



Art's-Way Manufacturing Co., Inc.

Model 6812
Sugar Beet Harvester

Illustrated Parts List
531090

Issued 8-04

ILLUSTRATED PARTS LIST

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.: _____

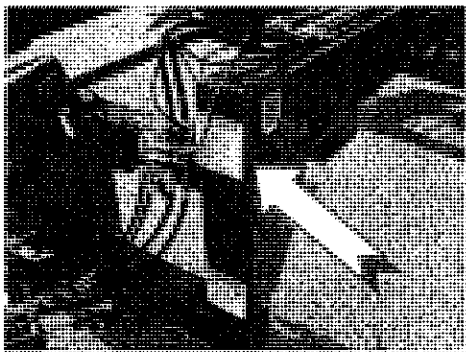


Figure 1 – Location of Serial and Model Placard on Harvester

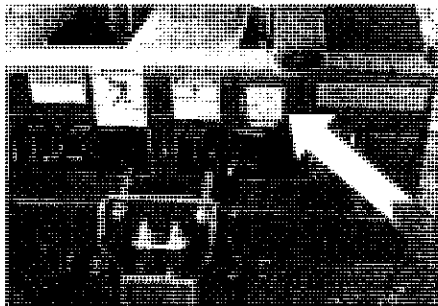


Figure 2 – Location of Serial and Model Placard on Header

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.

Building on a Art's-Way Tradition of Quality	
SERIAL NO.	
MODEL NO.	
Manufactured By Art's-Way Manufacturing Co., Inc. Armstrong, IA	

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

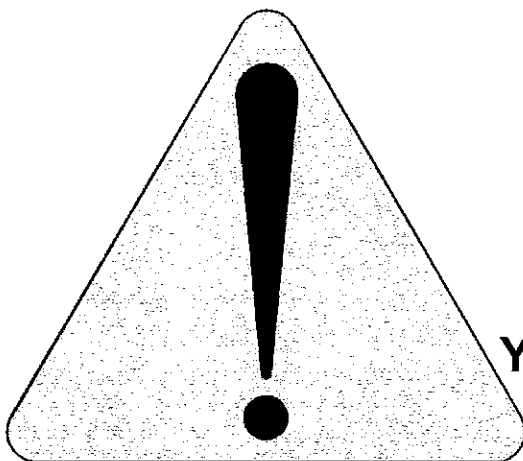


Figure 4 - Universal Safety Alert Symbol

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

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 2.) 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. Electrocution 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. Electrocution 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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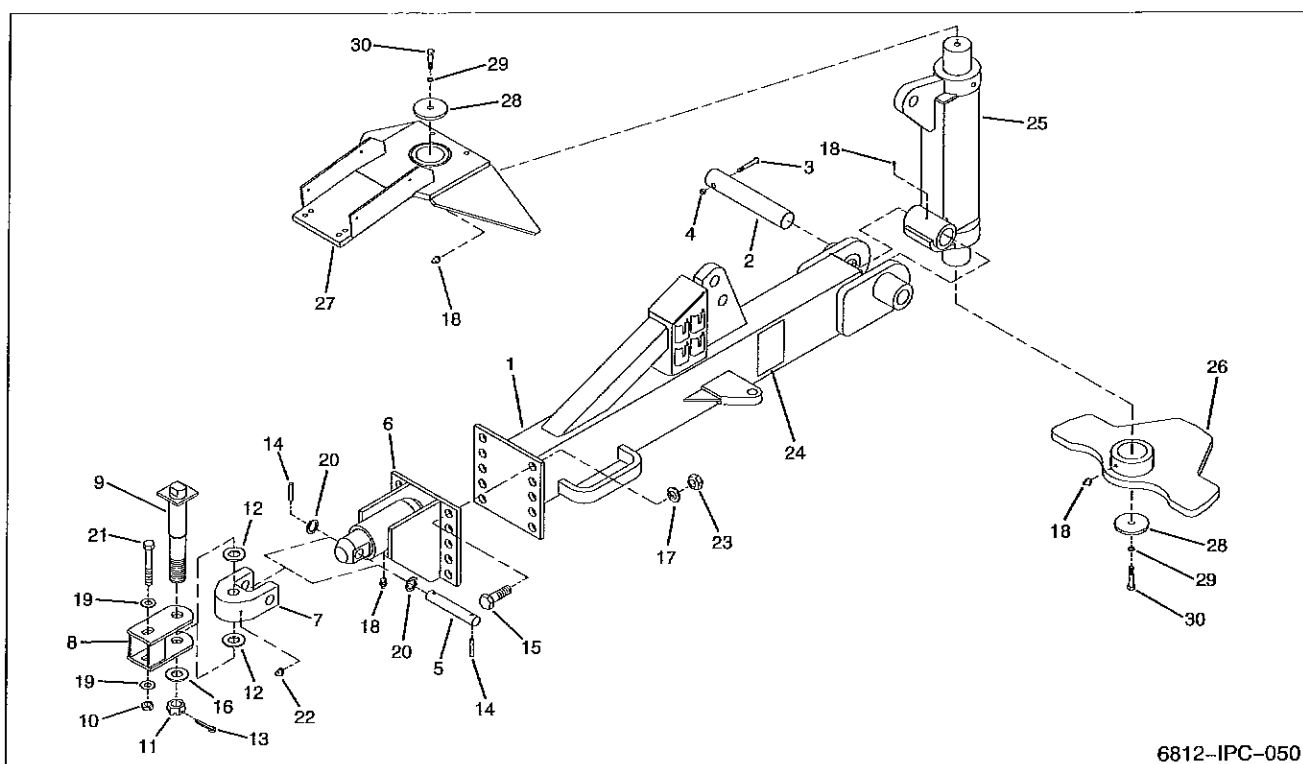
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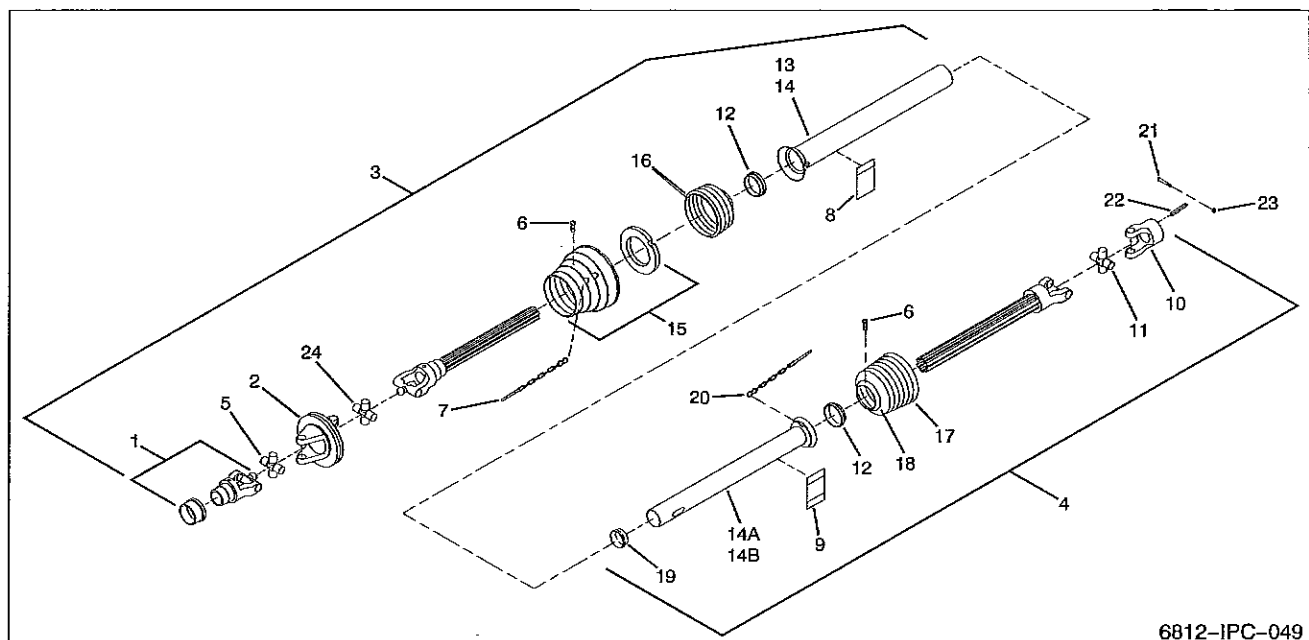
SECTION 1: HARVESTER

TONGUE ASSEMBLY



6812-IPC-050

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Tongue Assembly, 6812, (527000)	
1	518010		Hitch Wldt, Tongue 6812	1
2	517930		Pivot 2 OD x 11.5 L	1
3	038560		Bolt, HHCS 1/2-13 x 4	1
4	127890		Nut, Lock 1/2-13 Hex	1
5	252820		Pin, Hitch	1
6	290120		Hitch Wldt, Front	1
7	425490		Clevis, Hitch 1.5 inch Bolt	1
8	425500		Clevis, Wldt, Drawbar	1
9	439070		Pin Wldt, Hitch 1-3/8	1
10	991040		Nut, Lock 3/4-10 Hex	1
11	E552072		Nut, 1-3/8-6 Slot Hex GR8	1
12	425550		Washer, Hardened 1.56	2
13	B063768		Pin, 1/4 x 3 Cotter	1
14	E580053		Pin, 5/16 x 1-3/4 Roll	2
15	E672103		Bolt, 1-8 x 2-1/2 Hex	6
16	V063596		Washer, 1-5/8 x 3 x 0.165	4
17	003350		Washer, 1 inch Lock	6
18	013170		Zerk, 1/8-27 NPT	2
19	020720		Washer, 0.812 x 1.72 x 0.179	2
20	020650		Washer, 1.14 IO x 8.5 HHCS	1
21	991050		Bolt, 3/4- 10 x 8.5 HHCS	1
22	115590		Zerk, 1/4-28 Taper	1
23	J14H805		Nut, 1-8 Hex	6
24	467460		Decal, Caution, Hitch	1
25	519860		Wldt, Hitch Pivot	1
26	518480		Wldt, Plate Lower	1
27	519600		Wldt, Plate Upper	1
28	517670		Washer, Pivot	2
29	020440		Washer, Lock 5/8	2
30	990600		Bolt, HHCS 5/8-11 X 1-1/4	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
	345380		Yoke, 1-3/8-21 Spline	1
1	340210		* Collar Kit, 1-3/8-21 (Included with Fig Item 1)	1
	354840		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, Oanger 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

