and may be dangerous.
- Always wear relatively tight and belted clothing to avoid entanglement in moving parts. Wear sturdy, rough-soled work shoes and protective equipment for eyes, hair, hands, hearing and head.
- Do not allow other people in the area when operating, attaching, removing, assembling or servicing equipment.
- Never go underneath equipment lowered to the ground or raised, unless it is properly blocked and secured. Never place any part of the body underneath equipment or between moveable parts even when the engine has been turned off. Hydraulic system leak down, hydraulic system failures, mechanical failures or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death. Follow Operator's Manual instructions for working underneath and blocking requirements, or have work done by a qualified dealer.
- Ensure implement is properly attached, adjusted and in good operating condition.
- Never perform service or maintenance with engine running.
- Make sure hydraulic hoses and cylinders are fully purged of air before operating. Keep all persons away and fill the system by raising and lowering all functions several times. Air in the system can allow components to fall unexpectedly.
- Keep all persons away from operator control area while performing adjustments, service or maintenance.
- Make certain all movement of implement components has stopped before approaching for service.
- Tighten all bolts, nuts and screws to torque chart specifications. Check that all cotter pins are installed securely to ensure equipment is in a safe condition before operating.
- Ensure all safety decals are installed. Replace if damaged. (See Safety Decals section for location.)
- Ensure shields and guards are properly installed and in good condition. Replace if damaged.
- Do not disconnect hydraulic lines until engine is stopped, tractor is properly secured, equipment and all components are lowered to the ground, and system pressure is released by operating all valve control levers.

STORAGE

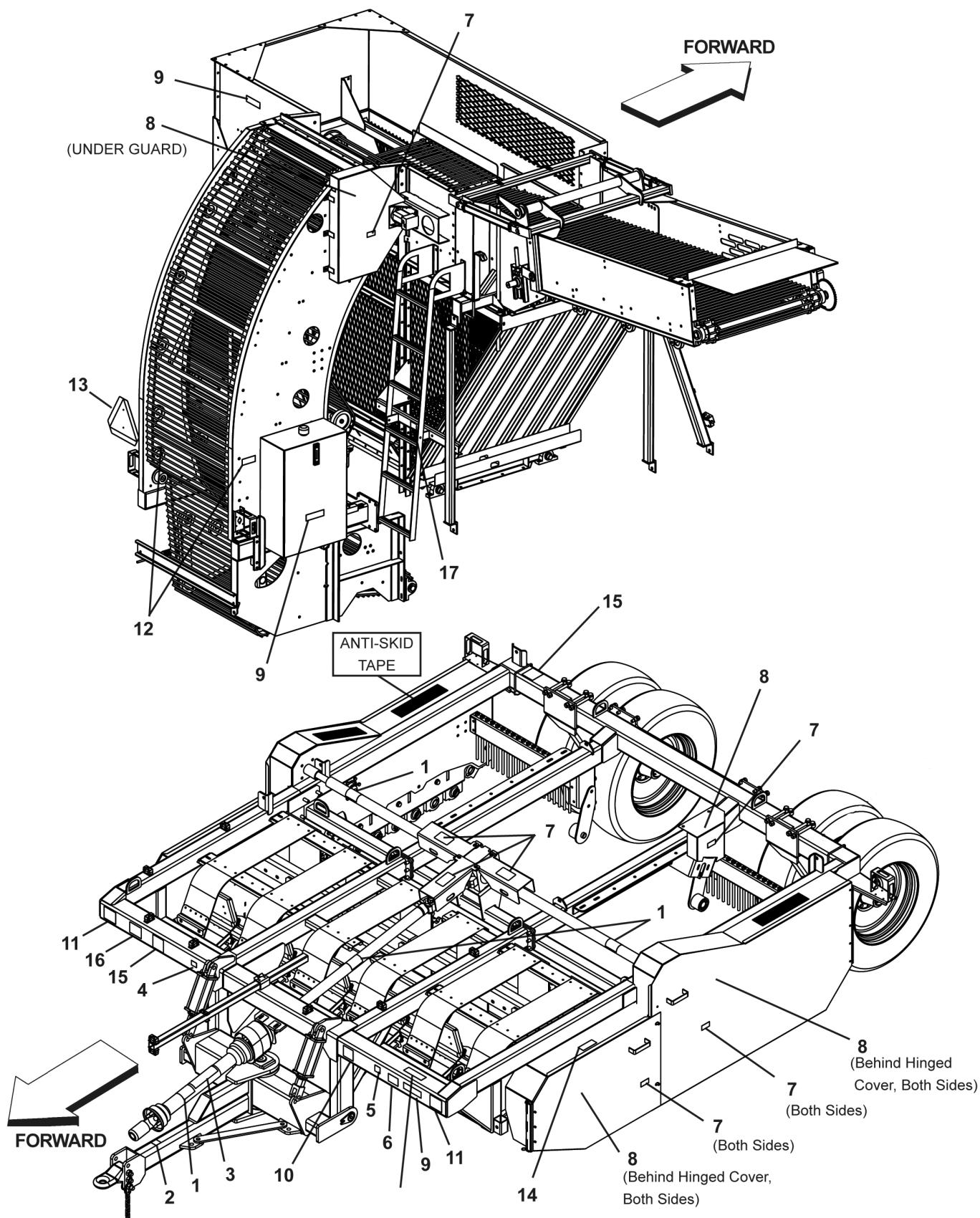
- For storage, disengage tractor PTO power to harvester, lower front lift cylinders so that lifter wheels are on the ground, lower truck boom, lower 3-point hitch. Operate tractor valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt. Remove driveline from tractor PTO. Chock (block) front and rear of harvester wheels.
- Keep children and bystanders away from storage area.



SAFETY & INSTRUCTIONAL DECALS

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

Replace Immediately If Damaged!





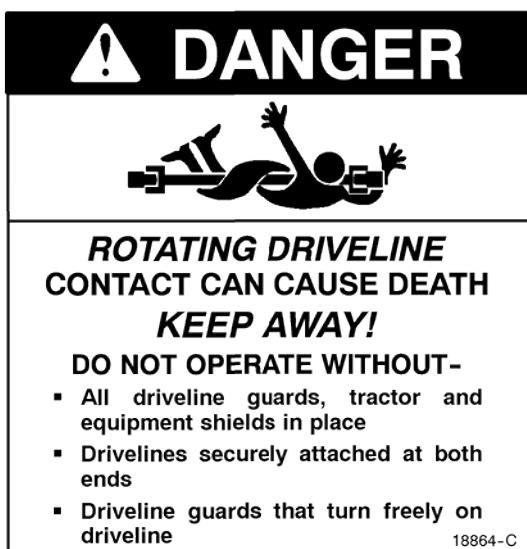
SAFETY & INSTRUCTIONAL DECALS

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

Replace Immediately If Damaged!



(Safety Decals continued from previous page)



1. 506-3-0196 Rotating Driveline Warning



2. 700-3-0519 PTO Speed Warning



3. 903-17456 Driveline Safety Sign

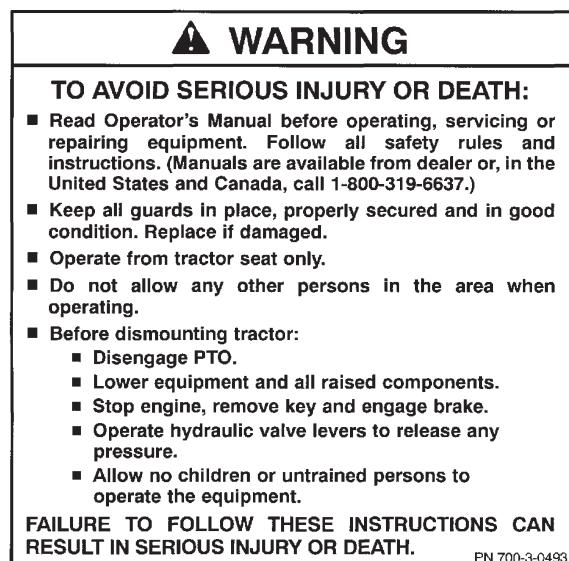
PN: 700-5-0018 (2019)



4. 200-3-1366 Serial Number Tag



5. 700-3-0494 Fall Hazard Warning



6. 700-3-0493 Read Manual Warning

(Safety Decals continued on next page)



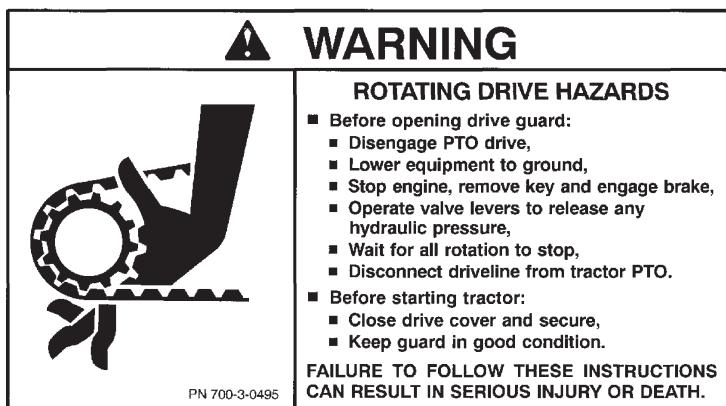
SAFETY & INSTRUCTIONAL DECALS

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

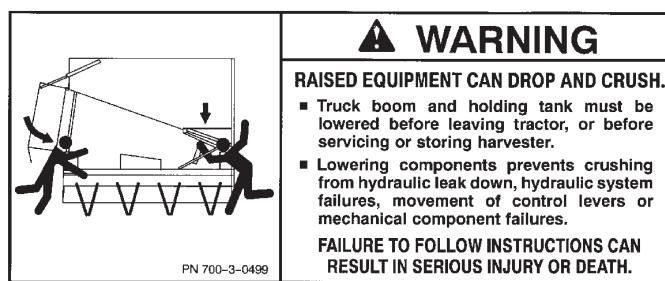
Replace Immediately If Damaged!



(Safety Decals continued from previous page)



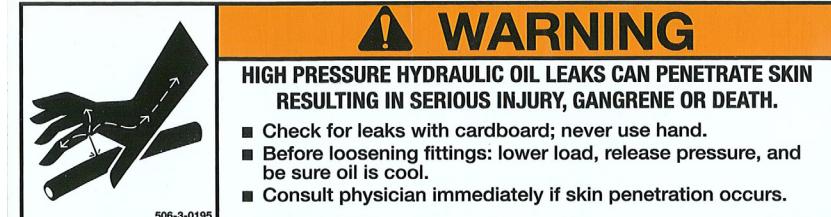
7. 700-3-0495 Rotating Drive Hazard



11. 700-3-0499 Raised Equipment Warning



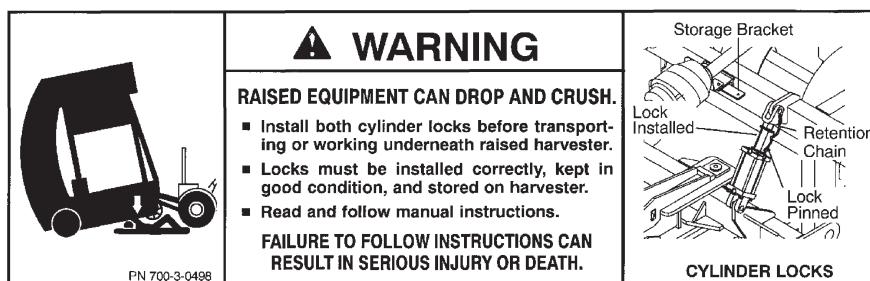
8. 506-3-0194 Shield Missing Warning



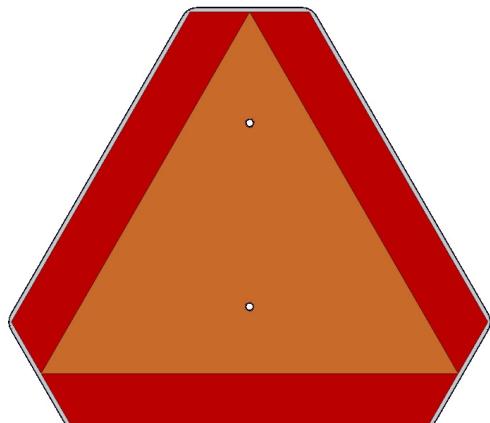
9. 506-3-0195 Hydraulic Pressure Warning



12. 700-3-0497 Elevator Chain Warning



10. 700-3-0498 Cylinder Lock Warning



13. 500-3-1696 SMV Sign

(Safety Decals continued on next page)



SAFETY & INSTRUCTIONAL DECALS

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

Replace Immediately If Damaged!



(Safety Decals continued from previous page)

⚠ WARNING

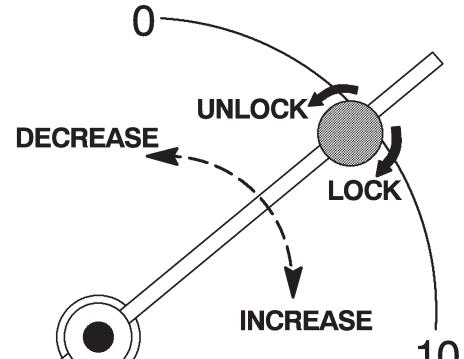
MANUAL CONTAINER AND MANUAL ARE MISSING

- REPLACE AND READ BEFORE OPERATING.
- KEEP MANUAL CONTAINER AND MANUAL MOUNTED IN THIS LOCATION. (Available from dealer or call 1-800-319-6637.)

FAILURE TO FOLLOW MANUAL INSTRUCTIONS AND SAFETY RULES CAN RESULT IN SERIOUS INJURY OR DEATH. 506-3-0192

14. 506-3-0192 Manual Container Warning

TRUCK BOOM MOTOR SPEED



17. 700-3-0672 Rear Elevator Motor Speed

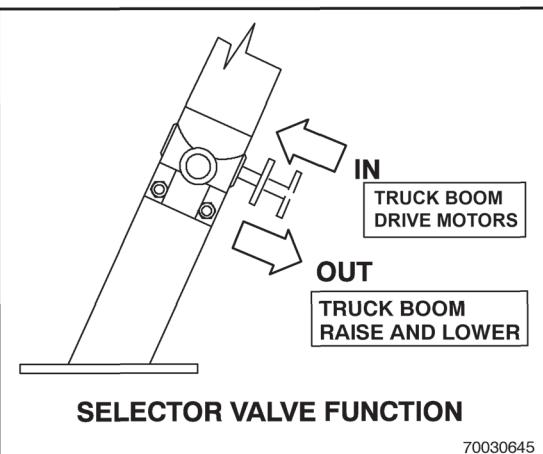
BOOM LOCK MUST BE ENGAGED WHEN TRUCK BOOM IS RAISED TO OPERATING POSITION:

1. Read manual and follow all instructions and safety rules.
2. Lock pin must be in lowered position.
3. Hydraulically raise truck boom.
4. Boom lock must fully rotate into engaged position as shown.
5. Check and do not operate unless boom lock is fully engaged and in good repair.

BOOM LOCK MUST BE RELEASED BEFORE TRUCK BOOM CAN BE LOWERED:

1. Read manual and follow all instructions and safety rules.
2. Hydraulically raise truck boom to full up position to remove boom weight from boom lock.
3. Stand behind truck boom and raise lock pin handle to raised position as shown.
4. Hydraulically lower truck boom to transport position.
5. The lock pin will automatically reset to the lowered position as the truck boom is lowered. If lock pin does not reset, have unit repaired before operating.

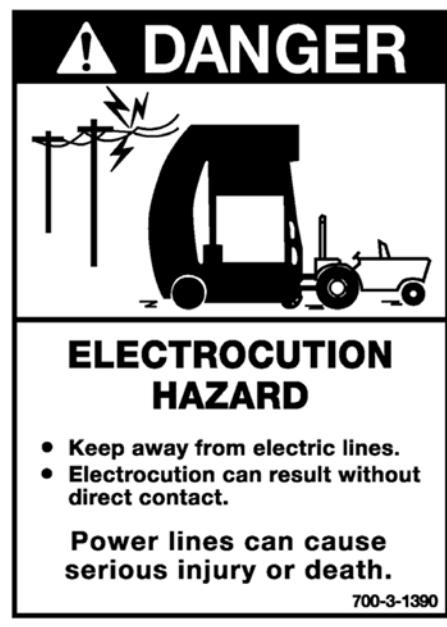
15. 700-3-0644 Boom Lock Warning



16. 700-3-0645 Selector Valve Function

16- PN-70030645

PN: 700-5-0018 (2019)



18. 700-3-1390 Electrocution Hazard

OPERATION

Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator.

In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel involved in the operation, transport, maintenance and storage of equipment.

It has been said "*The best safety device is an informed, careful operator.*" We ask you to be that kind of an operator.



WARNING

- Operators must be instructed in and be capable of the safe operation of the equipment, its attachments and all controls. Do not allow anyone to operate this equipment without proper instructions.
- Do not allow children or untrained persons to operate equipment.



CAUTION

- Always wear relatively tight and belted clothing to avoid entanglement in moving parts. Wear sturdy, rough-soled work shoes and protective equipment for eyes, hair, hands, hearing.



WARNING

- Make sure spring-activated locking pin or collar slides freely and is seated firmly in tractor PTO spline groove.
- Before starting tractor, check all equipment driveline guards for damage and make sure they rotate freely on all drive-lines. Replace any damaged guards. If guards do not rotate freely on drivelines, repair and replace bearings before operating.
- A minimum 20% of tractor and equipment weight must be on tractor front wheels with attachments in transport position. Without this weight, tractor could tip over causing personal injury or death. The weight may be attained

with a loader, front wheel weights, ballast in tires or front tractor weights. When attaining the minimum 20% weight on the front wheels, you must not exceed the Roll Over Protection Structure (ROPS) weight certification. Weigh the tractor and equipment. Do not estimate.



WARNING

- Ensure all safety decals are installed. Replace if damaged. (See Safety Decals section for location.)
- Ensure shields and guards are properly installed and in good condition. Replace if damaged.
- Do not allow other people in the area when operating, attaching, removing, assembling or servicing equipment.
- Keep bystanders away from equipment.

■ Never go underneath equipment lowered to the ground or raised, unless it is properly blocked and secured. Never place any part of the body underneath equipment or between moveable parts even when the engine has been turned off. Hydraulic system leak down, hydraulic system failures, mechanical failures or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death. Follow Operator's Manual instructions for working underneath and blocking requirements, or have work done by a qualified dealer.



CAUTION

- Operate only in daylight or good artificial light.



DANGER

- Avoid contact with electrical wires.



WARNING

- Keep hands, feet, hair and clothing away from equipment while engine is running. Stay clear of all moving parts.

- Always comply with all state and local lighting and marking requirements.
- No riders are allowed on equipment.
- Power unit must be equipped with ROPS or ROPS CAB and seat belt. Keep seat belt securely fastened. Falling off power unit can result in death from being run over or crushed. Keep foldable ROPS systems in "locked up" position at all times.

PRE-OPERATION CHECK LIST

(OWNER'S RESPONSIBILITY)

To assure safe and efficient operation it is essential, that each machine operator read and understand the operating procedures and related safety requirements outlined in this manual.

Complete the Pre-Operation Checklist before initial operation, after the first hour of field operation, and before each shift thereafter.

- Review and follow all safety rules and safety decal instructions on pages 4 through 11.
- Check that all safety decals are installed and in good condition. Replace if damaged.
- Check that all shields and guards are properly installed and in good condition. Replace if damaged.
- Check that all hardware and cotter pins are properly installed and secured.
- Check alignment and spacing of digger wheels.
- Check alignment of grab rolls and remove any obstructions.
- Check that elevator chains, rollers and tensioners move freely and without obstruction
- Check tractor and harvester tire pressures Service as necessary.
- Check that boom lock is in good repair. Do not operate unless boom lock is fully engaged when truck boom is raised.
- Check that equipment is properly and securely attached to tractor.
- Make sure driveline spring-activated locking collar slides freely and is seated firmly in tractor PTO spline groove.
- Before starting tractor, check all equipment driveline guards for damage and make sure they rotate freely on all drivelines. Replace any damaged guards. If guards do not rotate freely on drivelines, repair and replace bearings before operating.
- Do not allow riders.
- Check and keep all bystanders away from equipment working area.
- Check all lubrication points and grease as instructed in "Service, lubrication information". Make sure the PTO slip joint is lubricated and that the gearbox fluid levels are correct.
- Set tractor PTO at correct rpm for your equipment.
- Check that all hydraulic connections are correct and all hydraulic control movements function as described in the Operator's Manual.
- Check that all hydraulic hoses and fittings are in good condition and not leaking before starting tractor. Check that hoses are not twisted, bent sharply, kinked, frayed or pulled tight. Replace any damaged hoses immediately.
- Raise and lower equipment to make sure air is purged from hydraulic cylinders and hoses.
- Make sure tractor 3-point lift links do not interfere with hydraulic hoses or driveline throughout full turning range.
- Make sure tractor ROPS or ROPS CAB and seat belt are in good condition. Keep seat belt securely fastened during operation.
- Before starting engine, operator must be in tractor seat with seat belt fastened. Place transmission in neutral or park, engage brake and disengage tractor PTO.

Operation Continued

HARVESTER COMPONENTS

The harvester consists of several components which will be referred to throughout this manual. They are as follows:

1. **Main frame:** This is the base structure to which all components of the harvester are attached.
2. **Hitch:** Located on the front of the harvester, it is used to attach the harvester to a tractor. Hydraulic cylinders connect the Hitch to the Main Frame and are used to control the working depth and harvester steering.
3. **Lifter struts:** Lifter struts are attached to the front of the harvester to align with each row of beets. A pair of lifter wheels is attached to each strut to remove the beets from the soil.

4. **Paddle shaft:** Shaft and paddle assemblies rotate through each lifter wheel assembly directing all materials from between the lifter wheels onto the grab roll bed.

5. **Grab rolls bed:** Pairs of counter-rotating cleaning rolls remove soil and debris from the beets while moving beets to the vertical elevator.

6. **Vertical elevator:** Structure comprised of two powered belted chains moving the beets vertically from the grab rolls to the top of the holding tank.

7. **Holding tank:** Beet holding area. Beets are dropped into the tank until truck arrives.

8. **Carrier wheel struts:** Wheel and strut assemblies attach to the rear of the Main Frame. Struts are adjustable to level the machine for operation. Optional steerable struts are available.

9. **Truck boom:** The foldable conveyor extension on the top right of the harvester used to convey beets to the truck.

- 1. Main frame
- 2. Hitch
- 3. Lifter struts
- 4. Paddle shaft
- 5. Grab rolls
- 6. Vertical elevator
- 7. Holding tank
- 8. Carrier struts
- 9. Truck boom
- 10. Row Finder
- 11. Chain Bed
- 12. Tank Unload Conveyor
- 13. Belt Tightener (Boom)

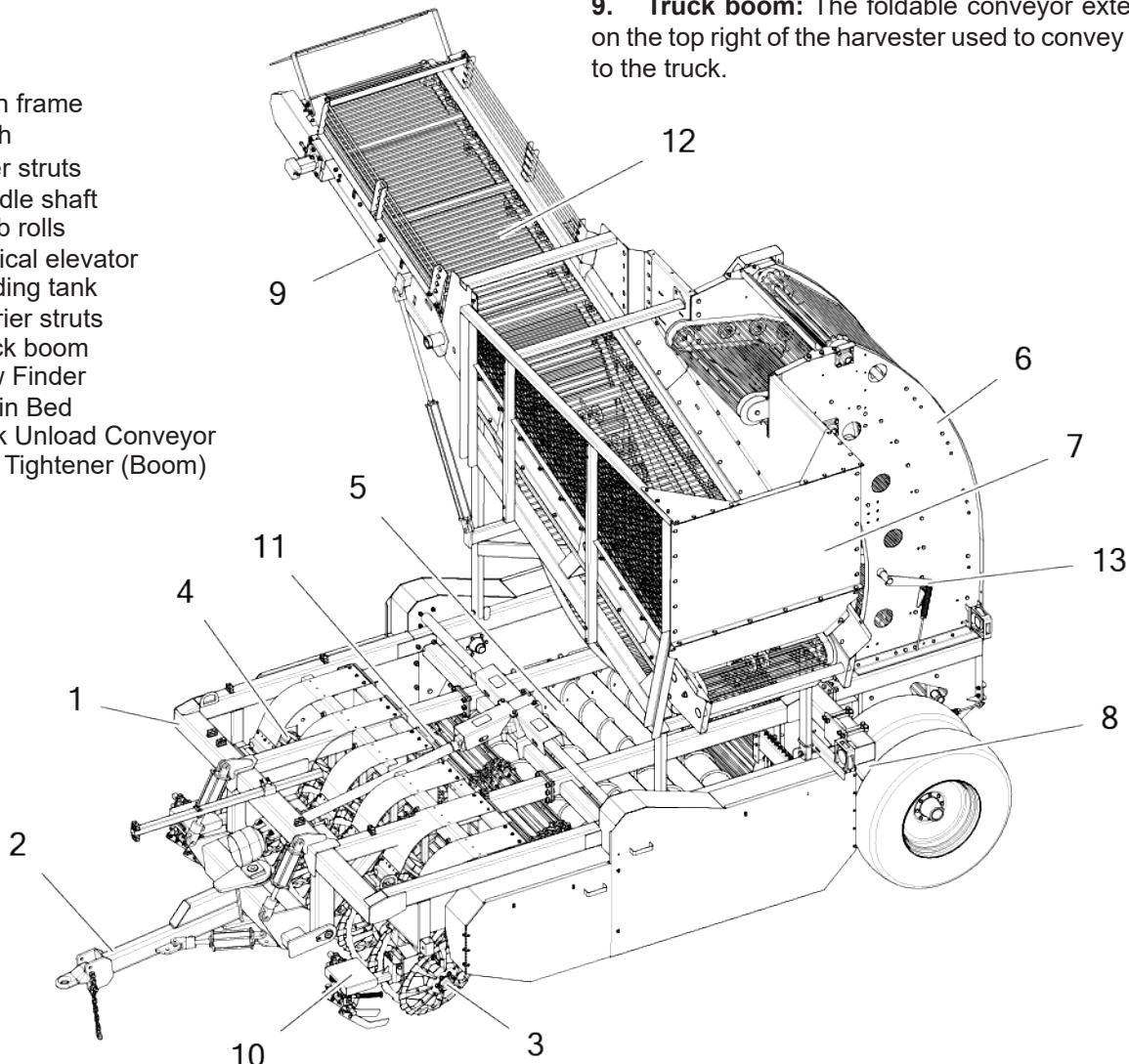


Figure 1. Beet Harvester Components

Operation Continued

10. Row Finder: Keeps the Harvester digger wheels centered on the beets.

11. Bed Chain: Chain that carries beets from lifer wheels to the grab roll bed.

12. Tank Unload Conveyor: Dumps beets into the Truck.

13. Belt Tightener: Keeps tension on belt.

The harvester main frame is supported by four wheels on two adjustable struts at the rear of the harvester, and by the tractor drawbar through the harvester hitch at the front.

The harvester controls the working depth of the lifter wheels through two hydraulic cylinders. The harvester hitch also controls the side to side position of the harvester through the hitch steering cylinder.

The lifter wheel struts are attached to the front tool bar of the main frame.

The grab rolls, main drive components and paddle shaft are attached to the main frame.

The elevator is attached to the center main frame members and the holding tank.

The holding tank is mounted on the main frame.

The Truck boom is mounted on the discharge end of the holding tank.

EQUIPMENT MATCHING

Harvester	Minimum HP
6 ROW 45cm	140 HP Class III
6 ROW 22"	140 HP Class III
6 ROW 30"	180 HP Class IV
8 ROW 22"	180 HP Class IV

Use the above guidelines to select a tractor with adequate power and weight to operate the harvester.

Use tractor manufacturer ASAE HP ratings and tractor class for tractor matching.

TIRE REQUIREMENTS

The loaded beet harvester will transfer 2500 to 3500 lbs. of static weight to the tractor drawbar. Tractor tires must be of adequate capacity to carry the additional load.

See your tractor operator's manual for selecting tires of the proper capacity and the correct air pressure required.

Dual tractor wheels set to the correct row spacing may be used to increase load capacity.

Tractor tire spacing must be adjusted to match the harvester row spacing.

PTO



WARNING

- **Connect PTO driveline directly to tractor PTO shaft. Never use adapter sleeves or adapter shafts. Adapters can cause driveline failures due to incorrect spline or incorrect operating length and result in personal injury or death.**

Tractor must be equipped with a 1000 rpm PTO shaft. The harvester may be equipped with either a 1-3/8"-21 or 1-3/4"-20 spline driveline to match the tractor output shaft without using adapters.

The harvester may be equipped with optional CV driveline.

HITCH REQUIREMENTS

The drawbar length must be adjusted to a minimum of 16" to 18" between the end of the tractor PTO shaft and the center of the hitch pin.

IMPORTANT

- **Fasten support chains so that they support the drawbar equally.**
- **Raise the three-point hitch only high enough to support the drawbar. Do not bend the drawbar or hitch components.**

Operation Continued

HYDRAULIC SYSTEM

The tractor must be equipped with a minimum of three operator controlled remote outlets and one power-beyond circuit or four operator controlled remote outlets on a closed center or pressure/flow compensated hydraulic system.

Each outlet requires a minimum flow of 12-16 GPM at 2000 psi.

On certain tractors using a pressure/flow compensated system, a load sensing line may be required for proper hydraulic system operation. Consult your tractor dealer for the specific requirements of your tractor hydraulic system.

- The tractor remote valve supplies hydraulic power for the depth control/transport cylinders.
- The tractor remote supplies hydraulic power to the Boom lift/lower cylinders or Hydraulic drive motors on Boom Unload Conveyor.
- The tractor remote valve supplies hydraulic power to the row finder override.
- The tractor remote valve or power-beyond circuit supplies hydraulic power for row finder and electric valve that controls Holding Tank Unload Conveyor and slide conveyor hydraulic cylinder.

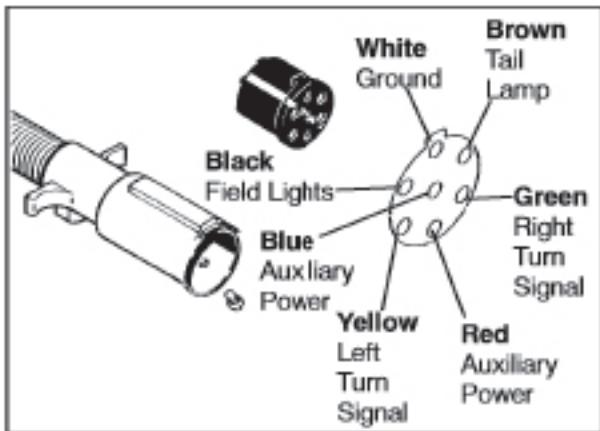


Figure 3. 7-Pin Electrical Connector

ELECTRICAL SYSTEM

The tractor must be equipped with a SAE J560a 7-pin electrical connector. This will provide power for turn signals, warning flashers, and operating power for the optional rear steering selector switch.

The harvester is equipped with warning flashers and turn signals located on each corner. Warning lights must be functional whenever the harvester is transported on public highways.

See your tractor operator's manual for instructions on warning light and turn signal operation.

If warning lights and turn signals do not function correctly, see your Alloway dealer.

TRACTOR BALLAST

The tractor should be equipped with manufacturer's maximum allowable front end ballast for operational and transport stability.

ATTACHING TRACTOR TO THE HARVESTER

Make sure there are no bystanders between tractor and harvester.

Carefully back up, until the Pin on the tractor is directly in line with the harvester clevis ring.

Stop engine, set parking brake, wait for all moving parts to stop and remove ignition key before dismounting.

Clean the hydraulic couplers and fittings to avoid oil contamination.

Connect the hydraulic hoses which control the front hitch cylinders to the tractor. Connect these hoses so that moving the control lever forward lowers the harvester (raises the hitch tongue) and moving the control lever rearward raises the harvester (lowers the hitch tongue).

Attach the safety chain to the drawbar support of the tractor. Attach Hydraulic Lines. Insert the 7-pin male harvester electrical cable into the tractor female connector.

