



Art's-Way Manufacturing Co., Inc.

Model 6812
Sugar Beet Harvester

Illustrated Parts List
531090

Issued 08-2005



This symbol means ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED. The message that follows the symbol contains important information about your safety. Carefully read the message. Make sure you fully understand the causes of possible injury or death.

IF THIS MACHINE IS USED BY AN EMPLOYEE, IS LOANED, OR IS RENTED, MAKE SURE THAT THE OPERATOR UNDERSTANDS THE TWO INSTRUCTIONS BELOW.

BEFORE THE OPERATOR STARTS THE ENGINE:

1. GIVE INSTRUCTIONS TO THE OPERATOR ON SAFE AND CORRECT USE OF THE MACHINE.
2. MAKE SURE THE OPERATOR READS AND UNDERSTANDS THE OPERATOR'S MANUAL FOR THIS MACHINE.

WARNING

IMPROPER OPERATION OF THIS MACHINE CAN CAUSE INJURY OR DEATH.

BEFORE STARTING THE ENGINE, DO THE FOLLOWING:

1. READ THE OPERATOR'S MANUAL.
2. READ ALL SAFETY DECALS ON THE MACHINE.
3. CLEAR THE AREA OF OTHER PERSONS.

LEARN AND PRACTICE SAFE USE OF MACHINE CONTROLS IN A SAFE AND CLEAR AREA BEFORE YOU OPERATE THIS MACHINE ON A JOB SITE.

It is your responsibility to observe pertinent laws and regulations and to follow manufacturer's instructions on machine operation and maintenance.

See your Authorized Art's-Way Manufacturing Co., Inc. dealer or Art's-Way Manufacturing Co., Inc. for additional operator's manuals, illustrated parts catalogs, and service manuals.

TO THE OWNER

Congratulations on the purchase of your new Art's-Way Sugar Beet Harvester. You have selected a top quality machine that is designed and built with pride to ensure you have many years of efficient and reliable service.

Many people have worked on the design, production, and delivery of this Sugar Beet Harvester. The information in this Manual is based on the knowledge, study, and experience through years of specializing in the manufacturing of farm machinery. This Manual is designed to provide you with important information regarding safety, maintenance, and machine operation so you can and will get the best possible performance from your Sugar Beet Harvester.

Even if you are an experienced operator of this or similar equipment, we ask that you read this manual before operating this Sugar Beet Harvester. The way you operate, adjust, and maintain this unit will have much to do with its successful performance. Any further questions you may have about this product of Art's-Way equipment should be directed to your local Art's-Way dealer or to Art's-Way Manufacturing Co., Inc., Armstrong, Iowa, 50514, (712) 864-3131.

SPECIFICATIONS AND DESIGN ARE SUBJECT TO CHANGE WITHOUT NOTICE

Art's-Way Manufacturing Co., Inc. is continually making product improvements. In doing so, we reserve the right to make changes and/or add improvements to our products without obligation for the equipment previously sold.

Modifications to this Sugar Beet Harvester may affect the performance, function, and safety of its operation. Therefore, no modification are to be made without the written permission of Art's-Way Manufacturing Co., Inc. Any modification made without the written permission of Art's-Way Mfg. Co. shall void the warranty of this product.

In the interest of continued safe operation of this Sugar Beet Harvester, pay particular attention to the safety alert symbol(s) throughout this Manual.

ART'S-WAY MANUFACTURING CO., INC. STATEMENT OF PRODUCT LIABILITY

Art's-Way Manufacturing Co., Inc. recognizes its responsibility to provide customers with a safe and efficient product. Art's-Way Manufacturing Co., attempts to design and manufacture its products in accordance with all accepted engineering practices effective at the date of design. This statement should not be interpreted to mean that our products will protect against the user's own carelessness or failure to follow common safety practices nor will Art's-Way Manufacturing Co., be liable for any such act. In addition, Art's-Way Manufacturing Co., assumes no liability for any altered product or any modified product by users or anyone other than an authorized dealer.

IMPORTANT WARRANTY INFORMATION

The warranty for this Sugar Beet Harvester appears on page 4 of this manual. In order to establish proper warranty registration, the Warranty Registration must be completed and returned to the factory. Failure to comply with this requirement may result in reduced warranty allowances.

LIMITATIONS OF THIS MANUAL

This Manual contains operating instructions for your 6812 Sugar Beet Harvester only. Any mention of other machinery in this manual other than the 6812 Sugar Beet Harvester is for reference only. This manual does not replace nor is it to be used for any machinery that may be attached to or used in conjunction with the 6812 Sugar Beet Harvester.

PARTS & SERVICE

As the purchaser of your new harvester, it is very important to consider the following factors:

A. Original Quality

B. Availability of Service Parts

C. Availability of Adequate Service Facilities

Art's-Way Manufacturing Co., Inc. has an excellent dealership network ready to answer any questions you may have about your harvester. Parts for your machine may be ordered through our dealers. When placing a parts order, please have the **model** and **serial number** ready. This will allow the dealer to fill your order as quickly as possible.

For your convenience, we have provided this space for you to record your model number, serial number, and the date of purchase, as well as your dealer's name and address.

Owner's Name: _____

Owner's Address: _____

Purchase Date: _____

Dealership Name: _____

Dealership Address: _____

Dealership Phone No.: _____

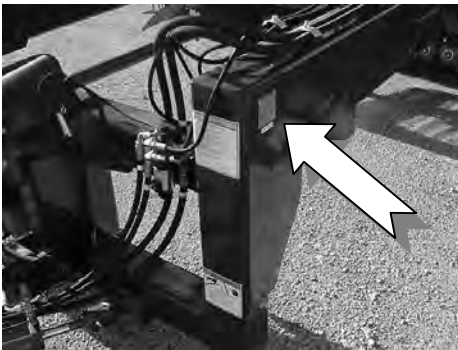


Figure 1 – Location of Serial and Model Placard on Harvester



Figure 2 – Location of Serial and Model Placard on Header

Machine Serial Number Location

The placard containing the serial and model number is located on the front left-hand side of the harvester frame and header.

Enter the serial number and model of your harvester and header within the space provided.

	
SERIAL NO.	
MODEL NO.	
<i>Manufactured By</i> Art's-Way Manufacturing Co., Inc. <i>Armstrong, IA</i>	

Figure 3 – Serial Model Number Placard

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LIMITED WARRANTY

Art's-Way Manufacturing Co., Inc. warrants the products it sells to be free from defects in material and workmanship for a period of one (1) year after the date of delivery to the first (original) purchaser, subject to the following conditions:

- Art's-Way Manufacturing Co., Inc. obligation and liability under this warranty is to repair or replace (at the company's option) any parts that upon manufacture were defective in material or workmanship.
- All parts and repairs under this warranty shall be supplied at Art's-Way Manufacturing Co., Inc. or an authorized Art's-Way Manufacturing Co., Inc. dealer, at the option of Art's-Way Manufacturing Co., Inc.
- Art's-Way Manufacturing Co., Inc. warranty does not extend to parts and elements not manufactured by Art's-Way Manufacturing Co., Inc. and which carry the warranty of other manufacturers.
- Transportation or shipping to an authorized dealer for necessary repairs is at the expense of the purchaser.
- 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. 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 expenses of delay and the Company's liability is limited to repair or replacement of defective parts as set forth herein.
- Any improper use and/or maintenance, including operation after discovery of defective or worn parts, operation beyond the rated capacity, substitution of parts not approved by Art's-Way Manufacturing Co., Inc., or any alternation or repair by other than an authorized Art's-Way Manufacturing Co., Inc. dealer which affects the product materially and adversely, shall void the warranty.
- 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.
- 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 the specific legal rights and you may have other rights that vary from state to state.

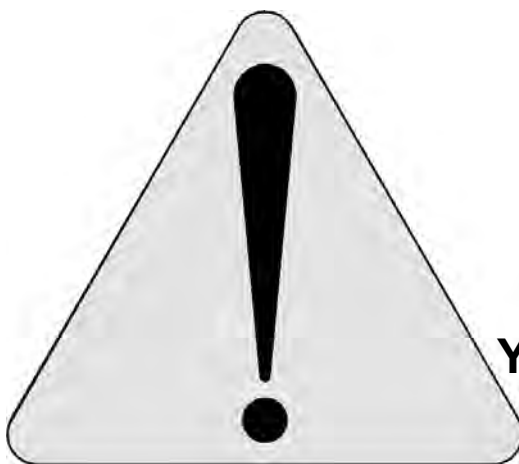
SAFETY FIRST

“A careful operator is the best insurance against an accident”

(National Safety Council)

Most accidents can be prevented if the operator:

- Fully understands how the machine functions
- Can anticipate situations which may produce problems
- Can make necessary corrections before problems develop



**THIS SYMBOL MEANS
ATTENTION!
BECOME ALERT!
YOUR SAFETY IS INVOLVED!**

Figure 4 - Universal Safety Alert Symbol

The American Society of Agricultural Engineers has adopted the Universal Safety Alert Symbol as a way to identify areas of potential danger if the equipment is not operated correctly. (See Figure 4.) Please be alert whenever you see this symbol in the manuals or on your harvester.

Art's-Way Manufacturing Co., Inc. strives to make our equipment as safe as possible. The Art's-Way 6812 Sugar Beet Harvester conforms to applicable safety standards at the time of manufacturing. A safety conscious equipment operator makes an effective accident-prevention program complete.

Safety features and instructions for the harvester are detailed Safety Guidelines section of this Operator's Manual. It is the responsibility of the owner to ensure that all operators read and understand the manual before they are allowed to operate the beet harvester. (Occupational Safety and Health Administration (OSHA) regulations 1928.57.)

NOTICES OF DANGER, WARNING, AND CAUTION

Signal Words: Note the use of signal words **DANGER**, **WARNING**, and **CAUTION** on the harvester and in this manual. The appropriate signal word for each has been selected using the following guidelines:



DANGER: IMMEDIATE AND SPECIFIC HAZARD WHICH *WILL* RESULT IN SEVERE PERSONAL INJURY OR DEATH IF PROPER PRECAUTIONS ARE NOT TAKEN.



WARNING: SPECIFIC HAZARD OR UNSAFE PRACTICE *COULD* RESULT IN SEVERE PERSONAL INJURY OR DEATH IF PROPER PRECAUTIONS ARE NOT TAKEN.



CAUTION: A REMINDER OF GOOD SAFETY PRACTICES. PERSONAL INJURY *COULD* RESULT IF PROPER PROCEDURES ARE NOT FOLLOWED.



SAFETY GUIDELINES



Remember:

“The Best Operator is a Safe Operator”



CAUTION: READ AND UNDERSTAND THE OPERATOR'S MANUAL AND ALL THE SAFETY DECALS BEFORE OPERATING THE HARVESTER. REVIEW ALL SAFETY INSTRUCTIONS WITH ALL OPERATORS ANNUALLY.

BEFORE OPERATING

- Do not wear loose fitting clothing as it may catch in moving parts.
- Make sure to install and/or secure all guards and shields, including the tractor power take-off (PTO) master shield, before starting or operating the harvester.
- Be sure that the correct implement driveline parts are used and that they are properly secured.
- Lower the lifter wheels when the harvester is not in use.
- Install the safety chain when attaching the harvester to the tractor.
- Clear the area of bystanders, especially children, when making repairs, adjustments or performing maintenance on the harvester.
- Do not allow riders.
- Put all tractor and machine controls in “neutral” and disengage the PTO before starting. Follow the starting instructions according to your tractor Manual.
- Operate the harvester only while seated on the tractor seat.
- Make sure the unit is adequately supported with safety blocks or safety stands when changing tires or performing maintenance.



CAUTION: KEEP WELL CLEAR OF MOVING PARTS. BE SURE TO SHUT OFF THE TRACTOR, SET THE PARKING BRAKE, PUT THE MACHINE IN NEUTRAL, AND REMOVE THE TRACTOR KEY WHILE MAKING ADJUSTMENTS. WAIT FOR ALL MOVEMENT TO STOP BEFORE APPROACHING THE MACHINE.

DURING OPERATION

- Keep hands, feet, hair, and clothing away from moving parts.
- Keep all shields and guards in place and in good working condition.

- Keep all bystanders, especially children, away from the harvester while in operation.
- Do not allow riders while the harvester is in operation.
- Do not attempt to unclog, clean, or adjust the harvester while it is running.
- Stay away from overhead power lines. Electrocutation can occur even without direct contact.
- Keep all hydraulic lines, fittings, and couplers tight and free of leaks. (Refer to Safety Guidelines – Hydraulic Safety.)
- Use caution when ascending or descending on the harvester. Wet shoes or boots are slippery.

MAINTENANCE SAFETY

- Follow all operating, maintenance and safety instructions found in this Manual.
- Before servicing, adjusting, repairing or unclogging the machine, always make sure the tractor engine is stopped, the machine is lowered to the ground, all controls are placed in neutral, the parking brake is set, and all the moving parts have stopped.
- Use sufficient tools, jacks, and hoists that have the capacity for the job.
- Use support blocks or safety stands when changing tires or performing maintenance.
- Follow good shop practices of keeping the service area clean and dry and use adequate light for the job at hand.
- Before applying pressure to the hydraulic system, make sure all lines, fittings and couplers are tightly secured and in good condition.
- Make sure all shields/guards are in place and properly secured when performing maintenance.

HYDRAULIC SAFETY

- Make sure components in the hydraulic system are kept clean and in good working condition.
- Relieve pressure from the hydraulic system before servicing or disconnecting from the tractor.
- Keep all hydraulic lines, fittings, and couplers tightly secured and free of leaks.
- Replace any worn, cut, abraded, flattened or crimped hoses.
- Do not make any temporary repairs to the hydraulic lines, fittings or hoses using tape, clamps, or cement. The hydraulic system operates under extremely high pressure and temporary repairs may fail suddenly and create a hazardous/dangerous situation.

- Wear proper hand and eye protection when searching for a high-pressure hydraulic leak. Use a piece of wood or cardboard as a backstop instead of hands to identify and isolate a leak. If injured by a concentrated high-pressure stream of hydraulic fluid, seek medical attention immediately. Serious infection or toxic reaction can develop if hydraulic fluid penetrates the surface of the skin.
- Before applying pressure to the system, make sure all components are tight and that the hydraulic lines, hoses and couplings are not damaged.

TRANSPORTATION SAFETY

- Make sure the harvester complies with all local regulations regarding transporting equipment on public roads and highways.
- Make sure the Slow Moving Vehicle (SMV) emblem and all lights and reflectors required by local highway and transportation authorities are properly in place, clean and clearly visible to traffic.
- Do not allow riders on any machinery during transport.
- Make sure the harvester is securely attached to the tractor and install a safety chain to the harvester.
- Make sure the tractor brake pedals are latched together.
- Do not exceed 20 mph (32 km/h) when transporting the harvester. Always reduce speed on rough roads and surfaces, or when going down inclines.
- Use caution when turning and always use the turn signals on the tractor to indicate your turning intentions to the other traffic.
- The weight of the trailed machine should NEVER exceed the weight of the towing vehicle.
- Check all clearances carefully whenever the machine is towed.
- Lower the elevator into the transport position before transporting the harvester on the highway.
- Stay away from overhead obstructions and power lines during transport. Electrocutation can occur even without direct contact.

STORAGE SAFETY

- Store the harvester in an area away from human activity.

- Do not permit children to play on or around the stored machine at any time.
- Make sure that the harvester is stored in an area with a firm and level base to prevent the machine from tipping or sinking into the ground.
- Block the wheels to prevent the machine from rolling.

TIRE SAFETY

- Have only a qualified tire dealer or tire repair service perform tire repairs.
- Do not attempt to install a tire on a wheel or rim unless you have the proper equipment and experience to do the job.
- Follow proper procedures when installing a tire on a wheel or rim to prevent an explosion that could result in serious injury.
- Do not substitute tires with a lesser road rating and/or capacity for the original equipment tires.



CAUTION: FAILURE TO FOLLOW PROPER PROCEDURES WHEN INSTALLING A TIRE ON A WHEEL OR RIM CAN PRODUCE AN EXPLOSION THAT MAY RESULT IN SERIOUS INJURY OR DEATH. DO NOT ATTEMPT TO INSTALL A TIRE UNLESS YOU HAVE THE PROPER EQUIPMENT AND EXPERIENCE TO PERFORM THE JOB. REPLACEMENT, REPAIR, AND/OR MAINTENANCE SHOULD BE DONE BY A QUALIFIED TIRE DEALER OR QUALIFIED REPAIR SERVICE.

ASSEMBLY SAFETY

- Use adequate manpower to perform assembly procedures safely.
- Assemble the harvester in an area with sufficient space to maneuver the largest components and allow easy access to all sides of the machine.
- Use only forklifts, lift cranes, jacks and tools with sufficient capacity for the loads.
- Do not allow spectators, especially children, in the working area.

Remember:

"The Best Operator is a Safe Operator"

ILLUSTRATED PARTS CATALOG

- The figure item corresponds to the number shown in the illustration. Figure items having a dash “-” next to the number indicates that the figure item is not displayed on the corresponding illustration.
- Numbers listed in the part number column are the numbers under which the parts are manufactured and by which the parts are identified by the manufacturer.
- Requirement shown in the Units Per Assy column is per Harvester or assembly. Items that have no specified quantity are designated by the letters “AR” (as required). “RF” listed in the Units Per Assy column indicates that the item is listed as a reference and the requirement is listed in another figure of the IPC.

The relationship of component parts of an installation or assembly may be determined by the degree of indenture in the nomenclature column. The next higher assembly can be found by referring to the first indentation above and to the left. The following example shows the format of this indented system:

1	2	3	4
*	*	*	*
DETAIL PART OR ASSEMBLY			
*	DETAIL PART BREAKDOWN OR ASSEMBLY BREAKDOWN		
*	*	ADDITIONAL BREAKDOWN OF DETAIL PART OR ASSEMBLY	
*	*	*	ADDITIONAL BREAKDOWN OF DETAIL PART OR ASSEMBLY

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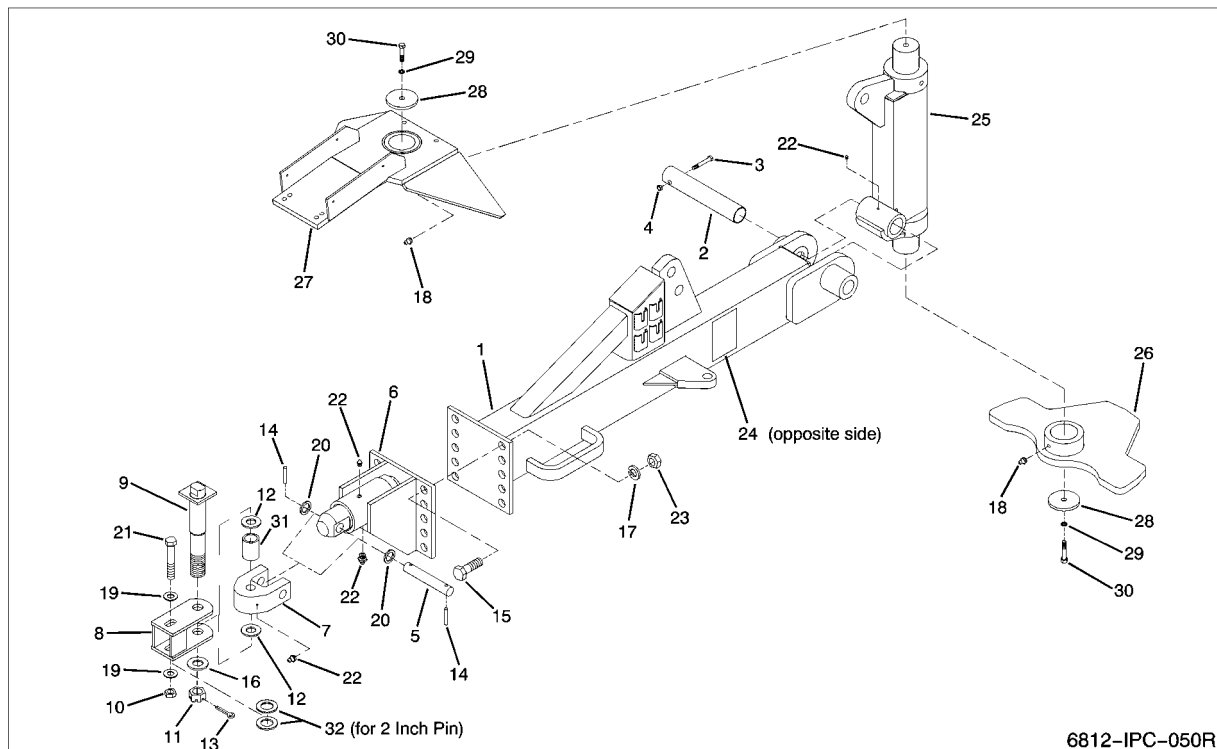
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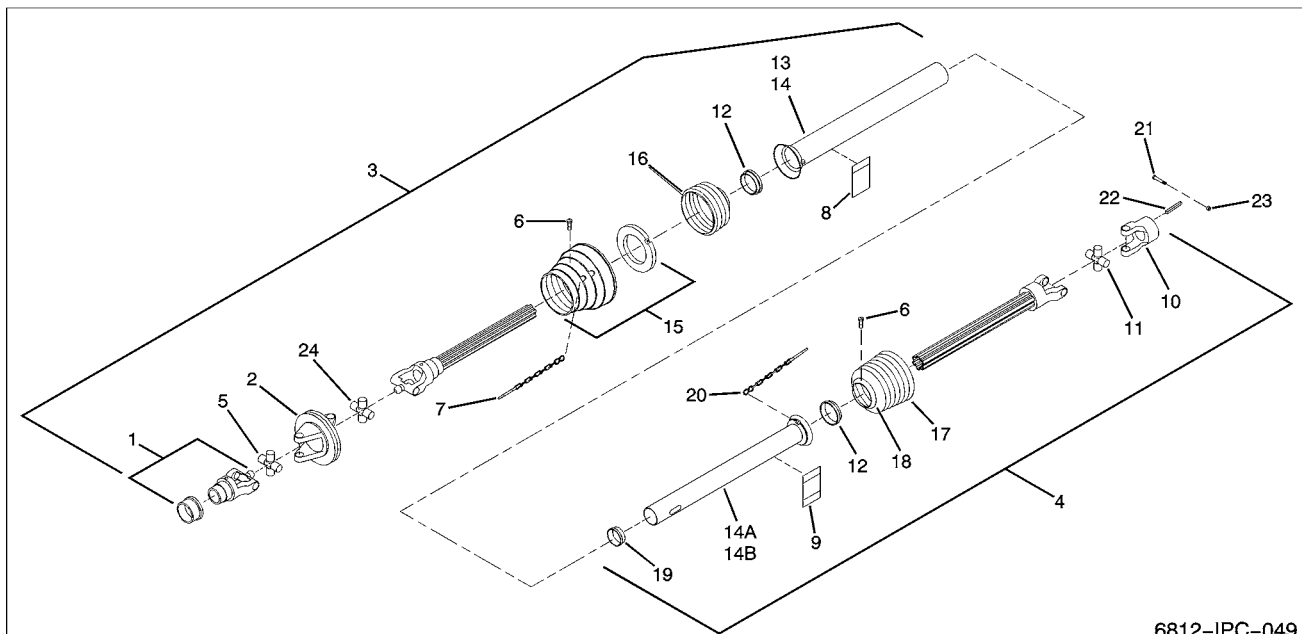
SECTION 1: HARVESTER

TONGUE ASSEMBLY



6812-IPC-050R1

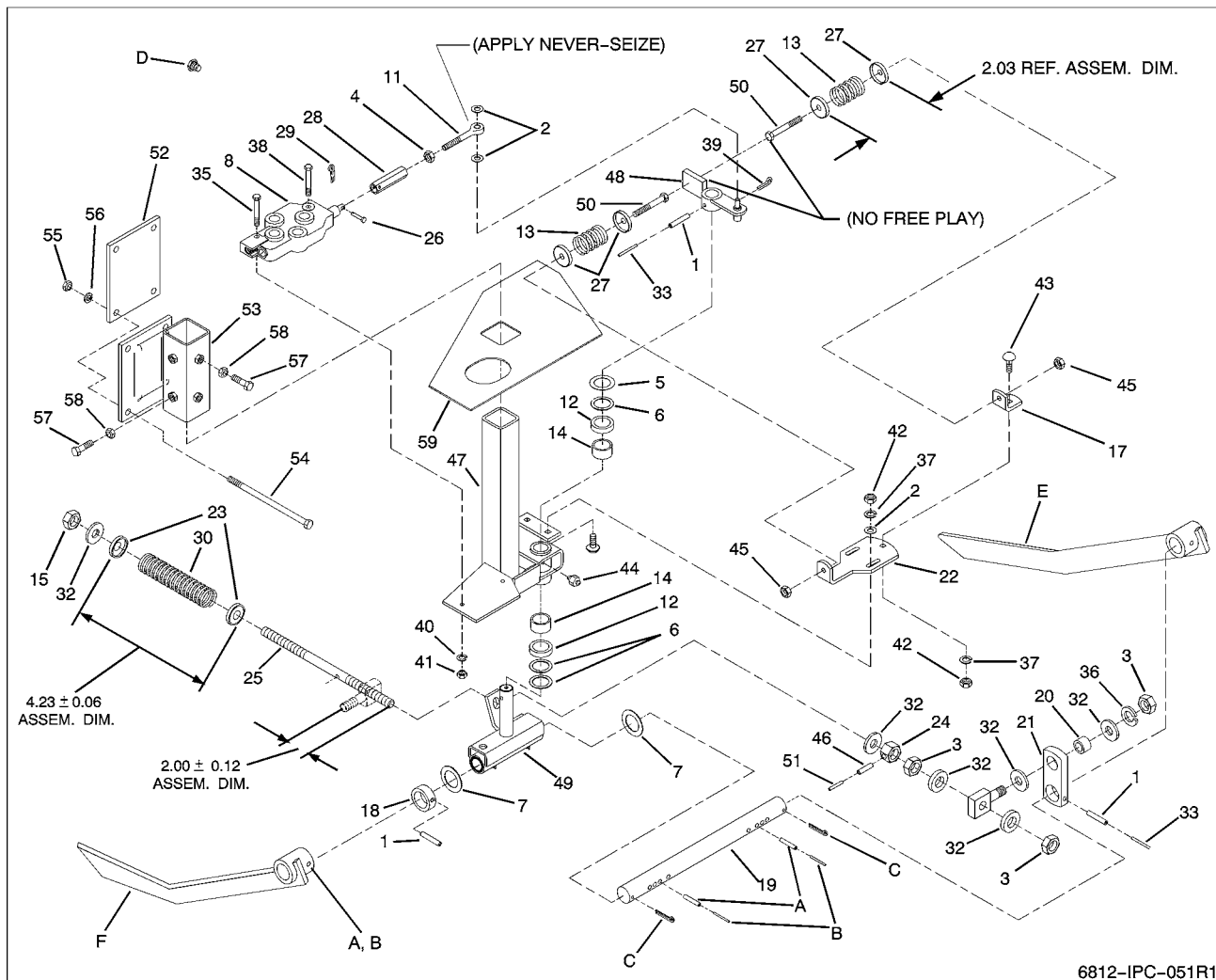
FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	518010		Tongue Assembly, 6812, (527000)	1
2	517930		Hitch Wldt, Tongue 6812	1
3	E672417		Pivot 2 OD x 11.5 L	1
4	127890		Bolt, HHCS 1/2-13 x 4 GR8	1
5	252820		Nut, Lock 1/2-13 Hex	1
6	290120		Pin, Hitch	1
7	531180		Hitch Wldt, Front	1
8	425500		Clevis, Hitch 1.5 inch Bolt	1
9	439070		Clevis, Wldt, Drawbar	1
10	991040		Pin Wldt, Hitch 1-3/8	1
11	991040		Nut, Lock 3/4-10 Hex	1
12	E552072		Nut, 1-3/8-6 Slot Hex GR8	1
13	425550		Washer, Hardened 1.56	2
14	V063768		Pin, 1/4 x 3 Cotter	1
15	E580053		Pin, 5/16 x 1-3/4 Roll	2
16	E672103		Bolt, 1-8 x 2-1/2 Hex	6
17	V063596		Washer, 1-5/8 x 3 x 0.165	4
18	003350		Washer, 1 inch Lock	6
19	035170		Zerk, 1/8-27 65°	2
20	020720		Washer, 0.812 x 1.72 x 0.179	2
21	020650		Washer, 1.14 ID x 1.63 OD	2
22	991050		Bolt, 3/4- 10 x 8.5 HHCS	1
23	115590		Zerk, 1/4-28 Taper	4
24	J14H805		Nut, 1-8 Hex	6
25	268860		Decal, Danger Rotating Driveline	1
26	519860		Wldt, Hitch Pivot	1
27	518480		Wldt, Plate Lower Pivot	1
28	519600		Wldt, Plate Upper Pivot	1
29	517670		Washer, Pivot	2
30	020440		Washer, Lock 5/8	2
31	990600		Bolt, HHCS 5/8-11 X 1-1/4	2
32	531590		Tube, Hitch Spacer	1
32	531190		Washer, 2 Inches	2

POWER TAKE OFF (PTO) DRIVE

6812-IPC-049

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	498750		Complete PTO Assembly, 1-3/8-21 Tractor Spline	1
	498760		Complete PTO Assembly, 1-3/4-20 Tractor Spline	1
	345830		Yoke, 1-3/8-21 Spline	1
1	340210		* Collar Kit, 1-3/8-21 (Included with Fig Item 1)	1
	345840		Yoke 1-3/4-20 Spline	1
	340200		* Collar Kit, 1-3/4-20 (Included with Fig Item 1)	1
2	345850		Double Yoke	1
3	498800		Tractor Half, PTO 1-3/8-21 Yoke	1
3	472160		Tractor Half, PTO 1-3/4-20 Yoke	1
4	357850		Implement Half, PTO 1-3/8-21	1
4	287450		Implement Half, PTO 1-3/4-20	1
5	345870		Kit, Cross and Bearing CV	2
6	345980		Screw, Shield (In Fig Items 15, 16, and 17)	8
7	354190		Chain, Safety 600mm	1
8	268860		Decal, Danger Rotating Driveline (On Fig Item 13)	1
9	340180		Decal, Danger Shield Missing (On Fig Item 14)	1
10	345910		Yoke, 1-3/4 RB 3/8 Keyway	1
11	182230		Kit, Cross and Bearing	1
12	182900		Bearing, Ring SC 25	2
13	357880		Tube, Outer Shield Oval 1-3/8	1
13	287490		Tube, Outer Shield Oval 1-3/4	1
14	357890		Tube, Inner Shield Round 1-3/8	1
14	287500		Tube, Inner Shield Round 1-3/4	1
15	345950		Assembly, CV Cone and Bearing	1
16	345960		Shield, Cone 3 Rib	1
17	340140		Shield, Cone 7 Rib	1
18	349250		Collar, Reinforced (359474)	1
19	340190		Bearing, Support	1
20	182890		Chain, Safety	1
21	990870		Bolt, HHCS 3/8-16 x 2 inch	1
22	021530		Key, Square 3/8 x 2	1
23	E552044		Nut, Lock 3/8-16 Hex Top Grade A	1
24	498820		Cross and Bearing Kit	1

ROW FINDER ASSEMBLY



6812-IPC-051R1

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	E580053		Rowfinder, 6812, (521970)	
2	I120394		Pin, 5/16 x 1-3/4 Roll	3
3	I124589		Washer, 0.406 x 0.812 x 0.051	4
4	I124829		Nut, 5/8-11 Hex G5	3
5	I22266R1		Nut, 3/8-16 Hex Jam G5	1
6	I22266R1		Washer, 1.15 x 1.75 x 0.027 Flat	3
7	I23041R1		Washer, 1.15 x 1.50 x 16 Ga. Flat	3
8	I608700R1		Washer, 1.28 x 2.0 x 0.054 Flat	2
11	343250		Valve Assembly, Open Center	1
12	413450		Eyebolt	1
13	JAT30144		Seal, 1.1 x 1.5 x 0.37	2
14	JCJ21FN		Spring, Comp. 0.99 x 1.38 x 2.0	2
15	JJD8813		Bearing, 1.12 x 0.75	2
16	JK40015		Nut, Hex 5/8-11 Top-Lock G8	1
	JN145970		Eyebolt	1

ROW FINDER ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
17	JN145971	Bracket, Angle	1
18	JN145972	Bushing	1
19	JN145977	Shaft, Cross	1
20	JN145980	Spacer	1
21	JN145981	Bracket, Spring	1
22	JN145982	Bracket, Adjustment	1
23	JN147036	Washer, Cupped	2
24	JN147174	Stop, Spring Compression	1
25	JN147175	Stud, Adjusting	1
26	JN73390	Pin, Valve	1
27	JN73401	Washer, Cupped	4
28	521750	Clevis, Valve	1
29	J11H230	Pin, Cotter 1/16 x 3/8	1
30	J23096	Spring, Comp. 1.0 x 1.41 x 6.0	1
32	J24H1373	Washer, 0.626 x 1.56 x 0.18 Flat	6
33	J34H288	Pin, 3/16 x 1-3/4 Roll	2
35	009800	Bolt, 5/16-18 x 2-1/2 HHCS G5	1
36	020440	Washer, 5/8 Lock	1
37	021180	Washer, 3/8 Lock	3
38	022910	Bolt, 5/16-18 x 2-1/4 HHCS G5	1
39	023090	Pin, 3/32 x 3/4 Cotter	1
40	023620	Washer, 5/16 Lock	2
41	023630	Nut, 5/16-18 Hex G5	2
42	027260	Nut, 3/8-16 Hex G5	3
43	035180	Bolt, 3/8-16 x 1-1/4 SSN CRG	3
44	049180	Zerk, 1/4-28 Lube Taper THD	1
45	073630	Nut, 3/8-16 Hex Nyl-Lock	2
46	1030808	Pin, 5/16 x 1-1/4 Roll	1
47	520600	Bracket Wldt, Frame	1
48	521740	Arm Wldt, Centering	1
49	521950	Shaft, T-Assembly, LH Spring	1
50	990820	Bolt, 3/8-16 x 3 HHCS G5	2
51	991100	Pin, 3/16 x 1-1/4 Expansion	1
52	520520	Plate, RF Mounting	1
53	533070	Mount Wldt, Rowfinder	1
54	E672288	Bolt, HHCS 1/2-13 x 7-1/2	4
55	005360	Nut, Hex 1/2-13 GR5 ZN	4
56	005370	Washer, Lock 1/2 ZN	4
57	990610	Bolt, HHCS 5/8-11 x 1-1/2	4
58	1121555	Nut, Jam 5/8-11 Hex ZN GR5	4
59	533080	Cover, Rowfinder	1
A	E580053	Pin, 5/16 x 1-3/4 Roll	2
B	J34H288	Pin, 3/16 x 3/4 Roll	2
C	003950	Pin, 3/16 x 2 Cotter	2
D	JAN140006	Plug, Closed Center	1
E	JAN142149	Sensor, Assembly LH	1
F	JAN142148	Sensor, Assembly RH	1

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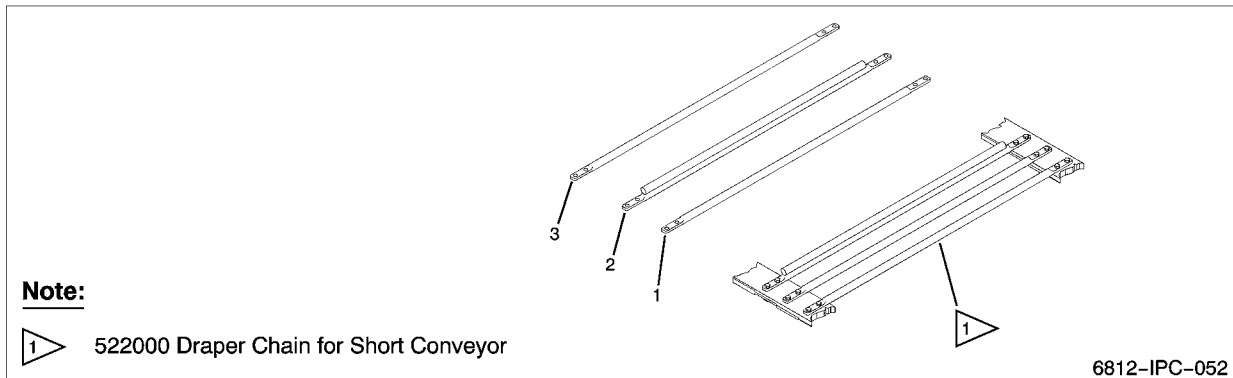
DRAPER CHAIN SERVICE PARTS

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	531020		Rod, 5/8 x 48, STR STD	-
2	531040		Rod, 5/8 x 48, Welded Flight	-
3	533970		Rod, 5/8 x 48, STR 0.31 Hole	-
-4	268670		Common Parts for General Repair – All Draper Chains Plate Backing	-
-5	463180		Screw, SF HCS, 12-28 x 1-1/4	-
-6	463190		Nut, Lock 12-28	-
-7	343300		Belt Splice Kit	-
-8	533950		Backer Plate for 5/16	-
-9	533940		Bolt, 5/16-20 x CTR SK Hex Socket	-
-10	181570		Nut, 5/16 Lk	-

