

ARTS-WAY

**MODEL 680B
BEET HARVESTER**

PARTS MANUAL

ART'S-WAY MANUFACTURING CO., INC.
ARMSTRONG, IOWA 50514
(712) 864-3131

248870 (C)

0691

WORK SAFELY - FOLLOW THESE RULES

A CAREFUL OPERATOR IS THE BEST INSURANCE AGAINST AN ACCIDENT



CAUTION! Before handling ANY equipment, READ the OPERATOR'S MANUAL.

Always use proper safety precautions. Tell your workers how to work safely.

BEFORE OPERATING

Do not wear loose fitting clothing; it may catch in moving parts.

Make sure that all safety shields, including the tractor power take-off master shield, are in place and properly secured before operating the machine.

Be sure that the correct implement drive line parts are used and that they are properly secured.

After servicing, be sure that all tools, parts or servicing equipment are removed from the machine.

Make sure that there is no one near the machine before starting it.

Be sure the tractor power take-off is disengaged before starting the tractor engine.

Lower the lifter wheels when harvester is not in use.

Make sure the unit is adequately blocked before working on it.

DURING OPERATION

Shut off the tractor engine, put key in pocket, and be sure to wait until all rotation has come to a complete stop before opening any covers, adjusting, cleaning, or lubricating.

No riders while machine is in operation.

Do not attempt to unclog, clean, or adjust machine while it is running.

Keep all shields and guards in place.

Keep hands, feet and clothing away from moving parts.

Keep children and bystanders away from the machine while in operation.

Apply brakes evenly when making emergency stops. Plan ahead.

Hydraulic fluid escaping under pressure can have enough force to penetrate the skin. Hydraulic fluid may also infect a minor cut or opening in the skin. If injured by escaping fluid, see a doctor at once. Serious infection or reaction can result if medical treatment is not given immediately. Make sure all connections are tight and that hoses and lines are in good condition before applying pressure to the system. Relieve all pressure before disconnecting the lines or performing other work on the hydraulic system. To find a leak under pressure use a small piece of cardboard or wood: Never use hands.

TRANSPORTING

Always use the safety chain and secure safely.

Do not fail to latch the tractor brakes together.

Tow at a maximum of 10 M.P.H. over rough roads and when going down inclines.

Maximum towing speed - 20 M.P.H.

Drive slowly when turning.

The weight of the trailed machine should **NEVER** exceed the weight of the towing vehicle.

Always use SMV (slow moving vehicle) emblem.

For daytime and nighttime, accessory light and devices should be used for adequate warning to operators of other vehicles.

Comply with your state and local laws governing highway safety, and with regulations when moving machinery on a highway.

Check clearances carefully wherever machine is towed.

Always raise the lifter wheels before transporting.

Always swing the truck loading elevator **IN** before transporting.

TO THE OWNER

This Art's-Way unit is another one of the fine products made and the purpose of this manual is to assist you in realizing the benefits you anticipated when you purchased this unit. Many people have contributed to the production of this product. They all have an interest in its successful performance and we are providing the operators manual to give you the benefit of the experience we have gained through years of building and testing this equipment. The way you operate and the care you give this unit will have much to do with the successful performance of this unit. The operators manual has been carefully prepared and illustrated to make it as easy as possible for you in the operation of your unit. It will pay you to read the entire manual carefully and familiarize yourself with all operations "before operating" this unit. Keep this manual handy for reference. We will be glad to answer any questions you may have. For further information call or write Art's-Way Manufacturing Co., Inc. (712) 864-3131, Armstrong, IA 50514.

LIMITED WARRANTY

The **ART'S-WAY MANUFACTURING CO., INC.** warrants products sold by it to be free from defects in material and workmanship for a period of one(1) **YEAR** after the date of delivery to the first purchaser subject to the following conditions:

(1) **ART'S-WAY MANUFACTURING CO., INC.'S** obligation and liability under this warranty is to repair or replace at the company's option, any parts which upon manufacture were defective in material or workmanship.

(2) All parts and repairs under this warranty shall be supplied at an authorized **ART'S-WAY MANUFACTURING CO., INC.** dealer or at the factory at the option of **ART'S-WAY MANUFACTURING CO., INC.**

(3) **ART'S-WAY MANUFACTURING CO., INC.'S** warranty does not extend to parts and elements not manufactured by **ART'S-WAY MANUFACTURING CO., INC.** and which carry the warranty of the other manufacturer.

(4) Transportation or shipping to an authorized dealer for necessary repairs is at the expense of the purchaser.

(5) ART'S-WAY MANUFACTURING CO., INC. MAKES NO OTHER WARRANTY EXPRESSED OR IMPLIED AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE BEYOND THAT EXPRESSLY STATED IN THIS WARRANTY. ART'S-WAY MANUFACTURING CO., INC.'S LIABILITY IS LIMITED TO THE TERMS SET FORTH IN THIS WARRANTY AND DOES NOT INCLUDE ANY LIABILITY FOR DIRECT, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES OR EXPENSE OF DELAY AND THE COMPANY'S LIABILITY IS LIMITED TO REPAIR OR REPLACEMENT OF DEFECTIVE PARTS AS SET FORTH HEREIN IN THE WARRANTY.

(6) Any improper use, including operation after discovery of defective or worn parts, operation beyond rated capacity, substitution or parts not approved by **ART'S-WAY MANUFACTURING CO., INC.**, or any alteration or repair by other than an authorized **ART'S-WAY MANUFACTURING CO., INC.** dealer which affects the product materially and adversely, shall void this warranty.

(7) No dealer, employee or representative is authorized to change this warranty in any way or grant any other warranty unless such change is made in writing and signed by an officer of **ART'S-WAY MANUFACTURING CO., INC.** at its home office.

(8) Some states do not allow limitations on how long an implied warranty lasts or exclusions of or limitations on relief such as incidental or consequential damages so the above limitations or exclusions may not apply to you. This warranty gives you specific legal rights and you may have other rights which vary from state to state.

ACCIDENTS can be prevented

A large number of accidents can be prevented by the operator anticipating the result before it happens and doing something about it. No power-driven equipment can be safer than the man at the controls.

The manufacturer is striving to make the equipment safe, but one careless act by the operator can void all such efforts.

The best kind of a safety device is a careful operator. **BE THAT KIND OF AN OPERATOR**, as no accident-prevention program can be a success without the co-operation of the operator of the equipment.

INFORMATION FOR ORDERING PARTS

OWNERS NAME _____

ADDRESS _____

DEALERS NAME _____

ADDRESS _____

SERIAL NUMBER _____

DATE PURCHASED _____

A Careful Operator

IS THE BEST INSURANCE

AGAINST AN ACCIDENT

National Safety Council

Art's-Way reserves the right to make changes or add improvements to its products at any time without incurring any obligation to make such changes to products manufactured previously. Art's-Way, or its dealers, accept no responsibility for variations which maybe evident in the actual specifications of its products and the statements and descriptions contained in this publication.

THE IMPORTANCE OF ADEQUATE PARTS AND SERVICE

The wise purchaser of a new machine gives consideration to the following factors:

1. ORIGINAL QUALITY
2. AVAILABILITY OF SERVICE PARTS
3. AVAILABILITY OF ADEQUATE SERVICE FACILITIES

In many cases the machine becomes the only means of performing certain tasks that must be done in a limited period of time. Wear and even breakage of parts are to be expected due to operating conditions. However, the user can still be assured of getting his work done on time if service parts and adequate service facilities are available.

Foresighted Art's-Way dealers make every effort to provide good service and maintain a completely adequate stock of service parts.

NOTICE TO CUSTOMER

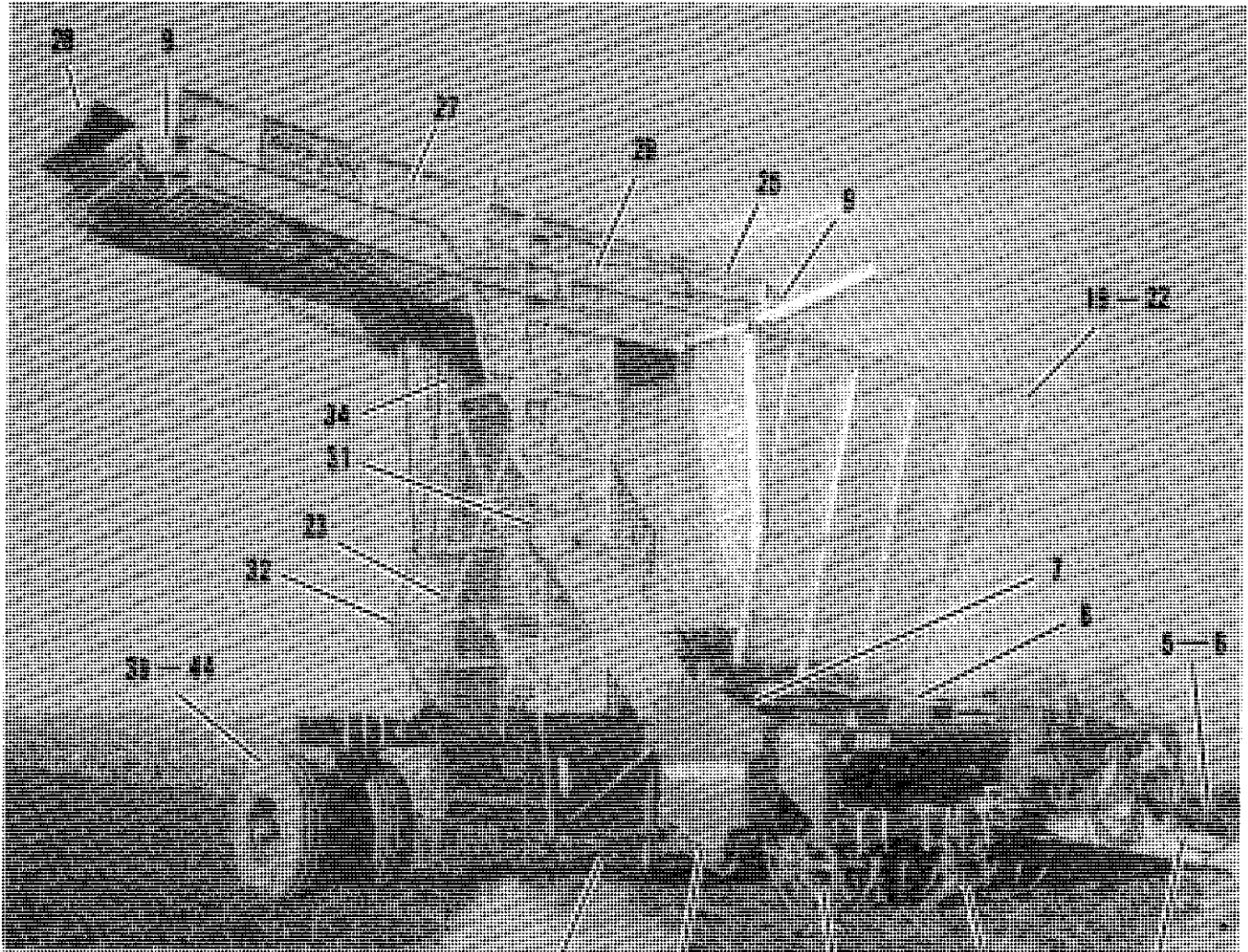
The illustrations and data used in this manual were current at the time of printing, but due to possible in-line production changes, your machine may vary slightly in detail. We reserve the right to redesign and change the machine as may be necessary without notification.

The warranty for this machine appears on page 2 of this manual. Record the model and serial number of your Beet Harvester in the spaces provided on previous page.

The warranty registration form in the back of the Parts Manual must be completed and returned to the factory in order to establish proper WARRANTY.

Whenever you correspond with the company, distributor or dealer concerning this machine, please specify model number and serial number. MACHINE SERIAL NO. LOCATION- LEFT FRONT CORNER OF THE MAIN FRAME.

This manual contains operating instructions for this machine only. It does not replace the manual(s) for any machine that it may be attached to or used with.



33

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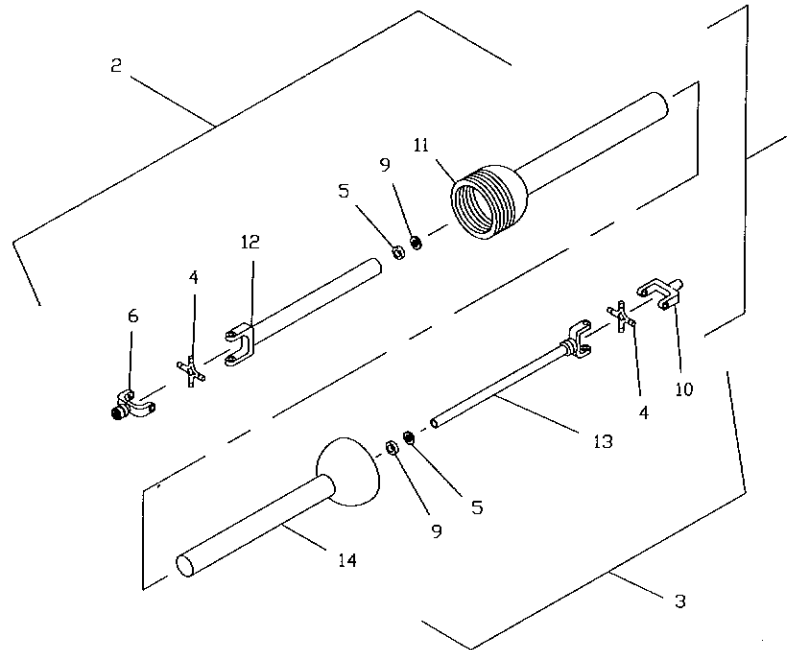
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Table of Contents

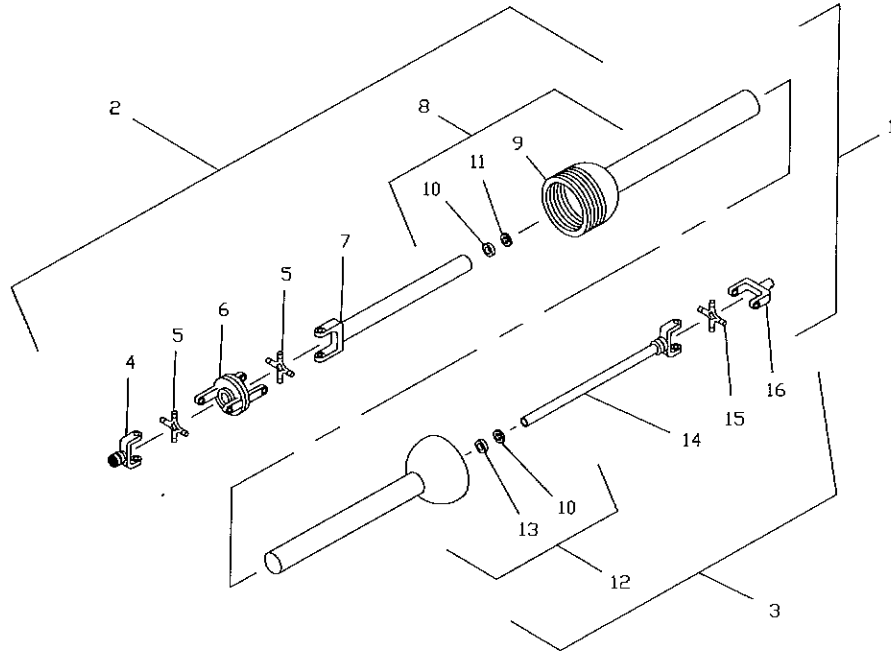
WORK SAFELY - FOLLOW THESE RULES	1
TO THE OWNER	2
LIMITED WARRANTY	2
ACCIDENTS can be prevented	3
ADEQUATE PARTS	4
PTO ASSEMBLY - STANDARD	5
PTO ASSEMBLY - CONSTANT VELOCITY	6
RIGHT GEARBOX	7
CENTER GEARBOX	8
10" ELECTRIC CLUTCH TRUCK AND TANK ELEVATOR	9
TONGUE	10
FRONT FRAME	11,12
REAR FRAME ASSEMBLY	13,14
GRAB ROLL DRIVE	15,16
HARVESTER ASSEMBLY WITH TANK	17,18
TANK AND CONVEYOR	19,20
TANK DRIVE ASSEMBLY	21,22
VERTICAL ELEVATOR ASSEMBLY	23,24
TANK ELEVATOR ASSEMBLY	25,26
TRUCK SWINGING ELEVATOR ASSEMBLY	27
ELEVATOR HOOD	28
HEAD SHAFT ASSEMBLY	29
DRAPER SPROCKET	30
CENTER JACKSHAFT	31
TIGHTENER ARM	32
CONE ROLLERS	33
INSIDE AND OUTSIDE FLANGED ROLLERS	33
STEEL ROLLER W/BALL BEARINGS	34
RUBBER ROLLER W/BALL BEARINGS	34
LIFTER WHEEL STANDARD STRUT	35,36
LIFTER WHEEL FLEX STRUT	37,38
FIXED CARRIER WHEELS	39,40
OSCILLATING CARRIER WHEEL	41,42
HEAVY DUTY STEERABLE WHEELS	43,44
HYDRAULIC ROW FINDER	45,46
CONTROL BOX AND WIRING	47
LIGHT PACKAGE	48
DRAWBAR SUPPORT	49
DECALS AND PAINT	50
SPECIFICATIONS	51,52

**PTO ASSEMBLY - STANDARD
35N SERIES**



ITEM	PART NUMBER	QTY	DESCRIPTION
1	E604030	1	PTO COMPLETE, 1-3/8"
2	228030	1	PTO, TRACTOR HALF
3	228040	1	PTO, IMPLEMENT HALF
4	010240	2	CENTER CROSS KIT
5	170280	2	RING, RETAINER
6	E830068	1	YOKE, TRACTOR 1-3/8"
6	236810	1	YOKE, TRACTOR 1-3/4"
7		-	
8		-	
9	199500	2	BEARING, NYLON
10	E830110	1	YOKE, IMPLEMENT
11	E694313	1	SHIELD, OUTER
12	E830109	1	YOKE & SHAFT
13	E830108	1	YOKE & TUBE
14	E694314	1	SHIELD, INNER

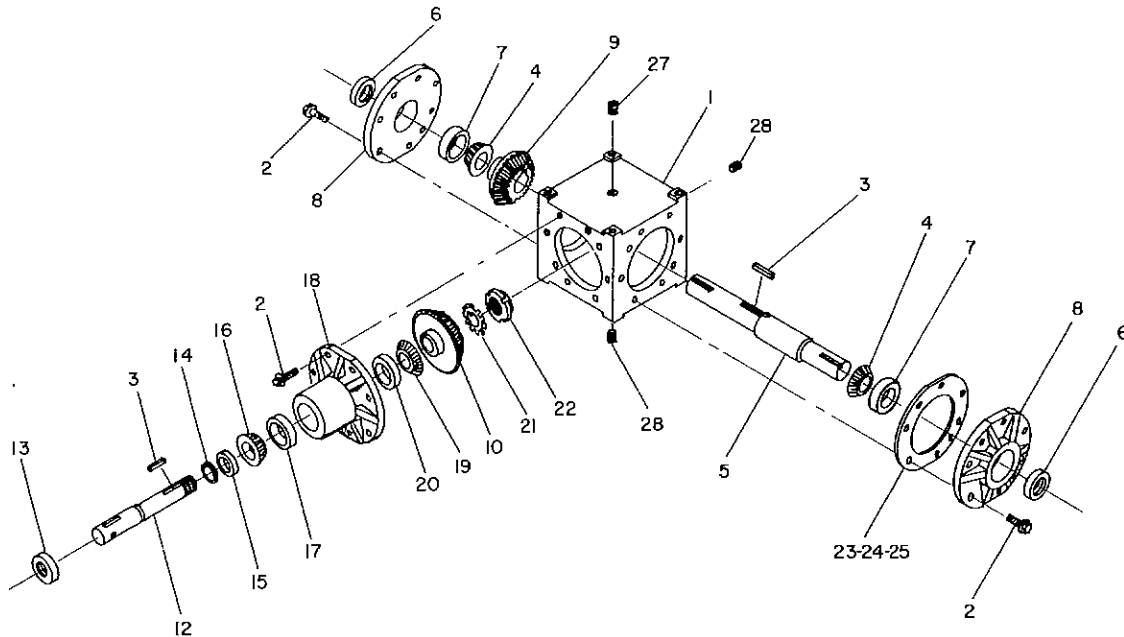
**PTO ASSEMBLY - CONSTANT VELOCITY
55R SERIES**



ITEM	PART NUMBER	QTY	DESCRIPTION
1	342910	-	PTO ASSY, 1-3/8"
1	342920	-	PTO ASSY, 1-3/4"
2	252550	1	TRACTOR HALF, 1-3/8"
2	252560	1	TRACTOR HALF, 1-3/4"
3	342930	1	IMPLEMENT HALF
4	241650	1	YOKE, TRACTOR 1-3/8"
4	242500	1	YOKE, TRACTOR 1-3/4"
5	241660	2	BEARING KIT, CV CENTER CROSS
6	241670	1	HOUSING ASSY, CENTER
7	252590	1	YOKE & SHAFT
8	253180	1	SHIELD, BELL & RETAINER
9	342960	1	BELL
10	168110	1	RETAINER, BEARING
11	253020	1	BEARING, NYLON
12	252610	1	SHIELD, IMPLEMENT HALF
13	246380	1	BEARING, NYLON INNER
14	342940	1	YOKE & TUBE, IMPLEMENT HALF
15	168060	1	KIT, CROSS & BEARING
16	342950	1	YOKE, IMPLEMENT

RIGHT GEARBOX - 231600

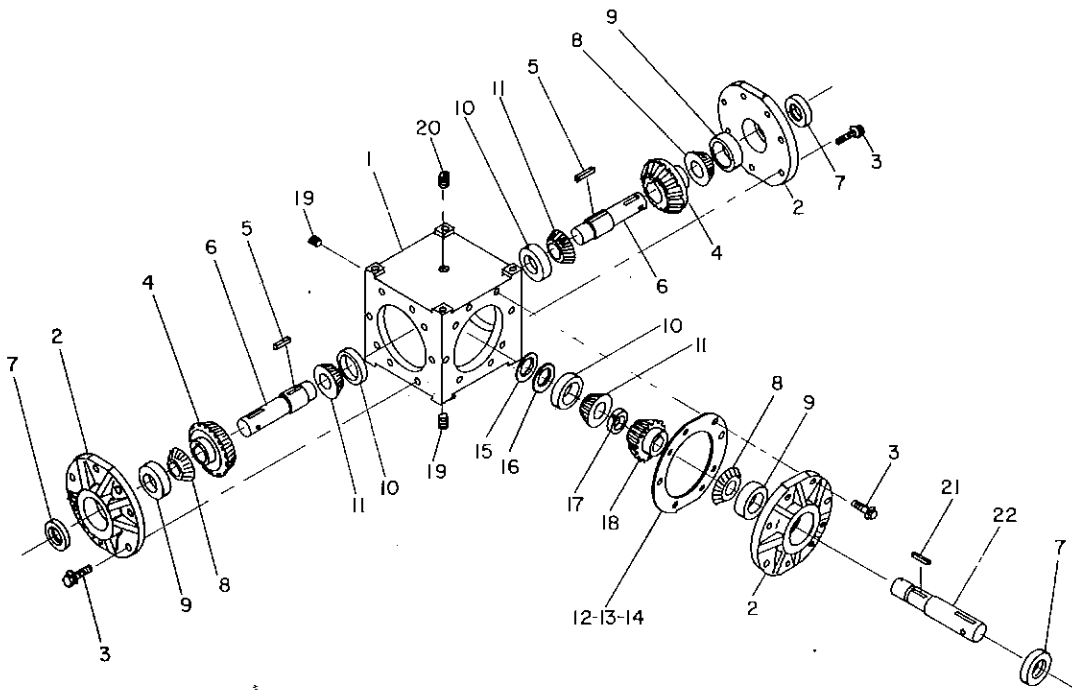
1.5:1 RATIO



ITEM	PART NUMBER	QTY	DESCRIPTION
1	235600	1	HOUSING, GEARBOX
2	184750	-	BOLT, SEMS 3/8" x 1-1/4"
3	236580	-	KEY, TAPERED 5/16"
4	189740	2	CONE, BEARING 1-3/4"
5	235660	1	SHAFT, OUTPUT
6	R67307	2	SEAL, 1-3/8"
7	189760	2	CUP, BEARING
8	189750	2	CAP
9	E302012	1	GEAR, BEVEL 20T
10	R67313	1	GEAR, 30T
11			
12	235670	1	SHAFT, PINION
13	235680	1	SEAL, 1-3/8" x 3" x 1/2"
14	R67305	1	RING, RETAINING
15	235690	1	COLLAR
16	235630	1	CONE, BEARING 1-3/8"
17	235620	1	CUP, BEARING
For 1988 & Prior - Gearbox Identified by 919597-1 or -2			
18	235610	1	CAP, LONG
19	235640	1	CONE, BEARING 1-3/8"
20	235650	1	CUP, BEARING
18	273880	1	CAP, LONG
19	273890	1	CONE, BEARING
20	273900	1	CUP, BEARING
For 1989 & Later - Gearbox Identified by 919597-3			
21	236590	-	WASHER, LOCK
22	236600	-	NUT, LOCK
23	R67301	-	GASKET, .015 THICK
24	R67302	-	GASKET, .005 THICK
25	R67303	-	GASKET, .003 THICK
26			
27	R66581	1	PLUG, PIPE 1/2"
28	026070	2	PLUG, PIPE 1/2"