Operation Continued

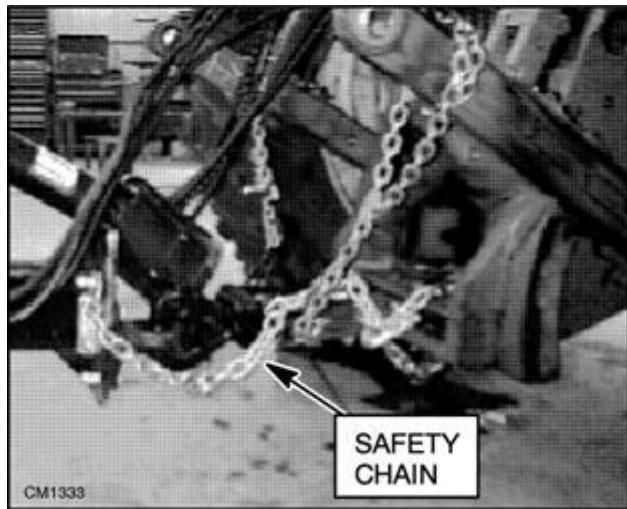


Figure 4. Lock Pin & Safety Chain

The unloader conveyer motor is operated by tractor remote valve. Connect the hoses originating at the harvester so that moving lever forward causes the boom conveyor motor to run forward.

The Rear Elevator conveyer motor is operated by tractor remote valve. Connect the hoses originating at the harvester so that moving lever forward causes the beets to run into the tank.

Check the harvester PTO shaft for smooth telescoping action. Attach the harvester PTO shaft to the tractor PTO shaft. Make sure the locking collar is fully engaged in the lock groove of the tractor PTO.

Hydraulically raise front of the harvester, stop engine, set park brake, wait for all moving parts to stop and remove ignition key before dismounting.

Install transport locks on depth control cylinders.

UNHOOKING THE TRACTOR FROM THE HARVESTER

Locate the harvester on a hard level surface. Make sure area is free of bystanders.

Lower machine with the tractor hydraulics from tractor seat, until machine is resting in a level and stable position on the lifter wheels. Planks or blocking of a suitable size may be used to prevent the harvester from sinking into the soil or damaging the floor surface.

Move boom locks out of cradled position and fully lower the truck boom. Stop the engine, set parking brake, remove ignition key and wait for all moving parts to stop before dismounting the tractor. Block the rear wheels of the harvester to prevent the harvester from rolling. Disconnect PTO shaft from tractor. Disconnect the safety tow chain. Disconnect the electrical cable from the tractor and store in a safe and secure position on the hitch. Remove Pin from hitch.

Lower the hitch to the full extension of the lift cylinders. Stop the engine, release hydraulic pressure in all remotes, set parking brake, remove ignition key and wait for all moving parts to stop before dismounting the tractor.

Disconnect all hydraulic lines and the rear steering electrical connector.

FIELD OPERATION

Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator.

In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel involved in the operation, transport, maintenance and storage of equipment.

It has been said "*The best safety device is an informed, careful operator.*" We ask you to be that kind of an operator.

The Alloway harvester will give best performance only if it is properly set for individual field conditions. These setting requirements may change with changes in soil moisture, density and beet varieties. The following explains the operation and adjustment of the machine. Check with your dealer or Alloway for special conditions.

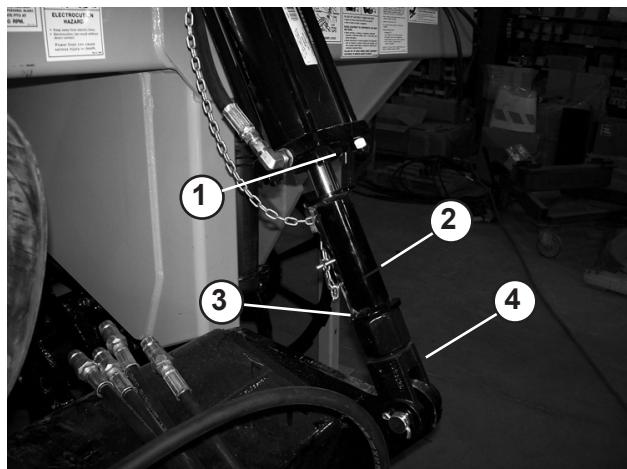
RAISING AND LOWERING THE HARVESTER

The harvester lift cylinders are attached to the harvester tongue and are used to raise the front of the harvester out of the ground. The lift cylinders are connected to tractor hydraulic outlet.

Harvester hydraulic connections should be made so that moving tractor control lever forward lowers the harvester and moving lever rearward raises the harvester.

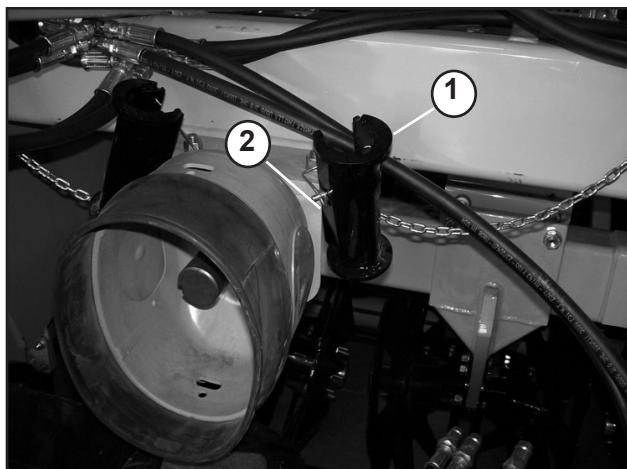
Transport locks are included and must be installed whenever the harvester is attached to the tractor but not involved in digging operations.

transport lock to hold lock in place on cylinder rod. Install transport lock for both lift cylinders



1. Front Lift Cylinder	2. Transport Lock
3. Lock Pin	4. Adjustable Depth Stop

Figure 9. Transport Locks Installed



1. Transport Lock	2. Lock Pin
-------------------	-------------

Figure 10. Transport Lock Storage Position

To install transport locks, depth stops must be adjusted equally. Raise harvester completely. Set tractor park brake, turn off tractor engine, remove key and exit tractor cab. Working from beside the lift cylinders, remove transport lock from storage bracket and install transport lock over cylinder rod. Install lock pin in

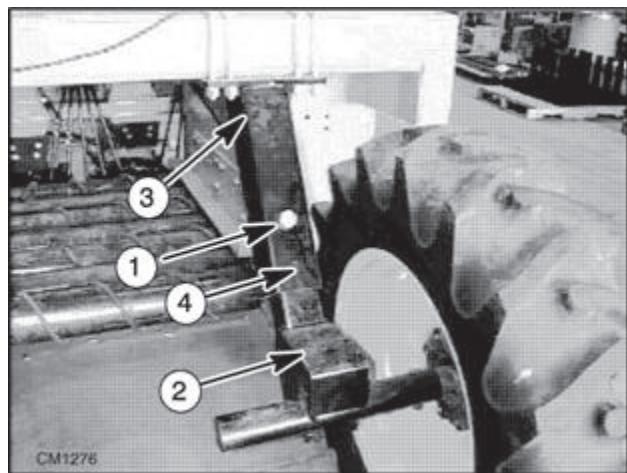
Field Operation Continued

Transport locks should be attached to the storage brackets whenever locks are removed for digging operation. Replace any lost or damaged transport lock component immediately. Recommended operating depth is between 2" and 3" measured from cleared undisturbed soil to the bottom of the cut trench behind the harvester.

IMPORTANT

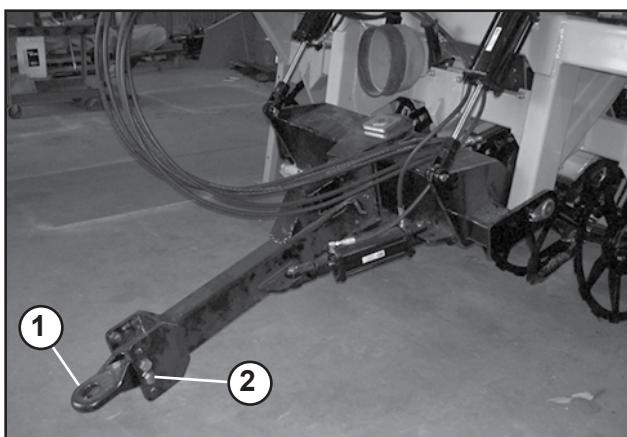
- When operating in rocky conditions, the lift circuit should be placed in "float" position to allow the harvester to raise over rocks without lifting the tractor.

With lifter wheels at the desired operating depth, the machine should be level front-to-rear and side-to-side. The rear carrier struts are individually adjustable to level the machine.



1. Leveling Adjustment Bolt
2. Spindle Housing
3. Support Strut
4. Leveling Adjustment Holes

Figure 12. Standard Rear Strut (Wheel Removed)



1. Adjustable Hitch Ring
2. Hitch Adjustment Bolts

Figure 13. Hitch Ring Adjustment

Manually adjustable rear struts are supplied on harvesters.

Additional leveling adjustment is possible by moving the hitch ring attached to the harvester tongue.

Adjust Chain Bed spacing between lifter wheels and Chain Bed by adjusting Pivot Bracket with adjusting bolt. Try to keep a minimum distance of approximately 1/2" between lifter wheels and Chain Bed.

Cleaning capacity of the harvester can be affected by raising or lowering the adjustable grabroll bed. The front of the side sheet may be lowered (This allows beets more time on grabroll bed for better cleaning.). The front of the side may be raised if less cleaning is needed.

RAISE TRUCK BOOM TO OPERATING POSITION

The truck boom must be raised from the lowered transport position and locked in the raised operating position before operating the truck boom conveyor. The truck boom is raised into position with single acting cylinders and is lowered to rest on boom locks during operation.



WARNING

- Truck boom lock must be engaged when truck boom is in operating position. Do not operate unloader conveyor unless boom lock is engaged and in good repair. Hydraulic system leak down, hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.

IMPORTANT

- Operate unloader conveyor only with truck boom fully raised and with boom lock engaged. Hydraulic pressure on boom cylinders must be relieved and hydraulic selector valve moved to the "in" position (row finder override function). Make sure all people and equipment are clear of the boom area.

Move the hydraulic selector valve to the "out" position to activate the truck boom circuit.

Field Operation Continued



Figure 14. Boom Lock Engaged

Using tractor remote lever #3, move lever rearward to retract the boom cylinders. Raise the truck boom completely until the boom locks drop into place as shown in Figure 14. Move control lever #3 forward to lower the boom to rest on the boom locks.

Stop the engine, set parking brake, remove ignition key and wait for all moving parts to stop before dismounting the tractor. Move the hydraulic selector valve to the "in" position to activate the harvester truck boom hydraulic motors.

LOWER TRUCK BOOM TO TRANSPORT POSITION

Make sure all people and equipment are clear of the boom area.

The hydraulic selector valve must be in the "out" position to activate the truck boom circuit.

Using tractor remote lever #3, move lever rearward to retract the boom cylinders. This will raise the truck boom completely and remove the boom weight from the boom locks.

Stop the engine, set parking brake, remove ignition key and wait for all moving parts to stop before dismounting the tractor.

Stand behind truck boom and pull the lock pin handle to position the lock pin in raised position as shown in Figure 15. This releases the boom lock so the truck boom can be lowered. Move tractor control lever forward and fully lower the truck boom.



Figure 15. Boom Lock Released



Figure 16. Truck Boom in Lowered Transport Position

HOLDING TANK/TRUCK BOOM, LOAD TANK

To load the tank while lifting beets: push the tractor hydraulic control lever past neutral.

Field Operation Continued

TRUCK BOOM & TANK UNLOAD

IMPORTANT

- Operate unloader conveyer only with truck boom fully raised and with boom lock in place. Hydraulic pressure on boom cylinders must be relieved. Make sure all people and equipment are clear of the boom area.

The holding tank serves as temporary storage for beets when opening fields, turning on the head lands or changing trucks.

TRUCK BOOM MOTOR SPEED, ADJUST

Adjust truck boom motor speed using the tractor remote. Start tractor and activate truck boom motor. Observe truck boom unloading speed.

ROW FINDER

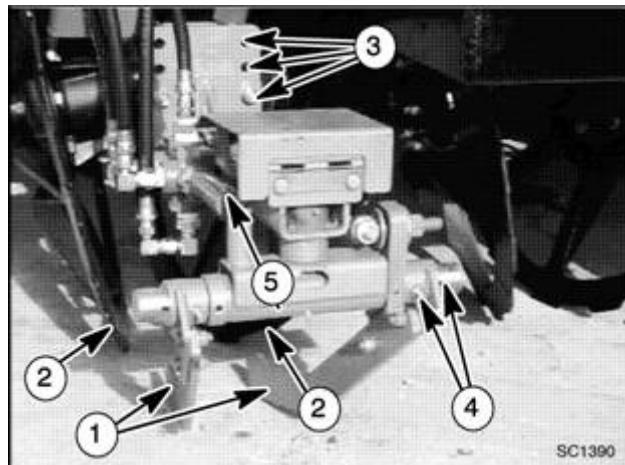
Automatic steering by the row finder requires constant hydraulic potential at the automatic steering valve. Hydraulic power for the row finder is provided by the tractor power-beyond kit or tractor remote #4 set for continuous operation.

Make sure the row finder assembly is level and the feeler arms are aligned with the center of the lifter wheels on the finder row.

With the harvester at the set operating depth, adjust the row finder feeler arms to run as lightly on the soil as possible. Adjust the width of the feeler arms to the approximate diameter of the beets at ground level. Adjust the length of the valve control rod to center the feeler arms on the lifter wheel strut. Adjust the auxiliary centering springs to the same position as the centering spring in the row finder valve spool. It is generally more productive to adjust the row finder on level ground in the land and not on the head land.

IMPORTANT

- Before backing up, raise harvester completely. The row finder may be damaged if it is allowed to contact the ground while



1. Feeler Arms	2. Lifter Wheels
3. Row Finder Height Adjustment	4. Feeler Arm with Adjustment
5. Steering Control Rod	

Figure 18. Row Finder

backing.

ROW FINDER OVERRIDE

A row finder override control is powered by tractor control valve. This provides manual control of the steering system and can be used to override the row finder.

To operate the row finder override control: activate tractor control lever rearward to move the harvester left, and forward to move the harvester right.

Field Operation Continued

PTO ENGAGEMENT

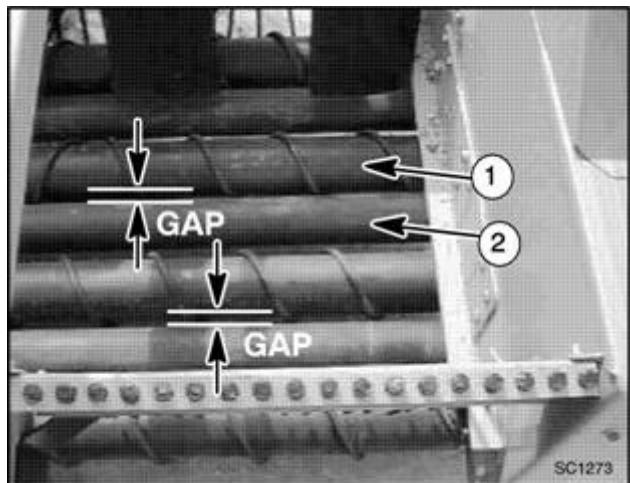
Set the tractor throttle to idle before engaging or disengaging the PTO.



WARNING

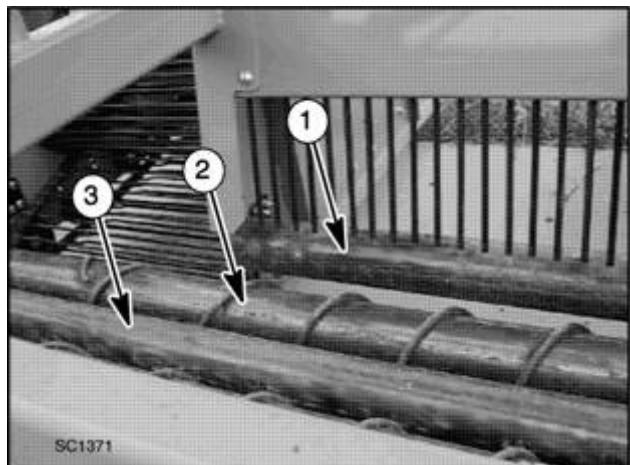
- Connect PTO driveline directly to tractor PTO shaft. Never use adapter sleeves or adapter shafts. Adapters can cause driveline failures due to incorrect spline or incorrect operating length and result in personal injury or death.

GRAB ROLLS



1. Spiral Roll (Fixed) 2. Smooth Roll (Adjustable)

Figure 21. Grab Roll Gap



1. Stub Roll (Optional) 2. Rear Spiral Roll
3. Smooth Roll

Figure 22. Stub Roll (Optional)

The grab roll bed is a series of counter-rotating roll pairs which help to clean the beets and move them to the elevator. The gap between roll pairs is adjustable for different cleaning requirements.

The grab roll bed is equipped with a system of cushions to help absorb shocks and permit small stones or other debris to pass between the grab rolls.

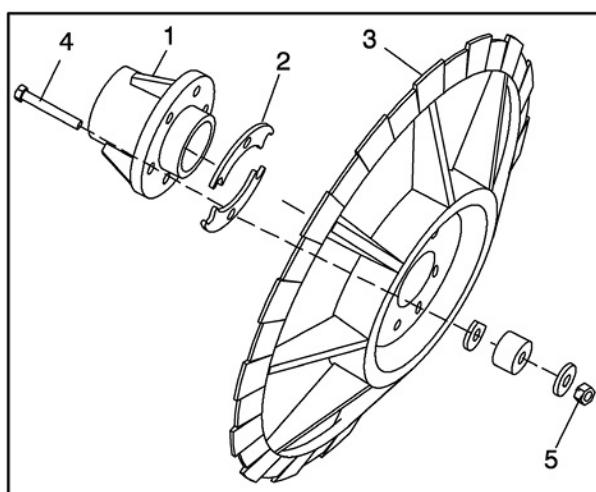
It is important to have an even space on the left and right sides of the harvester between the pairs of grab rolls; however, the individual pairs can have different gaps to accommodate conditions. For instance a wide gap may be helpful on the first pair of rollers to get rid of a lot of soil, and a narrow gap on the last pair may save tails. Spiral rolls are fixed in the grab roll bed. In 7-roll harvesters, the rear spiral roll has no paired smooth roll. Optional fixed-position rear stub rolls are available.

GRAB ROLL BED RODS

The grab roll rods are located at the rear of the roll bed, and may be removed for access to the bed.

LIFTER WHEELS

The pinch point width should be uniform across all rows of the harvester. The pinch point width can be adjusted by adding or removing pairs of spacers at each lifter wheel.



1. Hub 2. Spacer (Installed in pairs)
3. Lifter Wheel 4. Wheel Bolt
5. Wheel Nut

Figure 23. Install Lifter Wheel Spacers

Field Operation Continued

Raise harvester and install transport locks (see Blocking Method, page 32).

To remove or add spacers, loosen lifter wheel nuts and remove the bolt retaining each spacer (one bolt per spacer). Install or remove spacers as required to set the desired width and re-tighten the wheel nuts to 100 lb-ft. (without wheel cushions). With wheel cushions, tighten wheel nuts to compress wheel spring assemblies 1/4" from their free height.

Spacers must be installed as pairs. Multiple spacer pairs may be used at each wheel to increase the pinch point width.

It is not necessary to remove the lifter wheels when adding or removing spacers.

WHEEL SCRAPERS

Wheel scraper blades are adjustable for digging conditions. To adjust scraper blades, loosen retaining bolts and slide scraper blades to place the scraper closer to the wheel or away from the wheel. Retighten scraper retaining bolts.

WHEEL FILLERS

Under certain digging conditions, beets may fall through the spokes of the lifter wheels during operation. This condition may require the installation of filler spokes on the lifter wheels. To install fillers, remove two wheel nuts (opposite from each other) and install wheel filler. Retighten wheel retaining nuts.

FLEXING LIFTER STRUTS (Optional)

Flex struts are available for the lifter wheel struts for operation in rocky conditions.

Flex cushions on the lifter wheels will reduce damage to the lifter wheels in rocky conditions.

When operating in rocky conditions, the lift circuit should be run in "float" to allow the harvester to raise over rocks without lifting the tractor.

IMPORTANT

- When operating in rocky conditions, the lift circuit should be placed in "float" position to allow the harvester to raise over rocks without lifting the tractor.

PADDLE SHAFT

The paddle shaft provides a set of rotating paddles between each set of lifter wheels. Beets are moved onto the chain bed by the rotating paddles. The height of the paddle shaft may be raised or lowered to obtain the correct clearance for the harvesting conditions. With flex struts installed, the paddle shaft must be placed in the uppermost position to maintain adequate clearance between the paddle shaft and the lifter wheels. Keep front and rear paddle deflectors in place and in good condition; replace if damaged or missing.

TRUCK BOOM CONVEYER CHAIN

IMPORTANT

- Do not operate the unloader conveyer with the truck boom in the transport position, damage to the conveyer or drives may result.

Tighten boom conveyor chain using adjusting screws on front and back side of boom. Tighten until chain does not slip over drive sprockets. Tighten evenly.



Figure 23. Boom Conveyer Chain Tensioner

Field Operation Continued

VERTICAL ELEVATOR

A dual chain elevator moves the beets from the grab roll bed to the holding tank. A combination of straight and offset rods is used in the elevator to provide a pocket for carrying beets. All machines are equipped with 1:1 speeds for the vertical elevator chains. If scrubbing action is desired, the speed of the outside chain can be increased by replacing the 40 tooth "driven" sprocket with a 34 tooth sprocket. This will give a scrub ratio of approximately 15% between the two vertical elevator chains.

As the elevator fills with beets, spring loaded tensioner arms allow the chains to operate correctly. Tension adjustment springs for the outer chain are located on the both sides of the elevator. Tension adjustment spring for the inner chain is located on the right side of the elevator.

The vertical elevator is driven from the self contained hydraulic system or by 4th remote on tractor (optional). To speed up rear elevator use flow control. For more speed and power increase flow.

TRANSPORTING

Fully lower the elevator boom as instructed in "Truck Boom Lower".

Raise the machine and insert the transport locks on the hitch lift cylinders.

Transport locks must be installed whenever the harvester is transported.

Replace any lost or damaged transport lock component immediately.

Do not transport the harvester with beets in the holding tank.

Make sure reflectors, lights and the SMV sign are clean and clearly visible to other traffic.

Do not allow riders.

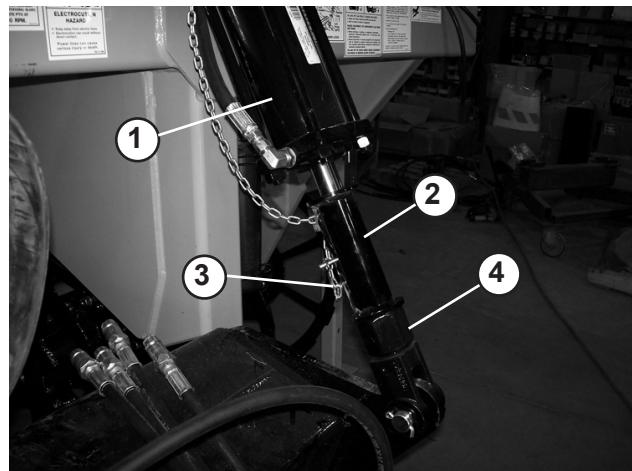
Use hazard flashers on the tractor and harvester when transporting.

Never exceed safe travel speed, slow down when making turns and traveling on rough roads or shoulders.

Only use a tractor of the recommended size and weight for transporting.

Lock foot brake pedals for even application during road travel.

Do not exceed 10 mph transport speed.



- 1. Lift Cylinder
- 2. Transport Lock
- 3. Lock Pin
- 4. Adjustable Depth Stop

Figure 24. Transport Locks Installed

STORAGE

WARNING

- For storage, disengage tractor PTO power to harvester, lower front lift cylinders so that lifter wheels are on the ground, lower truck boom, lower 3-point hitch. Operate tractor valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt. Remove driveline from tractor PTO. Chock (block) front and rear of harvester wheels.

CAUTION

- Keep children and bystanders away from storage area.

After the season's use, the machine should be thoroughly inspected and prepared for storage. Repair or replace any worn or damaged components to prevent any unnecessary down time at the start of the next season.

Field Operation Continued

To insure a long, trouble free life, this procedure should be followed when preparing the unit for storage.

Clear the area of bystanders.

Thoroughly wash the machine using a pressure washer to remove all dirt, mud, debris or residue.

Check the rotating components for damage or entangled material. Repair or replace damaged parts. Remove any entangled material.

Inspect all hydraulic hoses, fittings, lines and couplers. Tighten any loose fittings. Replace any hose that is cut, nicked or abraded or is separating from the crimped end of the fitting.

Change the oil in the gearbox.

Lubricate all grease fittings. Make sure that all grease cavities have been filled with grease to remove any water residue from the washings.

Touch up all paint nicks and scratches to prevent rusting.

Move to storage area.

Select an area that is dry, level and free of debris. Unhook from tractor.

Place PTO shaft on hitch to keep PTO off the ground.

Store the machine in an area away from human activity.

Do not allow children to play on or around the stored machine.

NOTES

OWNER SERVICE

Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator.

In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel involved in the operation, transport, maintenance and storage of equipment.

It has been said *“The best safety device is an informed, careful operator.”* We ask you to be that kind of an operator.

The information in this section is written for operators who possess basic mechanical skills. Should you need help, your dealer has trained service technicians available. For your protection, read and follow all safety information in this manual.

- Before dismounting tractor, disengage tractor PTO power to implement, lower front lift cylinders so that lifter wheels are on the ground. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt.
- Before performing any service or maintenance, disengage power to implement, lower front lift cylinders so that lifter wheels are on the ground, lower truck boom, lower 3-point hitch. Operate valve control levers to release any hydraulic pressure. Stop engine, set parking brake, remove key and unfasten seat belt. Disconnect driveline from tractor PTO. Chock (block) front and rear of implement wheels.
- Before working underneath a raised implement, read and follow all operator's manual instructions and safety rules. Implement must be attached to tractor, lift cylinder locks must be installed, and lift cylinders lowered against locks. Hydraulic system leak down, hydraulic system failures, or movement of control levers can cause equipment to drop unexpectedly and cause severe injury or death.



WARNING

- Never perform service or maintenance with engine running.
- Do not disconnect hydraulic lines until engine is stopped, tractor is properly secured, equipment and all components are lowered to the ground, and system pressure is released by operating all valve control levers.
- Keep all persons away from operator control area while performing adjustments, service or maintenance.



CAUTION

- Always wear relatively tight and belted clothing to avoid entanglement in moving parts. Wear sturdy, rough-soled work shoes and protective equipment for eyes, hair, hands, hearing and head.



WARNING

- Never go under equipment lowered to the ground or raised, unless it is properly blocked and secured. Never place any part of the body under equipment or between moveable parts even when the engine has been turned off. Hydraulic system leak down, hydraulic system failures, mechanical failures or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death. Follow Operator's Manual instructions for working underneath and blocking requirements, or have work done by a qualified dealer.

Owner Service Continued

BLOCKING METHOD FOR LIFTER WHEELS AND ROW FINDER SERVICE

The only approved blocking devices for this harvester are the cylinder transport locks supplied with the unit. The harvester must be located on a hard level surface and the transport locks properly installed. Do not use a transport lock or retaining pin which is bent or damaged. Replace any damaged or lost transport lock component immediately.

Do not work underneath harvester unless it is properly attached to the tractor and blocked securely. When properly attached, the unit will be anchored to minimize front-to-rear movement.

Before blocking, ensure harvester is securely attached to tractor. Truck boom must be fully lowered into transport position. Do not work on harvester with truck boom in any intermediate position. Raise harvester completely, set park brake, shut off engine, remove key, and chock tractor wheels. Without going under the harvester, carefully install transport locks and retaining pins. Start tractor and lower harvester onto transport locks. Cylinder depth stops must be set equally before installing transport locks. Disconnect PTO driveline before performing any maintenance on the harvester.

TRUCK BOOM SERVICE



WARNING

- **Before performing any maintenance on the beet harvester, the truck boom must be fully lowered into the transport position. Do not work on harvester with truck boom in any intermediate position. Hydraulic system leak down, hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.**
- **Truck boom lock must be engaged when truck boom is in operating position. Do not operate unloader conveyor unless boom lock is engaged and in good repair. Hydraulic system leak down, hydraulic system failures, mechanical failures, or movement of control levers can cause equipment to drop or rotate unexpectedly and cause severe injury or death.**

Before working on truck boom or any components on the right side of the harvester, the truck boom must be fully lowered into transport position. Do not work on harvester with truck boom in any intermediate position.

LUBRICATION (Figure 26)

Figure 26 shows the lubrication points. The accompanying chart gives the frequency of lubrication in operating hours, based on normal conditions. Severe or unusual conditions may require more frequent lubrication.

Do not let excess grease collect on or around parts, particularly when operating in sandy areas.

Use SAE multi-purpose high temperature grease, or SAE multi-purpose lithium based grease.

Use a lithium grease of No. 2 consistency with a MOLY (molybdenum disulfide) additive for all locations. Be sure to clean fittings thoroughly before attaching grease gun. When applied according to the lubrication chart, one good pump of most guns is sufficient. Do not over grease. Grease the telescoping driveline. Daily lubrication of the PTO slip joint is necessary or damage to U-joints, gearboxes, tractor PTO and/or harvester driveline can result. Close and secure all removable covers and guards before operating harvester.

DAILY SERVICE

Inspect all drive belts for slippage, damage or accumulation of foreign materials. Adjust and clean as necessary.

Inspect all drive chains and adjust as necessary.

Inspect paddle shaft for loose or missing paddles.

Inspect grab roll bed for alignment, spacing, and roll damage. Check that grab roll shock cushions are in good condition.

Inspect the elevator and unloader structures for missing or damaged rollers. Inspect unloader chain slide bars on the tank bottom for damage or wear; replace if necessary.

Owner Service Continued

Inspect hydraulic system for leaking or damaged components. Replace or repair leaking fittings immediately.

Inspect all conveyor chains for loose or missing cross rods. Check the splices on each belted chain, tighten chain as necessary.

Inspect lifter wheels and struts for alignment, loose or missing components, and proper setting.

Check tractor and harvester tire pressure. Service as necessary.

YEARLY SERVICE

Inspect PTO driveline components for wear or damage and repair as necessary.

Inspect all gearboxes for leaks or damage, and repair.

Drain and replace all gearbox lubricant and clean breathers.

Repack lifter wheel bearings and replace any worn or damaged components.

Inspect chain bed for damaged or bent chain and replace if necessary.

Inspect paddle shaft bearings, paddles, and deflectors. Replace as necessary.

Inspect grab rolls for proper alignment, bent rolls, or damaged flighting and replace if necessary. Inspect grab roll drive belts, sheaves and tighteners; repair any damaged components.

Inspect transport cylinder locks; replace any worn or damaged component.

Repack carrier wheel bearings and replace any damaged components.