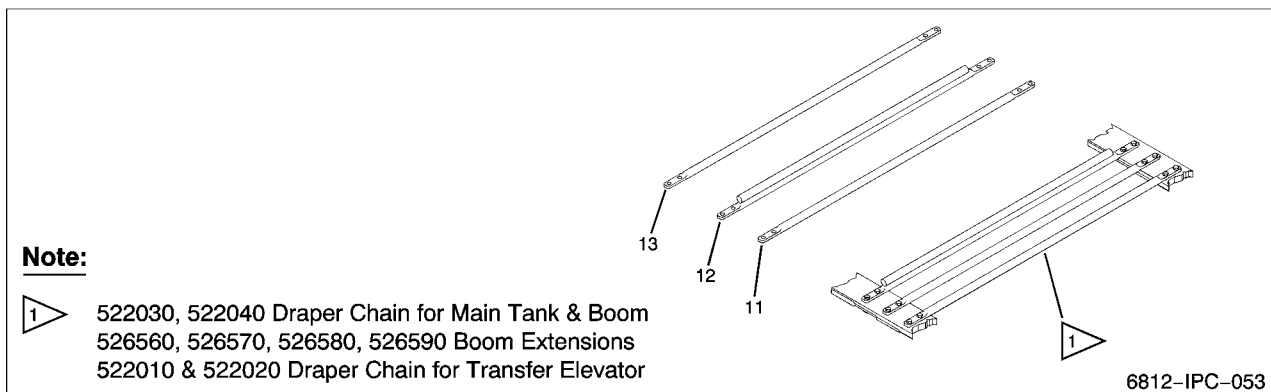
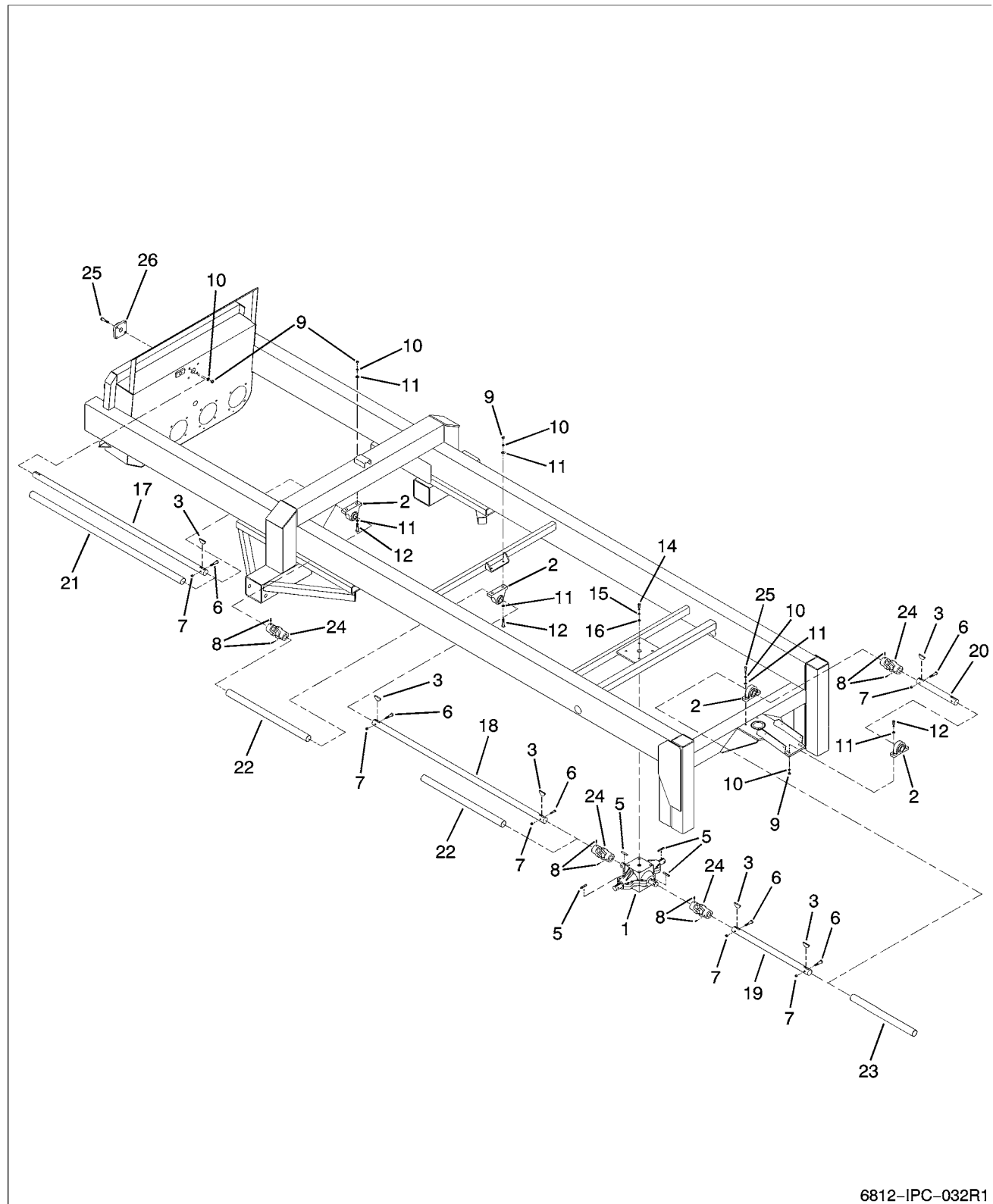
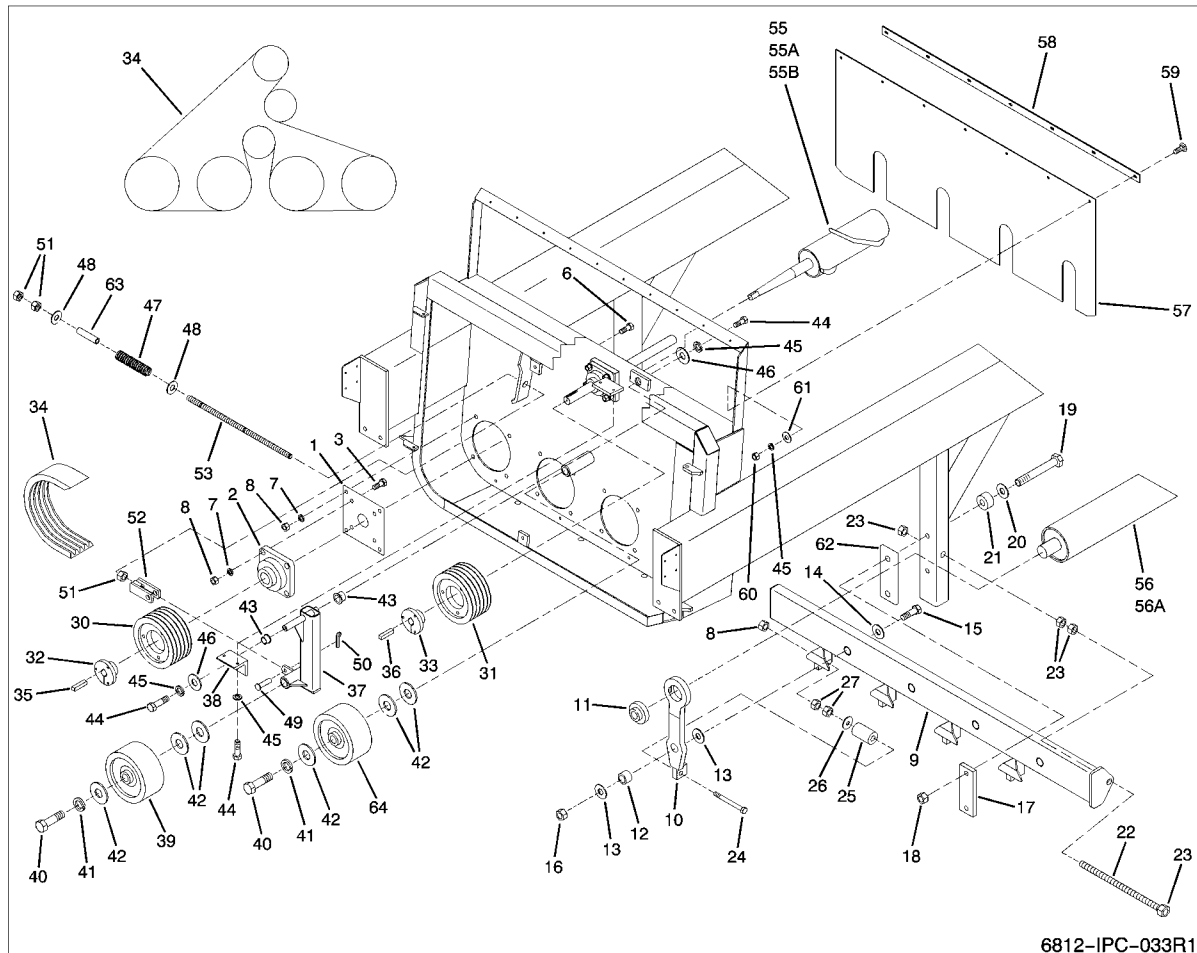


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
11	530990		Rod, 1/2 x 42, STR STD	-
12	531010		Rod, 1/2 x 42, Welded Flight	-
13	531000		Rod, 1/2 x 42, STR 1/4-20 Threaded, 2004	-
-	533960		Rod, 1/2 x 42 STR 5/16 Hole, 2005	-
-	533950		Backer Plate For 5/16	-
-	533940		Bolt 5/16 CTR SK Hex Socket	-
-	181570		Nut, 5/16	-



DRIVE SHAFT ASSEMBLIES

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	520400	Drive Shaft Assemblies, 6812, (523000-30)	1
2	522940	Gearbox, 4 Shaft	4
3	231950	Bearing, P Blk, 1.75 Wide, ECC Triple	6
5	006670	Key, Woodruff 3/8 x 2-3/4	4
6	I189304	Key, Square 3/8 x 1-1/2	6
7	E552044	Bolt, HHCS 3/8-16 x 3-1/4	6
8	120970	Nut, Lock 3/8-16	8
9	005360	Screw, HSSS 3/8-16 x 1/2	12
10	005370	Nut, Hex 1/2-13	12
11	I20601R1	Washer, Lock 1/2	12
12	007080	Washer, Flat 0.53 x 1.25 x 0.11	6
14	025100	Bolt, HHCS 1/2-13 x 2-1/2	4
15	020440	Bolt, HHCS 5/8-11 x 1-3/4	4
16	020430	Washer, Lock 5/8	4
17	526000	Washer, Flat 5/8	1
18	526010	Shaft, Rear Drive 1.75 x 90.75	1
19	526020	Shaft, Mid Drive 1.75 x 121.81	1
20	526030	Shaft, Front Drive 1.75 x 39.41	1
21	526040	Shaft, PTO Jack 1.75 x 15.25	1
22	526050	Shield, Rear Spin 2.4 x 76.0	2
23	525970	Shield, Middle Spin 2.4 x 58.5	1
24	286520	Shield, Inner Spin 2.4 x 29.5	4
25	031580	U-Joint, 1.75 RB x 1.75 RB	6
26	522960	Bolt, HHCS 1/2-13 x 2-3/4	1
		Bearing, 4 Hole Flange, 1.75 Wide EEC Triple	

CONVEYOR ROLLER DRIVES - REAR

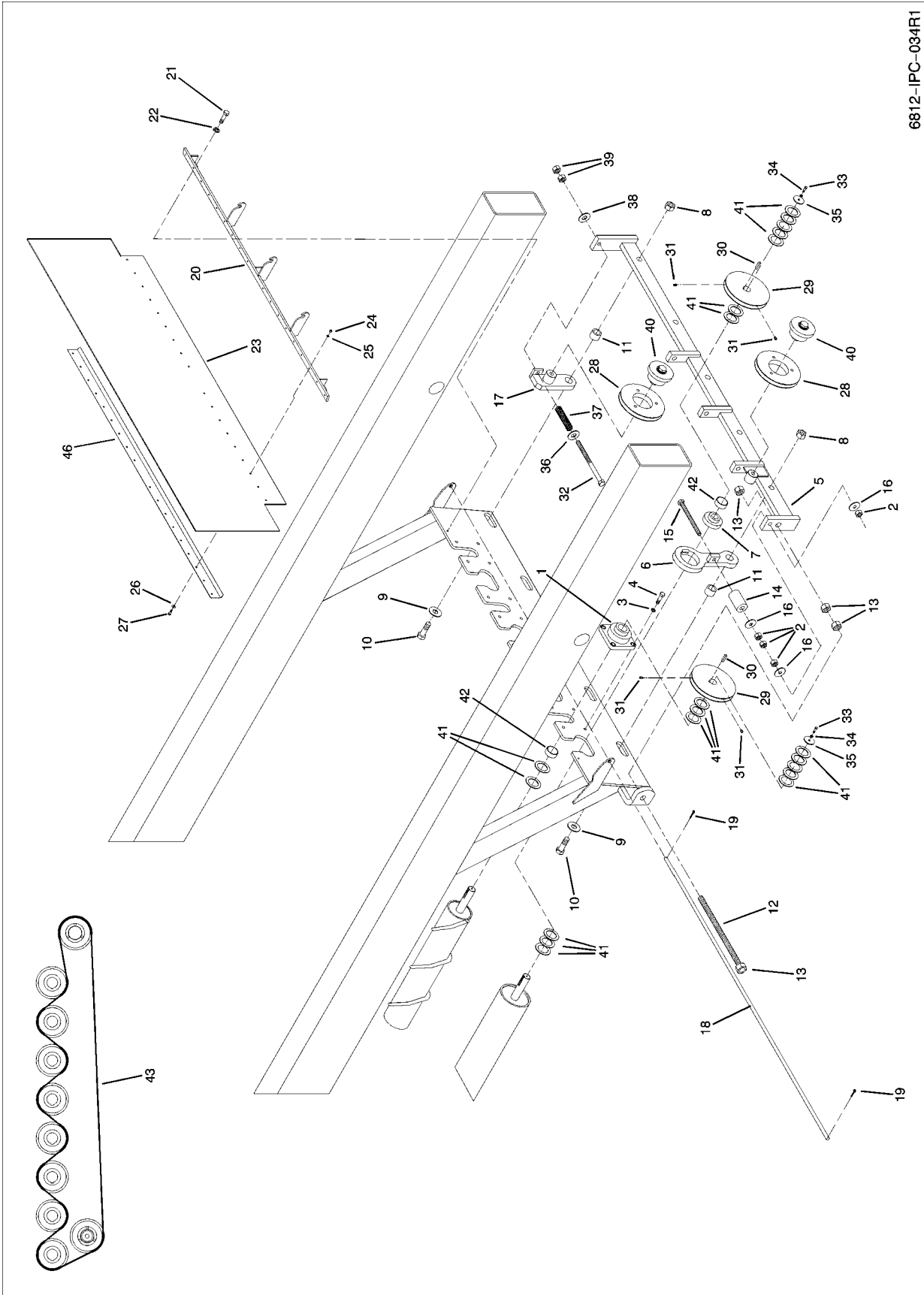
6812-IPC-033R1

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	521990		Conveyor Roller Drives - Rear (523000-50)	4
2	522970		Plate, Rear Grabroll Bearing	4
3	990620		Bearing, FLF 4H	16
6	990610		Bolt, HHCS 5/8-11 x 1-1/2	16
7	020440		Washer, Lock 5/8	52
8	I124589		Nut, Hex 5/8-11	52
9	518500		Rear Tube Wldt	1
10	525560		Arm Wldt, Sm Discharge	4
11	522920		Bearing, Ball 1-3/4	4
12	264730		Bushing, Grabroll Drive	4
13	264740		Washer, Hardened	8
14	990720		Washer, Flat Std	4
15	TG0679		Bolt, HHCS 1-8 x 4-1/2	4
16	990510		Nut, Lock 1-8 Hex	4
17	518490		Bar, Clamp, Rear Grabroll Adj	2
18	JK40016		Nut, Lock 3/4-10	4
19	1111952		Bolt, HHCS 3/4-10 x 8	4
20	J24H1401		Washer, Flat	4

CONVEYOR ROLLER DRIVES - REAR

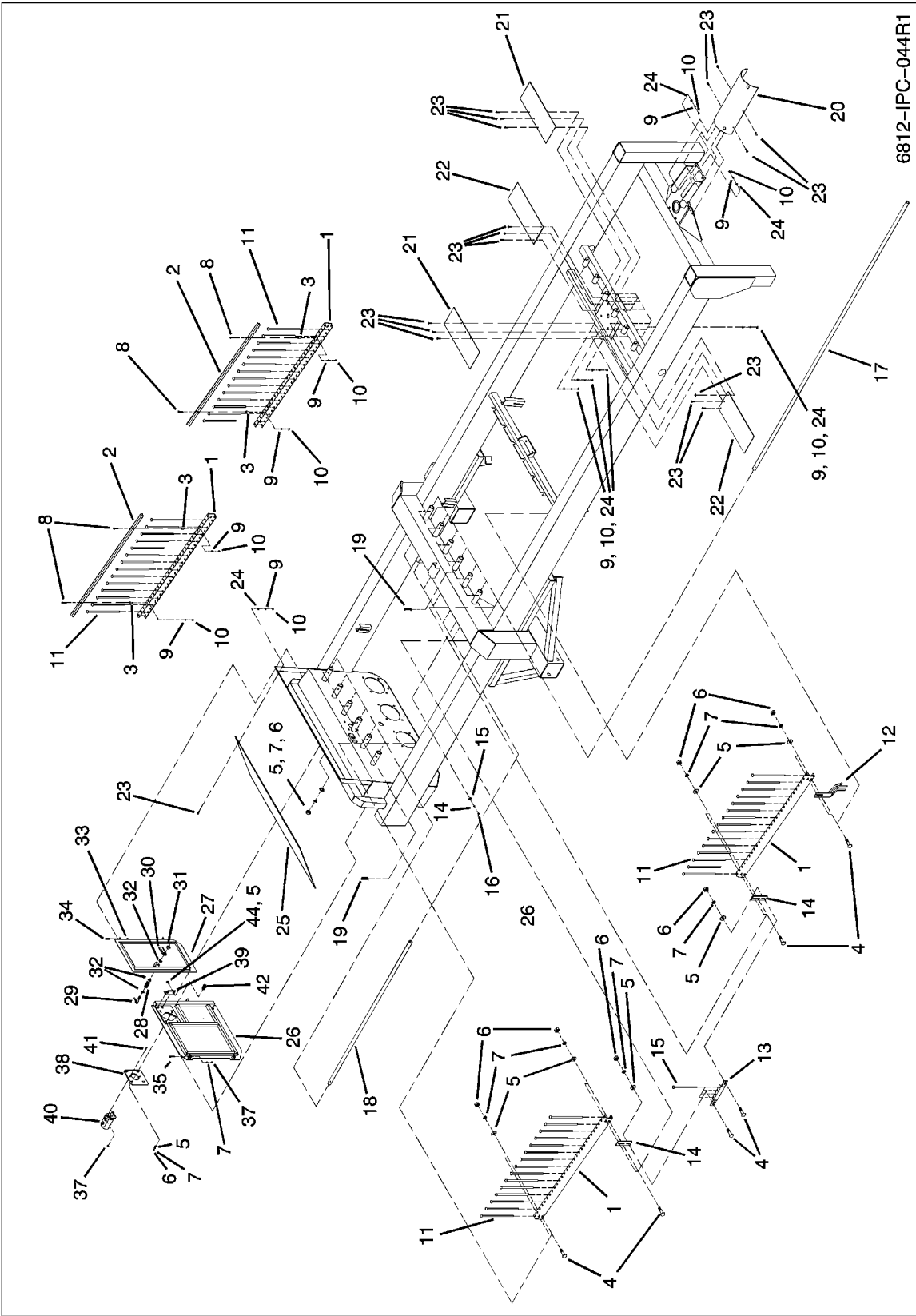
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
21	248290	Pad, Flex 1.75 x 0.75 x 1.00	4
22	518420	Rod, Threaded 1-8 UNC x 14.5	1
23	J14H0805	Nut, Hex 1-8	4
24	264760	Bolt, HHCS 5/8-11 x 8-1/2	4
25	248300	Pad, Flex, 1.75 x 0.75 x 3.0 GrN	4
26	340310	Washer, Flat 21/32 x 2.0 x 0.25	4
27	344630	Nut, Jam 5/8-11 Hex	8
30	522140	Sheave, 5 GRV, 10.9 OD, E BSH	4
31	522150	Sheave, 5 GRV, 7.1 OD, SF BSH	1
32	251230	BSHG, 2.0 Inch Bore x 1/2 Keyway	4
33	234760	BSHG, 1-3/4 x 3/8	1
34	522210	Belt, Banded 5-5V1800	1
35	R66305	Key, Square 1/2 x 2.0	4
36	021530	Key, Square 3/8 x 2	1
37	522330	Arm Wldt, Rear Tensioner	1
38	518060	Angle, Tensioner Arm Mtg	1
39	518600	Sheave Assy, Idler	1
	518610	* Sheave Wldt, Flat 6.62 OD	1
	523010	* Bearing, Insert 1-1/4 COD	1
	E642027	* Ring, Snap	1
40	522610	Bolt, HHCS 1-1/4-7 x 3-1/2	2
41	E829047	Washer, Lock 1-1/4	2
42	E829022	Washer, Flat 1-1/4	6
43	522600	Bushing, Oilite 1 x 1-1/4 x 3/4	2
44	012260	Bolt, HHCS 3/8-16 x 1.0	4
45	021180	Washer, Lock 3/8	11
46	169280	Washer, Flat 0.41 x 1.5 x 0.125	2
47	231000	Spring, Comp. 1.62 x 7.25	1
48	I486801R1	Washer, Flat 0.53 x 2.0 x 0.25	1
49	1071212	Pin, Clevis 1/2 x 1-1/2	1
50	124350	Pin, Cotter 1/8 x 1-1/2	1
51	005360	Nut, Hex 1/2-13	3
52	513841	Yoke Wldt, Threaded 1/2-13	1
53	486990	Rod, Threaded 1/2-13 x 25.5	1
55	521570	Grabroll, Spiral, STD, Steel	4
55A	521580	Grabroll, DBL, Spiral, Steel	4
55B	521590	Grabroll, Spiral, Poly	4
56	521550	Grabroll, Smooth Steel	4
56A	521560	Grabroll, Smooth Poly	4
57	523900	Rubber Flap	1
58	523890	Strap	1
59	035180	Bolt, CRG 3/8-16 x 1-1/4	7
60	027260	Nut, Hex 3/8-16	7
61	021190	Washer, Flat 3/8 STD	7
62	530900	Strap, 0.25 x 3 x 8.81	2
63	239040	Spacer, Spring Length	1
64	534380	Sheave Assy, Idler, 2 Brg	1
	534390	* Sheave Wldt, Flat 6.62 OD, 2 Brg	1
	523010	* Bearing, Insert 1-1/4 COD	2
	E642027	* Ring, Snap	1

CONVEYOR ROLLER DRIVES - FRONT



CONVEYOR ROLLER DRIVES - FRONT

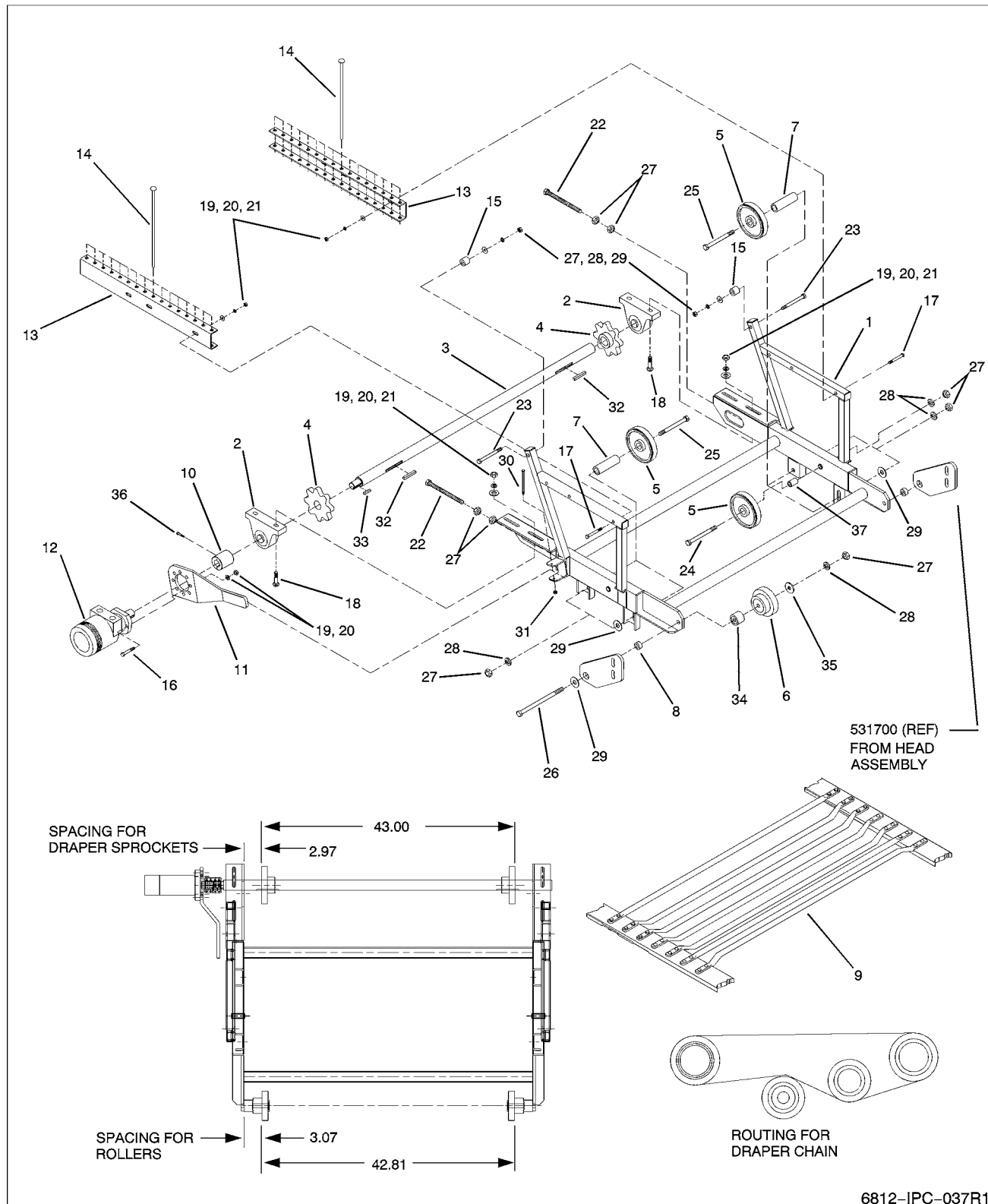
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
		Conveyor Roller Drives – Front, 6812, (523000-70)	
1	522970	Bearing, Flange 4-Hole	4
2	I124589	Nut, Hex 5/8-11	16
3	020440	Washer, Lock 5/8	16
4	990610	Bolt, HHCS 5/8-11 x 1-1/2	16
5	519150	Bar Wldt, Grabroll Adj	1
6	519280	Arm Wldt, Inlet End	4
7	522930	Bearing, Ball, 2, Wide Sod	4
8	990510	Nut, Lock 1-8 Hex	5
9	990720	Washer, Flat 1 Std	5
10	519720	Bolt, HHCS 1-8 x 4	5
11	519020	Bushing, 1.58 Grabroller Arm Adj	5
12	519730	Rod, Threaded 1-8 x 10	1
13	J14H805	Nut, Hex 1-8	4
14	264800	Pad, Flex 1.75 OD x 0.75 ID x 3.0	4
15	J08H4753	T Bolt, HHCS 5/8-11 x 10-1/2	4
16	340310	Washer, Flat 0.66 x 2.0 x 0.25	4
17	519180	Wldt, Shaft Mount	1
18	525490	Rod, Rubber Deflect, Supt	1
19	035850	Pin, Cotter 0.16 x 1.25	2
20	531660	Mount Wldt, Rubber Deflct	1
21	022420	Bolt, HHCS 3/8-16 x 3/4	3
22	021180	Washer, Lock 3/8	3
23	525460	Deflector, Rubber, Front	1
24	027660	Nut, Hex 1/4-20	18
25	029440	Washer, Lock 1/4	18
26	023260	Washer, Flat 1/4	18
27	042960	Bolt, HHCS 1/4-20 x 1.0	18
28	522250	Sheave, 1C, 6.4 OD	2
29	522240	Sheave, 1C, 6.0 OD, 2.0 Bore	8
30	525280	Key, Square 0.5 x 1.25	8
31	120970	Screw, HSSS 3/8-16 x 1/2	16
32	231070	Rod Wldt, Take-Up 15 Inches	1
33	031080	Bolt, HHCS 1/2-13 x 1.0	8
34	005370	Washer, Lock 1/2	8
35	509820	Washer, Flat, 2.38 OD x 0.56 ID	8
36	I486801R1	Washer, Flat 0.53 x 2.0 x 0.25	1
37	231000	Spring, Comp 1.62 x 7.25	1
38	005200	Washer, Flat 1/2	1
39	005360	Nut, Hex 1/2-13	2
40	522260	Bushing, w/ Bearing	2
41	396120	Bushing, Mach 2.03 x 3.0 x 0.14	80
42	527210	Spacer, 2.25 x 2.03 x 0.88	8
43	522270	Belt, Double CC158	1
46	532580	Angle, Rubber Hold Down	1



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DEFLECTORS

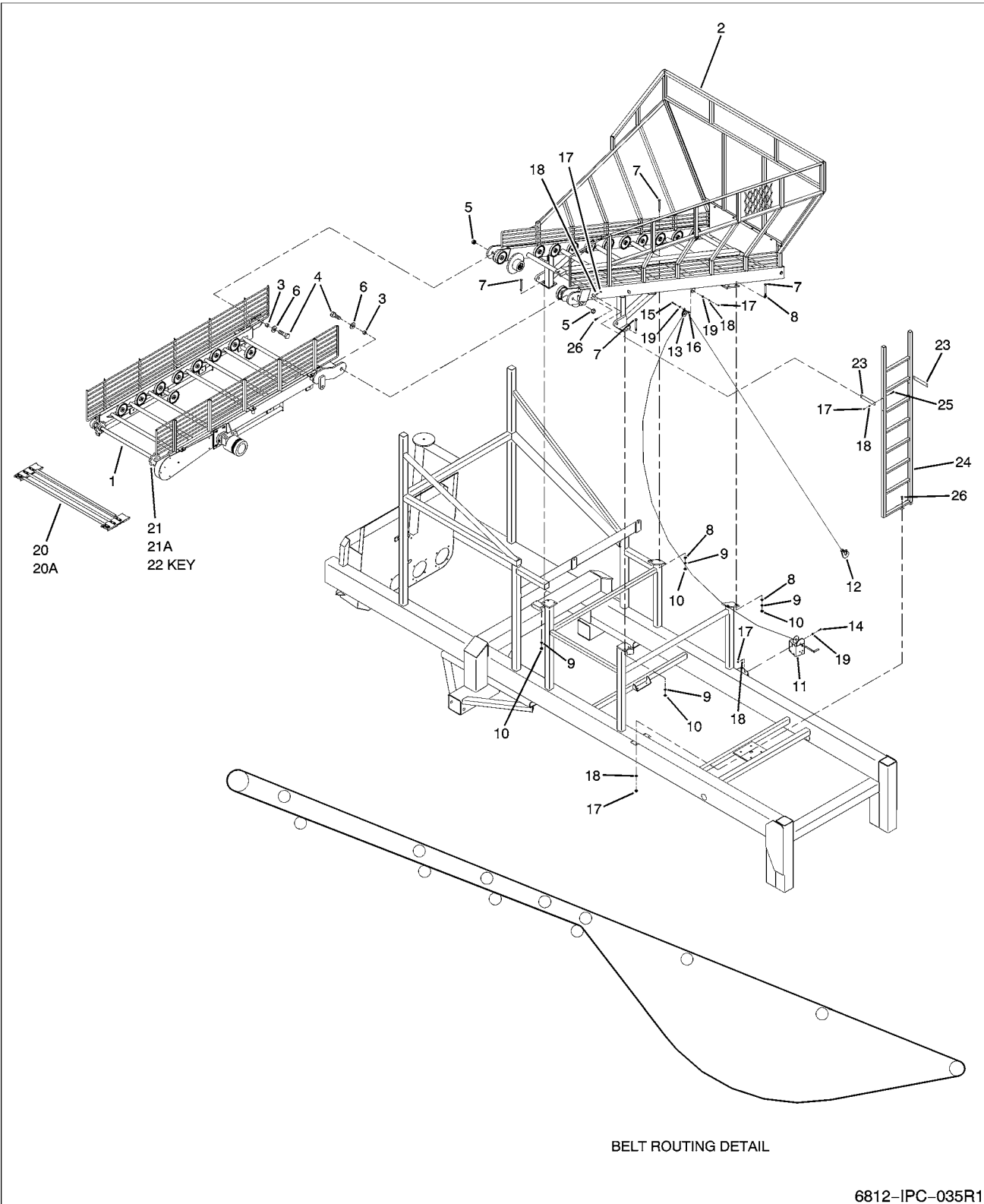
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
		Deflectors, 6812, (523000-150)	
1	525550	Channel, Grate 57.25 Long	4
2	525580	Angle, Cap	2
3	525590	Spacer, 0.5 OD x 0.31 ID x 1	4
4	025390	Bolt, CRG 1/2-13 x 1-3/4	20
5	005200	Washer, Flat 1/2 Standard	42
6	005360	Nut, Hex 1/2-13	42
7	005370	Washer, Lock 1/2 ZN	42
8	223540	Bolt, HHCS 1/4-20 x 1-3/4	4
9	029440	Washer, Lock 1/4 ZN	30
10	027660	Nut, Hex 1/4-20	30
11	347540	Rod, Grate 1/2 x 14.75	116
12	532130	Grate Wldt, Grabroll Front	2
13	532100	Grate Wldt, Axle	2
14	532090	Strap, Grate Mtg	4
15	532050	Rod, Grate Mtg	8
17	526690	Pipe, Grate Front	6
18	526700	Pipe, Grate Rear	6
19	R18660	Pin, Snapper	12
20	526710	Deflector, Jack Shaft	1
21	526720	Deflector, Gearbox	2
22	526730	Deflector, Head Drive	2
23	042960	Bolt, HHCS 1/4-20 x 1	26
24	023260	Washer, Flat 1/4 Standard	26
25	523710	Guard, Rear Drive	1
26	531730	Door, Wldt, RH Hyd. Pump MT	1
27	522340	Door, Wldt, LH Rear	1
28	518900	Spring, Comp. 0.94 x 14 GA x 2	1
29	518840	Handle Wldt, Door Latch	1
30	518850	Latch Wldt, Door	1
31	V062140	Nut, Jam 5/8-11	1
32	020430	Washer, Flat 5/8 STD	3
33	E552044	Nut, Lock 3/8-16	4
34	012260	Bolt, HHCS 3/8-16 X 1	4
35	990850	Bolt, HHCS 5/8-11 X 2-3/4	2
37	038850	Nut, Lock 5/8-11	2
38	531780	Plate, Pump, Adj Mount	1
39	531850	Locator Wldt, Rear Door	1
40	523510	Pump, 2-Stage, 6812	1
41	023950	Bolt, HHCS 1/2 x 2	2
42	991200	Bolt, CRG 1/2-13 x 2	4
-43	534340	Fixture, Plate Locator (Not Shown)	1
44	1770500	Bolt, HHCS 1/2-13 X 1-3/4 GR 5ZN	1

SHORT CONVEYOR ASSEMBLY

SHORT CONVEYOR ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
		Short Conveyor Assembly, 6812, (523500)	
1	516740	Conveyor Wldt, Short	1
2	522940	Bearing, PB, 1.75 Wide	2
3	517330	Shaft, Drive, Short Conveyor	1
4	533010	Sprocket, 9T – 0.62, 56mm	2
5	343280	Roller, Rubber 4.0 dia	6
6	523580	Roller, 5.0 OD, 0.62 dia	2
7	JN144798	Trunion, Wheel Retainer	4
8	523590	Spacer, Tube, 1.25 OD x 0.59 L	2
9	522000	Chain, Belted, 56mm x 40 (See Draper Chain Section for Parts)	1
10	523600	Coupler, 1.25 B, Spec	1
11	516650	Arm, Torque, Universal	1
12	523520	Motor, Hyd 18.7, 2000	1
-12A	384850	Kit, Seal 2000 Motor	1
13	516680	Channel, Rods, 31.25	2
14	347540	Rod, Grate, Round Head	32
15	E126195	Bushing, 11/16 x 1-1/4 x 1-1/8	2
16	023950	Bolt, HHCS 1/2-13 x 2.0 Gr5	2
17	007080	Bolt, HHCS 1/2-13 x 2-1/2	4
18	991200	Bolt, CRG 1/2-13 x 2.0 Gr5 ZN	4
19	005360	Nut, Hex 1/2-13 Gr5 ZN	10
20	005370	Washer, Lock 1/2 ZN	10
21	005200	Washer, Flat 1/2 Std	8
22	R66168	Bolt, Adj 5/8 x 6-1/2	2
23	056720	Bolt, HHCS 5/8-11 x 4 Gr5	2
24	990680	Bolt, HHCS 5/8-11 x 5-1/2	2
25	031490	Bolt, HHCS 5/8-11 x 5.0 Gr5	4
26	E672446	Bolt, HHCS 5/8-11 x 7.0 Gr5	2
27	I124589	Nut, Hex 5/8-11 Gr5 ZN	14
28	020440	Washer, Lock 5/8 Reg	10
29	020430	Washer, Flat 5/8 Std	6
30	V054934	Bolt, HHCS 5/16-18 x 3-3/4	1
31	025670	Nut, Lock 5/16-18 ZN	1
32	039960	Key, Square 3/8 x 2.3/4	2
33	021630	Key, Square 5/16 x 1-1/2	1
34	516560	Standoff, 0.62 x 1.50	2
35	526490	Cap, Roller	2
36	523610	Bolt, SHCS (Hex), 5/16-24	4
37	E724252	Spacer, 1.0 OD x 1-1/2 L	2
-38	530870	Bracket Wldt, Conveyor Support	2
-39	531700	Plate, Conveyor Support	2

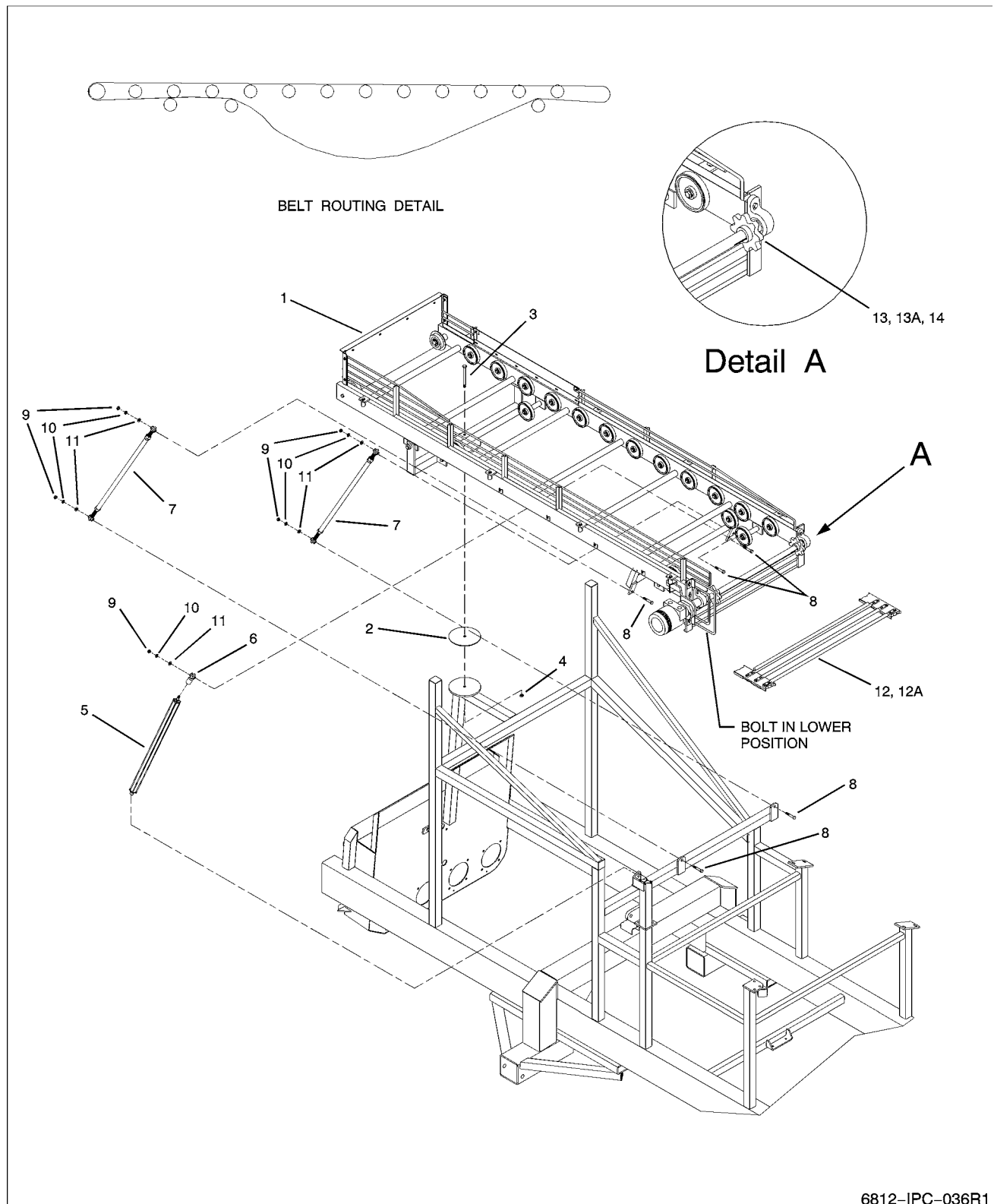
TANK AND BOOM CONVEYOR ASSEMBLIES



TANK AND BOOM CONVEYOR ASSEMBLIES

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	527180	Tank and Boom Conveyor Assemblies, 6812, (523000-90)	1
2	527190	Conveyor Assy, Boom	1
3	524040	Tank Assy	2
4	R66338	Bushing, Elev. Pivot	2
5	990510	Bolt, HHCS 1-8 x 3 GR5 ZN	2
6	042180	Nut, Lock 1-8 Hex GR5 ZN	2
7	990620	Washer, Flat 1.0 x 2.0 x 3/16	10
8	020430	Bolt, HHCS 5/8-11 x 2.0 GR5 ZN	8
9	020440	Washer, Flat 5/8 Std	10
10	I124589	Washer, Lock 5/8 Reg	10
11	525200	Nut, Hex 5/8-11 GR5 ZN	1
12	525570	Winch, Worm, 2000#	1
13	526500	Cable Assy, w/ Hook, 0.19 x 25 feet	1
14	012260	Pulley Block, Swivel Eye	3
15	018150	Bolt, HHCS 3/8-16 x 1.0 GR5 ZN	1
16	136970	Bolt, HHCS 3/8-16 x 1-3/4	1
17	027260	Spacer, Pulley	12
18	021180	Nut, Hex 3/8-16 GR5 ZN	12
19	021190	Washer, Lock 3/8 x 11/16	5
20	522030	Washer, Flat 3/8 Std	1
20A	522040	Chain, Belted 50mm x 277 (See Draper Chain Section for Parts)	1
21	523550	Chain, Belted 56mm x 248 (See Draper Chain Section for Parts)	2
21A	523570	Sprocket 10T, 50mm w/ Pins	2
22	167920	Sprocket 10T, 56mm w/ Pins	2
23	523850	Key, 3/8 x 2-1/2	2
24	524270	Strap, Ladder Mount	1
25	990820	Ladder, Wldt	2
26	006690	Bolt, HHCS 3/8-16 x 3	6
		Bolt, HHCS 3/8-16 x 1-1/4	