CENTER GEARBOX - 231610

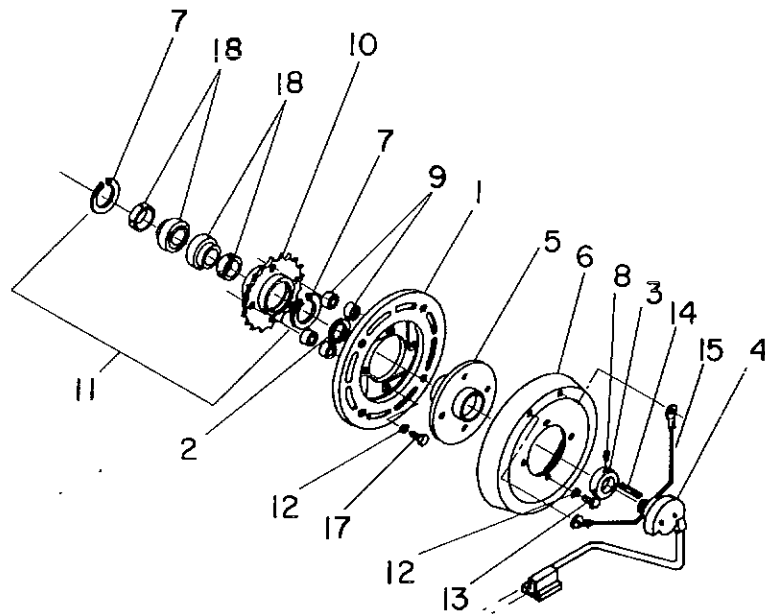
2:1 RATIO



ITEM	PART NUMBER	QTY	DESCRIPTION
1	235720	1	HOUSING, GEARBOX
2	235730	3	CAP, LONG
3	236550	-	SCREW, SEMS 7/16" X 1-1/4"
4	235750	2	GEAR, 36T
5	236560	-	KEY
6	235810	2	SHAFT, GEARBOX OUTPUT
7	235820	3	SEAL
8	235790	3	CONE, BEARING 1.75"
9	235780	3	CUP, BEARING
10	235760	3	CUP, BEARING
11	235770	3	CONE, BEARING 1-3/4"
12	235830	-	GASKET, .015
13	235840	-	GASKET, .005
14	235850	-	GASKET, .003
15	235870	-	SHIM, .010
16	235880	-	SHIM, .005
17	235860	-	RING, RETAINING
18	235740	1	GEAR, 18T
19	026070	2	PLUG, PIPE 1/2"
20	R66581	1	PLUG, PIPE 1/2"
21	236570	-	KEY
22	235800	1	SHAFT, GEARBOX INPUT

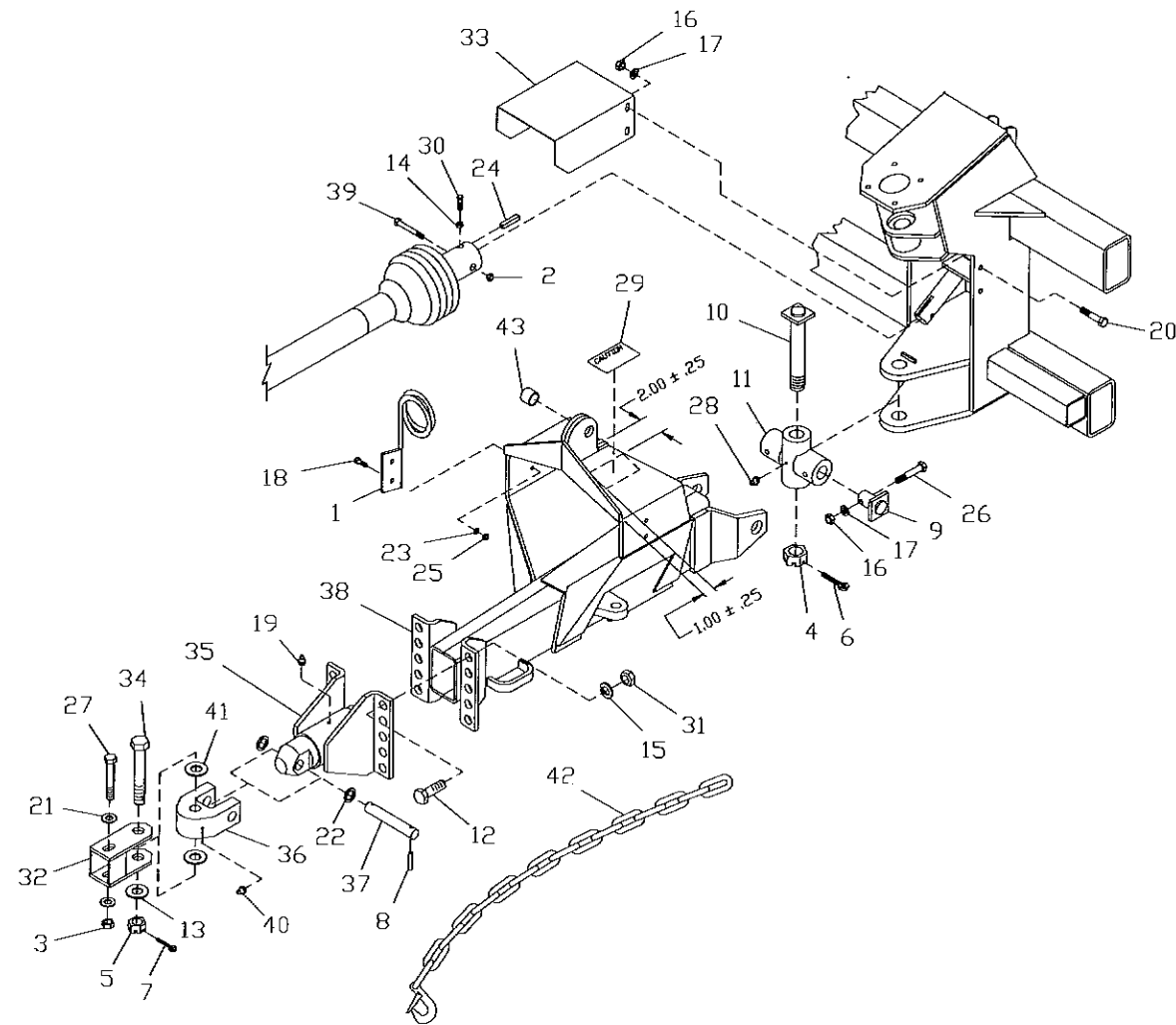
10" ELECTRIC CLUTCH TRUCK AND TANK ELEVATOR

238210



ITEM	PART NUMBER	QTY	DESCRIPTION
1	238150	1	ARMATURE ASSY, 10" DIA.
2	E126099	1	BUSHING, 1.50"
3	E184015	1	COLLAR, 1-7/16"
4	E347001	1	HOLDER ASSY, BRUSH W/CONNECTOR WIRE
5	238200	1	HUB WELD, 10" CLUTCH
6	238140	1	MAGNET ASSY, 10" DIA.
7	E642027	2	RING, RETAINING 2.812"
8	E672139	-	SCREW, AHSS 3/8" x 5/16"
9	E724114	4	SPACER
10	238280	1	SPROCKET WELD, 60 30T
11	238290	1	SPROCKET ASSY, 60 30T W/BRG
12	021180	-	WASHER, LOCK 3/8"
13	012260	-	BOLT, HHCS 3/8" x 1"
14	167920	-	KEY, SQ 3/8" x 2-1/2"
15	E834026	1	WIRE ASSY, BRUSH HOLDER
16			
17	011370	-	BOLT, HHCS 3/8" x 1-1/2"
18	1794108	1	BEARING ASSY, 1-7/16"

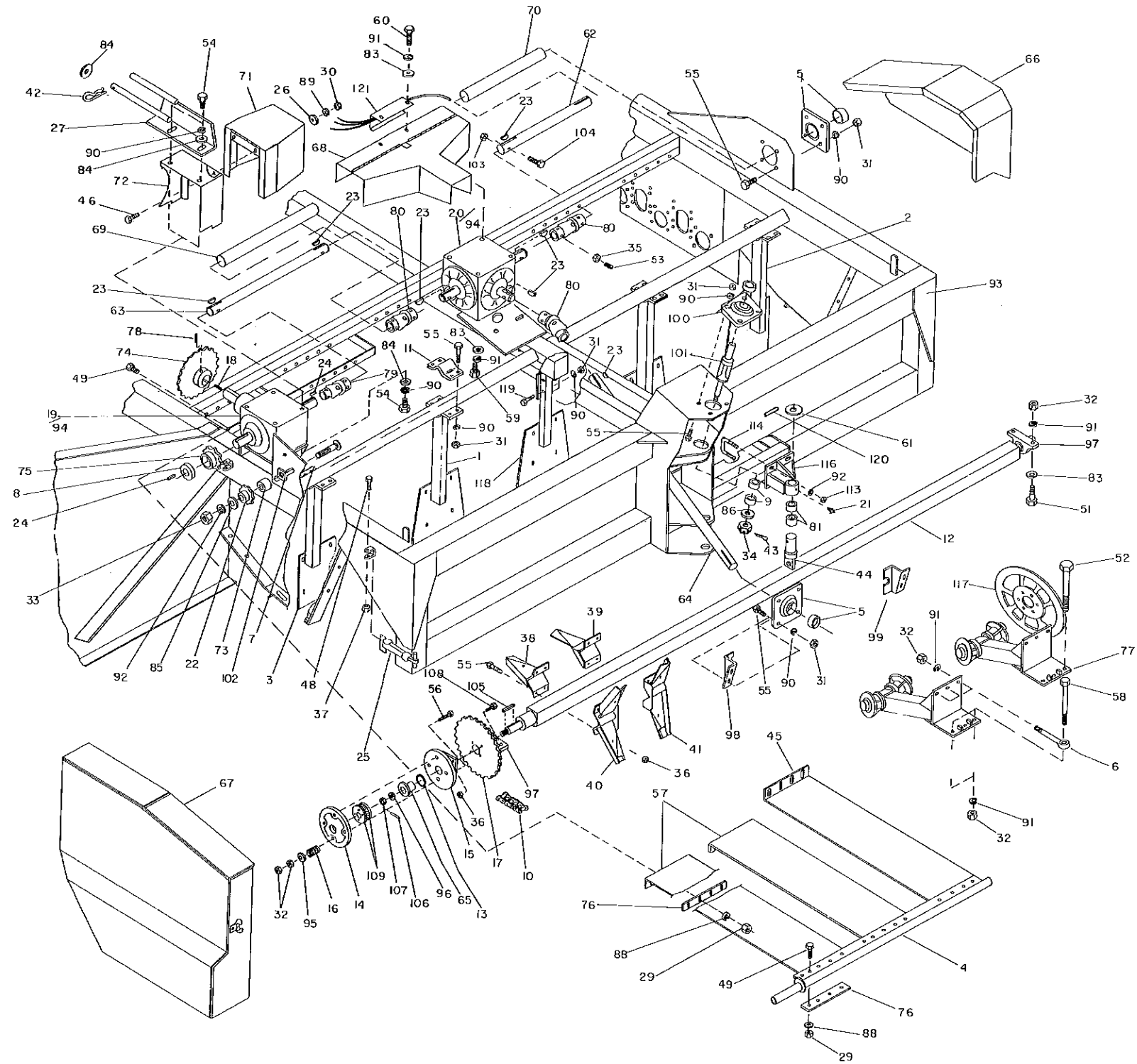
TONGUE



TONGUE - 252890

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E150004	1	CARRIER, HOSE
2	E552044	-	NUT, LOCK 3/8"
3	991040	-	NUT, LOCK 3/4"
4	E552084	-	NUT, SLOTTED 1-1/2"
5	E552092	-	NUT, SLOTTED 1-1/8"
6	E580042	-	PIN, COTTER 3/16" x 3"
7	E580046	-	PIN, COTTER 1/4" x 2-1/2"
8	E580053	-	PIN, ROLL 5/16" x 1-3/4"
9	E580086	2	PIN WELDMENT, SIDE
10	E580109	1	PIN WELDMENT
11	E586014	1	PIVOT WELDMENT
12	E672103	-	BOLT, HHCS 1" x 2-1/2"
13	E829021	-	WASHER, FLAT 1.25" x 2.75" x .164"
14	I124829	-	NUT, JAM 3/8"
15	O03350	-	WASHER, LOCK 1"
16	O05360	-	NUT, HEX 1/2"
17	O05370	-	WASHER, LOCK 1/2"
18	O11370	-	BOLT, HHCS 3/8" x 1-1/2"
19	O13170	1	ZERK, GREASE 1/8"
20	O14770	-	BOLT, HHCS 1/2" x 1-1/2"
21	O20720	-	WASHER, FLAT .812" x 1.75" x .179"
22	O20650	-	WASHER, FLAT 1.140" x 1.630" x .134"
23	O21180	-	WASHER, LOCK 3/8"
24	O21530	-	KEY, SQ 3/8" x 2"
25	O27260	-	NUT, HEX 3/8"
26	O38560	2	BOLT, HHCS 1/2" x 4"
27	I111952	1	BOLT, HHCS 3/4" x 8"
28	1100756	1	ZERK, GREASE 1/4"
29	115370	1	DECAL, HITCH INSTRUCTIONS
30	131730	-	SCREW, SHSS 3/8" x 1-1/4"
31	J14H794	-	NUT, HEX 3/4"
32	260920	1	CLEVIS WELD, HITCH
33	246180	1	SHIELD, PTO
34	342820	1	BOLT, HHCS 1-1/8" x 8" HITCH
35	252790	1	HITCH WELDMENT, FRONT
36	252810	1	HITCH, CLEVIS
37	252820	1	PIN, HITCH
38	252870	1	TONGUE WELDMENT
39	990870	-	BOLT, HHCS 3/8" x 3-1/2"
40	115590	-	ZERK, GREASE 1/4" SELF TAPPING
41	231970	-	WASHER, FLAT 1-1/8" x 2-1/4" HARD
42	JAR90579	-	CHAIN, SAFETY
43	232240	2	BUSHING

FRONT FRAME

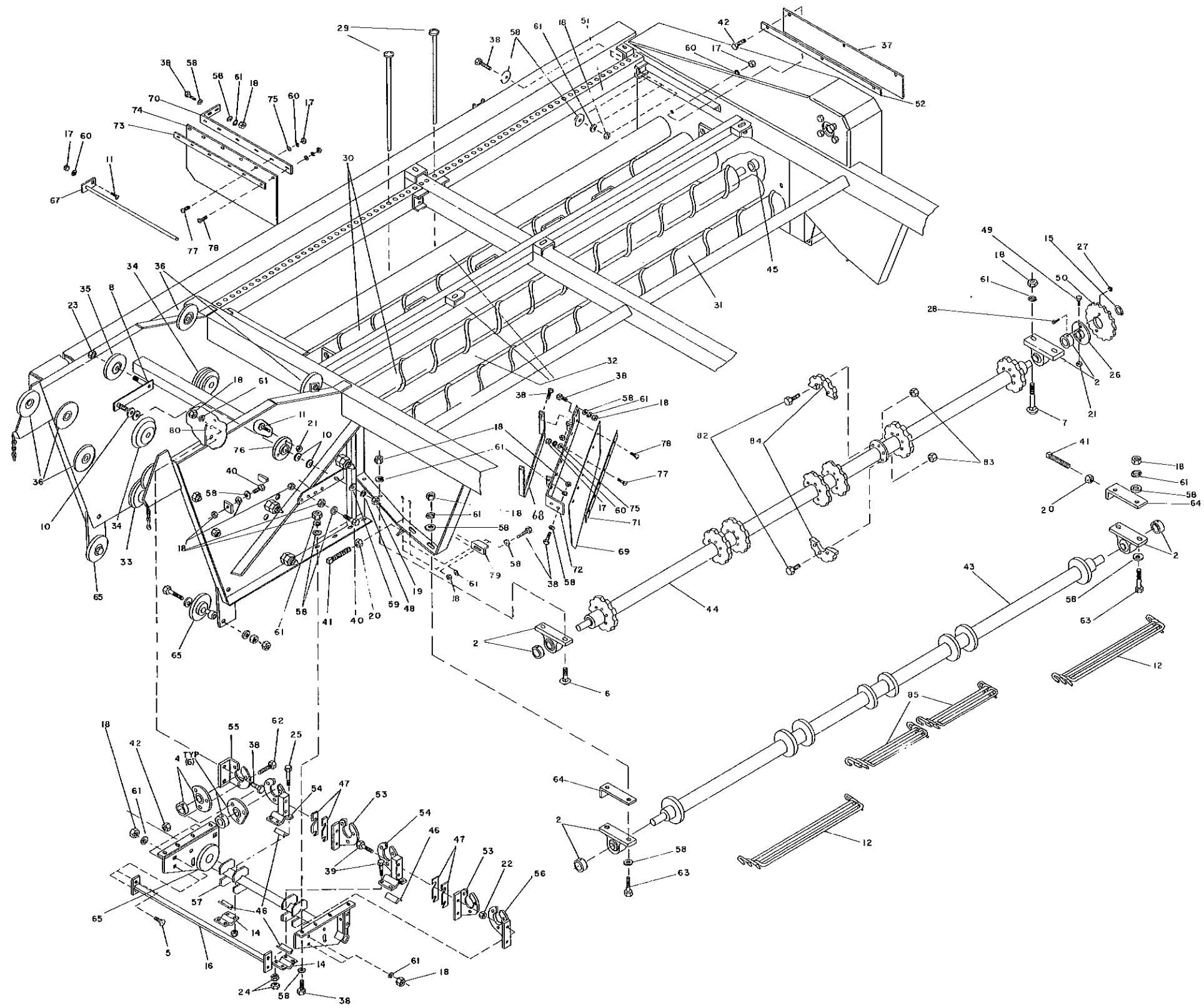


FRONT FRAME - 231590

ITEM	PART NUMBER	QTY	DESCRIPTION
1	244690	4	BARRIER
1	244650	-	FLAP, RUBBER
2	244620	1	BARRIER, LH
2	244660	-	FLAP, RUBBER SIDE
3	244630	1	BARRIER, RH
3	244660	-	FLAP, RUBBER SIDE
4	E066054	2	BAR, COVER WELDMENT
5	E072489	2	BEARING, FLANGE 1-3/4"
5	236490	-	BEARING ONLY, 1-3/4" W/LOCK COLLAR
6			
7	E096078	-	BOLT, CRG 3/4" x 3.00"
8	E126011	1	BUSHING, TAPERED "Q1" 1.375"
9	E126113	2	BUSHING, NOTCHED
10	225110	1	CHAIN, ROLLER 88P
11	E174068	6	CLAMP
12	E682753	1	SHAFT WELDMENT, PADDLE
12	E407085	-	SHAFT, IDLER PLUG
12	E407086	-	SHAFT, DRIVE PLUG
13	E126201	-	BUSHING, 2-1/2" x 3-7/8" x 10GA.
14	E280016	1	FLANGE WELDMENT, SPRING
15	E358044	1	HOUSING ASSEMBLY, CLUTCH
16	239080	4	SPRING, COMPRESSION SLIP CLUTCH
17	E740881	1	SPROCKET, 80 A 45
18	035060	-	KEY, SQ 5/16" x 2-1/2"
19	231600	1	GEARBOX, MODEL 514 TYPE "E" (see page 7)
20	231610	1	GEARBOX, MODEL 615A TYPE "J" (see page 8)
21	115590	2	ZERK, GREASE 1/4"
22	240550	1	SPROCKET, IDLER, 80 12T
23	231950	-	KEY, WOODRUFF 3/8" x 2-3/4"
24	020400	-	KEY, SQ 5/16" x 2"
25	E504003	2	LATCH, RUBBER
26	021190	-	WASHER, FLAT .438" x 1" x .083"
27	231620	1	MOUNT WELDMENT
28	027660	-	NUT, HEX 1/4"
29	023630	-	NUT, HEX 5/16"
30	027260	-	NUT, HEX 3/8"
31	005360	-	NUT, HEX 1/2"
32	1124589	-	NUT, HEX 5/8"
33	036750	-	NUT, HEX 3/4"
34	129830	-	NUT, HEX 7/8" SLOTTED
35	1124829	-	NUT, JAM 3/8"
36	19413967	-	NUT, LOCK 1/2"
37	037550	-	NUT, LOCK 1/4"
38	341080	6	PADDLE WELDMENT, RH SINGLE
39	341090	6	PADDLE WELDMENT, LH SINGLE
40	341060	6	PADDLE WELDMENT, RH DOUBLE
41	341070	6	PADDLE WELDMENT, LH DOUBLE
42	E580035	-	PIN, HAIR .120" x 2-3/8" OAL
43	E580036	-	PIN, COTTER 1/8" x 2"
44	268240	1	PIN, ROW FINDER CYLINDER
45	E658085	4	COVER, RUBBER
46	022420	-	BOLT, HHCS 3/8" x 3/4"
47	012051	-	BOLT, HHCS 1/4" x 3/4"
48	047000	-	BOLT, HHCS 1/4" x 1-1/2"
49	005900	-	BOLT, HHCS 5/16" x 1"
50	037790	-	BOLT, HHCS 3/8" x 2"
51	023110	-	BOLT, HHCS 5/8" x 2-1/2"
52			
53	022520	-	SCREW, SHSS 3/8" x 1"
54	014770	-	BOLT, HHCS 1/2" x 1-1/2"
55	023950	-	BOLT, HHCS 1/2" x 2"
56	990680	-	BOLT, HHCS 5/8" x 5-1/2"
57	240960	2	COVER, RUBBER SHORT
58			
59	990610	-	BOLT, HHCS 5/8" x 1-1/2"