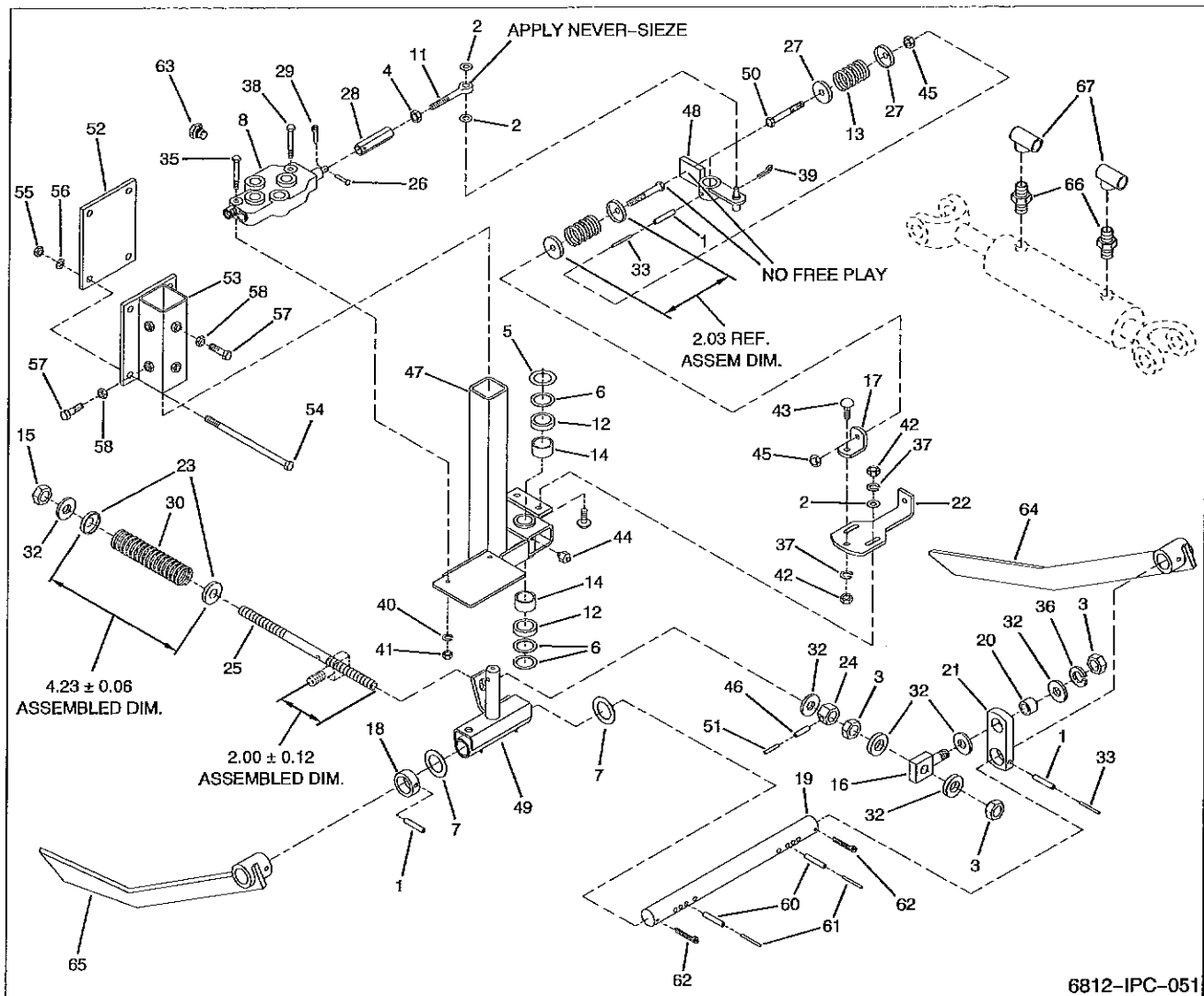
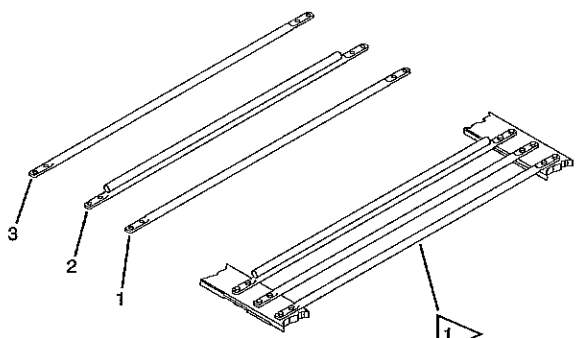


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Rowfinder, 6812, (517900)	
1	E580053		Pin, 5/16 x 1-3/4 Roll	3
2	I120394		Washer, 0.406 x 0.812 x 0.051	4
3	I124589		Nut, 5/8-11 Hex G5	3
4	I124829		Nut, 3/8-16 Hex Jam G5	1
5	I22266R1		Washer, 1.15 x 1.75 x 0.027 Flat	3
6	I23041R1		Washer, 1.15 x 1.50 x 16 Ga. F1	3
7	I608700R1		Washer, 1.28 x 2.0 x 0.54 Flat	2
8	343250		Valve Assembly, Open Center	1
11	413450		Eyebolt	1
12	JAT30144		Seal, 1.1 x 1.5 x 0.37	2
13	JCJ21FN		Spring, Comp. 0.99 x 1.38 x 2.0	2
14	JJD8813		Bearing, 1.12 x 0.75	2
15	JK40015		Nut, Hex 5/8-11 Top-Lock G8	1
16	JN145970		Eyebolt	1

ROW FINDER ASSEMBLY

FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
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	09800	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 THO	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 G%	2
51	991100	Pin, 3/16 x 1-1/4 Expansion	1
52	520520	Plate, RF Mounting	1
53	520540	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	990600	Bolt, HHCS 5/8-11 x 1-1/4	4
58	1121555	Nut, Jam 5/8-11 Hex ZN GR5	4
60	E580053	Pin, 5/16 x 1-3/4 Roll	2
61	J34H288	Pin, 3/16 x 3/4 Roll	2
62	003950	Pin, 3/16 x 2 Cotter	2
63	JAN140006	Plug, Closed Center	1
64	JAN142149	Sensor, Assembly LH	1
65	JAN142148	Sensor, Assembly RH	1
66	166250	Adapter, Straight	2
67	166290	Adapter, Tee	2

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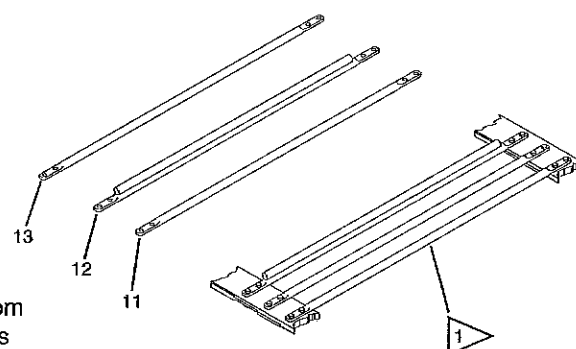
DRAPER CHAIN SERVICE PARTS


Note:

1 522000 Draper Chain for Short Conveyor

6812-IPC-052

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	531030		Rod, 5/8 x 48, STR 1/4-20 Threaded	-
			Common Parts for General Repair – All Draper Chains	
-4	268670		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	455490		Backer Plate for 1/4	-
-9	455500		Bolt, 1/4-20 x 1 CTR SK Hex Socket	-



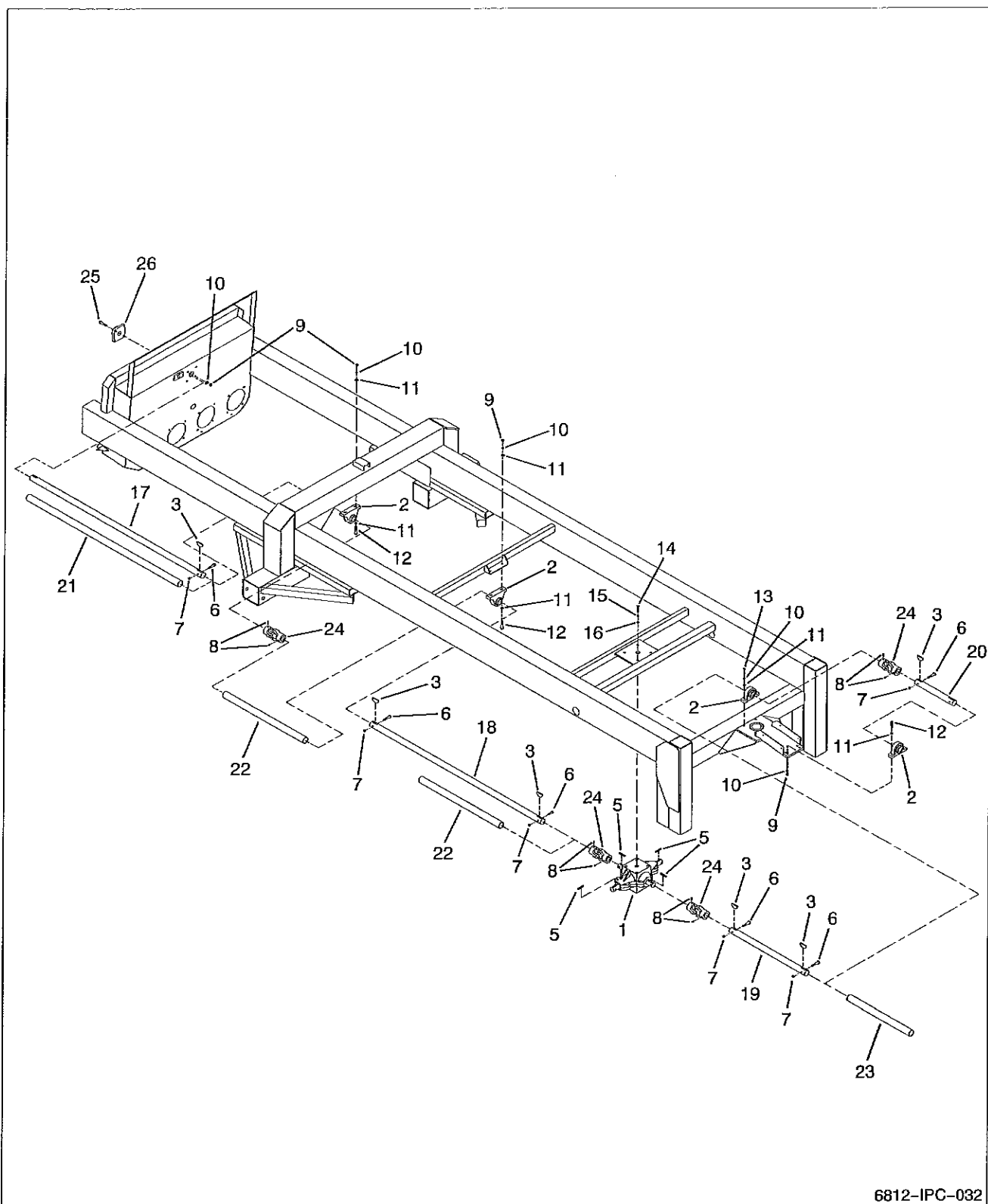
Note:

1 522030, 522040 Draper Chain for Main Tank & Boom
526560, 526570, 526580, 526590 Boom Extensions
522010 & 522020 Draper Chain for Transfer Elevator

6812-IPC-053

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	-

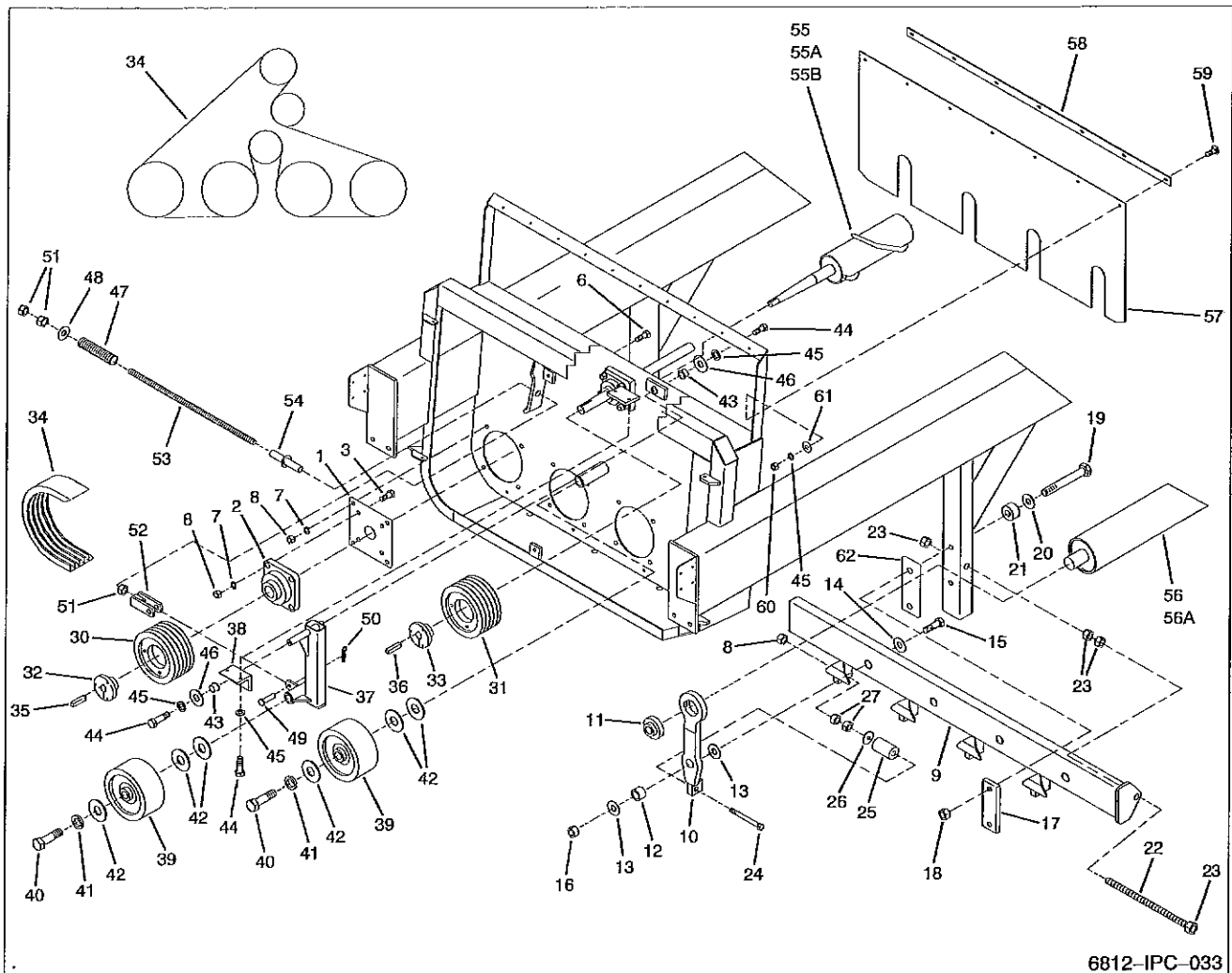
DRIVE SHAFT ASSEMBLIES



DRIVE SHAFT ASSEMBLIES

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
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
13	023950		Bolt, HHCS 1/2-13 x 2-1/2	2
14	025100		Bolt, HHCS 1/2-13 x 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	4
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



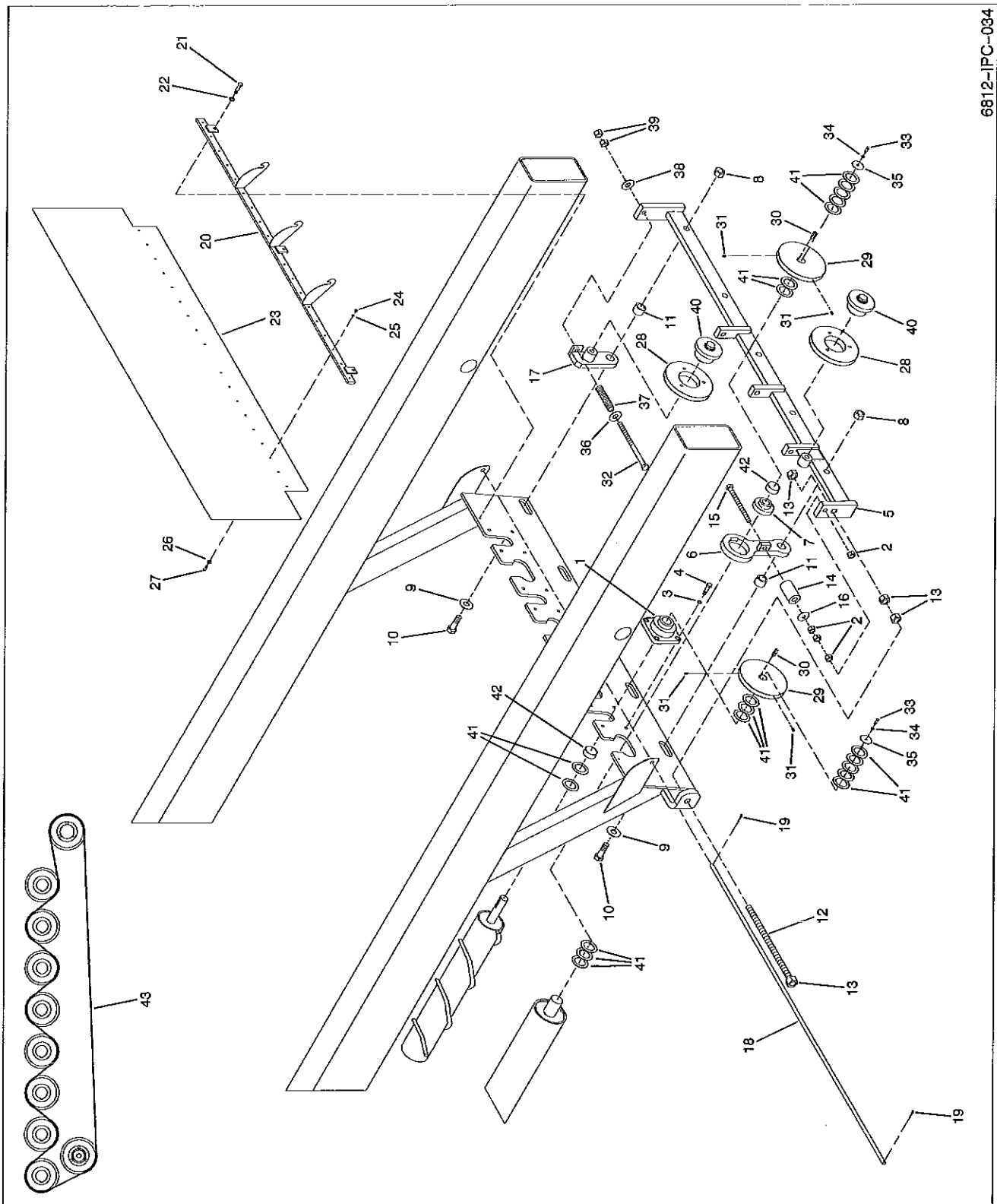
6812-IPC-033

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Conveyor Roller Drives - Rear (523000-50)	
1	521990		Plate, Rear Grabroll Bearing	4
2	522970		Bearing, FLF 4H	4
3	990620		Bolt, HHCS 5/8-13 x 2	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.B-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

CONVEYOR ROLLER DRIVES - REAR

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
18	JK40016		Nut, Lock 3/4-10	4
19	990980		Bolt, HHCS 3/4-10 x 7-1/2	4
20	J24H1401		Washer, Flat	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 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	2
	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	4
46	169280		Washer, Flat 3/8	4
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
54	518130		Guide Wldt, Tensioner	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