Owner Service Continued

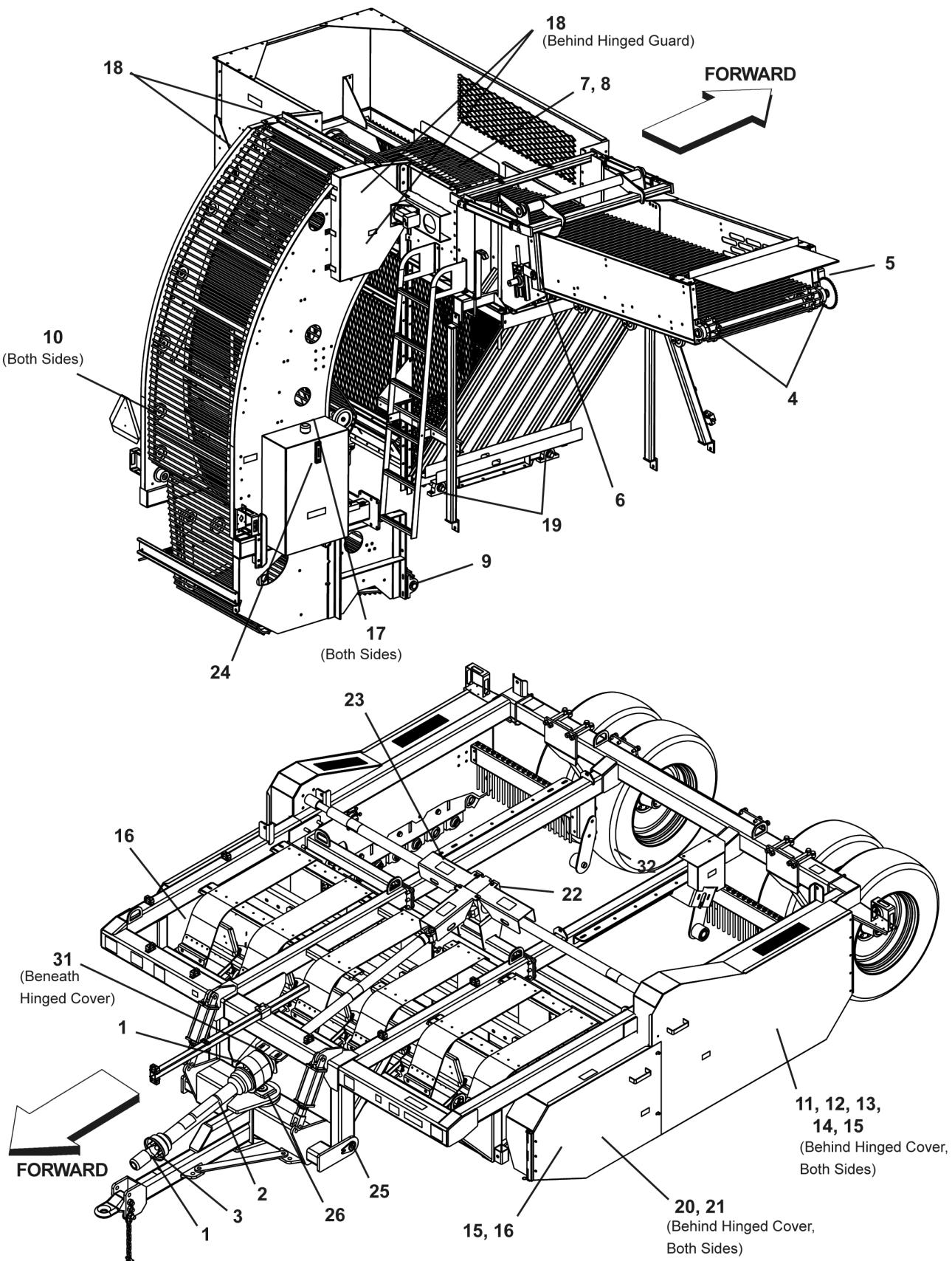


Figure 26. Lubrication Locations

Owner Service Continued

LUBRICATION CHART

Item No.	Description	Frequency	Number
1	U-Joint	24 hrs	2(std) or 3(CV)
2	Slip-Joint	24 hrs	1
3	Cv-Joint (Optional)	24 hrs	1
4	Cross Shaft	24 hrs	2
5	Motor Primary Shaft Bearing	24 hrs	1
6	Truck Boom Belt Tightener Bearings	24 hrs	2
7	Slide Conveyor Takeup Bearing	24 hrs	1
8	Slide Conveyor Shaft Bearings	24 hrs	1
9	Lower Elevator Cross Shaft Bearings	24 hrs	1
10	Elevator Tensioner Pivots	8 hrs	2
11	Grab Roll Bearing	24 hrs	16
12	Cushion Pivot	8 hrs	6
13	Grab Roll Idler Pivots	Yearly	4
14	Grab Roll Drive Bearing	24 hrs	2
15	Paddle Shaft Primary Drive	24 hrs	4
16	Paddle Shaft Bearings	24 hrs	2 or 3
17	Elevator Tensioner Pivots	8 hrs	2
18	Elevator Upper Shafts	24 hrs	4
19	Holding Tank Bearings	24 hrs	1
20	Chain Bed Shaft Bearings	24 hrs	1
21	Idler Pulley Hubs	24 hrs	2
22	Main Gearbox: Check Lube Level	24 hrs	1
23	Main Gearbox Output U-Joints	24 hrs	2
24	Oil Level & Temp Gauge	8 hrs	Check
25	Hitch Lift Pivots	8 hrs	2
26	Hitch Steering Pivots	8 hrs	2
27	Lifter Wheel Bearing	24 hrs	1 (each wheel)
28	Row Finder Pivot Shafts	8 hrs	2
29	Rear Steering Pivot Shaft (Optional)	8 hrs	2
30	Rear Steering Level Adjuster (Optional)	8 hrs	4
31	PTO Carrier Bearing	24 hrs	1
32	Short Grab Roll Bearing	24 hrs	2

MAINTENANCE

Before performing any maintenance or inspections on the harvester, shut off the tractor, set the parking brake, release all hydraulic system pressure with the tractor hydraulic controls and remove the key from the tractor.

GRAB ROLL DRIVE BELT ADJUSTMENT (Figure 28)

Open grab roll side door. Tighten the tension spring adjustment bolt so as to show approximately 1/8" gap between each of the spring coils.

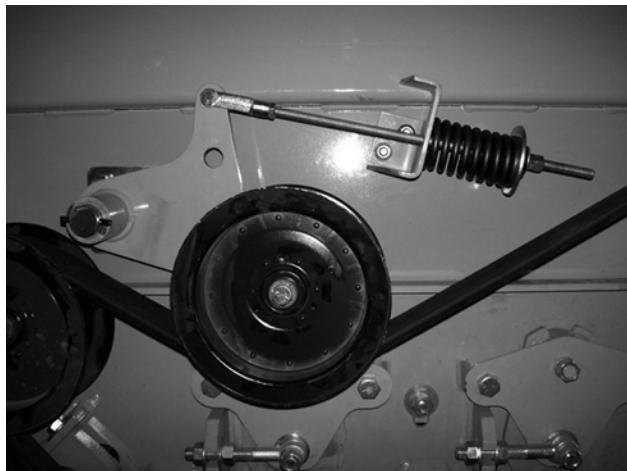


Figure 28. Grab Roll Drive

BELT REPLACEMENT (NEW BELT)

To remove belt, loosen the idler spring.

Install belt over grab roll sheaves as shown in Figure 29.

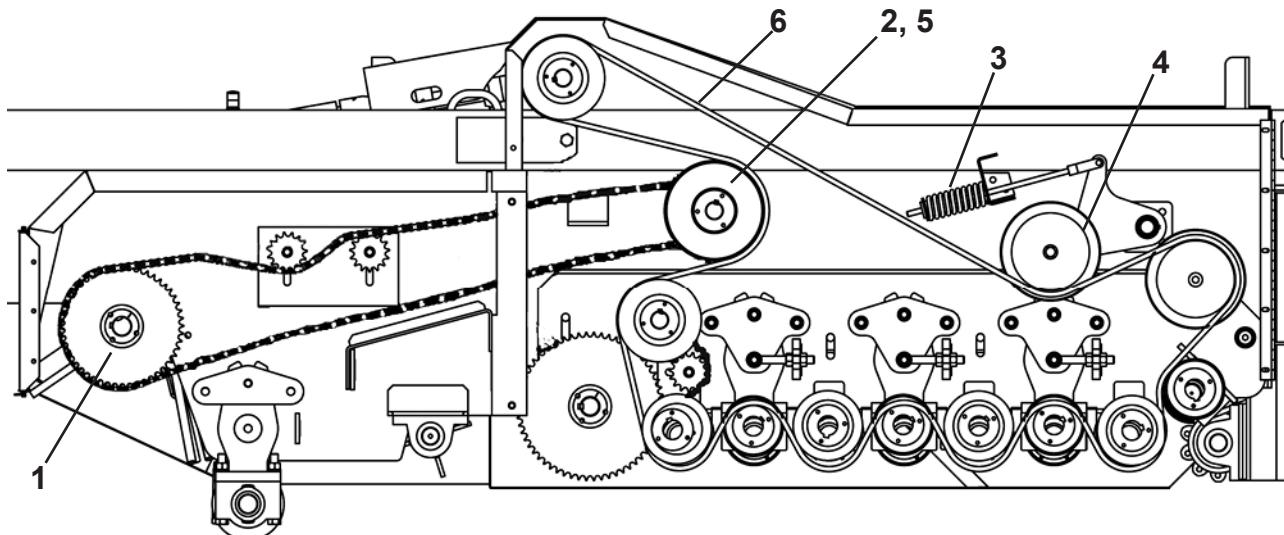
Route belt around drive sheaves and idlers as shown in Figure 31. Do not pry belt over sheaves as damage to the belt may result.

Tighten idler spring until belt does not slip under full load operation. Close and secure grab roll side door.

PADDLE SHAFT, ELEVATOR AND UNLOADER DRIVE CHAINS

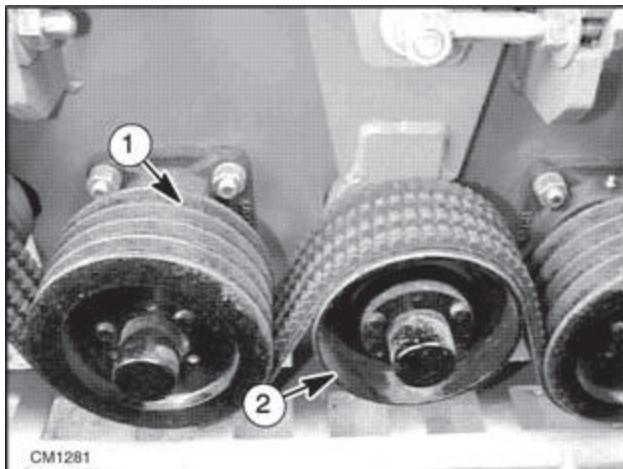
Adjust drive chains by moving idler sprocket until chain has 9mm (3/8") slack in the long side of the chain. Elevator inner and outer chains are set at the factory to run at the same speed. In some conditions scrubbing action may be needed. By running the inner and outer chains at different speeds, beets are "rolled" up the elevator for additional cleaning.

A 34-tooth top sprocket (driven) is available to increase the outer elevator speed and provide a 15% scrubbing ratio between elevator chains.



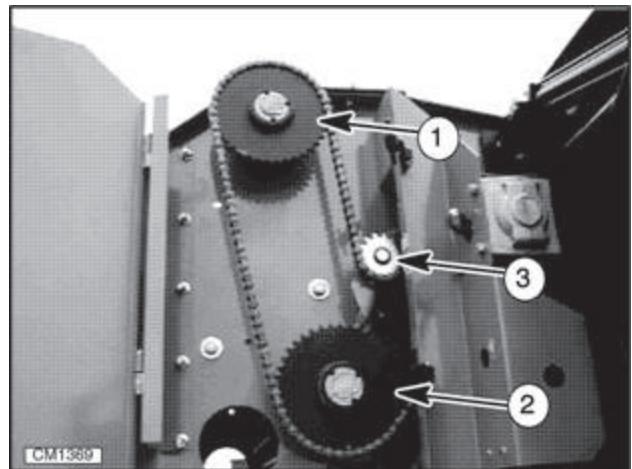
1. Paddle Shaft Primary Drive	2. Grab Roll Drive Sheaves	3. Idler Spring
4. Belt Idler	5. Paddle Shaft Drive Sprocket	6. Grab Roll Drive Belt

Figure 30. Grab Roll Drive



1. Grab Roll Drive Sheave,
Grooved (Fixed Position Spiral Roll)
2. Grab Roll Drive Sheave,
Flat (Adjustable Postion Smooth Roll)

Figure 29. Belt Routing



1. Outer Elevator, "Driven" Sprocket, (40T Std, 34T Opt)
2. Inner Elevator, "Driven" Sprocket (40T)
3. Idler

Figure 33. Elevator Upper Drive

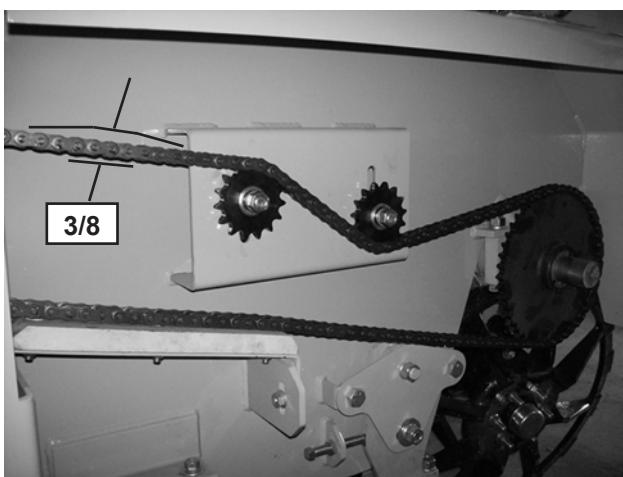


Figure 32. Drive Chain Adjustment

ELEVATOR SPEED ADJUSTMENT (Figure 33)

Working from the holding tank, remove shield and drive chain at top of elevator.

Remove outer elevator chain drive sprocket.

Install appropriate replacement drive sprocket (40-tooth standard or 34-tooth optional scrubber sprocket.)

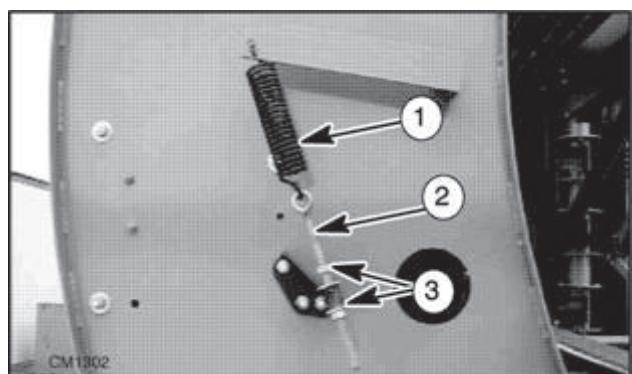
Add or remove chain links to fit new sprockets. Install drive chain and adjust.

Close and fasten drive shield.

Inspect all elevator drive sprockets and rollers for damage or missing components. Missing or damaged rollers will cause chain tension to be incorrect.

Replace any missing or damaged roller.

With the elevator empty of beets and free from accumulated dirt, adjust elevator tightener springs (both sides) so that they have 1/8" gap between coils.



1. Tension Spring
2. Adjustment Eyebolt
3. Jam Nut

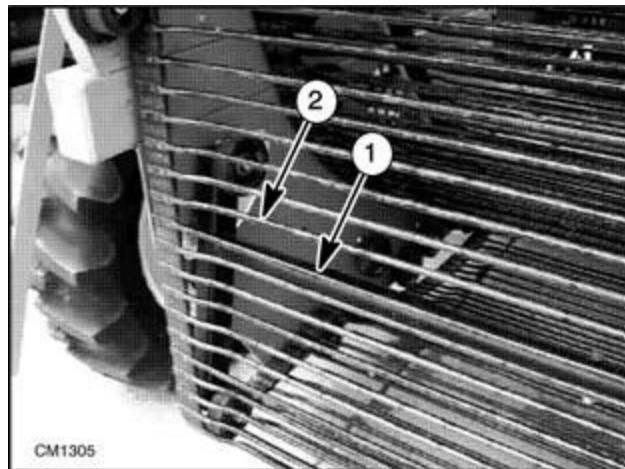
Figure 34. Elevator Tensioner

ELEVATOR CHAIN CROSS ROD REPLACEMENT

Elevator chains have a combination of straight and offset rods which are spaced for maximum performance. Truck boom conveyer has all straight rods. Do not operate the harvester with loose, bent or missing cross rods. Replace rods with the type removed. Install offset rods with the offset away from the beets as shown in Figure 35.

Remove rivets attaching rod to belt. Use caution to avoid damaging the belt.

Attach replacement rod to belt using bolts and threaded back-plate. Make sure offset portion of rod is away from the beets.

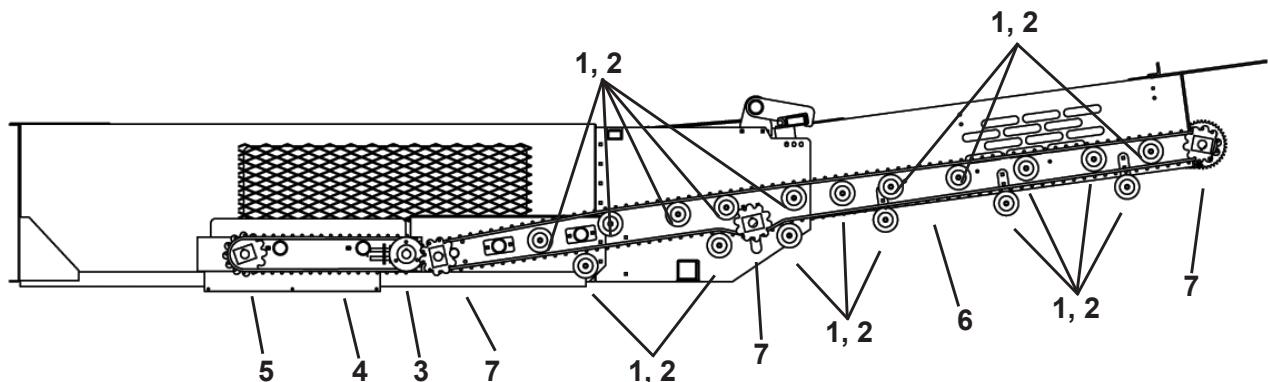


1. Straight Rod (1) 2. Offset Rod (5)

Figure 35. Elevator Cross Rods

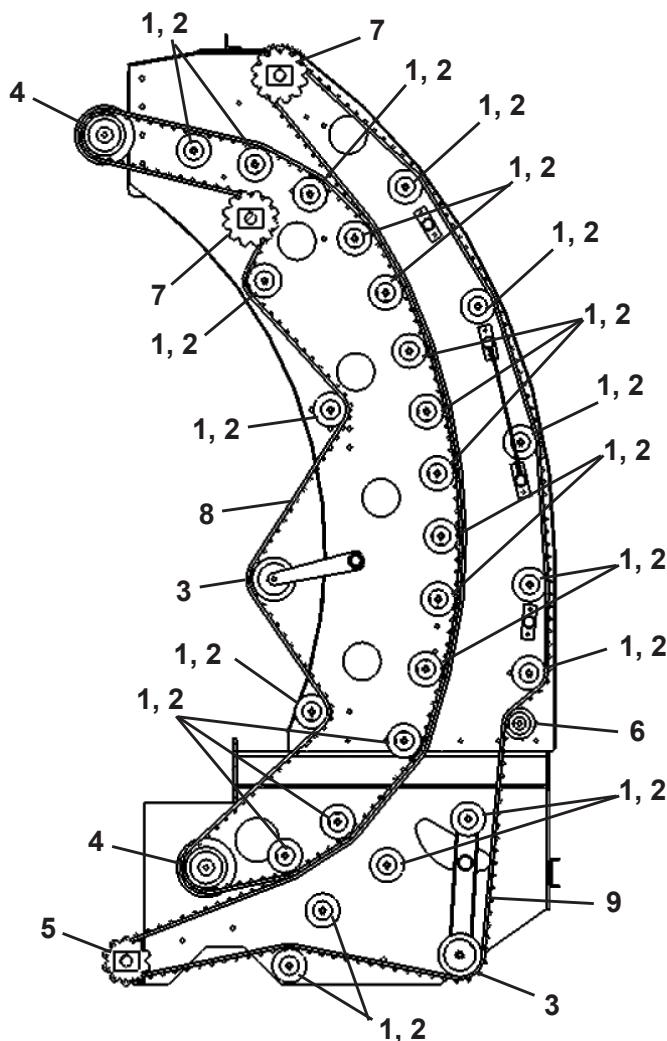
ELEVATOR CHAIN ROUTING AND ROLLER LOCATION (Figure 36 & Figure 37)

Roller location and elevator chain routing must be correct to provide proper tension during operation. Replace any damaged or missing rollers using the correct type specified.



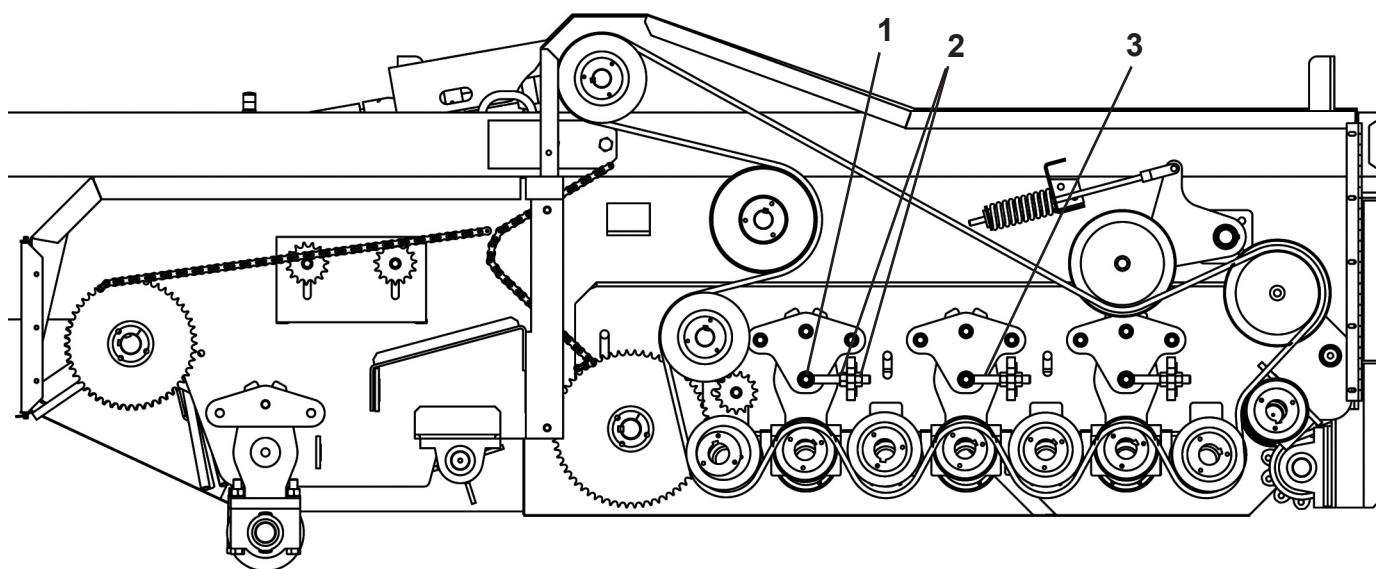
1. 5" Roller	2. Standoff
3. 7" Smooth Sprocket	4. Unloader Conveyer (Belted Chain, Short)
5. 12 Tooth, 50mm, 1-3/4" Sprocket	6. Unloader Conveyer (Belted Chain, Long)
7. 10 Tooth, 50mm, 1-3/4" Sprocket	

Figure 36. Roller Components (Boom - Tank Bottom)



1. 5" Roller	2. Standoff
3. 7" Smooth Sprocket	4. 6" Nose Roller
5. 10 Tooth, 50mm, 1-3/4" Sprocket	6. 5" Flanged Roller
7. 12 Tooth, 50mm, 1-3/4" Sprocket	8. Inner Chain (Belted)
9. Outer Chain (Belted)	

Figure 37. Roller Components (Elevator)



1. Pivot Bolts	2. Jam Nuts	3. Eye-Bolts
----------------	-------------	--------------

Figure 38. Grab Roll Adjustment

HOLDING TANK CHAIN GLIDES

Replaceable glides in the tank bottom provide wear surfaces for the unloader conveyer chain.

Remove worn or damaged glides and install replacement glides using new hardware.

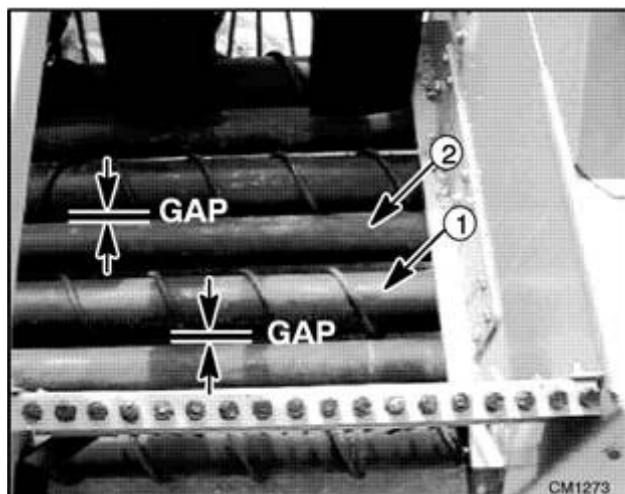
BED CHAIN ADJUSTMENT

To adjust bed chain open front door (both sides). Loosen center bolt in Pivot Bracket. Loosen Adjusting Bolt, adjust Bed Chain to allow 1/2" gap between Bed Chain and lifter wheels. Retighten Hardware.

GRAB ROLL ADJUSTMENT (Figure 38 and Figure 39)

Before working on any components on the right side of the harvester, the truck boom must be fully lowered into transport position with hydraulic pressure relieved or locked in unload position with boom locks installed. Do not work on harvester with truck boom in any intermediate position.

It is important to have an even space on the left and right sides of the harvester between the pairs of grab rolls; however, the individual pairs can have different gaps to accommodate conditions. For instance a wide gap may be helpful on the first pair of rolls to get rid of a lot of soil, and a narrow gap on the last pair may save tails. Spiral rolls are fixed in the grab roll bed.



1. Smooth Roll (Adjustable)
2. Spiral Roll (Fixed)

Figure 39. Grab Roll Gap

Open grab roll drive shields and secure. Loosen the 3/4" nut at the pivot point of the pivot arm bearing holder.

Loosen both 3/4" nuts on the eyebolt and move the smooth roll bearing housing to adjust the gap between the paired rollers. Adjust both sides of each roll pair to the same gap. When all roll pairs are adjusted to the desired gap, tighten all bolts to specifications in Bolt Torque Chart.

Check grab roll drive belt tension and adjust if necessary. (See Grab Roll Drive Belt.)

GRAB ROLL CUSHIONS (REPLACE)

The grab roll bed is equipped with a system of cushions to help absorb shocks and permit small stones or other debris to pass between the paired grab rolls. Each adjustable roll swing arm has a cushion bushing to provide limited roll movement.

Before working on any components on the right side of the harvester, the truck boom must be fully lowered into transport position with hydraulic pressure relieved or locked in unload position with boom locks installed. Do not work on harvester with truck boom in any intermediate position.

Open grab roll drive shields and secure. Loosen or remove grab roll drive belt.

Remove roll adjustment eyebolts. Remove retaining plate.

Remove and replace grab roll cushions.

Reinstall retaining plate, nuts and eyebolts. Tighten nuts to 100 lbs-ft.

Adjust grab roll gap as described in Grab Roll Adjust.

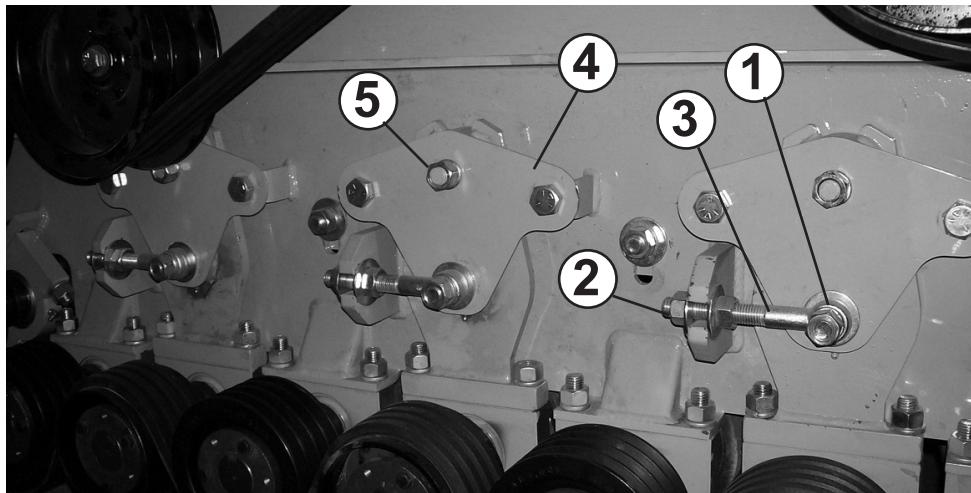
Tighten remaining bolts to specifications in Bolt Torque Chart.

Replace grab roll drive belt.

Close grab roll drive shield and secure for operation.

LIFTER STRUT ADJUSTMENT

Lifter struts should be adjusted to match the row spacing of the beets being harvested. When struts are moved, paddles must be adjusted to prevent



- 1. Pivot Bolts
- 2. Jam Nuts
- 3. Eye-Bolts
- 4. Tie Bar
- 5. Cushion Retaining Bolts

Figure 40. Grab Roll Cushions

contact between paddles and lifter wheels.

Raise harvester and install transport locks (See Blocking Method).

Loosen strut mounting bolts. Slide strut to new location and tighten evenly. When moving strut, it may be necessary to loosen paddle support on paddle shaft to allow strut to be moved.

Measure to confirm correct row spacing and tighten to specifications in Bolt Torque Chart, page 13 (standard struts). Tighten optional flex strut cushion bolts to 100 lbs./ft.

Adjust paddles and paddle shaft (see Paddle Shaft Adjustment, page 42).

LIFTER WHEEL SPACERS

Harvesting small beets may require the use of optional fillers to prevent beets from being lost through lifter wheel spokes.

Raise harvester and install transport locks.

Remove two opposite wheel nuts from each lifter wheel.

Attach wheel fillers to the lifter wheel with a filler rod between each wheel spoke.

Re-install wheel nuts and tighten to specifications in Bolt Torque Chart.

The pinch point width should be uniform across all rows of the harvester. The pinch point width can be adjusted by adding or removing pairs of spacers at each lifter wheel.

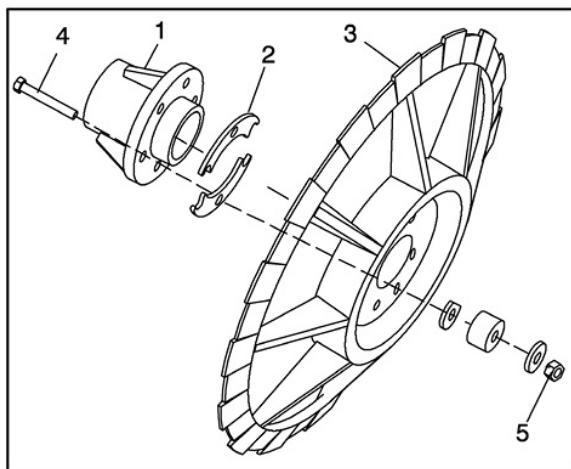
Raise harvester and install transport locks (see Blocking Method).

To remove or add spacers, loosen lifter wheel nuts and remove the bolt retaining each spacer (one bolt per spacer). Install or remove spacers as required to set the desired width and re-tighten the wheel nuts to 100 lb-ft.

Spacers must be installed as pairs. Multiple spacer pairs may be used at each wheel to increase the pinch point width. It is not necessary to remove the lifter wheels when adding or removing spacers.

PADDLE SHAFT ADJUSTMENT

The paddle shaft may be adjusted to provide proper movement of beets onto the grab roll bed. Paddle assemblies are adjustable side-to-side to maintain an equal gap between lifter wheels. The paddle shaft may be adjusted vertically to move paddles closer to the lifter wheels. The paddle assemblies must be adjusted after any movement of lifter wheels or struts. When using flex struts, paddle shaft must be raised to the uppermost position so that wheels cannot contact paddle shaft when strut is moved rearward by contact with a rock.



1. Hub
2. Spacer (Installed in pairs)
3. Lifter Wheel
4. Wheel Bolt
5. Wheel Nut

Figure 41. Install Lifter Wheel Spacers

Raise harvester and install transport locks (see Blocking Method, page 28). Loosen paddle assemblies on paddle shaft and adjust so that each paddle is centered between the lifter wheels.

Tighten paddle assembly bolts to specifications in Bolt Torque Chart, page 15.

Loosen paddle shaft bearing housings and lift or lower shaft to provide 2-1/2" clearance between paddle shaft and lifter wheels. With flex struts installed, paddle shaft must be placed in the uppermost position. Clearance must be at least 2-1/2" to allow for strut movement.

Tighten paddle shaft bearing housings to specifications in Bolt Torque Chart, page 15.