ITEM	PART NUMBER	QTY	DESCRIPTION
60	990600	-	BOLT, HHCS 5/8" x 1-1/4"
61	E126034	-	BUSHING, MACHINE 1.88"ID x 2.80"OD x .134"
62	247040	1	SHAFT, LEFT
63	247050	1	SHAFT, RIGHT
64	231650	1	SHAFT, FRONT
65	228740	1	HUB, CLUTCH
66	231670	1	SHIELD WELDMENT, UPPER
67	E694485	1	SHIELD WELDMENT, RH
68	262400	1	SHIELD WELDMENT, MAIN GEARBOX
69	247060	1	SHIELD, RIGHT JACKSHAFT
70	247070	1	SHIELD, LEFT JACKSHAFT
71	262350	1	SHIELD ASSY, GEARBOX RH
72	262390	1	BRACKET, SHIELD MOUNTING RH
73	E724122	-	SPACER, .82"ID x 1.05"OD x .500"
74	E740968	1	SPROCKET, 80 30T
75	E741067	1	SPROCKET, 80 Q 15
76	E758084	12	STRAP, 1/8" x 1" x 12"
77	268900	-	STANDARD STRUT ASSEMBLY (see page 35-36)
77	268890	-	FLEX STRUT ASSEMBLY (see page 37-38)
78	070020	-	SCREW, AHSS 3/8" x 1/2"
79	233630	1	JOINT, UNIVERSAL 1.75" x 1.38"
79	E830075	-	YOKE, IMPLEMENT 1.375"
79	010240	-	CENTER CROSS KIT
79	236460	-	YOKE, 35N 1-3/4"
80	E823023	3	JOINT UNIVERSAL 1.75" x 1.75"
80	236460	-	YOKE, 35N 1-3/4"
80	010240	-	CENTER CROSS KIT
81	268250	-	RACE, INNER 1.88" x 2.12" x 1.5"
82	023260	-	WASHER, FLAT 1/4" x .31" x 3/4"
83	035210	-	WASHER, FLAT, .656" x 1.312" x .095"
84	005200	-	WASHER, FLAT .562" x 1.375" x .109"
85	1131017	-	WASHER, FLAT .812" x 1.46" x .108"
86	E829019	-	WASHER, FLAT .938" x 2.25" x .164"
87	029440	-	WASHER, LOCK 1/4"
88	023620	-	WASHER, LOCK 5/16"
89	021180	-	WASHER, LOCK 3/8"
90	005370	-	WASHER, LOCK 1/2"
91	020440	-	WASHER, LOCK 5/8"
92	036800	-	WASHER, LOCK 3/4"
93	230930	1	MAIN FRAME WELDMENT (NOT SERVICEABLE)
94			
95	125547R1	-	WASHER, FLAT .656" x 1.312" x .188"
96	R31090	-	WASHER, FLAT 1.03" x 2-1/8" x .224"
97	013420	2	BEARING, 2" PILLOW BLOCK W/LOCK COLLAR
97	E072431	-	BEARING ONLY, 2" W/LOCK COLLAR
98	231720	1	COVER, LEFT HAND
99	231730	1	COVER, RIGHT HAND
100	010560	1	BEARING, FLANGE 1-1/2" W/LOCK COLLAR
100	1478037R92	-	BEARING ONLY, 1-1/2" W/LOCK COLLAR
101	229690	1	PIN, CYLINDER DOUBLE
102	231760	1	WASHER, SQ 3/4"
103	073630	-	NUT, LOCK 3/8"
104	990870	-	BOLT, HHCS 3/8" x 3-1/2"
105	030380	-	KEY, SQ 3/8" x 3"
106	040900	-	PIN, ROLL 3/16" x 1-5/8"
107	042110	-	NUT, SLOTTED 1"
108	1770500	-	BOLT, HHCS 1/2" x 1-3/4"
109	225040	2	JAW, HARDENED SLIP CLUTCH
110	236400	-	SPACER, 2" PIPE x 1.12" LG
111	121719R1	-	WASHER, FLAT 2.03" x 2-3/4" x .105"
112	1121555	-	NUT, JAM 5/8"
113	J14H794	-	NUT, HEX 3/4"
114	246120	-	U-BOLT, 3/4"
115	244790	-	KIT, 4 ROW FILLER
116	268180	1	BRACKET WELD, HYD ROW FINDER CYLINDER
117	264670	-	WHEEL, LIFTER
118	244640	1	BARRIER, CENTER
119	990840	-	BOLT, HHCS 1/2" x 3"
120	E580057	-	PIN, ROLL 3/8" x 2-1/2"
121	270500	-	JUNCTION ASSY, ELECTRICAL

REAR FRAME

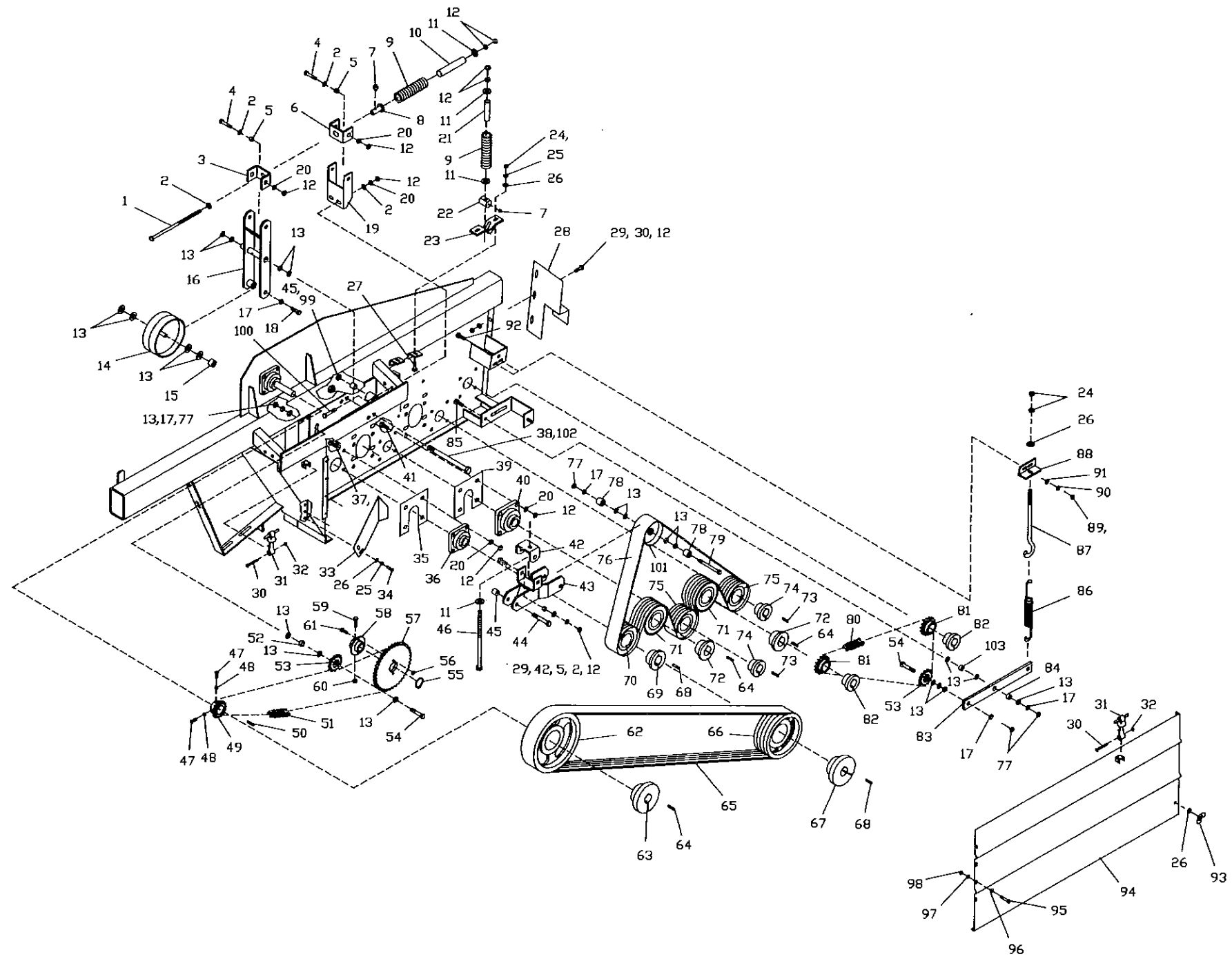


REAR FRAME ASSEMBLY - 231940

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E036002	2	ARM, DRAPER ROLLER, OUTSIDE
2	E072001	4	BEARING ASSY, PILLOW BLOCK 1-7/16"
2	200320	-	BEARING ONLY, 1-7/16" W/LOCK COLLAR
3			
4	E072391	6	BEARING ASSY, 1-7/16"
5	156850	-	BOLT, CRG 1/2" x 1-1/2"
6	991200	-	BOLT, CRG 1/2" x 2"
7	E096054	2	BOLT, CRG 1/2" x 5-1/2"
8	E104147	2	BRACKET WELD, DRAPER ROLLER INSIDE
9			
10	E126057	-	BUSHING, MACHINE 3/4"ID x 14GA.
11	170530	-	BOLT, CRG 3/8" x 1"
12	E166035	52	CHAIN, DRAPER .50" x 40" 2.38P
13	011370	-	BOLT, HHCS 3/8" x 1-1/2"
14	E174071	2	CLAMP, SQ TUBE
15	010380	1	RING, RETAINING EXTERNAL
16	231810	1	BAR WELD, CROSS
17	027260	-	NUT, HEX 3/8"
18	005360	-	NUT, HEX 1/2"
19	036750	-	NUT, HEX 3/4"
20	114380	-	NUT, JAM 1/2"
21	I9411655	-	NUT, LOCK 3/8"
22	037540	-	NUT, LOCK 1/2"
23	E552046	-	NUT, HEX 5/8"
24	I25526R1	-	NUT, HEX 1/2" PHC
25	251080	-	BOLT, HHCS 1/2" x 3-1/2"
26	252160	1	HUB, SHEAR
27	025670	-	NUT, LOCK 5/16"
28	030030	-	BOLT, HHCS 5/16" x 1-1/4"
29	240970	66	GRATE ROD, 1/2" x 17-3/4"
30	E650089	2	GRAB ROLL, #3 & #5
30	E850141	-	SHAFT & DISK, IDLER
30	E850234	-	SHAFT & DISK, DRIVE
31	E650136	1	GRAB ROLL, #1
31	E850141	-	SHAFT & DISK, IDLER
31	E850437	-	SHAFT & DISK, DRIVE
32	E650140	3	GRAB ROLL #2, #4 & #6
32	E850146	-	SHAFT & DISK, IDLER
32	E850472	-	SHAFT & DISK, DRIVE
33	253190	2	ROLLER ASSY, CONE (see page 33)
34	244530	4	ROLLER ASSY, OUTSIDE FLANGED (see page 33)
35	247100	2	ROLLER, RUBBER 5" x 5/8"
36	247110	8	ROLLER ASSY, RUBBER (see page 34)
37	E658084	1	FLAP, RUBBER
38	014770	-	BOLT, HHCS 1/2" x 1-1/2"
39	1770608	-	BOLT, HHCS 1/2" x 3-1/2"
40	023950	-	BOLT, HHCS 1/2" x 2"
41	E672369	-	SCREW, SHSS 1/2" x 4"
42	I359783C1	-	NUT, LOCK 3/8"
43	240920	1	SHAFT WELD, BED IDLER
44	E682738	1	SHAFT WELD, CHAIN CONVEYOR DRIVE
45	E724178	5	SPACER, BUSHING 1.628" x 2" x 1.125"
46	E724203	4	SPACER, RUBBER
47	E724307	8	SPACER, GRAB ROLL
48	036800	-	WASHER, LOCK 3/4"
49	231870	-	BOLT, HHCS 3/8" x 2-3/4"
50	252180	1	SPROCKET, 60 40T
51	E406832	2	CHANNEL, GRATE
52	E758083	1	STRAP, 1/4" x 1" x 37"
53	E762378	2	SUPPORT, BEARING
54	237200	2	SUPPORT, BEARING
55	E762380	1	SUPPORT, REAR BEARING
56	246780	1	SUPPORT, FRONT BEARING

ITEM	PART NUMBER	QTY	DESCRIPTION
57	231840	1	SUPPORT, TRANSFER ROLL
58	005200	-	WASHER, FLAT .562" x 1.375" x .109"
59	990710	-	WASHER, FLAT .812" x 2.00" x .149"
60	021180	-	WASHER, LOCK 3/8"
61	005370	-	WASHER, LOCK 1/2"
62	268870	-	BOLT, HHCS 3/8" x 1-1/2"
63	007080	-	BOLT, HHCS 1/2" x 2-1/2"
64	E104319	2	BRACKET, BEARING ADJUSTMENT
65	244700	4	ROLLER ASSY, INSIDE FLANGED (see pg 33)SEE NOTE
66	020170	-	BOLT, CRG 3/8" x 1"
67	240730	1	ROD WELD, UPPER MUD
68	238690	1	STOP WELD, RUBBER FLAP
69	246730	1	FLAP, RUBBER CHAIN BED
70	238710	1	BAR, FLAP GRABROLLS
71	238720	1	STRIP, RUBBER BACKING CHAIN
72	246870	1	BAR WELD, CHAIN BED
73	238750	1	STRIP, RUBBER BACKING GRABROLL
74	238770	1	FLAP, RUBBER GRABROLL
75	021190	-	WASHER, FLAT .438" x 1.00" x .083"
76	252250	2	BEARING ASSY, HUGGER ARM
76	252230	-	HOUSING, HUGGER ARM BEARING
76	252240	-	BEARING, BALL 20mm
77	035180	-	RING, RETAINING INTERNAL
77	035180	-	BOLT, CRG 3/8" x 1-1/4"
78	041450	-	BOLT, CRG 3/8" x 2"
79	246750	1	STOP, ADJUSTABLE
80	246980	1	PLATE, COVER
81			
82	011370	-	BOLT, HHCS 3/8" x 1-1/2"
83	073630	-	NUT, LOCK 3/8"
84	244490	8	SPROCKET, 10T 2.38P SPLIT DRAPER
85	244500	52	CHAIN, DRAPER .50" x 23.5" x 2.38P

GRAB ROLL DRIVE

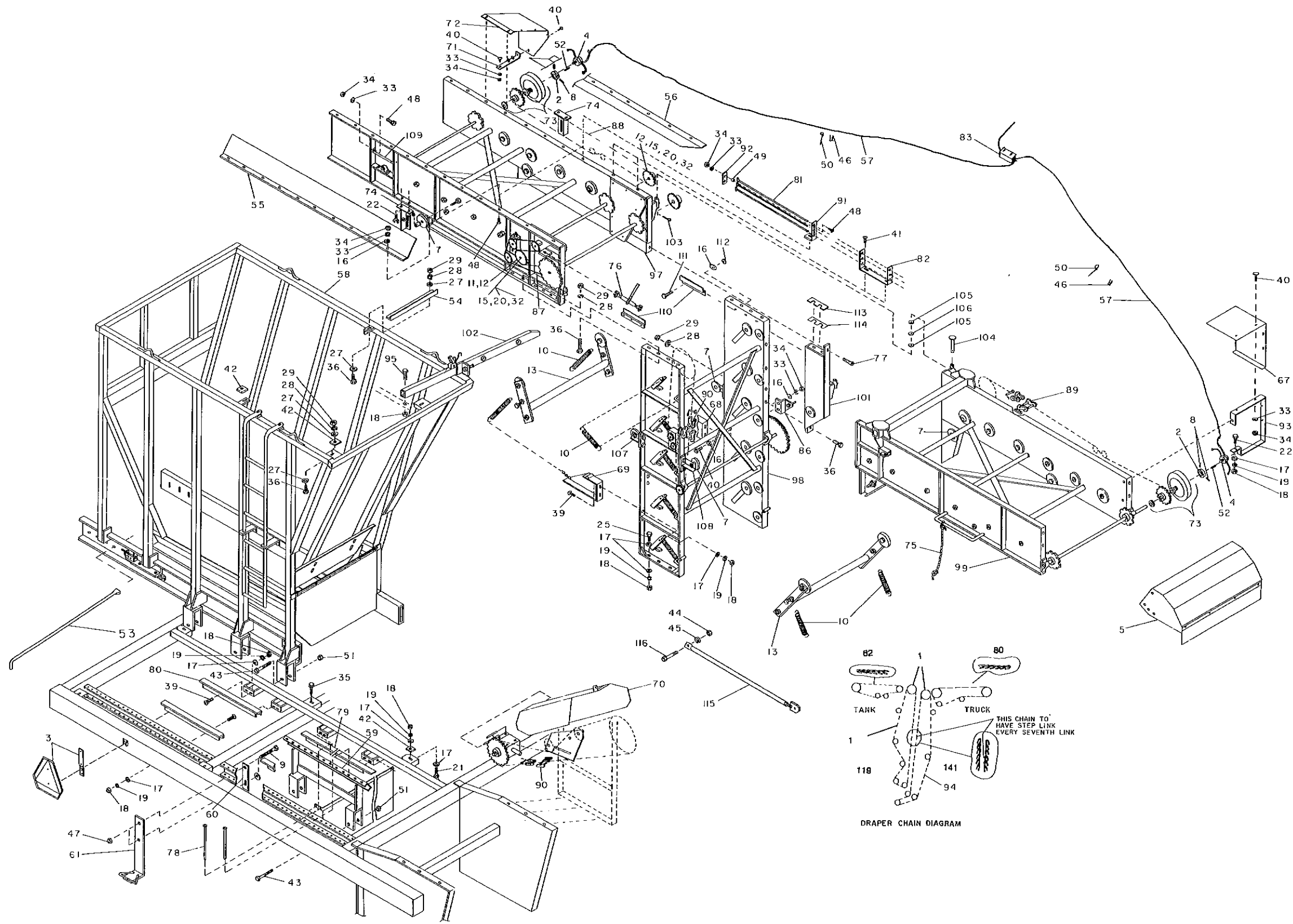


GRAB ROLL DRIVE - 231090

ITEM	PART NUMBER	QTY	DESCRIPTION
1	231060	1	ROD WELD, TAKE-UP 19"
2	005200	-	WASHER, FLAT .562" x 1.375" x .109"
3	231040	1	BRACKET, SPRING PIVOT
4	014770	-	BOLT, HHCS 1/2" x 1-1/2"
5	231030	6	SPACER, 3/4"OD x 3/8"L
6	251010	1	BRACKET, SPRING PIVOT
7	115590	2	ZERK, GREASE 1/4"
8	251030	1	GUIDE
9	231000	2	SPRING, COMPRESSION 1.62" x 7.25"
10	231050	1	SPACER, SPRING LENGTH
11	I486801R1	-	WASHER, FLAT .531" x 2" x 1/4"
12	005360	-	NUT, HEX 1/2"
13	035210	-	WASHER, FLAT .656" x 1.312" x .095"
14	E706098	1	SHEAVE, IDLER FLAT 8"OD
15	E126197	1	BUSHING, .688" x 1.25" x .94"
16	230960	1	ARM WELD, PRIMARY DRIVE IDLER
17	020440	-	WASHER, LOCK 5/8"
19	240890	1	BRACKET, IDLER TAKE-UP
20	005370	-	WASHER, LOCK 1/2"
21	239040	1	SPACER, SPRING LENGTH
22	251020	1	GUIDE
23	251830	1	BRACKET WLDT, IDLER TAKE-UP
24	027260	-	NUT, HEX 3/8"
25	021180	-	WASHER, LOCK 3/8"
26	021190	-	WASHER, FLAT .438" x 1.00" x .083"
27	035180	-	BOLT, CRG 3/8" x 1-1/4"
28	252740	1	FILLER, LEFT REAR
29	156850	-	BOLT, CRG 1/2" x 1-1/2"
30	047000	-	BOLT, HHCS 1/4" x 1-1/2"
31	E504003	2	LATCH, RUBBER
32	037550	-	NUT, LOCK 1/4"
33	246880	1	SHIELD, #60 DRIVE
34	012260	-	BOLT, HHCS 3/8" x 1"
35	265470	1	PLATE, SEAL BEARING
36	240900	1	BEARING, 1-15/16" FLANGE
36	236500	-	BEARING ONLY, 1-15/16" W/LOCK COLLAR
37	023950	-	BOLT, HHCS 1/2" x 2"
38	E672071	1	BOLT, HHCS 5/8" x 8-1/2"
39	265460	5	PLATE, SEAL BEARING
40	E072375	5	BEARING ONLY, 1-5/8" W/LOCK COLLAR
40	E072102	-	BEARING, 1-5/8" FLANGE
41	1770500	-	BOLT, HHCS 1/2" x 1-3/4"
42	239030	1	BRACKET, SPRING PIVOT
43	246900	1	ARM WLDT, IDLER FINAL
44	990590	1	BOLT, HHCS 3/4" x 4"
45	E126151	2	BUSHING, SPACER .753" x 1.003" x 1.
46	231070	1	ROD WELD, TAKE-UP 15"
47	022520	-	SCREW, SHSS 3/8" x 1"
48	I124829	-	NUT, JAM 3/8
49	252170	1	SPROCKET, 60B14 1.75"ID
50	021530	-	KEY, SQ 3/8" x 2"
51	E164080	1	CHAIN ASSY, ROLLER #60 106P
52	E724085	2	SPACER, BUSHING .742" x 1.050" x .5
53	E366013	2	SPROCKET, IDLER 60B13
54	990650	2	BOLT, HHCS 5/8" x 3"
55	010380	1	RING, RETAINING
56	025670	-	NUT, HEX 5/16" LOCK
57	252180	1	SPROCKET, PLATE R60 40T
58	252160	1	HUB, SHEAR 1-7/16"
59	231870	-	BOLT, HHCS 3/8" x 2-3/4"
60	I9411655	-	NUT, HEX 3/8" LOCK
61	030030	-	BOLT, HHCS 5/16" x 1-1/4"
62	E706102	1	SHEAVE, 12.40"OD 3C
63	E126196	1	BUSHING, TAPER "E" 1.75"
64	030380	-	KEY, SQ 3/8" x 3"
65	E825014	1	BELT, 3HC 110
66	E706101	1	SHEAVE, 9.4"OD 3C
67	E126177	1	BUSHING, SPECIAL TAPER "E" 1.938"
68	E388049	-	KEY, SQ 1/2" x 3"
69	230980	1	BUSHING, TAPER "SK" 1-15/16"

ITEM	PART NUMBER	QTY	DESCRIPTION
70	240910	1	SHEAVE, 4B 5.95"OD
71	E706108	2	SHEAVE, FLAT .625"OD "SK"
72	E126179	2	BUSHING, TAPER "SK" 1-5/8"
73	167920	-	KEY, SQ 3/8" x 2-1/2"
74	E126112	2	BUSHING, SPECIAL TAPER "SD" 1.625"
75	E706093	2	SHEAVE, 4B 6"OD
76	E080070	1	BELT, 4B 95 (LOWERED-HI SPEED)
76	E820072	1	BELT, 4HB 103 (RAISED-HI SPEED)
77	I124589	-	NUT, HEX 5/8"
78	E126195	2	BUSHING, .688"ID x 1.25"OD x 1.12"L
79	990680	1	BOLT, HHCS 5/8" x 5-1/2"
80	038040	1	CHAIN ASSY, ROLLER #60 54P
81	E740215	2	SPROCKET, 60P15
82	E126073	2	BUSHING, SPECIAL TAPER "P1" 1.625"
83	240870	1	ARM, IDLER #60
84	E126020	1	BUSHING, STEEL
85	056720	3	BOLT, HHCS 5/8" x 4"
86	220860	1	SPRING, EXTENSION 5.75"
87	R66275	1	BOLT, EYE 3/8" x 8-1/2"
88	240880	1	CLIP, SPRING
89	023630	-	NUT, HEX 5/16"
90	023620	-	WASHER, LOCK 5/16"
91	R61494	-	WASHER, FLAT .344" x .875" x .063"
92	032970	-	BOLT, CRG 5/16" x 1"
93	117600	-	NUT, WING 3/8"
94	231020	1	SHIELD WELD, LOWER GRAB ROLL
95	042960	-	BOLT, HHCS 1/4" x 1"
96	I120392	-	WASHER, FLAT .281" x .625" x .051"
97	029440	-	WASHER, LOCK 1/4"
98	027660	-	NUT, HEX 1/4"
99	1100238	-	NUT, LOCK 3/4"
100	041410	2	BOLT, HHCS 1/2" x 3-1/4"
101	E706099	1	SHEAVE, IDLER FLAT 5"OD
102	038400	-	NUT, LOCK 5/8"
103	E724045	2	SPACER, 3/4" PIPE x 1-1/2"