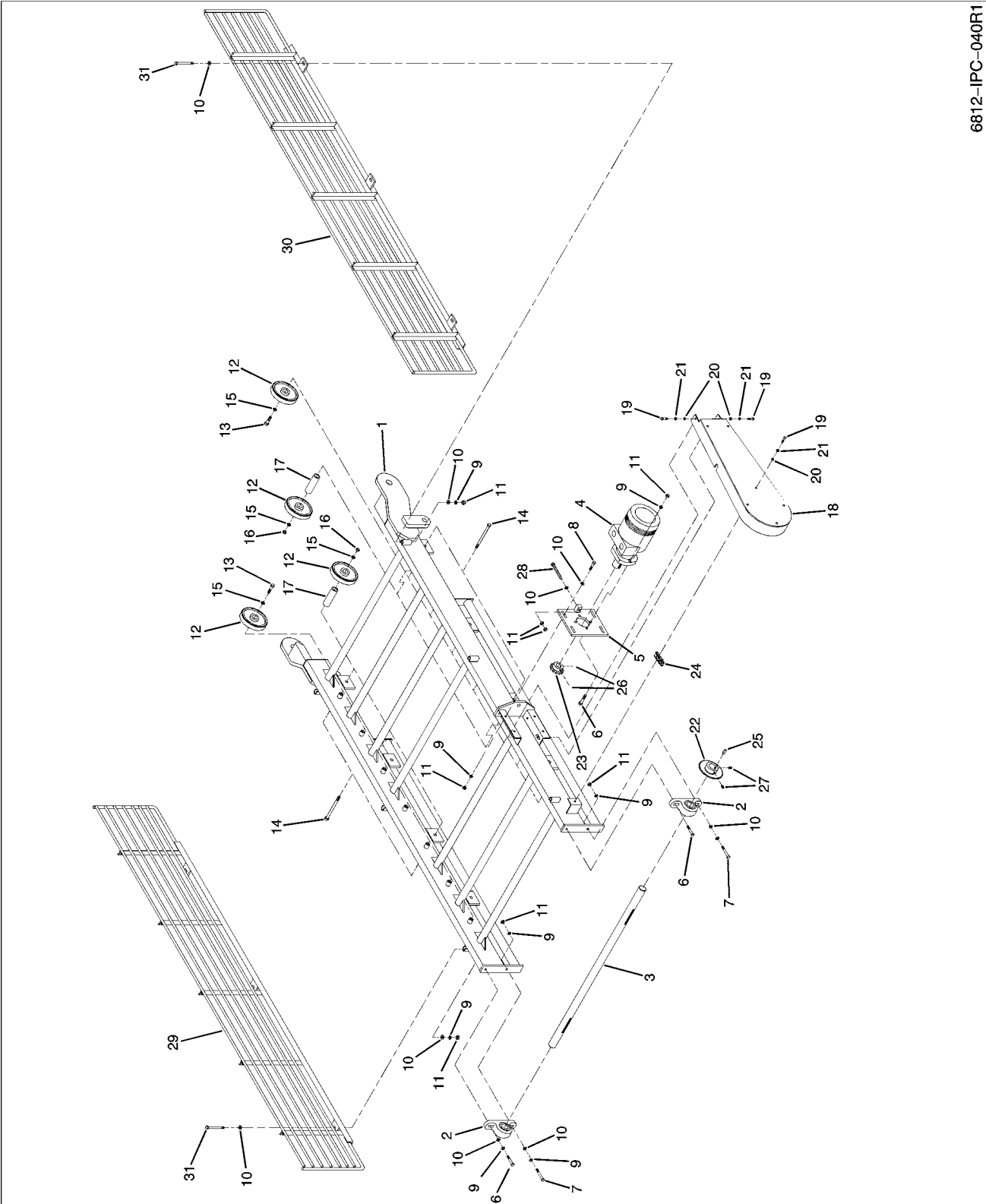
TRANSFER CONVEYOR ASSEMBLY



TRANSFER CONVEYOR ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	527170	Transfer Conveyor Assembly, 6812, (523000-100)	1
2	526430	Conveyor Assy, Transfer	1
3	991050	Disk, Pivot, Wear	1
4	991050	Bolt, HHCS 3/4-10 x 8-1/2	1
4	JK40016	Nut, Lock 3/4-10 GR8 ZN	1
5	525320	Cylinder, Hyd, 2.5 x 36	1
6	525360	Ball Wldt, Rod End	1
7	527200	Arm Assy, Parallel	2
8	990830	Bolt, HHCS 3/4-10 x 3-1/2	5
9	J14H794	Nut, Hex 3/4-10 GR5 ZN	5
10	036800	Washer, Lock 3/4	5
11	I131017	Washer, Flat 3/4	5
12	522010	Chain, Belted, 50mm x 174 (See Draper Chain Section for Parts)	1
12A	522020	Chain, Belted, 56mm x 155 (See Draper Chain Section for Parts)	5
13	533020	Sprocket, 9T/0.50, 50mm, Split	2
13A	523560	Sprocket, 8T – 56mm w/o Pins	2
14	167920	Key, Square 3/8 x 2-1/2	2

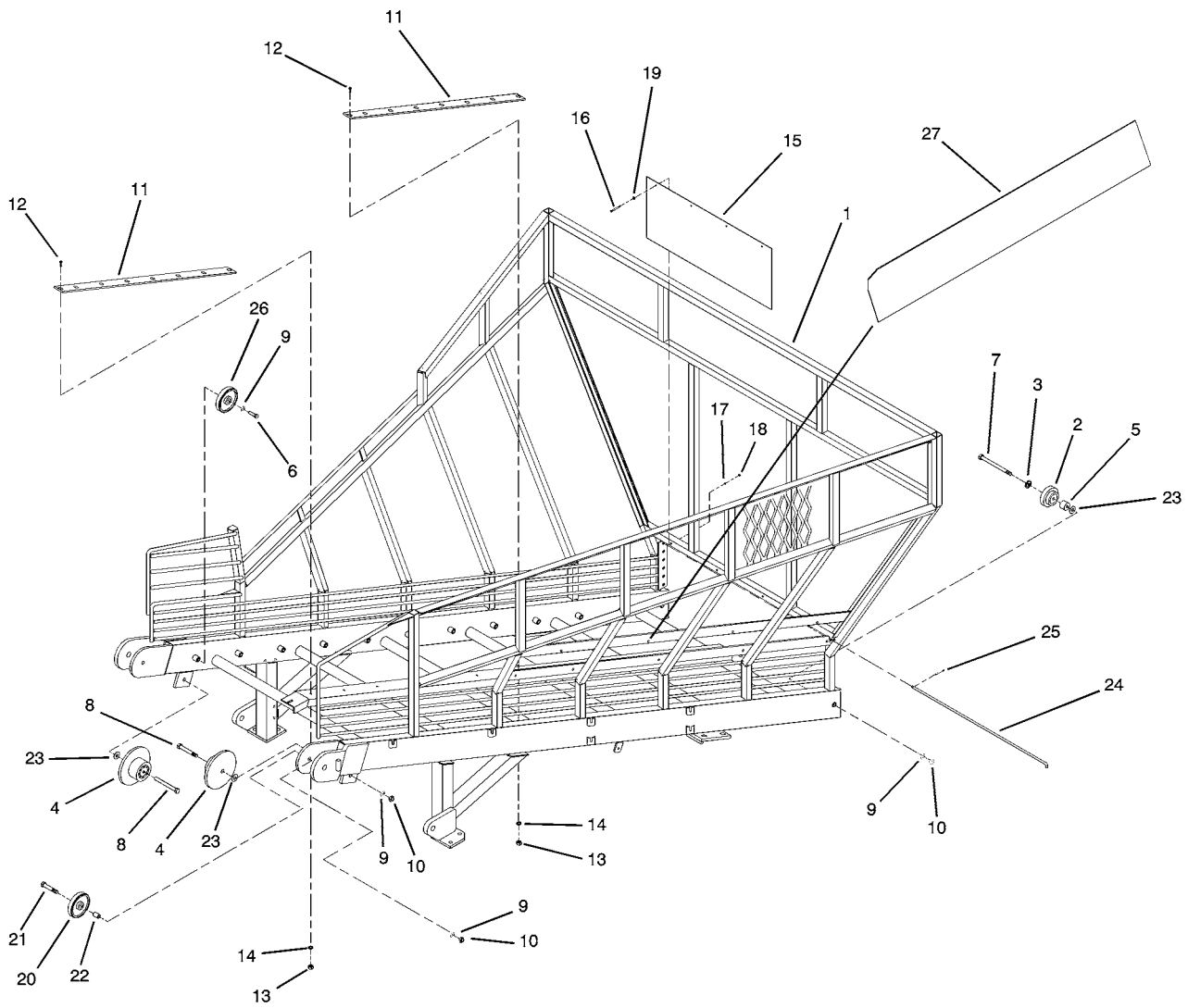
BOOM CONVEYOR UNIT



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BOOM CONVEYOR UNIT

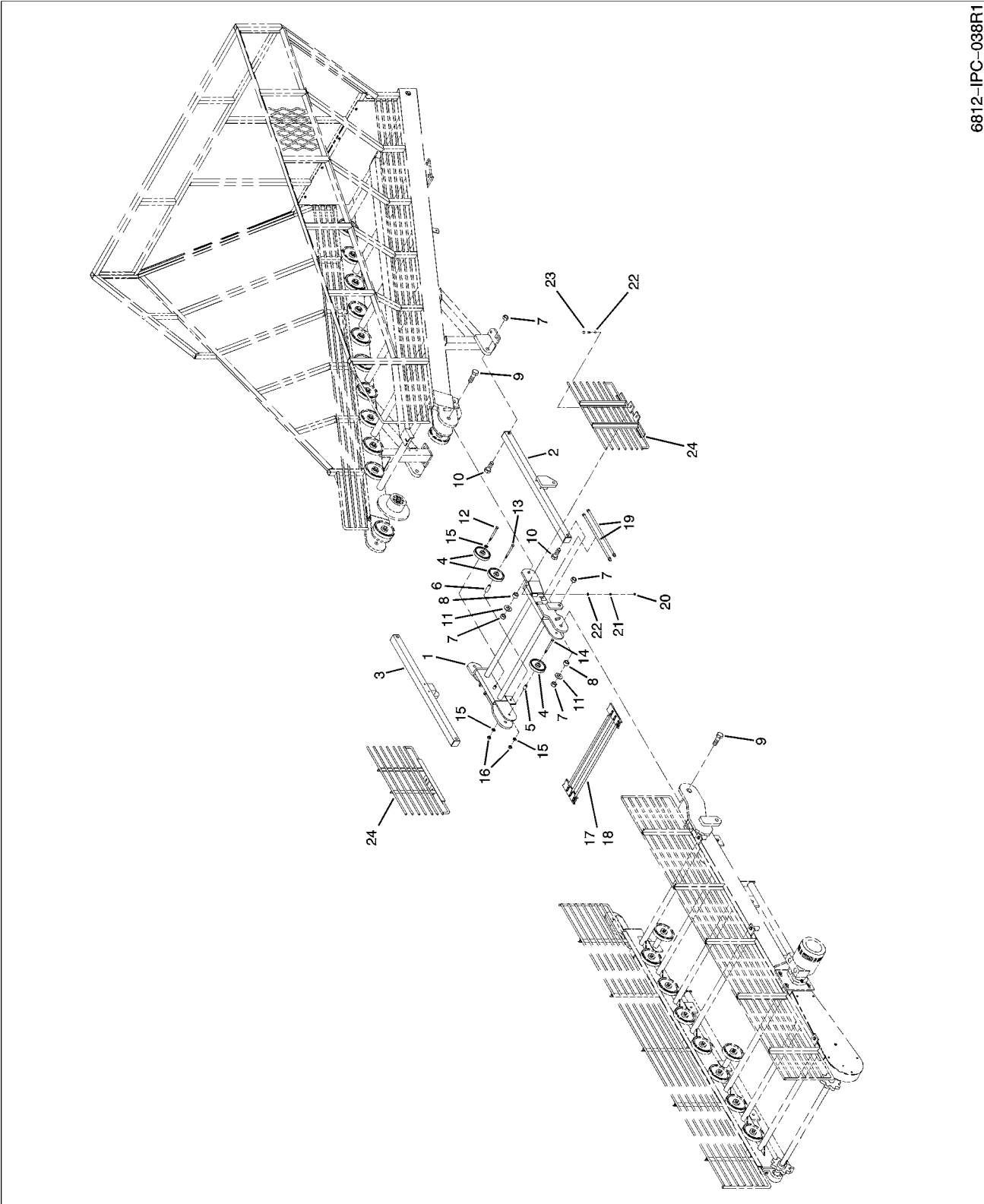
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	517480	Boom Conveyor Unit, 6812, (527180)	1
2	522940	Conveyor Wldt, Truck Boom	2
3	524560	Bearing, PB, 1.75 Wide	1
4	523530	Shaft, Drive, Boom 1.75 x 51	1
5	520030	Motor, Hyd 20, 2000, 7/8 OR	1
6	023950	Plate Wldt, Motor Mtg	4
7	007080	Bolt, HHCS 1/2-13 x 2.0 GR5	2
8	E096046	Bolt, HHCS 1/2-13 x 2-1/2	4
9	005370	Bolt, CRG 1/2-13 x 1-1/2	10
10	005200	Washer, Lock 1/2 ZN	9
11	005360	Washer, Flat 1/2 Std	10
12	343280	Nut, Hex 1/2-13 GR5 ZN	18
13	990610	Roller, Rubber 4.0 Dia	14
14	031490	Bolt, HHCS 5/8-11 x 1-1/2	4
15	020440	Bolt, HHCS 5/8-11 x 5	18
16	I124589	Washer, Lock 5/8 Reg	4
17	532770	Nut, Hex 5/8-11 GR5 ZN	4
18	524570	Spacer, 1.0 OD x 0.69 x 2.94	1
	524580	Shield Assy, Boom Drive	1
	524590	* Panel, Outer, Boom Shield	1
		* Wrapper, Boom Shield	1
19	517220	* Clip, Boom Shield	3
20	012260	Bolt, HHCS 3/8-16 x 1.0 GR5	3
21	021180	Washer, Lock 3/8	3
22	021190	Washer, Flat 3/8 Std	1
23	532780	Sprocket, 60B36 1.75 Bore	1
24	276520	Sprocket, RC60B12 1.25 Inch Bore	1
25	532790	Chain, Roller #60 x 108P	1
26	013510	Key, Square 3/8 x 1-1/4	2
27	010990	Screw, HSSS 5/16-18	2
28	120970	Screw, HSSS 3/8-16	1
29	034650	Bolt, HHCS 1/2-13 x 3-1/2	1
30	527220	Grate Wldt, Boom Rear	1
31	527240	Grate Wldt, Boom Front	6
32	031870	Bolt, HHCS 1/2-13 x 3-3/4	6
33	005370	Washer, Lock 1/2	6
34	005360	Nut, Hex 1/2-13	12
	005200	Washer, Flat 1/2 Std	

TANK ASSEMBLY

TANK ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	523740	Tank Assembly, 6812, (527190)	1
2	523580	Tank Wldt, 6812 BH	2
3	526490	Roller, 5 Inch OD, 0.62 Dia Mtg.	2
4	423070	Cap, Roller	2
5	516560	Roller, Flange 4.0 OD	2
5	516560	Standoff, 0.62 x 1.50	2
6	990610	Bolt, HHCS 5/8-11 x 1-1/2	22
7	262620	Bolt, HHCS 5/8-11 x 8.0	2
8	028330	Bolt, HHCS 5/8-11 x 4-1/2	2
9	020440	Washer, Lock 5/8 Reg	28
10	I124589	Nut, Hex 5/8-11 GR5 ZN	6
11	531910	Strip, Wear, UHMW, 1.0 Inch Thick	2
12	395840	Screw, FCHMS 3/8-16 X 1-1/4 GR5	8
13	027260	Nut, Hex 3/8-16 GR5 ZN	8
14	021180	Washer, Lock 3/8 x 11/16	8
15	523950	Flap, Rubber, Elev. End	1
16	022910	Bolt, HHCS 5/16-18 x 2-1/4	4
17	023620	Washer, Lock 5/16	13
18	023630	Nut, Hex 5/16-18 GR5 ZN	13
19	022920	Washer, Flat 5/16 Std	13
20	343280	Roller, Rubber 4.0 Dia	2
21	I271429	Bolt, HHCS 5/8-11 x 3-1/2	2
22	E724252	Spacer, 0.69 x 5/32 W x 1.5 L	2
23	020430	Washer, Flat 5/8 Std	6
24	522790	Rod, LH	6
25	116820	Pin, Cotter 1/16 x 3/4 ZN	6
26	247100	Roller Rubber, 5 Dia	22
27	531920	Filler, Front Panel, Poly	1
28	005900	Bolt, HHCS 5/16 x 1	9

BOOM EXTENSION - 8R28/30

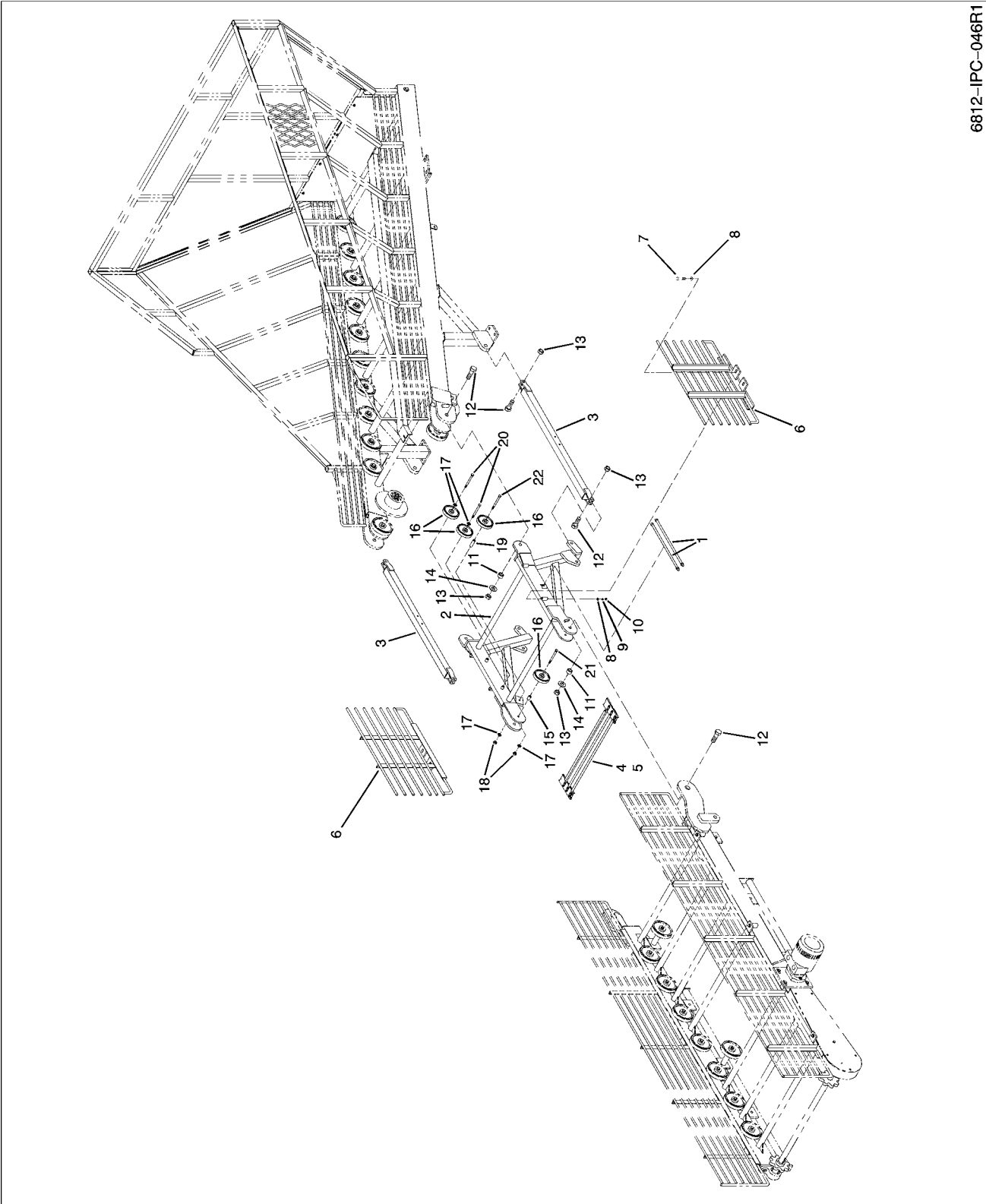


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BOOM EXTENSION - 8R28/30

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	524110		Boom Extension, 6812, (526790)	1
2	526840		Boom Wldt 28 Inch Ext	1
3	526850		Boom Support Wldt 28 Foot Front	1
4	343280		Boom Support Wldt 28 Foot Back	6
5	E724252		Roller, Rubber 4.0 dia.	2
6	532770		Spacer, 1 OD x 5/32 x 1-1/2	2
7	990510		Spacer, 1.0 OD x 0.69 x 2.94	6
8	524040		Nut, Lock 1-8 Hex (Item from Original Elevator Mtg.)	2
9	R66338		Bushing, Elev. Pivot (Item from Original Elevator Mtg.)	2
10	991060		Bolt, HHCS 1-8 x 3 (Item from Original Elevator Mtg.)	4
11	042180		Bolt, HHCS 1-8 x 5	2
12	990610		Washer, Flat 1 x 2 x 3/16 (Item from Original Elevator Mtg.)	2
13	031490		Bolt, HHCS 5/8-11 x 1-1/2	2
14	056720		Bolt, HHCS 5/8-11 x 5	2
15	020440		Bolt, HHCS 5/8-11 x 4	6
16	I124589		Washer, Lock 5/8 x 1-5/64 x 5/32	4
17	526590		Nut, Hex 5/8-11	1
18	526580		Chain, Belted 50mm (See Draper Chain Section for Parts)	1
19	526820		Chain, Belted 56mm (See Draper Chain Section for Parts)	2
20	005360		Hose, Hyd 5/8 x 28	4
21	005370		Nut, Hex 1/2-13	4
22	005200		Washer, Lock 1/2	8
23	031870		Washer, Flat 1/2	4
24	530530		Bolt, HHCS 1/2-13 x 3-3/4	2
			Grate Wldt 28 Inch Extension	

BOOM EXTENSION – 12R22

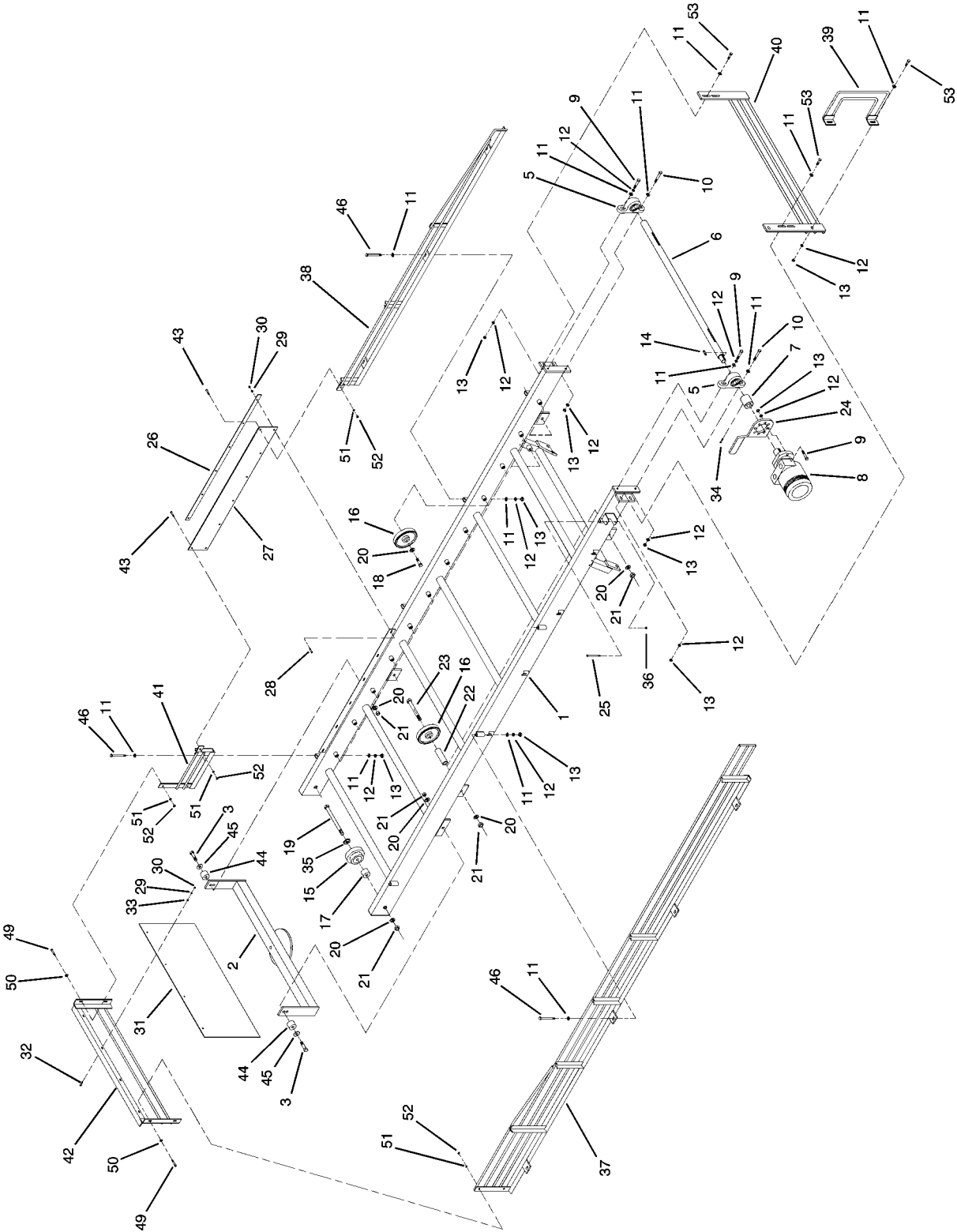


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BOOM EXTENSION 12R22

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	526830	Boom Extension, 6812, (526800)	2
2	524010	Hose, Hyd 5/8 x 44	1
3	524100	Boom Wldt 44 Inch Ext	2
4	526570	Arm Wldt, Ext. Support	1
5	526560	Chain, Belted 50mm (See Draper Chain Section for Parts)	1
6	530540	Chain, Belted 56mm (See Draper Chain Section for Parts)	2
7	031870	Grate Wldt 44 Foot Ext	4
8	005200	Bolt, HHCS 1/2-13 x 3-3/4	8
9	005370	Washer, Flat 1/2	4
10	005360	Washer, Lock 1/2	4
11	524040	Nut, Hex 1/2-13	2
12	R66338	Bushing, Elev. Pivot (Item from Original Elevator Mtg.)	6
13	990510	Bolt, HHCS 1-8 x 3 (Item from Original Elevator Mtg.)	6
14	042180	Nut, Lock 1-8 Hex (Item from Original Elevator Mtg.)	2
15	E724252	Washer, Flat 1 x 2 x 3/16 (Item from Original Elevator Mtg.)	2
16	343280	Spacer, 1 OD x 5/32 W x 1-1/2 LG	8
17	020440	Roller, Rubber 4.0 dia.	8
18	I124589	Washer, Lock 5/8	4
19	532770	Nut, Hex 5/8-11	2
20	990610	Spacer, 1.0 OD x 0.69 x 2.94	4
21	056720	Bolt, HHCS 5/8-11 x 1-1/2	2
22	031490	Bolt, HHCS 5/8-11 x 4	2

TRANSFER CONVEYOR UNIT



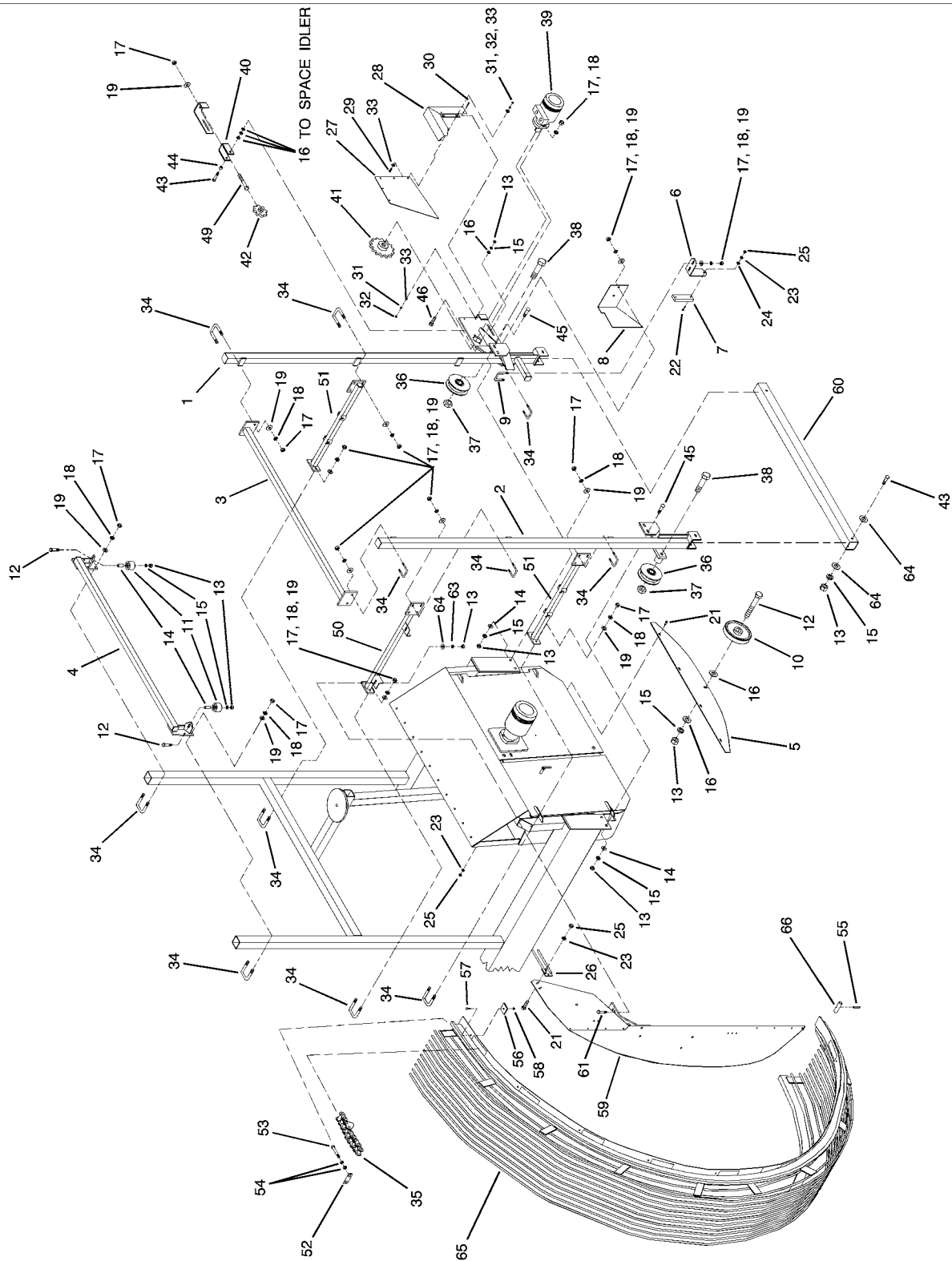
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TRANSFER CONVEYOR UNIT

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Transfer Conveyor Unit, 6812, (527170)	
1	516540		Wldt, Conveyor Transfer	1
2	516390		Swivel Wldt, Transfer Elevator	1
3	990850		Bolt, HHCS 5/8-11 x 2-3/4	2
5	522940		Bearing, PB, 1.75 Wide	2
6	516370		Shaft, Drive, Trans Conveyor	1
7	523530		Coupler, 1.25B, Spec	1
8	523530		Motor, Hyd 20,2000, 7/8 OR	1
9	023950		Bolt, HHCS 1/2-13 x 2.0 GR5	4
10	007080		Bolt, HHCS 1/2-13 x 2-1/2	2
11	005200		Washer, Flat 1/2 Std	22
12	005370		Washer, Lock 1/2 ZN	18
13	005360		Nut, Hex 1/2-13 GR5 ZN	18
14	021630		Key, Square 5/16 x 1-1/2	1
15	523580		Roller, 5 Inch OD, 0.62 Dia	2
16	343280		Roller, Rubber 4.0 Dia	30
17	516560		Standoff, 0.62 x 1.00	2
18	990610		Bolt, HHCS 5/8-11 x 1-1/2	26
19	262620		Bolt, HHCS 5/8-11 x 8	2
20	020440		Washer, Lock 5/8 Reg	34
21	I124589		Nut, Hex 5/8-11 GR5 ZN	8
22	532770		Spacer, 1.0 OD x 0.69 x 2.94	4
23	031490		Bolt, HHCS 5/8-11 x 5	4
24	516650		Arm, Torque, LH	1
25	E672388		Bolt, HHCS 5/16-18 x 3-1/4	1
26	517540		Strap, Inlet Flap	1
27	517550		Flap, Rubber, Inlet	1
28	254060		Bolt, CRG 5/16-18 x 1 SSN ZN	6
29	023620		Washer, Lock 5/16 x 37/64	11
30	023630		Nut, Hex 5/16-18 GR5 ZN	11
31	523950		Flap, Rubber, Elev. End	1
32	005900		Bolt, HHCS 5/16-18 x 1 GR5	4
33	022920		Washer, Flat 5/16 Std	4
34	523610		Bolt, SHCS (Hex), 5/15-24	4
35	526490		Cap, Roller Seal	2
36	025670		Nut, 5/16 Lock	1
37	527360		Grate, Upper Wldt, RH	1
38	527370		Grate, Upper Wldt, LH	1
39	527520		Grate Wldt, RH, Trans	1
40	527530		Grate Wldt, Outer, Trans	1
41	527540		Grate Wldt, Short	1
42	527570		Grate Wldt, End	1
43	006690		Bolt, 3/8-16 x 1-1/4 GR5 ZN	2
44	467270		Spacer, 0.64 ID x 1.0 x 0.75	2
45	020430		Washer, Std. 5/8	2
46	031870		Bolt, HHCS 1/2-13 x 3-3/4	8
49	011370		Bolt, HHCS 3/8-16 x 1-1/2	4
50	021190		Washer, Flat 3/8 Std	4
51	021180		Washer, Lock 3/8 x 11/16	6
52	027260		Nut, Hex 3/8-16 GR5 ZN	6
53	030470		Bolt, CRG 1/2-13 x 1-1/4	6

FERRIS WHEEL

6812-IPC-045R1



FERRIS WHEEL

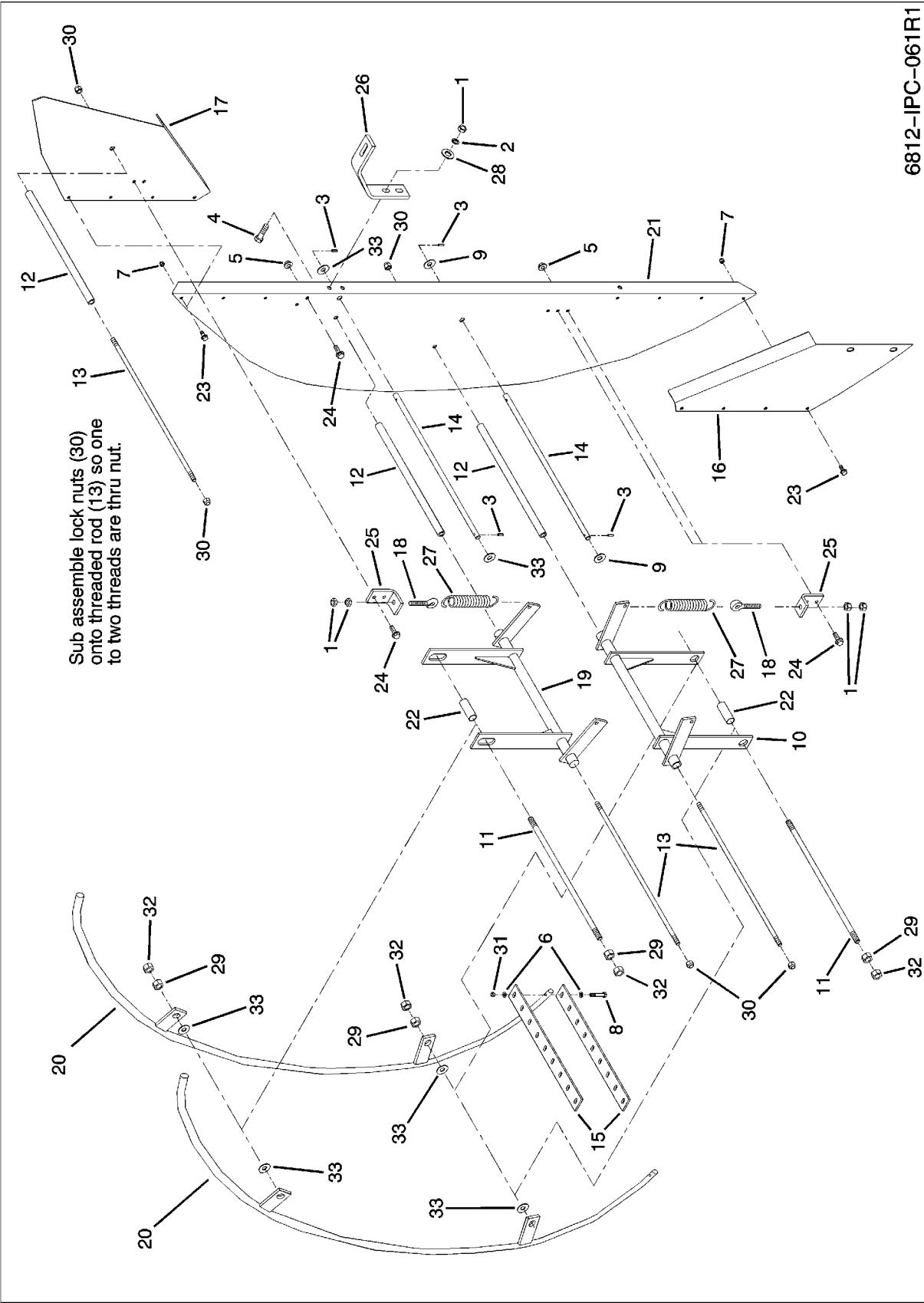
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	532390	Ferris Wheel, 6812, (523480)	1
2	532340	Support Wldt, RH F Wheel	1
3	519630	Support Wldt, LH F Wheel	1
4	519630	Tube Wldt, Upper FW	1
5	534060	Tube Wldt, Frt Upper FW	1
6	523790	Filler, Lower FW	1
7	523800	Holder, Chain Guide	1
8	523810	Bar, UHMW, Chain Guide	1
9	523820	Filler, RH Rear	1
10	290890	Bolt, U 1/2-13 x 2-1/16 x 3	1
11	343280	Roller Rubber 4.0 Dia	1
12	413970	Roller Assy, Wheel Retainer	2
13	028330	Bolt, HHCS 5/8-11 x 4-1/2	2
14	I124589	Nut, Hex 5/8-11 GR5 ZN	18
15	413980	Spacer	2
16	020440	Washer, Lock 5/8 Reg	14
17	035210	Washer, Flat 5/8 SAE	30
18	005360	Nut, Hex 1/2-13 GR5 ZN	42
19	005370	Washer, Lock 1/2 ZN	42
20	005200	Washer, Flat 1/2 Std	30
21	023110	Bolt, HHCS 5/8-11 x 2-1/2	1
22	170530	Bolt, CRG 3/8-16 x 1.0	6
23	J03H1558	Bolt, CRG 3/8-16 x 1-1/2	2
24	021180	Washer, Lock 3/8 x 11/16	9
25	021190	Washer, Flat 3/8 Std	4
26	027260	Nut, Hex 3/8-16 GR5 ZN	8
27	533120	Grate Wldt, Upper Ret	1
28	523770	Flap, F. Wheel Shield	1
29	532400	Shield, FW Drive	1
30	028230	Screw, THMS 5/16-18 x 3/4	5
31	030030	Bolt, HHCS 5/16-18 x 1-1/4	2
32	023620	Washer, Lock 5/16 x 37/64	7
33	023630	Nut, Hex 5/16-18 GR5 ZN	7
34	022920	Washer, Flat 5/16 Std	12
35	468370	Bolt, U 1/2 x 3.0 x 4.25 ZN	18
36	433700	Chain Assy, Wheel Drive	1
37	433240	Roller Assy, Wheel Guide	2
38	JN144757	Nut, Wheel 1-8 Guide	2
39	990920	Bolt, HHCS 1-8 x 4-1/2 GR5	2
40	523520	Motor, Hyd 18.7, 2000, 7/8 OR	1
41	532290	Yoke Wldt, FW Idler	1
42	523760	Sprocket, Assy, 1.25B, 14T	1
43	JAN142341	Sprocket Assy, 8T	1
44	345000	Bolt, 5/8-11 x 5-1/2	2
45	JN147291	Bushing, 0.875 x 0.656 x 0.62	1
46	005210	Bolt, CRG 1/2-13 x 2-1/4	4
47	023950	Bolt, HHCS 1/2-13 x 2 GR5	2