ELECTRICAL SYSTEM

The harvester is equipped with a SAE J560a 7-pin electrical connector. This provides power for turn signals, warning flashers, row finder override, boom fold selector switch, and optional rear steering switch.

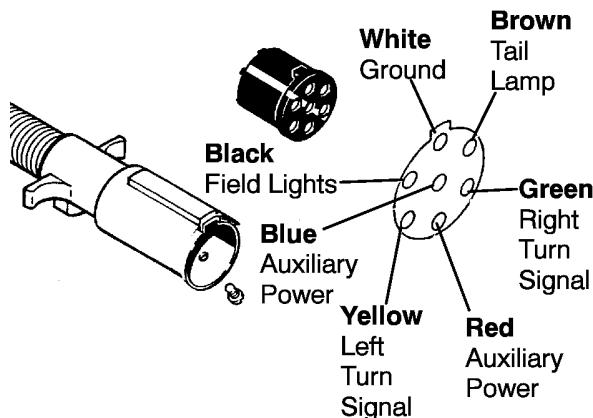


Figure 45. 7-Pin Electrical Connector

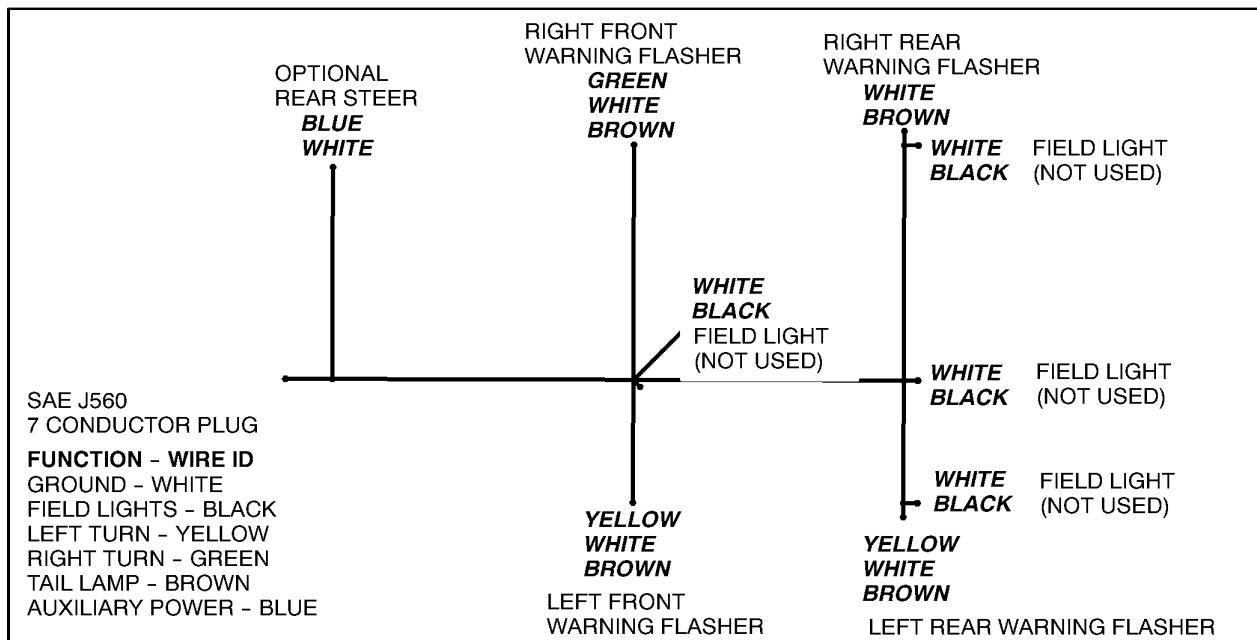
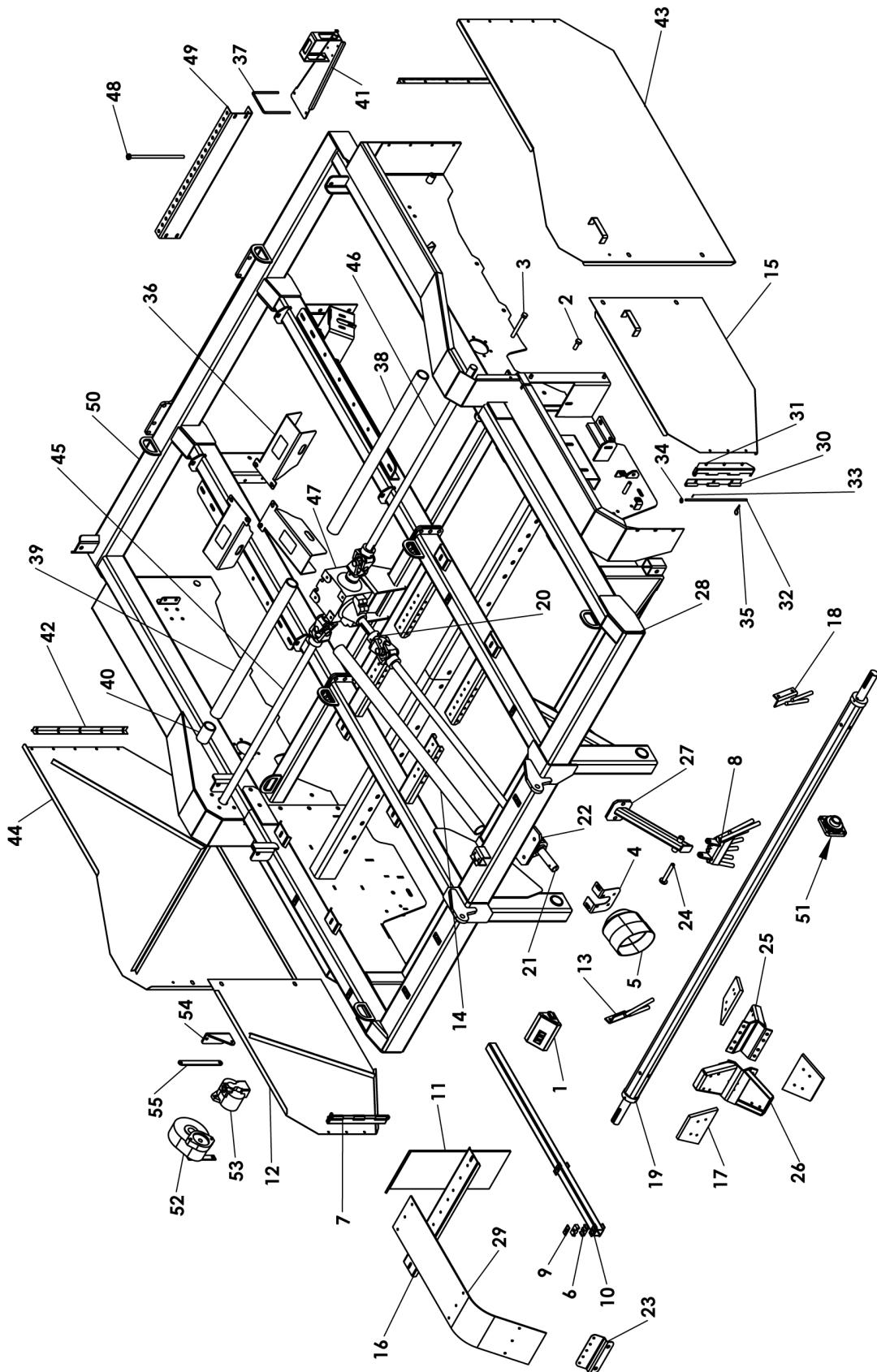


Figure 46. Harvester Harness (Without Rear Steering)

BEET HARVESTER

(All hardware is Grade 5 unless otherwise specified to be Grade 8.)

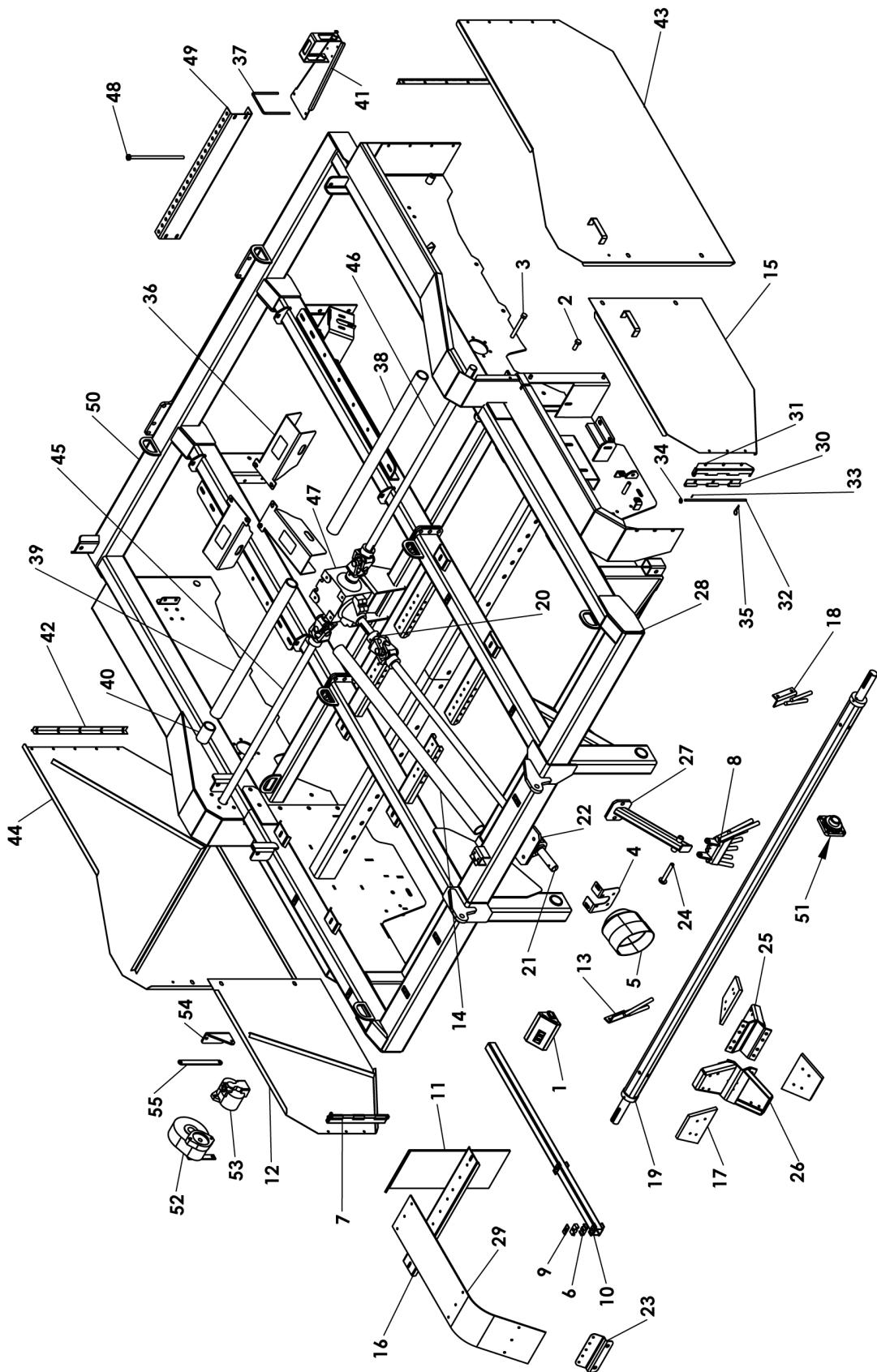
FRAME COMPONENTS



FRAME COMPONENTS

ITEMNO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0531	SWITCH BOX ASSEMBLY	1
2	900-01403	HEX BOLT - 3/4NC X 2 GR5 ZP	18
3	900-01427	HEX BOLT - 3/4NC X 6 GR5 ZP	4
4	700-3-0444	FRONT BELL MOUNT	1
5	903-18007	PTO BELL	1
6	900-31069	CLAMP BODY - HOSE HOLDER	A/R
7	700-2-0671	HINGE ASSY - DOOR (includes Ref. 30-35)	2
8	700-3-1483	FRONT BARRIER - 45cm	7
	700-2-0568	FRONT BARRIER - 22"	5
	700-2-1666	FRONT BARRIER - 30"	5
9	900-31068	COVER PLATE AND BOLT	2
10	700-2-0552	HYDRAULIC HOSE HOLDER TUBE	1
11	700-3-0317	PADDLE DEFLECTOR	1
12	700-2-0509	DOOR WELD - FRONT RH	1
13	700-2-0421	FRONT BARRIER SIDE PLATE - RH	1
	700-2-0691	FRONT BARRIER SIDE PLATE - RH (30")	
14	700-3-1189	SHAFT SHIELD-FRONT	1
15	700-2-0508	FRONT DOOR WELD - LH	1
16	700-3-1025	MOUNT PLATE - PADDLE COVER (6R45cm, 622)	4
	700-3-1620	MOUNT PLATE - PADDLE COVER (624)	4
	700-3-0772	MOUNT PLATE - PADDLE COVER (630, 822)	4
17	700-3-1207	RUBBER FLAPS - NARROW	18
	700-3-0946	RUBBER FLAPS - PRIOR TO 2007	18
18	700-2-0420	LEFT SIDE BARRIER WELD	1
	700-3-1692	FRONT BARRIER SIDE PLATE - LH (30")	1
19	700-2-0477	PADDLE TUBE WELD - 622	1
	700-2-0690	PADDLE TUBE WELD - 624	1
	700-2-0646	PADDLE TUBE WELD - 822	2
20	903-05034	U-JOINT - 1.75 KEYED 44R	3
21	700-3-0814	FRONT DRIVE SHAFT	1
22	901-01272	BRG 1.75 PILLOW BLOCK - IPTCI NAPL 209-28	1
23	700-3-0807	MOUNT PLATE - FRONT PADDLE COVER	4
24	700-2-0353	PIN WELD - FRONT BARRIER	5
25	700-2-0069	PADDLE WELD (ONE PADDLE)	6
26	700-2-0070	PADDLE WELD (TWO PADDLES)	6
27	700-2-0351	MOUNT WELD - FRONT BARRIER	5
28	700-2-0445	BODY FRAME WELD - (622)	1
	700-2-0687	BODY FRAME WELD - (624)	1
	700-2-0643	FRONT FRAME WELD - (630, 822)	1
29	700-3-1126	PADDLE COVER	6
30	700-2-0635	BACK HINGE WELD	2
31	700-2-0636	OUTER HINGE WELD	2
32	700-3-1567	ROD - HINGE PIN	2
33	900-29082	PIN ROLL 1/8 X 3/4	2
34	900-11033	FLAT WASHER 3/8 ZP	2
35	900-25003	3/32 HAIR PIN COTTER #7	2
36	500-2-0537	SHIELD WITH DECAL	3
37	900-35023	U-BOLT 3/8 X 6 X 6 X 1.5	2
38	700-3-1184	SHAFT SHIELD (LH) - (622)	1
	700-3-1613	SHAFT SHIELD (LH) - (624)	1
	700-3-1533	SHAFT SHIELD (LH) - (630, 822)	1

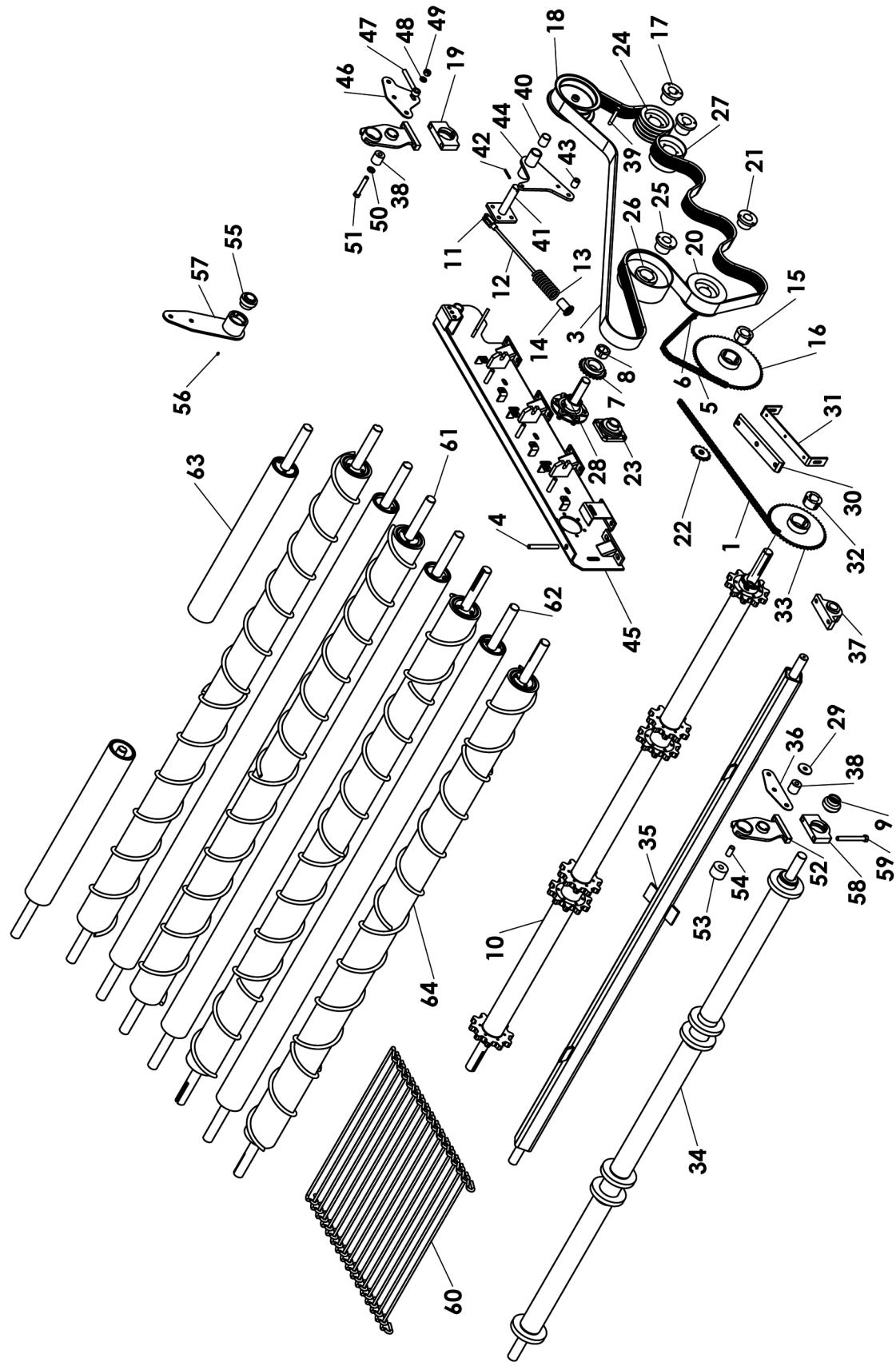
FRAME COMPONENTS (CONTINUED)



FRAME COMPONENTS (CONTINUED)

ITEMNO.	PART NUMBER	DESCRIPTION	QTY.
39	700-3-1185	SHAFT SHIELD (RH) - (622)	1
	700-3-1611	SHAFT SHIELD (RH) - (624)	1
	700-3-1535	SHAFT SHIELD (RH) - (630, 822)	1
40	700-3-1186	SHAFT SHIELD-SHORT	1
41	700-2-0514	AMBER LIGHT BRACKET	1
42	700-3-1107	SHIELD HINGE-BACK	2
43	700-2-0506	DOOR WELD - REAR LH	1
44	700-2-0507	DOOR WELD - RH	1
45	700-3-1183	SIDE DRIVE SHAFT (RH) - (622)	1
	700-3-1610	SIDE DRIVE SHAFT (RH) - (624)	1
	700-3-1534	SIDE DRIVE SHAFT (RH) - (630, 822)	1
	700-3-1780	SIDE DRIVE SHAFT (RH) - (6R45cm)	1
46	700-3-1026	SIDE DRIVE SHAFT (LH)- (622)	1
	700-3-1612	SIDE DRIVE SHAFT (LH)- (624)	1
	700-3-0854	SIDE DRIVE SHAFT (LH)- (630, 822)	1
	700-3-1779	SIDE DRIVE SHAFT (LH)- (6R45cm))	1
47	903-15547	G-BOX - SUPERIOR #680ACF006876	1
48	700-2-0345	REAR BARRIER ROD WELDMENT	5
49	700-3-1028	CLIP - REAR BARRIER (622)	2
	700-3-1607	CLIP - REAR BARRIER (624)	2
	700-3-0773	CLIP - REAR BARRIER (630, 822)	2
50	700-2-0452	BODY FRAME WELD - (622 REAR)	1
	700-2-0684	BODY FRAME WELD - (624 REAR)	1
	700-2-0648	BODY FRAME WELD - (630, 822 REAR)	1
51	901-01185	1-3/4 4-BOLT BEARING (822 ONLY)	2
52	903-15563	PARALLEL SHAFT REDUCER - HUB CITY 85LH-B2 (See page 70)	1
53	904-05244	HYD PUMP #25504RSC	1
54	700-3-1155	TORQUE ARM BRACKET	1
55	700-3-1156	TORQUE ARM	1
	700-2-0515	FRONT FRAME ASSY - 6 ROW 17.7" SPACING	1
	700-2-0672	FRONT FRAME ASSY - 6 ROW 22" SPACING	1
	700-2-0682	FRONT FRAME ASSY - 6 ROW 24" SPACING	1
	700-2-0642	FRONT FRAME ASSY - 6 ROW 30" SPACING & 8 ROW 22" SPACING	1
	700-2-0451	REAR FRAME ASSY	1

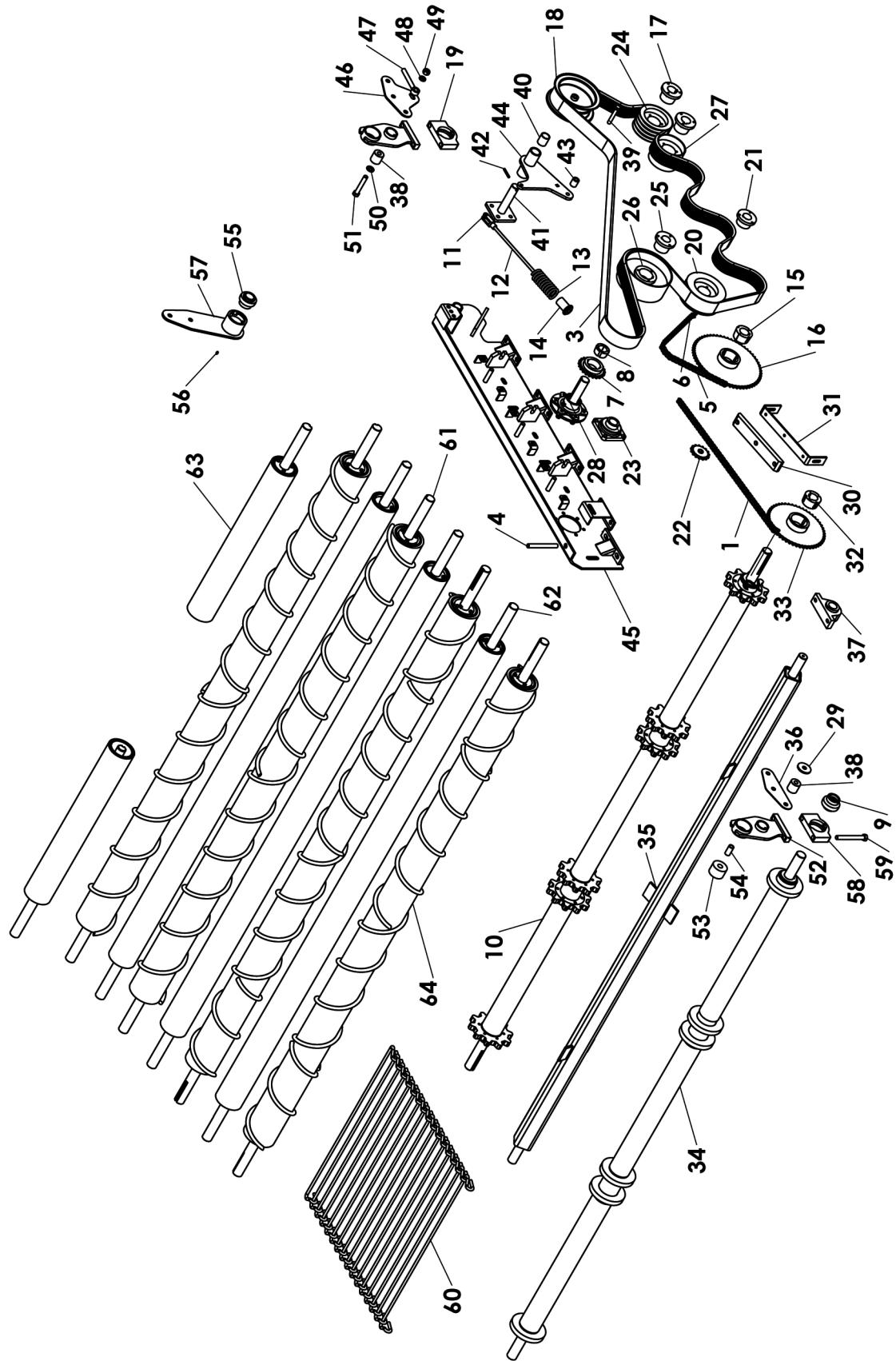
CHAIN BED & GRAB ROLL DRIVE COMPONENTS



CHAIN BED & GRAB ROLL DRIVE COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-3-1564	ROLLER CHAIN, RS-60, 98 LINKS	1
2	903-03062	RS-60 CONNECTING LINK	2
3	903-01440	BELT 4B240	1
4	700-3-1562	THREADED ROD - GRAB ROLL BED	1
5	700-3-1563	ROLLER CHAIN, RS-60, 35 LINKS	1
6	903-03089	OFFSET LINK #60-1	1
7	903-11080	SPROCKET - 60BTL22H 2012	2
8	903-08450	BUSHING TAPER LOCK 2012 - 1.93 B	2
9	901-01280	1-15/16 INSERT BRG NA-210-31	2
10	700-2-0448	DRIVE TUBE ASSY - CHAIN BED (622)	1
	700-2-0685	DRIVE TUBE ASSY - CHAIN BED (624)	
	700-2-0649	DRIVE TUBE ASSY - CHAIN BED (630, 822)	
	700-2-0741	DRIVE TUBE ASSY - CHAIN BED (6R45cm))	
	700-3-0809	SPROCKET, SPLIT	
11	500-3-1247	CLEVIS	1
12	700-3-1180	THREADED ROD-BELT TIGHTENER	1
13	905-14018	SPRING - 2.44 OD X .38 WIRE X 6.00 FL X 10.5 COILS	1
14	500-2-0580	SPRING SUPPORT WELD	1
15	903-08449	BUSHING TAPER LOCK 2517 - 1.93 B	1
16	903-11061	SPROCKET - 60BTL60	1
17	903-08452	TYPE Q1 HUB 1-15/16 BORE	8
18	500-3-1249	PULLEY - 8 OD X 3.25 X .63 ID FLANGED	2
19	700-2-0377	BEARING BLOCK ASSY - 1.93	1
	901-01280	1-15/16 INSERT BRG NA-210-31	
20	903-08400	PULLEY - 4B80SK	2
21	903-08416	TYPE SK HUB 1-3/4 BORE	2
22	903-11066	IDLER SPROCKET - 60B15H .63 BORE	3
23	901-01185	BEARING - NANFS 209-28 1.75	1
24	903-08431	PULLEY - 4B66 Q1	4
25	903-08419	TYPE Q1 HUB 1-3/4 BORE	1
	903-08452	TYPE Q1 HUB 1-15/16 BORE (6R45cm)	
26	700-2-0374	10 SMOOTH PULLEY WELD	1
	700-2-0745	10 SMOOTH PULLEY WELD	1
27	700-2-0267	PULLEY WELD - 6 INCH	4
28	700-2-0373	HUB & SPINDLE ASSY - IDLER PULLEY	1
29	700-3-1110	WASHER - 2-3/4 OD X 3/4 ID X 1/4	1
30	700-3-1100	UHMW WEAR STRAP - CHAIN SLIDE	1
31	700-3-1099	CHAIN SLIDE PLATE	1
32	903-08450	BUSHING TAPPER LOCK 2012 - 1.93 B	1
33	903-11079	SPROCKET - 60BTL48 - 2012	1
34	700-2-0447	FRONT CHAIN BED TUBE - (622)	1
	700-2-0689	FRONT CHAIN BED TUBE - (624)	
	700-2-0644	FRONT CHAIN BED TUBE - (630, 822)	
	700-2-0737	FRONT CHAIN BED TUBE - (6R45cm)	
35	700-2-0450	CENTER CHAIN BED SUPPORT TUBE WELD (622)	1
	700-2-0691	CENTER CHAIN BED SUPPORT TUBE WELD (624)	
	700-2-0645	CENTER CHAIN BED SUPPORT TUBE WELD (630, 822)	
36	700-3-0774	TIE STRAP - BED CHAIN	1
37	901-01272	BRG 1.75 PILLOW BLOCK - IPTCI NAPL 209-28	1
38	700-3-0458	BUSHING - KNULED	2
39	900-01361	HEX BOLT 5/8 - 11 X 4 GRADE 5	1
40	901-01343	OILITE BUSHING 1.5 ID X 1.75 OD X 2.0 L	2
41	700-2-0347	BASE WELD - BELT TENSIONER	1

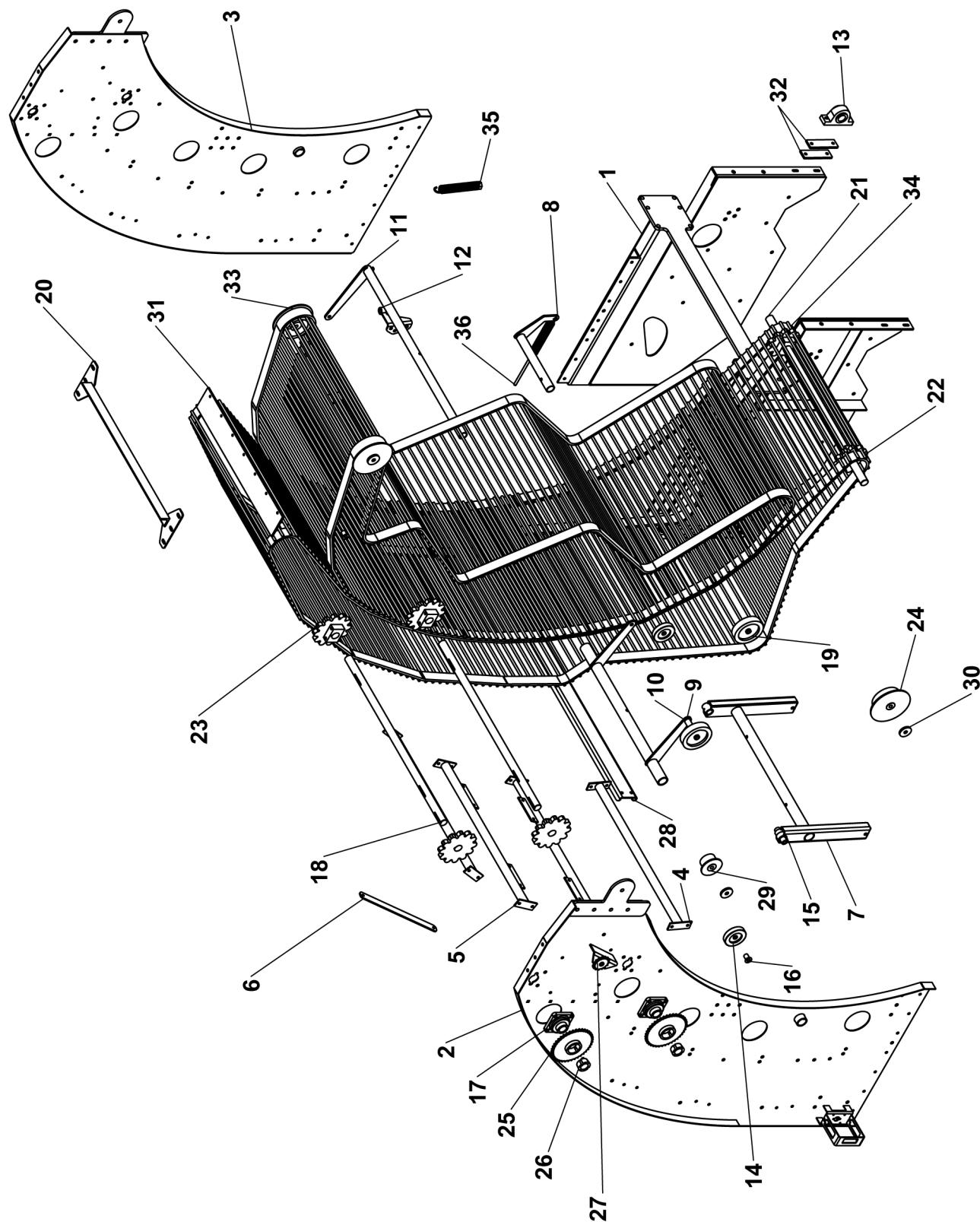
CHAIN BED & GRAB ROLL DRIVE COMPONENTS (CONTINUED)