HARVESTER ASSEMBLY WITH TANK

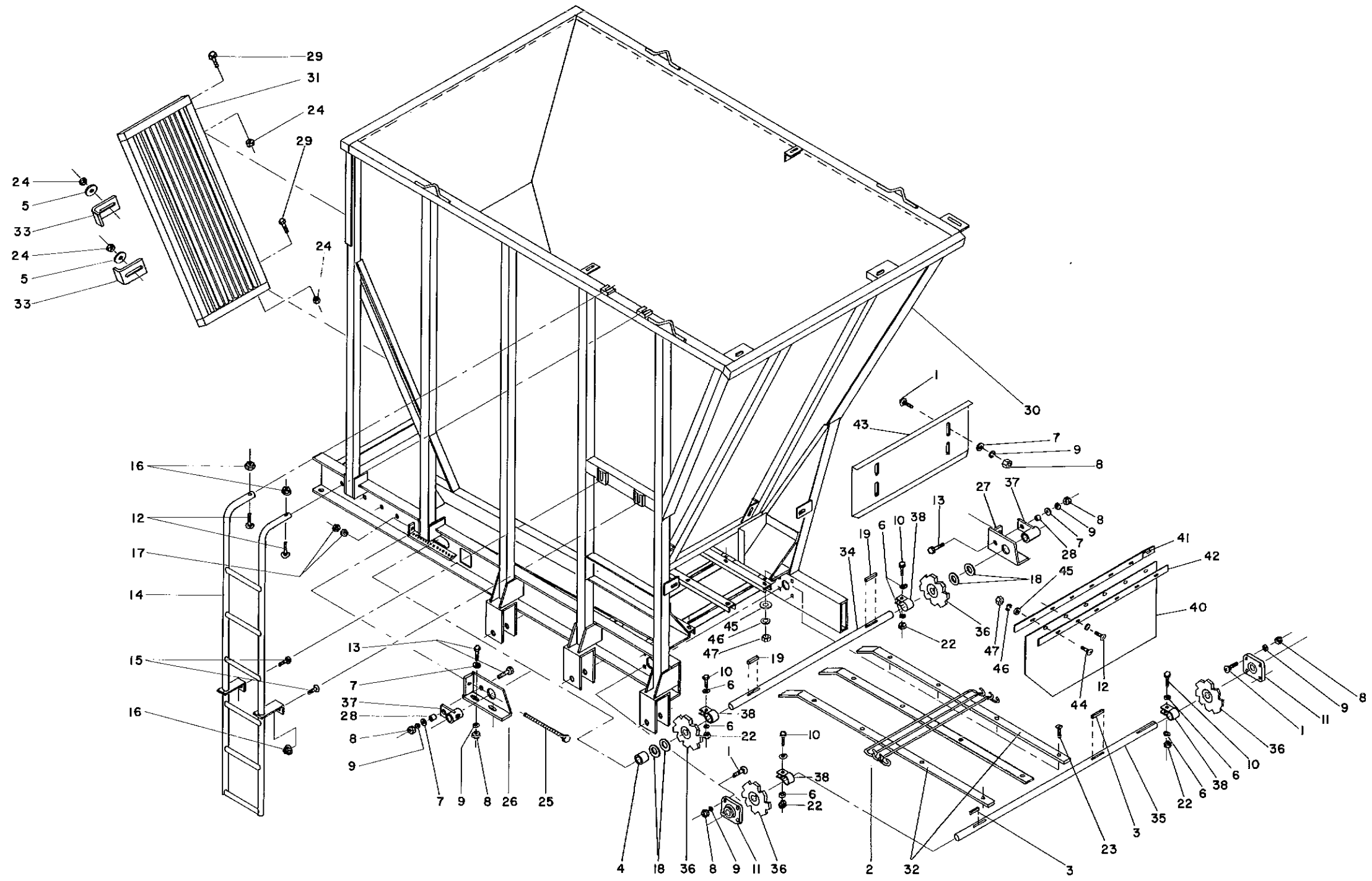


HARVESTER ASSEMBLY WITH TANK

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E166035	261	CHAIN, DRAPER .50" x 40" 2.38P
2	E184015	3	COLLAR, ROUND 1.437"
3	E224133	1	DECAL ASSY, SLOW MOVING VEHICLE
4	E347001	2	HOLDER ASSEMBLY, BRUSH
5	E348023	1	HOOD ASSEMBLY (see page 28)
6			
7	247110	6	ROLLER ASSY, RUBBER 5" (see page 34)
8	E672139	-	SCREW, AHSS 3/8" x 5/16"
9	E672446	2	BOLT, HHCS 5/8" x 7"
10	E738016	16	SPRING, .250" x 2-1/8" OD x 9"
11	E740120	1	SPROCKET, 60 B 20 SCRUBBER RATIO
12	E740169	2	SPROCKET, 60 B 24 NON-SCRUBBER RATIO
13	E790016	1	TIGHTENER ASSY (see page 32)
14	273080	1	WIRE ASSY, 4 FT
15	I124829	-	NUT, JAM 3/8"
16	R61494	-	WASHER, FLAT .344" x .875" x .063"
17	005200	-	WASHER, FLAT .562" x 1.375" x .109"
18	005360	-	NUT, HEX 1/2"
19	005370	-	WASHER, LOCK 1/2"
20	006670	-	KEY, SQ 3/8" x 1-1/2"
21	007080	-	BOLT, HHCS 1/2" x 2-1/2"
22	010730	-	BOLT, HHCS 1/2" x 1-1/4"
23			
24	012410	-	BOLT, CRG 5/16" x 3/4"
25	014770	-	BOLT, HHCS 1/2" x 1-1/2"
26	020190	-	NUT, LOCK 5/16"
27	020430	-	WASHER, FLAT .688" x 1.75" x .134"
28	020440	-	WASHER, LOCK 5/8"
29	020450	-	NUT, HEX 5/8"
30	021180	-	WASHER, LOCK 3/8"
31	021190	-	WASHER, FLAT .438" x 1.00" x .083"
32	022520	-	SCREW, SHSS 3/8" x 1"
33	023620	-	WASHER, LOCK, 5/16"
34	023630	-	NUT, HEX 5/16"
35	023950	-	BOLT, HHCS 1/2" x 2"
36	025100	-	BOLT, HHCS 5/8" x 1-3/4"
37	025760	-	BOLT, HHCS 5/16" x 1-1/2"
38	027260	-	NUT, HEX 3/8"
39	030470	-	BOLT, CRG 1/2" x 1-1/4"
40	032970	-	BOLT, CRG 5/16" x 1"
41	035180	-	BOLT, CRG 3/8" x 1-1/4"
42	035780	-	WASHER, SQ FLAT .25" x 1.75"
43	036730	5	BOLT, HHCS 3/4" x 6-1/2"
44	J14H794	-	NUT, HEX 3/4"
45	036800	-	WASHER, LOCK 3/4"
46	036890	30	CLIP, SPRING
47	038400	-	NUT, LOCK 5/8"
48	049280	-	BOLT, CRG 5/16" x 1-1/2"
49	144730	4	SPACER, LONG 1/2"
50	149670	-	TIE, NYLON CABLE
51	152360	-	NUT, LOCK 3/4"
52	167920	3	KEY, SQ 3/8" x 2-1/2"
53	229700	4	ROD, CONVEYOR GRATE
54	229950	1	ANGLE, ELEVATOR TIE CONNECTING
55	229970	1	BAFFLE, TANK ELEVATOR REAR
56	229980	1	BAFFLE, TANK ELEVATOR FRONT
57	270330	2	WIRE ASSY, 25 FT
58	230310	1	TANK & CONVEYOR ASSEMBLY (see page 19-20)
59	230370	1	FRAME WELDMENT, REAR GUARD
60	230460	1	BAR, CLAMP
61	230490	1	STEP WELDMENT
62			
63			

ITEM	PART NUMBER	QTY	DESCRIPTION
64			
65			
66			
67	252390	1	SHIELD, CLUTCH TRUCK ELEVATOR
68	232260	1	BRACKET WELDMENT, FRONT
69	232270	1	BRACKET WELDMENT, REAR
70	232320	1	SHIELD WELDMENT, LOWER ELEVATOR
71	238110	1	SUPPORT, CLUTCH SHIELD
72	238120	1	SHIELD, TANK ELEVATOR ELECTRIC CLUTCH
73	238210	2	CLUTCH, ELECTRIC 60 30T (see page 9)
74	239860	2	BRACKET WELDMENT, DRAPER
75	211491	1	ROPE, PLASTIC WHITE
76	R39520	1	JACK, RATCHET
77	245550	-	BOLT, FHCS 1/2" x 2"
78	240970	2	ROD, HEADED 1/2" x 17.75"
79	260640	2	ANGLE, LONG CONVEYOR GUIDE
80	260630	2	ANGLE, SHORT CONVEYOR GUIDE
81	241030	6	ROD, ELEVATOR GRATE
82	246010	2	U BRACKET, UPPER GRATE
83	270500	1	JUNCTION ASSY, ELECTRIC
84			
85	241130	1	SPROCKET, 60 B 13
86	241140	1	BRACKET WELD, SHIELD CATCH
87	241160	1	CHAIN, ROLLER 60 125P
88	241170	1	CHAIN, ROLLER 60 198P
89	241180	1	CHAIN, ROLLER 60 272P
90	241190	2	CHAIN, ROLLER 80 142P
91	245880	2	BRACKET, UPPER GRATE
92	241210	2	HOLDER, UPPER GRATE
93	241220	1	BAR, CLUTCH DRIVE
94	241230	3	CHAIN, ROLLER DRAPER 49 LINKS
94	E166035	-	CHAIN, DRAPER .50" x 40" 2.38P
94	E166036	-	CHAIN, DODGED DRAPER 40"
95	990840	-	BOLT, HHCS 1/2" x 3"
96	990660	-	BOLT, CRG 5/8" x 3-1/4"
97	245410	1	ELEVATOR ASSEMBLY, TANK (see page 25-26)
98	245430	1	ELEVATOR ASSEMBLY, VERTICAL (see page 23-24)
99	245420	-	ELEVATOR ASSEMBLY, TRUCK (see page 27)
100			
101	245990	1	SUPPORT ASSY, TANK ELEVATOR
102	245940	1	SUPPORT ASSY, ELEVATOR
102	252450	1	TUBE, SUPPORT WELDMENT
102	252480	1	SUPPORT, ADJUSTABLE ANGLE
102	253850	1	LATCH & CHANNEL
103	124340	-	PIN, COTTER 3/16" x 1-1/2"
104	245120	2	PIN WELDMENT, HINGE
105	245510	4	WASHER, THRUST
106	245520	2	WASHER, THRUST BRONZE
107	245380	2	TAKE-UP BRACKET WELDMENT
108	245400	1	TAKE-UP BRACKET WELDMENT LONG
109	246080	1	HANDLE
110	239060	2	STRIP, LINER
111	005900	-	BOLT, HHCS 5/16" x 1"
112	025670	-	NUT, LOCK 5/16"
113	248700	-	SHIM, THICK TANK ELEVATOR
114	248710	-	SHIM, THIN TANK ELEVATOR
115	E102114	1	BRACE ASSY, FRONT
115	E102111	1	BRACE WELDMENT, FRONT
115	E259002	1	BOLT, SPECIAL EYE .75" x 13"
116	990540	-	BOLT, HHCS 3/4" x 2"
117	260650	2	BAR, GUIDE SPACER

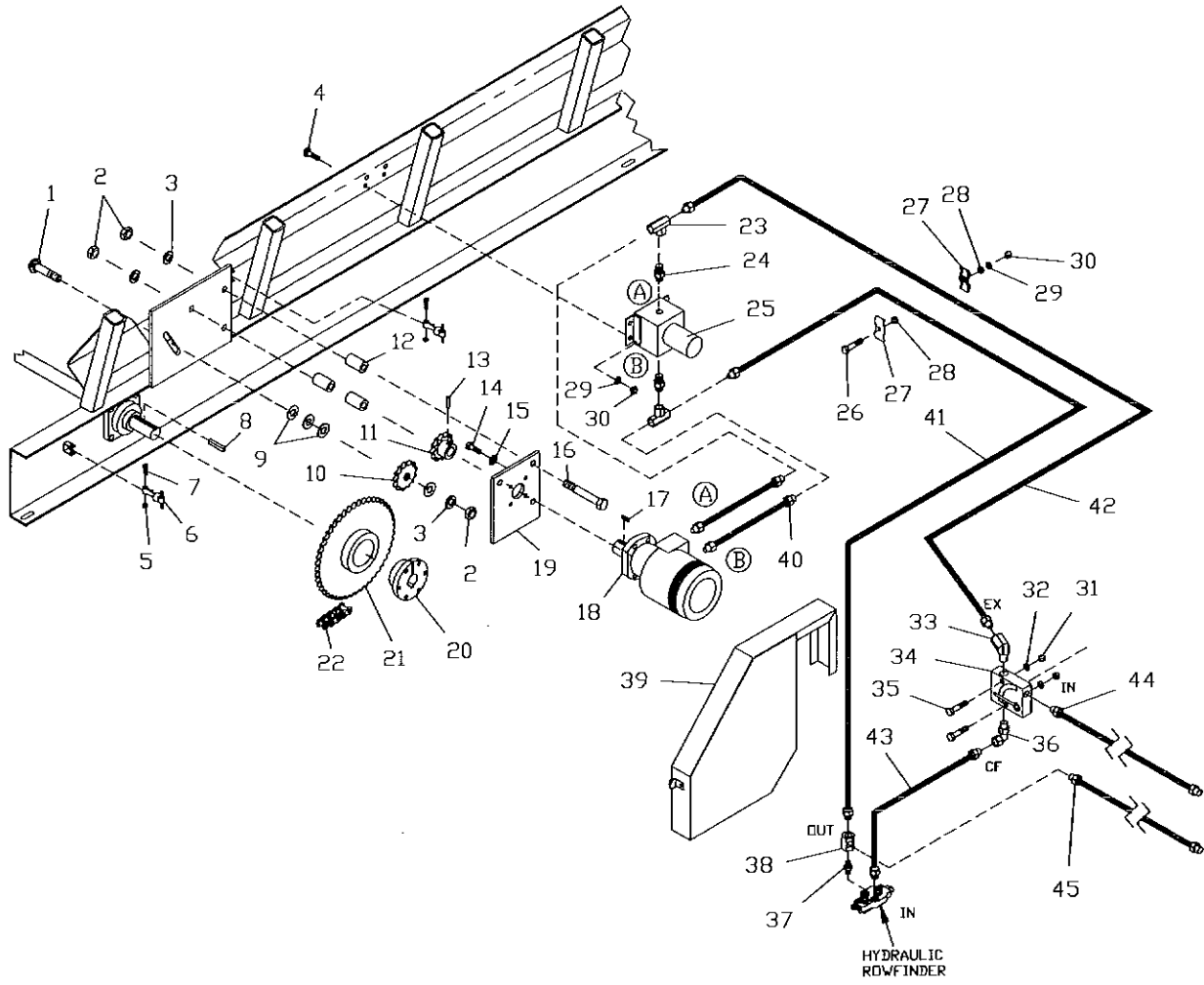
TANK AND CONVEYOR



TANK AND CONVEYOR - 230310

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E096046	-	BOLT, CRG 1/2" x 1-1/2"
2	260470	67	CHAIN, DRAPER .62" x 2.38"P x 40"W 1LK
3	E388074	-	KEY, SQ 3/8" x 2-1/4"
4	E724073	3	SPACER, BUSHING 1.440" x 1.750" x 1.125"
5	I486801R1	-	WASHER, FLAT .531" x 2" x 1/4"
6	R61494	-	WASHER, FLAT .344" x .875" x .063"
7	005200	-	WASHER, FLAT .562" x 1.375" x .109"
8	005360	-	NUT, HEX 1/2"
9	005370	-	WASHER, LOCK 1/2"
10	005900	-	BOLT, HHCS 5/16" x 1"
11	E072103	2	BEARING, FLANGE 1-7/16" W/LOCK COLLAR
12	012420	-	BOLT, CRG 3/8" x 1-1/2"
13	014770	-	BOLT, HHCS 1/2" x 1-1/2"
14	019090	1	LADDER ASSEMBLY
15	170530	-	BOLT, CRG 3/8" x 1"
16	020180	-	NUT, HEX 3/8"
17	I124589	-	NUT, HEX 5/8"
18	020560	-	WASHER, FLAT 1.531" x 2.25" x .134"
19	021530	-	KEY, SQ, 3/8" x 2"
20			
21			
22	025670	-	NUT, LOCK 5/16"
23	E672128	-	SCREW, SFHS 3/8" x 1"
24	037540	-	NUT, LOCK 1/2"
25	R66168	2	BOLT, ADJUSTMENT 5/8" x 6-1/2"
26	239480	1	TAKE-UP ASSY, BEARING REAR
27	239470	1	TAKE-UP ASSY, BEARING FRONT
28	152710	-	SPACER, .53"ID x .75"OD x .25"
29	1770500	-	BOLT, HHCS 1/2" x 1-3/4"
30	228980	1	TANK WELDMENT, FINAL HOLDING
31	239590	1	DOOR WELD, TANK ACCESS
32	250880	3	STRIP, WEAR
33	229720	2	BRACKET, DOOR LOCK
34	230320	1	SHAFT, IDLER
35	269990	1	SHAFT, CLUTCH DRIVE
36	240490	4	SPROCKET&HUB ASSY, 8T (see page 30)
37	230350	2	BEARING & HOLDER ASSY, IDLER
37	230360	-	BEARING, OILITE 1-7/16"ID x 2"L
38	234380	4	CLAMP, SPROCKET HOLDER 1-7/16"
39			
40	239540	1	BELTING, TANK DISCHARGE
41	239520	1	BAR, TANK FLAP
42	239530	1	STRIP, BACK-UP TANK FLAP
43	239580	1	CHANNEL, TANK GATE
44	018150	-	BOLT, HHCS 3/8" x 1-3/4"
45	021190	-	WASHER, FLAT 3/8" x 1" x .083"
46	021180	-	WASHER, LOCK 3/8"
47	027260	-	NUT, HEX 3/8"

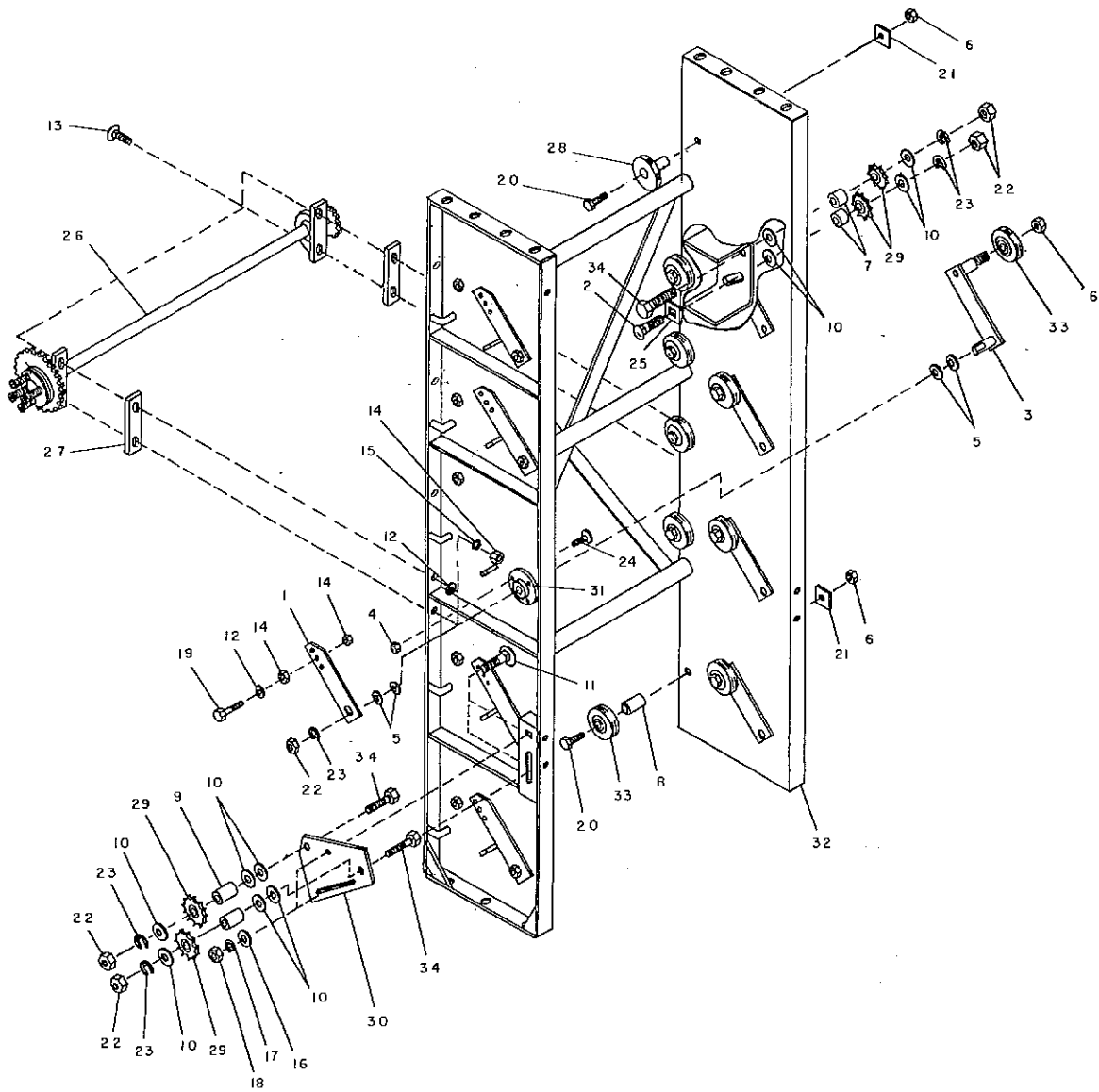
TANK DRIVE ASSEMBLY - 343270



TANK DRIVE ASSEMBLY - 343270

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E096058	-	BOLT, CRG 5/8" x 2-1/2"
2	I124589	-	NUT, HEX 5/8"
3	020440	-	WASHER, LOCK 5/8"
4	170530	-	BOLT, CRG 3/8" x 1"
5	037550	-	NUT, LOCK 1/4"
6	205650	2	HOOK, RUBBER
7	047000	-	BOLT, HHCS 1/4" x 1-1/2"
8	E388074	-	KEY, SQ 3/8" x 2-1/4"
9	035210	-	WASHER, FLAT .656" x 1.312" x .095"
10	E366013	1	SPROCKET, IDLER 60B13
11	268610	1	SPROCKET, RC60 12T
12	JN147304	3	SPACER, 2.14"
13	188650	-	SCREW, SET HSHD 5/16" x 5/16"
14	J19H2284	-	BOLT, HHCS 3/8" x 7/8"
15	J12H310	-	WASHER, LOCK INT TOOTH 3/8"
16	056720	3	BOLT, HHCS 5/8" x 4"
17	006180	-	KEY, WOODRUFF 1/4" x 1"
18	014280	1	MOTOR, HYDRAULIC
19	270000	1	PLATE, MOTOR MOUNT
20	268590	1	BUSHING, SF 1-7/16" BORE
21	270010	1	SPROCKET, 60SF 48.00
22	159100	1	CHAIN, ROLLER #60H
23	166290	2	ADAPTER, TEE 1/2"
24	343370	2	ADAPTER, STAIGHT 3/4"
25	343360	1	VALVE, ELECTRIC HYDRAULIC 3/8" 2-WAY
26	018150	-	BOLT, HHCS 3/8" x 1-3/4"
27	JN185041	2	CLAMP, HOSE
28	J28H518	2	SPACER
29	021180	-	WASHER, LOCK 3/8"
30	027260	-	NUT, HEX 3/8"
31	027660	-	NUT, HEX 1/4"
32	029440	-	WASHER, LOCK 1/4"
33	270620	1	ELBOW, PIPE 1/2" 45 DEGREE
34	006300	1	VALVE, FLOW CONTROL
35	023250	-	BOLT, HHCS 1/4" x 2-3/4"
36	166230	1	ELBOW, PIPE 1/2" 90 DEGREE
37	JAN131153	1	UNION, W/O'RING
38	JN132040	1	TEE, W/O'RING
39	342780	1	SHIELD, TANK DRIVE
40	166140	2	HOSE ASSY, HYDRAULIC 1/2" 24"
41	343490	1	HOSE ASSY, HYDRAULIC 1/2" x 120"
42	E386015	1	HOSE ASSY, HYDRAULIC 1/2" x 96"
43	268990	1	HOSE ASSY, HYDRAULIC 1/2" x 26"
44	164560	1	HOSE ASSY, HYDRAULIC 1/2" x 120"
45	269000	1	HOSE ASSY, HYDRAULIC 1/2" x 146"