FERRIS WHEEL

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
47	520280		Tie, Lower Ret	2
48	I4331028		Bolt, CRG 5/8-11 x 1-3/4	4
49	162930		Bolt, HHCS 1/2-13 x 5-1/2	1
50	532350		Brace Wldt, Ret Support	1
51	532360		Brace Wldt, w/ Clips	2
52	JN145108		Strap, Rocker	12
53	J19H2969		Bolt, HHCS 5/8-11 x 3-1/2	12
54	1121555		Nut, Jam 5/8-11 Hex ZN GR5	24
55	012560		Pin, Expan 3/16 x 1 ZN	14
56	JN144807		Block Replacement	18
57	254060		Bolt, CRG 5/16-18 x 1 SSN ZN	18
58	020190		Nut, Lock 5/16-18 GR2 ZN	18
59	520200		Retainer Assembly, 6812	1
60	532160		Tube, Bumper	
61	990620		Bolt, HHCS 5/8-11 x 2-1/2 GR5 ZN	2
62	432550		Stripper Assy (Not Shown)	1
63	020440		Washer, Lock 5/8 Reg	2
64	020430		Washer, Flat 5/8 Std	12
65	431750		Wheel Wldt, Half	2
	438820		Flap, Wheel, Wide (Option For Ferris Wheel)	
66	438860		Strap, Wheel, Wide (Option For Ferris Wheel)	28
	431860		Connector, Rod, 0.56 dia	

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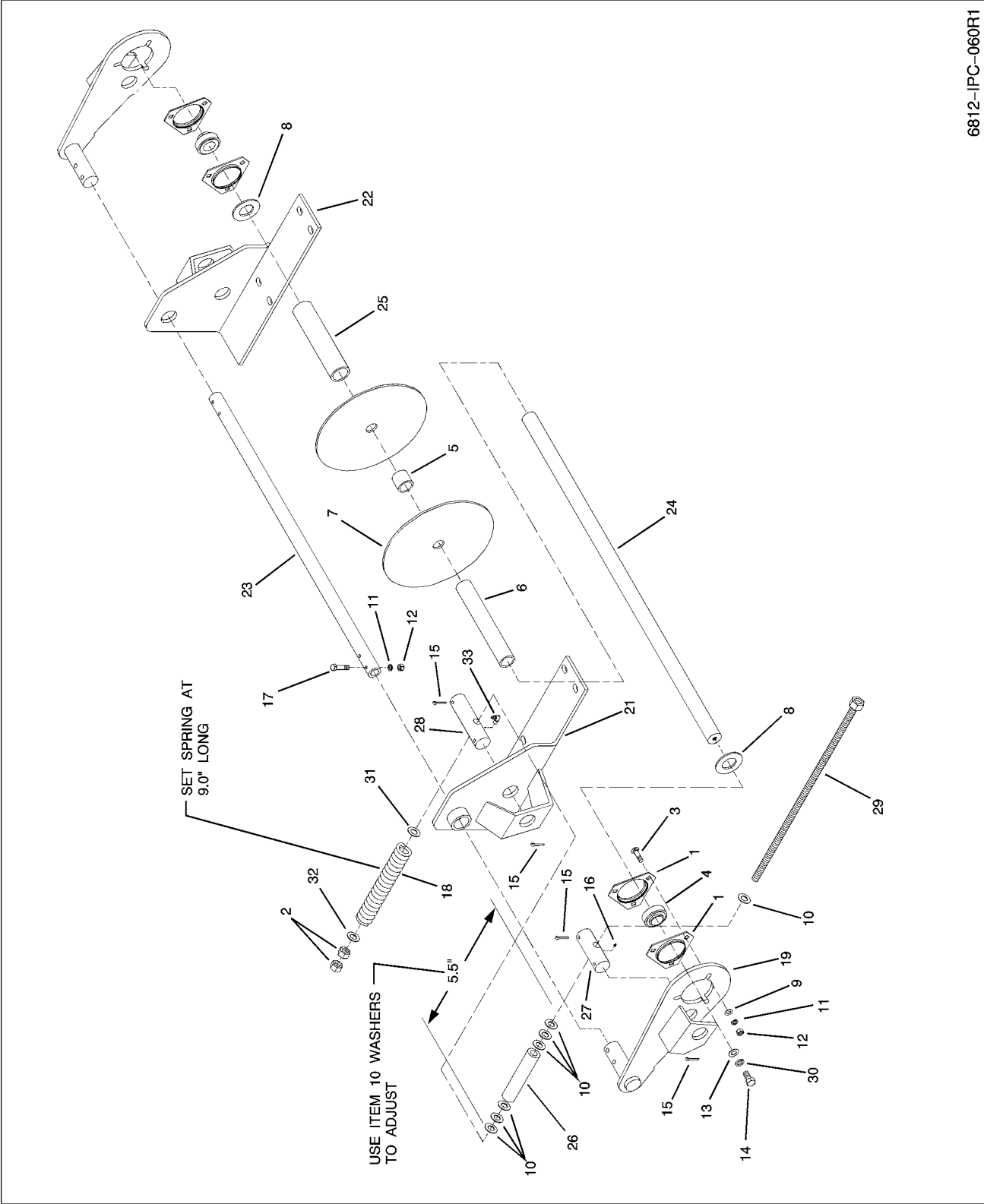
RETAINER



RETAINER

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	005360		Retainer, 6812, (520200)	
2	005370		Nut, Hex 1/2 G5 ZN	16
3	012550		Washer, Lock 1/2 ZN	8
4	014770		Pin, Expansion 1/4 x 1.25	4
			Bolt, HHCS 1/2 x 1.50 G5 ZN	8
5	020180		Nut, Hex Flg LK 3/8 G5	10
6	021190		Washer, Flat 0.44 x 1.00 x 0.083	20
7	025670		Nut, Hex LK 5/16 G5	14
8	029930		Bolt, HHCS 3/8 x 2.25 G5 ZN	10
9	035210		Washer, Flat 0.66 x 1.31 x 0.095	2
10	433070		Pivot Assembly, Retainer	1
11	433010		Rod, Retainer Supt. 5/8 x 23.31	2
12	433050		Spacer, 0.88 x 0.56 x 25.5	3
13	433040		Rod, Retainer Pivot 0.50 x 27.5	3
14	433030		Rod, Retainer Stop 0.88 x 27.5	2
15	433020		Strap, Retainer	2
16	520210		Side, Hopper Lower, RH	1
16	520220		Side, Hopper Lower, LH	1
17	520230		Side Weld, LH Upper Retainer	1
17	520240		Side Weld, RH Upper Retainer	1
18	290930		Bolt, Eye 1/2 x 3.50	4
19	433060		Pivot Weld, Upper Retainer	1
20	520250		Rod Weldment, Retainer	10
21	342600		Side Weld, LH Retainer	1
21	342610		Side Weld, RH Retainer	1
22	J28H2612		Spacer Blk, Pipe 3/4 x 2.00	18
23	JN10212		Screw, HX Flg 5/16 x 0.75 G5	14
24	JN10214		Screw, HX Flg LK 3/8 x 1.0 G5	10
25	JN144004		Bracket, Spring	4
26	JN144650		Bracket, Retainer	2
27	394890		Spring, Ext. 2.2 OD x 10.44 CL	4
28	I120396		Washer, Flat 0.53 x 1.06 x 0.074	8
29	I124589		Nut, Hex 5/8 G5 Zn	4
30	I9413967		Nut, Hex Lock 1/2 G5 ZN	6
31	I9411655		Nut, Hex Lock 3/8 G5 ZN	10
32	038850		Nut, Hex Lock 5/8 GRA ZN	4
33	I21471R1		Washer, Flat 21/32 x 1 x 1/8 ZN	6

STRIPPER

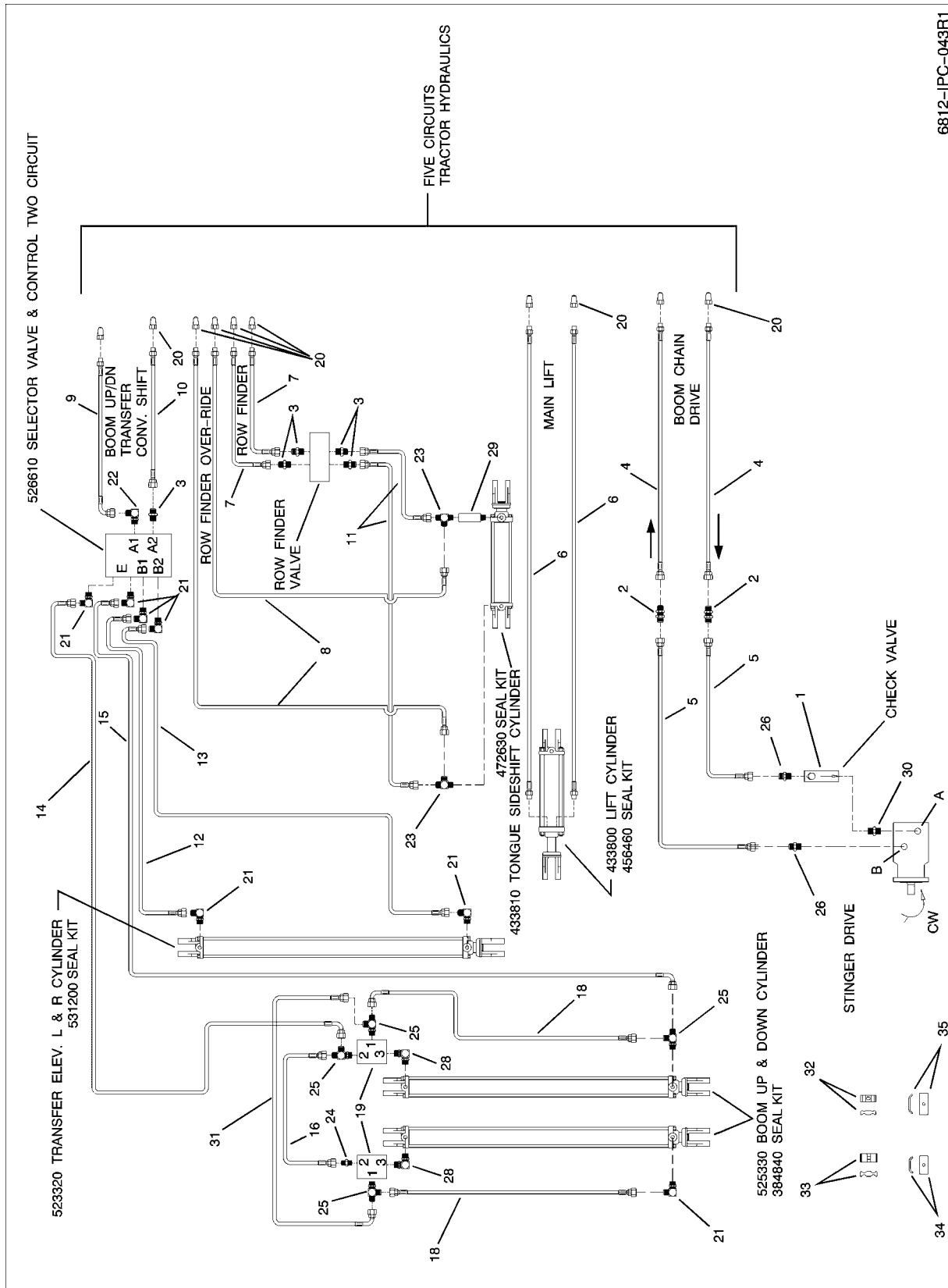


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STRIPPER

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	E281004		Stripper, 6812, (432550)	4
2	I124589		Flangette, Brg. 3 Hole	4
3	J03H1558		Nut, Hex 5/8-11 GR5 ZN	6
4	JJD9275		Bolt, CRG. 3/8-16 x 1.5 GR5	2
5	432590		Bearing, Ball 1.38 x 2.83 x 0.74	10
6	432570		Spacer, Rotary Stripper	1
7	JN144896		Spacer, 1.90 OD x 1.52 ID x 10.8	11
8	R61502		Disk, Rotary Stripper	2
9	I120394		Washer, Flat 1-3/8 STD	6
10	020430		Washer, Flat 3/8 SAE	12
11	021180		Washer, Flat 5/8 STD	10
12	023060		Washer, Lock 3/8 ZN	10
13	I486801R1		Nut, Lock 3/8-16 GR5 ZN	2
14	010730		Washer, Flat 17/32 x 2 x 1/4	2
15	114370		Bolt, HHCS 1/2-13 x 1.25	8
16	115590		Pin, Cotter 1/4 x 2 ZN	2
17	037630		Zerk, 1/4-28 Taper Drive	4
18	U52000015		Bolt, HHCS 3/8-16 x 2.5 GR5	2
19	415140		Spring, Compression	1
20	415150		Arm Wldt., RH Stripper	1
21	415160		Arm Wldt., LH Stripper	1
22	415170		Mount Wldt., RH Stripper	1
23	432560		Mount Wldt., LH Stripper	1
24	432580		Tube, Torque Stripper	1
25	433090		Axle, Disk Mount Stripper	1
26	462130		Spacer, 1.9 OD x 1.52 ID x 9.05	2
27	415220		Stop, Stripper Tube	2
28	415230		Pivot, Center Arm Strip	2
29	534410		Pivot, Center Mount Strip	2
30	005370		Bolt Wldt., 5/8-11 x 20.5 THD	2
31	I21905R1		Washer, Lock 1/2 ZN	2
32	340310		Washer, 21/32 x 1-3/4 x 1/4	2
33	1100756		Washer, 21/32 x 2 x 1/4	4
			Zerk, 1/4-28 x 90 Degree	2

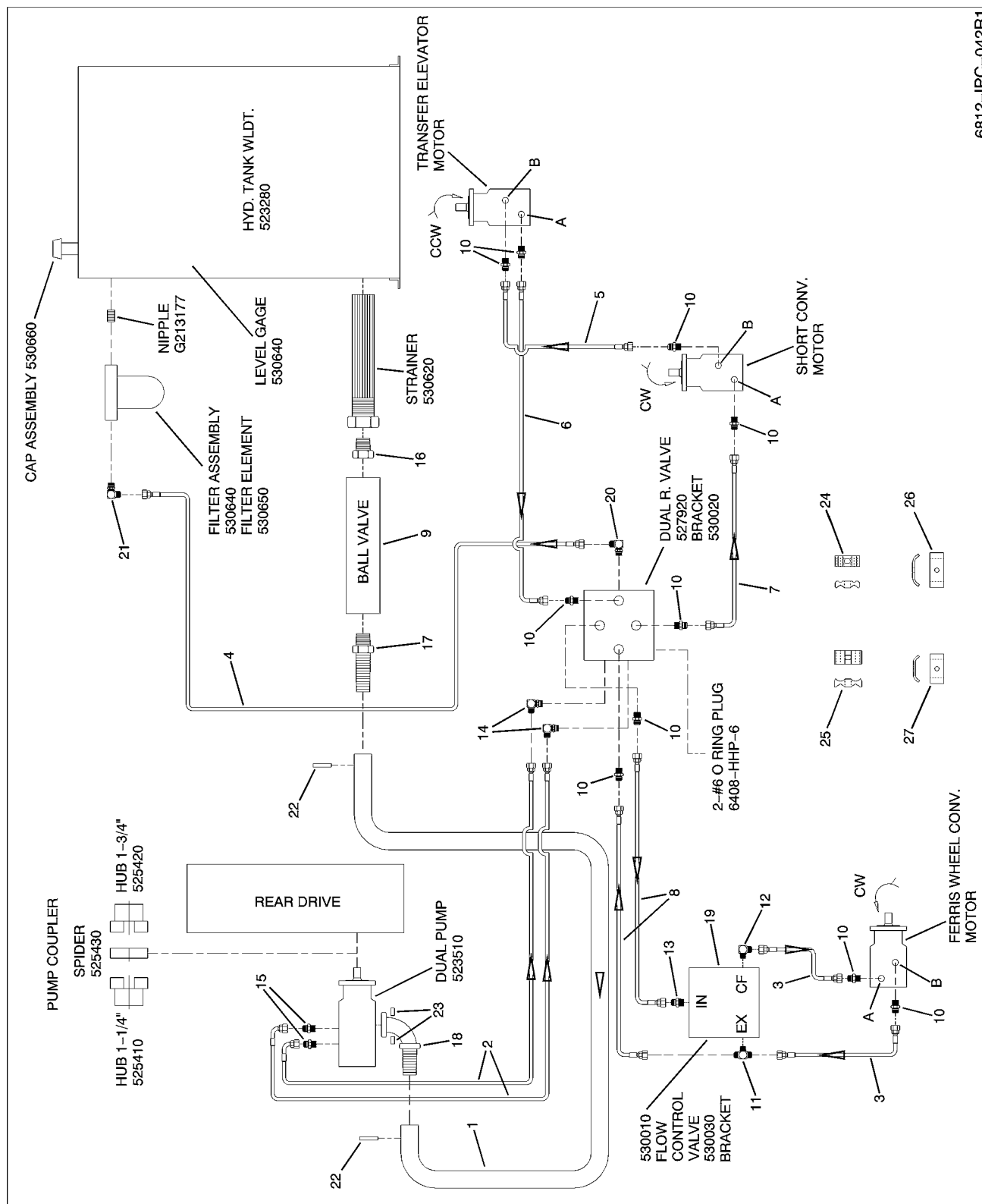
TRACTOR HYDRAULIC CIRCUITS



TRACTOR HYDRAULIC CIRCUITS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	530340	Tractor Hydraulic Circuits, 6812, (530580)	1
2	530350	Check Valve #10 ORB	2
3	530180	Adapter, Bulkhead F-7/8-14JIC	5
4	529930	Adapter, STR.M-3/4-16JIC X M-3/4-16ORB	2
5	529940	Hose, Hyd 5/8 x 172	2
6	529950	Hose, Hyd 5/8 x 335	2
7	529960	Hose, Hyd 1/2 x 130	2
8	529970	Hose, Hyd 1/2 x 168	2
9	530040	Hose, Hyd 1/2 x 126	1
10	530050	Hose, Hyd 1/2 x 146	1
11	530060	Hose, Hyd 1/2 x 58	2
12	530070	Hose, Hyd 1/4 x 283	1
13	530080	Hose, Hyd 1/4 x 300	1
14	528120	Hose, Hyd 1/4 x 254	1
15	530120	Hose, Hyd 1/4 x 277	1
16	530090	Hose, Hyd 1/4 x 79	1
18	530100	Hose, Hyd 1/4 x 26	1
19	534080	Pilot Operated Ck Valve	2
20	I1285718C2	Male Tractor Conn. x 7/8 ORB	10
21	I2185128	Adapter, 90, M-9/16-18JIC X M-3/4-16ORB	7
22	530210	Adapter, 90, M-3/4-16JIC X M-3/4-16ORB	1
23	530200	Adapter, Tee (2)M-3/4-16JIC X (1)M-1/2NPT	2
24	528160	Fitting, Hyd. Str. 6MJX x 8MBO	1
25	530250	Adapter, Tee, (2)M-9/16-18JIC X (1)M-3/4-16ORB	4
26	I2185062	Adapter, Str. M-7/8-14JIC X 7/8-14ORM	2
28	530260	Adapter, 90, (2)M-3/4-160ORM w/ Nut	2
29	419140	Restrictor, 1/2-14 M To F w/0.062R	1
30	530600	Adjustable O-Ring Hex Nipple	1
31	534020	Hose, Hyd 1/4 x 90	1
32	527690	Clamp, Small Plastic	AR
33	527700	Clamp, LG Plastic	AR
34	527670	Bar, Short	AR
35	527680	Bar, Long	AR

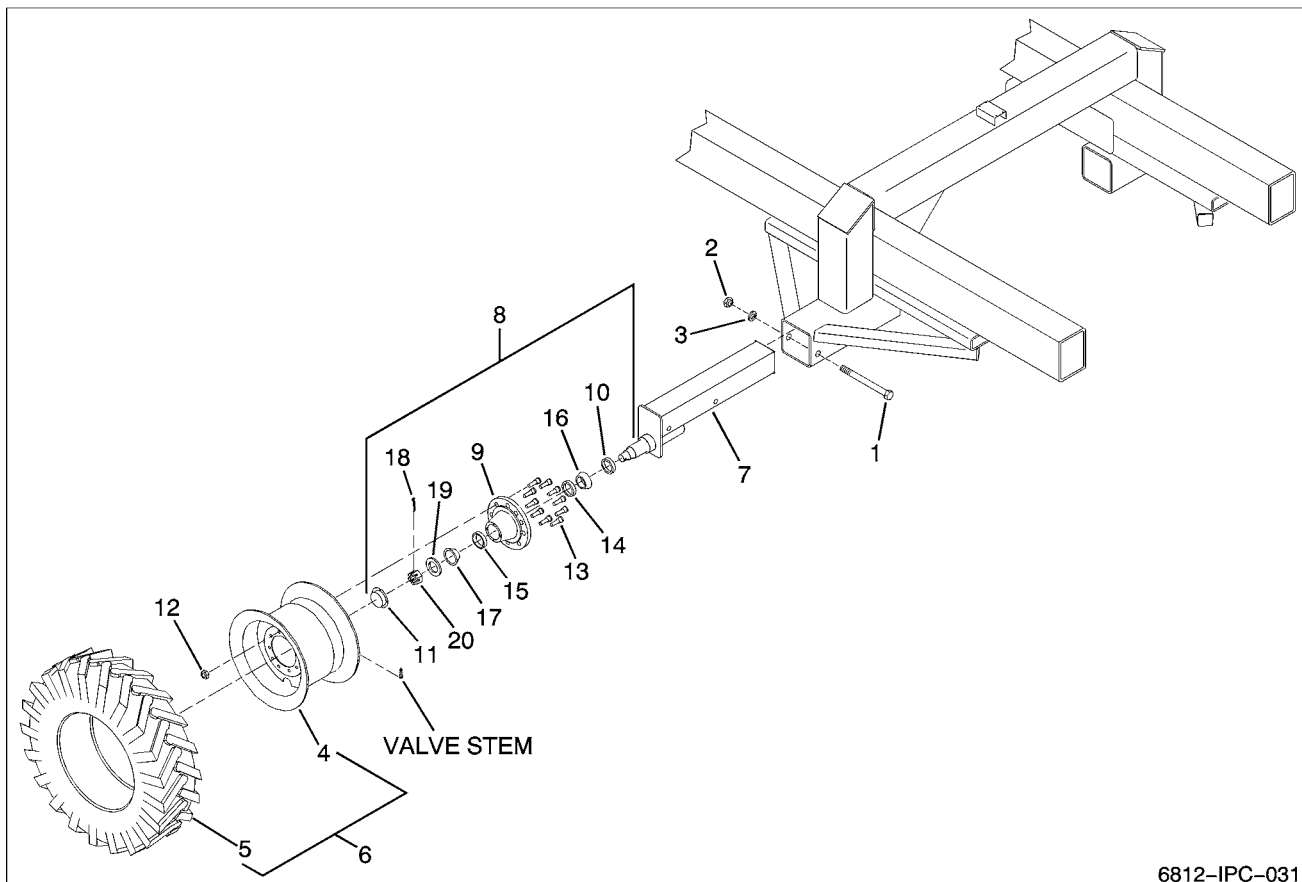
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SELF CONTAINED HYDRAULIC CIRCUITS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	529840	Self Contained Hydraulic Circuit, 6812, (530450)	1
2	529850	Hose, Suction 1-1/2 x 141	2
3	529870	Hose, Hyd 3/4 x 140	2
4	529910	Hose, Hyd 5/8 x 45	1
5	529890	Hose, Hyd 1 x 78	1
6	529900	Hose, Hyd 5/8 x 345	1
7	529880	Hose, Hyd 5/8 x 164	1
8	529860	Hose, Hyd 5/8 x 216	2
9	529980	Hose, Hyd 5/8 x 79	1
10	I2185062	Valve, Ball F-1-1/2 NPT	10
11	530140	Adapter, Str. M7/8 JIC-M7/8 ORB	1
12	530150	Adapter, Tee (2)1-1/16JICM, (1)3/4NPTM	1
13	530130	Adapter, 90, M-1-/16JIC X M-3/4NPT	1
14	530000	Adapter, M-1-1/16-12JIC X M-3/4NPT	2
15	529990	Adapter, 90, 1-1/16-12JICM X 7/8-14ORM	2
16	529920	Adapter, Str. 1-1/16-12JICM X 1-1/16-12ORM	1
17	530190	Adapter, Reducer 2 x 1-1/2 NPT	1
18	530220	Adapter, Str. Barb 1-1/2NPT x 1-1/2 Bare	1
19	530010	Adapter, Flg 90, 1-1/2 x 1-1/2 Barb	1
20	530160	Valve, Flow Control 3/4 NPT	1
21	530170	Adapter, 90, 1-5/16-12JICM X 1-5/16-12ORBM	1
22	530330	Adapter, 90, 1-5/16JICM X 1-1/4 NPTM	2
23	530230	Clamp, HC-150	1
24	527690	Flange Kit Complete 1-1/2	AR
25	527700	Clamp, Small Plastic	AR
26	527670	Clamp, LG Plastic	AR
27	527680	Bar, Short	AR
		Bar, Long	AR

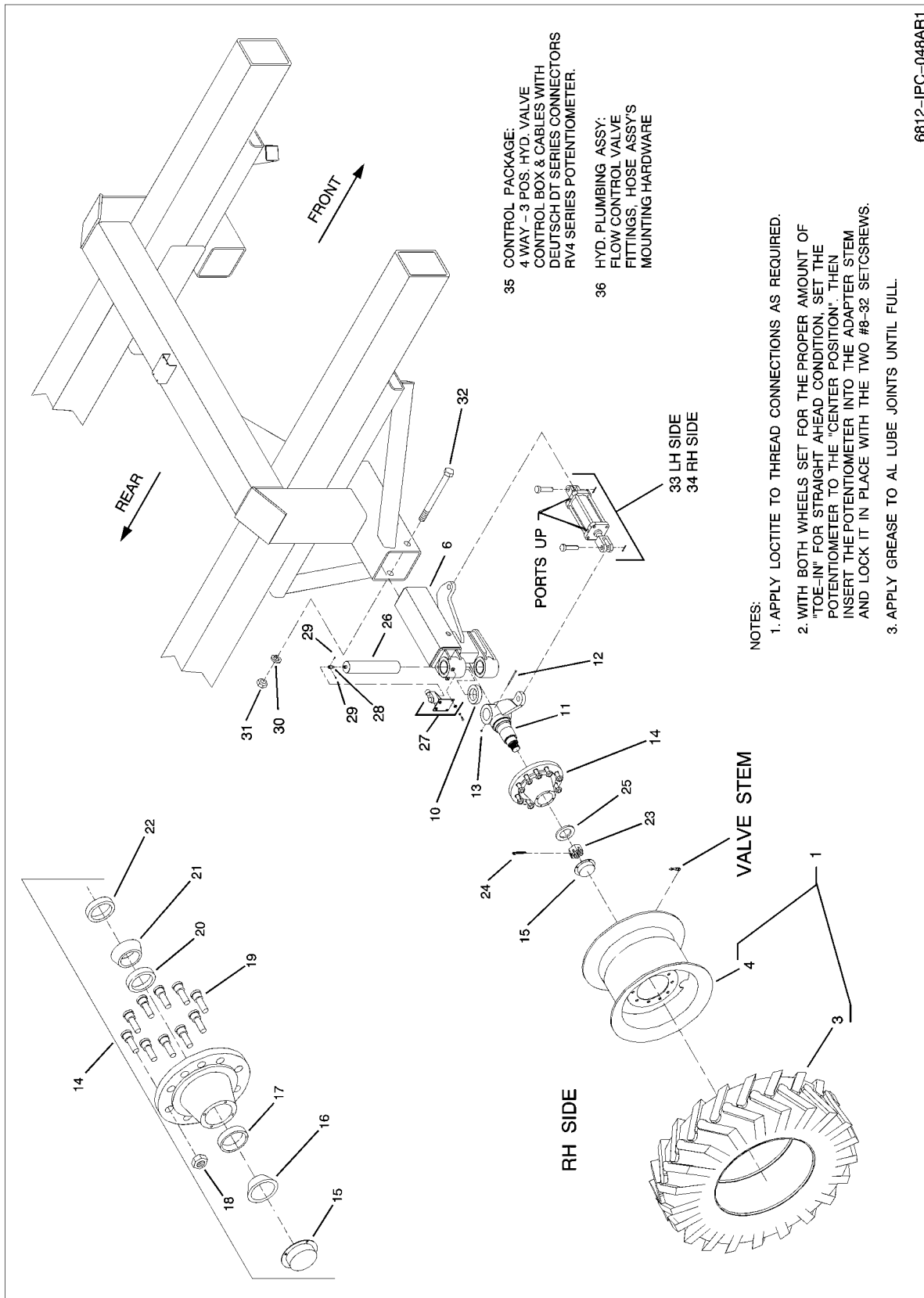
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CARRIER WHEEL ASSEMBLY

6812-IPC-031

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Carrier Wheel Assembly, 6812, (517880)	
1	525050		Bolt, HHCS 1.25-7 x 10 GR5	1
2	J14H824		Nut, Hex 1.25-7 GR5	1
3	E829047		Washer, Lock 1.25 x 2-0.05 x 31	1
4	522050		Wheel 32 x 21, 10-13.19, 11.05	1
5	521920		Tire, 24.5-32, 12 Ply, S AT	1
6	524980		Wheel and Tire Assembly (RH)	1
6A	524990		Wheel and Tire Assembly (LH)	1
7	519410		Spindle Wldt, 6812 BH	1
8	525000		Axle Assembly, Fixed 6812 BH	1
9	522060		* Hub Assembly, 10 Bolt	1
10	522110		* * Grease Seal	1
11	455720P		* * Hub Cap	1
12	455740		* * 3/4 Flange Nuts	10
13	275460		* * 3/4 Stud Bolt	10
14	522070		* * Inner Cup	1
15	522080		* * Outer Cup	1
16	522090		* * Inner Cone	1
17	522100		* * Outer Cone	1
18	I4322448		* Cotter Pin 3/8 x 3.0	1
19	522130		* Washer, Flat 0.25 x 2.25 x 4	1
20	522120		* Nut, Castle 2-12	1

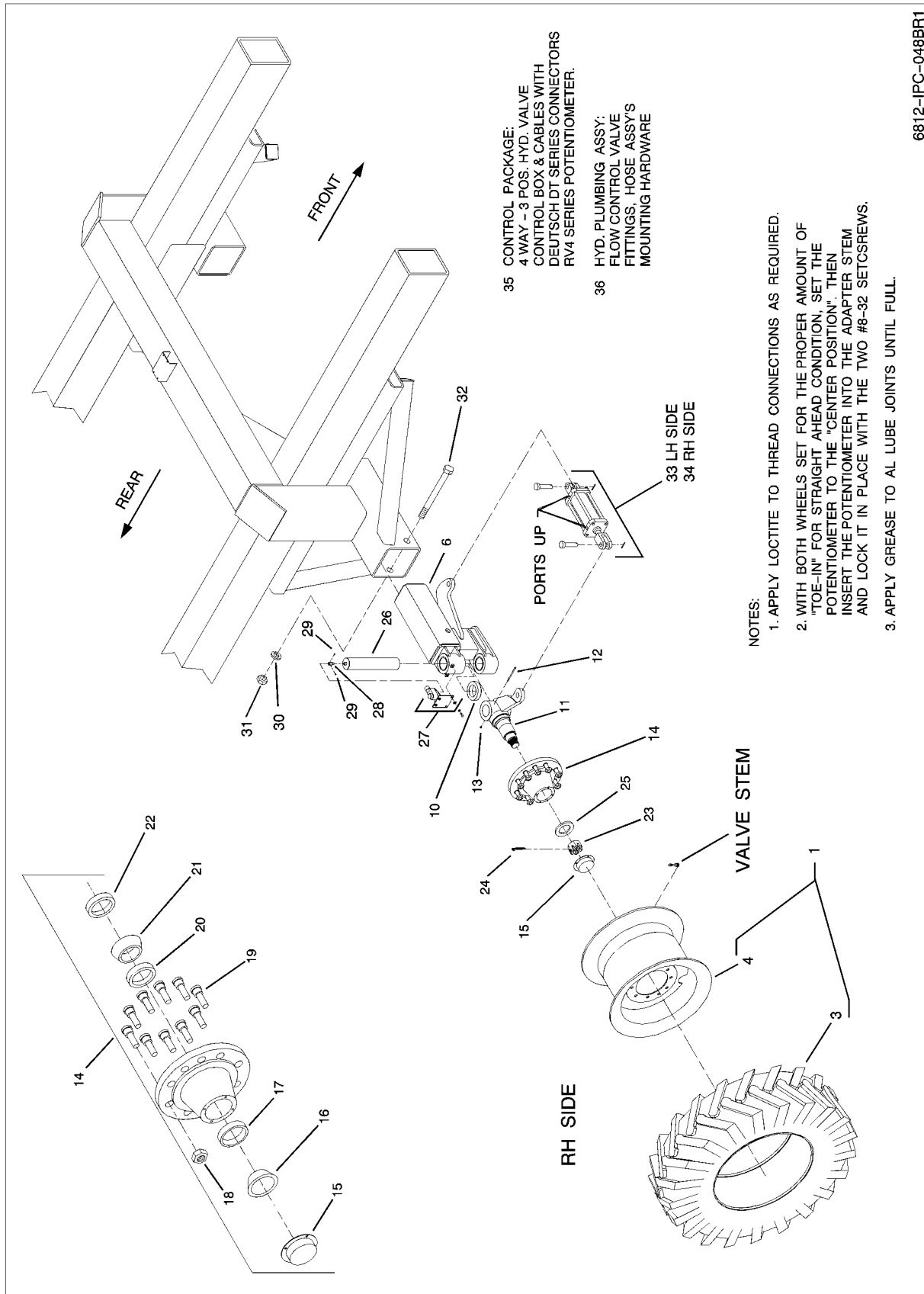
OPTIONAL STEERING ASSEMBLY - WIDE



OPTIONAL STEERING ASSEMBLY - WIDE

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
	534580	Wide Option For All Except 6R22/24 (Narrow Option For 6R22/24)	
1	524980	Wheel And Tire Assembly (RH)	1
-2	524990	Wheel And Tire Assembly (LH)	1
3	521920	* Tire, 24.5-32, 12 Ply, Super At	-
4	522050	* Wheel 32 x 21, 10-13.19, 11.05	-
-5	534650	Axle Assembly, Wide Steerable	2
6	534270	* Support Wldt, Wide Steering	1
6A	534110	* Bearing, Sleeve 3.0 ID X 3.5 OD X 4L	2
-7	534770	* Plate, Mounting	1
-8	005900	* Bolt, HHCS 5/16-18 X 1	2
-9	023620	* Washer, Lock 5/16	2
10	534210	* Bearing, 3.0 Ball Thrust	1
11	534160	* Spindle Wldt, 6812 Steer Axle	1
12	E672045	* Bolt, HHCS 1/2-13 X 5-1/2 GR5 ZN	1
13	127890	* Nut, Lock 1/2-13 GR5 CAD – 2 Way	1
14	534650	Hub Assembly, 10 Bolt	1
15	455720P	* Hub Cap	1
16	522090	* Outer Cone	1
17	522080	* Outer Cup	1
18	455740	* 3/4 Flange Nut	10
19	275460	* 3/4 Stud Bolt	10
20	522070	* Inner Cup	1
21	522090	* Inner Cone	1
22	522110	* Seal, Grease	1
23	522120	* Nut, Castle 2-12	1
24	I4322448	* Pin, Cotter 3/8 X 3.0	1
25	522130	* Washer, Flat 0.25 X 2.25 X 4.0	1
26	534680	* Kingpin Wldt, 3.0 Dia X 15.50	1
27	528210	Box Assembly, Steering Indicator	1
28	534690	Bar, Hex Threaded 11/16 Inch	1
29	043340	Screw, AHSS 8-32 X 3/8 PL	2
30	E829047	Washer, Lock 1 1/4	2
31	J14H824	Nut, Hex 1 1/4-7 GR5 ZN	2
32	525050	Bolt, HHCS 1 1/4-7 X 10, GR 5 ZN	2
33	515360	Cylinder, Hyd, 3.50 B X 1.25 R X 8.00 Str	1
34	515370	Cylinder, Hyd, 3.75 B X 1.38 R X 8.00 Str	1
-35	527980	Control Package	1
-36	528190	Components, Hydraulic Plumbing	1
-37	T01512	Loctite, Threadlocker 271	AR

OPTIONAL STEERING ASSEMBLY - NARROW

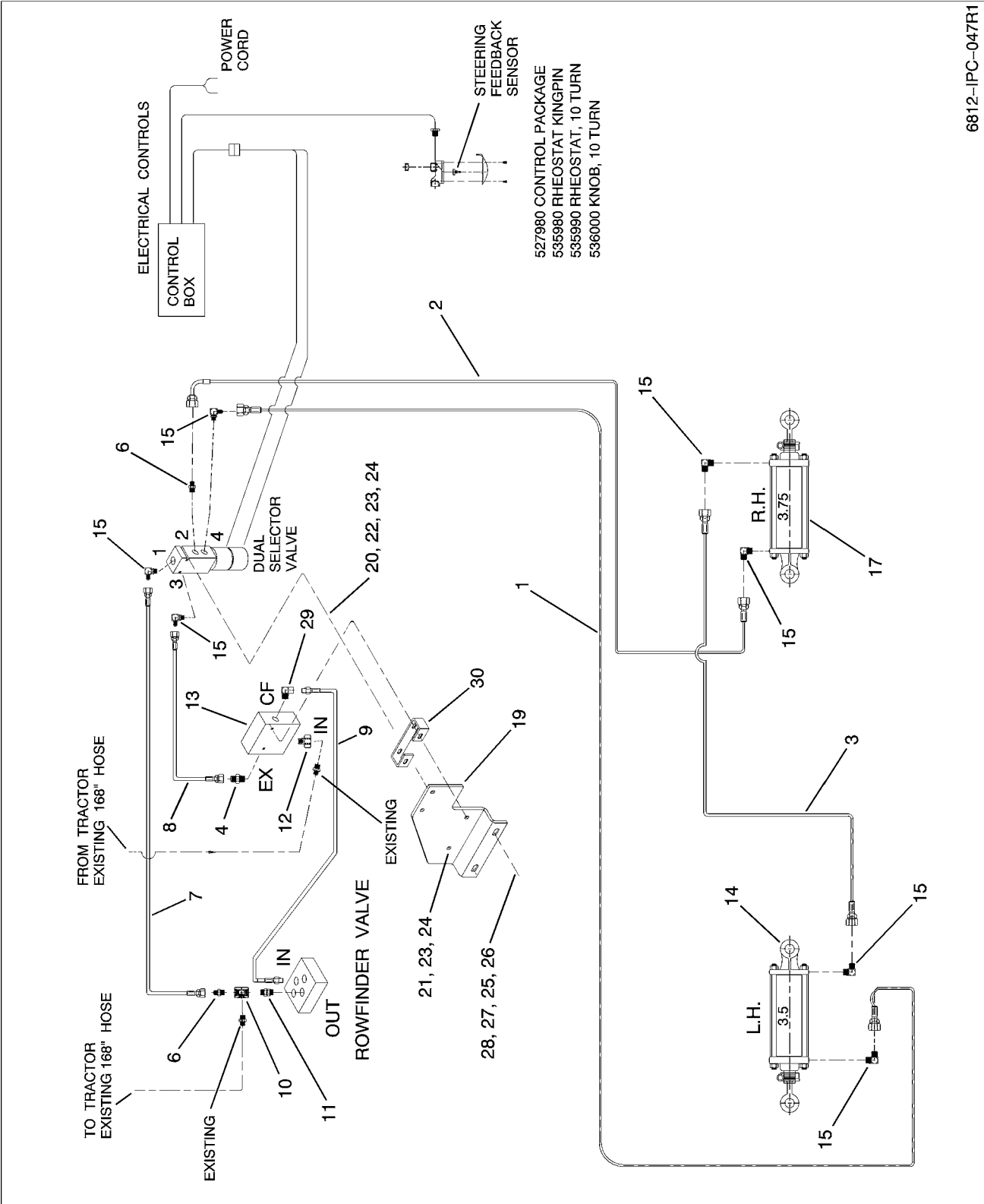


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OPTIONAL STEERING ASSEMBLY - NARROW