CHAIN BED & GRAB ROLL DRIVE COMPONENTS (CONTINUED)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
42	900-29208	5/16 X 2-1/4 ROLL PIN	1
43	700-3-0785	SPACER BUSHING - BELT TENSIONER	1
44	700-2-0371	PIVOT BRACKET WELD - BELT TENSIONER RH	1
45	700-2-0459	GRAB ROLLER ADJUSTMENT PLATE WELD	1
46	700-3-0753	TIE STRAP	1
47	900-03463	3/4-10 EYE BOLT	1
48	900-11017	3/4 LOCK WASHER	1
49	900-06015	HEX NUT - 3/4 NC	1
50	900-11038	3/4" FLAT WASHER	1
51	900-01421	3/4-10 X 4 HEX BOLT	1
52	700-2-0375	SWING ARM WELD (GRABROLL) 1.93	2
53	700-3-0557	SPACER, GRAB ROLL ARM	2
54	700-3-0609	PIVOT BUSHING - SWING ARM	2
55	901-01310	1-3/4 INSERT BRG NA-209-28	1
56	905-15024	ZERK 1/4-28 UNF STRAIGHT	1
57	700-2-0364	INNER BEARING PLATE - GRABROLLS	1
58	700-3-0857	MACHINED BEARING BLOCK - 1.93	1
59	900-01425	HEX BOLT - 3/4NC X 5-1/2 GR5 ZP	2
60	903-03151	CHAIN .5 X 42 X 2.38 X 40 LINKS	1
61	700-2-0503	SPIRAL PLASTIC GRAB ROLL - REAR (622)	2
	700-2-0457	SPIRAL STEEL GRAB ROLL - REAR (622)	2
	700-2-0667	SPIRAL STEEL GRAB ROLL - HD (622)	2
	700-2-0752	SPIRAL STEEL GRAB ROLL - REAR (6R45cm)	2
	700-2-0696	SPIRAL STEEL GRAB ROLL - REAR HD (624)	2
	700-2-0361	SPIRAL PLASTIC GRAB ROLL - REAR (630, 822)	2
	700-2-0661	SPIRAL STEEL GRAB ROLL - REAR (822)	2
	700-3-0913	GRAB ROLL REPLACEMENT SHAFT	A/R
	903-08452	HUB Q1 1-15/16 BORE	A/R
62	700-2-0481	SMOOTH PLASTIC GRAB ROLLER (622)	3
	700-2-0458	SMOOTH STEEL GRAB ROLL (622)	3
	700-2-0668	SMOOTH STEEL GRAB ROLL - HD (622)	3
	700-2-0754	SMOOTH STEEL GRAB ROLL (6R45cm)	3
	700-2-0698	SMOOTH STEEL GRAB ROLL (624)	3
	700-2-0389	SMOOTH PLASTIC GRAB ROLL (822)	3
	700-2-0663	SMOOTH STEEL GRAB ROLL (822)	3
	700-3-0913	GRAB ROLL REPLACEMENT SHAFT	A/R
	903-08452	HUB Q1 1-15/16 BORE	A/R
63	700-2-0483	PLASTIC STUB ROLL (622)	2
	700-2-	STEEL STUB ROLL (622)	2
	700-2-0669	STEEL STUB ROLL - HD (622)	2
	700-2-0753	STEEL STUB ROLL (6R45cm))	2
	700-2-0699	STEEL STUB ROLL (624)	2
	700-2-0388	PLASTIC STUB ROLL (822)	2
	700-2-0664	STEEL STUB ROLL (822)	2
	700-2-0087	STUB ROLL REPLACEMENT SHAFT	A/R
	903-08452	HUB Q1 1-15/16 BORE	A/R
64	700-2-0499	SPIRAL PLASTIC GRAB ROLL, FRONT (622)	2
	700-2-0455	SPIRAL STEEL GRAB ROLL, FRONT (622)	2
	700-2-0666	SPIRAL STEEL GRAB ROLL, FRONT - HD (622)	2
	700-2-0751	SPIRAL STEEL GRAB ROLL, FRONT (6R45cm)	2
	700-2-0697	SPIRAL STEEL GRAB ROLL, FRONT - HD (624)	2
	700-2-0386	SPIRAL PLASTIC GRAB ROLL, FRONT (822)	2
	700-2-0657	SPIRAL STEEL GRAB ROLL, FRONT (822)	2
	700-3-0913	GRAB ROLL REPLACEMENT SHAFT	A/R
	903-08452	HUB Q1 1-15/16 BORE	A/R

ELEVATOR COMPONENTS

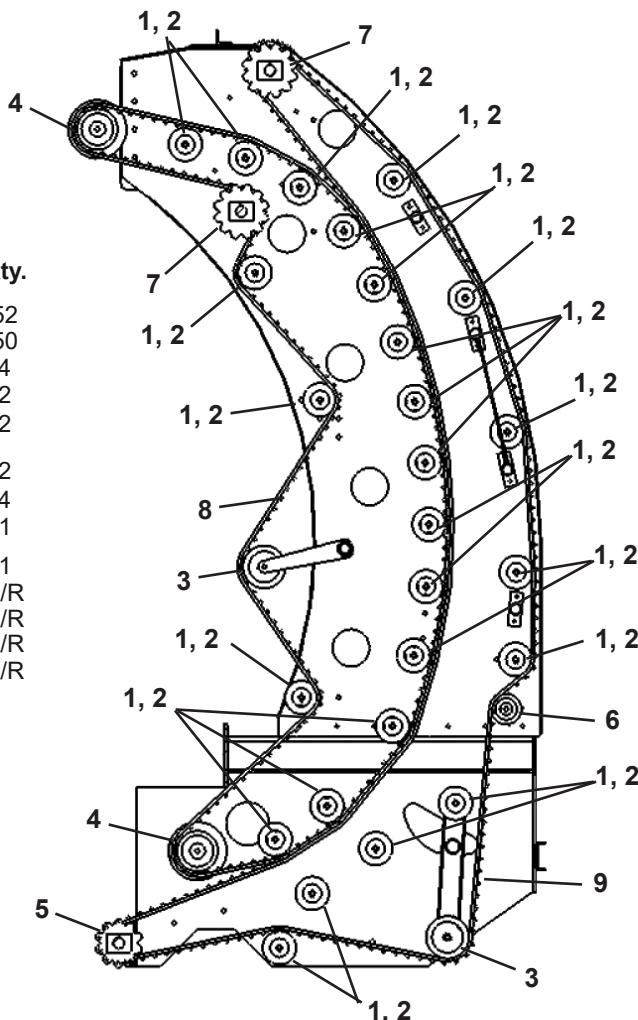


ELEVATOR COMPONENTS

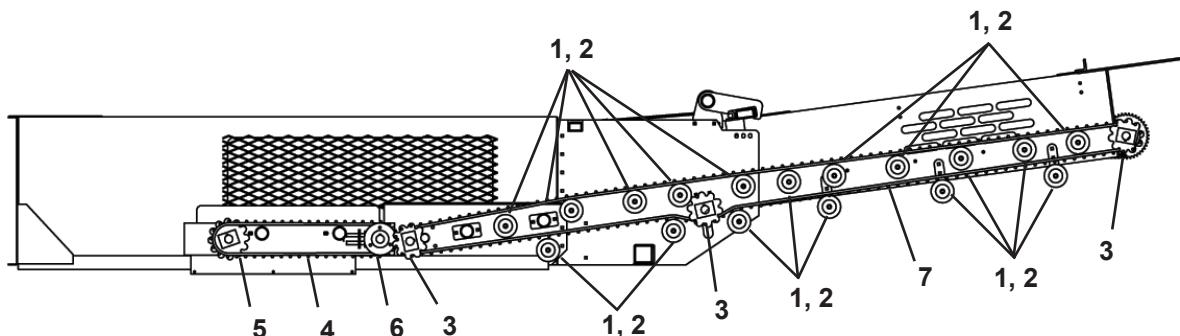
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0524	REAR ELEVATOR MOUNT WELD	1
2	700-2-0031	SIDE PLATE WELD (RH)	1
3	700-2-0032	SIDE PLATE WELD (LH)	1
4	700-2-0023	SPREADER BAR WELD	2
5	700-2-0024	SPREADER STIFFENER BAR WELD	2
6	700-3-0080	BAR - SPREADER STIFFENER	2
7	700-2-0028	OUTSIDE ARM WELD	1
8	700-2-0381	TENSION ARM WELD (OUTSIDE)	1
9	700-3-0417	SLEEVE - OUTSIDE ARM	4
10	700-2-0027	TENSION ARM WELD (MAIN)	1
11	700-2-0026	TENSION ARM WELD	1
12	700-2-0030	BRACKET WELD - SPRING TENSIONER	1
13	901-01272	BRG 1.75 PILLOW BLOCK - IPTCI NAPL 209-28	2
14	903-08433	5" RUBBER ROLLER	52
15	700-3-0547	SPACER - ELEVATOR H-WELD	2
16	903-08424	SPACER ROLLER STANOFF	50
17	901-01185	BEARING - NANFS 209-28 1.75	4
18	700-3-0086	DRIVE SHAFT - ELEVATOR	2
19	903-08425	7" CAST RUBBER WHEEL	4
20	700-2-0096	DEFLECTOR WELD	1
21	700-3-0862	LOWER SHAFT - ELEVATOR	1
22	903-11068	SPROCKET - 10T 50MM PITCH 1.75 BORE	2
23	903-11067	SPROCKET - 12T 50MM PITCH 1.75 BORE	4
24	903-08437	6 INCH NOSE ROLLER	4
25	903-11070	SPROCKET - 60BTL40	2
26	903-08412	BUSHING TAPPER LOCK 2012 - 1.75 B	2
27	903-11066	IDLER SPROCKET - 60B15H .63 BORE	1
28	700-3-1212	CHANNEL-ELEVATOR	1
29	903-08426	5 INCH FLANGE ROLLER	2
30	500-3-1463	WASHER	6
31	700-3-1213	RUBBER FLAP - REAR ELEVATOR	1
32	700-3-1214	BEARING SPACER - 3/8 INCH	4
33	903-03130	BELTED CHAIN INSIDE VERTICAL	1
34	903-03131	BELTED CHAIN OUTSIDE VERTICAL	1
35	700-2-0550	SPRING TENSIONER ASSEMBLY	2
36	700-3-1255	1/2-13 TENSION ROD	1
	700-2-0380	ELEVATOR ASSEMBLY	1

ROLLER COMPONENTS (ELEVATOR)

Item No.	Part Number	Description	Qty.
1	903-08433	5" Roller	52
2	903-08424	Standoff	50
3	903-08425	7" Cast Rubber Wheel	4
4	903-08437	6" Nose Roller	2
5	903-11068	10 Tooth 50mm 1-3/4" Sprocket	2
6	903-08426	5" Flanged Roller	2
7	903-11067	12 Tooth 50mm 1-3/4" Sprocket	4
8	903-03130	Inside Belted Chain	1
9	903-03131	Outside Belted Chain	1
	903-03135	Belted Chain Repair Splice	A/R
	903-03134	4' Chain Extension	A/R
		Belted Chain Backing Plate	A/R
		1/4 x 1-1/4 NF Counter Sink	A/R
		Allen Bolt	



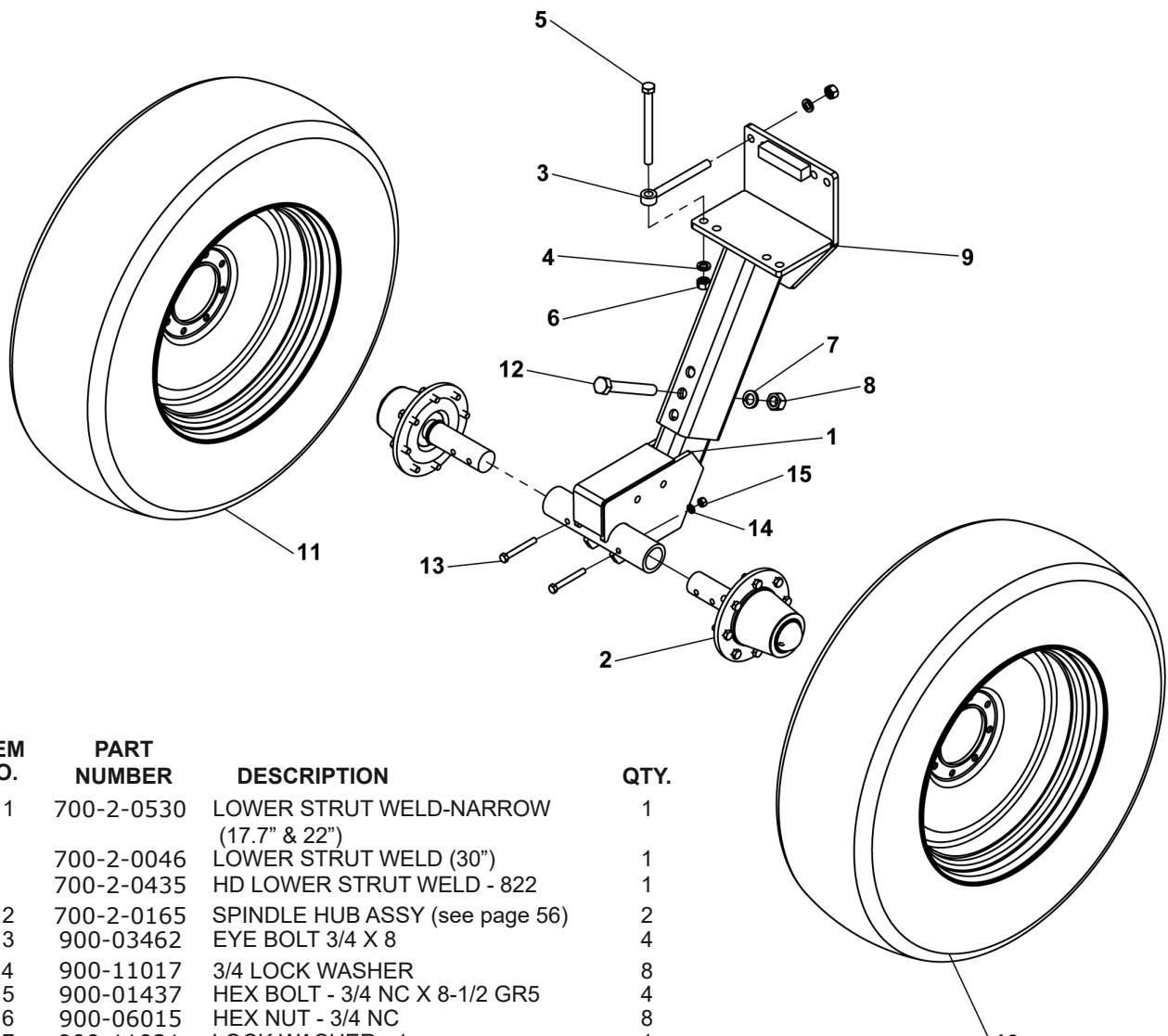
ROLLER COMPONENTS (BOOM - TANK BOTTOM)



Ref No	Part Number	Description	Qty.
1	903-08433	5" Roller	34
2	903-08424	Standoff	30
3	903-11068	10 Tooth, 50MM, 1-3/4" Sprocket	2
4	903-03155	Belted Boom Chain, Short	1
5	903-11067	12 Tooth, 50mm, 1-3/4" Sprocket	2

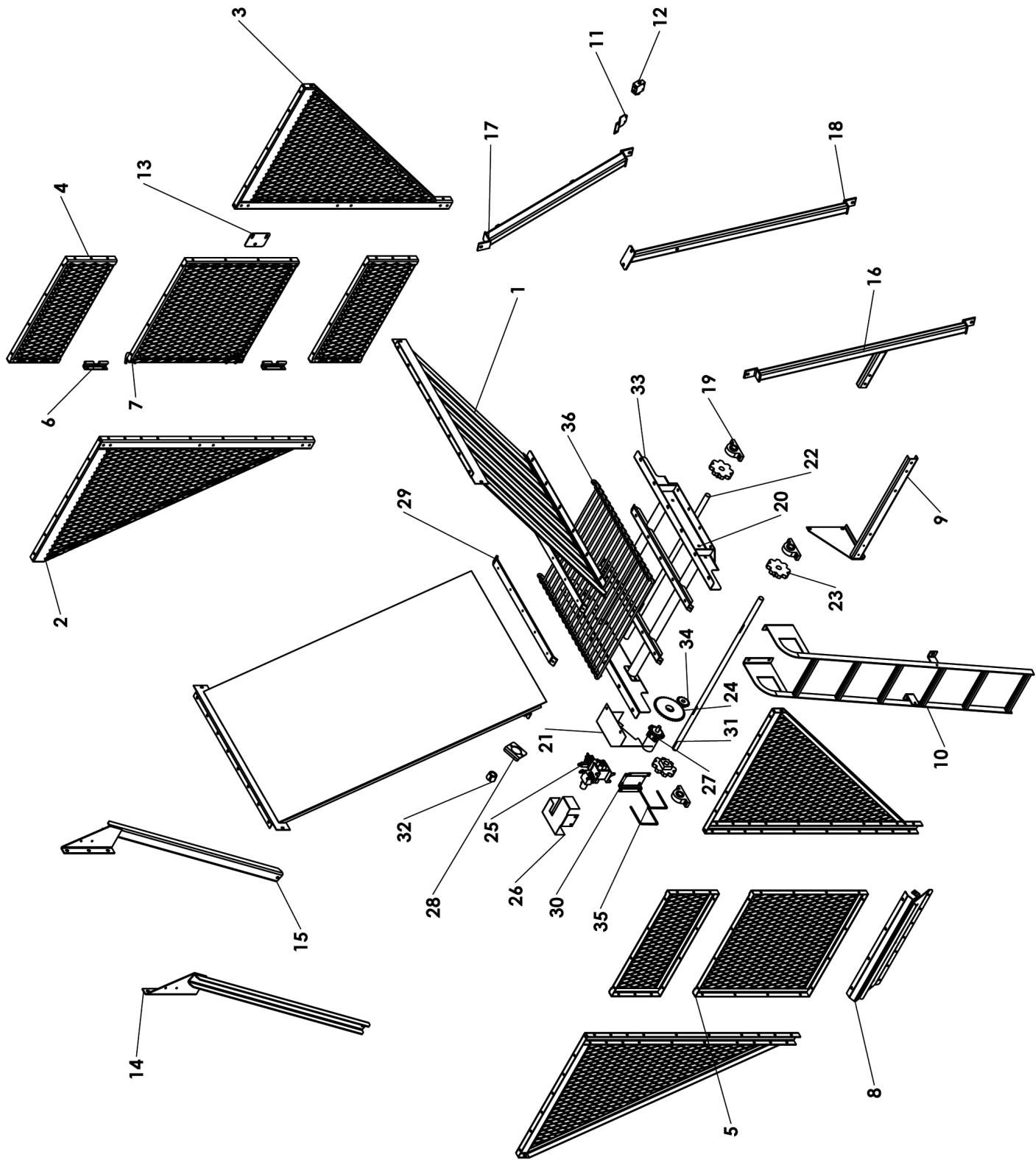
Item No.	Part Number	Description	Qty.
6	700-20526	7" Smooth Sprocket	2
7	903-03132	Belted Boom Chain, Long	1
	903-03134	4' Chain Extension	A/R
	903-03135	Belted Chain Repair Splice	A/R
	903-03141	Belted Chain Backing Plate	A/R
	900-03469	1/4 x 1-1/4NF Countersink Bolt	A/R

STRUT COMPONENTS



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0530	LOWER STRUT WELD-NARROW (17.7" & 22")	1
	700-2-0046	LOWER STRUT WELD (30")	1
	700-2-0435	HD LOWER STRUT WELD - 822	1
2	700-2-0165	SPINDLE HUB ASSY (see page 56)	2
3	900-03462	EYE BOLT 3/4 X 8	4
4	900-11017	3/4 LOCK WASHER	8
5	900-01437	HEX BOLT - 3/4 NC X 8-1/2 GR5	4
6	900-06015	HEX NUT - 3/4 NC	8
7	900-11021	LOCK WASHER - 1	1
8	900-06019	1-8 HEX NUT	1
9	700-2-0529	UPPER STRUT WELD-NARROW	1
	700-2-0047	UPPER STRUT WELD	1
	700-2-0436	HD UPPER STRUT WELD - 822	1
10	700-2-0167	TIRE AND RIM ASSY	1
	905-09127	RIM 24 x 10, 88T	
	905-09130	TIRE 12-4-24	
	700-2-0438	TIRE AND RIM ASSY RIM 24 x W15L TIRE 16.9-24	1
11	700-2-0168	TIRE AND RIM ASSY	1
	905-09127	RIM 24 x 10, 88T	
	905-09130	TIRE 12-4-24	1
	700-2-0438	TIRE AND RIM ASSY	1
12	900-01535	HEX BOLT - 1NC X 7-1/2 GR5 ZP	1
13	900-01245	1/2 X 4 HEX BOLT GR5 ZP	2
	900-01247	1/2 X 4-1/2 HEX BOLT GR5 ZP	2
14	900-11013	WASHER, LOCK 1/2	2
15	900-06009	NUT HEX 1/2 UNC	2
	700-2-0528	REAR STRUT ASSEMBLY - NARROW	1
	700-2-0382	REAR STRUT ASSEMBLY	
	700-2-0437	HD REAR STRUT ASSEMBLY	

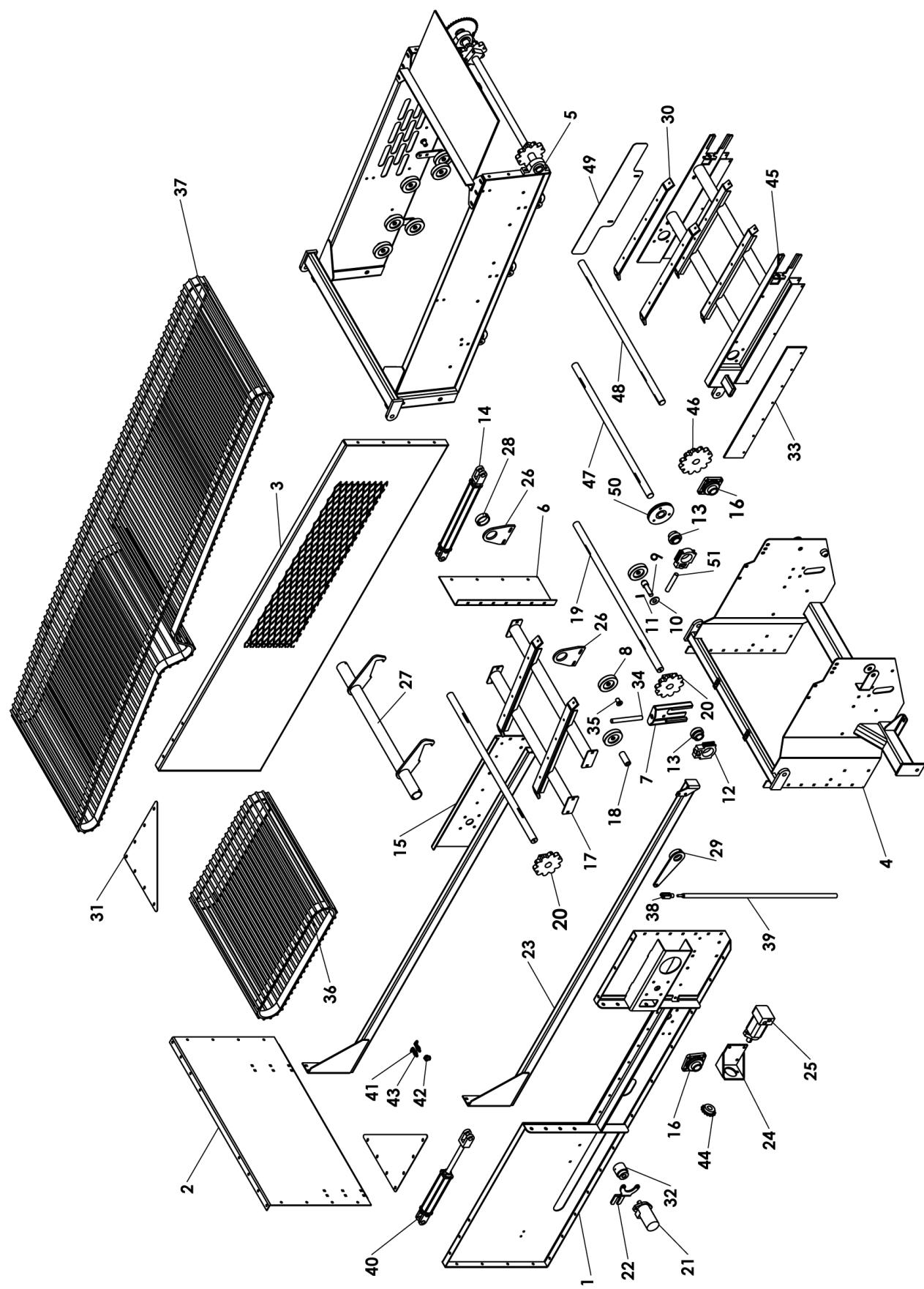
HOPPER COMPONENTS



HOPPER COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0513	TANK SLIDE ASSY-LARGE TANK	2
2	700-2-0395	MESH WELD - RH	2
3	700-2-0396	MESH WELD - LH	2
4	700-2-0402	BOTTOM FRONT TANK WELD	3
5	700-2-0403	DOOR WELD - REAR	1
6	700-2-0422	HINGE WELD - TANK DOOR	2
7	700-2-0423	DOOR WELD - FRONT	1
8	700-2-0495	REAR GATE ASSY	1
9	700-2-0501	LADDER SUPPORT WELD	1
10	700-2-0502	LADDER WELD - 622	1
11	700-3-1240	MOUNTING BRACKET - CHECK VALVE	1
12	905-03155	CHECK VALVE - 1/2 NPT PORTS	1
13	700-2-0634	DOOR STOP WELD	1
14	700-2-0654	TANK SUPPORT WELD - REAR LEFT 8ROW	1
15	700-2-0655	TANK SUPPORT WELD - FRONT LEFT	1
16	700-2-0653	SUPPORT TUBE WELD-RH REAR	1
17	700-2-0399	TUBE WELD	1
18	700-2-0656	SUPPORT TUBE WELD - FRONT BOOM - 822	1
19	901-01345	BRG 1.50 PILLOW BLOCK - IPTCI NAPL 208-24	4
20	700-2-0489	TANK SLIDE WELD	1
21	700-3-1466	SHIELD - TANK UNLOAD CONVEYOR	1
22	700-3-0932	CROSS SHAFT - TANK CONVEYOR	1
23	903-11082	SPROCKET - H237 8T 1.5B	5
24	903-11070	SPROCKET - 60BTL40	1
25	700-2-0538	2 BANK VALVE - 38/36 SERIES WITH FITTINGS	1
26	700-3-1465	SHIELD - VALVE	1
27	904-05241	HYD MOTOR - CHAR-LYNN H SERIES 101-1040	1
28	700-3-0894	MOUNT PLATE - HYD MOTOR	1
29	700-3-1124	UHMW SLIDE-TANK	2
30	700-3-1190	VALVE MOUNTING PLATE	1
31	700-3-0890	DRIVE SHAFT - TANK CONVEYOR	1
32	903-08456	BUSHING TAPPER LOCK 2012 - 1.50 B	1
33	700-2-0517	BOTTOM TANK MOUNT PLATE WELD	2
34	903-11083	#60-1 15 TOOTH SPROCKET	1
35	900-35023	U-BOLT 3/8 X 6 X 6 X 1.5	2
36	903-03152	HOOK CHAIN .63 X 42 X 2.38 X 46 LINKS	1
	903-03157	CHAIN .63 X 42 X 2.38 - SINGLE LINK	
	700-2-0525	LOWER TANK ASSEMBLY (622) - 6 TON	1