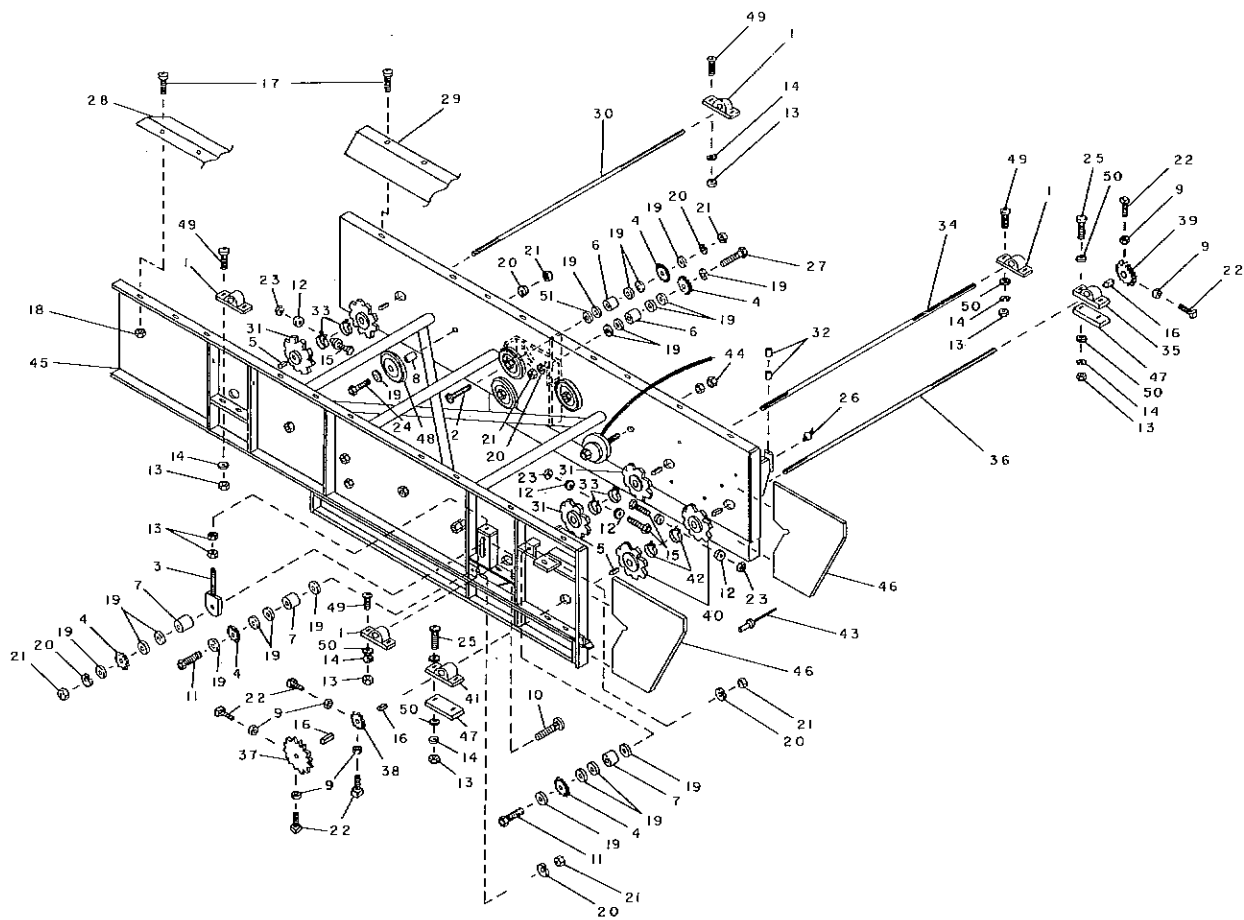
VERTICAL ELEVATOR ASSEMBLY



VERTICAL ELEVATOR ASSEMBLY - 245430

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E036003	10	ARM
2	E096078	-	BOLT, CRG 3/4" x 3"
3	E104147	10	BRACKET WELD, INSIDE DRAPER ROLLER
4	I9411655	30	NUT, LOCK 3/8"
5	E126057	50	BUSHING, MACHINE 3/4" x 14GA.
6	E552046	-	NUT, LOCK 5/8"
7	E724006	2	SPACER, CONE ROLLER
8	E724305	10	SPACER
9	E724310	2	SPACER, PIPE 3/4" x 1.1/4"
10	I131017	-	WASHER, FLAT .812" x 1.46" x .108"
11	250140	-	BOLT, CRG 5/8" x 1-1/2"
12	005200	-	WASHER, FLAT .562" x 1.375" x .109"
13	005210	-	BOLT, CRG 1/2" x 2-1/4"
14	005360	-	NUT, HEX 1/2"
15	005370	-	WASHER, LOCK 1/2"
16	020430	-	WASHER, FLAT .688" x 1.75" x .134"
17	020440	-	WASHER, LOCK 5/8"
18	I124589	-	NUT, HEX 5/8"
19	023950	-	BOLT, HHCS 1/2" x 2"
20	028330	-	BOLT, HHCS 5/8" x 4-1/2"
21	035780	-	WASHER, SQ 1/4" x 1-3/4"
22	J14H794	-	NUT, HEX 3/4"
23	036800	-	WASHER, LOCK 3/4"
24	170530	-	BOLT, CRG 3/8" x 1"
25	231760	-	WASHER, SQ 3/4"
26	239970	1	JACK SHAFT ASSY (see page 31)
27	240160	2	SPACER, BEARING
28	240480	2	ROLLER ASSY, STEEL 4-3/4" x 1-5/8" (see page 34)
29	240550	4	SPROCKET, IDLER 80 12T
30	240720	1	PLATE, LOWER IDLER
31	252250	10	BEARING ASSY, HUGGER ARM
31	252210	1	HOUSING, HUGGER ARM BEARING
31	252230	2	BEARING, BALL 20MM
31	252240	1	RING, RETAINING INTERNAL
32	245230	1	ELEVATOR WELD, VERTICAL
33	247100	20	ROLLER, RUBBER 5" x 5/8"
34	990830	-	BOLT, HHCS 3/4" x 3-1/2"

TANK ELEVATOR ASSEMBLY

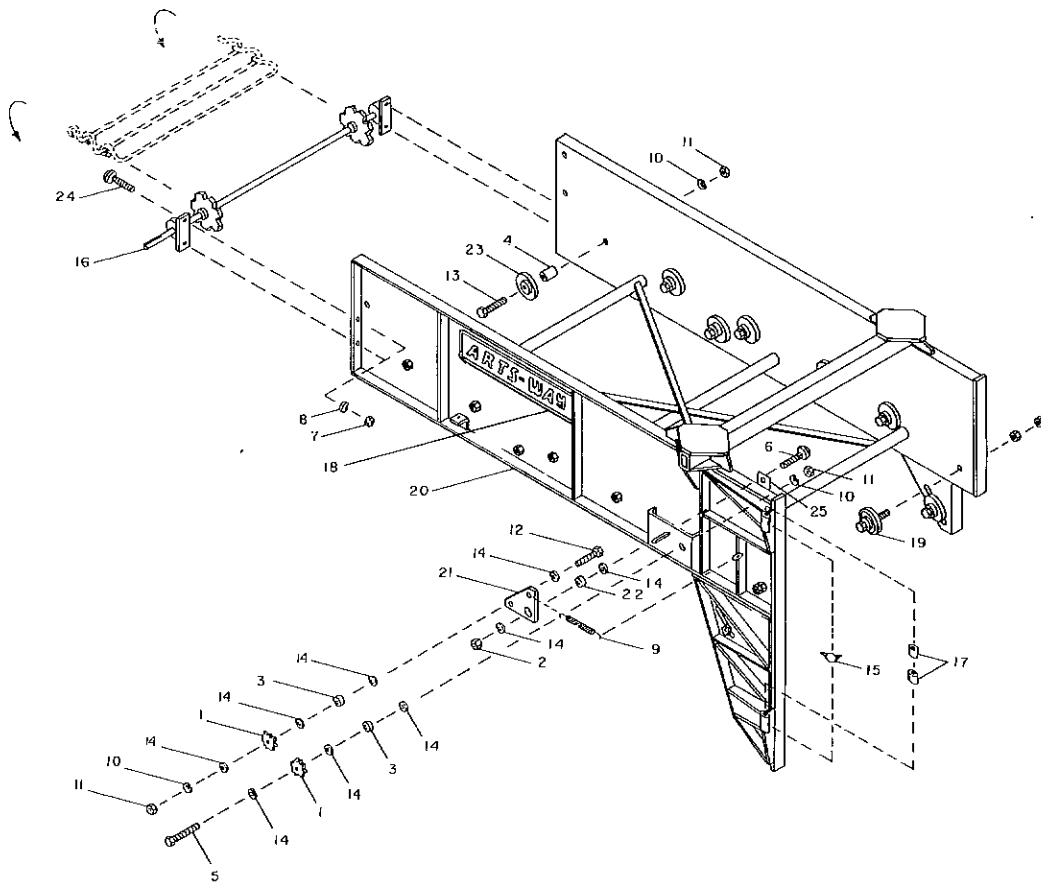


TANK ELEVATOR ASSEMBLY - 245410

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E072001	4	BEARING ASSY, PILLOW BLOCK 1-7/16"
1	200320	-	BEARING ONLY, 1-7/16" W/LOCK COLLAR
2	E096060	1	BOLT, CRG 5/8" x 4"
3	E259001	1	BOLT, EYE 1/2" x 6-1/4"
4	E366013	5	SPROCKET, IDLER 60B13
5	E388074	-	KEY, SQ 3/8" x 2-1/4"
6	E724045	2	SPACER, LONG 1-1/2"
7	E724056	3	SPACER, BUSHING .742" x 1.050" x .750"
8	E724305	8	SPACER, LONG 2-1/2"
9	I124829	-	NUT, JAM 3/8"
10	I18574R1	-	BOLT, CRG 5/8" x 3-1/2"
11	I271729	-	BOLT, HHCS 5/8" x 3-1/2"
12	R61494	-	WASHER, FLAT .344" x .875" x .063"
13	005360	-	NUT, HEX 1/2"
14	005370	-	WASHER, LOCK 1/2"
15	005900	-	BOLT, HHCS 5/16" x 1"
16	006670	-	KEY, SQ 3/8" x 1-1/2"
17	012410	-	BOLT, CRG 5/16" x 3/4"
18	020190	-	NUT, LOCK 5/16"
19	020430	-	WASHER, FLAT .688" x 1.75" x .134"
20	020440	-	WASHER, LOCK 5/8"
21	020450	-	NUT, HEX 5/8"
22	022520	-	SCREW, SHSS 3/8" x 1"
23	025670	-	NUT, LOCK 5/16"
24	028330	8	BOLT, HHCS 5/8" x 4-1/2"
25	990840	-	BOLT, HHCS 1/2" x 3"
26	049180	1	ZERK, GREASE 1/4"
27	056720	1	BOLT, HHCS 5/8" x 4"
28	229970	1	BAFFLE, TANK ELEVATOR REAR
29	229980	1	BAFFLE, TANK ELEVATOR FRONT
30	230330	1	SHAFT, CLUTCH DRIVE
31	230340	4	SPROCKET & HUB ASSY 1-7/16" (see page 30)
32	232240	2	BUSHING, 1-1/4" TO 1 HYDRAULIC CYLINDER
33	234380	4	CLAMP, SPROCKET HOLDER 1-7/16"
34	238020	1	SHAFT, HEAD DRIVE 1-7/16" x 53"
35	238420	1	BEARING, PILLOW BLOCK 1-3/4"
35	236490	-	BEARING ONLY, 1-3/4" W/LOCK COLLAR
36	240050	1	SHAFT, TOP VERTICAL ELEVATOR
37	240060	1	SPROCKET, 80 B 36
38	240070	1	SPROCKET, 60 B 24
39	240080	1	SPROCKET, 60 B 30
40	240100	2	SPROCKET & HUB ASSY 1-3/4"(see page 30)
41	240130	1	BEARING, PILLOW BLOCK 1-3/4"
42	240170	2	CLAMP, SPROCKET HOLDER 1-3/4"
43	240820	-	RIVET, POP 1/4" x 3/4"
44	244530	2	ROLLER ASSY, OUTSIDE FLANGED (see page 33)
45	245160	1	TANK ELEVATOR WELDMENT SWING
46	245240	2	LINER, PLASTIC ELEVATOR
47	245500	2	SPACER, BEARING
48	247100	8	ROLLER, RUBBER 5" x 5/8"
49	991200	-	BOLT, CRG 1/2" x 2"
50	I120396	-	WASHER, FLAT .531" x 1.062" x .074"
51	990710	-	WASHER, FLAT .812" x 2" x 1/8"

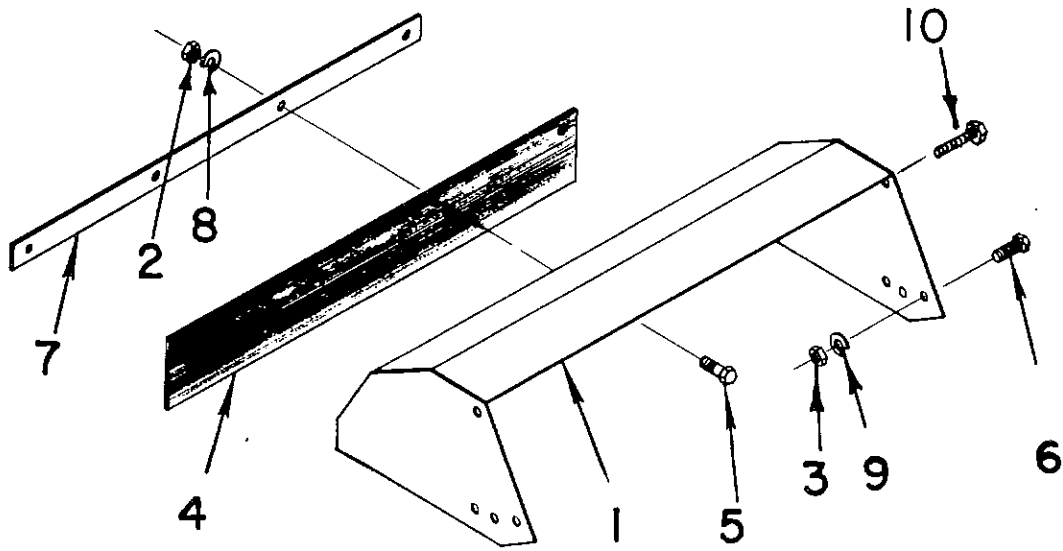
TRUCK SWINGING ELEVATOR ASSEMBLY

245420



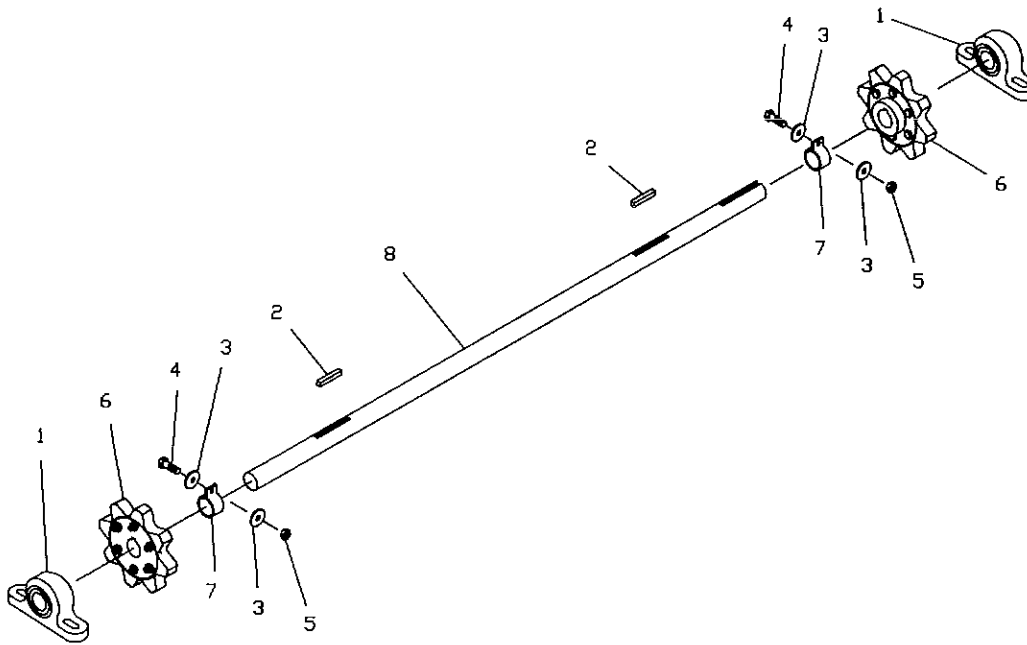
ITEM	PART NUMBER	QTY	DESCRIPTION
1	E366013	2	SPROCKET, IDLER 60B13
2	E552046	-	NUT, LOCK 5/8"
3	E724056	2	SPACER, BUSHING .742" x 1.050" x .750"
4	E724305	12	SPACER, 1" x .156"W x 2.1/2"
5	I271729	-	BOLT, HHCS 5/8" x 3-1/2"
6	250140	-	BOLT, CRG 5/8" x 1-1/2"
7	005360	-	NUT, HEX 1/2"
8	005370	-	WASHER, LOCK 1/2"
9	017200	1	SPRING, ROLL FEED
10	020440	-	WASHER, LOCK 5/8"
11	020450	-	NUT, HEX 5/8"
12	990650	-	BOLT, HHCS 5/8" x 3.0"
13	028330	12	BOLT, HHCS 5/8" x 4-1/2"
14	035210	-	WASHER, FLAT 5/8" x 1-1/4" x .095"
15	049180	2	ZERK, GREASE 1/4"
16	232080	1	HEAD SHAFT ASSY, TRUCK ELEVATOR (see page 29)
17	232240	4	BUSHING, 1-1/4" TO 1" HYDRAULIC CYLINDER
18	267850	2	DECAL, ARTS-WAY
19	244530	2	ROLLER ASSEMBLY, OUTSIDE FLANGED (see page 33)
20	245870	1	ELEVATOR WELDMENT, TRUCK
21	245970	1	CHAIN TIGHTENER
22	246000	1	SPACER, 5/8" x 1" x .31"
23	247100	12	ROLLER, RUBBER 5" x 5/8"
24	991200	-	BOLT, CRG 1/2" x 2"
25	250150	-	WASHER, SQUARE 5/8"

ELEVATOR HOOD - E348023



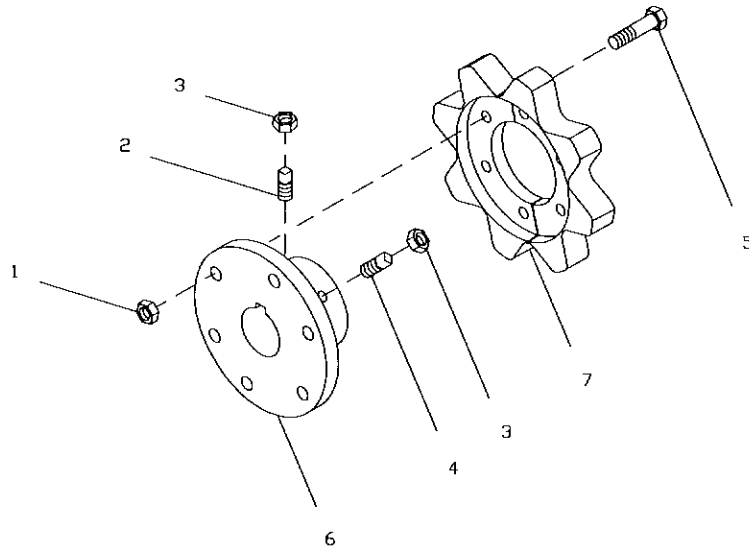
ITEM	PART NUMBER	QTY	DESCRIPTION
1	E348022	1	HOOD WELDMENT
2	027660	-	NUT, HEX 1/4"
3	005360	-	NUT, HEX, 1/2"
4	E658083	1	FLAP, RUBBER
5	042960	-	BOLT, HHCS 1/4" x 1"
6	031080	-	BOLT, HHCS 1/2" x 1"
7	E758085	1	STRAP
8	029440	-	WASHER, LOCK 1/4"
9	005370	-	WASHER, LOCK 1/2"
10	010730	-	BOLT, HHCS 1/2" x 1-1/4"

HEAD SHAFT ASSEMBLY - 232080



ITEM	PART NUMBER	QTY	DESCRIPTION
1	E072001	2	BEARING ASSY, 1-7/16" PILLOW BLOCK
2	E388074	2	KEY, SQ 3/8" x 2-1/4"
3	R61494	-	WASHER, FLAT .344" x .875" x .063"
4	005900	-	BOLT, HHCS 5/16" x 1"
5	025670	-	NUT, LOCK 5/16"
6	230340	2	SPROCKET & HUB ASSEMBLY (see page 30)
7	234380	2	CLAMP, 1-7/16" SPROCKET HOLDER
8	230330	1	SHAFT, CLUTCH DRIVE

DRAPER SPROCKET



ITEM	PART NUMBER	QTY	DESCRIPTION
1	073630	-	NUT, LOCK 3/8"
2	022520	-	SCREW, SHSS 3/8" x 1"
3	1124829	-	NUT, JAM 3/8"
4	131730	-	SCREW, SHSS 3/8" x 1-1/4"
5	011370	-	BOLT, HHCS 3/8" x 1-1/2"
6	SEE BELOW	-	
7	SEE BELOW	-	

TANK ELEVATOR SPROCKET ASSEMBLY

6	230340	-	SPROCKET & HUB ASSY, 1-7/16" BORE 10T
	E360024	1	HUB, 1-7/16" BORE
7	E740505	1	SPROCKET, SPLIT 10T

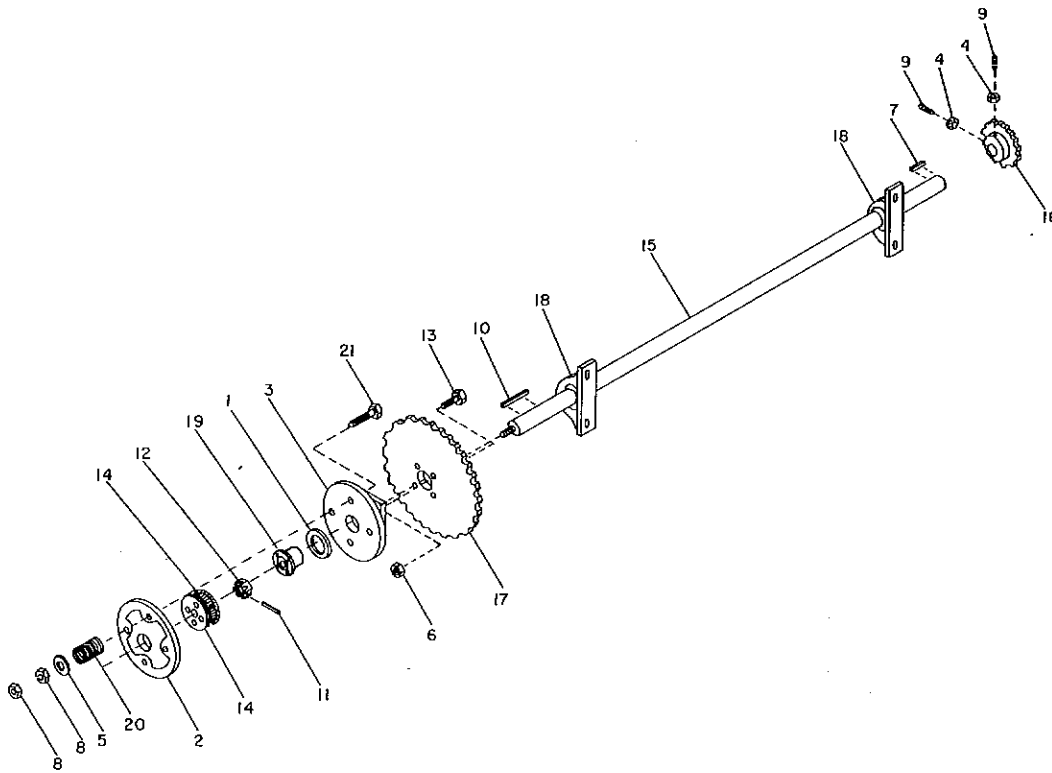
VERTICAL ELEVATOR SPROCKET ASSEMBLY

6	240100	-	SPROCKET & HUB ASSY, 1-3/4" BORE 10T
	240090	1	HUB, 1-3/4" BORE
7	E740505	1	SPROCKET, SPLIT 10T

TANK CONVEYOR SPROCKET ASSEMBLY

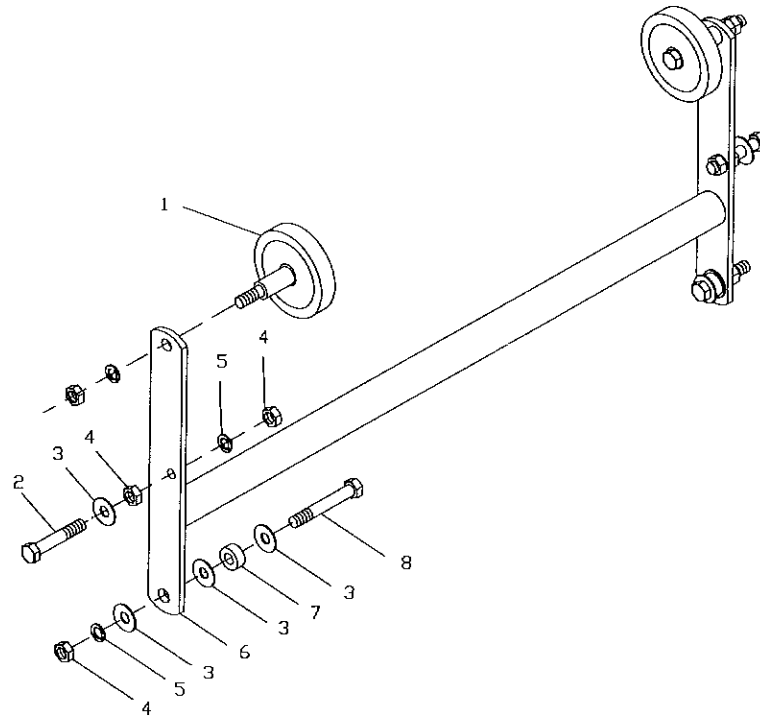
6	240490	-	SPROCKET & HUB ASSY, 1-7/16" BORE 8T
	E360024	1	HUB, 1-7/16" BORE
7	260660	1	SPROCKET, SPLIT 8T