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	534570		Narrow Option For All For 6R22/24	
-2	527960		Wheel And Tire Assembly (RH)	1
3	527950		Wheel And Tire Assembly (LH)	1
	527930		* Tire, 24.5-32, 12 Ply, Super At	-
4	527940		* Wheel 32 x 21, 10-13.19, 11.05	-
-5	534640		Axle Assembly, Wide Steerable	2
6	534220		* Support Wldt, Wide Steering	1
	534110		* Bearing Sleeve, 3 ID X 35 OD X 42	2
-7	534770		* Plate, Mounting	1
-8	005900		* Bolt, HHCS 5/16-18 X 1	2
-9	023620		* Washer, Lock 5/16	2
10	534210		* Bearing, 3.0 Ball Thrust	1
11	534160		* Spindle Wldt, 6812 Steer Axle	1
12	E672045		* Bolt, HHCS 1/2-13 X 5-1/2 GR5 ZN	1
13	127890		* Nut, Lock 1/2-13 GR5 CAD – 2 Way	1
14	522060		Hub Assembly, 10 Bolt	1
15	455720P		* Hub Cap	1
16	522100		* Outer Cone	1
17	522080		* Outer Cup	1
18	455740		* 3/4 Flange Nut	10
19	275460		* 3/4 Stud Bolt	10
20	522070		* Inner Cup	1
21	522090		* Inner Cone	1
22	522110		* Seal, Grease	1
23	522120		* Nut, Castle 2-12	1
24	I4322448		* Pin, Cotter 3/8 X 3.0	1
25	522130		* Washer, Flat 0.25 X 2.25 X 4.0	1
26	534680		* Kingpin Wldt, 3.0 Dia X 15.50	1
27	528210		Box Assembly, Steering Indicator	1
28	534690		Bar, Hex Threaded 11/16 Inch	1
29	043340		Screw, AHSS 8-32 X 3/8 PL	2
30	E829047		Washer, Lock 1 1/4	2
31	J14H824		Nut, Hex 1 1/4-7 GR5 ZN	2
32	525050		Bolt, HHCS 1 1/4-7 X 10, GR 5 ZN	2
33	515360		Cylinder, Hyd, 3.50 B X 1.25 R X 8.00 Str	1
34	515370		Cylinder, Hyd, 3.75 B X 1.38 R X 8.00 Str	1
-35	527980		Control Package	1
-36	528190		Components, Hydraulic Plumbing	1
-37	T01512		Loctite, Threadlocker 271	AR

HYDRAULIC STEERING COMPONENTS



HYDRAULIC STEERING COMPONENTS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
		Hydraulic Steering Components, 6812, (528190)	
1	528110	Hose, Hyd 1/4 x 340	1
2	528120	Hose, Hyd 1/4 x 251	1
3	528130	Hose, Hyd 1/4 x 168	1
4	528140	Fitting, Hyd St 1/2P-#6JIC	1
6	528160	Fitting, Hyd Str-3/40R-#6JIC	2
7	528170	Hose, Hyd 1/4 x 30	1
8	528180	Hose, Hyd 1/4 x 23	1
9	288630	Hose, Hyd 1/2 x 36	1
10	JN132040	Adapter, Hyd Tee – 3/4 OR	1
11	JAN131153	Connector Assy – 3/4 OR	1
12	423800	Fitting, Hyd St 1/2PM-3/4 ORF	1
13	006300	Flow Control, Full Range	1
14	515360	Cylinder, Hyd. 3.50B x 8 Inch Str., Seq	AR
15	I2185128	Fitting, Hyd. 90 3/4 OR- #6 JIC	7
17	515370	Cylinder, Hyd. 3.75B x 8 Inch Str., Seq	AR
19	528260	Brkt, Valves, Steering	1
20	E672006	Bolt, HHSC 1/4-20 x 2	2
21	031560	Bolt, HHCS 1/4-20 x 2-1/2	2
22	023260	Washer, Flat	6
23	027660	Nut, Hex 1/4-20	6
24	029440	Washer, Lock	6
25	021180	Washer, Lock	2
26	027260	Nut, Hex 3/8-16	2
27	021190	Washer, Flat	2
28	J03H1558	Bolt, CRG 3/8-16 x 1-1/2	2
29	166230	Elbow 90 St, 1/2 NPT	1
30	531230	Bracket, Valve Mtg	1
31	531240	Angle, Rheost Prot	1
32	-	Bolt, CRG 5/16-18 x 1	2
33	-	Bolt, HHCS 1/4-20 x 1	2
34	-	Nut, Hex Flg Lk 5/16-18	2

SAFETY LIGHTS

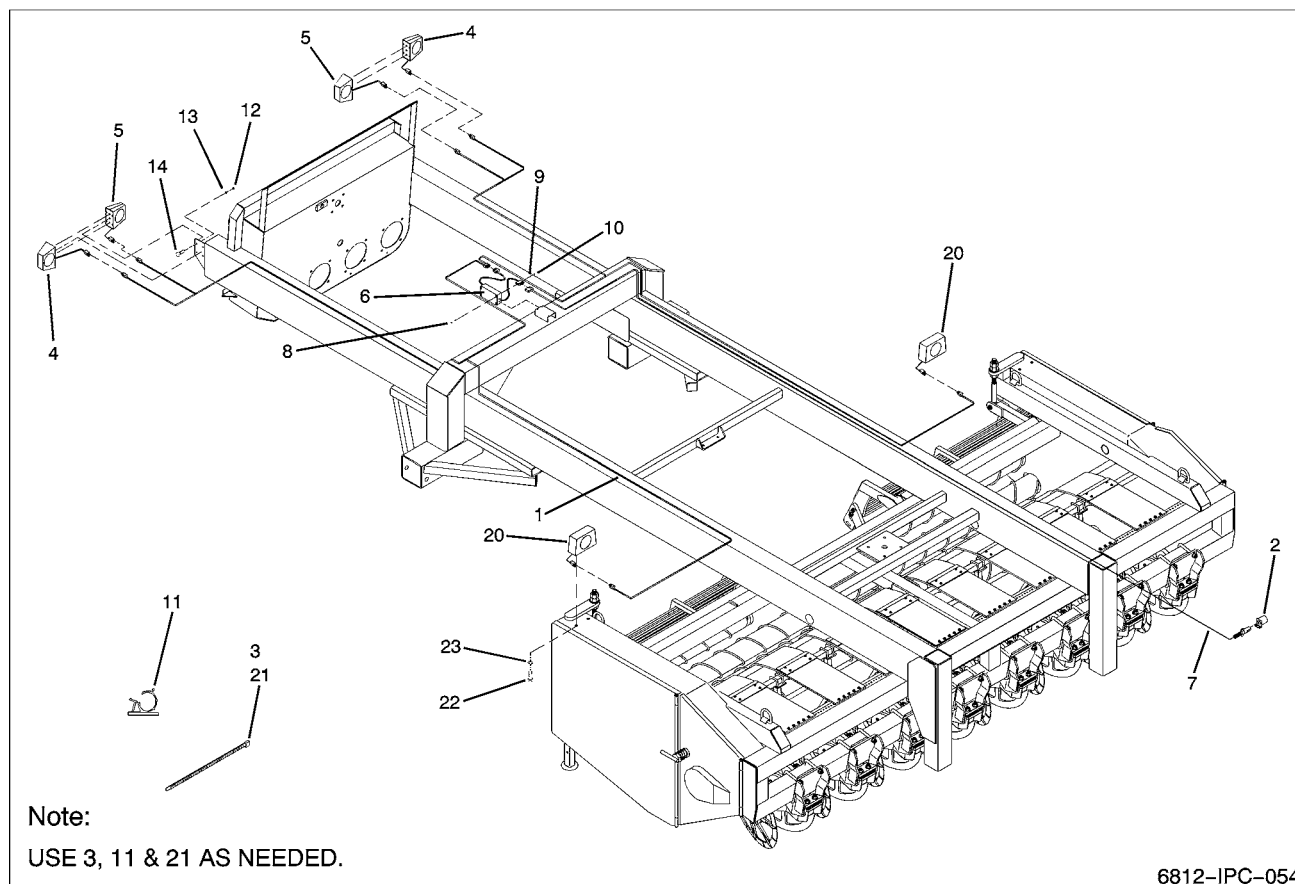
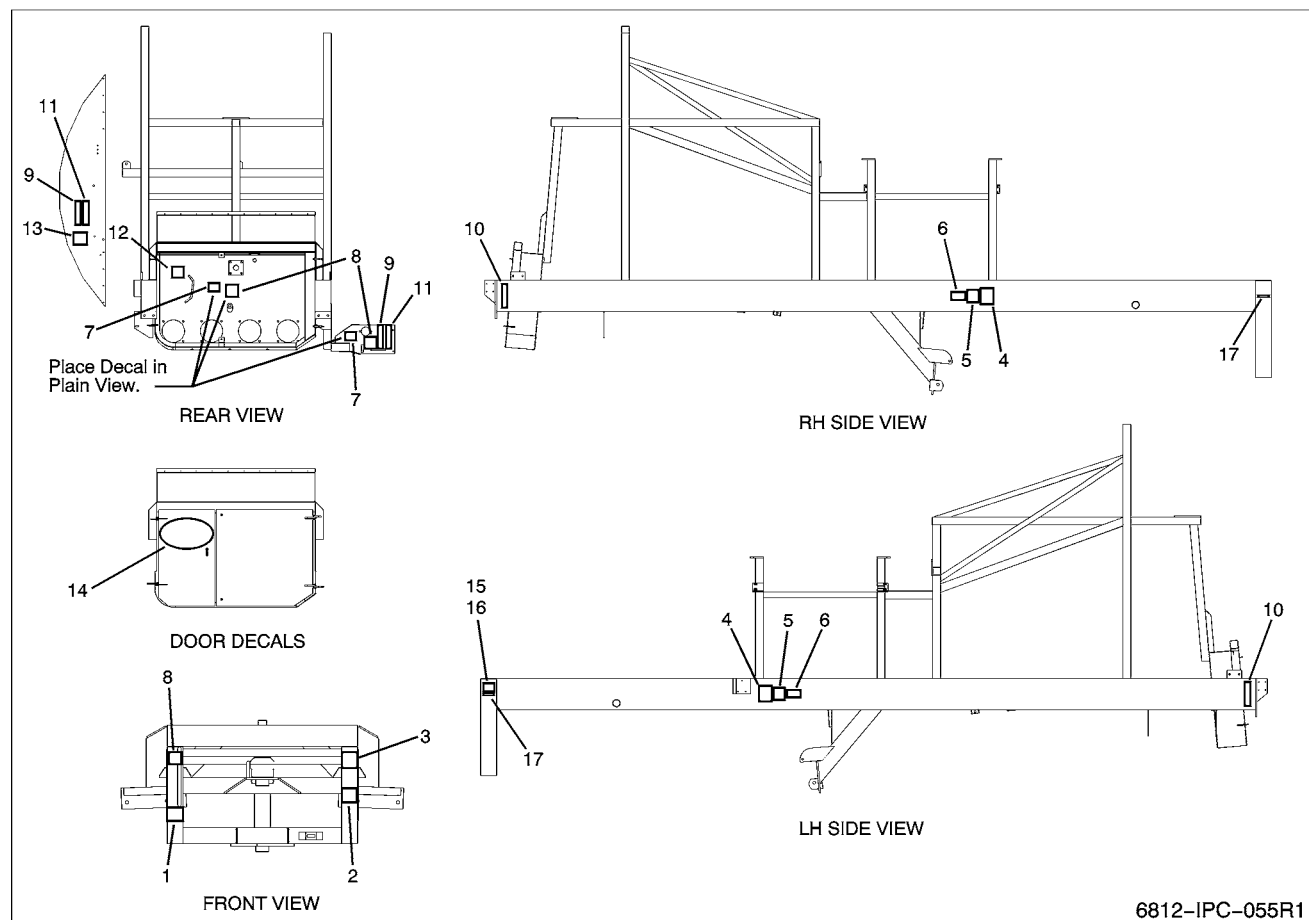


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	526780		Safety Lights, 6812, (531070)	1
2	JPT1296		Harness, Wishbone	1
3	149670		Bracket, Storing Holder	20
4	476510		Tie, 3/16 x 11 Cable	2
5	476520		Lamp Assembly, Amber	2
6	476540		Lamp Assembly, Red Rear	1
7	476570		Converter, AG Safety Light	1
8	476640		Harness, PRI. Safety Lights	4
9	120600		Bolt, Hex Mach 10-24 x 1-1/2	4
10	120590		Washer, Lock 10 x 21/64 x 3/64	4
11	036890		Nut, Hex 10-24	25
12	027660		Clip, Plastic Loop, Adhesive Back	8
13	029440		Nut, Hex 1/4-20	8
14	223540		Washer, Lock 1/4	8
	526770		Bolt, HHCS 1/4-20 x 1-3/4	1
20	476510		Dealer Installed Light Kit	2
21	149670		* Lamp Assembly, Amber	10
22	042960		* Tie, 3/16 x 11 Cable	4
23	029440		* Bolt, HHCS 1/4-20 x 1	4
			* Washer, Lock 1/4	4

HARVESTER DECALS

6812-IPC-055R1

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
				*	*	
		Harvester Decals, 6812, (530810)				
1	345420	Decal, Rowfinder Instructions				1
2	346310	Decal, Warning High Pressure Fluid				1
3	368040	Decal, Caution Safety Instructions				1
4	467400	Decal, Warning Flying Object				2
5	467410	Decal, Danger Rotating Roll				2
6	467420	Decal, Warning Riders Falling				2
7	467430	Decal, Danger Shield Missing				2
8	467450	Decal, Warning Moving Part				1
9	476450	Tape, Red Reflector				2
10	476460	Tape, Yellow Reflector				2
11	476470	Tape, Red-Orange Reflector				2
12	289500	Decal, Spring Length				1
13	510730	Decal, Warning Ferris Wheel				1
14	519480	Decal, Art's-Way Logo				1
15	355500	Tag, Serial Number				1
16	204510	Nail, 1/4 Grip				4
17	133420	Patent Pending				2

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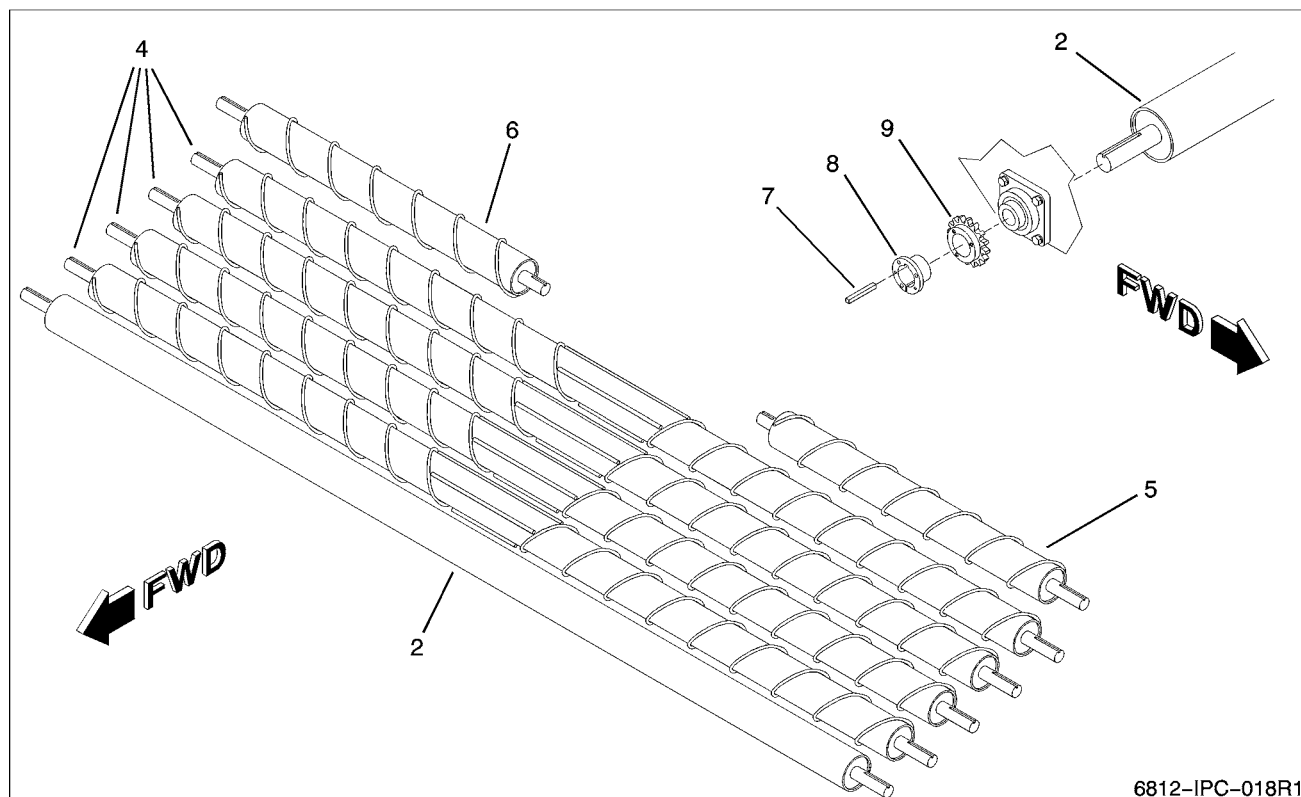
SECTION 2: HEAD ASSEMBLIES

6 Row 22/24 (6R22/24)

6 Row 28/30 AND 8 Row 22 (6R28/30, 8R22)

8 Row 28/30 (8R28/30)

12 Row 22 (12R22)

ROLLER GROUPING – SMOOTH AND GRABROLL (6R22/24)

6812-IPC-018R1

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
-1	525740	Roller Grouping, Smooth Head	1
2	527160	* Roll Wldt, Smooth 136.5	1
-3	525810	Grabroll Grouping, Steel Head	1
4	527130	* Roll Weld, Conveyor Steel (#1thru #4)	4
5	527140	* Roll Weld, Diverter LH	1
6	527150	* Roll Weld, Diverter RH	1
7	167920	* Key Sq 3/8 X 2-1/2	1
8	288070	* Bushing, Split Taper QD SK	1
9	P99646	* Sprocket, 80SK17	1

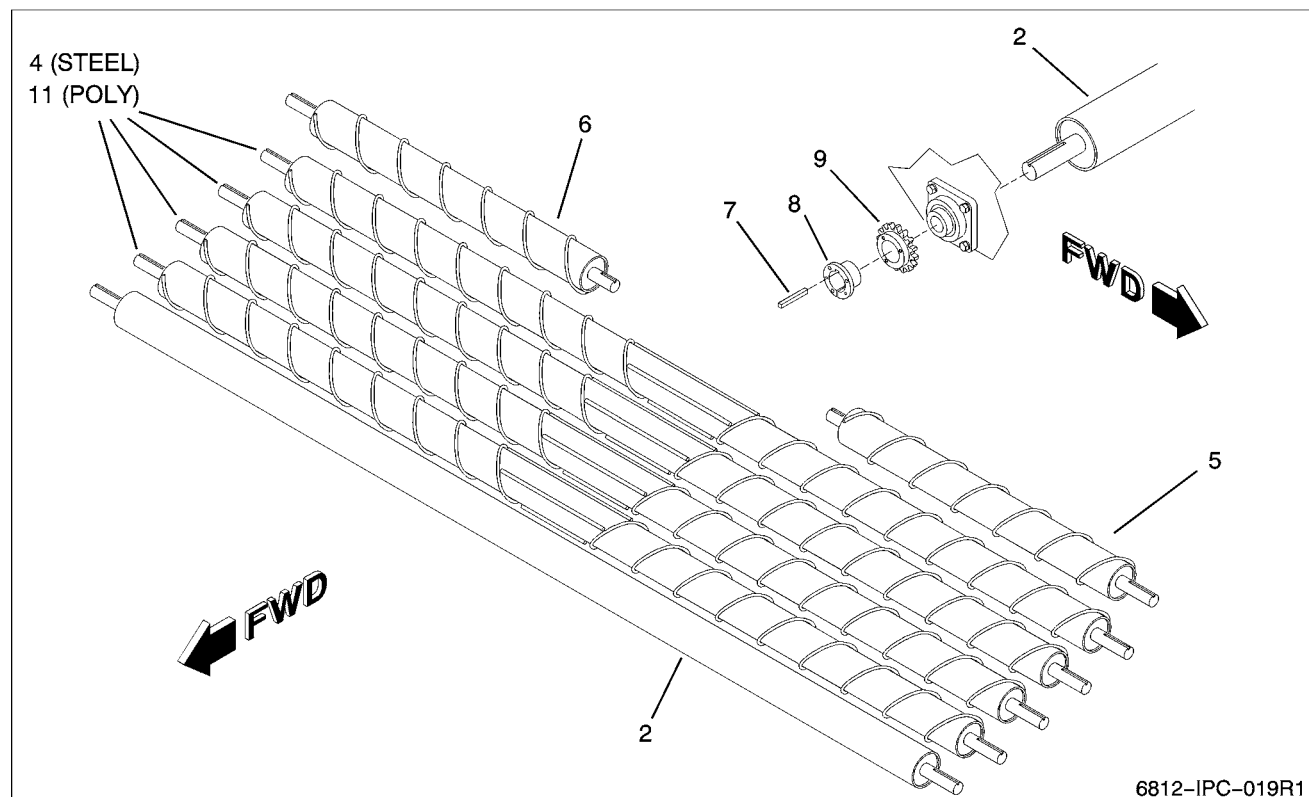
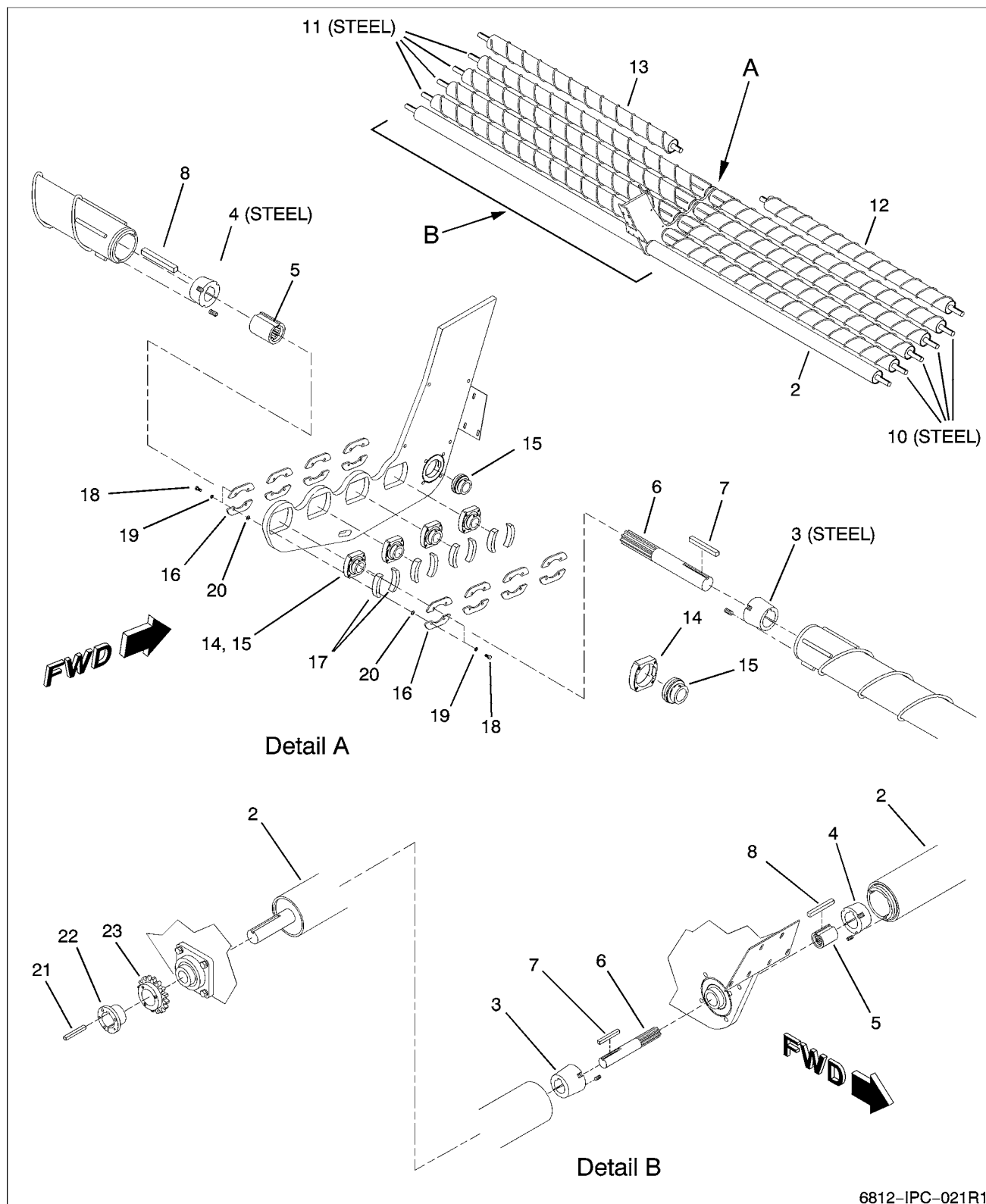
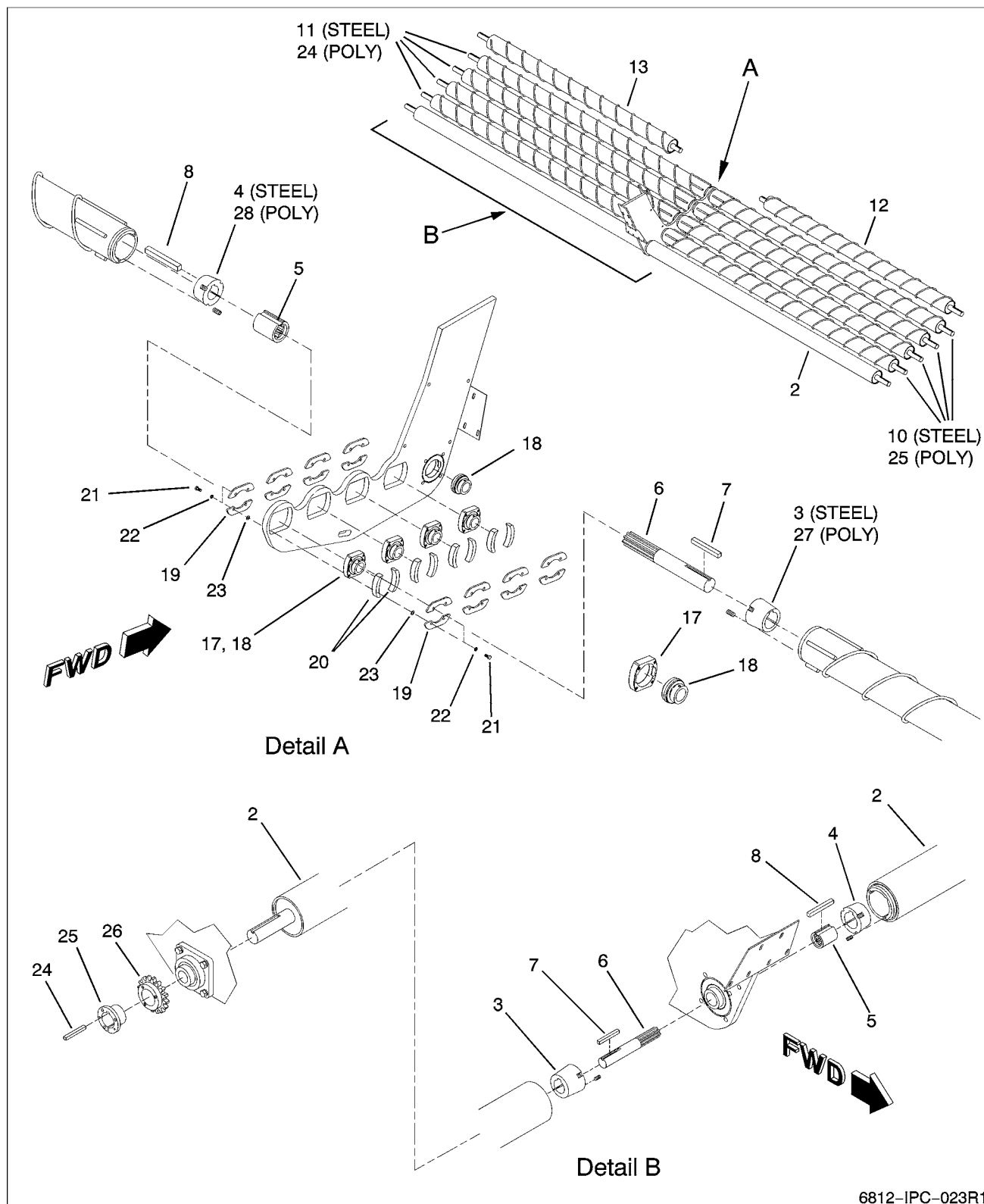
ROLLER GROUPING – SMOOTH AND GRABROLL (6R28/30, 8R22)

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		*	*	*	*	
-1	525750	Roller Grouping, Smooth				1
2	528030	* Roll Wldt, Smooth, 170.5				1
-3	525820	Grabroll Grouping, Steel				1
4	521870	* Roll Wldt, Conv. Steel (#1 thru #4)				4
5	521890	* Roll Wldt, Diverter Steel LH				1
6	521900	* Roll Wldt, Diverter Steel RH				1
7	167920	* Key Sq 3/8 x 2-1/2				1
8	288070	* Bushing, Split Taper QD SK				1
9	P99646	* Sprocket, 80SK17				1
-10	525850	Grabroll Grouping, Poly				1
11	525870	* Roll Wldt, Conveyor Poly (#1 thru #4)				4

ROLLER GROUPING – SMOOTH AND GRABROLL (8R28/30)

ROLLER GROUPING – SMOOTH AND GRABROLL (8R28/30)

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
-1	525760		Roller Grouping, Smooth Head	
2	527110		* Roll Wldt, Smooth, 6.62 OD	2
3	524370		Bushing, Taper Lock 3535 1-3/4 Bore 3/8 KW (Smooth And Steel)	5
4	527380		Bushing, Taper lock 3535 2-3/4 Bore 5/8 KW (Smooth And Steel)	5
5	524390		Sleeve, Shaft 1-3/4-27 Spl ID x 2.75 OD 5/8 KW	5
6	524400		Shaft, 1-3/4 Dia 3/8 KW 1-3/4-27 Spl x 10.00	5
7	030380		Key, Square 3/8 x 3	5
8	524150		Key, Square 5/8 x 3	5
-9	525830		Grabroll Grouping, Steel	
10	527070		* Roll Wldt, Conveyor Steel LH (#1 thru #4)	4
11	527080		* Roll Wldt, Conveyor Steel RH (#1 thru #4)	4
12	527090		* Roll Wldt, Diverter LH	1
13	527100		* Roll Wldt, Diverter RH	1
14	533850		Holder, Brg Ctr Cushioned	4
15	522920		Bearing, Ball 1-3/4 SOD	5
16	533870		Plate, Cushion Side Retain	16
17	533900		Cushion, Ctr Brg Half Moon	8
18	022420		Bolt, HHCS 3/8-16 X 3/4	32
19	021180		Washer, Lock 3/8	32
20	I120394		Washer, Flat 3/8 SAE	32
21	167920		Key Sq 3/8 X 2-1/2	1
22	288070		Bushing, Split Taper Q1	1
23	E741066		Sprocket, 80Q18	1

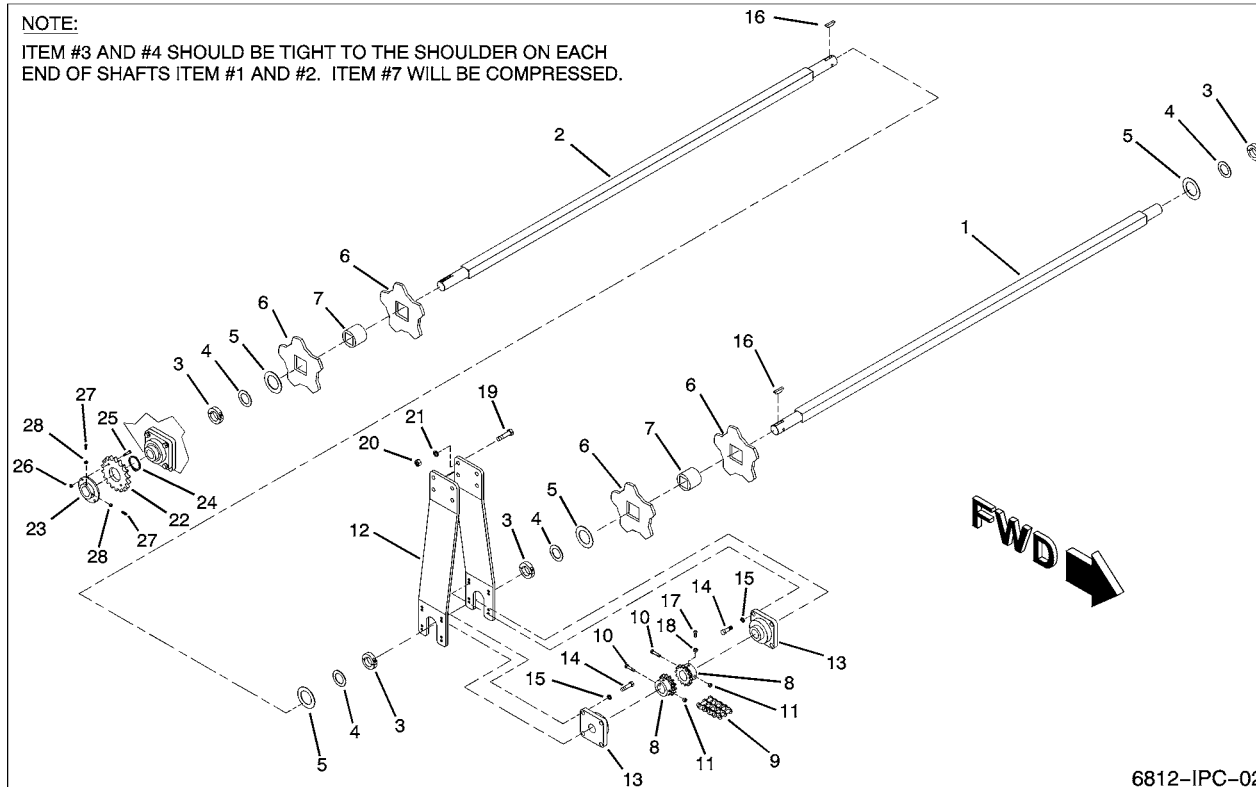
ROLLER GROUPING – SMOOTH AND GRABROLL (12R22)

ROLLER GROUPING - SMOOTH AND GRABROLL (12R22)

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
-1	525770		Roller Grouping, Smooth Head	
2	527120		* Roll Wldt, Smooth, 6.62 OD x 127.5	2
3	524370		Bushing, Taper Lock 3535 1-3/4 Bore 3/8 KW (Smooth And Steel)	5
4	524380		Bushing, Taper Lock 3535 2-3/4 Bore 5/8 KW (Smooth And Steel)	5
5	524390		Sleeve, Shaft 1-3/4-27 Spl ID x 2.75 OD 5/8 KW	5
6	524400		Shaft, 1-3/4 Dia 3/8 KW 1-3/4-27Spl x 10.00	5
7	030380		Key, Square 3/8 x 3.00	5
8	524150		Key, Square 5/8 x 3.00	5
-9	525840		Grabroll Grouping, Steel	
10	527010		* Roll Wldt, Conveyor Steel LH (#1 thru #4)	4
11	527020		* Roll Wldt, Conveyor Steel RH (#1 thru #4)	4
12	527030		Roll Wldt, Diverter LH	1
13	527040		Roll Wldt, Diverter RH	1
14	533850		Holder, Brg Ctr Cushioned	4
15	522920		Bearing, Ball 1-3/4 SOD	5
16	533870		Plate, Cushion Side Retain	16
17	533900		Cushion, Ctr Brg Half Moon	8
18	022420		Bolt, HHCS 3/8-16 X 3/4	32
19	021180		Washer, Lock 3/8	32
20	I120394		Washer, Flat 3/8 SAE	32
21	167920		Key Sq 3/8 X 2-1/2	1
22	288070		Bushing, Split Taper Q1	1
23	E741066		Sprocket, 80Q18	1
24	525860		Grabroll Grouping, Poly	
25	525880		* Roll Wldt, Conveyor Poly LH (#1 thru #4)	4
26	525890		* Roll Wldt, Conveyor Poly RH (#1 thru #4)	4
27	524350		Bushing, Taper Lock 1-3/4 Bore 3/8 KW (Poly)	4
27	524360		Bushing, Taper Lock 2-3/4 Bore 5/8 KW (Poly)	4

ROLLER GROUPING – STAR ROLLER (6R28/30, 8R22)**NOTE:**

ITEM #3 AND #4 SHOULD BE TIGHT TO THE SHOULDER ON EACH END OF SHAFTS ITEM #1 AND #2. ITEM #7 WILL BE COMPRESSED.



6812-IPC-020R1

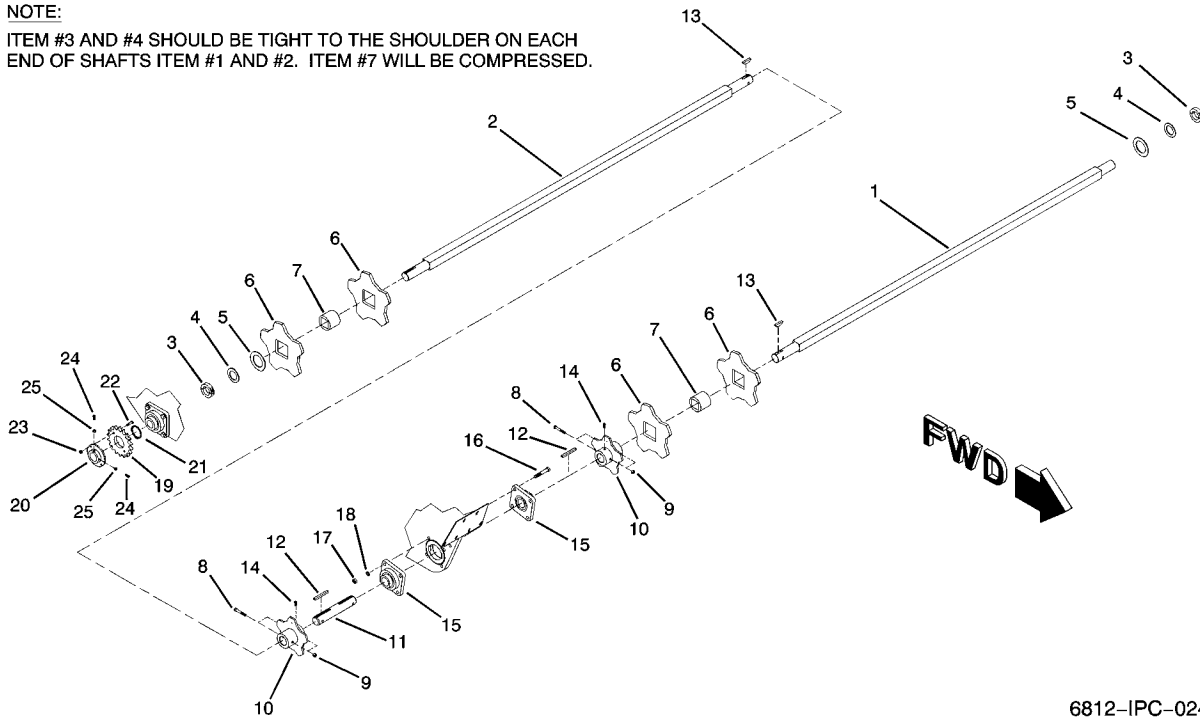
FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	525780		Roller Grouping, Star 6R28/30 And 8R22	
2	524190		Shaft, LH Star 1.75 X 89.00	1
3	524200		Shaft, RH Star 1.75 X 91.53	1
4	287700		Lock Collar, Split 1.75	4
5	E126034		Bushing, Mach 1.88 X 2.88 X 0.13	4
6	E126201		Bushing, Mach 2.5 X 3.87 X 0.134	4
7	287570		Plate, Star 8.0 Dia	56
8	287600		Spacer, Rubber	54
9	287610		Sprocket, H60B14 1.78 Bore	2
10	163770		Chain, 60-2 14P	1
11	340360		Bolt, HHCS 3/8-16 X 3-1/2	2
12	I359783C1		Nut, Lock 3/8 Hex	2
13	520630		Mount Wldt. Ctr Brg Mtg	1
14	522960		Bearing, Flg 4.H 1.75	2
15	014770		Bolt, HHCS 1/2-13 X 1-1/2	8
16	005370		Washer, Lock 1/2	8
17	231950		Key, Woodruff 1222-1 3/8	2
18	R61566		Screw, SQHSS 3/8-16 X 3/4	2
19	I124829		Nut, Jam 3/8-16 Hex	2
20	023110		Bolt, HHCS 5/8-11 X 2-1/2	8
21	I124589		Nut, Hex 5/8-11	8
22	020440		Washer, Lock 5/8	8
23	532450		Sprocket, Plate RC80-A18T	1

ROLLER GROUPING – STAR ROLLER (6R28/30, 8R22)

FIG ITEM	PART NUMBER	1 2 3 4 * * * * NOMENCLATURE	UNITS PER ASSY
23	532460	Hub Wldt., Shear 1.75 ID	1
24	040290	Ring, Retainer	1
25	025760	Bolt, HHCS 5/16-18 X 1-1/2	2
26	025670	Nut, Lock 5/16-18	2
27	039730	Screw, SQHSS 5/16-18 X 1	2
28	033500	Nut, Jam 5/16-18 Hex	2

ROLLER GROUPING – STAR ROLLER (8R28/30)**NOTE:**

ITEM #3 AND #4 SHOULD BE TIGHT TO THE SHOULDER ON EACH END OF SHAFTS ITEM #1 AND #2. ITEM #7 WILL BE COMPRESSED.