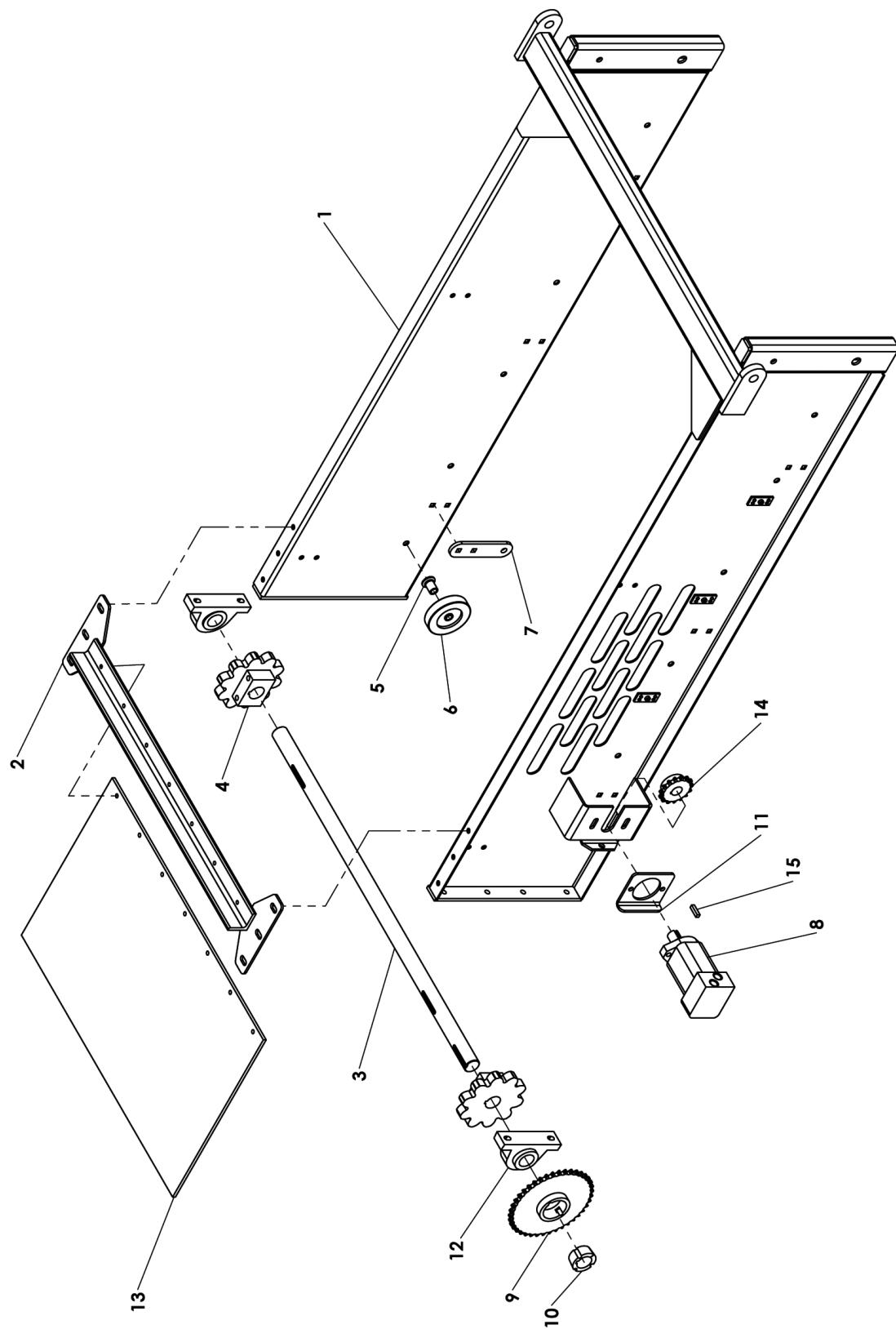
LARGE TANK COMPONENTS



LARGE TANK COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0419	HOPPER BACK SHEET WELD - LARGE TANK	1
2	700-3-1115	END PLATE - TANK (622)	1
3	700-2-0384	UPPER FRONT PANEL WELD	1
4	700-2-0486	INTERMEDIATE WELD -622	1
5	700-2-0491	OUTER BOOM WELD - 622	1
6	700-3-1114	CORNER PLATE - TANK (622)	1
7	700-2-0404	CONVEYOR TAKEUP WELD	2
8	903-08433	5" RUBBER ROLLER	16
9	700-3-0916	PIVOT PIN - BOOM	2
10	900-11040	1" FLAT WASHER	2
11	900-29208	5/16 X 2-1/4 ROLL PIN	2
12	901-01359	T209 BEARING HOUSING	4
13	901-01310	1-3/4 INSERT BRG NA-209-28	4
14	905-21396	HYDRAULIC CYL 2 X 20 - (20TD20-112)	2
15	700-2-0487	CONVEYOR SLIDE - FRONT	1
16	901-01305	BEARING - UCFS 209-28 1.75 (W/SET SCREWS)	4
17	700-2-0412	CHAIN SLIDE WELD	1
18	700-3-0924	STANDOFF - INNER WHEEL	6
19	700-3-0928	IDLER SHAFT - SHORT CONVEYOR	2
20	903-11068	SPROCKET - 10T 50MM PITCH 1.75 BORE	4
21	904-05241	HYD MOTOR - CHAR-LYNN H SERIES 101-1040	1
22	700-3-0945	TORQUE ARM - HYD MOTOR	1
23	700-2-0493	CONVEYOR SLIDE - REAR	1
24	700-2-0426	HYD MOTOR MOUNT WELD	1
25	904-05223	HYD MOTOR - CHAR-LYNN 1041026	1
26	700-3-0979	PIVOT EAR - BOOM LOCK	2
27	700-2-0494	LOCK BAR WELD - BOOM (622)	1
28	700-3-1146	COLLAR BOOM LOCK - PAINTED	1
29	700-2-0498	BOOM LOCK LEVER	1
30	700-3-1169	UHMW SLIDE-SLIDE CONVEYOR	4
31	700-3-1218	CORNER GUSSET - TANK	2
32	700-2-0527	COUPLER WELD - HYD MOTOR	1
33	700-3-1213	RUBBER FLAP - REAR ELEVATOR	1
34	700-3-1221	THREADED ROD - TAKEUP	2
35	903-08424	SPACER ROLLER STANDOFF	8
36	903-03155	BELTED CHAIN BOOM SHORT	1
37	903-03154	BELTED CHAIN BOOM LONG	1
38	500-3-1247	CLEVIS	1
39	700-2-0547	HANDLE WELD	1
40	905-21390	HYDRAULIC CYL 2 X 10	1
41	905-03211	ELBOW, 6MJIC x 6FJICSVL (90 DEG)	2
42	905-03210	ADAPTER, 6MJIC x 12MORB	1
43	905-03212	ADAPTER, 6MJIC x 8MORB	2
44	903-11085	#60-1 15 TOOTH SPROCKET 1-1/4 B W/KSS	1
45	700-2-0441	TANK CONVEYOR WELD - UPPER	1
46	903-11067	SPROCKET - 12T 50MM PITCH 1.75 BORE	2
47	700-3-0944	IDLER SHAFT - SHORT CONVEYOR	1
48	700-3-0927	DRIVE SHAFT - SHORT CONVEYOR	1
49	700-3-1215	BACKBOARD - CONVEYOR	1
50	700-2-0526	SMOOTH SPROCKET WELD -1.75	2
51	700-3-1217	THREADED ROD - TAKEUP	2
	700-2-0485	LARGE TANK ASSY (622)	1

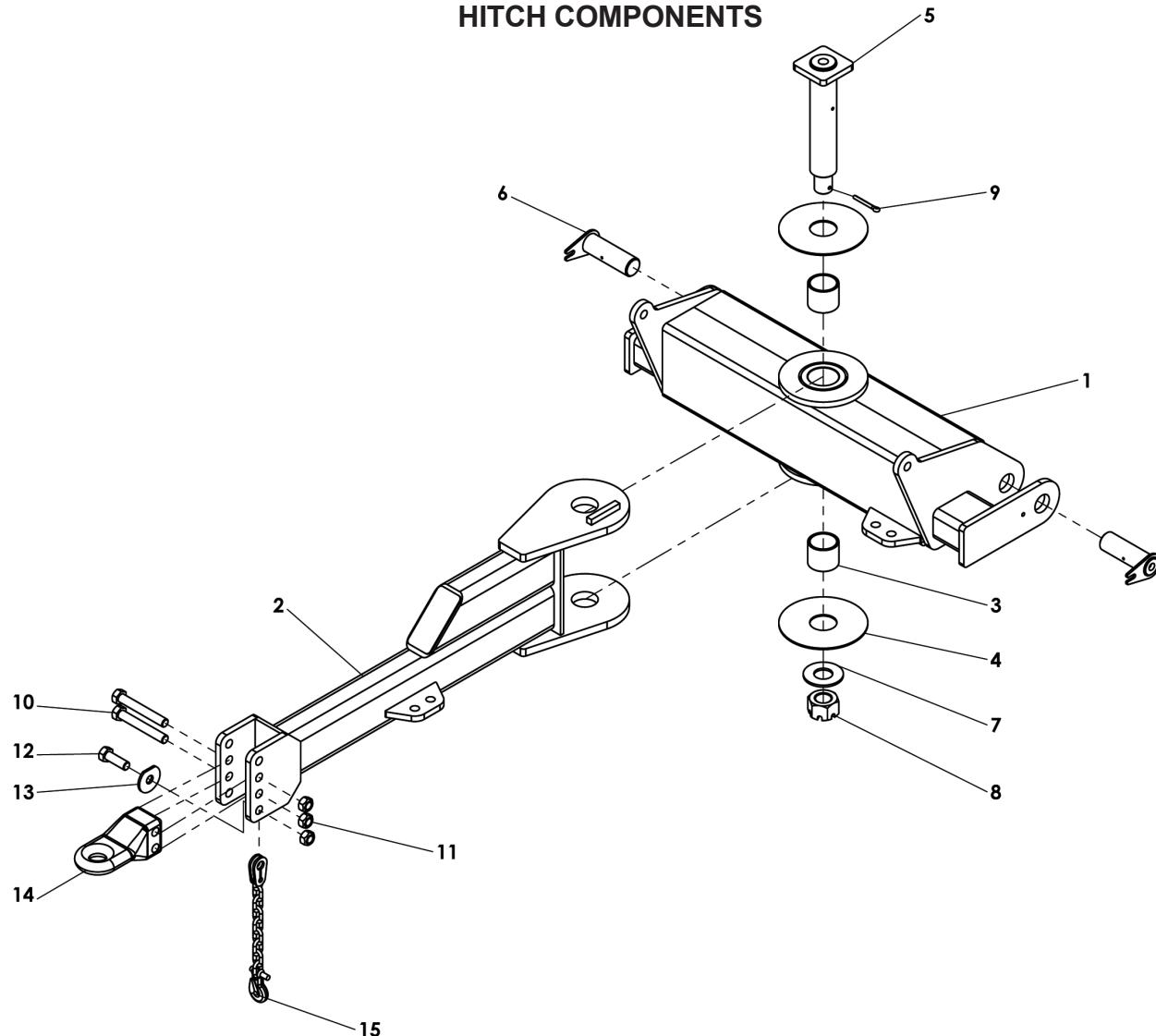
OUTER BOOM COMPONENTS



OUTER BOOM COMPONENTS

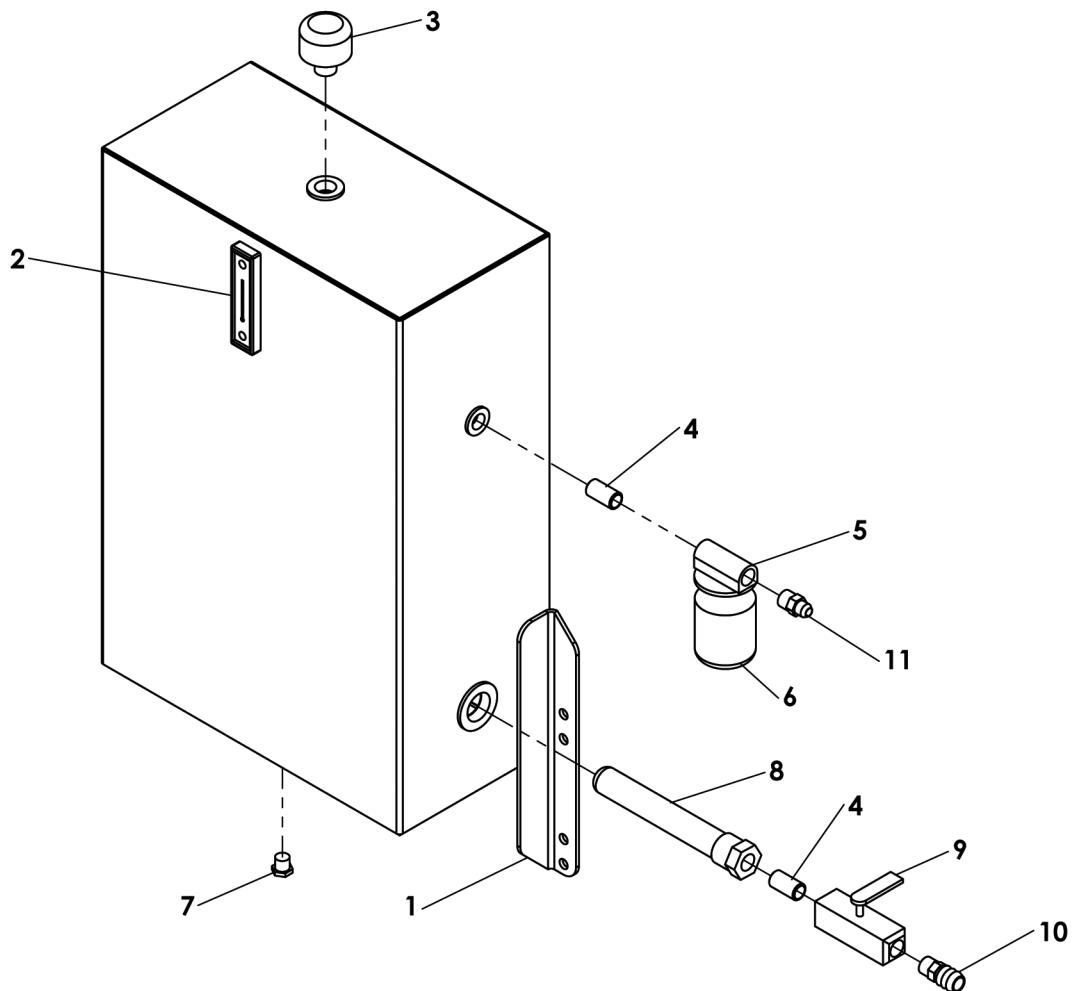
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0492	OUTER BOOM WELD - 622	1
2	700-2-0096	DEFLECTOR WELD	1
3	700-3-0086	DRIVE SHAFT - ELEVATOR	1
4	903-11068	SPROCKET - 10T 50MM PITCH 1.75 BORE	2
5	903-08424	SPACER ROLLER STANDOFF	18
6	903-08433	5" RUBBER ROLLER	18
7	700-3-0230	ROLLER DROP STRAP	6
8	904-05223	HYD MOTOR - CHAR-LYNN 1041026	1
9	903-11070	SPROCKET - 60BTL40	1
10	903-08412	BUSHING TAPPER LOCK 2012 - 1.75 B	1
11	700-3-0894	MOUNT PLATE - HYD MOTOR	1
12	901-01303	BRG 1.75 PILLOW BLOCK - IPTCI NAPL 209-28	2
13	700-3-1220	RUBBER FLAP - BOOM	1
14	903-11085	#60-1 15 TOOTH SPROCKET 1-1/4 B W/KSS	1
15	100-3-1318	KEY - 3/8 x 3/8 x 1-1/2	1
	700-2-0491	OUTER BOOM WELDMENT - 622	1

HITCH COMPONENTS



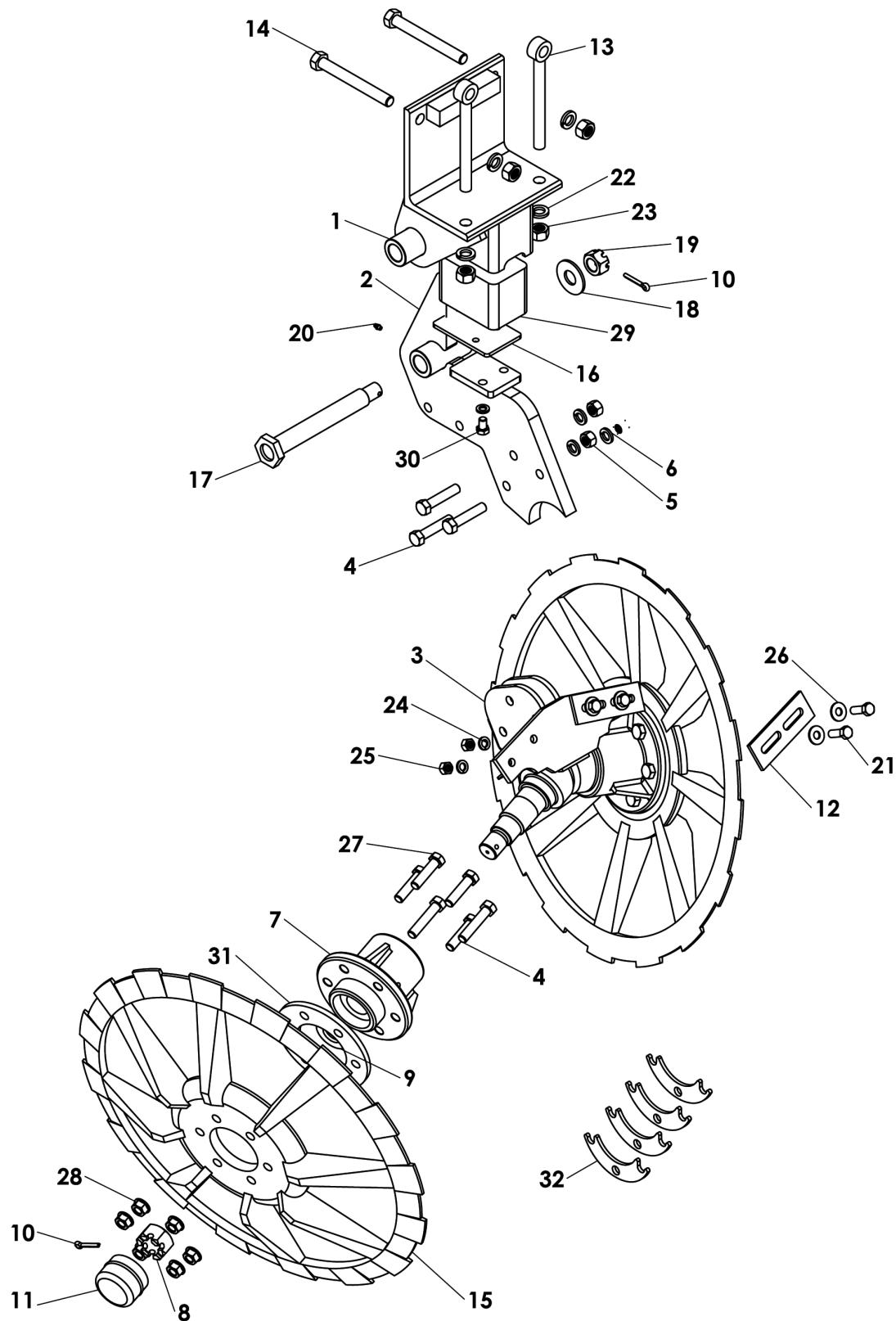
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0338	INNER HITCH WELDMENT	1
2	700-2-0337	FRONT HITCH WELDMENT	1
3	901-01344	SPLIT BUSHING - 3 ID X 3.50D X 3 LONG	2
4	700-3-0741	THRUST WASHER - HITCH	2
5	700-2-0340	POLE PIN WELDMENT - HITCH	1
6	700-2-0019	PIN WELDMENT - HITCH MOUNT	2
7	900-11048	2 FLAT WASHER ZN	1
8	900-06239	2 NC HEAVY HEX SLOTTED NUT G5 ZP	1
9	900-23084	3/8 X 3-1/2 COTTER PIN	1
10	900-02930	1-8 X 7" HEX BOLT	2
11	900-06514	1-8 TOP LOCK NUT	3
12	900-01519	1-8 X 3" HEX BOLT	1
13	500-3-1631	WASHER 1.03 X 3.25 X .25	1
14	505-3-0831	HITCH TONGUE COMP CAT3	1
15	905-07123	TOW CHAIN SAFETY 21,000 LB	1
	700-2-0339	HITCH ASSEMBLY	1

HYDRAULIC TANK COMPONENTS - 40 GALLON



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0431	40 GAL HYD TANK WELD	1
2	905-03190	5 INCH SIGHT LEVEL GAGE	1
3	905-03202	BREATHER CAP - 1 NPT	1
4	903-03201	3/4 NPT NIPPLE	2
5	905-03203	HYD FILTER - 3/4 NPT	1
6	905-03204	HYDRAULIC FILTER	1
7	905-01548	PIPE PLUG - 1/2 MPT	1
8	905-03206	SUCTION SCREEN - S15-100-RV5	1
9	905-03207	BRASS BALL VALVE - 3/4"	1
10	905-03208	NIPPLE - 3/4MP X 1-1/4 HOSE BARB	1
11	905-03205	ADAPTOR - 12MPT X 8MJIC	1
700-2-0533 HYDRAULIC TANK ASSY - 40 GAL			1

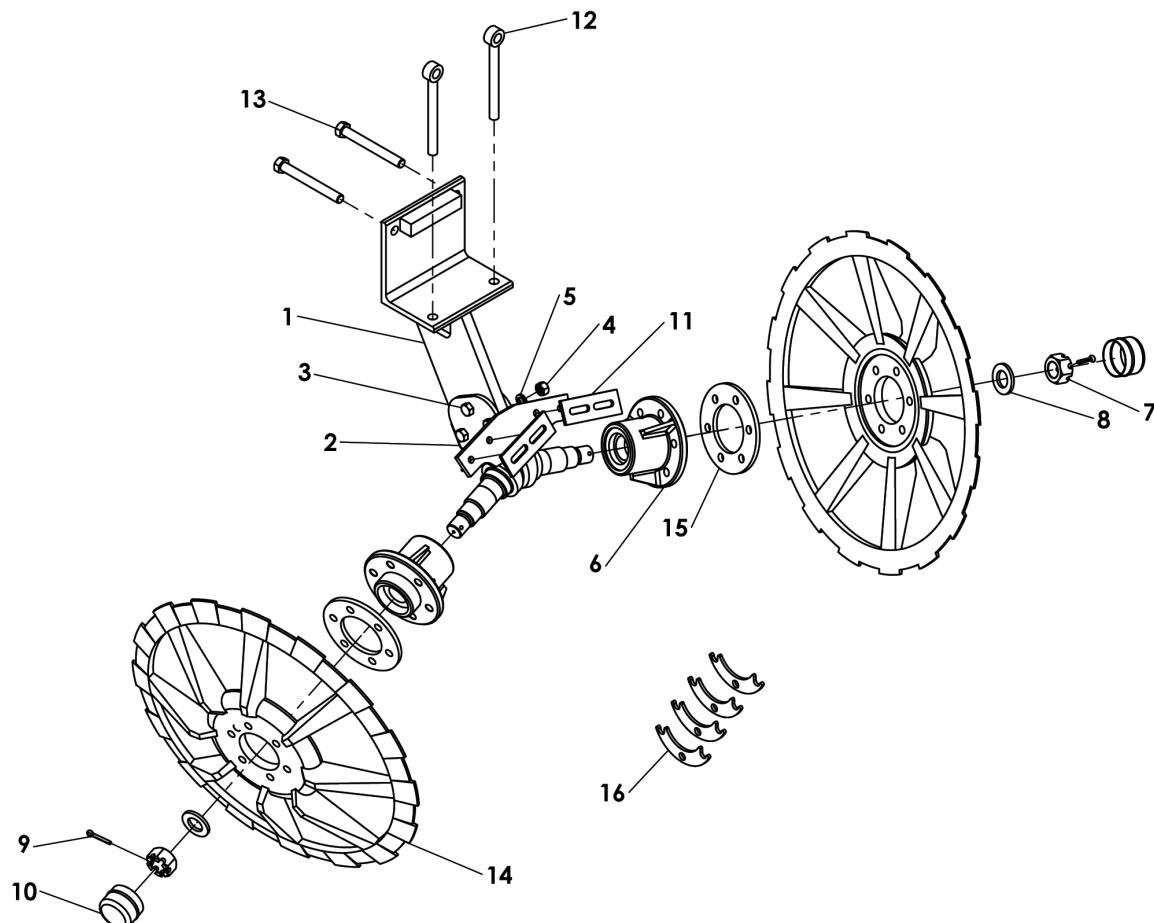
STANDARD CUSHION DIGGER STRUT COMPONENTS



STANDARD CUSHION DIGGER STRUT COMPONENTS

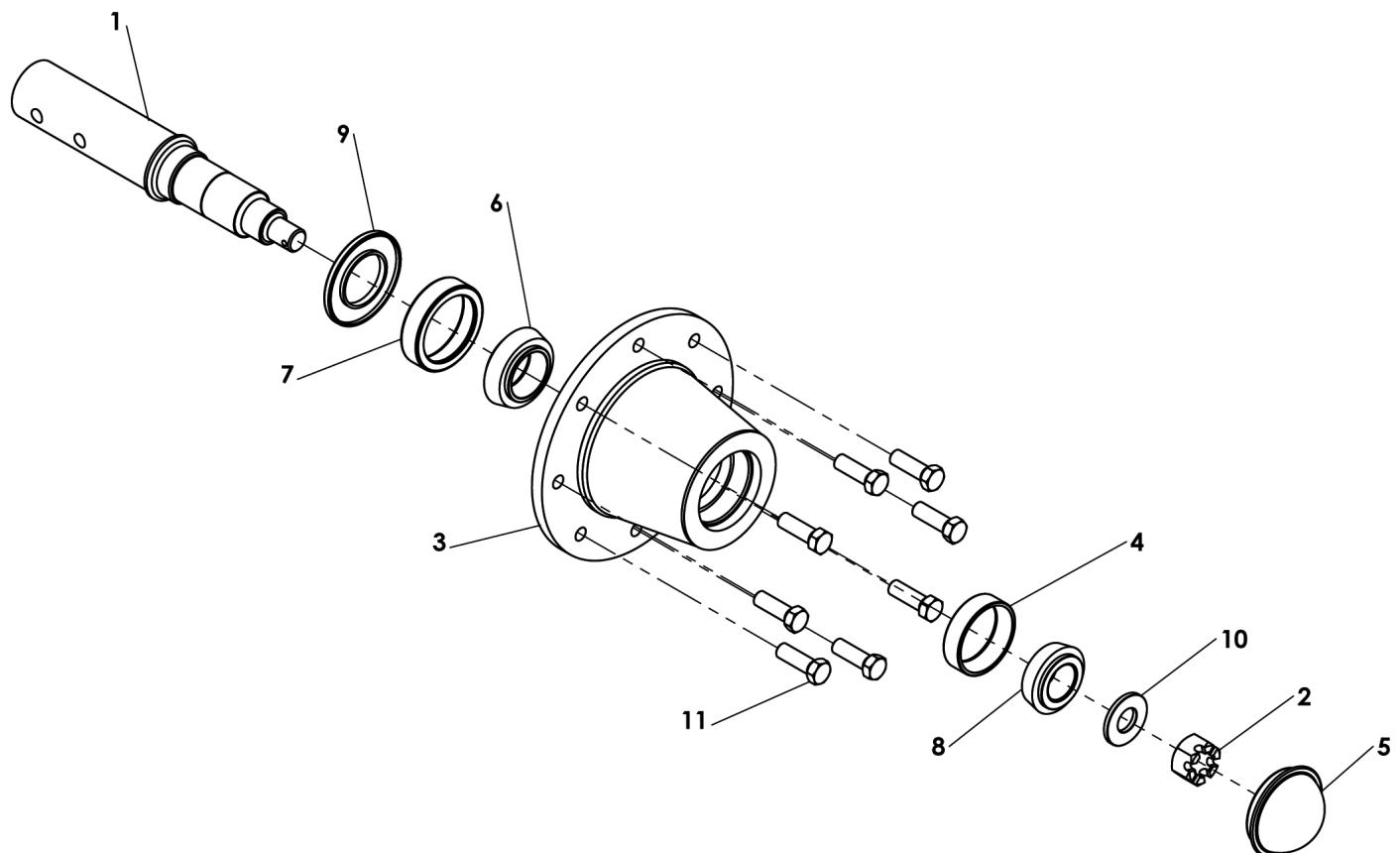
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0534	PIVOT MOUNT WELD	1
2	700-2-0535	LIFTER PIVOT	1
3	700-2-0464	SPINDLE WELD - (STD 22"-30")	1
	700-2-0511	SPINDLE WELD - (17.7" ROWS)	1
4	900-01353	5/8 NC X 3 HEX BOLT GRADE 5	7
5	900-06013	NUT HEX 5/8 UNC	3
6	900-11015	WASHER, LOCK, 5/8	3
7	700-2-0410	HUB ASSY - DIGGER STRUT	2
8	900-06068	1-3/8 - 12 SLOTTED HEX NUT	2
9	120-3-0003	WASHER - 1.41 OD X 2.5 OD X .25	2
10	900-23064	COTTER PIN - 1/4 X 2	3
11	905-09129	DUST CAP- 3 OD X 2.25 DP	2
12	700-3-1056	SCRAPER BLADE - DIGGER STRUTS	2
13	900-03462	EYE BOLT 3/4 X 8	2
14	900-01429	HEX BOLT - 3/4NC X 6-1/2 GR5 ZP	2
15	700-3-0303	LIFTER WHEEL - 28 CASTING	2
	700-2-0323	WHEEL FILLER WELDMENT (OPTIONAL)	2
16	700-3-1237	RUBBER BOLT PLATE	1
17	700-2-0537	DIGGER STRUT LIFT PIN	1
18	900-11040	1" FLAT WASHER	1
19	900-06061	1-8 HEX SLOTTED NUT	1
20	905-15024	ZERK 1/4-28 UNF STRAIGHT	1
21	900-01225	1/2 NC X 1-1/2 HEX BOLT GR 5	4
22	900-11017	3/4 LOCK WASHER	4
23	900-06015	HEX NUT - 3/4 NC	4
24	900-11013	WASHER, LOCK 1/2	6
25	900-06009	NUT HEX 1/2 UNC	4
26	900-11035	1/2 FLAT WASHER	4
27	900-01347	5/8" X 2-1/2 NC HEX BOLT	8
28	900-06145	5/8 WHIZ NUT	12
29	700-3-1397	ROCK CUSHION	1
30	900-01217	HEX BOLT - 1/2 NC X 3/4 ZP	2
31	700-3-1475	WHEEL SPACER - 3/8" (17.7" ROWS ONLY)	2
32	700-3-0447	WHEEL SPACER - 1/4" (22" ROWS ONLY)	4
	700-2-0641	CUSHION STRUT ASSY. (STD - REF 1-30)	1
	700-2-0536	CUSHION STRUT ASSY. (17.7" ROWS - REF 1-31)	1

DIGGER STRUT COMPONENTS



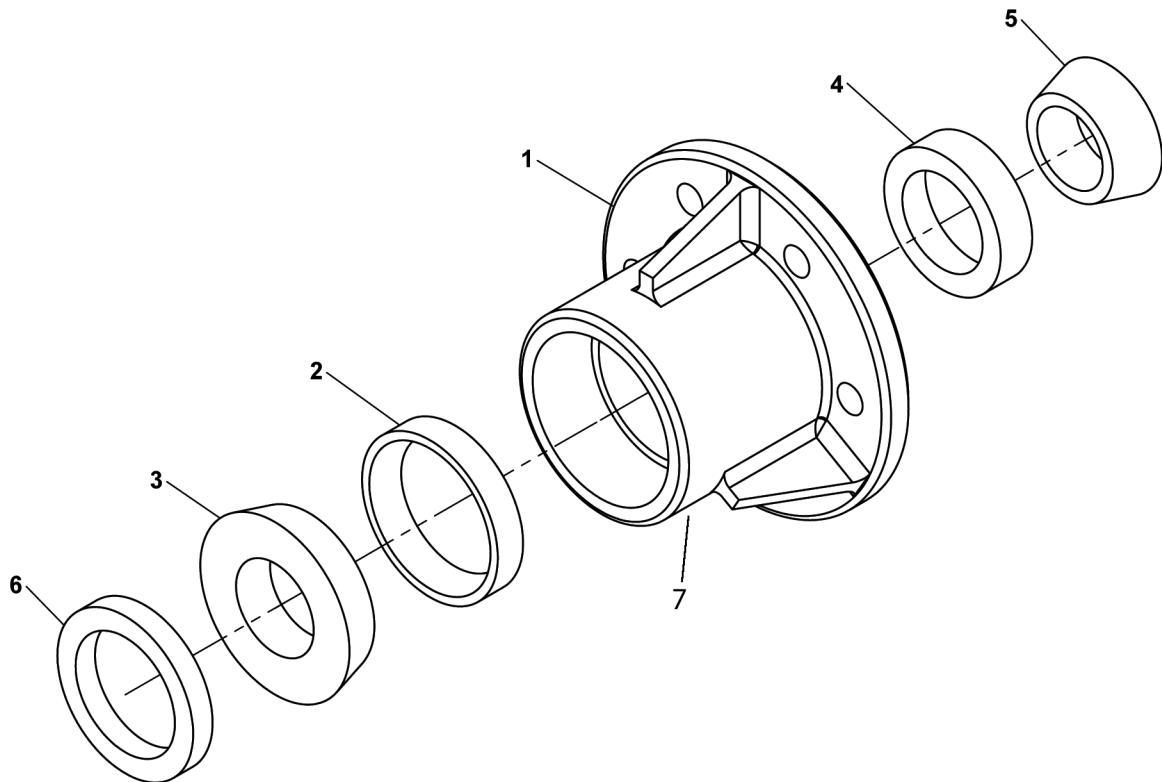
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0407	STRUT WELD - DIGGER	1
2	700-2-0464	SPINDLE WELD - (STD 22"-30")	1
3	700-2-0511	SPINDLE WELD - (17.7" ROWS)	1
3	900-01353	5/8 NC X 3 HEX BOLT GRADE 5	3
4	900-06013	NUT HEX 5/8 UNC	3
5	900-11015	WASHER, LOCK, 5/8	3
6	700-2-0410	HUB ASSY - DIGGER STRUT	2
7	900-06068	1-3/8 - 12 SLOTTED HEX NUT	2
8	120-3-0003	WASHER - 1.41 OD X 2.5 OD X .25	2
9	900-23064	COTTER PIN - 1/4 X 2	2
10	905-09129	DUST CAP- 3 OD X 2.25 DP	2
11	700-3-1056	SCRAPER BLADE - DIGGER STRUTS	2
12	900-03462	EYE BOLT 3/4 X 8	2
13	900-01425	HEX BOLT - 3/4NC X 6-1/2 GR5 ZP	2
14	905-98055	LIFTER WHEEL - VALLEY BEET	2
15	700-3-0303	LIFTER WHEEL - 28 CASTING (SUPERSEDED BY 905-98055)	2
15	700-3-1475	WHEEL SPACER - 3/8" (17.7" ROWS ONLY)	2
16	700-3-0447	WHEEL SPACER - 1/4" (22" ROWS ONLY)	4
OPTIONAL	700-3-3824	LIFTER WHEEL TAB	8
OPTIONAL	700-3-3863	FRONT SCRAPER MOUNT LH	1
OPTIONAL	700-3-3864	FRONT SCRAPER BLADE	2
OPTIONAL	700-3-3865	FRONT SCRAPER MOUNT RH	1
OPTIONAL	700-2-0323	WHEEL FILLER	2
	700-2-0409	STRUT ASSEMBLY (STD - REF 1-14)	1
	700-2-0512	STRUT ASSEMBLY (17.7" ROWS - REF 1-15)	1