CONVEYOR ROLLER DRIVES - FRONT

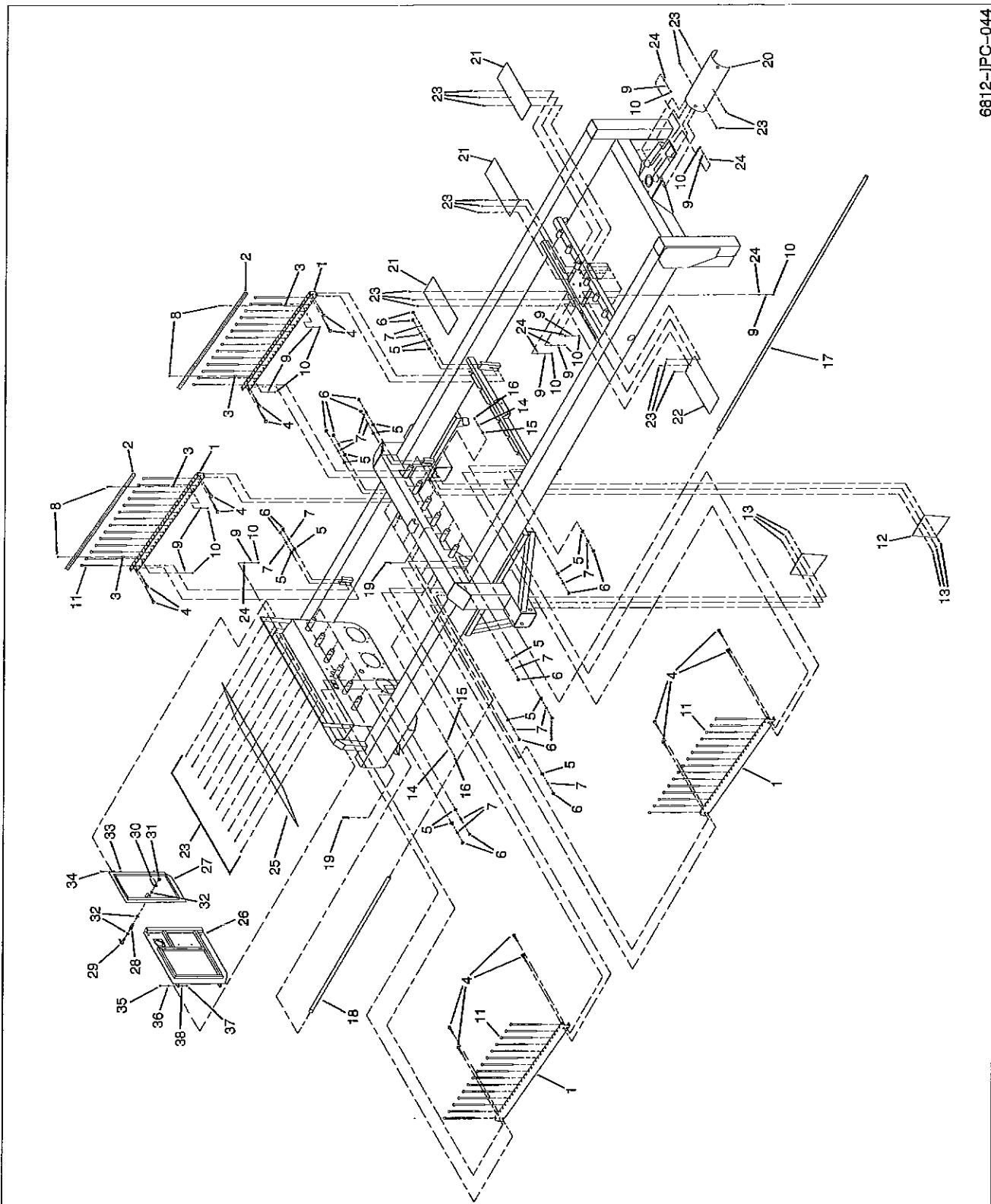


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CONVEYOR ROLLER DRIVES - FRONT

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			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	J14HB05		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	525500		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 D.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

DEFLECTORS

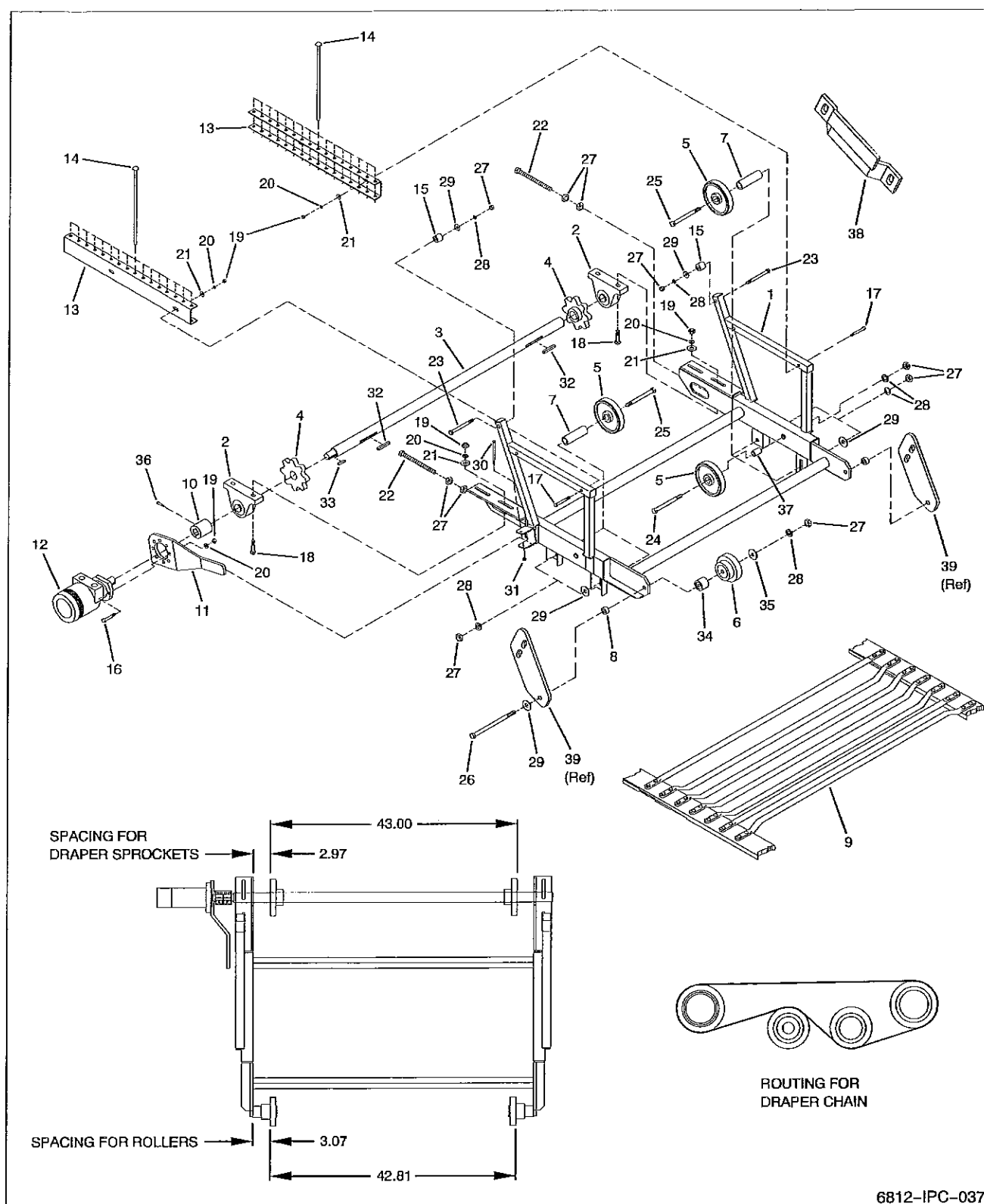


6812-IPC-044

DEFLECTORS

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	525550		Deflectors, 6812, (523000-150)	
2	525580		Channel, Grate 57.25 Long	4
3	525590		Angle, Cap	4
4	030470		Spacer, 0.5 OD x 0.31 ID x 1	8
5	005200		Bolt, CRG 1/2-13 x 1-1/4	16
6	005360		Washer, Flat 1/2 Standard	3B
7	005370		Nut, Hex 1/2-13	34
8	223540		Washer, Lock 1/2 ZN	34
9	029440		Bolt, HHCS 1/4-20 x 1-3/4	8
10	027660		Washer, Lock 1/4 ZN	34
11	347540		Nut, Hex 1/4-20	34
12	525630		Rod, Grate 1/2 x 14.75	116
13	012410		Deflector, Side	2
14	023620		Bolt, CRG 5/16-18 x 3/4	6
15	022920		Washer, Lock 5/16 ZN	6
16	023630		Washer, Flat 5/16	6
17	526690		Nut, Hex 5/16-18	6
18	526700		Pipe, Grate Front	6
19	R18660		Pipe, Grate Rear	6
20	526710		Pin, Snapper	12
21	526720		Deflector, Jack Shaft	1
22	526730		Deflector, Gearbox	2
23	042960		Deflector, Head Drive	2
24	023260		Bolt, HHCS 1/4-20 x 1	26
25	523710		Washer, Flat 1/4 Standard	26
26	522390		Guard, Rear Drive	1
27	522340		Door, Wldt, RH Hyd. Pump MT	1
28	518900		Door, Wldt, LH Rear	1
29	518840		Spring, Comp., 0.94 x 14 GA x 2	1
30	518850		Handle Wldt, Door Latch	1
31	V062140		Latch Wldt, Door	1
32	020430		Nut, Jam 5/8-11	1
33	E552044		Washer, Flat 5/8 STD	3
34	012260		Nut, Lock 3/8-16	2
35	014470		Bolt, HHCS 3/8-16 x 1	2
36	I120396		Bolt, HHCS 1/2-13 x 1-1/2	2
37	JK40014		Washer, Flat 1/2	2
38	005370		Nut, Lock 1/2-13	2
			Washer, Lock 1/2	2