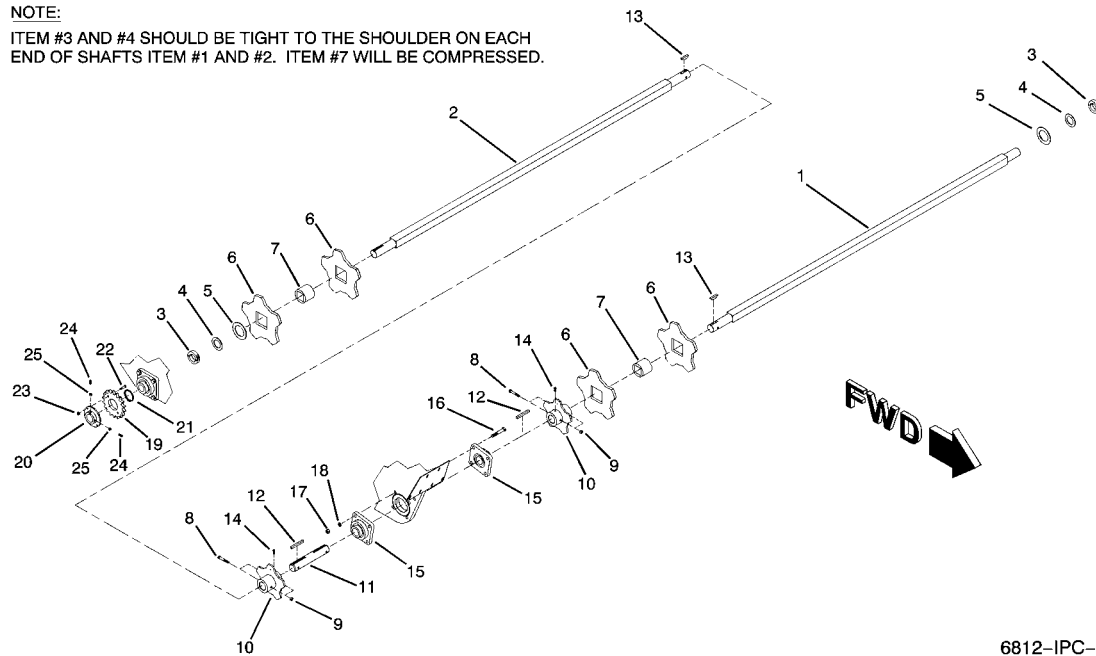


6812-IPC-024-1R1

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
	525790	Roller Grouping, Star Roller 8R28/30 Head	1
1	524210	* Shaft, LH Star Roll 1.75 x 118.00	1
2	524220	* Shaft, RH Star Roll 1.75 x 120.53 Drive	1
3	287700	* Lock Collar, Split 1.75 Bore	2
4	E126034	* Bushing, Mach 1.88 x 2-88 x 0.130	2
5	E126201	* Bushing, Mach 2.50 x 3.87 x 0.134	2
6	287570	* Plate, Star 8.0 Dia	76
7	287600	* Spacer, Rubber	74
8	340360	* Bolt, HHCS 3/8-16 X 3-1/2	4
9	I359783C1	* Nut, Lock 3/8 Hex	4
10	532170	* Coupler & Star Wldt, Shaft	2
11	524140	* Shaft, Ctr 1.75 Dia x 10.00	1
12	036940	* Key, Square 3/8 x 3-1/2	2
13	231950	* Key, Woodruff (1222-1) 3/8	2
14	R61566	* Screw, SQHSS 3/8-16 x 3/4	2
15	522960	* Bearing, FLG	2
16	041410	* Bolt, HHCS 1/2-13 X 3-1/4 Gr5 Zn	4
17	005360	* Nut, Hex 1/2-13 Gr5 Zn	4
18	005370	* Washer, Lock 1/2	4
19	532450	* Sprocket, Plate RC80-A18T	1
20	532460	* Hub Wldt, Shear 1.75 ID	1
21	040290	* Ring, Retainer	1
22	025760	* Bolt, HHCS 5/16-18 X 1-1/2	2
23	025670	* Nut, Lock 5/16-18	2
24	039730	* Screw, SQHSS 5/16-18 X 1	2
25	033500	* Nut, Jam 5/16-18 Hex	2

ROLLER GROUPING – STAR ROLLER (12R22)**NOTE:**

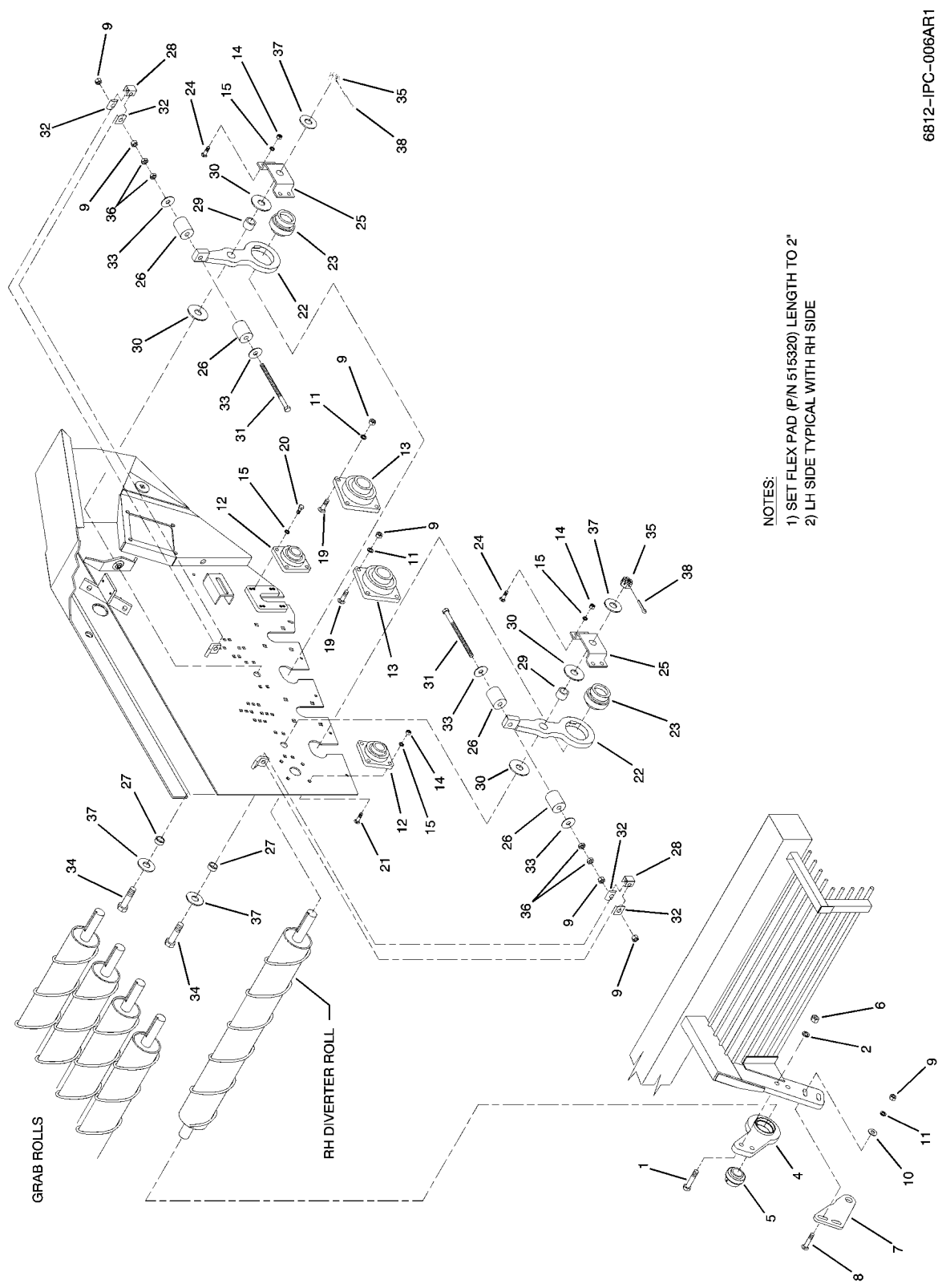
ITEM #3 AND #4 SHOULD BE TIGHT TO THE SHOULDER ON EACH
END OF SHAFTS ITEM #1 AND #2. ITEM #7 WILL BE COMPRESSED.



6812-IPC-024R1

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		*	*	*	*	
1	525800	Roller Grouping, Star Head				1
2	524230	* Shaft, LH Star Roll 1.75 x 129.50				1
3	287700	* Shaft, RH Star Roll 1.75 x 134.75 Drive				1
		* Lock Collar, Split 1.75 Bore				2
4	E126034	* Bushing, Mach 1.88 x 2-88 x 0.130				2
5	E126201	* Bushing, Mach 2.50 x 3.87 x 0.134				2
6	287570	* Plate, Star 8.0 Dia				88
7	287600	* Spacer, Rubber				86
8	340360	* Bolt, HHCS 3/8-16 x 3-1/2				4
9	I359783C1	* Nut, Lock 3/8 Hex				4
10	532170	* Coupler & Star Wldt, Shaft				2
11	524140	* Shaft, Ctr 1.75 Dia x 10.00				1
12	036940	* Key, Square 3/8 x 3-1/2				2
13	231950	* Key, Woodruff (1222-1) 3/8				2
14	R61566	* Screw, SQHSS 3/8-16 x 3/4				2
15	522960	* Bearing, FLG 4H 1.75				2
16	041410	* Bolt, HHCS 1/2-13 X 3-1/4				4
17	005360	* Nut, Hex 1/2-13				4
18	005370	* Washer, Lock 1/2				4
19	532450	* Sprocket, Plate RC80-A18T				1
20	532460	* Hub Wldt, Shear 1.75 ID				1
21	040290	* Ring, Retainer				1
22	025760	* Bolt, HHCS 5/16-18 X 1-1/2				2
23	025670	* Nut, Lock 5/16-18				2
24	039730	* Screw, SQHSS 5/16-18 X 1				2
25	033500	* Nut, Jam 5/16-18 Hex				2

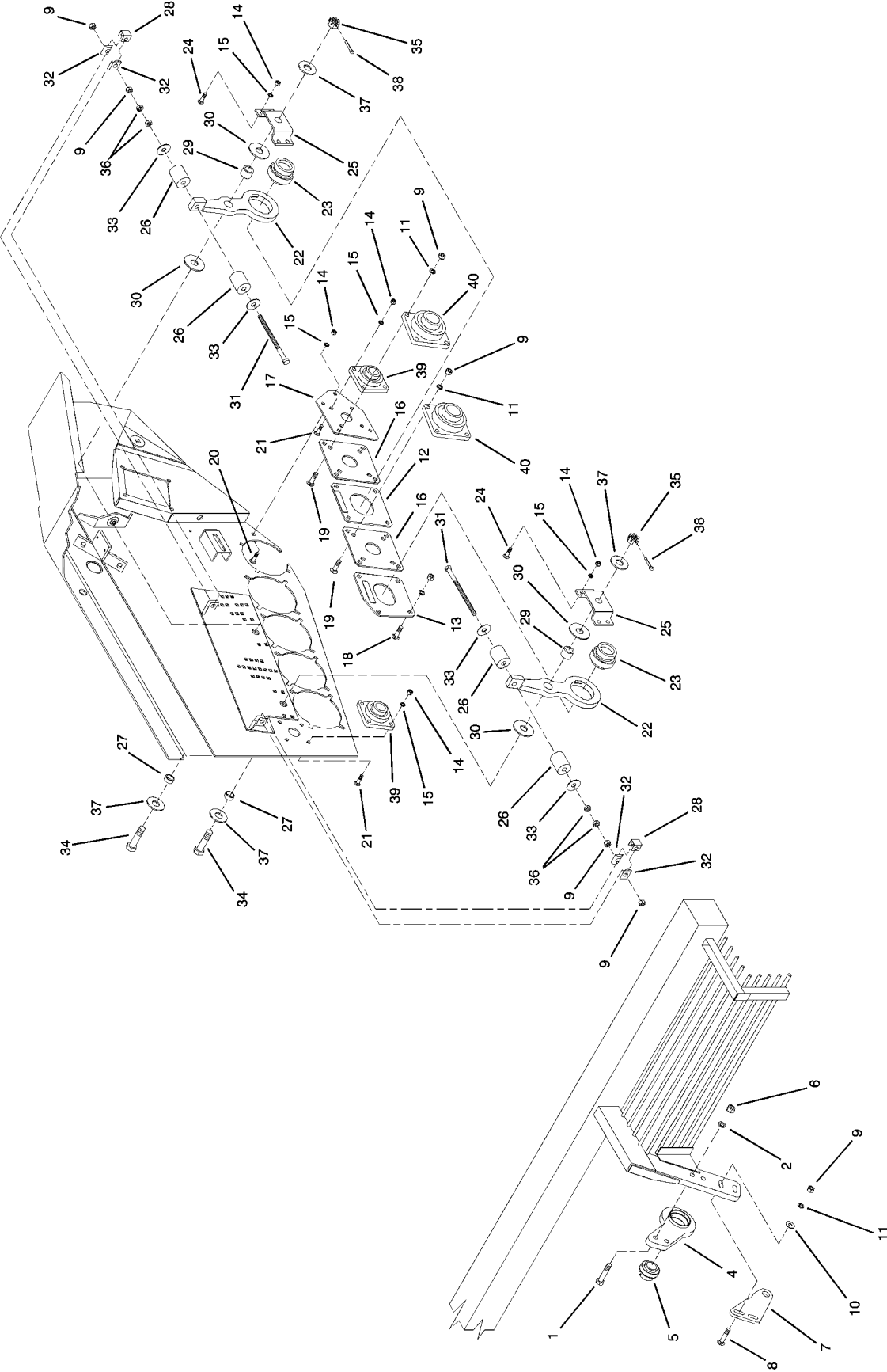
GRABROLL MOUNTING (6R22/24, 6R28/30, 8R22)



GRABROLL MOUNTING (6R22/24, 6R28/30, 8R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	990570	Bolt, HHCS 3/4-10 X 3	4
2	036800	Washer, Lock, 3/4	4
-3	519220	Arm Wldt, LH Diverter Support (Not Shown)	1
4	519230	Arm Wldt, RH Diverter Support (Shown)	1
5	522920	Bearing, Ball 1-3/4 SOD	2
6	J14H794	Nut, Hex, 3/4-10	3
7	531700	Plate, Conveyor Front Support	2
8	275710	Bolt, CRG 5/8-11 X 3	2
9	I124589	Nut, Hex 5/8-11	28
10	020430	Washer, Flat, 5/8 STD	4
11	020440	Washer, Lock, 5/8	20
12	522960	Bearing, FLG, 4H, 1.75	4
13	522970	Bearing, FLG, 4H, 2.00	4
14	005360	Nut, Hex 1/2-13	24
15	005370	Washer, Lock 1/2	32
19	287880	Bolt, CRG, 5/8-11 x 2 SSN	16
20	014770	Bolt, HHCS 1/2-13 x 1-1/2	8
21	463750	Bolt, CRG, 1/2-13 x 2 SSN	8
22	346110	Arm Wldt, Grabroll Drive	4
23	522930	Bearing, Insert 2.0 SOD	4
24	156850	Bolt, CRG 1/2-13 X 1-1/2 SSN	16
25	264770	Bracket, Grabroll Arm	4
26	515320	Pad, Flex 1.75 X 0.75 X 2.38 L	8
27	344250	Bushing, Steel 1 X 1-1/4 X 1/2	4
28	344310	Clip, Retainer Drive	4
29	264730	Bushing, Grabroll Drive	4
30	264740	Washer, Hardened 1.06 X 3 X 0.105	8
31	J08H4753	Bolt, HHCS 5/8-11 X 10-1/2 SP	4
32	264780	Washer, Oval 5/8	8
33	340310	Washer, Flat 0.66 X 2.0 X 0.25	8
34	344270	Bolt, HHCS 1-14 X 3-1/2 Drill	4
35	344280	Nut, Slotted 1-14	4
36	344630	Nut, Jam 5/8-11 Hex	8
37	990720	Washer, Flat 1 STD	8
38	003950	Pin, Cotter 3/16 X 2	4

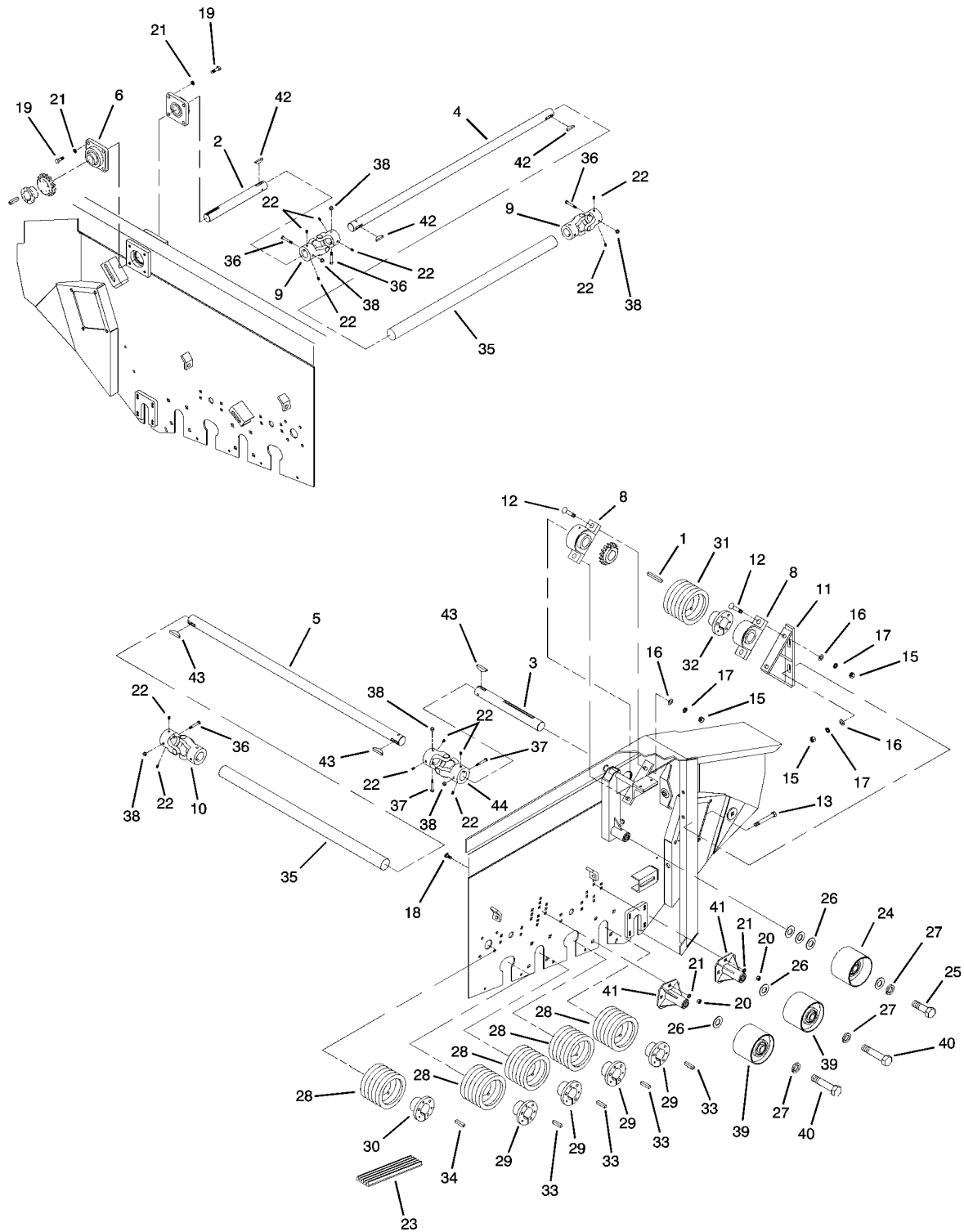
GRABROLL MOUNTING (8R28/30, 12R22)



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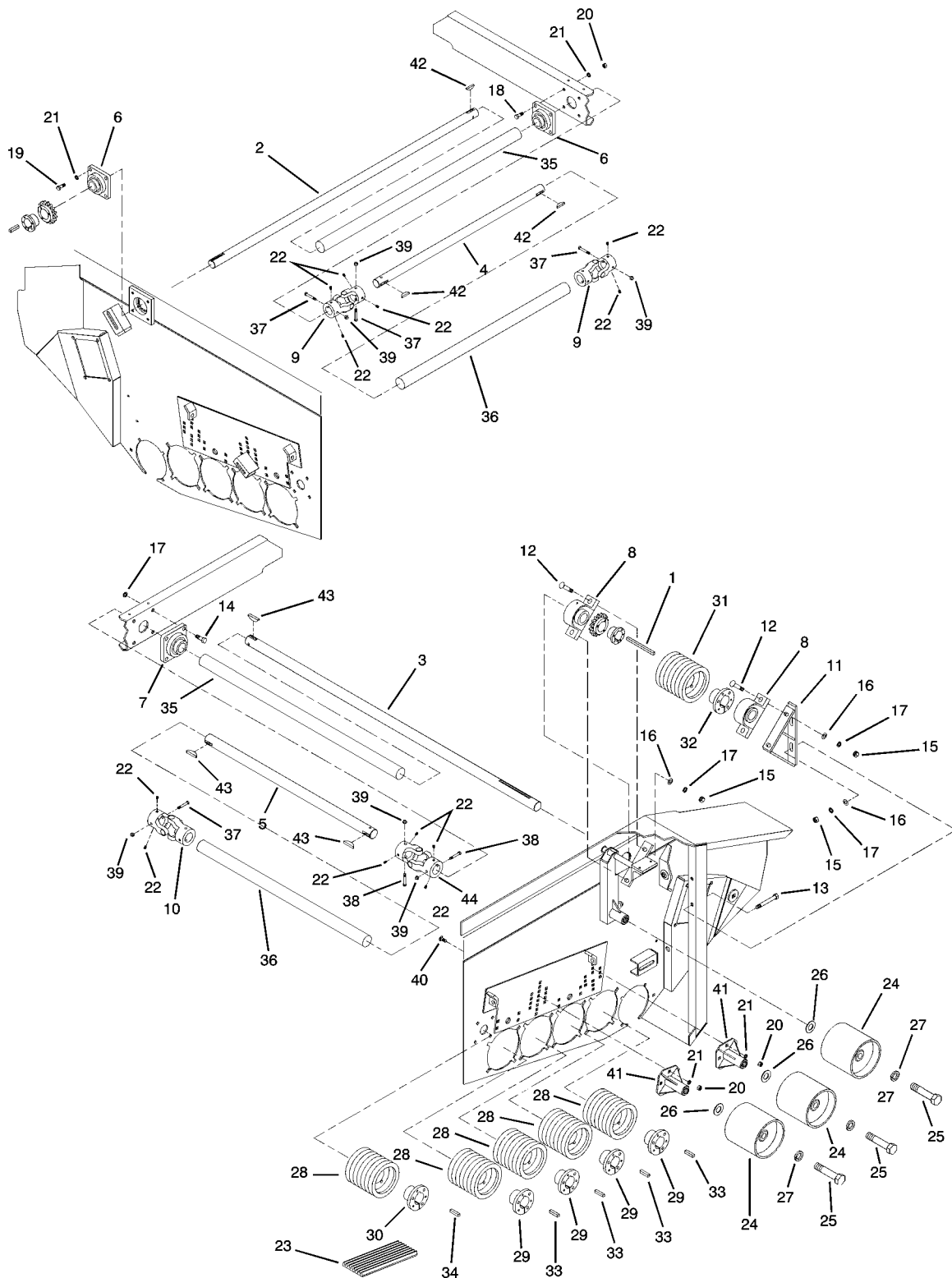
GRABROLL MOUNTING (8R28/30, 12R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	990570	Bolt, HHCS 3/4-10 X 3	4
2	036800	Washer, Lock, 3/4	4
-3	519220	Arm Wldt, LH Diverter Support (Not Shown)	1
4	519230	Arm Wldt, RH Diverter Support (Shown)	1
5	522920	Bearing, Ball 1-3/4 SOD	2
6	J14H794	Nut, Hex, 3/4-10	4
7	531700	Plate, Conveyor Front Support	2
8	275710	Bolt, CRG 5/8-11 X 3	4
9	I124589	Nut, Hex 5/8-11	60
10	020430	Washer, Flat, 5/8 STD	4
11	020440	Washer, Lock, 5/8	52
12	533180	Plate Wldt, Middle BRG Mtg	2
13	533190	Plate Wldt, Rear BRG Mtg	2
14	005360	Nut, Hex 1/2-13	40
15	005370	Washer, Lock 1/2	40
16	520700	Plate, Rear BRG Mtg	4
17	520710	Plate, Front BRG Mtg	2
18	250140	Bolt, CRG 5/8-11 X 1-1/2 Gr5 Zn	32
19	287880	Bolt, CRG, 5/8-11 x 2 SSN	16
20	014770	Bolt, HHCS 1/2-13 x 1-1/2	8
21	463750	Bolt, CRG, 1/2-13 x 2 SSN	16
22	533150	Arm Wldt, Grabroll Drive	4
23	533170	Bearing, Insert 2-7/16 SOD	4
24	156850	Bolt, CRG 1/2-13 X 1-1/2 SSN	16
25	264770	Bracket, Grabroll Arm	4
26	515320	Pad, Flex 1.75 X 0.75 X 2.38 L	8
27	344250	Bushing, Steel 1 X 1-1/4 X 1/2	4
28	344310	Clip, Retainer Drive	4
29	264730	Bushing, Grabroll Drive	4
30	264740	Washer, Hardened 1.06 X 3 X 0.105	8
31	J08H4753	Bolt, HHCS 5/8-11 X 10-1/2 SP	4
32	264780	Washer, Oval 5/8	8
33	340310	Washer, Flat 0.66 X 2.0 X 0.25	8
34	344270	Bolt, HHCS 1-14 X 3-1/2 Drill	4
35	344280	Nut, Slotted 1-14	4
36	344630	Nut, Jam 5/8-11 Hex	8
37	990720	Washer, Flat 1 STD	8
38	003950	Pin, Cotter 3/16 X 2	4
39	522960	Bearing, FLG 4H 1.75	4
40	522980	Bearing, FLG 4H 2-7/16	4

CONVEYOR ROLLER DRIVES (6R22/24, 6R28/30, 8R22)

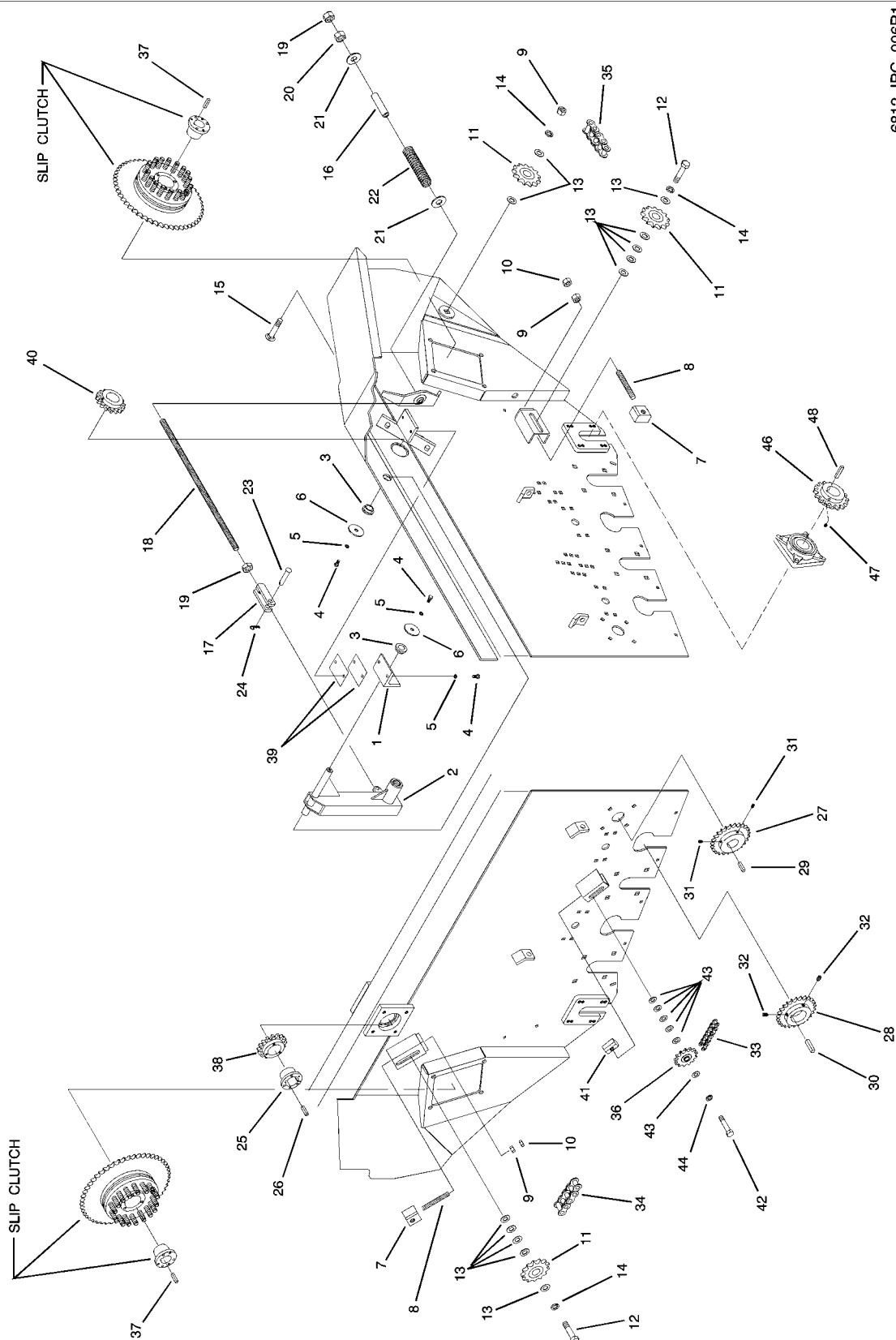
CONVEYOR ROLLER DRIVES (6R22/24, 6R28/30, 8R22)

FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	156040	Key, SQ 1/2 X 4	1
2	532620	Shaft, LH DRV Out 1.75 X 16.00	1
3	532650	Shaft, RH DRV Out 2.0 X 17.50	1
4	532640	Shaft, LH DRV In 1.75 X 55.66 (6R28/30 and 8R22)	1
4	532630	Shaft, LH DRV In 1.75 X 38.66 (6R22/24)	1
5	532670	Shaft, RH Drive In 2.0 X 58.62 (6R28/30 and 8R22)	1
5	532660	Shaft, RH DRV In 2.0 X 41.62 (6R22/24)	1
6	522960	Bearing, FLG 4H 1.75	2
8	522950	Bearing, PB 2.0	2
9	286520	U-Joint, 1-3/4 RB X 1-3/4 RB	2
10	439110	U-Joint, 1-3/4 RB X 2.0 RB	1
11	523630	Mount Wldt, Bearing, RH Drive	1
12	E096058	Bolt, CRG 5/8-11 X 2-1/2	4
13	028330	Bolt, HHCS 5/8-11 X 4-1/2	2
14	525960	Shield, Spin 2.4 X 50.0	1
15	I124589	Nut, Hex, 5/8-11	6
16	020430	Washer, Flat 5/8 STD	10
17	020440	Washer, Lock, 5/8	7
18	156850	Bolt, CRG 1/2-13 X 1-1/2 SSN	8
19	014770	Bolt, HHCS, 1/2-13 x 1-1/2	8
20	005360	Nut, Hex 1/2-13	8
21	005370	Washer, Lock Half	20
22	218660	Screw, HSSS 3/8-16 X 3/8	12
23	522220	Belt, Banded, 5-5V2000	1
24	518600	Sheave Assy, Idler, 1.25 (ID)	1
25	522610	Bolt, HHCS, 1-1/4-7 x 3-1/2	1
26	E829022	Washer, Flat, 1-1/4 SAE	10
27	E829047	Washer, Lock, 1-1/4	3
28	522160	Sheave, 8 GRV 5V, 6.3 (OD), SK	5
29	346340	Bushing, QD SK, 2.00 Bore	4
30	251220	Bushing, QD SF, 2.00 Bore	1
31	522170	Sheave, 5 GRV 5V, 7.5 (OD), SF	1
32	R37960	Bushing, QD SK, 1-3/4 Bore	1
33	R66305	Key, Square, 1/2 x 2	4
34	021530	Key, Square, 3/8 x 2	1
35	525990	Shield, Spin 2.4 X 46.5	1
36	I189304	Bolt, HHCS 3/8-16 X 3-1/4	4
37	991150	Bolt, HHCS 3/8-16 X 4	2
38	073630	Nut, Lock 3/8-16 Hex Nylon	6
39	534380	Sheave Assy, Idler, 1.25 (ID)	2
40	522860	Bolt, HHCS 1-1/4-7 X 5-1/2	2
41	533130	Mount Wldt, Idler	2
42	231950	Key, Woodruff, 3/8 X 2-3/4	3
43	498120	Key, Woodruff, 1/2 X 2-3/4	3
44	532060	U-Joint, 2.0 RB X 2.0 RB	1

CONVEYOR ROLLER DRIVES (8R28/30, 12R22)

CONVEYOR ROLLER DRIVES (8R28/30, 12R22)

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	424010		Key, Square, 1/2 X 7-1/4	1
2	532680		Shaft, LH DRV Out 1.75 X 71.66	1
3	532710		Shaft, RH DRV Out 2.0 X 78.00	1
4	532700		Shaft, LH DRV In 1.75 X 45.00 (12R22)	1
4	532690		Shaft, LH DRV In 1.75 X 29.0 (8R28/30)	1
5	532730		Shaft, RH DRV In 2.0 X 45.00 (12R22)	1
5	532720		Shaft, RH DRV In 2.0 X 29.00 (8R22/30)	1
6	522960		Bearing, FLG 4H 1.75	2
7	522970		Bearing, FLG 4H 2.00	1
8	522950		Bearing, PB, 2.00	2
9	286520		U-Joint, 1-3/4 RB X 1-3/4 RB	2
10	439110		U-Joint, 1-3/4 RB X 2.0 RB	1
11	523630		Mount Wldt, Bearing, RH Drive	1
12	E096058		Bolt, CRG 5/8-11 X 2-1/2	4
13	028330		Bolt, HHCS 5/8-11 X 4-1/2	2
14	990620		Bolt, HHCS 5/8-11 X 2	4
15	I124589		Nut, Hex 5/8-11	10
16	020430		Washer, Flat 5/8 Std	6
17	020440		Washer, Lock 5/8	10
18	023950		Bolt, HHCS 1/2-13 X 2	4
19	014770		Bolt, HHCS 1/2-13 X 1-1/2	4
20	005360		Nut, Hex 1/2-13	12
21	005370		Washer, Lock 1/2	16
22	218660		Screw, HSSS 3/8-16 X 3/8	12
23	522230		Belt, Banded 8-5V2000	1
24	520760		Sheave Assembly, Idler 1.25 ID	3
25	522860		Bolt, HHCS 1-1/4-7 X 5-1/2	3
26	E829022		Washer, Flat 1-1/4 SAE	3
27	E829047		Washer, Lock 1-1/4	3
28	522180		Sheave, 8-GRV 5V, 7.1 OD SF	5
29	522220		Bushing, QD SF, 2.44 Bore	4
30	234760		Bushing, QD SF, 1-3/4 Bore	1
31	522190		Sheave, 8-GRV 5V, 8.5 OD E	1
32	251230		Bushing, QD E 2.4 Bore	1
33	R66305		Key, SQ 1/2 X 2	4
34	021530		Key, SQ 3/8 X 2	1
35	525940		Shield, Outer Spin 2.4 X 53.5	2
36	525950		Shield, Inner Spin 2.4 X 45.0	2
37	I189304		Bolt, HHCS 3/8-16 X 3-1/4	4
38	991150		Bolt, HHCS 3/8-16 X 4	2
39	073630		Nut, Lock 3/8-16 Hex Nylon	6
40	156850		Bolt, CRG 1/2-13 X 1-1/2 SSN	8
41	533130		Mount Wldt, Idler	2
42	231950		Key, Woodruff 3/8 X 2-3/4	3
43	498120		Key, Woodruff 1/2 X 2-3/4	3
44	532060		U-Joint, 2.0 RB X 2.0 RB	1

PADDLE SHAFT AND CHAIN DRIVES (6R22/24, 6R28/30, 8R22)

PADDLE SHAFT AND CHAIN DRIVES (6R22/24, 6R28/30, 8R22)