SPINDLE HUB COMPONENTS



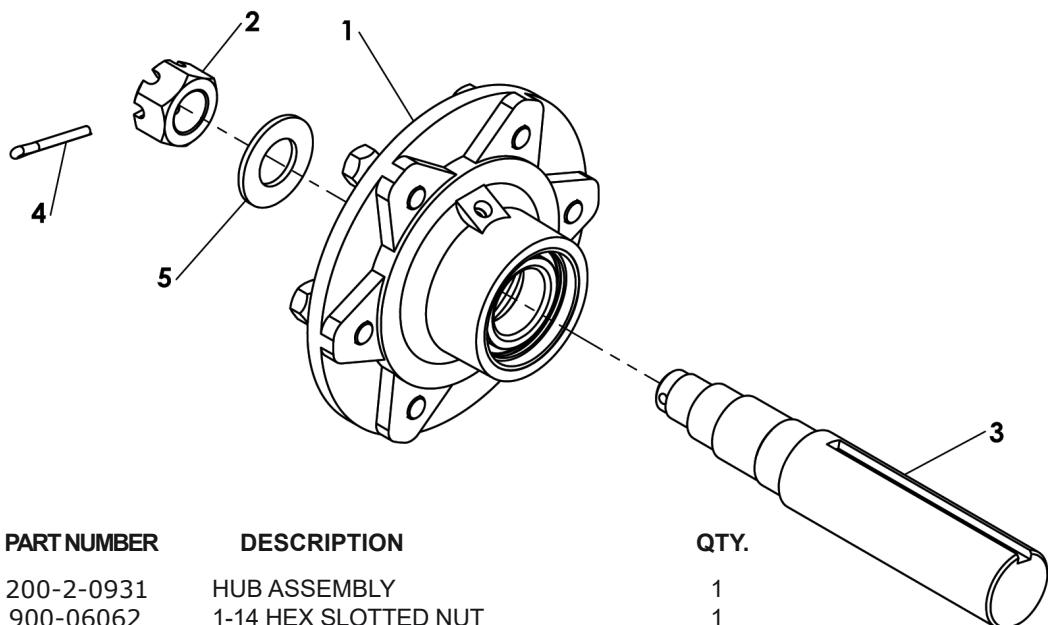
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-3-0143	SPINDLE REAR STRUT	1
2	905-09132	SLOTTED HEX NUT 7/8 -14 NF	1
3	905-09136	HUB - 8 BOLT	1
4	901-01324	BEARING CUP (OUTER)	1
5	905-09135	CAP	1
6	901-01325	BEARING CUP (INNER)	1
7	901-01152	BEARING CUP CONE	1
8	901-01326	BEARING CONE	1
9	901-09215	SEAL	1
10	905-09067	WASHER	1
11	905-09039	WHEEL BOLT 9/16-18 X 1-11/16	8
	700-2-0165	SPINDLE HUB ASSEMBLY	1

DIGGER STRUT HUB COMPONENTS

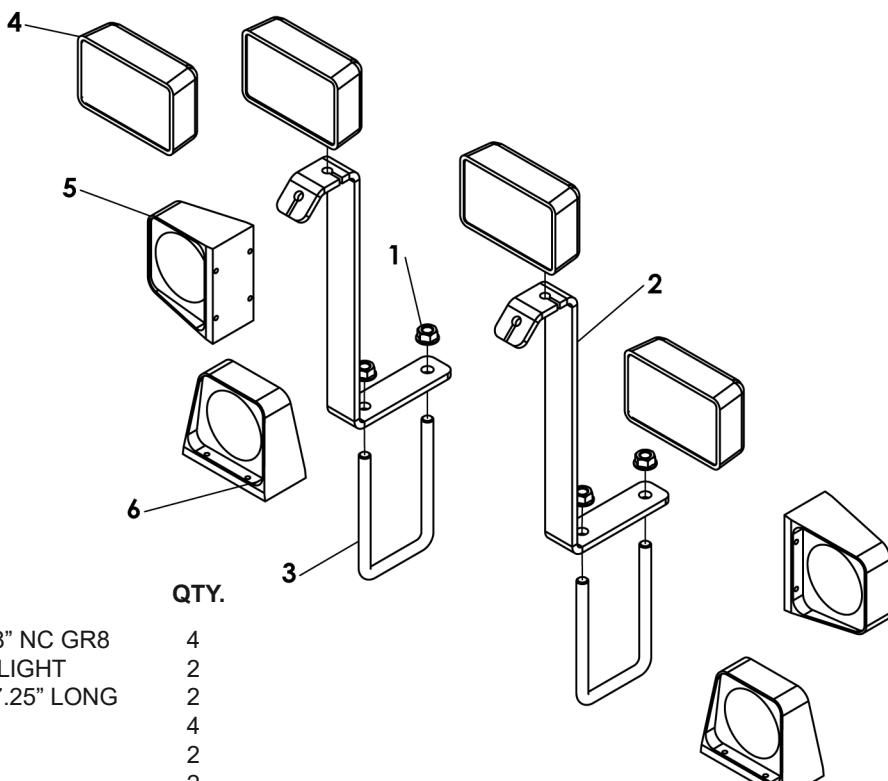


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-3-0275	HUB - MACHINED (DIGGER)	1
2	901-01319	BEARING CUP #362A	1
3	901-01320	BEARING CONE #368A	1
4	901-01321	BEARING CUP #26823	1
5	901-01322	BEARING CONE #26884	1
6	901-09214	SEAL - NATIONAL #415302	1
700-2-0410		HUB ASSY - DIGGER STRUT	

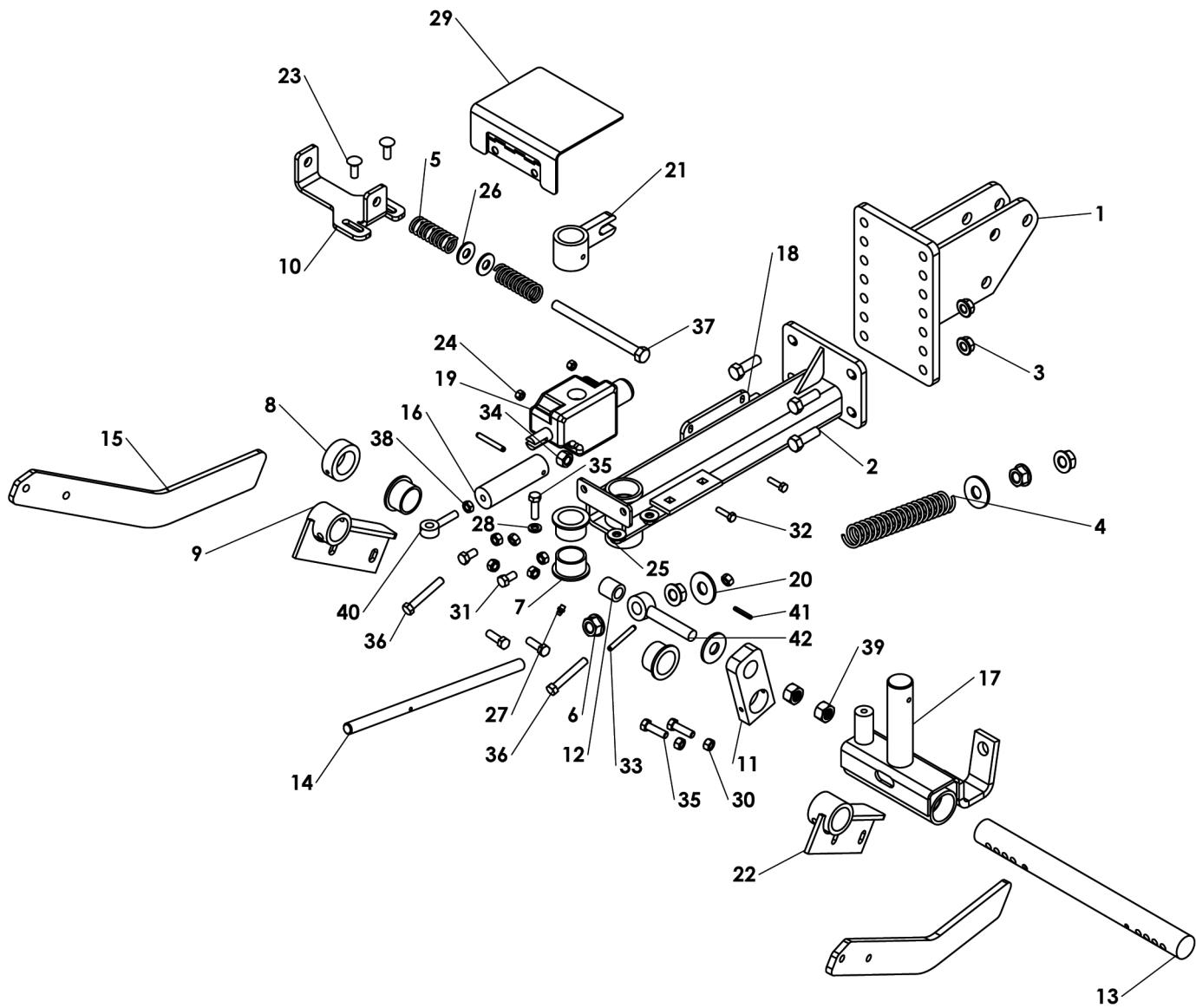
IDLER PULLEY HUB & SPINDLE COMPONENTS



LIGHT KIT COMPONENTS



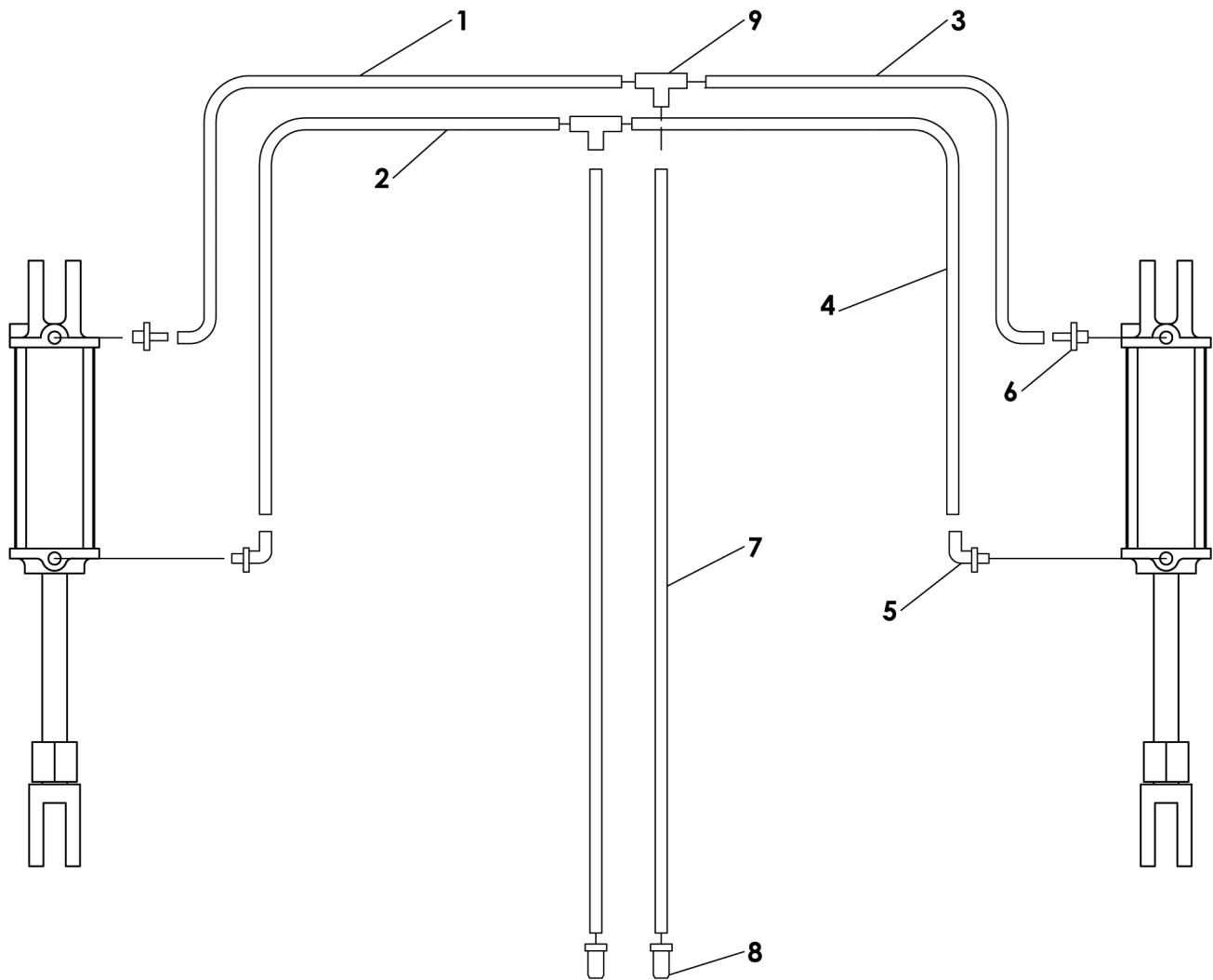
ROWFINDER COMPONENTS



ROWFINDER COMPONENTS

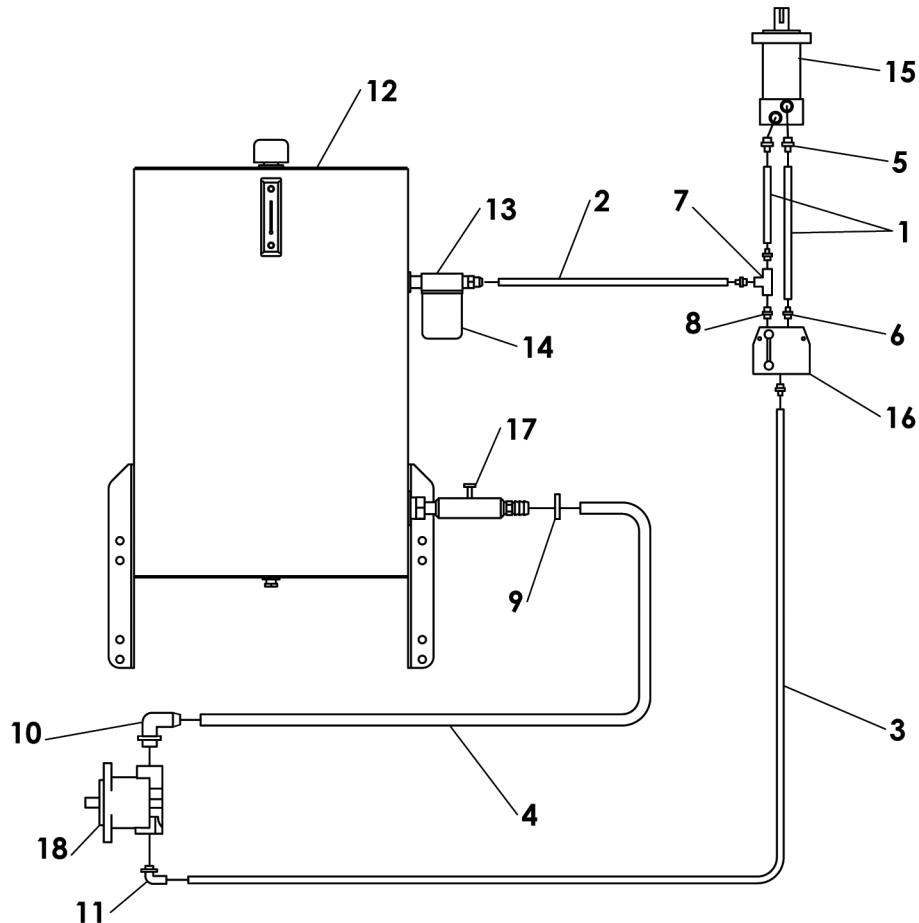
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0425	ADJ PLATE WELD - ROW FINDER	1
2	900-01225	1/2 NC X 1-1/2 HEX BOLT GR 5	4
3	900-06143	1/2 NC SPIRALOCK NUT ZP GR5	4
4	905-14007	SPRING - 1.245 OD X .148 WIRE X .4029 P X 7.75 LONG	1
5	905-14006	SPRING - 1.00 OD X .128 WIRE X 2.95 LONG X .2993 PITCH	2
6	900-06145	5/8 WHIZ NUT	4
7	700-3-0383	OILITE BUSHING - FF-1618-1	4
8	901-01323	SET COLLAR - 1.38	1
9	700-2-0123	FINGER WELD RH	1
10	700-3-0339	PLATE SPRING	1
11	700-3-0349	BLOCK DOWN PRESSURE	1
12	700-3-0350	BUSHING DOWN PRESSURE BLOCK	1
13	700-3-0351	SHAFT HORZ PIVOT	1
14	700-3-0352	ROD ROW FINDER	1
15	700-3-0356	FINGER	2
16	700-3-0382	SHAFT, TIE ROD-ROW FINDER	1
17	700-2-0112	PIVOT WELD	1
18	700-2-0103	PIVOT MOUNT WELD	1
19	905-03116	DIRECTIONAL CONTROL VALVE	1
20	900-11037	WASHER, FLAT, 5/8"	3
21	700-2-0106	STEERING PADDLE WELD	1
22	700-2-0124	FINGER WELD LH	1
23	900-01695	CARRIAGE BOLT 3/8 NC X 1 ZP	2
24	900-06001	1/4-20 HEX NUT	3
25	900-11033	FLAT WASHER 3/8 ZP	2
26	900-11035	1/2 FLAT WASHER	2
27	905-15024	ZERK 1/4-28 UNF STRAIGHT	1
28	900-11011	WASHER LOCK	1
29	700-2-0130	SHIELD WELDMENT	1
30	900-06500	NUT HEX 3/8 TOP LOCK	10
31	900-01105	3/8-16 X .75" HEX BOLT	2
32	900-01069	1/4 NC X 1-3/4 HEX BOLT	3
33	900-29182	1/4 X 2 ROLL PIN	2
34	900-06504	NUT HEX 1/2 NC TOP LOCK ZP	1
35	900-01111	3/8NC X 1-1/4 HEX BOLT GR 5	5
36	900-01121	3/8NC X 2-1/2 HEX BOLT GR 5	2
37	900-01255	HEX FL BOLT 1/2 UNC X 6-1/2	1
38	900-06273	HEX JAM NUT 3/8-NF (WIP)	1
39	900-06013	NUT HEX 5/8 UNC	2
40	903-05044	EYEBOLT - ROD END	1
41	900-29132	PIN ROLL 3/16 X 1-1/4	1
42	900-03465	EYE BOLT 5/8 X 3	1
	700-1-0019	HYDRAULIC ROWFINDER - COMPLETE	1

HITCH HYDRAULIC COMPONENTS



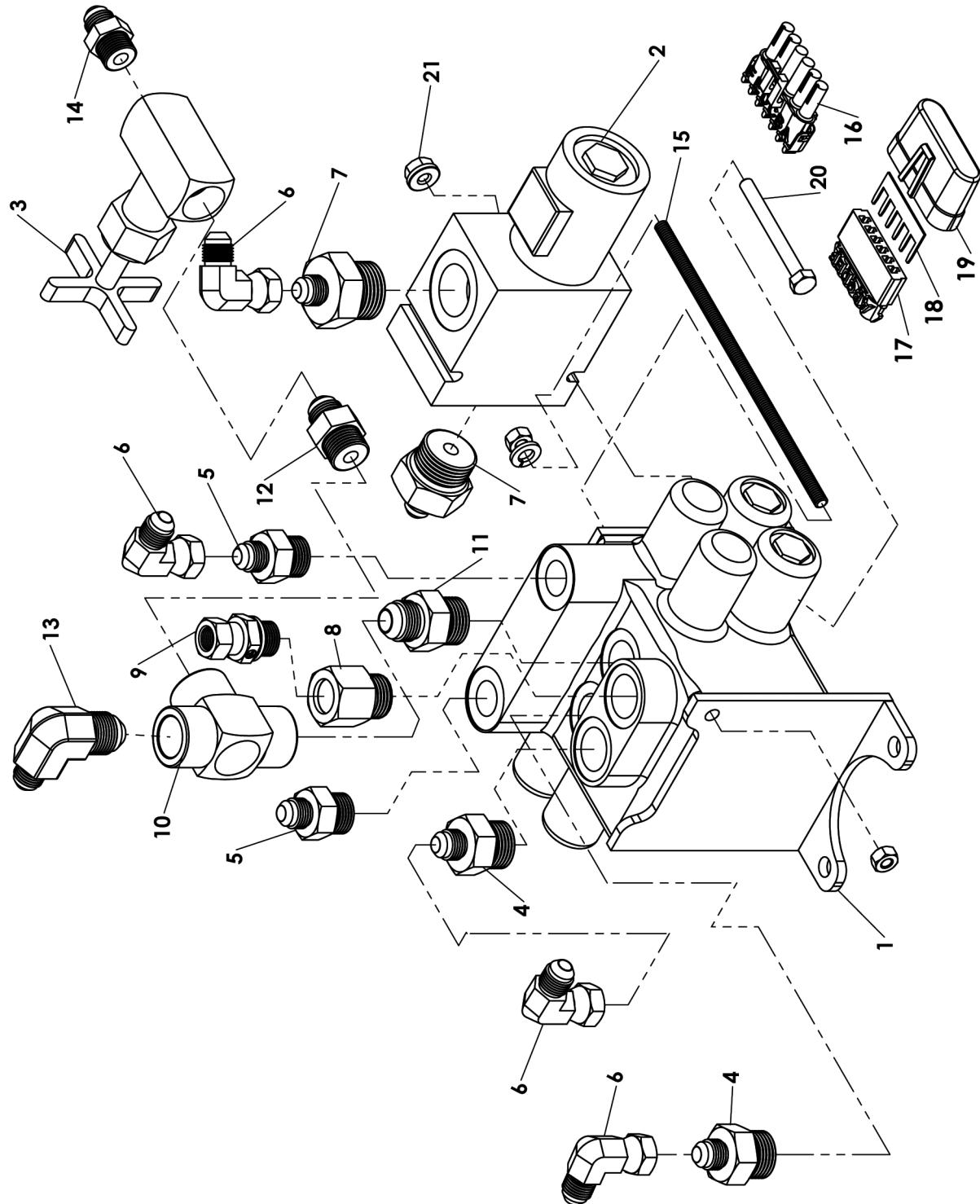
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	905-19192	HOSE 3/8", 6FJIC x 6FJIC x 18"	1
2	905-19191	HOSE 3/8", 6FJIC x 6FJIC x 24"	1
3	905-19190	HOSE 3/8", 6FJIC x 6FJIC x 30"	1
4	905-19189	HOSE 3/8", 6FJIC x 6FJIC x 42"	1
5	905-03114	ELBOW 90°, 6MJIC x 3/4-16MORB	2
6	905-03115	ADAPTER, 6MJIC x 3/4-16MORB	2
7	905-19210	HOSE 3/8", 6FJIC x 8MORBSVL x 120"	2
8	905-19126	QUICK COUPLER, MALE 8MORB	2
9	905-03112	TEE, 6MJIC	2
700-1-0021		HITCH, HYDRAULIC COMPONENT KIT	

REAR ELEVATOR HYDRAULIC COMPONENTS



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	905-19208	HOSE 1/2", 8FJIC x 8FJIC x 60"	2
2	905-19207	HOSE 1/2", 8FJIC x 8FJIC x 24"	1
3	905-19206	HOSE 1/2", 8FJIC x 8FJIC x 120"	1
4	905-19208	HOSE 1-1/4", 20FJIC (one end only) x 126"	1
5	905-03121	ADAPTER, 10MORB x 8MJIC	2
6	905-03200	ADAPTER, 12MPT x 8MJIC	4
7	905-03227	TEE, 12FPT	1
8	905-03201	NIPPLE, 12MPT x 12MPT	1
9	905-03217	HOSE CLAMP, 1-1/4" HOSE	1
10	905-03221	ELBOW 90°, 20MJIC x 20MORB	1
11	905-03222	ELBOW 90°, 8MJIC x 12MORB	1
12	700-2-0431	40 GAL HYDRAULIC TANK	1
13	905-03203	HYDRAULIC FILTER ASSEMBLY - 3/4 NPT	1
14	905-03204	HYDRAULIC FILTER	1
15	905-05223	HYDRAULIC MOTOR - CHAR-LYN 1041026	1
16	905-03218	TOP PORT FLOW CONTROL VALVE WITH RELIEF	1
17	905-03207	BRASS BALL VALVE - 3/4"	1
18	904-05244	HYDRAULIC PUMP #25504RSC	1
	700-1-0025	REAR ELEVATOR, HYDRAULIC COMPONENT KIT	1

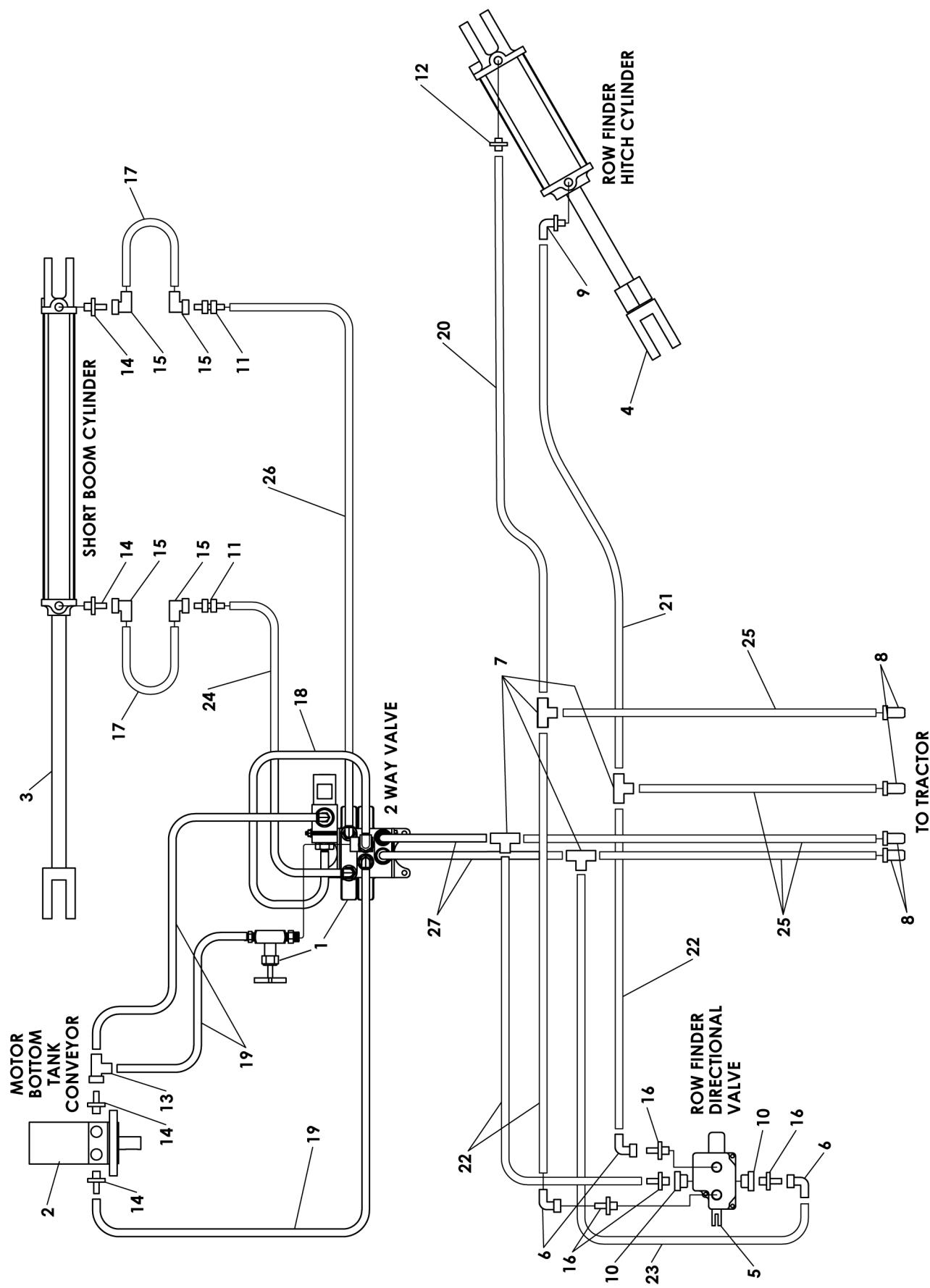
HYDRAULIC VALVE COMPONENTS



HYDRAULIC VALVE COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	905-03188	2 BANK VALVE - 38/36 SERIES	1
2	905-03189	DUMP VALVE	1
3	905-03209	NEEDLE VALVE	1
4	905-03198	ADAPTER, 10MORB-6MJIC	2
5	905-03212	ADAPTER, 6MJIC x 8MORB	2
6	905-03211	ELBOW 90°, 6MJIC x 6FJICSVL	4
7	905-03210	ADAPTER, 6MJIC x 12MORB	2
8	905-03214	ADAPTER, 10MORB x 6FPT	1
9	905-03215	ADAPTER, 6MPT x 6FJICSVL	1
10	905-03166	ADAPTER, 8FPT TEE	1
11	905-03213	ADAPTER, 8MPT x 10MORB	1
12	905-03216	ADAPTER, 6MPT-8MPT	1
13	905-03117	ELBOW 90°, 6MJIC x 8MPT	1
14	905-03129	ADAPTER, 6MJIC x 6MPT	1
15	700-3-1421	THREADED ROD FOR VALVE ASSY	1
16	904-01219	6 PRONG TOWER	1
17	904-01218	6 CONTACT SHROUD	1
18	904-01228	COMMON BAR, 6 GANG, SEAL SPLICE PACK	1
19	904-01233	CAVITY PLUG	1
20	900-01021	.25 UNC X 2 1/2 BOLT	1
21	900-06136	FLANGE WHIZ NUT, 1/4"-20	1
	700-2-0538	2 BANK VALVE - 38/36 SERIES WITH FITTINGS	1