SHORT CONVEYOR ASSEMBLY

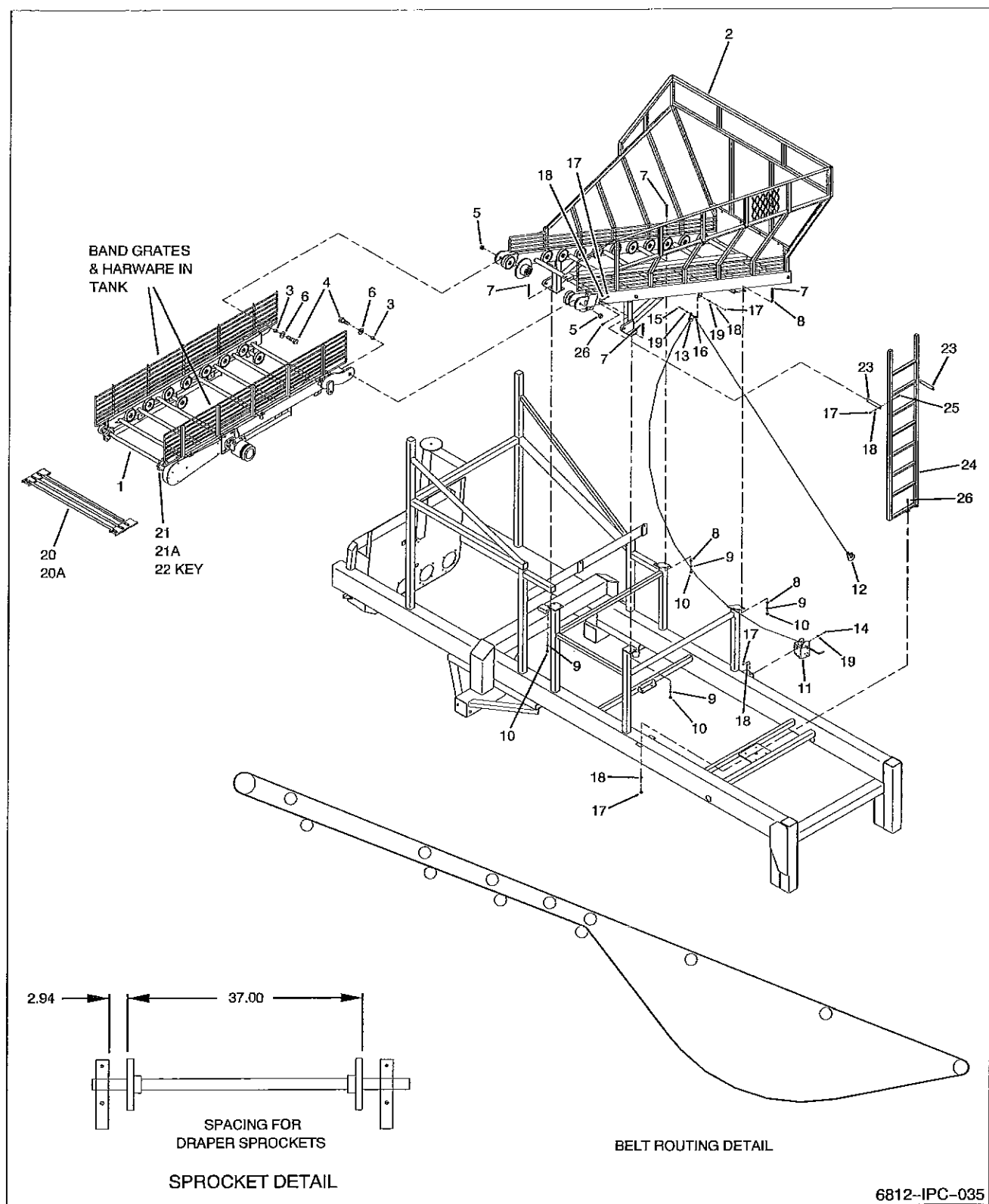


6812 Sugar Beet Harvester – Section 1: Harvester
SHORT CONVEYOR ASSEMBLY

29

FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	516740	Short Conveyor Assembly, 6812, (523500)	1
2	522940	Conveyor Wldt, Short	2
3	517330	Bearing, PB, 1.75 Wide	1
4	526600	Shaft, Drive, Short Conveyor	2
5	343280	Sprocket, 8T – 0.62, 56mm	6
6	523580	Roller, Rubber 4.0 dia	2
7	JN144798	Roller, 5.0 OD, 0.62 dia	4
8	523590	Trunion, Wheel Retainer	2
9	522000	Spacer, Tube, 1.25 OD x 0.59 L	1
10	523600	Chain, Belted, 56mm x 40 (See Draper Chain Section for Parts)	1
11	516650	Coupler, 1.25 B, Spec	1
12	523520	Arm, Torque, Universal	1
-12A	384850	Motor, Hyd 18.7, 2000	1
13	516680	Kit, Seal 2000 Motor	2
14	347540	Channel, Rods, 31.25	32
15	E126195	Rod, Grate, Round Head	2
16	023950	Bushing, 11/16 x 1-1/4 x 1-1/8	2
17	007080	Bolt, HHCS 1/2-13 x 2.0 GR5	4
18	991200	Bolt, HHCS 1/2-13 x 2-1/2	4
19	005360	Bolt, CRG 1/2-13 x 2.0 GR5 ZN	10
20	005370	Nut, Hex 1/2-13 GR5 ZN	10
21	005200	Washer, Lock 1/2 ZN	8
22	R66168	Washer, Flat 1/2 Std	2
23	056720	Bolt, Adj 5/8 x 6-1/2	2
24	990680	Bolt, HHCS 5/8-11 x 4 GR5	2
25	031490	Bolt, HHCS 5.8-11 x 5-1/2	4
26	E672446	Bolt, HHCS 5.8-11 x 5.0 GR5	2
27	I124589	Bolt, HHCS 5.8-11 x 7.0 GR5	14
28	020440	Nut, Hex 5.8-11 GR5 ZN	10
29	020430	Washer, Lock 5.8 Reg	6
30	V054934	Washer, Flat 5/8 Std	1
31	025670	Bolt, HHCS 5/16-18 x 3-3/4	1
32	039960	Nut, Lock 5/16-18 ZN	2
33	021630	Key, Square 3.8 x 2.3/4	1
34	516560	Key, Square 5.16 x 1-1/2	2
35	526490	Standoff, 0.62 x 1.50	2
36	523610	Cap, Roller	4
37	E724252	Bolt, SHCS (Hex), 5/16-24	2
38	530870	Spacer, 1.0 OD x 1-1/2 L	2
39	519260	Bracket Wldt, Conveyor Support	2
		Plate, Conveyor Support	2

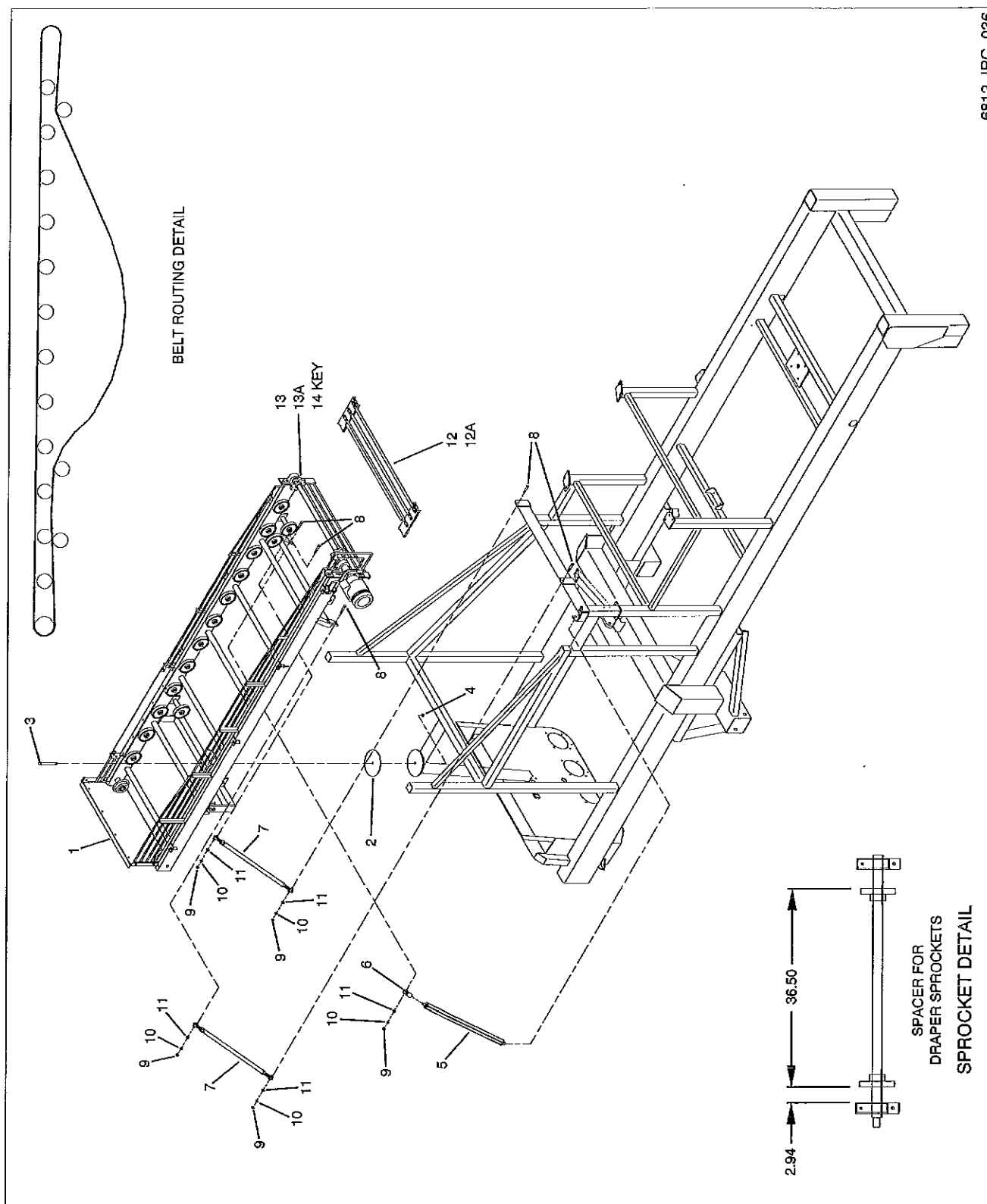
TANK AND BOOM CONVEYOR ASSEMBLIES



TANK AND BOOM CONVEYOR ASSEMBLIES

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	527180		Tank and Boom Conveyor Assemblies, 6812, (523000-90)	
2	527190		Conveyor Assy, Boom	1
3	524040		Tank Assy	1
4	R66338		Bushing, Elev. Pivot	2
5	990510		Bolt, HHCS 1-8 x 3 GR5 ZN	2
6	042180		Nut, Lock 1-B Hex GR5 ZN	2
7	990620		Washer, Flat 1.0 x 2.0 x 3/16	2
8	020430		Bolt, HHCS 5/8-11 x 2.0 GR5 ZN	10
9	020440		Washer, Flat 5/8 Std	8
10	I124589		Washer, Lock 5.8 Reg	10
11	525200		Nut, Hex 5/8-11 GR5 ZN	10
12	525570		Winch, Worm, 2000#	1
13	526500		Cable Assy, w/ Hook, 0.19 x 25 feet	1
14	012260		Pulley Block, Swivel Eye	1
15	018150		Bolt, HHCS 3/8-16 x 1.0 GR5 ZN	3
16	136970		Bolt, HHCS 3/8-16 x 1-3/4	1
17	027260		Spacer, Pulley	1
18	021180		Nut, Hex 3/8-16 GR5 ZN	4
19	021190		Washer, Lock 3.8 x 11/16	4
20	522030		Washer, Flat 3/8 Std	5
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)	1
21A	523570		Sprocket 1DT, 50mm	2
22	167920		Sprocket 10T, 56mm	2
23	523850		Key, 3.8 x 2-1/2	2
24	524270		Strap, Ladder Mount	2
25	990820		Ladder, Wldt	1
26	006690		Bolt, HHCS 3/8-16 x 3	2
			Bolt, HHCS 3/8-16 x 1-1/4	6