CENTER JACKSHAFT - 239970



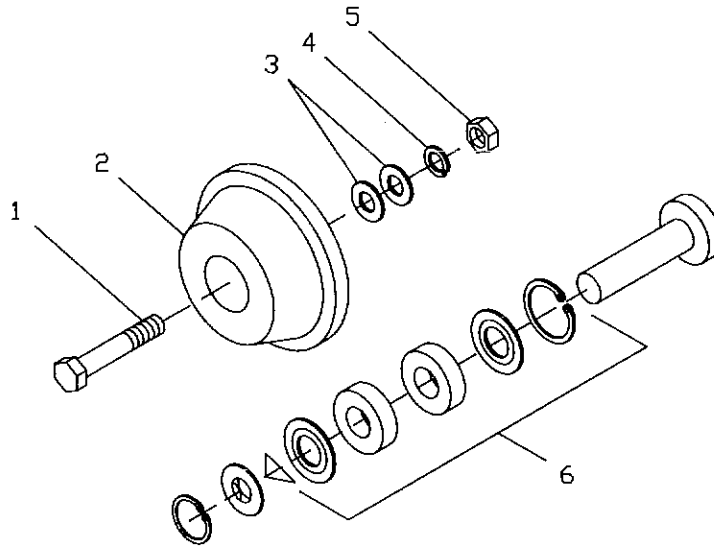
ITEM	PART NUMBER	QTY	DESCRIPTION
1	E126201	1	BUSHING, 2-1/2" x 3-7/8"
2	E280016	1	FLANGE WELDMENT, SPRING
3	E358044	1	HOUSING ASSEMBLY, CLUTCH
4	1124829	-	NUT, JAM 3/8"
5	125547R1	-	WASHER, FLAT .656" x 1.312" x .188"
6	19413967	-	NUT, LOCK 1/2"
7	006670	-	KEY, SQ 3/8" x 1-1/2"
8	1121555	-	NUT, JAM 5/8"
9	022520	-	SCREW, SHSS 3/8" x 1"
10	030380	-	KEY, SQ 3/8" x 3"
11	040900	-	PIN, ROLL 3/16" x 1-5/8"
12	042110	-	NUT, SLOTTED 1"
13	1770500	-	BOLT, HHCS 1/2" x 1-3/4"
14	225040	2	JAW, HARDENED SLIP CLUTCH
15	238270	1	SHAFT, CLUTCH JACK VERTICAL ELEVATOR
16	238300	1	SPROCKET, 80 B 15
17	238310	1	SPROCKET, 80 A 36
18	238420	2	BEARING, PILLOW BLOCK 1-3/4"
18	236490	-	BEARING ONLY, 1-3/4" W/LOCK COLLAR
19	238430	1	HUB WELDMENT, SLIP CLUTCH
20	239080	4	SPRING, COMPRESSION SLIP CLUTCH
21	990680	-	BOLT, HHCS 5/8" x 5-1/2"

TIGHTENER ARM - E790016



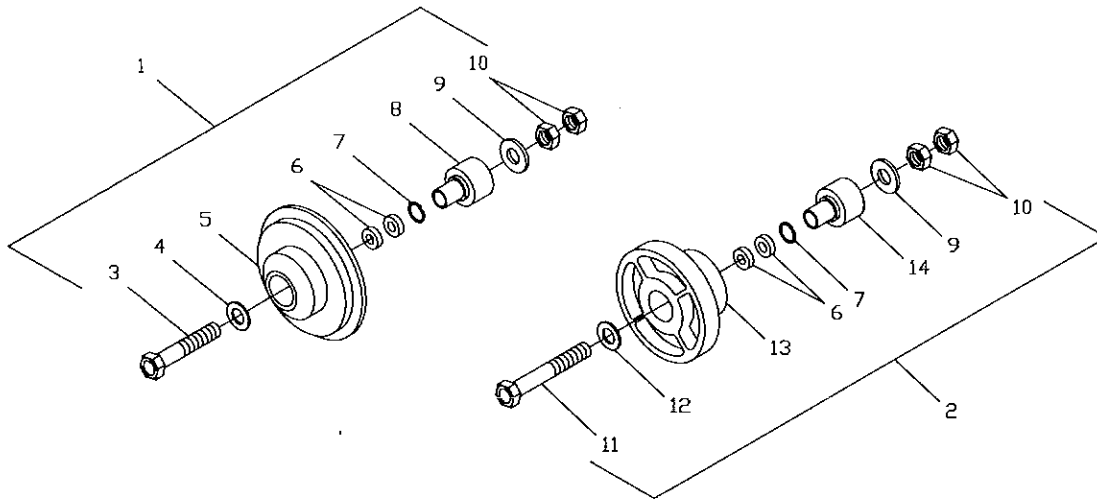
ITEM	PART NUMBER	QTY	DESCRIPTION
1	247110	2	ROLLER ASSY, RUBBER (see page 34)
2	990840	-	BOLT, HHCS 1/2" x 3"
3	005200	-	WASHER, FLAT .562" x 1.375" x .109"
4	005360	-	NUT, HEX 1/2"
5	005370	-	WASHER, LOCK 1/2"
6	E790015	1	TIGHTENER WELDMENT
7	E126002	2	BUSHING, TIGHTENER
8	038560	2	BOLT, HHCS 1/2" x 4"

CONE ROLLERS - 253190



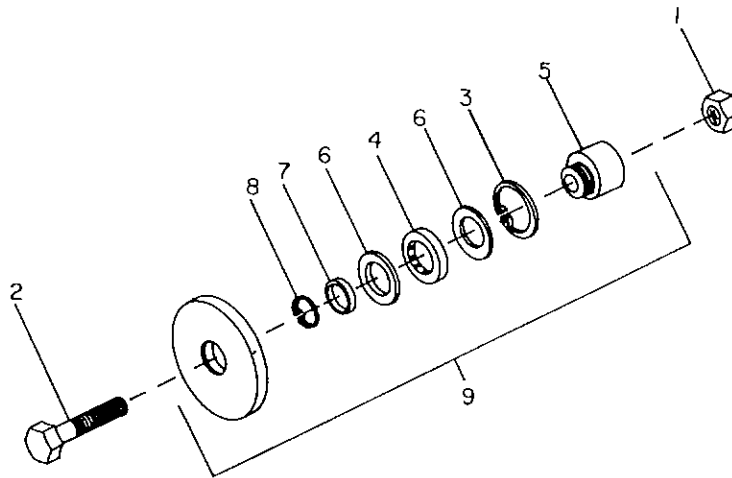
ITEM	PART NUMBER	QTY	DESCRIPTION
1	1271729	-	BOLT, HHCS 5/8" x 3-1/2"
2	253200	1	ROLLER ASSY, CONE 6"
3	035210	-	WASHER, FLAT .656" x 1.312" x .095"
4	020440	-	WASHER, LOCK 5/8"
5	1124589	-	NUT, HEX 5/8"
6	244480	-	KIT, ROLLER REPAIR

INSIDE AND OUTSIDE FLANGED ROLLERS



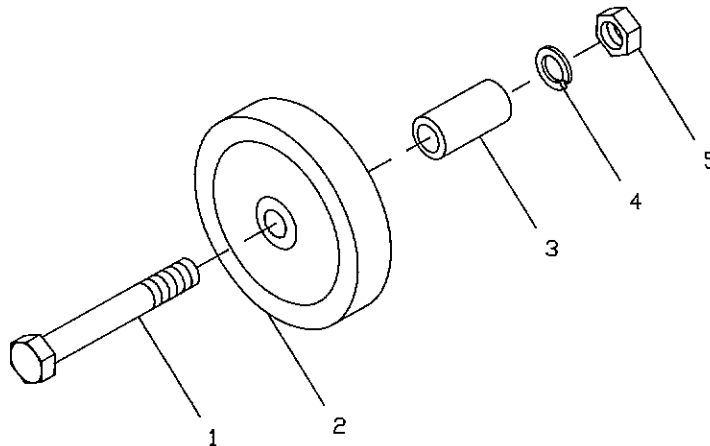
ITEM	PART NUMBER	QTY	DESCRIPTION
1	244530	1	ROLLER ASSY, OUTSIDE FLANGED
2	244700	1	ROLLER ASSY, INSIDE FLANGED
3	990590	1	BOLT, HHCS 3/4" x 4"
4	034800	-	WASHER, FLAT .75"ID x 1.50"OD x .075"
5	244520	1	ROLLER ASSY, FLANGED
6	240790	2	BEARING, BALL 25mm
7	129270	-	RING, RETAINING
8	244510	1	HUB, ROLLER
9	990710	-	WASHER, FLAT .812" x 2" x .149"
10	036750	-	NUT, HEX 3/4"
11	023550	1	BOLT, HHCS 3/4" x 5"
12	1131017	-	WASHER, FLAT .812" x 1.46" x .108"
13	240770	1	ROLLER, INSIDE FLANGED
14	240780	1	HUB, ROLLER SPACER

STEEL ROLLER W/BALL BEARINGS



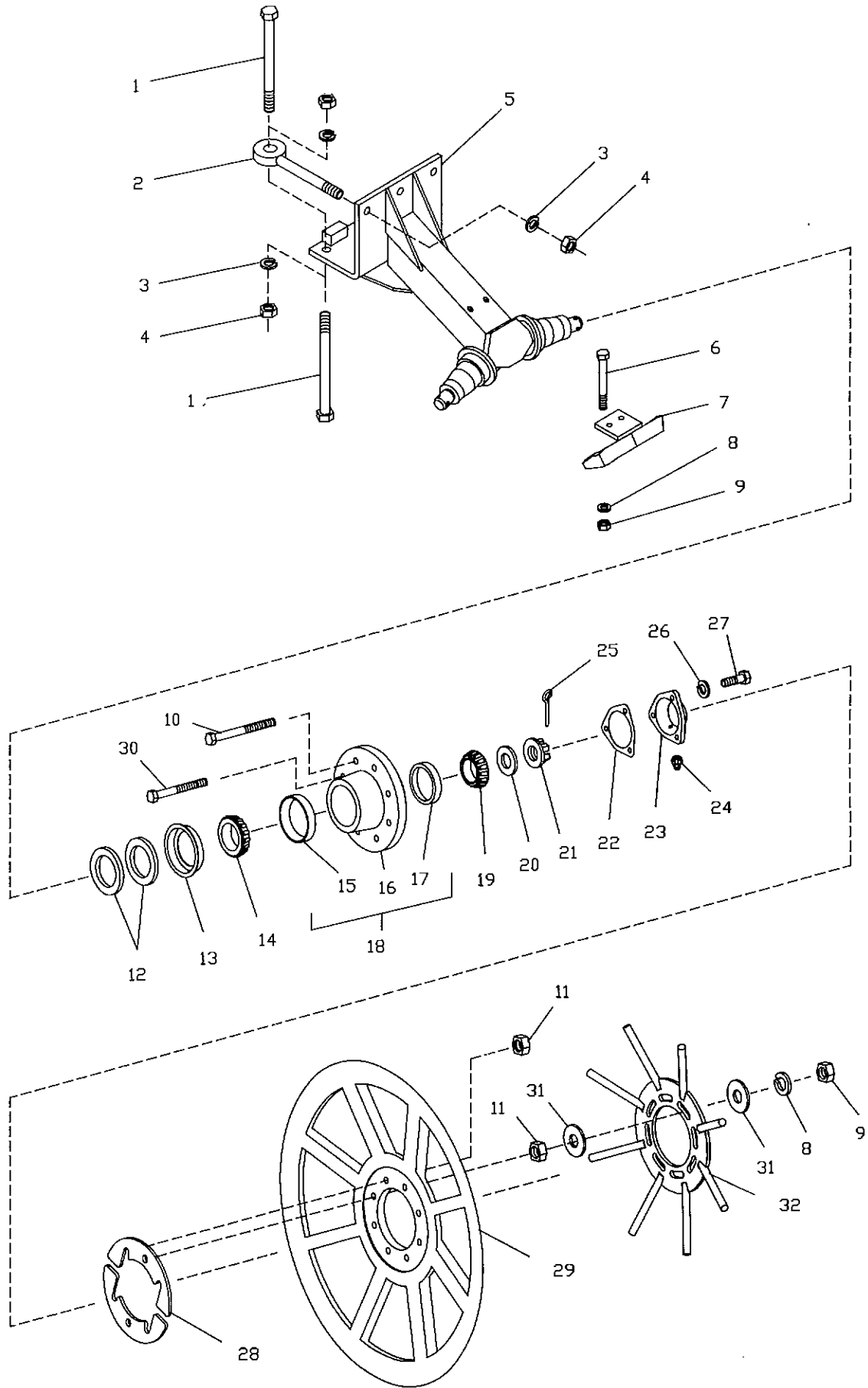
ITEM	PART NUMBER	QTY	DESCRIPTION
1	E552046	-	NUT, LOCK 5/8"
2	028330	1	BOLT, HHCS 5/8" x 4-1/2"
3	129270	-	RING, SNAP
4	240790	1	BEARING, BALL 25mm
5	242390	1	SHAFT, STUB
6	242400	2	RING, SEAL
7	242410	-	SEPARATOR
8	242420	-	RING, SNAP
9	240480	1	ROLLER ASSY, 4.75" OD

RUBBER ROLLER W/BALL BEARINGS - 247110



ITEM	PART NUMBER	QTY	DESCRIPTION
1	028330	1	BOLT, HHCS 5/8" x 4-1/2"
2	247100	1	ROLLER, RUBBER 5-1/8" W/BALL BEARING
3	E724305	1	SPACER, 1" x 5/32" x 1/2"
4	020440	-	WASHER, LOCK 5/8"
5	1124589	-	NUT, HEX 5/8"

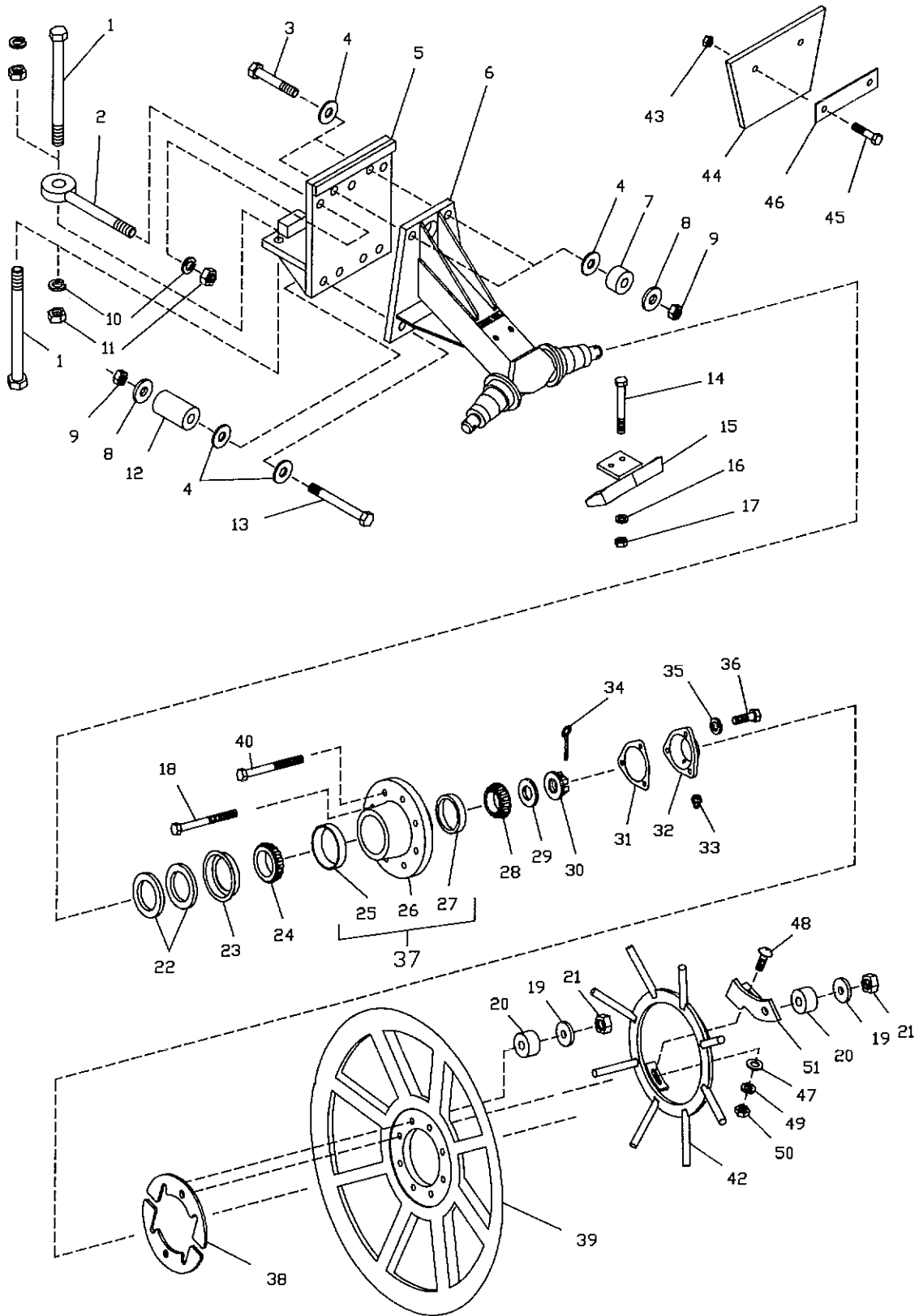
LIFTER WHEEL STANDARD STRUT



LIFTER WHEEL STANDARD STRUT - 268900

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E672071	3	BOLT, HHCS 5/8" x 8-1/2"
1	E672362	3	BOLT, HHCS 5/8" x 9" (FOR ROWFINDER)
2	E096016	3	BOLT, EYE 5/8" x 6"
3	020440	-	WASHER, LOCK 5/8"
4	020450	-	NUT, HEX 5/8"
5	267370	1	STRUT WELDMENT, STANDARD
6	018310	2	BOLT, HHCS 1/2" x 6"
7	341310	1	BULLHORN WELD, SCRAPER
8	005370	-	WASHER, LOCK 1/2"
9	005360	-	NUT, HEX 1/2"
10	268910	4	BOLT, SPECIAL 1/2" x 4-1/4"
11	127890	-	NUT, LOCK 1/2"
12	263170	-	WASHER, FELT
13	263160	-	RETAINER, FELT
14	261640	2	CONE, BEARING 2.375"
15	261650	2	CUP, BEARING
16	267350	2	HUB, LIFT STRUT
17	E072462	2	CUP, BEARING
18	267430	2	HUB ASSY, W/CUPS
19	184960	2	CONE, BEARING 2"
20	E829036	-	WASHER, FLAT 1-1/4"
21	340320	-	NUT, SLOTTED 1-1/4" FLANGE
22	JN70509	-	GASKET, HUB
23	JN72550	2	CAP, HUB
24	JJD7798	2	ZERK, GREASE 1/8"
25	013600	-	PIN, ROLL 1/4" x 2"
26	021180	-	WASHER, LOCK 3/8"
27	012260	-	BOLT, HHCS 3/8" x 1"
28	268570	-	SPACER, WHEEL
29	264670	2	LIFTER WHEEL, CAST STEEL
30	041410	-	BOLT, HHCS 1/2" x 3-1/4"
31	005200	-	WASHER, FLAT 1/2"
32	267480	2	CLOSEUP, LIFTER WHEEL

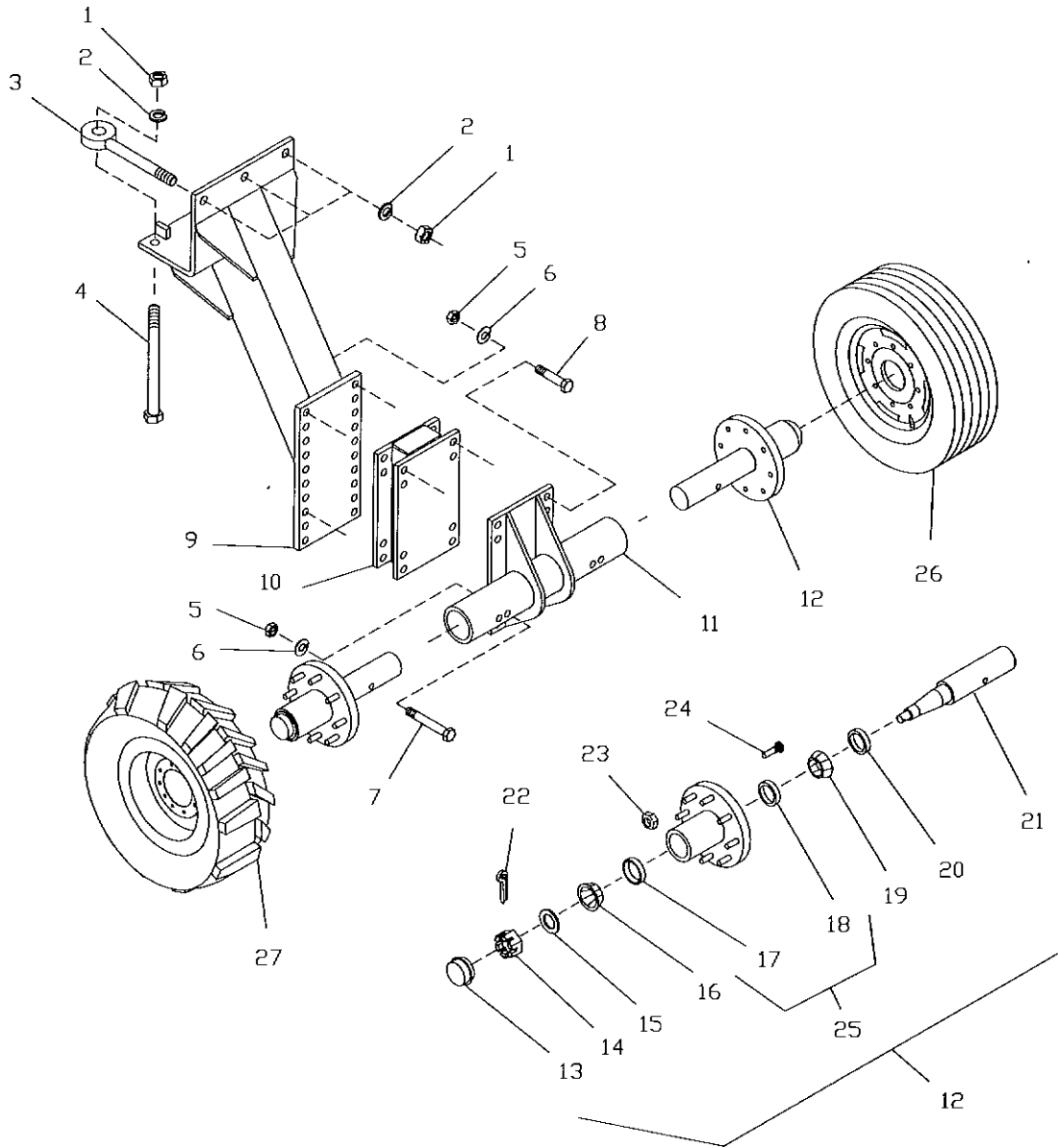
LIFTER WHEEL FLEX STRUT



LIFTER WHEEL FLEX STRUT - 268890

ITEM	PART NUMBER	QTY	DESCRIPTION
1	E672449	3	BOLT, HHCS 3/4" x 9-1/2"
1	147170	3	BOLT, HHCS 3/4" x 9"
2	251530	3	BOLT, EYE 3/4" x 6-1/2"
3	056720	2	BOLT, HHCS 5/8" x 4"
4	020430	-	WASHER, FLAT .688" x 1.75" x .134"
5	248280	1	STRUT WELDMENT, FLEX UPPER
6	267360	1	STRUT WELDMENT, FLEX LOWER
7	248290	2	PAD, FLEX 1.00"
8	340310	-	WASHER, FLAT .656" x 2.0" x .25"
9	E552046	-	NUT, LOCK 5/8"
10	036800	-	WASHER, LOCK 3/4"
11	J14H794	-	NUT, HEX 3/4"
12	248300	4	PAD, FLEX 3.00"
13	990680	4	BOLT, HHCS 5/8" x 5-1/2"
14	018310	2	BOLT, HHCS 1/2" x 6"
15	341310	1	BULLHORN WELD, SCRAPER
16	005370	-	WASHER, LOCK 1/2"
17	005360	-	NUT, HEX 1/2"
18	340300	4	BOLT, HEX 1/2" x 4-1/4"
19	I486801R1	-	WASHER, FLAT .531" x 2.0" x .25"
20	267710	12	PAD, FLEX 1.00"
21	127890	-	NUT, LOCK 1/2"
22	263170	4	WASHER, FELT
23	263160	2	RETAINER, FELT
24	261640	2	CONE, BEARING 2.375"
25	261650	2	CUP, BEARING
26	267350	2	HUB, LIFTER STRUT 8-BOLT
27	E072462	2	CUP, BEARING
28	184960	2	CONE, BEARING 2"
29	E829036	-	WASHER, FLAT 1.31" x 2.5" x .156"
30	340320	-	NUT, SLOTTED 1-1/4" FLANGE
31	JN70509	2	GASKET, HUB
32	JN72550	2	CAP, HUB
33	JJD7798	-	ZERK, GREASE 1/8"
34	013600	-	PIN, ROLL 1/4" x 2"
35	021180	-	WASHER, LOCK 3/8"
36	012260	-	BOLT, HHCS 3/8" x 1"
37	267430	2	HUB ASSY, W/CUPS
38	268570	2	SPACER, WHEEL
39	264670	2	LIFTER WHEEL, CAST STEEL
40	030420	8	BOLT, HHCS 1/2" x 4-1/2"
41	005200	-	WASHER, FLAT 1/2"
42	340260	2	CLOSEUP, LIFTER WHEEL FLEX
43	I9413967	-	NUT, LOCK 1/2" TOP
44	248800	3	PADDLE, RUBBER
45	014770	-	BOLT, HHCS 1/2" x 1-1/2"
46	273280	3	STRAP, PADDLE
47	021190	-	WASHER, FLAT 3/8"
48	035180	-	BOLT, CRG 3/8" x 1-1/4"
49	021180	-	WASHER, LOCK 3/8"
50	027260	-	NUT, HEX 3/8"
51	341290	4	BRACKET, MOUNTING