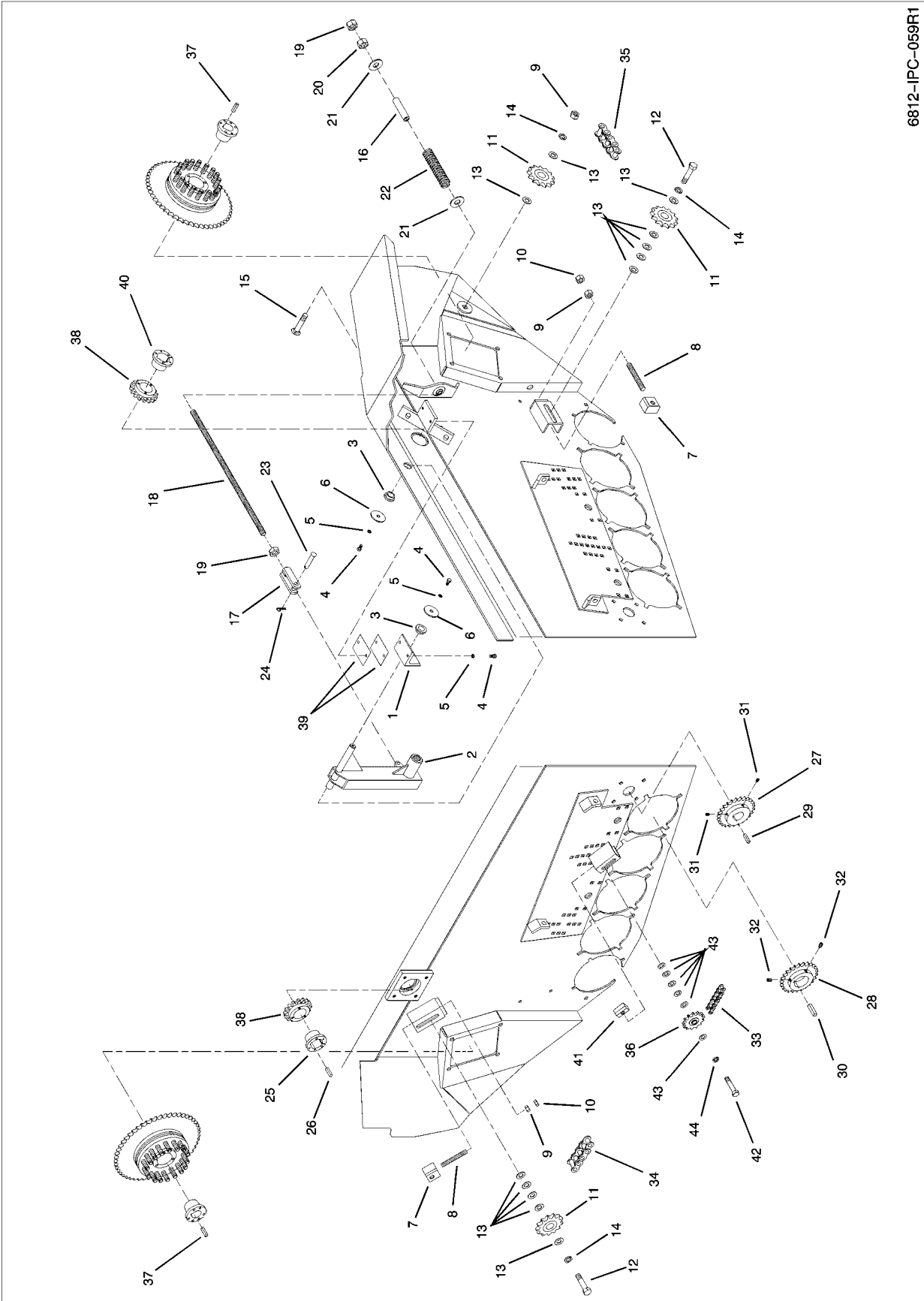
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	518060	Angle, Tensioner Arm Mtg	1
2	518160	Arm Wldt, Belt Tensioner	1
3	522600	Bushing, Oilite 1 X 1-1/4 x 3/4	2
4	012260	Bolt, HHCS 3/8-16 X 1	4
5	021180	Washer, Lock 3/8	4
6	169280	Washer, Flat 0.406 X 1.5 X 1.3	2
7	518070	Block, Idler Adjustment	2
8	518080	Rod, Threaded 3/4-10 X 5.5	2
9	J14H794	Nut, Hex 3/4-10	3
10	E552038	Nut, Jam 3/4-10 Hex	2
11	240550	Sprocket, Idler 80-12T	3
12	990830	Bolt, HHCS 3/4-10 X 3-1/2	2
13	I131017	Washer, Flat 3/4 SAE	20
14	036800	Washer, Lock, 3/4	3
15	G146921	Bolt, CRG 3/4-10 X 3	1
16	239040	Spacer, Spring Length 4.25 Inch	1
17	513841	Yoke Wldt, Threaded 1/2-13	1
18	533230	Rod, Threaded 1/2-13 X 27.0	1
19	114380	Nut, Jam 1/2-13 Hex	2
20	005360	Nut, Hex 1/2-13	1
21	I486801R1	Washer, Flat 0.531 X 2.0 X 0.25	2
22	231000	Spring, Comp. 1.62 x 7.25	1
23	1071212	Pin, Clevis 1/2 X 1-1/2	1
24	124350	Pin, Cotter 1/8 X 1-1/2	1
25	288070	Bushing, Split Taper Q1 1.75	1
26	167920	Key, Sq 3/8 X 2-1/2	1
27	523920	Sprocket, 60B25 1.75 Bore 0.375 Keyway	1
28	523930	Sprocket, 60B25 2.00 Bore 0.500 Keyway	1
29	021530	Key, Square, 3/8 x 2	1
30	R66305	Key, Square, 1/2 x 2	1
31	1070121	Screw, HSSS, 3/8-16 x 3/4 Nylon Lock BLO	2
32	532960	Chain, Roller, RC60 62 Pitches	1
34	523980	Chain, Roller, RC80 81 Pitches	1
35	523990	Chain, Roller, RC80 126 Pitches	1
36	E366013	Sprocket, Idler 60B13 Idler	1
37	030380	Key, Sq 3/8 X 3	1
38	E741067	Sprocket, 80Q15	1
39	532760	Shim, Idler Arm	1
40	531360	Sprocket, 80B15T 2.0 Bore	1

PADDLE SHAFT AND CHAIN DRIVES (6R22/24, 6R28/30, 8R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
41	518380	Slide, Idler Tensioner	1
42	990650	Bolt, HHCS 5/8-11 X 3	1
43	035210	Washer, Flat 5/8 SAE	6
44	020440	Washer, Lock 5.8	1

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PADDLE SHAFT AND CHAIN DRIVES (8R28/30, 12R22)



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ADDLE SHAFT AND CHAIN DRIVES (8R28/30, 12R22)

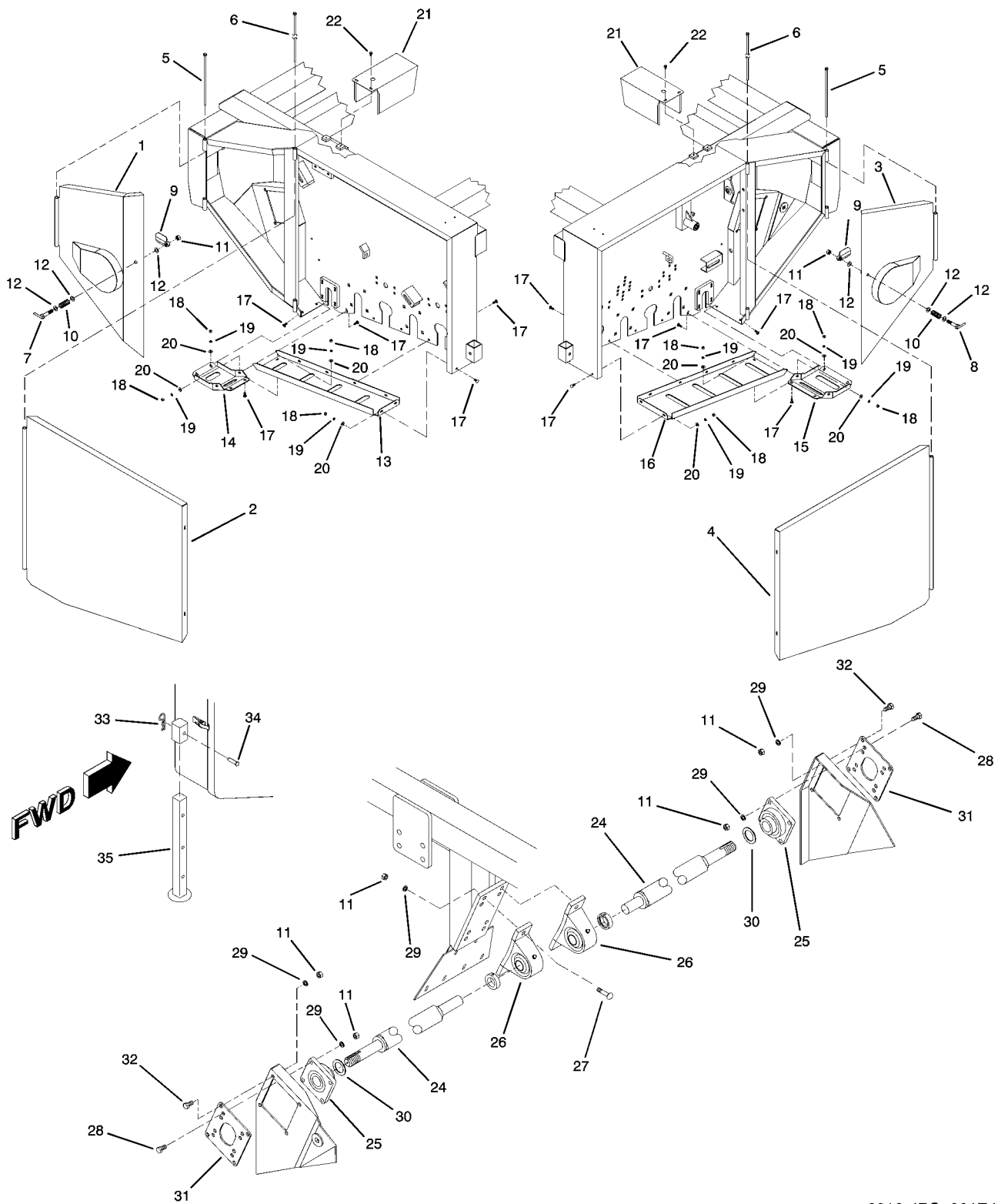
FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	518060	Angle, Tensioner Arm Mtg	1
2	520720	Arm Wldt, Belt Tensioner	1
3	522600	Bushing, Oilite 1 X 1-1/4 x 3/4	2
4	012260	Bolt, HHCS 3/8-16 X 1	4
5	021180	Washer, Lock 3/8	4
6	169280	Washer, Flat 0.406 X 1.5 X 1.3	2
7	518070	Block, Idler Adjustment	2
8	518080	Rod, Threaded 3/4-10 X 5.5	2
9	J14H794	Nut, Hex 3/4-10	3
10	E552038	Nut, Jam 3/4-10 Hex	2
11	240550	Sprocket, Idler 80-12T	3
12	990830	Bolt, HHCS 3/4-10 X 3-1/2	2
13	I131017	Washer, Flat 3/4 SAE	20
14	036800	Washer, Lock, 3/4	3
15	G146921	Bolt, CRG 3/4-10 X 3	1
16	533060	Spacer, Spring Length 6.0 Inch	1
17	513841	Yoke Wldt, Threaded 1/2-13	1
18	533230	Rod, Threaded 1/2-13 X 27.0	1
19	114380	Nut, Jam 1/2-13 Hex	2
20	005360	Nut, Hex 1/2-13	1
21	I486801R1	Washer, Flat 0.531 X 2.0 X 0.25	2
22	231000	Spring, Comp. 1.62 x 7.25	1
23	1071212	Pin, Clevis 1/2 X 1-1/2	1
24	124350	Pin, Cotter 1/8 X 1-1/2	1
25	288070	Bushing, Split Taper Q1 1.75	1
26	167920	Key, Sq 3/8 X 2-1/2	1
27	523920	Sprocket, 60B25 1.75 Bore 0.375 Keyway	1
28	523930	Sprocket, 60B25 2.00 Bore 0.500 Keyway	1
29	021530	Key, Square, 3/8 x 2	1
30	R66305	Key, Square, 1/2 x 2	1
31	1070121	Screw, HSSS, 3/8-16 x 3/4 Nylon Lock BLO	2
32	532960	Chain, Roller, RC60 62 Pitches	1
34	523980	Chain, Roller, RC80 81 Pitches	1
35	523990	Chain, Roller, RC80 126 Pitches	1
36	E366013	Sprocket, Idler 60B13 Idler	1
37	030380	Key, Sq 3/8 X 3	1
38	E741067	Sprocket, 80Q15	1
39	532760	Shim, Idler Arm	1
40	531360	Sprocket, 80B15T 2.0 Bore	1

PADDLE SHAFT AND CHAIN DRIVES (8R28/30, 12R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
41	518380	Slide, Idler Tensioner	1
42	990650	Bolt, HHCS 5/8-11 X 3	1
43	035210	Washer, Flat 5/8 SAE	6
44	020440	Washer, Lock 5.8	1

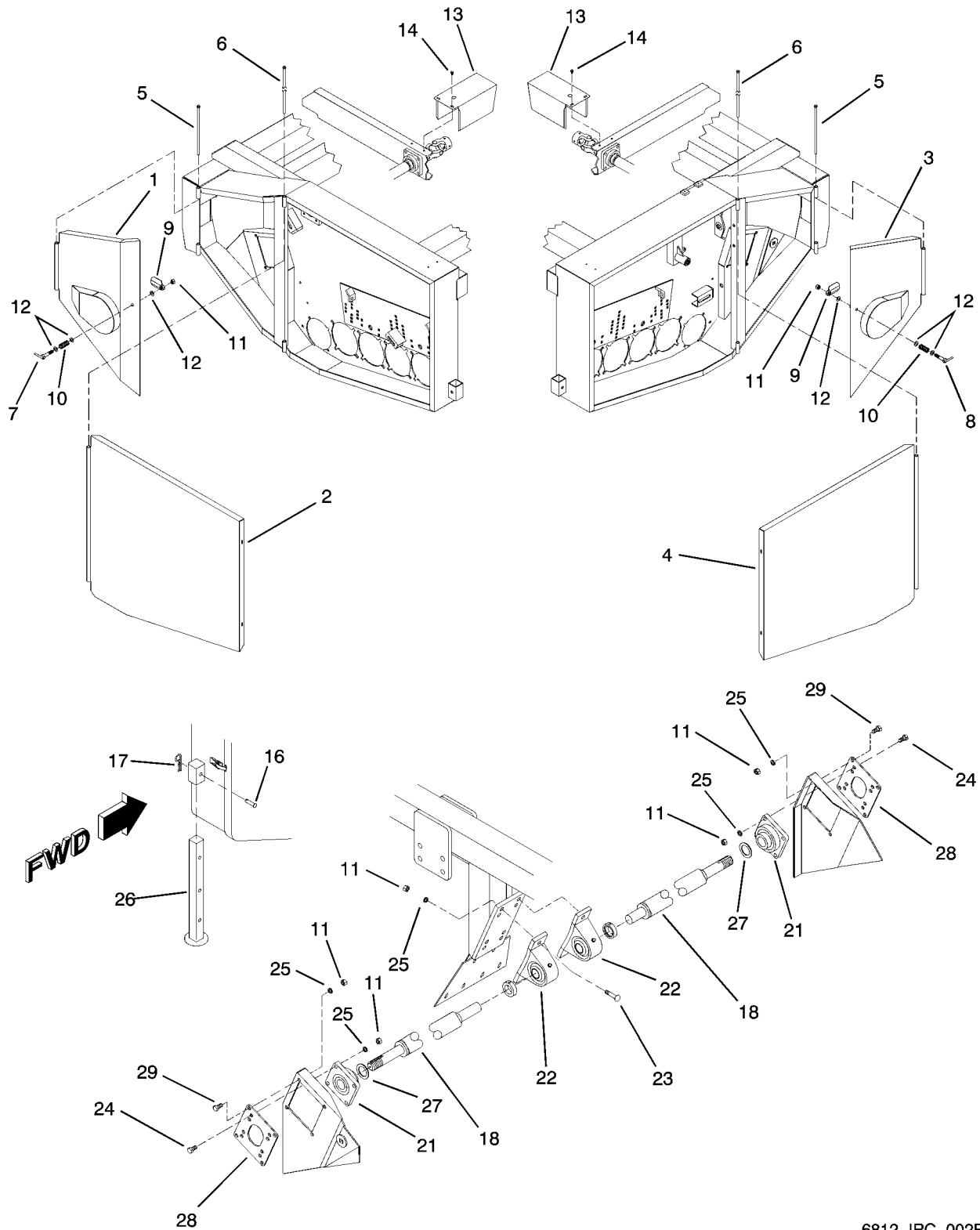
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HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS, AND STANDS (6R22/24, 6R28/30, 8R22)



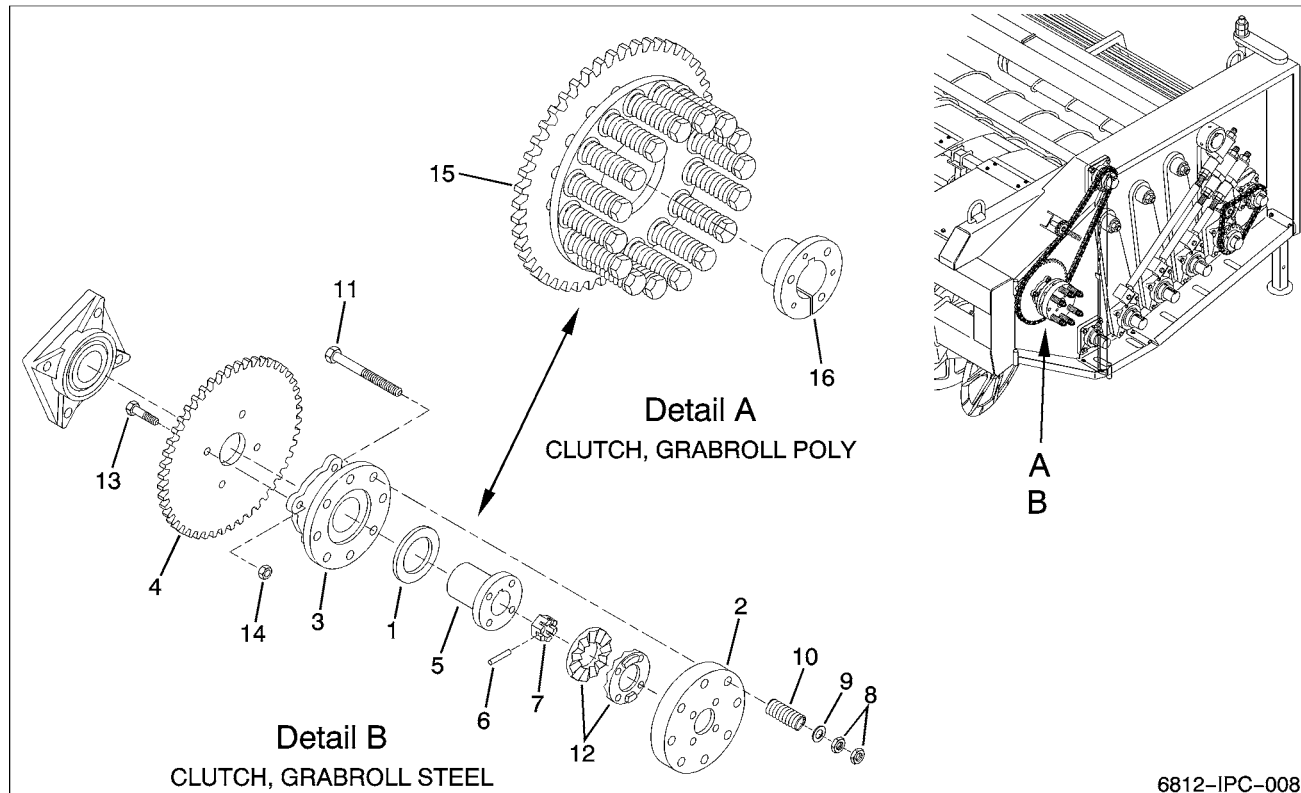
HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS, AND STANDS (6R22/24, 6R28/30, 8R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	518670	Door Wldt, Head, LH Front	1
2	518680	Door Wldt, Head, LH Rear	1
3	518690	Door Wldt, Head, RH Front	1
4	518700	Door Wldt, Head, RH Rear	1
5	518710	Pin Wldt, Front Door	2
6	518720	Pin Wldt, Rear Door	2
7	518830	Handle Wldt, Door Latch, LH, 5/8 x 4.00	1
8	518840	Handle Wldt, Door Latch, RH, 5/8 x 4-1/2	1
9	518850	Latch Wldt, Door	2
10	518900	Spring, Comp, 0.94 (OD), 14 GA x 2.00	2
11	I124589	Nut, Hex, 5/8-11 Gr5 ZN	22
12	020430	Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN	6
13	532850	Panel, Lower Middle LH	1
14	532860	Panel, Lower Rear LH	1
15	532870	Panel, Lower Middle RH	1
16	532880	Panel, Lower Rear RH	1
17	J03H1558	Bolt, CRG, 3/8-16 X 1-1/2 SSN	11
18	027260	Nut, Hex, 3/8-16	11
19	021180	Washer, Lock 3/8	11
20	021190	Washer, Flat, 3/8 STD	11
21	532740	Shield, Head Drive	2
22	JN71292	Bolt, HXHD 5/16-18 X 1/2	4
24	523200	Shaft Wldt, Paddle 94.0 (6R28/30 And 8R22)	2
24	523210	Shaft Wldt, Paddle 77.0 (6R22/24)	2
25	522970	Bearing, FLG 4H 2.0	2
26	522950	Bearing, PB 2.0	2
27	E096058	Bolt, CRG 5/16-11 X 2-1/2	4
28	990620	Bolt, HHCS 5/8-11 X 2	8
29	020440	Washer, Lock 5/8	20
30	396120	Bushing, Mach 2-1/32 X 3 X 0.13	2
31	533090	Plate, Brg Mtg	2
32	990610	Bolt, HHCS 5/8-11 X 1-1/2	8
33	E580035	Pin, Hair 1/8 X 2-3/8 Cotter	2
34	216830	Pin, Clevis 5/8 X 3	2
35	519070	Stand Wldt, Head	2

HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS AND STANDS (8R28/30, 12R22)

HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS AND STANDS (8R28/30, 12R22)

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	518670	Door Wldt, Head, LH Front	1
2	518680	Door Wldt, Head, LH Rear	1
3	518690	Door Wldt, Head, RH Front	1
4	518700	Door Wldt, Head, RH Rear	1
5	518710	Pin Wldt, Front Door	2
6	518720	Pin Wldt, Rear Door	2
7	518830	Handle Wldt, Door Latch, LH, 5/8 x 4.00	1
8	518840	Handle Wldt, Door Latch, RH, 5/8 x 4-1/2	1
9	518850	Latch Wldt, Door	2
10	518900	Spring, Comp, 0.94 (OD), 14 Ga x 2.00	2
11	I124589	Nut, Hex, 5/8-11 Gr5 ZN	22
12	020430	Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN	6
13	533370	Sheet, UHMW Ctr Head	2
14	007080	Bolt, HHCS 1/2-13 X 2-1/2	4
16	216830	Pin, Clevis 5/8 X 3	2
17	E580035	Pin, Hair 1/8 x 2-3/8 Cotter	2
18	523180	Shaft Wldt, Paddle Drive 139.00 Long (12R22)	2
18	523190	Shaft, Wldt, Paddle Drive 123.0 (8R28/30)	2
21	522970	Bearing, Flg 4H 2.0	2
22	522950	Bearing, PB 2.0	2
23	E096058	Bolt, CRG 5/8-11 X 2-1/2	4
24	990620	Bolt, HHCS 5/8-11 X 2	8
25	020440	Washer, Lock 5/8	20
26	519070	Stand Wldt, Head	2
27	396120	Bushing, MACH 2-1/32 X 3.0 X 0.13	2
28	533090	Plate, Brg Mtg	2
29	990610	Bolt, HHCS 5/8-11 X 1-1/2	8

PADDLE SHAFT CLUTCHES

6812-IPC-008

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	E126201	Bushing, Mach 2.5 x 3.87 x 0.134	2
2	411260	Flange, Spring Clutch	2
3	411410	Housing Assembly, Clutch	2
4	E740881	Sprocket, 80A45	2
5	238430	Hub Wldt, Slip Clutch	2
6	040900	Pin, Roller 3/16 x 1-5/8 ZN	2
7	042110	Nut, Slotted 1-14 Gr5 ZN Hex	2
8	1121555	Nut, Jam 5/8-11 Hex ZN Gr5	24
9	I25547R1	Washer, Flat 21/32 x 1-5/16 x 3/16 PHC	12
10	239080	Spring, Compression Slip Clutch	12
11	201660	Bolt, HHCS 5/8-11 x 6 Gr5 ZN	12
12	225040	Jaw, Hardened Slip Clutch	4
13	1770500	Bolt, HHCS 1/2-13 x 1-3/4 Gr5 ZN	8
14	I9413967	Nut, Lock 1/2-13 GrB CAD Plated Top Lock	8
15	479300	Clutch, Slip Paddle Shaft	2
-15A	511990	* Sprocket, 80A45, Hard	2
-15B	511980	* Friction Disk	11
16	288070	Bushing, Split Taper Q1 1-3/4	2

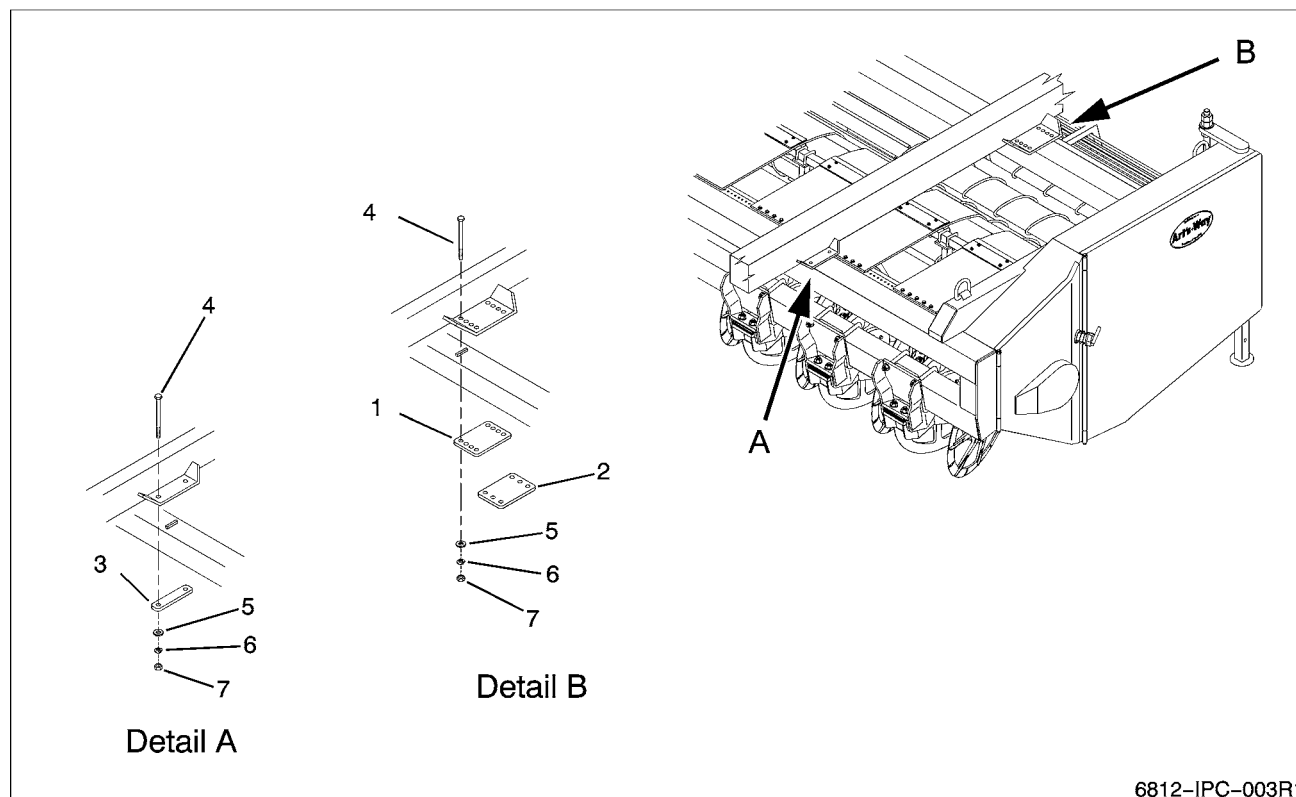
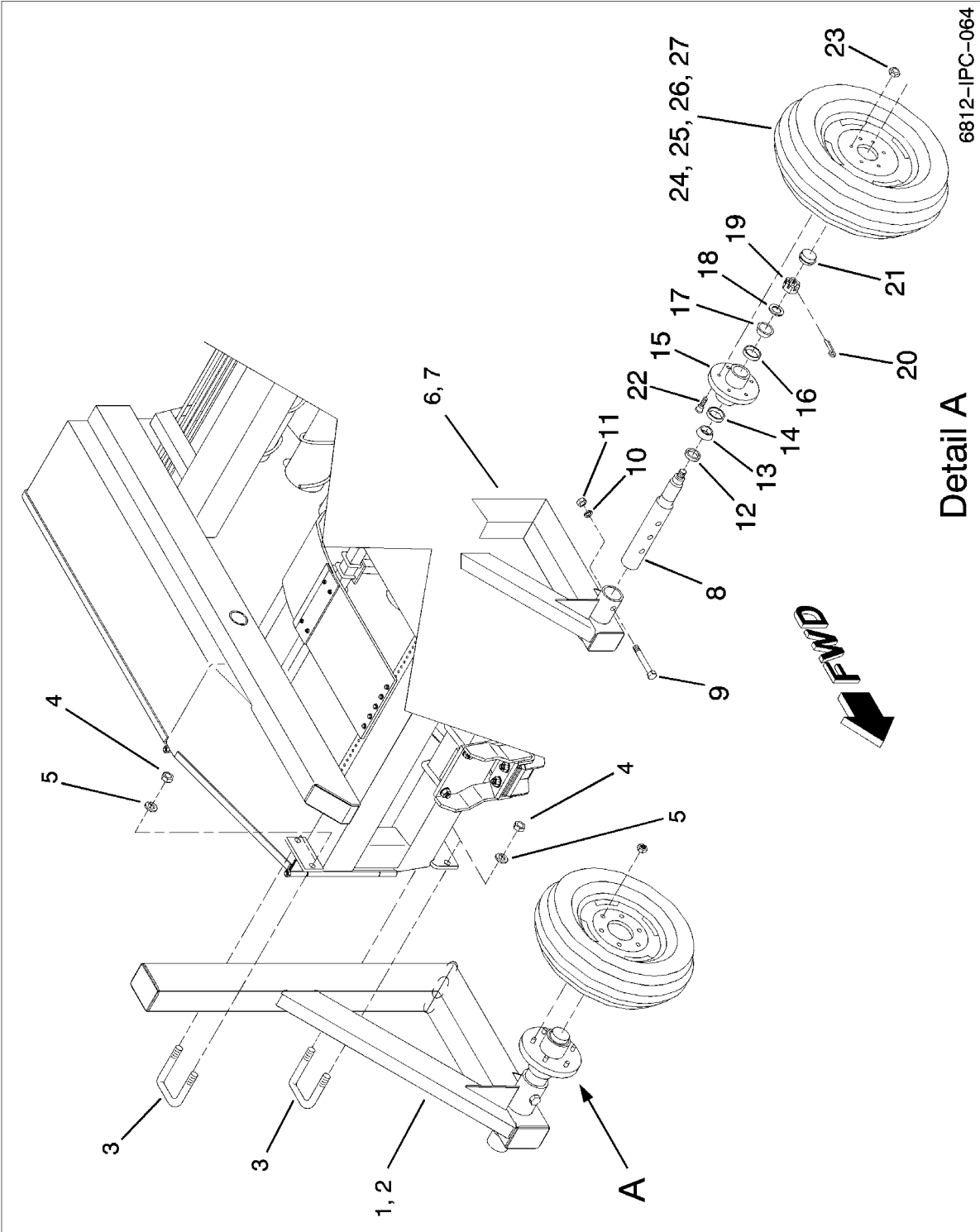
HEAD TO BASIC UNIT MOUNTING

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	520350		Plate, Rear Head Mtg, 8 Hole	2
2	520360		Plate, Rear Head Mtg, 6 Hole (Some 6R28/30 And 8R22)	2
3	520370		Plate, Front Head Mtg, 2 Hole	4
4	991050		Bolt, HHCS, 3/4-10 x 8-1/2 Gr5 ZN	24
5	I131017		Washer, Flat, 3/4 SAE x 13/16 x 1-15/32 x 9/64 ZN	48
6	036800		Washer, Lock, 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	24
7	J14H794		Nut, Hex, 3/4-10 GR5 ZN	24

CARRIER WHEEL ASSEMBLY



CARRIER WHEEL ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
-1	520930	Carrier Wheel Assembly, LH 6812	1
2	520940	Carrier Wheel Assembly, RH 6812 (Shown)	1
3	534400	U-Bolt, 3/4-10 X 4.0 X 4-3/4	4
4	J14H794	Nut, Hex 3/4-10 Gr5 ZN	8
5	036800	Washer, Lock 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	8
-6	520950	* Frame Wldt, LH Carrier Wheel	1
7	520960	* Frame Wldt, RH Carrier Wheel (Shown)	1
8	523380	* Spindle, Carrier Wheel	1
9	I271729	* Bolt, HHCS 5/8-11 x 3-1/2	1
10	020440	* Washer, Lock 5/8	1
11	I124589	* Nut, Hex 5/8-11	1
12	121130	* Seal, 2.12 x 3.06 x 0.50	1
13	007600	* Bearing, Cone 1.62	1
14	018930	* Inner Cup	1
15	007590	* Hub, 6 Bolt	1
16	018860	* Outer Cup	1
17	012630	* Bearing, Cone 1.25	1
18	020720	* Washer, Flat 13/16 x 1-3/4 x 3/16	1
19	020710	* Nut, Slotted 3/4-16	1
20	026630	* Pin Cotter 5/32 x 1-1/2	1
21	035420	* Cap, Hub 2-1/2	1
22	046700	* Bolt, Stud 9/16-18 x 2-1/8	6
23	046710	* Nut, Wheel 9/16-18	6
24	500770	* Wheel & Tire Assembly	1
25	U51900004	* * Wheel, 15 x 10 LB, 6-6-4.62, 3800#	1
26	I1980927C1	* * Tire, 11L-15 8 Ply TL Util	1
27	164420	* * Stem Valve Core & Cap	1

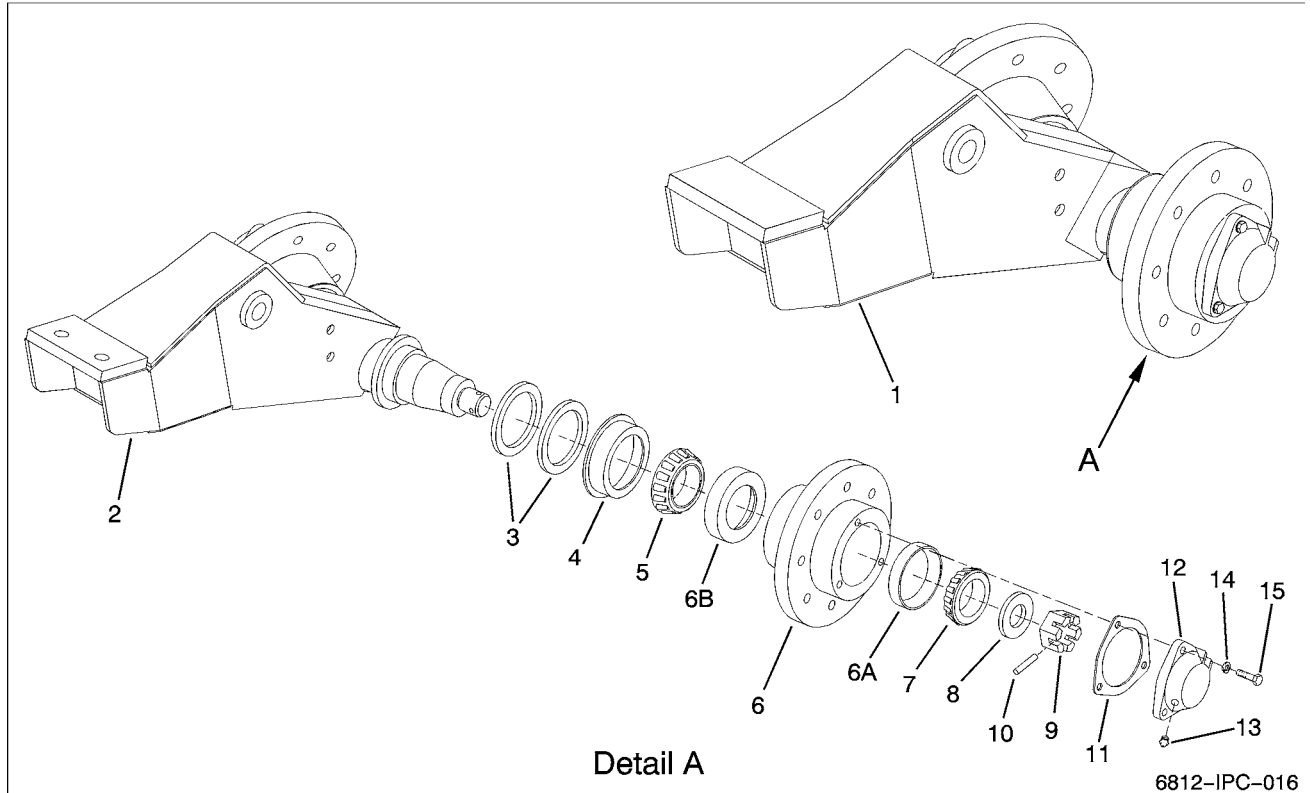
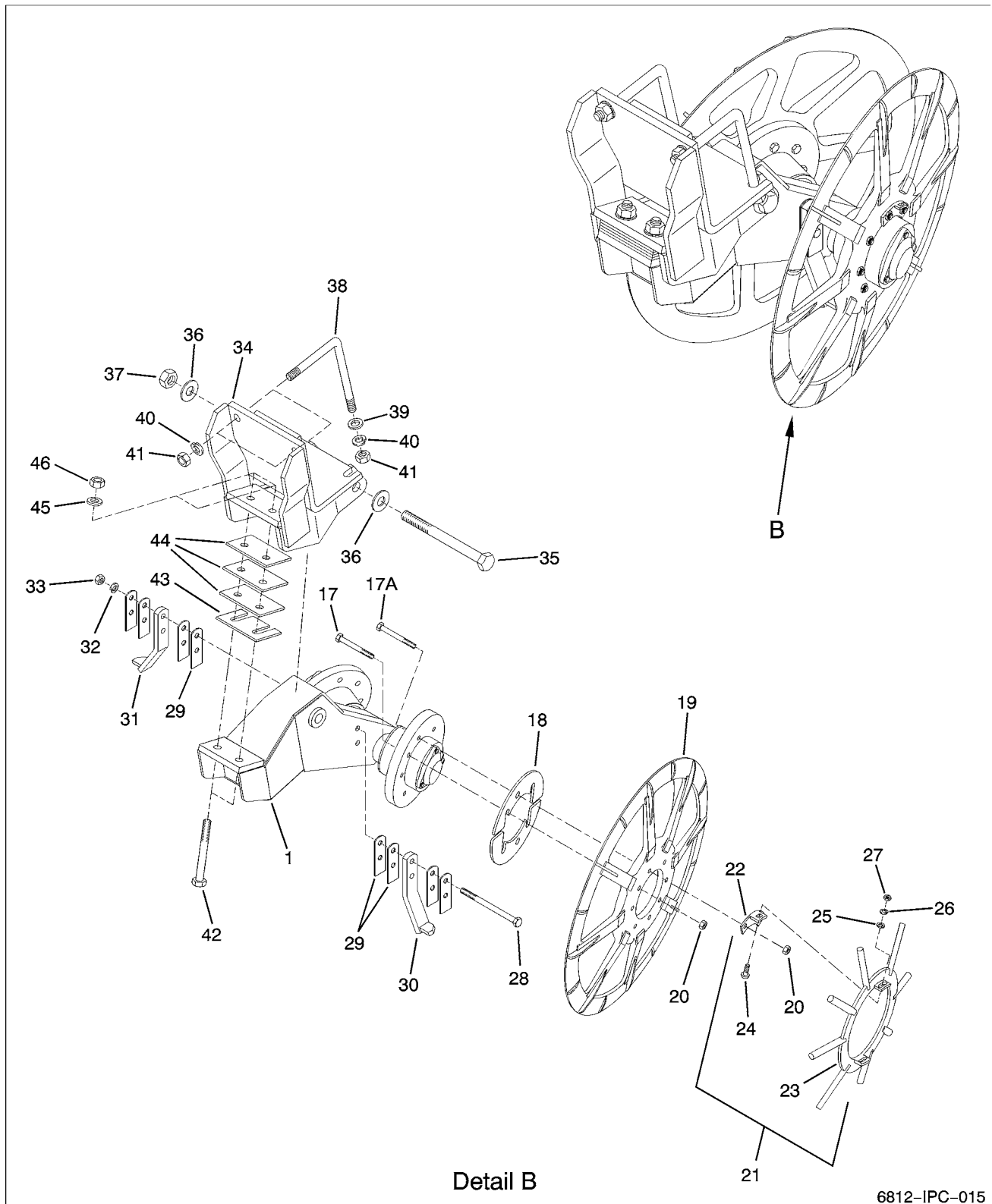
LIFTER GROUPING – STRUT ASSEMBLY