TRANSFER CONVEYOR ASSEMBLY

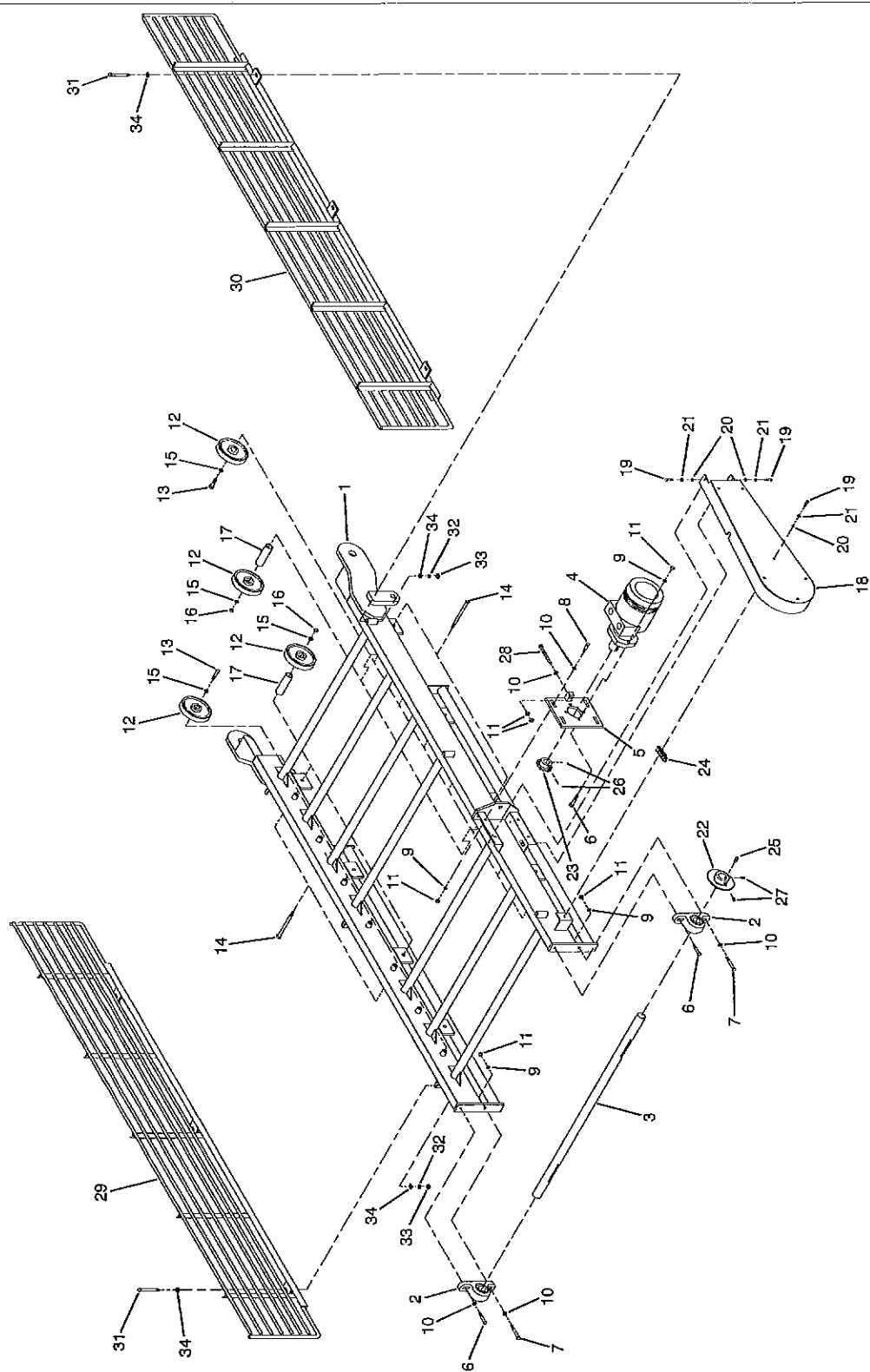


TRANSFER CONVEYOR ASSEMBLY

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	527170		Transfer Conveyor Assembly, 6812, (523000-100)	1
2	526430		Conveyor Assy, Transfer	1
3	E672088		Disk, Pivot, Wear	1
4	JK40016		Bolt, HHCS 3.4-10 x 6.0	1
			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	990560		Bolt, HHCS 3.4-10 GR5 ZN	8
9	J14H794		Nut, Hex 3.4-10 GR5 ZN	8
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	523540		Sprocket, 8T – 50mm w/ Pins	2
13A	523560		Sprocket, 8T – 56mm w/o Pins	2
14	167920		Key, Square 3/8 x 2-1/2	2

BOOM CONVEYOR UNIT

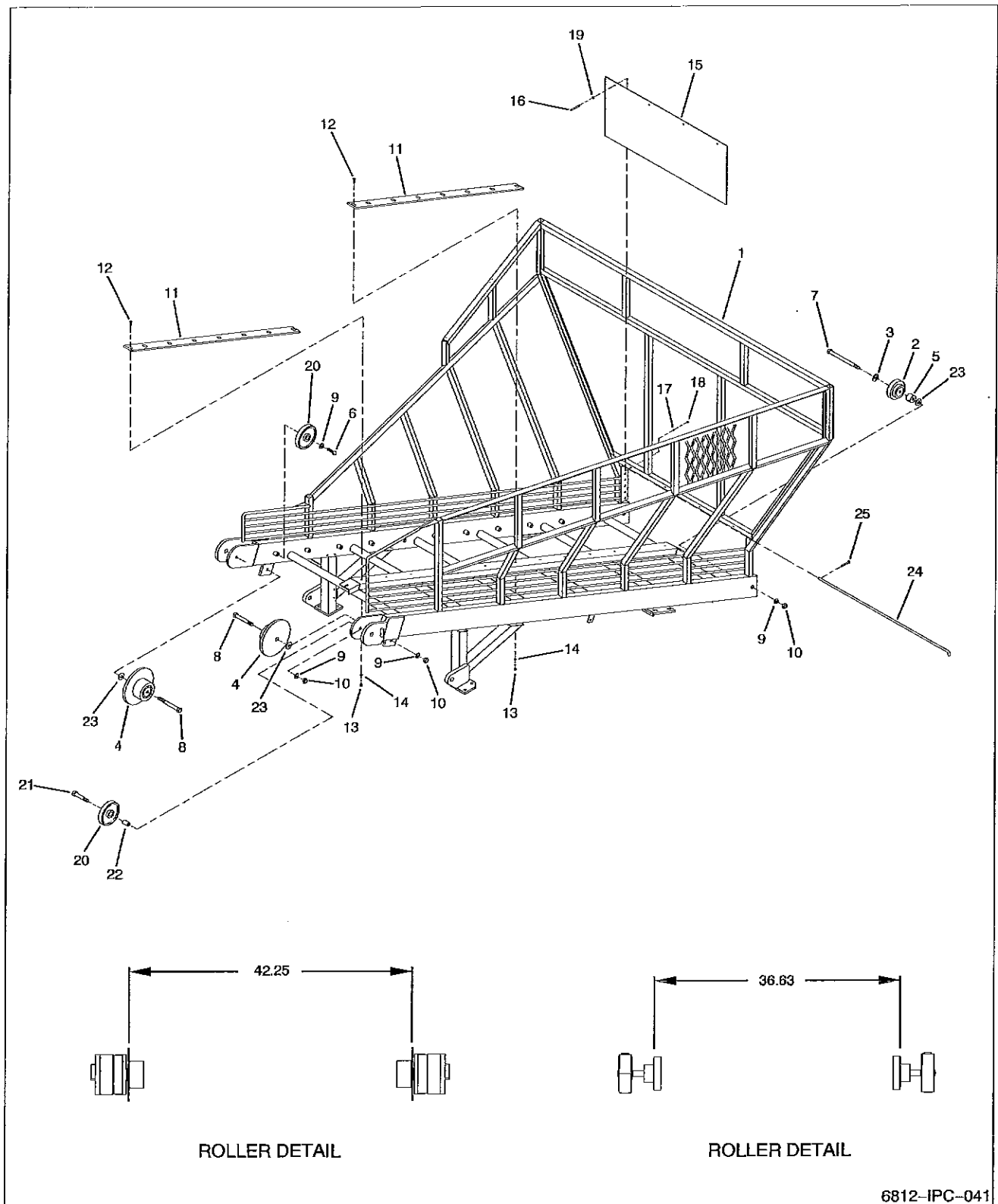
6812-IPC-040



BOOM CONVEYOR UNIT

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Boom Conveyor Unit, 6812, (527180)	
1	517480		Conveyor Wldt, Truck Boom	1
2	522940		Bearing, PB, 1.75 Wide	2
3	524560		Shaft, Drive, Boom 1.75 x 51	1
4	523530		Motor, Hyd 20, 2000, 7/8 OR	1
-4A	384850		Kit, Seal 2000 Motor	1
5	520030		Plate Wldt, Motor Mtg	1
6	023950		Bolt, HHCS 1/2-13 x 2.0 GR5	4
7	007080		Bolt, HHCS 1/2-13 x 2-1/2	2
8	E096046		Bolt, CRG 1/2-13 x 1-1/2	4
9	005370		Washer, Lock 1/2 ZN	10
10	005200		Washer, Flat 1/2 Std	9
11	005360		Nut, Hex 1/2-13 GR5 ZN	10
12	343280		Roller, Rubber 4.0 Dia	18
13	990610		Bolt, HHCS 5/8-11 x 1-1/2	14
14	990680		Bolt, HHCS 5/8-11 x 5-1/2	4
15	020440		Washer, Lock 5/8 Reg	18
16	I124589		Nut, Hex 5/8-11 GR5 ZN	4
17	JN144798		Trunion, Wheel Retainer	4
18	524570		Shield Assy, Boom Drive	1
	524580		* Panel, Outer, Boom Shield	1
	524590		* Wrapper, Boom Shield	1
	517220		* Clip, Boom Shield	1
19	012260		Bolt, HHCS 3/8-16 x 1.0 GR5	3
20	021180		Washer, Lock 3/8	3
21	021190		Washer, Flat 3/8 Std	3
22	526470		Sprocket, 60B36 1.75 Bore	1
23	276520		Sprocket, RC60B12 1.25 Inch Bore	1
24	526480		Chain, Roller #60 x 110P	1
25	013510		Key, Square 3/8 x 1-1/4	1
26	010990		Screw, HSSS 5/16-18	2
27	120970		Screw, HSSS 3/8-16	2
28	034650		Bolt, HHCS 1/2-13 x 3-1/2	1
29	527220		Grate Wldt, Boom Rear	1
30	527240		Grate Wldt, Boom Front	1
31	031870		Bolt, HHCS 1/2-13 x 3-3/4	6
32	005370		Washer, Lock 1/2	6
33	005360		Nut, Hex 1/2-13	6
34	005200		Washer, Flat 1/2 Std	12