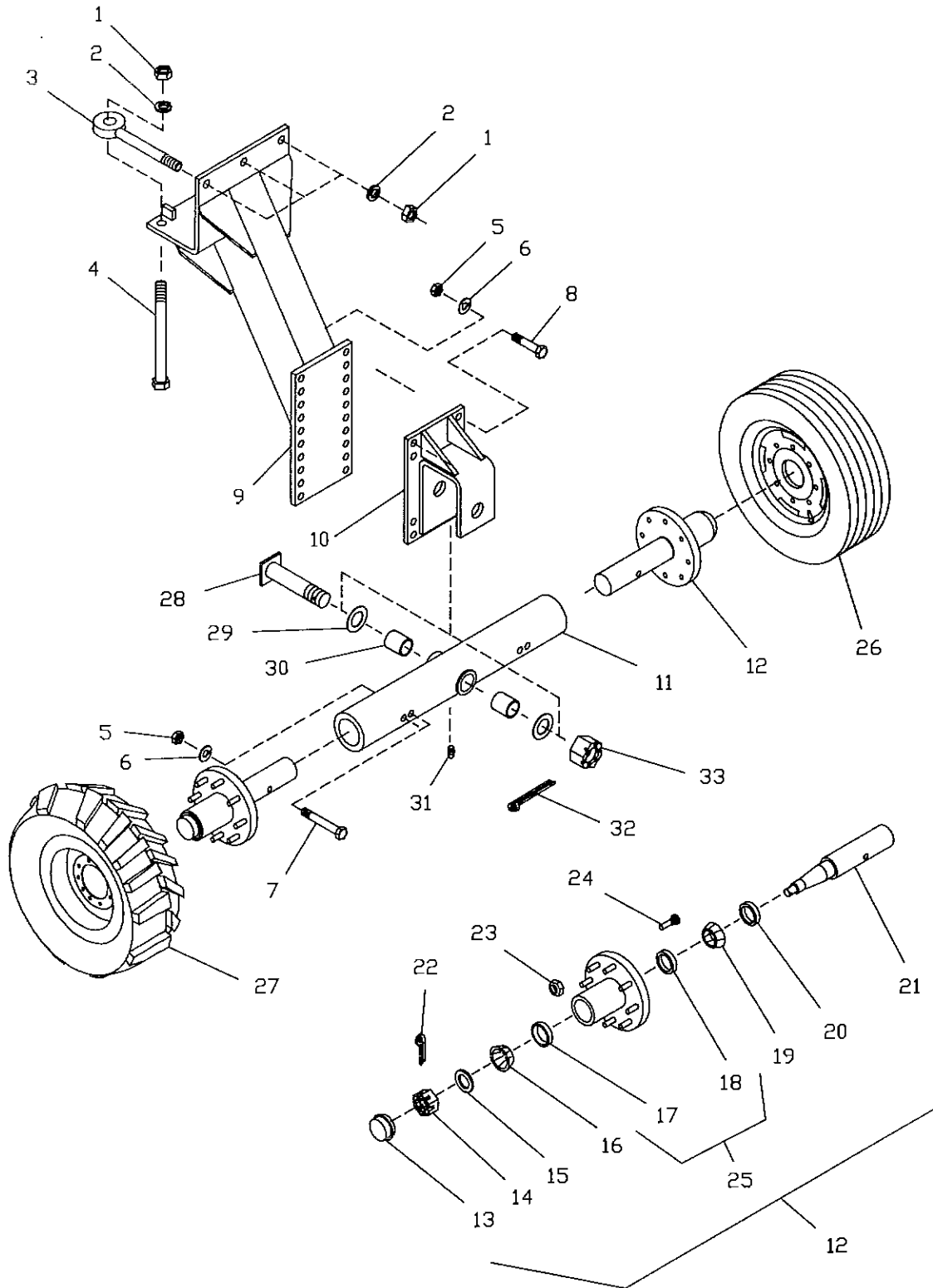
FIXED CARRIER WHEELS



FIXED CARRIER WHEELS - 228570

ITEM	PART NUMBER	QTY	DESCRIPTION
1	J14H794	-	NUT, HEX 3/4"
2	036800	-	WASHER, LOCK
3	E096162	6	BOLT, EYE 3/4" x 7"
4	E672449	3	BOLT, HHCS 3/4" x 9-1/2"
5	I124589	-	NUT, HEX 5/8
6	020440	-	WASHER, LOCK 5/8
7	028330	2	BOLT, HHCS 5/8" x 4-1/2"
8	990620	-	BOLT, HHCS 5/8" x 2"
9	E506084	2	LEG WELDMENT, CARRIER WHEEL
10	345440	1	BRACKET, EXTENSION (FOR TRACTION TIRE ONLY)
11	228760	2	BRACKET WELDMENT, AXLE
12	TG0496	4	HUB & SPINDLE ASSY
13	TG0769	4	CAP, HUB
14	129830	-	NUT, HEX 7/8" SLOTTED
15	E829019	-	WASHER, FLAT 15/16"
16	E072319	4	CONE, BEARING 1-5/16"
17	I13324D	4	CUP, BEARING
18	E072317	4	CUP, BEARING
19	E072316	4	CONE, BEARING 2"
20	TG0770	4	SEAL
21	TG0761	4	SPINDLE
22	026630	-	PIN, COTTER 5/32" x 1-1/2"
23	046710	-	NUT, WHEEL 9/16"
24	046700	-	BOLT, STUD 9/16" x 2-1/8"
25	TG0763	4	HUB ASSY, W/CUPS & STUDS
26	TG0495	4	WHEEL & TIRE ASSY
26	TG0740	4	TIRE, TUBELESS 11.00 x 16 12-PLY
26	TG0750	4	WHEEL, W10L-16 8-BOLT
26	164420	4	VALVE STEM, W/CORE & CAP
27	278440	4	WHEEL & TIRE ASSY LH (TRACTION)
27	278450	4	WHEEL & TIRE ASSY RH (TRACTION)
27	042263	4	WHEEL, 11 x 16.1 8-BOLT
27	164420	4	VALVE STEM, W/CORE & CAP
27	278460	4	TIRE, TUBELESS TRACTION 13.50 x 16.1 6-PLY

OSCILLATING CARRIER WHEEL

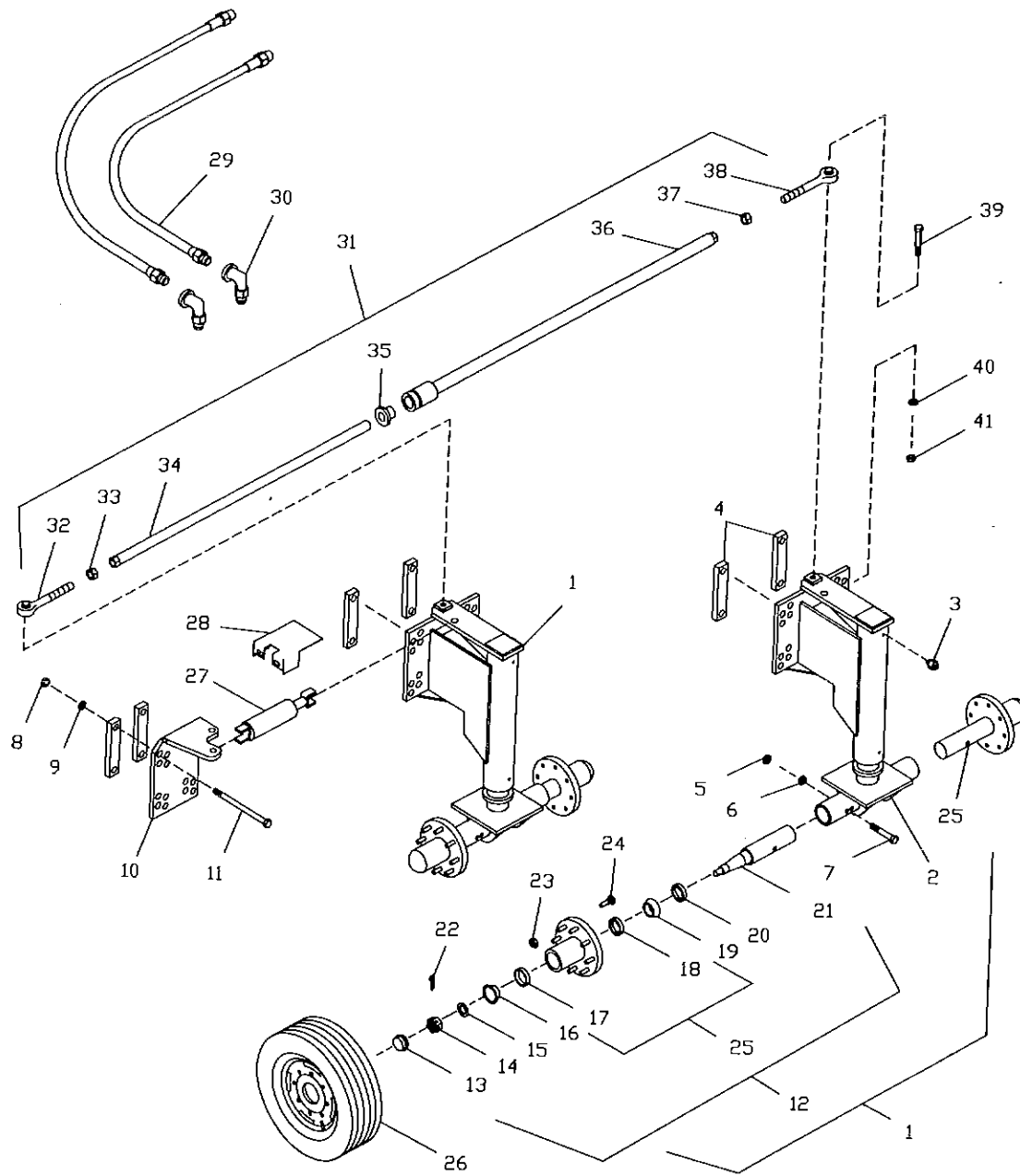


OSCILLATING CARRIER WHEEL

252010 - 44" 268840 - 28" & 30"

ITEM	PART NUMBER	QTY	DESCRIPTION
1	J14H794	-	NUT, HEX 3/4"
2	036800	-	WASHER, LOCK 3/4"
3	E096162	3	BOLT, EYE 3/4" x 7"
4	E672449	3	BOLT, HHCS 3/4" x 9-1/2"
5	I124589	-	NUT, HEX 5/8
6	020440	-	WASHER, LOCK 5/8
7	031490	1	BOLT, HHCS 5/8" x 5"
8	990620	-	BOLT, HHCS 5/8" x 2"
9	E506084	1	LEG WELDMENT, CARRIER WHEEL
10	251960	1	BRACKET, AXLE MOUNTING
11	268810	1	BEAM WELDMENT, AXLE 44"
11	268820	1	BEAM WELDMENT, AXLE 28"-30"
12	TG0496	2	HUB & SPINDLE ASSY
13	TG0769	1	CAP, HUB
14	129830	-	NUT, HEX 7/8" SLOTTED
15	E829019	-	WASHER, FLAT 15/16"
16	E072319	2	CONE, BEARING 1-5/16"
17	I13324D	2	CUP, BEARING
18	E072317	2	CUP, BEARING
19	E072316	2	CONE, BEARING 2"
20	TG0770	2	SEAL
21	TG0761	2	SPINDLE
22	026630	-	PIN, COTTER 5/32" x 1-1/2"
23	046710	-	NUT, WHEEL 9/16"
24	046700	-	BOLT, STUD 9/16" x 2-1/8"
25	TG0763	2	HUB ASSY, W/CUPS & STUDS
26	TG0495	2	WHEEL & TIRE ASSY
26	TG0740	2	TIRE, TUBELESS 11.00 x 16 12-PLY
26	TG0750	2	WHEEL, W10L-16 8-BOLT
26	164420	2	VALVE STEM, W/CORE & CAP
27	278440	2	WHEEL & TIRE ASSY LH (TRACTION)
27	278450	2	WHEEL & TIRE ASSY RH (TRACTION)
27	042263	2	WHEEL, 11 x 16.1 8-BOLT
27	164420	2	VALVE STEM, W/CORE & CAP
27	278460	2	TIRE, TUBELESS TRACTION 13.50 x 16.1 6-PLY
28	251860	-	PIN, PIVOT 1-1/2"
29	JN2018M	-	WASHER, THRUST 1.53"
30	044550	-	BUSHING, OILITE
31	115590	-	ZERK, GREASE 1/4"
32	E580042	-	PIN, COTTER 3/16" x 3"
33	E552084	-	NUT, HEX 1-1/2" SLOTTED

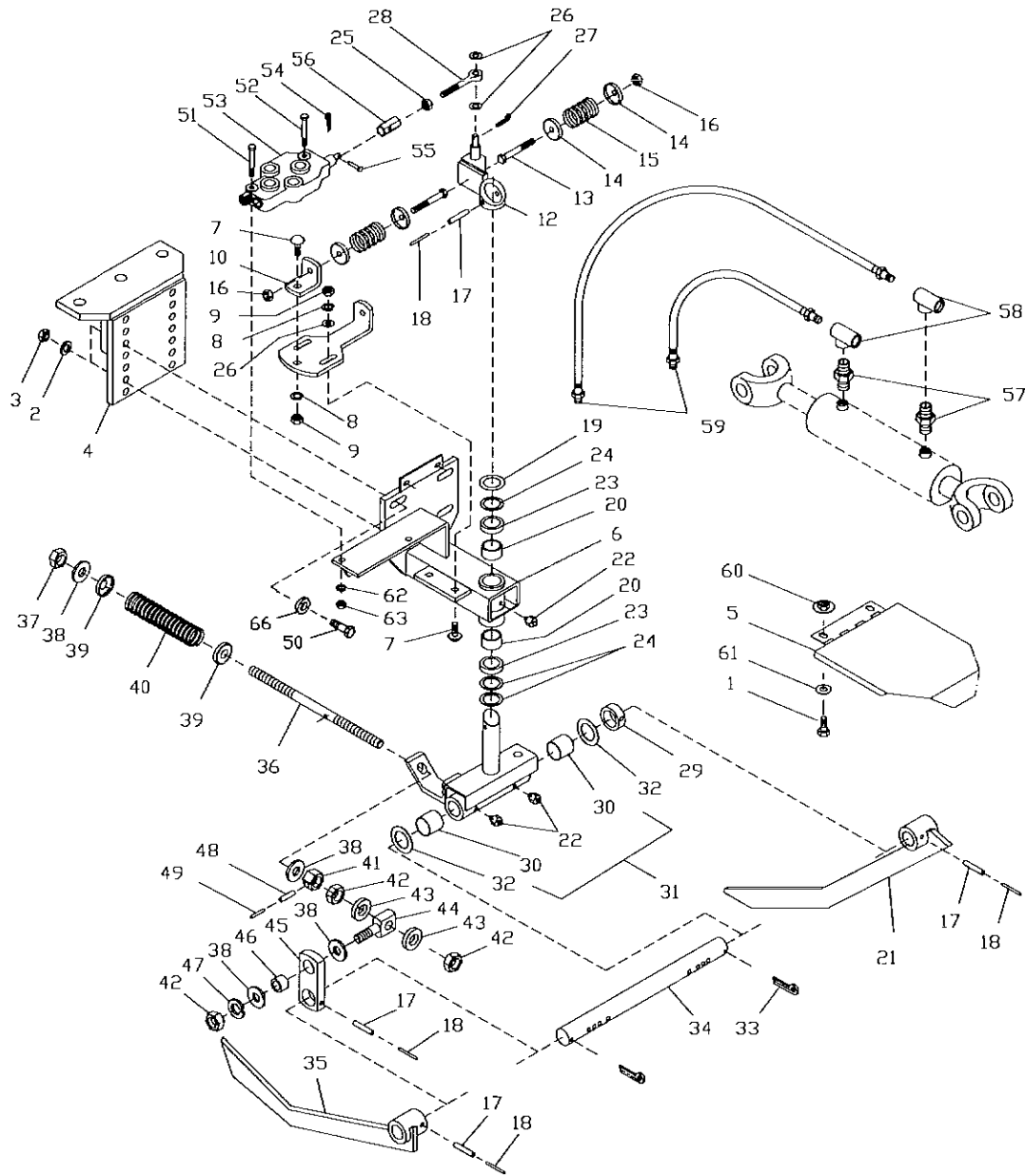
HEAVY DUTY STEERABLE WHEELS



HEAVY DUTY STEERABLE WHEELS - 236730

ITEM	PART NUMBER	QTY	DESCRIPTION
1	252060	2	STRUT & HUB ASSY, HD STEERABLE
2	252050	2	STRUT ASSY, HD STERRABLE
3	E334006	4	ZERK, 5/16" GREASE PRESS
4	E174044	4	PLATE, CLAMP
5	I124589	-	NUT, HEX 5/8
6	020440	-	WASHER, LOCK 5/8
7	028330	4	BOLT, HHCS 5/8" x 4-1/2"
8	J14H805	-	NUT, HEX 1"
9	003350	-	WASHER, LOCK 1"
10	236640	1	BRACKET, CYLINDER
11	252020	16	BOLT, HHCS 1" x 8"
12	TG0496	4	HUB & SPINDLE ASSY
13	TG0769	4	CAP, HUB
14	129830	-	NUT, HEX 7/8" SLOTTED
15	E829019	-	WASHER, FLAT 15/16"
16	E072319	4	CONE, BEARING 1-5/16"
17	I13324D	4	CUP, BEARING
18	E072317	4	CUP, BEARING
19	E072316	4	CONE, BEARING 2"
20	TG0770	4	SEAL
21	TG0761	4	SPINDLE
22	026630	-	PIN, COTTER 5/32" x 1-1/2"
23	046710	-	NUT, WHEEL 9/16"
24	046700	-	BOLT, STUD 9/16" x 2-1/8"
25	TG0763	4	HUB ASSY, W/CUPS & STUDS
26	TG0495	4	WHEEL & TIRE ASSY
26	TG0740	4	TIRE, TUBELESS 11.00 x 16 12-PLY
26	TG0750	4	WHEEL, W10L-16 8-BOLT
26	164420	4	VALVE STEM, W/CORE & CAP
27	E222002	4	CYLINDER
28	E694360	1	SHIELD, CYLINDER
29	E356113	1	HOSE, HYDRAULIC 1/2" x 300"
30	006240	2	ELBOW, STREET 1/2" x 90 DEG
31	E648044	2	TIE-ROD ASSY
32	E822006	1	TURNBUCKLE END, 1" x 8" RH
33	147310	-	NUT, HEX 1"
34	E648043	1	TIE-ROD WELDMENT, LH
35	E126108	1	BUSHING, SPLIT TAPER
36	E648042	1	TIE-ROD WELDMENT, RH
37	E552087	-	NUT, HEX 1" LH THREAD
38	E822007	1	TURNBUCKLE END, 1" x 8" LH
39	990590	2	BOLT, HHCS 3/4" x 4"
40	036800	-	WASHER, LOCK 3/4"
41	J14H794	-	NUT, HEX 3/4"