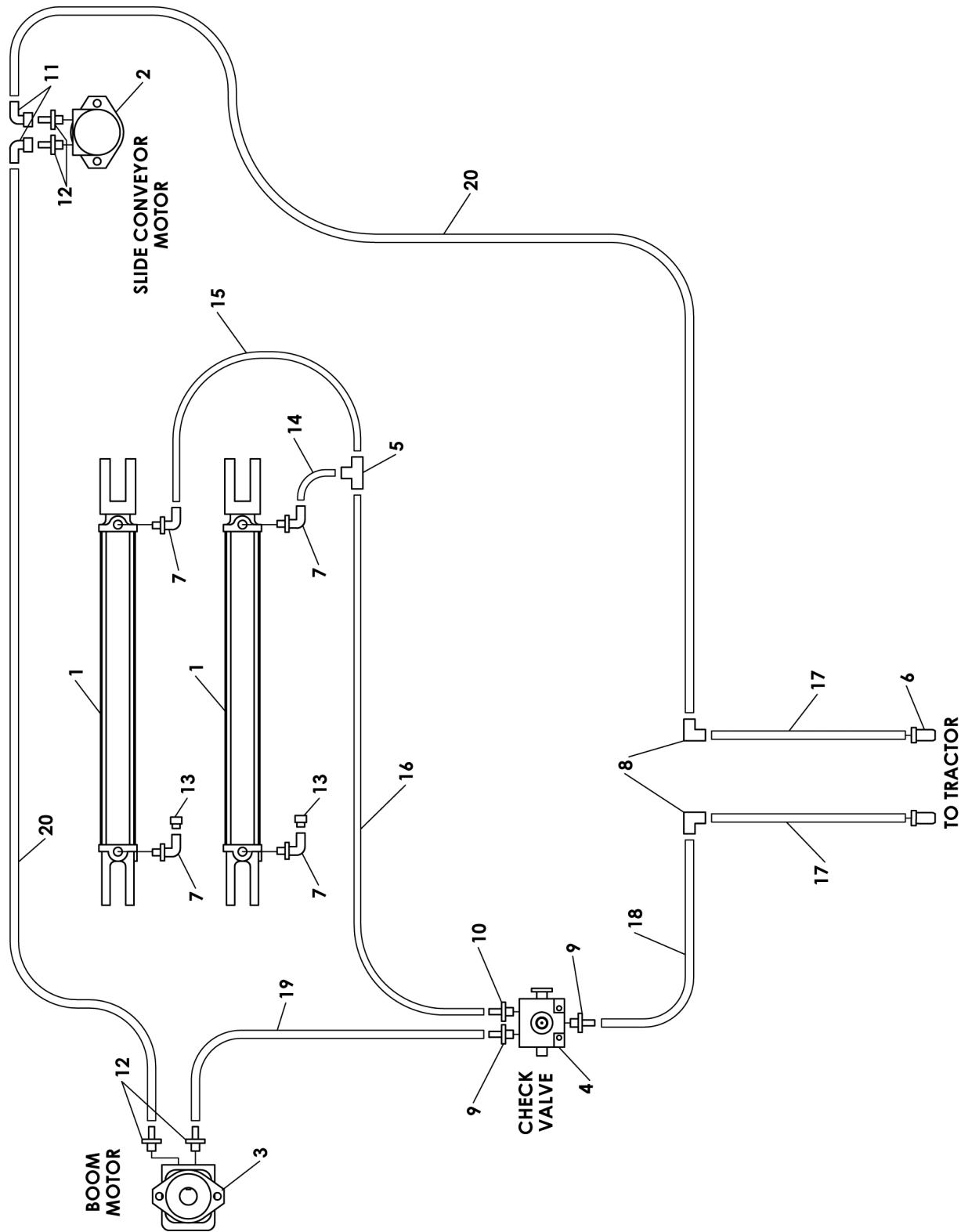
ROWFINDER AND ELECTRIC VALVE HYDRAULIC COMPONENTS



ROWFINDER AND ELECTRIC VALVE HYDRAULIC COMPONENTS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	700-2-0538	2 BANK VALVE - 38/36 SERIES WITH FITTINGS	1
2	904-05241	HYD MOTOR - CHAR-LYNN H SERIES 101-1040	1
3	905-21396	HYDRAULIC CYL 2 X 20 - (20TD20-112)	1
4	905-21400	HYD CYL - 3.5 X 8	1
5	905-03116	DIRECTIONAL CONTROL VALVE	1
6	905-03163	ELBOW 90°, 6MJIC x 6FJIC	3
7	905-03112	TEE 6MJIC	4
8	905-19126	QUICK COUPLER	4
9	905-03114	ELBOW 90°, 6MJIC X 3/4-16 MORB	1
10	905-03196	ADAPTER, 12MPT x 8FPT	2
11	905-03228	BULKHEAD STRAIGHT, 6MJIC x 6MJIC	2
12	905-03162	RESTRICTOR, 6MJIC x 8MORB	1
13	905-03199	TEE, 6FJIC x 6MJIC x 6MJIC	1
14	905-03198	ADAPTER, 10MORB x 6MJIC	4
15	905-03211	ELBOW 90°, 6FJIC x 6MJIC	4
16	905-03110	ADAPTER, 1/2MPT x 6MJIC	4
17	905-19217	HOSE 3/8", 6FJIC x 6FJIC, 10-1/2"	2
18	905-19192	HOSE 3/8", 6FJIC x 6FJIC, 18"	1
19	905-19191	HOSE 3/8", 6FJIC x 6FJIC, 24"	3
20	905-19169	HOSE 3/8", 6FJIC x 6FJIC, 54"	1
21	905-19197	HOSE 3/8", 6FJIC x 6FJIC, 60"	1
22	905-19195	HOSE 3/8", 6FJIC x 6FJIC, 66"	3
23	905-19196	HOSE 3/8", 6FJIC x 6FJIC, 72"	1
24	905-19203	HOSE 3/8", 6FJIC x 6FJIC, 112"	1
25	905-19155	HOSE 3/8", 6FJIC x 6FJIC, 120"	4
26	905-19202	HOSE 3/8", 6FJIC x 6FJIC, 136"	1
27	905-19171	HOSE 3/8", 6FJIC x 6FJIC, 193"	2

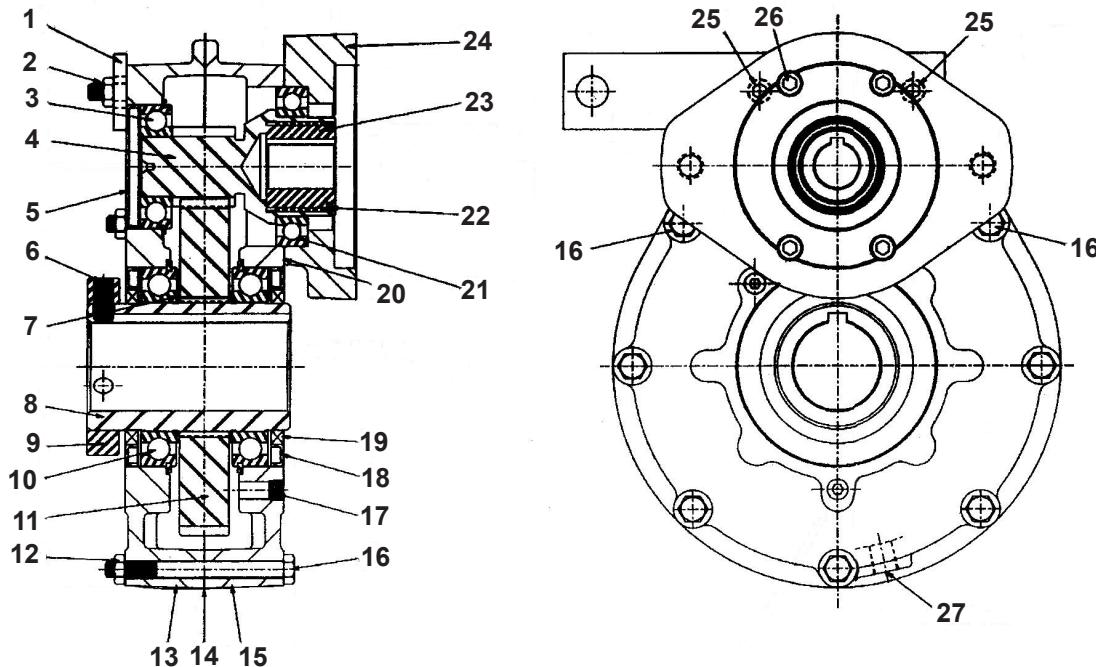
BOOM CONVEYOR HYDRAULIC COMPONENTS



BOOM CONVEYOR HYDRAULIC COMPONENTS

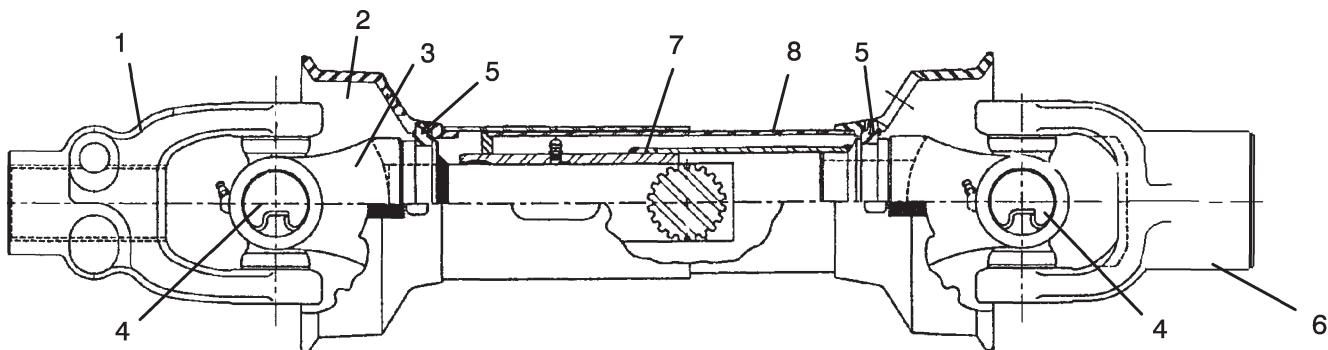
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	905-21396	HYDRAULIC CYL 2 X 20 - (20TD20-112)	2
2	904-05241	HYD MOTOR - CHAR-LYNN H SERIES 101-1040	1
3	904-05223	HYD MOTOR - CHAR-LYNN 1041026	1
4	905-03155	CHECK VALVE - 1/2 NPT PORTS	1
5	905-03112	TEE 6MJIC	1
6	905-19126	QUICK COUPLER	2
7	905-03114	ELBOW 90°, 6MJIC x 3/4-16 MORB	4
8	905-03194	ELBOW 90°, 8MJIC x 8MJIC	2
9	905-03107	ADAPTER, 1/2MPT x 8MJIC	2
10	905-03110	ADAPTER, 1/2MPT x 6MJIC	1
11	905-03195	ELBOW 90°, 8FJIC x 8MJIC	2
12	905-03121	ADAPTER, 10MORB x 8MJIC	4
13	905-03140	CAPS, 6FJIC (BREATHER), #830-FS-06	2
14	905-19192	HOSE 3/8", 6FJIC x 6FJIC x 18"	1
15	905-19194	HOSE 3/8", 6FJIC x 6FJIC x 90"	1
16	905-19193	HOSE 3/8", 6FJIC x 6FJIC x 106"	1
17	905-19211	HOSE 1/2", 8MORBSVL X 8FJIC x 120"	2
18	905-19204	HOSE 1/2", 8FJIC X 8FJIC x 132"	1
19	905-19205	HOSE 1/2", 8FJIC X 8FJIC x 155"	1
20	905-19184	HOSE, 1/2" 8FJICSVL X 8FJICSVL x 300"	2
	700-1-0022	TRUCK BOOM, HYDRAULIC COMPONENT KIT	1

PARALLEL SHAFT REDUCER - HUB CITY 85LH-B2



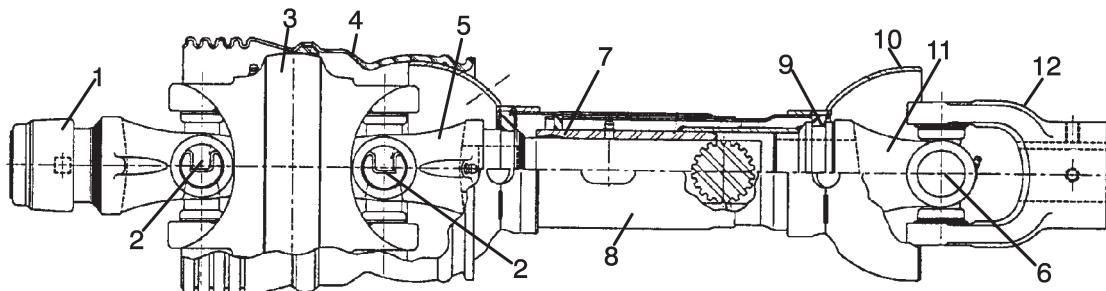
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	903-18278	PLATE, TORQUE	1
2	900-06003	NUT, HEX 5/16-18 NC	2
3	901-01373	BEARING, BALL 206-SG OR EQ	1
4	903-11091	GEAR, INTG SPUR 17T	1
5	905-01557	PLUG, EXPANSION	1
6	900-16255	SCREW, SOCKET SET GR8 3/8 NC x 3/4	3
7	903-18281	SPACER, SHIM	2
8	900-31076	SLEEVE, OUTPUT 1.750	1
9	900-31077	COLLAR, LOCKING	1
10	901-01374	BEARING, BALL 113-KSG OR EQ	2
11	903-11092	GEAR, SPUR 53T	1
12	900-06004	NUT, HEX 5/16NF	7
13	903-18279	HOUSING, HALF	1
14	905-05014	GASKET, CASE HALF	1
15	903-18280	HOUSING, HALF	1
16	900-01080	SCREW, HEX CAP GR 5 5/16 NF x 3-1/2	7
17	905-01558	PLUG, PIPE SOCKET 1/8 NPT HT	2
18	905-01559	PLUG, EXPANSION	2
19	901-09234	SEAL, TCH 253062SM	2
20	905-05015	GASKET, FLANGE TO GEARBOX	1
21	901-01375	BEARING, BALL 9110K OR EQ	1
22	900-29432	RING, RETAINING RR-168 OR EQ	1
23	901-01376	BUSHING	1
24	903-18282	FLANGE, MOTOR B2	1
25	900-16405	SCREW, SOCKET CAP 5/16 NC x 3-1/2	2
26	900-16396	SCREW, SOCKET CAP 5/16 NC x 1-1/4	4
27	905-01560	PLUG, PIPE SOCKET 1/4 NPT HT	1
28	905-05016	GASKET, FLANGE TO HYDRAULIC PUMP	1
29	905-01561	BREATHER, 1/4 NPT BRASS WIRE	1
30	901-09235	O-RING, - 240 OR EQ	1
31	903-15563	PARALLEL SHAFT REDUCER - HUB CITY 85LH-B2	1

PTO SHAFT - WEASLER (STANDARD)



REF.	PART NUMBER	DESCRIPTION	QTY.	REF.	PART NUMBER	DESCRIPTION	QTY.
1	903-17472	Q.D. Yoke Assembly (1-3/8")	1	6	903-17475	Yoke	2
	903-18068	Q.D. Repair Kit (1-3/8")	1	7	903-18063	Yoke, Tube & Slip Sleeve	1
	903-17531	Q.D. Yoke Assembly (1-3/4")	1	8	903-18062	Inner Guard	1
	903-17729	Q.D. Repair Kit (1-3/4")	1		903-18054	PTO Shaft (1-3/4"), complete	1
2	903-18069	Outer Guard	1		903-18053	PTO Shaft (1-3/8"), complete	1
3	903-18070	Yoke & Shaft	1		903-18072	Tractor Half With Guard, 1-3/8"	1
4	903-17525	44R Cross & Bearing Kit	2		903-18071	Tractor Half With Guard, 1-3/4"	1
5	903-17851	Nylon Bearing	2		903-18066	Implement Half With Guard	

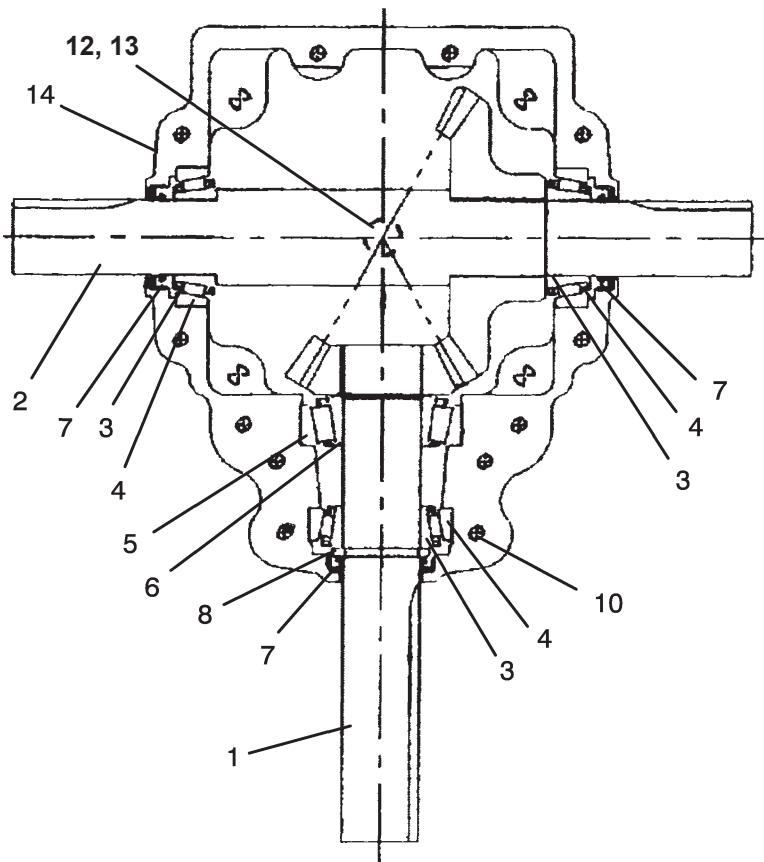
PTO SHAFT - WEASLER (CONSTANT VELOCITY)



REF.	PART NUMBER	DESCRIPTION	QTY.	REF.	PART NUMBER	DESCRIPTION	QTY.
1	903-17711	Safety Slide Lock Yoke Assembly, 1-3/8"	1	8	903-18103	Outer Guard	1
	903-18106	Repair Kit, 1-3/8"	1	9	903-17851	Nylon Bearing Repair Kit	1
	903-17771	Safety Slide Lock Yoke Assembly, 1-3/4"	1	10	903-18102	Inner Guard	1
	903-17772	Repair Kit, 1-3/4"	1	11	903-18101	Yoke, Tube & Slip Sleeve	1
2	903-17712	Cross & Bearing Kit	2	12	903-17475	Yoke	1
3	903-17713	Center Housing Assembly	1		903-18091	PTO Shaft, 1-3/8" Complete	1
4	903-17714	Bell Extension	1		903-18090	PTO Shaft, 1-3/4" Complete	1
5	903-18105	Yoke & Shaft	1		903-18098	PTO Half With Guard, 1-3/8" tractor half	
6	903-17525	Cross & Bearing Kit	1		903-18099	PTO Half With Guard, 1-3/4" tractor Half	
7	903-18104	Nylon Bearing Repair Kit	1		903-18100	PTO Half With Guard, Implement	

GEARBOX - SUPERIOR (3-WAY)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	903-15550	Assy, Pinion Shaft\Gear	1
2	903-15551	Assy, Cross Shaft\Gear	1
3	901-01150	Bearing Cone	3
4	901-01152	Bearing Cup	3
5	901-01153	Bearing Cup	1
6	901-01151	Bearing Cone	1
7	901-09125	Seal, 1-3/4"	3
8	900-39030	Retaining Ring, 1-3/4"	1
10	900-03033	3/8 NC x 2-1/4 Socket Head Cap Screw	12
11	905-03078	Plug (1/2 NPT)	1
12	905-01159	Bushing, 1/2 NPT to 1/8 NPT	1
13	905-03080	Plug, Pressure Relief	1
14	903-15548	Casting Machined, Threaded(1.857:1)	1
15	903-15549	Casting Machined	1
	903-15547	(1.857:1) Gearbox, Complete	1

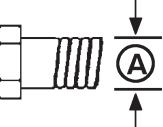


BOLT TORQUE CHART

SAE Series Torque Chart

Always tighten hardware to these values unless a different torque value or tightening procedure is listed for a specific application. Fasteners must always be replaced with the same grade as specified in the manual parts list.

Make sure fastener threads are clean and you properly start thread engagement.

SAE Bolt Head Identification		 SAE Grade 2 (No Dashes)		 SAE Grade 5 (3 Radial Dashes)		 SAE Grade 8 (6 Radial Dashes)	
Ⓐ Diameter (Inches)	Wrench Size	MARKING ON HEAD					
		SAE 2		SAE 5		SAE 8	
		ft./lb.	(Nm)	ft./lb.	(Nm)	ft./lb.	(Nm)
1/4"	7/16'	6	(8)	10	(13)	14	(18)
5/16"	1/2"	12	(17)	19	(26)	27	(37)
3/8"	9/16"	23	(31)	35	(47)	49	(67)
7/16"	5/8"	36	(48)	55	(75)	78	(106)
1/2"	3/4"	55	(75)	85	(115)	120	(163)
9/16"	13/16"	78	(106)	121	(164)	171	(232)
5/8"	15/16"	110	(149)	170	(230)	240	(325)
3/4"	1-1/8"	192	(261)	297	(403)	420	(569)
7/8"	1-5/16"	306	(416)	474	(642)	669	(907)
1"	1-1/2"	350	(475)	680	(925)	1020	(1383)
1-1/8"	1-11/16"	450	(610)	885	(1200)	Bolt Diameter	
1-1/4"	1-7/8"	600	(815)	1255	(1700)		
1-3/8"	2-1/16"	675	(915)	1620	(2200)		
1-1/2"	2-1/4"	920	(1250)	2200	(2900)		

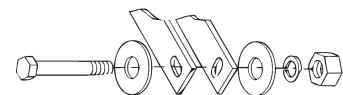
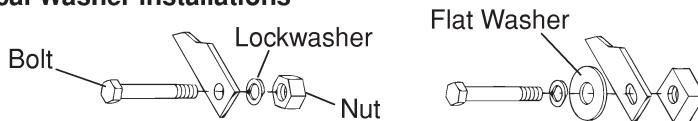
Metric Series Torque Chart

Use only metric tools on metric hardware. Always tighten hardware to these values unless a different torque value or tightening procedure is listed for a specific application. Fasteners must always be replaced with the same grade.

Make sure fastener threads are clean and you properly start thread engagement.

Ⓐ Diameter & Thread Pitch (Millimeters)	Wrench Size	COARSE THREAD				FINE THREAD				Ⓐ Diameter & Thread Pitch (Millimeters)	Metric Bolt Head Identification		
		MARKING ON HEAD				MARKING ON HEAD							
		Metric 8.8		Metric 10.9		Metric 8.8		Metric 10.9					
		Nm	ft./lb.	Nm	ft./lb.	Nm	ft./lb.	Nm	ft./lb.				
6x1.0	10 mm	8	6	11	8	8	6	11	8	6x1.0	 Metric Grade 8.8		
8x1.25	13 mm	20	15	27	20	21	16	29	22	8x1.0	 Metric Grade 10.9		
10x1.5	16 mm	39	29	54	40	41	30	57	42	10x1.25			
12x1.75	18 mm	68	50	94	70	75	55	103	76	12x1.25			
14x2.0	21 mm	109	80	151	111	118	87	163	120	14x1.5			
16x2.0	24 mm	169	125	234	173	181	133	250	184	16x1.5			
18x2.5	27 mm	234	172	323	239	263	194	363	268	18x1.5			
20 x 2.5	30 mm	330	244	457	337	367	270	507	374	20x1.5			
22 x 2.5	34 mm	451	332	623	460	495	365	684	505	22 x 1.5			
24 x 3.0	36 mm	571	421	790	583	623	459	861	635	24 x 2.0			
30 x 3.0	46 mm	1175	867	1626	1199	1258	928	1740	1283	30 x 2.0			

Typical Washer Installations



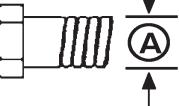
8/9/00

BOLT TORQUE CHART

SAE Series Torque Chart

Always tighten hardware to these values unless a different torque value or tightening procedure is listed for a specific application. Fasteners must always be replaced with the same grade as specified in the manual parts list.

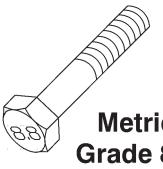
Make sure fastener threads are clean and you properly start thread engagement.

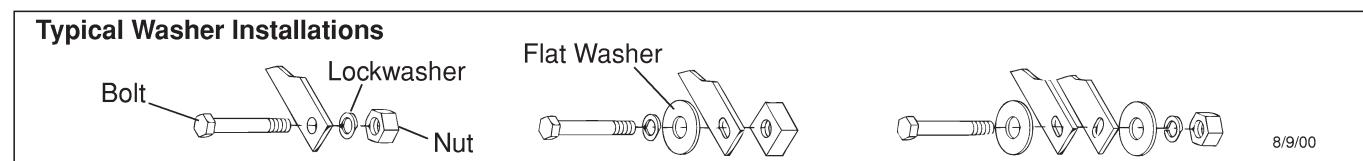
SAE Bolt Head Identification		 SAE Grade 2 (No Dashes)		 SAE Grade 5 (3 Radial Dashes)		 SAE Grade 8 (6 Radial Dashes)	
(A) Diameter (Inches)	Wrench Size	MARKING ON HEAD					
		SAE 2		SAE 5		SAE 8	
ft./lb.	(Nm)	ft./lb.	(Nm)	ft./lb.	(Nm)	ft./lb.	(Nm)
1/4"	7/16'	6	(8)	10	(13)	14	(18)
5/16"	1/2"	12	(17)	19	(26)	27	(37)
3/8"	9/16"	23	(31)	35	(47)	49	(67)
7/16"	5/8"	36	(48)	55	(75)	78	(106)
1/2"	3/4"	55	(75)	85	(115)	120	(163)
9/16"	13/16"	78	(106)	121	(164)	171	(232)
5/8"	15/16"	110	(149)	170	(230)	240	(325)
3/4"	1-1/8"	192	(261)	297	(403)	420	(569)
7/8"	1-5/16"	306	(416)	474	(642)	669	(907)
1"	1-1/2"	350	(475)	680	(925)	1020	(1383)
1-1/8"	1-11/16"	450	(610)	885	(1200)	Torque meter	
1-1/4"	1-7/8"	600	(815)	1255	(1700)		
1-3/8"	2-1/16"	675	(915)	1620	(2200)		
1-1/2"	2-1/4"	920	(1250)	2200	(2900)		

Metric Series Torque Chart

Use only metric tools on metric hardware. Always tighten hardware to these values unless a different torque value or tightening procedure is listed for a specific application. Fasteners must always be replaced with the same grade.

Make sure fastener threads are clean and you properly start thread engagement.

(A) Diameter & Thread Pitch (Millimeters)	Wrench Size	COARSE THREAD				FINE THREAD				(A) Diameter & Thread Pitch (Millimeters)	Metric Bolt Head Identification		
		MARKING ON HEAD				MARKING ON HEAD							
		Metric 8.8		Metric 10.9		Metric 8.8		Metric 10.9					
		Nm	ft./lb.	Nm	ft./lb.	Nm	ft./lb.	Nm	ft./lb.				
6x1.0	10 mm	8	6	11	8	8	6	11	8	6x1.0	 Metric Grade 8.8		
8x1.25	13 mm	20	15	27	20	21	16	29	22	8x1.0			
10x1.5	16 mm	39	29	54	40	41	30	57	42	10x1.25			
12x1.75	18 mm	68	50	94	70	75	55	103	76	12x1.25			
14x2.0	21 mm	109	80	151	111	118	87	163	120	14x1.5			
16x2.0	24 mm	169	125	234	173	181	133	250	184	16x1.5			
18x2.5	27 mm	234	172	323	239	263	194	363	268	18x1.5			
20 x 2.5	30 mm	330	244	457	337	367	270	507	374	20x1.5			
22 x 2.5	34 mm	451	332	623	460	495	365	684	505	22 x 1.5			
24 x 3.0	36 mm	571	421	790	583	623	459	861	635	24 x 2.0			
30 x 3.0	46 mm	1175	867	1626	1199	1258	928	1740	1283	30 x 2.0			



INDEX

CHECK LISTS

- Delivery Check List(Dealer's Responsibility), 3
- Pre-Delivery Check List(Dealer's Responsibility), 3
- Pre-Operation Check List(Owner's Responsibility), 13

GENERAL

- Bolt Size Chart, 71
- Bolt Torque Chart, 72
- General Information, 1
- Introduction, 2
- Specifications, 2
- Table of Contents, 1
- Warranty, 74

OPERATION

- Attaching Tractor to the Harvester, 15
- Beet Harvester Components, 13
- Depth Stops and Transport Locks, 16
- Equipment Matching, 14
 - Electrical System, 15
 - Hitch Requirements, 15
 - Hydraulic System, 15
 - PTO, 15
 - Tire Requirements, 14
 - Tractor Ballast, 15
- Field Operation, 16
 - Depth Stops and Transport Locks, 16
 - Flexing Lifter Struts (Optional), 21
 - Grab Roll Bed Rods, 20
 - Grab Rolls, 20
 - Holding Tank/Truck Boom, Load Tank, 19
 - Holding Tank/Truck Boom, Unload Tank, 19
 - Lifter Wheels, 20
 - Paddle Shaft, 21
 - PTO Engagement, 20
 - Raising and Lowering the Harvester, 16
 - Row Finder, 19
 - Row Finder Override, 19
 - Truck Boom, Lower, 18
 - Truck Boom, Raise, 18
 - Truck Boom Conveyer Chain, 21
 - Truck Boom Motor Speed, Adjust, 19
 - Vertical Elevator, 21
 - Wheel Fillers, 21
 - Wheel Scrapers, 21
 - Pre-Operation Check List (Owner's Responsibility), 13
 - Storage, 22
 - Transporting, 21
 - Unhooking the Tractor from the Harvester, 16

OWNER SERVICE

- Blocking Method for Lifter Wheels and Row Finder Service, 23
- Daily Service, 24
- Lubrication, 24

OWNER SERVICE *(Continued)*

- Lubrication Chart, 27
- Maintenance, 28
 - Belt Replacement (New Belt), 28
 - Elevator Chain Cross Rod Replacement, 29
 - Elevator Chain Routing and Roller Location, 29
 - Elevator Speed Adjustment, 29
 - Grab Roll Adjustment, 31
 - Holding Tank Chain Glides, 31
 - Lifter Strut Adjustment, 32
 - Lifter Wheel Fillers, 32
 - Paddle Shaft, Elevator and Unloader Drive Chains, 28
- Truck Boom Service, 24

PARTS INDEX, 35

SAFETY

- Check Lists
 - Delivery (Dealer's Responsibility), 3
 - Pre-Delivery (Dealer's Responsibility), 3
 - Pre-Operation (Owner's Responsibility), 13
 - Safety & Instructional Decals, 8
 - Safety-Alert Symbol (Explanation), 2
 - Safety Rules, 4

WARRANTY

Please enter information below and **SAVE FOR FUTURE REFERENCE.**

Date Purchased: _____

From (Dealer): _____

Model Number: _____

Serial Number: _____

ALLOWAY warrants each new ALLOWAY product to be free from defects in material and workmanship. This warranty is applicable only for the normal service life expectancy of the machine or components, not to exceed twelve consecutive months from the date of delivery of the new ALLOWAY product to the original purchaser.

Genuine ALLOWAY replacement parts and components will be warranted for 90 days from date of purchase, or the remainder of the original equipment warranty period, whichever is longer.

Under no circumstances will it cover any merchandise or components thereof, which, in the opinion of the company, has been subjected to negligent handling, misuse, alteration, an accident, or if repairs have been made with parts other than those obtainable through ALLOWAY.

The company in no way warrants engines, batteries, tires or other trade accessories since these items are warranted separately by their respective manufacturers.

Our obligation under this warranty shall be limited to repairing or replacing, free of charge to the original purchaser, any part that in our judgement shall show evidence of such defect, provided further that such part shall be returned within thirty (30) days from date of failure to ALLOWAY, routed through the dealer and distributor from whom the purchase was made, transportation charges prepaid.

This warranty shall not be interpreted to render us liable for injury or damages of any kind or nature to person or property. This warranty does not extend to loss of crops, loss because of delay in harvesting, or any expense or loss incurred for labor, supplies, substitute machinery, rental or for any other reason.

Except as set forth above, ALLOWAY SHALL HAVE NO OBLIGATION OR LIABILITY OF ANY KIND ON ACCOUNT OF ANY OF ITS EQUIPMENT AND SHALL NOT BE LIABLE FOR SPECIAL OR CONSEQUENTIAL DAMAGES. ALLOWAY MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED, AND, SPECIFICALLY, ALLOWAY DISCLAIMS ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SOME STATES OR PROVINCES DO NOT PERMIT LIMITATIONS OR EXCLUSIONS OF IMPLIED WARRANTIES OR INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE LIMITATIONS OR EXCLUSIONS IN THIS WARRANTY MAY NOT APPLY.

This warranty is subject to any existing conditions of supply which may directly affect our ability to obtain materials or manufacture replacement parts.

ALLOWAY reserves the right to make improvements in design or changes in specifications at any time, without incurring any obligations to owners of units previously sold.

No one is authorized to alter, modify, or enlarge this warranty nor the exclusions, limitations and reservations.

The logo for ALLOWAY. The word "ALLOWAY" is written in a bold, black, sans-serif font. To the right of the "Y" in "ALLOWAY" is a graphic element consisting of three yellow diagonal bars of increasing height, resembling a stylized mountain or a bar chart.

PART NUMBER
700-3-1574

Alloway Equipment Company

4230 14th Ave NW. Fargo, ND 58102

877-275-8714 tel

701-356-4985 fax

ALLOWAY 