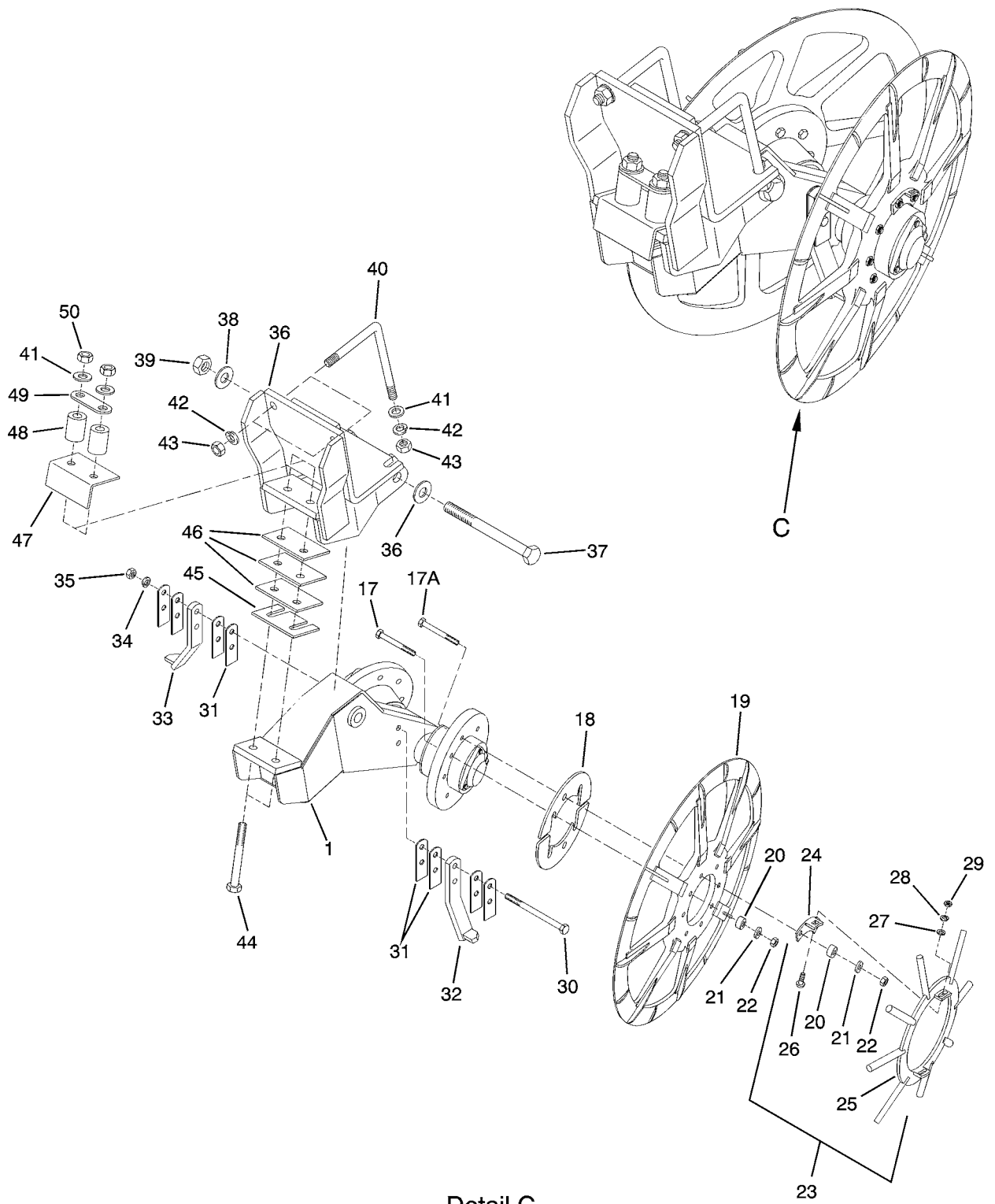
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521780	Strut Assembly, Flexible Pivot	1
2	521820	* Strut Wldt, Pivot Flex	1
3	263170	* Washer, Felt	4
4	263160	* Retainer, Felt	2
5	261640	* Cone Bearing, TM#28985 2.38 ID	2
6	267430	* Hub Assembly, Strut	2
-6A	E072462	* * Cup, Bearing	1
-6B	261650	* * Cup, Bearing	1
7	184960	* Cone Bearing, TM#368 2.00 ID	2
8	E829036	* Washer, 1.31 x 2.50 x 0.156	2
9	340320	* Nut, Slotted 1-1/4 Flange	2
10	013600	* Pin, Roll 0.25 x 2.00	2
11	JN70509	* Gasket, Hub	2
12	JN72550	* Cap, Hub Lifter Wheel	2
13	JJD7798	* Ftg, 1/8-27 Spec. Taper DR	2
14	021180	* Washer, Lock 3/8	6
15	012260	* Bolt, HHCS 3/8-16 x 1.0	6

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LIFTER GROUPING – FIXED STRUTS

LIFTER GROUPING – FIXED STRUTS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521780	Strut Assembly, Flexible Pivot	1
17	031580	Bolt, 1/2-13 x 2-3/4 HHCS Gr5 ZN	8
17A	990840	Bolt, 1/2-13 x 3 HHCS Gr5 ZN (used w/Close-up)	8
18	268570	Spacer, Beet Wheel (As Required – 6 Maximum)	8
19	491750	Wheel Lifter Machining 2000	2
20	127890	Nut 1/2-13 Hex Lock Gr5	16
21	463340	Kit, Close-up (OPTIONAL)	1
22	463370	* Bracket, Mounting Close-up Flex	4
23	463350	* Close-Up, Lifter Wheel	2
24	035180	* Bolt, 3/8 x 1-1/4 CRG	4
25	021190	* Washer, Flat 0.438 x 1.00 x 0.083	4
26	021180	* Washer, 3/8 Lock	4
27	027260	* Nut, 3/8 Hex	4
28	E672313	Bolt, HHCS 1/2-13 x 7-1/2 Gr5 ZN	2
29	521790	Shim, Spacer 1.5 x 3.5 (As Required – 8 Maximum)	8
30	521800	Scraper Wldt, LH	1
31	521810	Scraper Wldt, RH	1
32	005370	Washer, Lock 1/2 ZN	2
33	005360	Nut, Hex 1/2-13 Gr5 ZN	2
34	431590	Upper Wldt, Pivot Flex Strut	1
35	458530	Bolt, HHCS 1-8 x 7-1/2 Gr5 ZN	1
36	990720	Washer, Flat 1.00 (STD)	2
37	1110440	Nut, Hex 1-8 Lock w/Nylon Insert	1
38	403860	Bolt, “L” 3/4 x 6-7/8 x 8-3/4	2
39	J24H1401	Washer, Flat 0.781 x 1.75 x 0.194 ZN	2
40	036800	Washer, Lock 3/4	4
41	J14H794	Nut, Hex 3/4	4
42	990580	Bolt, HHCS 3/4-10 x 3-1/4 Gr5 ZN	2
43	516180	Shim, Pivot, 10 GA Flex Strut	1
44	436800	Shim Pivot Flex Strut	3
45	I131017	Washer, Flat 0.812 SAE ZN	2
46	1100238	Nut, Lock 3/4-10 Nylon Hex	2

LIFTER GROUPING – FLEX STRUTS

LIFTER GROUPING – FLEX STRUTS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521780	Strut Assembly, Flexible Pivot	1
17	038560	Bolt, 1/2-13 x 4.0 HHCS Gr5 ZN	8
17A	340300	Bolt, 1/2-13 x 4.25 HHCS Gr5 ZN (used w/Close-up)	8
18	268570	Spacer, Beet Wheel	8
19	491750	Wheel Lifter Machining 2000	2
20	267710	Pad, Flex 1.00	16
21	I486801R1	Washer, 0.531 x 2.00 x 0.25 Flat ZN	16
22	127890	Nut 1/2-13 Hex Lock Gr5	16
23	463340	Kit, Close-up (OPTIONAL)	1
24	463370	* Bracket, Mounting Close-up Flex	4
25	463350	* Close-Up, Lifter Wheel	2
26	035180	* Bolt, 3/8 x 1-1/4 CRG	4
27	021190	* Washer, Flat 0.438 x 1.00 x 0.083	4
28	021180	* Washer, 3/8 Lock	4
29	027260	* Nut, 3/8 Hex	4
30	E672313	Bolt, HHCS 1/2-13 x 7-1/2 Gr5 ZN	2
31	521790	Shim, Spacer 1.50 x 4.5 (As Required – 8 Maximum)	8
32	521800	Scraper Wldt, LH	1
33	521810	Scraper Wldt, RH	1
34	005370	Washer, Lock 1/2 ZN	2
35	005360	Nut, Hex 1/2-13 Gr5 ZN	2
36	431590	Upper Wldt, Pivot Flex Strut	1
37	458530	Bolt, HHCS 1-8 x 7-1/2 Gr5 ZN	1
38	990720	Washer, Flat 1 STD	2
39	1110440	Nut, Hex 1-8 Lock w/Nylon Insert	1
40	403860	Bolt, “L” 3/4 x 6-7/8 x 8-3/4	2
41	J24H1401	Washer, Flat 0.781 x 1.75 x 0.194 ZN	4
42	036800	Washer, Lock 3/4	4
43	J14H794	Nut, Hex 3/4	4
44	990980	Bolt, HHCS 3/4-10 x 7-1/2 Gr5 ZN	2
45	516180	Shim, Pivot, 10 GA Flex Strut	1
46	436800	Shim Pivot Flex Strut	3
47	458950	Shield, Pivot Strut	1
48	515890	Pad, Flex	2
49	433150	Washer, Double Flat 0.80 x 2.50 x 5.50 x 3/8 ZN	1
50	1100238	Nut, Lock 3/4-10 Nylon Hex	2

PADDLES TO PADDLE SHAFT (ALL HEADS)

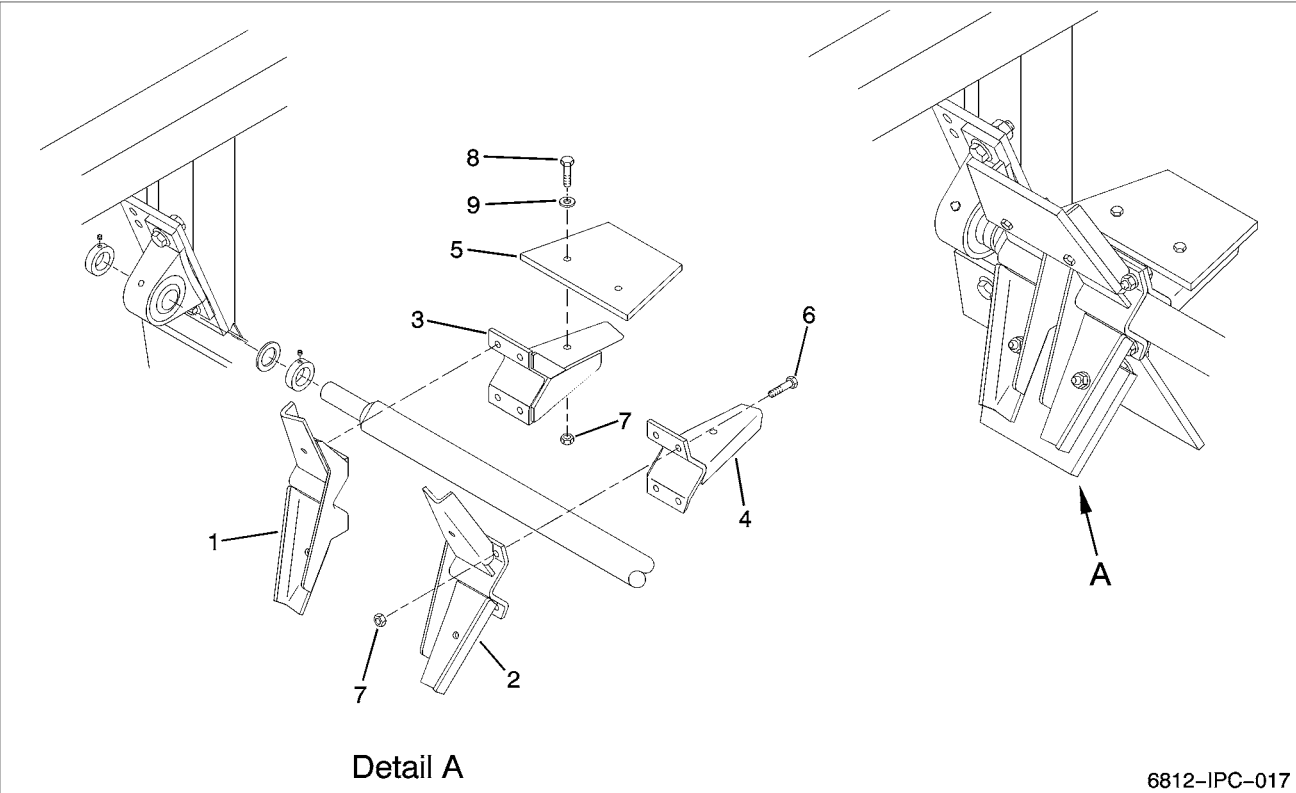
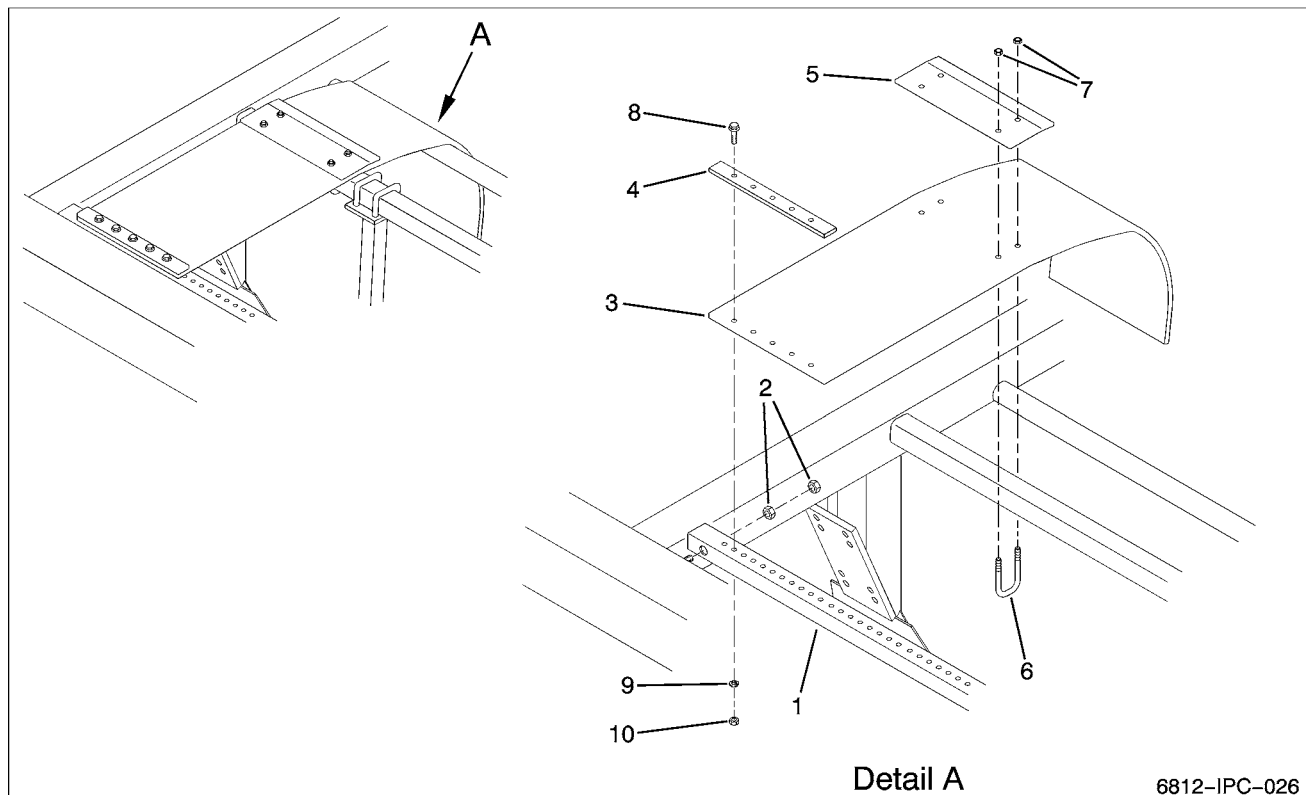
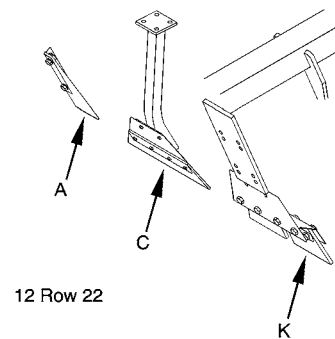
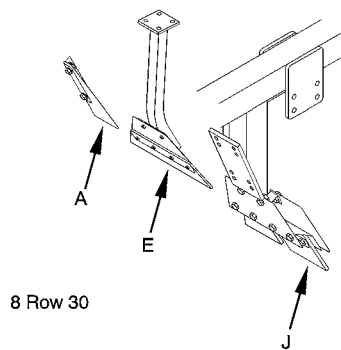
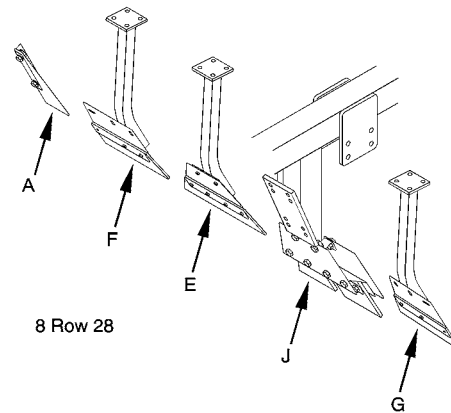
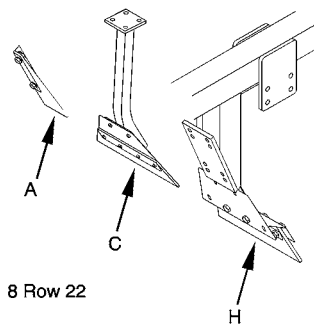
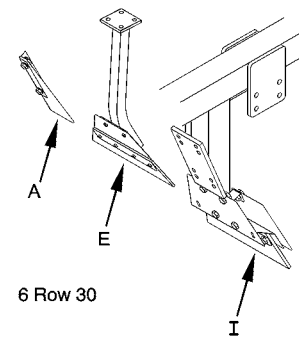
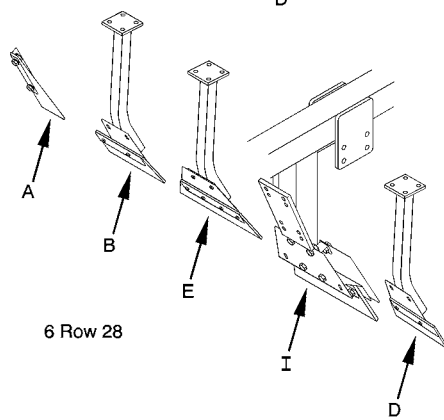
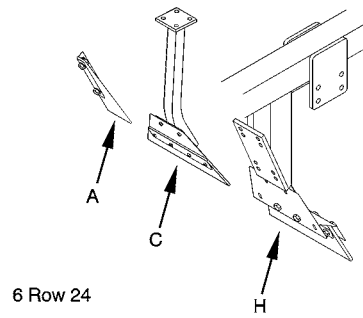
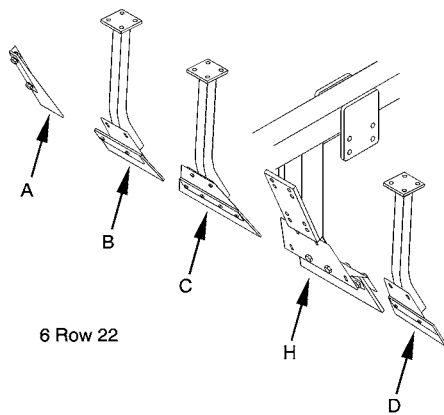


FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	354220	Paddle Wldt, RH Double	1
2	354230	Paddle Wldt, LH Double	1
3	354240	Paddle Wldt, RH Single	1
4	354250	Paddle Wldt, LH Single	1
5	511970	Paddle UHMW, 0.50 Thick	3
6	407610	Bolt, HHCS 1/2-13 x 2 Gr8 ZN	8
7	I9413967	Nut, Lock 1/2-13 GrB CAD Plated Top Lock	16
8	014770	Bolt, HHCS 1/2-13 x 1-1/2 Gr5 ZN	6
9	005200	Washer, Flat 1/2 STD 9/16 x 1-3/8 x 7/64 ZN	6

COVERS TO HEAD (ALL HEADS)

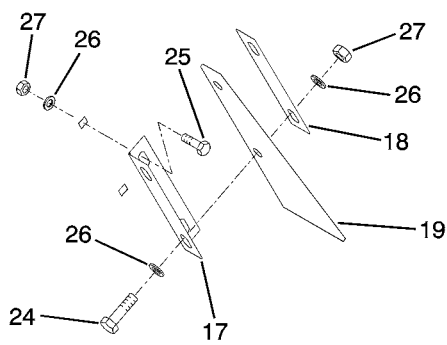
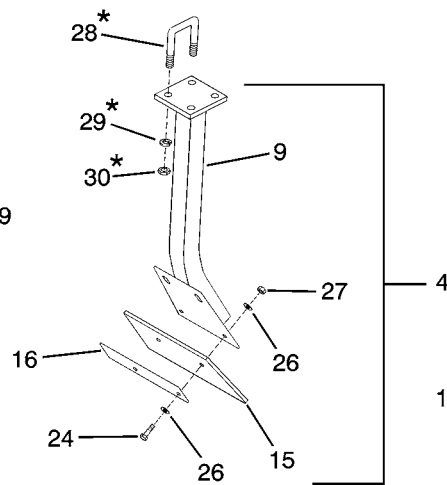
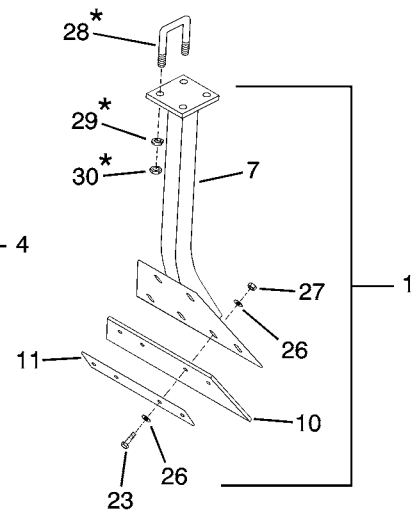
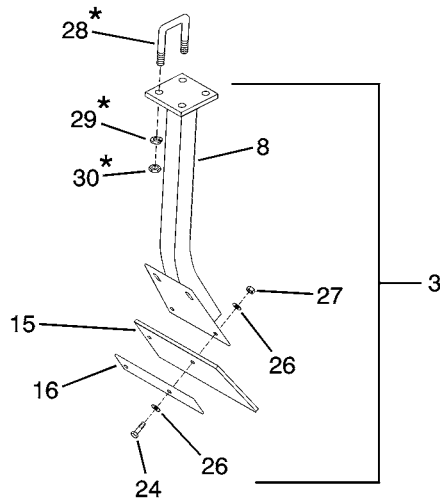
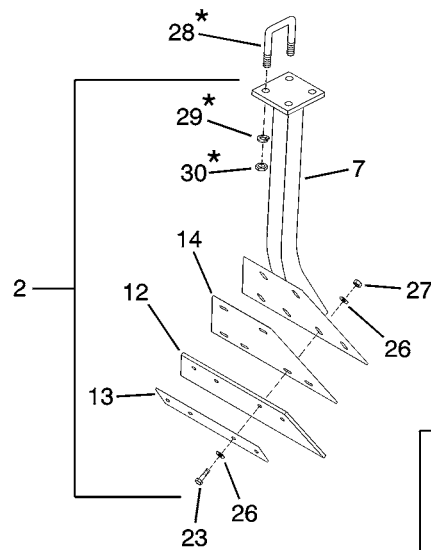
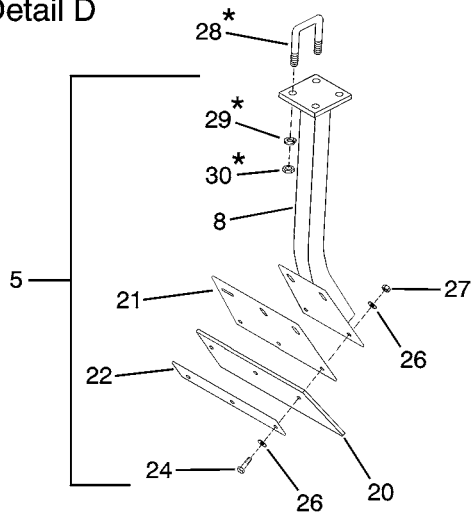
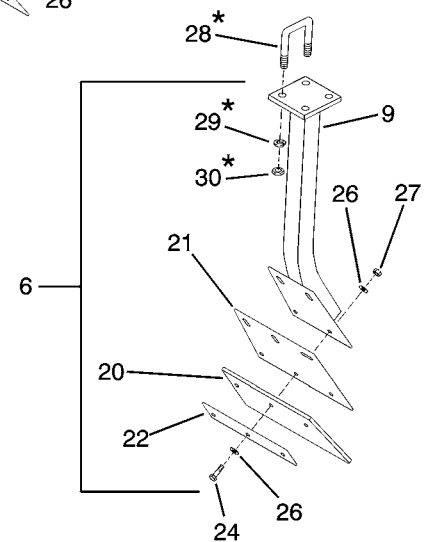
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FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521440	Tube, Cover Mtg 1.5 Sq x 62.0 (6R22/24)	2
1	520410	Tube, Cover Mtg 1.5 Sq x 82.50 (6R28/30 or 8R22)	2
1	521430	Tube, Cover Mtg 1.5 Sq x 103.0 (8R28/30)	2
1	521420	Tube, Cover Mtg 1.50 Sq x 122.00 (12R22)	2
2	J14H794	Nut, Hex 3/4-10 Gr5 ZN	8
		Cover Assembly	
3	477530	* Cover, Rubber	1
4	443060	* Strap, Cover Holder	1
5	481620	* Bracket, Cover	1
6	290890	* Bolt, U 1/2-13 x 2-1/16 x 3	2
7	I9413967	* Nut, Lock 1/2-13 GrB CAD Plated Top Lock	4
8	009800	* Bolt, HHCS 5/16-18 x 2-1/2 Gr5 ZN	5
9	023620	* Washer, Lock 5/16 x 37/64 x 5/64 ZN	5
10	023630	* Nut, Hex 5/16-18 Gr5 ZN	5

BARRIER ARRANGEMENTS (ALL HEADS)

BARRIER ARRANGEMENTS (ALL HEADS)

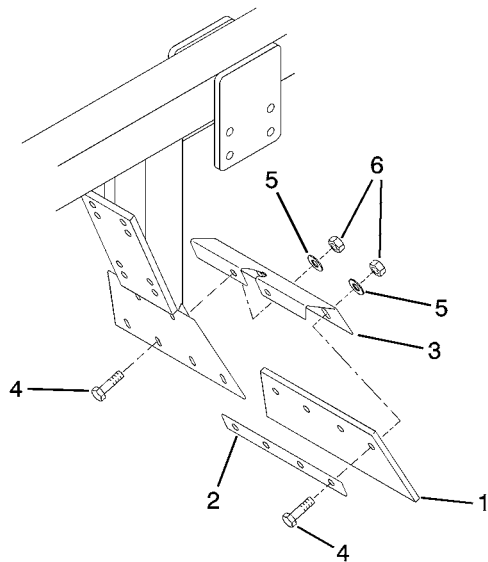
DETAIL LETTER	PART NUMBER SEE BARRIER DETAIL	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
C		6 Row 22 Barrier Arrangements Barrier Assembly, Center	4
H		Center Head Frame, Barrier Mtg	1
A		LH and RH Side Barrier	2
D		Barrier Assembly, Left	1
B		Barrier Assembly, Right	1
C		6 Row 24 Barrier Arrangements Barrier Assembly, Center	4
H		Center Head Frame, Barrier Mtg	1
A		LH and RH Side Barrier	2
E		6 Row 28 Barrier Arrangements Barrier Assembly, Center	4
I		Center Head Frame, Barrier Flap Mtg	1
A		LH and RH Side Barrier	2
D		Barrier Assembly, Left	1
B		Barrier Assembly, Right	1
E		6 Row 30 Barrier Arrangements Barrier Assembly, Center	4
I		Center Head Frame, Barrier Flap Mtg	1
A		LH and RH Side Barrier	2
C		8 Row 22 Barrier Arrangements Barrier Assembly, Center	6
H		Center Head Frame, Barrier Flap Mtg	1
A		LH and RH Side Barrier	2
E		8 Row 28 Barrier Arrangements Barrier Assembly, Center	6
J		Center Head Frame, Barrier Mtg	1
A		LH and RH Side Barrier	2
D		Barrier Assembly, Left	1
B		Barrier Assembly, Right	1
E		8 Row 30 Barrier Arrangements Barrier Assembly, Center	6
J		Center Head Frame, Barrier Mtg	1
A		LH and RH Side Barrier	2
C		12 Row 22 Barrier Arrangements Barrier Assembly, Center	10
K		Center Head Frame, Barrier Flap Mtg	1
A		LH and RH Side Barrier	2

BARRIER DETAILS (ALL HEADS)**Detail A****Detail B****Detail C****Detail D****Detail E****Detail F****Detail G**

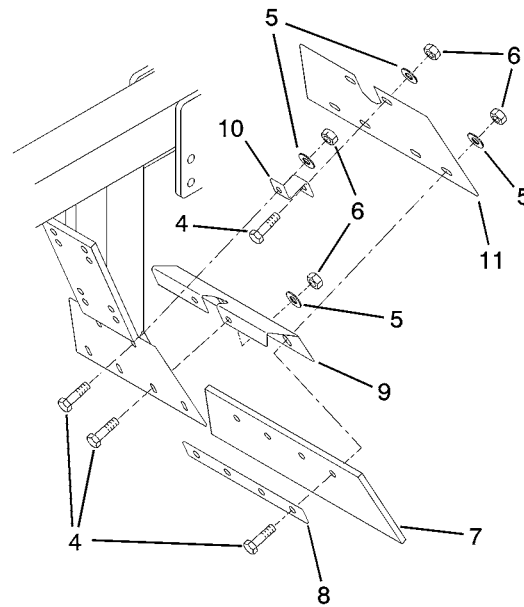
* These parts are not included in Barrier Assemblies

BARRIER DETAILS (ALL HEADS)

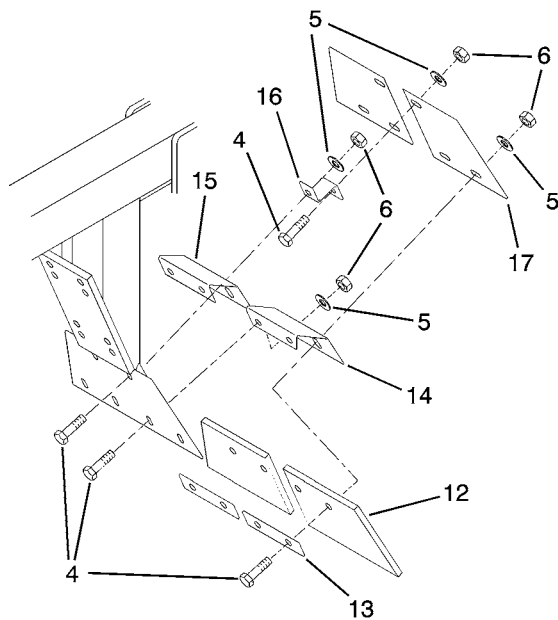
FIG ITEM	PART NUMBER	NOMENCLATURE
		1 2 3 4 * * * *
1	446320	Barrier Assembly, Center
2	446330	Barrier Assembly, Center
3	446280	Barrier Assembly, Left
4	446360	Barrier Assembly, Right
5	530920	Barrier Assembly, Left
6	530930	Barrier Assembly, Right
7	446310	Barrier Wldt
8	446340	Barrier Wldt
9	446350	Barrier Wldt
10	244650	Flap, Rubber
11	244670	Strap, Barrier
12	244720	Flap, Rubber
13	244730	Strap, Barrier
14	242350	Plate, Barrier 4 Row
15	447090	Flap, Rubber Side 6 Row
16	447100	Strap, Barrier Side 6 Row
17	524540	Angle, Barrier Mtg
18	524550	Strap, Barrier Flap Mtg
19	526390	Flap, Rubber Side Barrier
20	526400	Flap Rubber Side
21	526410	Plate Side, Barrier
22	526420	Strap Barrier Side
23	006690	Bolt, HHCS 3/8-16 x 1-1/4 Hex
24	011370	Bolt, HHCS 3/8-16 x 1.50
25	J03H1558	Bolt, CRG 3/8-16 x 1-1/2 SSN Gr5 ZN
26	I120394	Washer, 3/8 Flat
27	073630	Nut, 3/8-16 Hex Nylon Lock
28	290890	Bolt, U 1/2-13 x 2-1/16 x 3 (* Not Included in Barrier Assembly)
29	005370	Washer, Lock 1/2 ZN (* Not Included in Barrier Assembly)
30	005360	Nut, Hex 1/2-13 Gr5 ZN (* Not Included in Barrier Assembly)

BARRIERS , CENTER HEAD FRAME (ALL HEADS)

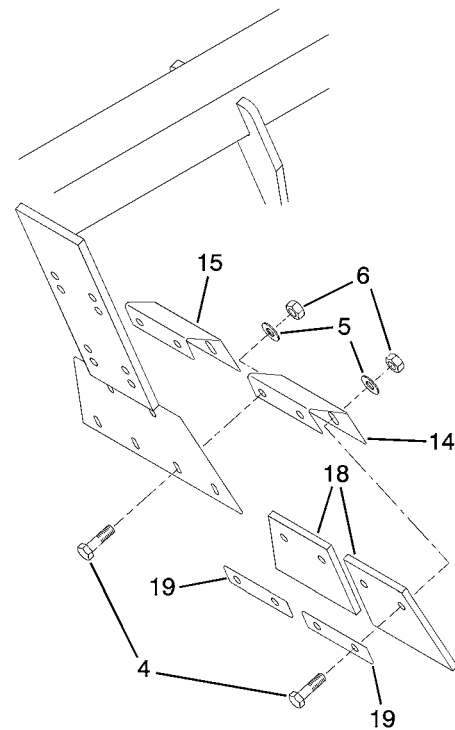
Detail H
6R22/24 OR 8R22



Detail I
6R28/30



Detail J
8R28/30

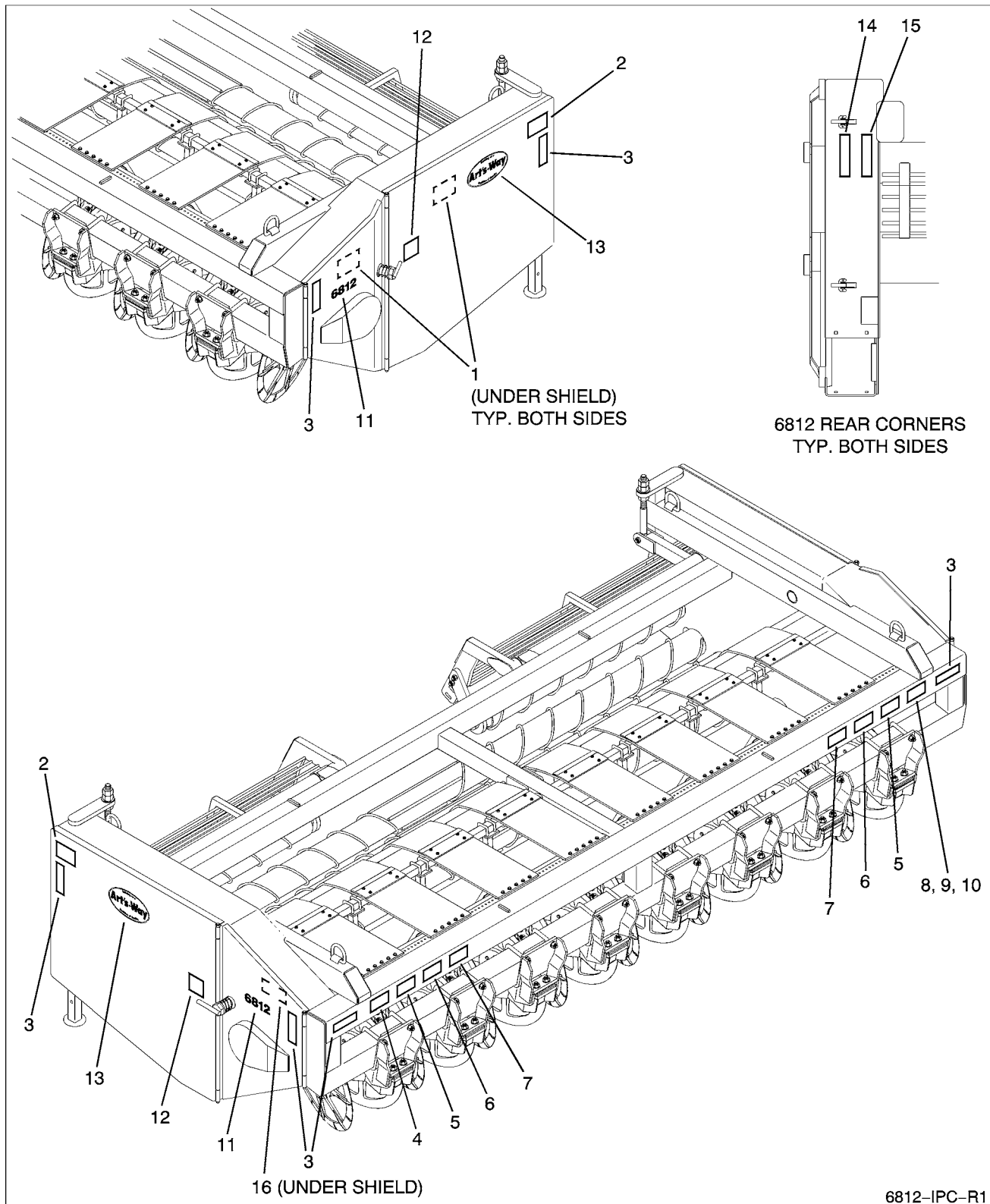


Detail K
12R22

BARRIERS, CENTER HEAD FRAME (ALL HEADS)

FIG ITEM	PART NUMBER	NOMENCLATURE
		1 2 3 4 * * * *
1	244650	Flap, Rubber Barrier Center 6 Row
2	244670	Strap, Barrier Center 6 Row
3	530410	Plate, Barrier Center Adapter
4	011370	Bolt, HHCS 3/8-16 x 1-1/2 Gr5 ZN
5	I120394	Washer, Flat 3/8 SAE 13/32 x 13/16 x 1/16 ZN
6	073630	Nut, Lock 3/8-16 Gr2 ZN Nylon Hex
7	244720	Flap, Rubber 4 Row
8	244730	Strap, Barrier Center 4 Row
9	530410	Plate, Barrier Center Adapter
10	530500	Strap, Barrier Attaching
11	530590	Plate, Barrier Center
12	530490	Flap, Rubber 4 Row
13	530520	Strap, Barrier Center 4 Row
14	530420	Plate, Barrier LH Center
15	530430	Plate, Barrier RH Center
16	530500	Strap, Barrier Attach
17	530480	Plate, Barrier 4 Row
18	530440	Flap, Rubber Barrier Center 6 Row
19	530510	Strap, Barrier Center 6 Row

DECALS



DECALS

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	467430	Decal, Danger, Shield Missing	4
2	467470	Decal, Warning, Overhead Hazard	1
3	476460	Tape, Yellow, Retro-Reflective	6
4	467440	Decal, Danger, Electrocution	1
5	467410	Decal, Danger, Rotating Roll Hazard	2
6	467400	Decal, Warning, Thrown Object Hazard	2
7	467420	Decal, Warning, No Riders/Falling Hazard	2
8	355500	Tag, Serial Number, Finished	1
9	204510	Nail, 1/4 Grip	4
10	133420	Patent Pending	1
11	519540	Decal, 6812 Beet Harvester	2
12	467450	Decal, Warning, Moving Part Hazard	2
13	519480	Decal, Art's-Way Logo, 11.5 x 20.1	2
14	476450	Tape, Red, Retro-Reflective	2
15	476470	Tape, Red-Orange, Florescent	2
16	289500	Decal, Idler Spring 4-1/2 Inch (6R28/30 And 8R22)	1
17	533050	Decal, Idler Spring 6-1/4 Inch (8R28/30, 9R24/26, 12R22)	1

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