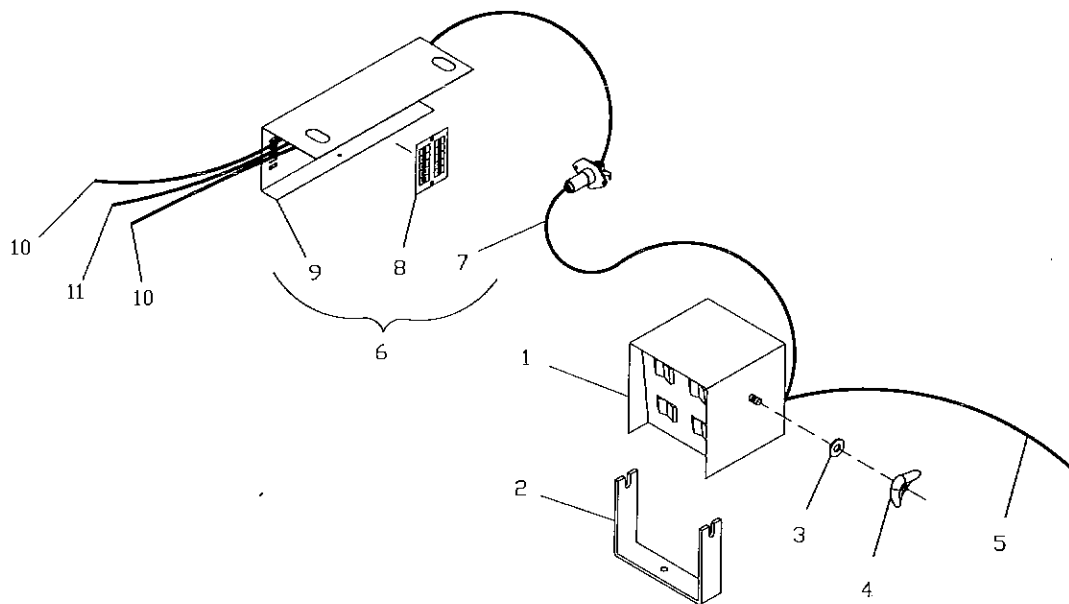
HYDRAULIC ROWFINDER



HYDRAULIC ROW FINDER - 342970

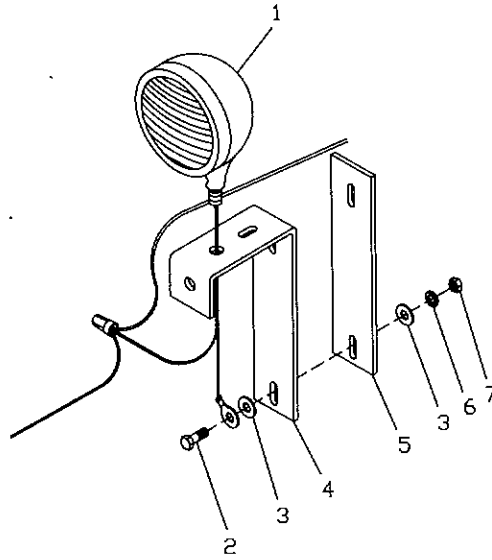
ITEM	PART NUMBER	QTY	DESCRIPTION
1	011370	-	BOLT, HHCS 3/8" x 1-1/2"
2	005370	-	WASHER, LOCK 1/2"
3	005360	-	NUT, HEX 1/2"
4	259470	1	BRACKET, WELDMENT MOUNTING
5	259620	1	SHIELD, WELDMENT ROW FINDER
6	259510	1	BRACKET, WELDMENT FRAME
7	035180	-	BOLT, CRG 3/8" x 1-1/4"
8	021180	-	WASHER, LOCK 3/8"
9	027260	-	NUT, HEX 3/8"
10	JN145971	1	BRACKET, ANGLE
11	JN145982	1	BRACKET, ADJUSTMENT
12	259560	1	ARM, WELDMENT CENTERING
13	990820	-	BOLT, HHCS 3/8" x 3"
14	JN73401	4	WASHER, CUPPED
15	JCJ21FN	2	SPRING, COMPRESSION .99" x 1.38" x 2"
16	073630	-	NUT, LOCK 3/8"
17	E580053	-	PIN, ROLL 5/16" x 1-3/4"
18	J34H288	-	PIN, ROLL 3/16" x 1-3/4"
19	I22266R1	-	WASHER, FLAT 1-1/8" x 1-3/4" x .027"
20	JJD8813	2	BEARING, 1.12"
21	JAN142149	1	SENSOR ASSY L.H.
22	049180	3	ZERK, GREASE 1/4"
23	JAT30144	2	SEAL, 1.1"
24	I23041R1	-	WASHER, FLAT 1.156" x 1.5" x .060"
25	I124829	-	NUT, JAM 3/8"
26	I120394	-	WASHER, FLAT .406" x .812" x .051"
27	023090	-	PIN, COTTER 3/32" x 3/4"
28	JAN71924	1	PIN, CONNECTING
29	JN145972	1	BUSHING, 1-1/4"ID
30	JL1713C	2	BUSHING, SHAFT
31	259590	1	SHAFT, "T" ASSY
32	I608700R1	-	WASHER, FLAT 1.281" x 2" x .054"
33	003950	-	PIN, COTTER 3/16" x 2"
34	JN145977	1	SHAFT, CROSS
35	JAN142148	1	SENSOR ASSY., R.H.
36	JN147175	1	STUD, ADJUSTING
37	JK40015	-	NUT, LOCK 5/8"
38	J24H1373	-	WASHER, FLAT .656" x 1.56" x .180"
39	JN147036	2	WASHER, CUPPED
40	J23096	1	SPRING, COMPRESSION 1" x 1-3/8" x 6"
41	JN147174	1	STOP, SPRING COMPRESSION
42	I124589	-	NUT, HEX 5/8"
43	J24H1367	-	WASHER, FLAT .656" x 1.25" x .250"
44	JN145970	1	BOLT, EYE 5/8" x 2.6"
45	JN145981	1	BRACKET, SPRING
46	JN145980	-	SPACER
47	020440	-	WASHER, LOCK 5/8"
48	1030808	-	PIN, ROLL 5/16" x 1-1/4"
49	991100	-	PIN, EXPAND 3/16" x 1-1/4"
50	1770500	-	BOLT, HHCS 1/2" x 1-3/4"
51	009800	-	BOLT, HHCS 5/16" x 2-1/2"
52	022910	-	BOLT, HHCS 5/16" x 2-1/4"
53	343250	1	CONTROL VALVE ASSY, OPEN CENTER
53	JAN103392	1	SEAL KIT, ROW FINDER VALVE
54	J11H230	-	PIN, COTTER 1/16" x 3/8"
55	JN73390	-	PIN, VALVE
56	JN73405	1	CLEVIS, VALVE
57	166250	2	ADAPTER, STRAIGHT
58	166290	2	ADAPTER, TEE
59	259600	2	HOSE, HYDRAULIC 3/8" x 79"
60	020180	-	NUT, LOCK 3/8" FLANGE
61	021190	-	WASHER, FLAT .438" x 1.0" x .083"
62	023620	-	WASHER, LOCK 5/16"
63	023630	-	NUT, HEX 5/16"
64	JAN71922	-	PLUG, OPEN CENTER (NOT SHOWN)
65	JAN14000	-	PLUG, CLOSED CENTER (NOT SHOWN)
66	005200	-	WASHER, FLAT 1/2"

CONTROL BOX AND WIRING



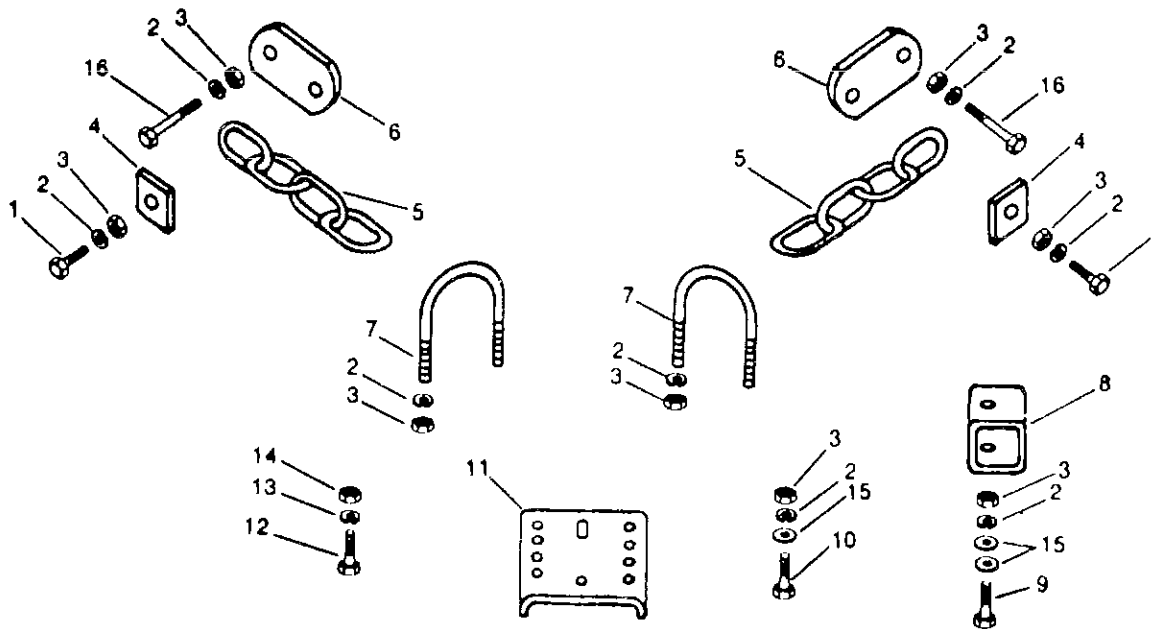
ITEM	PART NUMBER	QTY	DESCRIPTION
1	345560	1	CONTROL BOX ASSEMBLY
1	270210	1	DECAL, FRONT CONTROL BOX
1	270220	1	DECAL, REAR CONTROL BOX
1	345510	4	SWITCH, ROCKER ON-ON
2	270160	1	BRACKET, CONTROL BOX MOUNTING
3	022920	-	WASHER, FLAT 5/16"
4	035360	-	NUT, WING 1/4"
5	209390	1	CORD, SERVICE
6	270500	1	JUNCTION, ELECTRICAL ASSEMBLY
7	270350	1	WIRE ASSY, MAIN CONTROL
7	345590	1	WIRE ASSY, TRACTOR HALF
7	345600	1	WIRE ASSY, IMPLEMENT HALF
8	270470	1	BLOCK, CONTACT BARRIER
9	270490	1	SHIELD, ELECTRIC JUNCTION
10	270330	2	WIRE ASSY, 25 FT (TO ELECTRIC CLUTCHES)
11	273080	1	WIRE ASSY, 4 FT (TO HYDRAULIC TANK VALVE)

LIGHT PACKAGE - 270310



ITEM	PART NUMBER	QTY	DESCRIPTION
1	242110	3	LAMP, 12V HORIZ. MOUNT HALOGEN
2	011370	-	BOLT, HHCS 3/8" x 1-1/2"
3	021190	-	WASHER, FLAT 3/8"
4	236250	3	BRACKET, LIGHT MOUNTING
5	236260	2	BAR, LIGHT BRACKET BACK UP
6	021180	-	WASHER, LOCK 3/8"
7	027260	-	NUT, HEX 3/8"

DRAWBAR SUPPORT - JBN140202



ITEM	PART NUMBER	QTY	DESCRIPTION
1	013430	-	BOLT, HHCS 5/8" x 2-1/4"
2	020440	-	WASHER, LOCK 5/8"
3	1124589	-	NUT, HEX 5/8"
4	JN146861	2	WASHER, RECT. 21/32" x 1-1/4" x 1-1/2" x .250"
5	JAN142550	2	CHAIN, LINK
6	JN146862	2	STRAP, DRAWBAR SUPPORT
7	JN146864	2	U-BOLT, 5/8"
8	JN146865	1	TUBE (USE W/1-3/8" DRAWBAR)
9	990680	-	BOLT, HHCS 5/8" x 5-1/2" (USE W/1-3/8" DRAWBAR)
10	J19H3208	-	BOLT, HHCS 5/8" x 3" (USE W/1-3/8" DRAWBAR)
11	JN146863	1	PLATE, DRAWBAR SUPPORT
12	990570	-	BOLT, HHCS 3/4" x 3" (USE W/1-3/4" DRAWBAR)
13	036800	-	WASHER, LOCK 3/4"
14	J14H794	-	NUT, 3/4"
15	035210	-	WASHER, FLAT 21/32" x 1-5/16" x .090"
16	J19H3208	-	BOLT, HHCS 5/8" x 3"
16	J19H3170	-	BOLT, HHCS 5/8" x 4-1/2" (USE W/1-3/8" DRAWBAR)

DECALS AND PAINT

PART NUMBER	DESCRIPTION
236050	PAINT, 16 OZ. SPRAY CAN BLUE
212180	PAINT, 1 QT. CAN BLUE
212170	PAINT, 1 GAL. CAN BLUE
153090	PAINT, 16 OZ. SPRAY CAN WHITE
212000	PAINT, 1 QT. CAN WHITE
211990	PAINT, 1 GAL. CAN WHITE
E224032	DECAL, WARNING-DO NOT LIFT COVER
E224071	DECAL, CAUTION-KEEP HANDS-SHIELDS
E224072	DECAL, WARNING-STAND OR RIDE
E224146	DECAL, STRIPE
148190	DECAL, CAUTION SHIELD FOR PROTECTION
227420	REFLECTOR, AMBER
227430	REFLECTOR, RED
234340	DECAL, CAUTION 8 INSTRUCTIONS
234350	DECAL, DANGER CHECK ELEC CLEARANCE
234360	DECAL, DANGER ROTATING ROLLS
235420	DECAL, IMPORTANT IDLER SPRING
245150	DECAL, ARTS-WAY
247150	DECAL, 680B
248750	DECAL, CHAIN PATH
267860	LABEL, FEMA
E224133	DECAL ASSY, SLOW MOVING VEHICLE
115370	DECAL, HITCH INSTRUCTIONS
E770002	TAG, WARNING CHECK OIL LEVEL
267850	DECAL, ARTS-WAY

SPECIFICATIONS
680B BEET HARVESTER
GENERAL DESCRIPTION

Overall Dimensions
 Transport 13'9"H x 18'4"W x 17'4"L
 Operating 13'9"H x 24'W x 17'4"L

Machine Weight 15,000 lbs

Tank:
 Construction Welded Steel
 Capacity 11,000 pounds
 Unloading: Chain type conveyor, actuated by electro-hydraulic valve and hydraulic motor

Tread Width Adjustable to row spacing

Tires Non-Tank 11L-15 8 ply
 Implement 11.00-16 12 Ply
 Traction 13.50 x 16.1 6 Ply

Operating pressure 36 psi (non-tank)
 45 psi (Implement)
 25 psi (Traction)

Row Spacing
 4 rows 28 to 30 inches
 6 rows 22 to 24 inches

Operating Speed 4.5 to 6 mph

Lift and Depth Control* Hydraulic

Steering Hitch Control** Hydraulic

*Requires 5" x 8" Remote Cylinder(not furnished)
 **Requires 4" x 8" Remote Hydraulic Cylinder(not furnished)

Lifter Wheels
 (2 per row) 28 inches solid rim Heavy Duty Cast Steel

Lifter Struts
 Heavy Duty Tapered Bearings

Lifter Wheel Scrapers
 to prevent mud buildup on lifter wheels

Paddle Shaft and Drive

Type: Three steel per row

Drive: Heavy #80 Roller Chain with Heavy Duty Slip clutch

Bed Chain and Drive

Size: 25 Sq.Ft.

Type: Two 40-inch and two 23.5-inch wide Draper Chain

Drive: #60 Roller Chain with Shear Bolt Protection

Grab Rolls and Drive

Size: 35 Sq.Ft.

Type: Three 6-5/8-inch grab rolls with 3/4" spiral rods and three 5-inch smooth grab rolls

Drive: Belt Drives with Spring Loaded Idlers

CENTER GEARBOX

Center: Heavy, 1-3/4" Diameter Shafts
 Capacity - 5 Qts 90W Gear Oil

Right: Heavy 1-3/8" Diameter Shafts
 Capacity - 2 Qts 90W Gear Oil

Elevator

Size: Width, 40-inch Draper Chain Hugger Action

Type: Electric Clutch controlled, retractable for transport.

Tightening Torque Guide
SAE GRADE 5 - Coarse Thread

SIZE	CLAMP LOAD	PLAIN	PLATED
1/4 - 20(250)	2,025	8 ft. lbs.	76 in. lbs.
5/16 - 18(3125)	3,338	17 ft. lbs.	13 ft. lbs.
3/8 - 16(375)	4,950	31 ft. lbs.	23 ft. lbs.
7/16 - 14(4375)	6,788	50 ft. lbs.	37 ft. lbs.
1/2 - 13(500)	9,075	76 ft. lbs.	57 ft. lbs.
9/16 - 12(5625)	11,625	109 ft. lbs.	82 ft. lbs.
5/8 - 11(625)	14,400	150 ft. lbs.	112 ft. lbs.
3/4 - 10(750)	21,300	266 ft. lbs.	200 ft. lbs.
7/8 - 9(875)	29,475	430 ft. lbs.	322 ft. lbs.
1 - 8(1000)	38,625	644 ft. lbs.	483 ft. lbs.
1-1/8 - 7(1125)	42,375	794 ft. lbs.	596 ft. lbs.

SPECIFICATIONS

TRACTOR REQUIREMENTS

Recommended Horsepower Rating

Tank 140 PTO HP (minimum)
Non-Tank 120 PTO HP (minimum)

Remote Cylinders: (Not Furnished)

(1) 4" x 8" and (1) 5" x 8"

Hydraulics Requirements

Tractor must be equipped with three remote hydraulic outlets, four remotes if equipped with steerable wheels. The tractor must be capable of supply 20 gpm. If using the "Power Beyond" connect to the row finder, and tank drives.

PTO Shaft

Tractors must have 1.38-inch or 1.75-inch diameter 1000 rpm PTO shaft.

Front Ballast

Maximum tractor front balast is required.

Drawbar Support (Recommended)

Electrical System

12-Volt

ATTACHMENTS

Row Finder: To keep the harvester on the row.

Lifter wheel close-ups: to prevent loss of small beets through lifter wheels

Lifter wheel spacers: to increase lifter wheel opening by 1/4" increments

Lifter wheel cushions: to protect lifter wheels in rocky soil conditions(standard on flex struts).

Constant Velocity PTO: allows turning without disengaging PTO

Flashing Warning Light Kit: recommended where regulations allow when towing harvester. Order JTY15263

Light Package: to light machine for night use (3 sealed beam halogen lights)

Fixed or Steerable Wheels

Extra Fixed or Steerable Carrier Sturt: helps flotation in very wet conditions

Spring Loaded #2 Grab Roll: Allows #1 and #2 Grab rolls to move apard on drive end

INDEX

PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY
006240	44	30	148190	50		228760	40	11	231840	14	57
006300	22	34	149670	18	50	228980	20	30	232080	27	16
010240	5	4	152710	20	28	229690	12	101	232240	10	43
010240	12	79	153090	50		229700	18	53	232240	26	32
010240	12	80	159100	22	22	229720	20	33	232240	27	17
010380	14	15	164420	40	26	229950	18	54	232260	18	68
010380	16	55	164420	40	27	229970	18	55	232270	18	69
010560	12	100	164420	42	26	229970	26	28	232320	18	70
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014280	22	18	164420	44	26	229980	26	29	234340	50	
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018310	36	6	166140	22	40	230320	20	34	234360	50	
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019090	20	14	166250	46	57	230330	29	8	234380	26	33
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115370	10	29	225110	12	10	231670	12	66	235870	8	15
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129270	33	7	227430	50		231730	12	99	236050	50	
129270	34	3	228030	5	2	231760	12	102	236250	48	4
144730	18	49	228040	5	3	231760	24	25	236260	48	5
147170	38	1	228740	12	65	231810	14	16	236400	12	110

INDEX

PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY	PART NUMBER	PAGE	KEY
236460	12	79	240060	26	37	241670	6	6	246000	27	22
236460	12	80	240070	26	38	242110	48	1	246010	18	82
236490	12	5	240080	26	39	242390	34	5	246080	18	109
236490	26	35	240090	30	6	242400	34	6	246120	12	114
236490	31	18	240100	26	40	242410	34	7	246180	10	33
236500	16	36	240100	30		242420	34	8	246380	6	13
236550	8	3	240130	26	41	242500	6	4	246730	14	69
236640	44	10	240160	24	27	244480	33	6	246750	14	79
236810	5	6	240170	26	42	244490	14	84	246780	14	56
237200	14	54	240480	24	28	244500	14	85	246870	14	72
238020	26	34	240480	34	9	244510	33	8	246880	16	33
238110	18	71	240490	20	36	244520	33	5	246900	16	43
238120	18	72	240490	30		244530	14	34	246980	14	80
238140	9	6	240550	12	22	244530	26	44	247040	12	62
238150	9	1	240550	24	29	244530	27	19	247050	12	63
238200	9	5	240720	24	30	244530	33	1	247060	12	69
238210	18	73	240730	14	67	244620	12	2	247070	12	70
238270	31	15	240770	33	13	244630	12	3	247100	14	35
238280	9	10	240780	33	14	244640	12	118	247100	24	33
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238300	31	16	240790	34	4	244660	12	2	247100	27	23
238310	31	17	240820	26	43	244660	12	3	247100	34	2
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239590	20	31	241220	18	93	245880	18	91	251960	42	10
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239970	24	26	241650	6	4	245970	27	21	252050	44	2
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INDEX

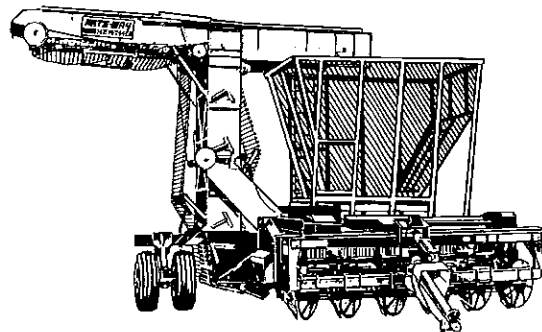
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252160	14	26	261640	38	24	270210	47	1	343370	22	24
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252230	14	76	263160	38	23	270490	47	9	990590	16	44
252230	24	31	263170	36	12	270500	12	121	990590	33	3
252240	14	76	263170	38	22	270500	18	83	990590	44	39
252240	24	31	264670	12	117	270500	47	6	990680	12	56
252250	14	76	264670	36	29	270620	22	33	990680	16	79
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252450	18	102	265470	16	35	273880	7	18	990680	49	9
252480	18	102	267350	36	16	273890	7	19	E036002	14	1
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252590	6	7	267370	36	5	278440	42	27	E0706098	16	14
252610	6	12	267430	36	18	278450	40	27	E072001	14	2
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252820	10	37	267850	50		340300	38	18	E072316	40	19
252870	10	38	267860	50		340320	36	21	E072316	42	19
253020	6	11	268180	12	116	340320	38	30	E072316	44	19
253180	6	8	268240	12	44	341060	12	40	E072317	40	18
253190	14	33	268250	12	81	341070	12	41	E072317	42	18
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253850	18	102	268570	38	38	341090	12	39	E072319	40	16
259460	46	59	268590	22	20	341290	38	51	E072319	42	16
259470	46	4	268610	22	11	341310	36	7	E072319	44	16
259510	46	6	268810	42	11	341310	38	15	E072375	16	40
259560	46	12	268820	42	11	342780	22	39	E072391	14	4
259590	46	31	268890	12	77	342820	10	34	E072431	12	97
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260650	18	117	269990	20	35	342950	6	16	E096016	36	2
260660	30	7	270000	22	19	342960	6	9	E096054	14	7
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INDEX

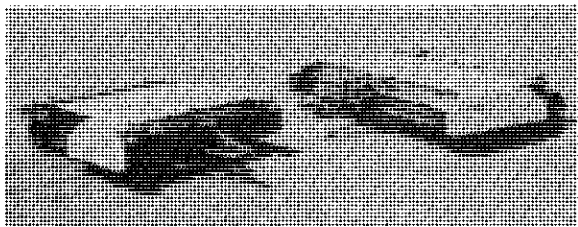
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E096162	40	3	E259001	26	3	E672446	18	9	E762380	14	55
E096162	42	3	E259002	18	115	E672449	38	1	E770002	50	
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E102114	18	115	E280016	31	2	E672449	42	4	E790016	18	13
E104147	14	8	E302012	7	9	E682738	14	44	E820072	16	76
E104147	24	3	E347001	9	4	E682753	12	12	E822006	44	32
E104319	14	64	E347001	18	4	E694313	5	11	E822007	44	38
E126002	32	7	E348022	28	1	E694314	5	14	E823023	12	80
E126011	12	8	E348023	18	5	E694360	44	28	E825014	16	65
E126020	16	84	E356113	44	29	E694485	12	67	E830068	5	6
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E126113	12	9	E366013	27	1	E724045	26	6	E850146	14	32
E126151	16	45	E386015	22	42	E724056	26	7	E850234	14	30
E126177	16	67	E406832	14	51	E724056	27	3	E850437	14	31
E126179	16	72	E407085	12	12	E724073	20	4	E850472	14	32
E126195	16	78	E407086	12	12	E724085	16	52	I13324D	40	17
E126196	16	63	E504003	12	25	E724114	9	9	I13324D	42	17
E126197	16	15	E504003	16	31	E724122	12	73	I13324D	44	17
E126201	12	13	E506084	40	9	E724178	14	45	I478037R92	12	100
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E164080	16	51	E580109	10	10	E724305	26	8	JAN103392	46	53
E166035	14	12	E586014	10	11	E724305	27	4	JAN131153	22	37
E166035	18	1	E604030	5	1	E724305	34	3	JAN142148	46	35
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E174044	44	4	E648043	44	34	E738016	18	10	JAN71924	46	28
E174068	12	11	E648044	44	31	E740120	18	11	JAR90579	10	42
E174071	14	14	E650089	14	30	E740169	18	12	JAT30144	46	23
E184015	9	3	E650136	14	31	E740215	16	81	JCJ21FN	46	15
E184015	18	2	E650140	14	32	E740505	30	7	JJD8813	46	20
E222002	44	27	E658083	28	4	E740881	12	17	JL1713C	46	30
E224032	50		E658084	14	37	E740968	12	74	JN132040	22	38
E224071	50		E658085	12	45	E741067	12	75	JN145971	46	10
E224072	50		E672071	16	38	E758083	14	52	JN145972	46	29
E224133	18	3	E672071	36	1	E758084	12	76	JN145977	46	34
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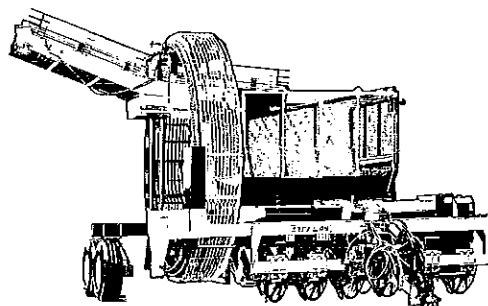
ARTS-WAY



MODEL 680B BEET HARVESTER



MODELS 784A, 786A & 630 DEFOLIATORS



MODEL 690 BEET HARVESTER



ART'S-WAY MANUFACTURING CO., INC.
ARMSTRONG, IOWA 50514
(712) 864-3131