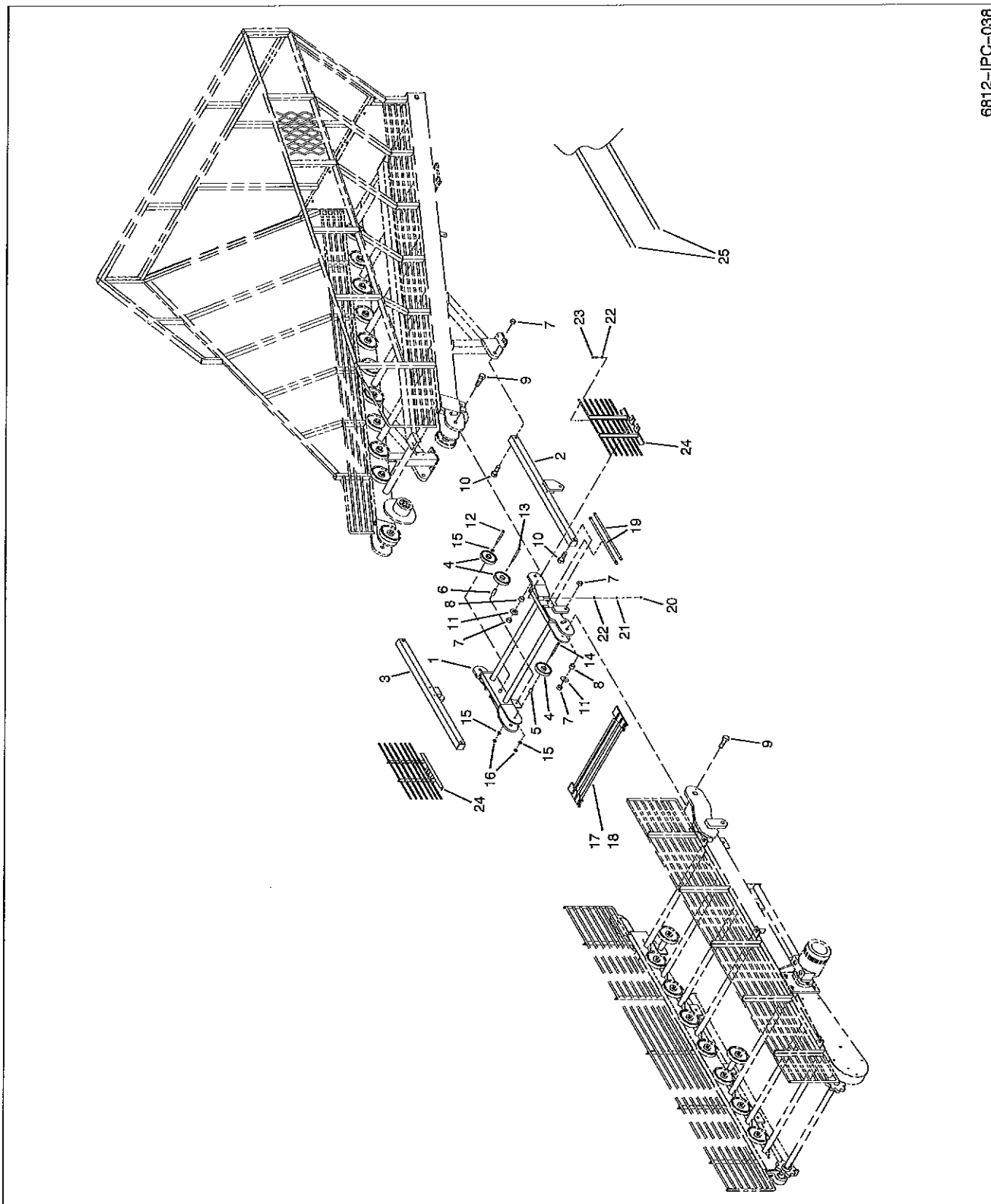
TANK ASSEMBLY



TANK ASSEMBLY

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	523740		Tank Assembly, 6812, (527190)	
2	523580		Tank Wldt, 6812 BH	1
3	526490		Roller, 5 Inch OD, 0.62 Dia Mtg.	2
4	423070		Cap, Roller	2
			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	521940		Strip, Wear, UHMW, 0.38 x 3.0, Half	2
12	E672128		Screw, FCHMS 3/8-16 GR5	16
13	027260		Nut, Hex 3/8-16 GR5 ZN	16
14	021180		Washer, Lock 3/8 x 11/16	16
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	4
18	023630		Nut, Hex 5/16-18 GR5 ZN	4
19	022920		Washer, Flat 5/16 Std	4
20	343280		Roller, Rubber 4.0 Dia	24
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

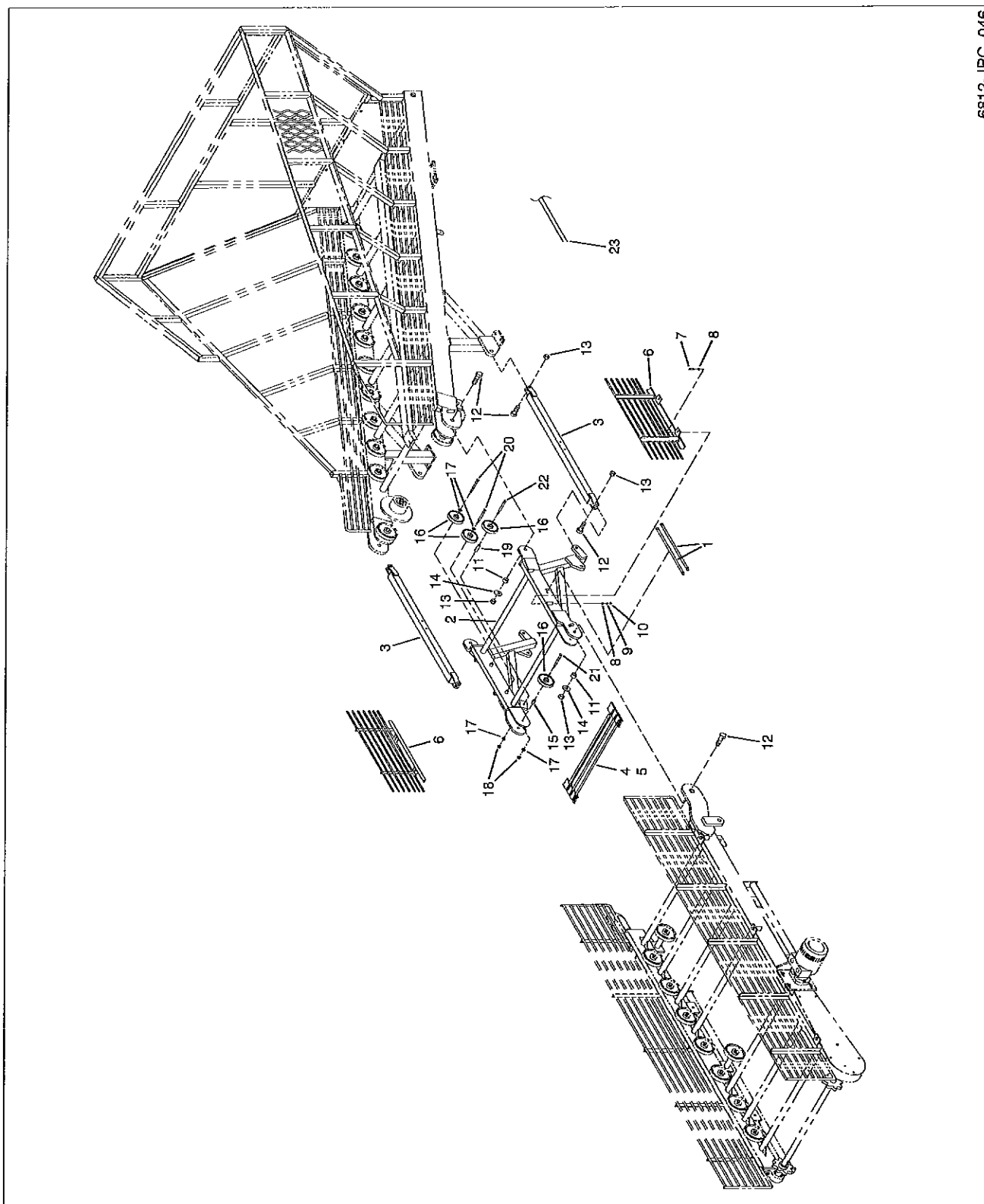
BOOM EXTENSION - 8 Row 28/30



BOOM EXTENSION - 8 Row 28/30

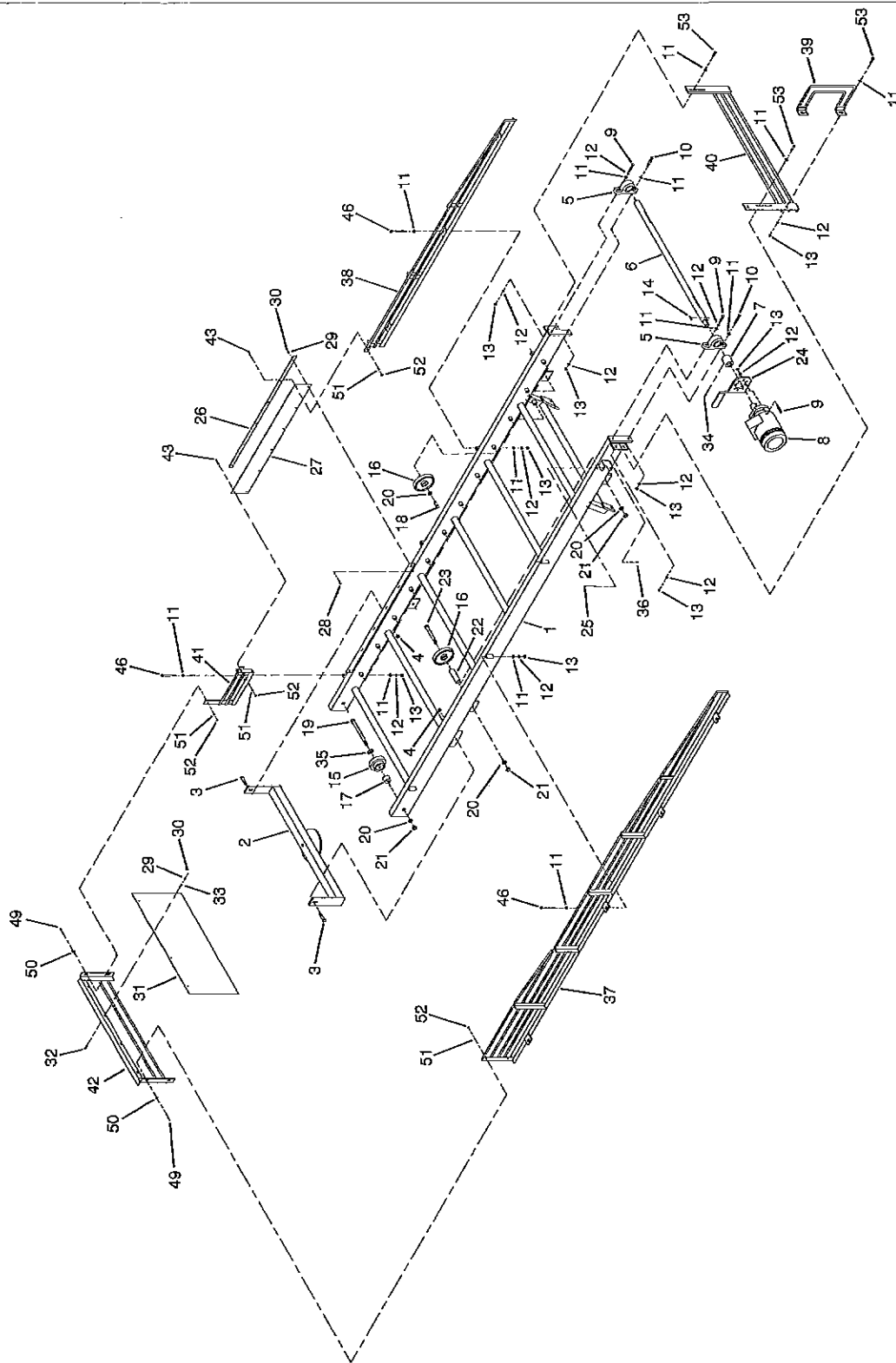
FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Boom Extension, 6812, (526790)	
1	524110		Boom Wldt 28 Inch Ext	1
2	526840		Boom Support Wldt 28 Foot Front	1
3	526850		Boom Support Wldt 28 Foot Back	1
4	343280		Roller, Rubber 4.0 dia.	6
5	E724252		Spacer, 1 OD x 5/32 x 1-1/2	2
6	JN144798		Trunion, Wheel Retainer	2
7	990510		Nut, Lock 1-8 Hex (Item from Original Elevator Mtg.)	6
8	524040		Bushing, Elev. Pivot (Item from Original Elevator Mtg.)	2
9	R66338		Bolt, HHCS 1-8 x 3 (Item from Original Elevator Mtg.)	2
10	991060		Bolt, HHCS 1-8 x 5	4
11	042180		Washer, Flat 1 x 2 x 3/16 (Item from Original Elevator Mtg.)	2
12	990610		Bolt, HHCS 5/8-11 x 1-1/2	2
13	990680		Bolt, HHCS 5/8-11 x 5-1/2	2
14	056720		Bolt, HHCS 5/8-11 x 4	2
15	020440		Washer, Lock 5/8 x 1-5/64 x 5/32	6
16	I124589		Nut, Hex 5/8-11	4
17	526590		Chain, Belted 50mm (See Draper Chain Section for Parts)	1
18	526580		Chain, Belted 56mm (See Draper Chain Section for Parts)	1
19	526820		Hose, Hyd 5/8 x 28	2
20	005360		Nut, Hex 1/2-13	4
21	005370		Washer, Lock 1/2	4
22	005200		Washer, Flat 1/2	8
23	031870		Bolt, HHCS 1/2-13 x 3-3/4	4
24	530530		Grate Wldt 28 Foot Extension	2
25	530940		Hose, Hydraulic, 1/4 x 28	2

BOOM EXTENSION – 12 Row 22



BOOM EXTENSION 12 ROW 22

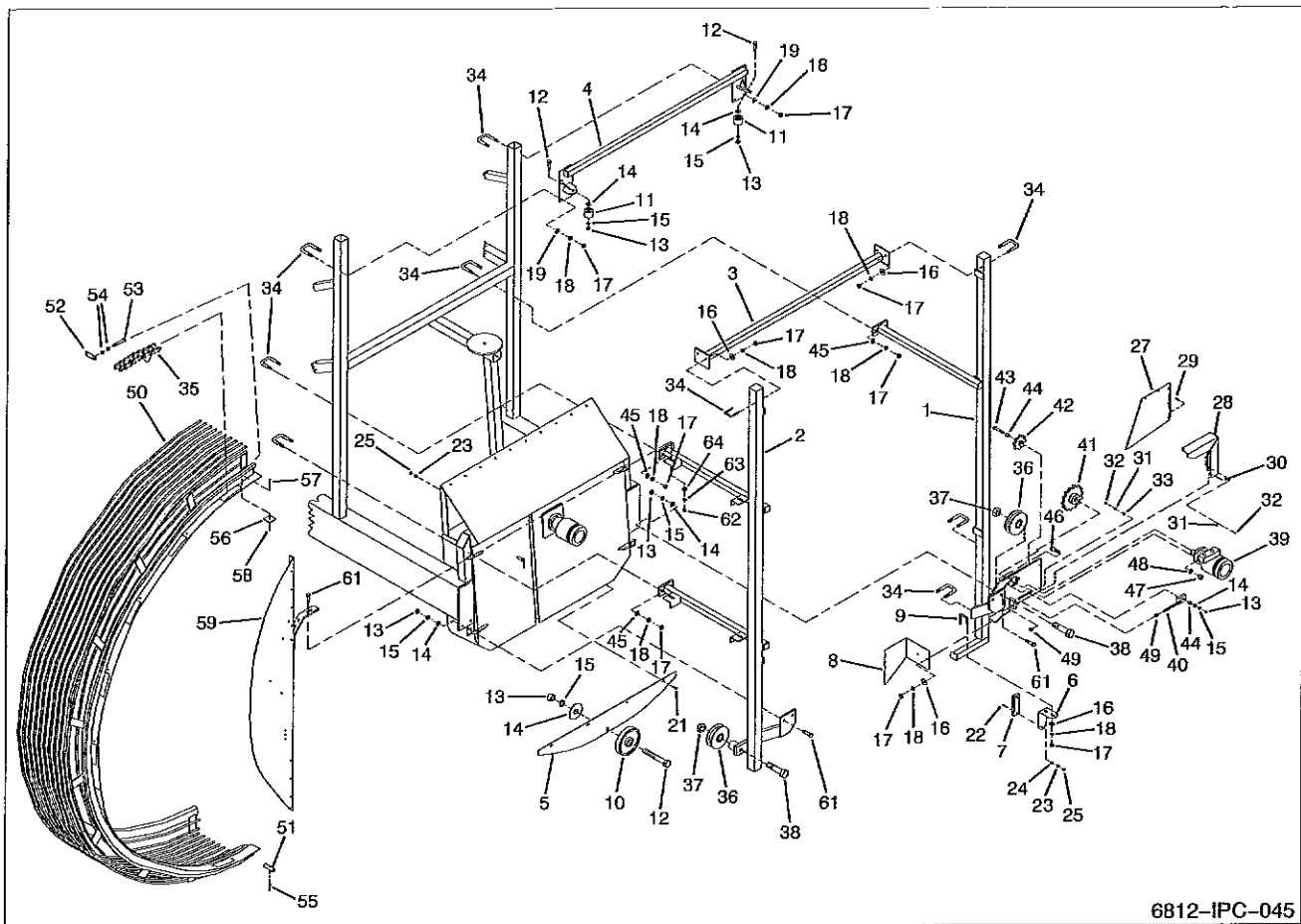
FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	526830		Boom Extension, 6812, (526800)	
2	524010		Hose, Hyd 5/8 x 44	2
3	524100		Boom Wldt 44 Inch Ext	1
4	526570		Arm Wldt, Ext. Support	2
			Chain, Belted 50mm (See Draper Chain Section for Parts)	1
5	526560		Chain, Belted 56mm (See Draper Chain Section for Parts)	1
6	530540		Grate Wldt 44 foot ext	2
7	031870		Bolt, HHCS 1/2-13 x 3-3/4	4
8	005200		Washer, Flat 1/2	8
9	005370		Washer, Lock 1/2	4
10	005360		Nut, Hex 1/2-13	4
11	524040		Bushing, Elev. Pivot (Item from Original Elevator Mtg.)	2
12	R66338		Bolt, HHCS 1-8 x 3 (Item from Original Elevator Mtg.)	6
13	990510		Nut, Lock 1-8 Hex (Item from Original Elevator Mtg.)	6
14	042180		Washer, Flat 1 x 2 x 3/16 (Item from Original Elevator Mtg.)	2
15	E724252		Spacer, 1 OD x 5/32W x 1-1/2 LG	2
16	343280		Roller, Rubber 4.0 dia.	8
17	020440		Washer, Lock 5/8	8
18	I124589		Nut, Hex 5/8-11	4
19	JN144798		Trunion, Wheel Retainer	2
20	990610		Bolt, HHCS 5/8-11 x 1-1/2	4
21	056720		Bolt, HHCS 5/8-11 x 4	2
22	990680		Bolt, HHCS 5/8-11 x 5-1/2	2
23	530910		Hose, Hydraulic, 1/4 x 44	2



TRANSFER CONVEYOR UNIT

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	516540		Transfer Conveyor Unit, 6812, (527170)	1
2	516390		Wldt, Conveyor Transfer	1
3	990620		Swivel Wldt, Transfer Elevator	2
4	038850		Bolt, HHCS 5/8-11 x 2.0 GR5	2
5	522940		Nut, Lock 5/8-11 Hex	2
6	516370		Bearing, PB, 1.75 Wide	1
7	523530		Shaft, Drive, Trans Conveyor	1
8	523530		Coupler, 1.25B, Spec	1
-8A	384850		Motor, Hyd 20, 2000, 7/B OR	1
9	023950		Kit, Seal 2000 Motor	4
10	007080		Bolt, HHCS 1/2-13 x 2.0 GR5	2
11	005200		Bolt, HHCS 1/2-13 x 2-1/2	22
12	005370		Washer, Flat 1/2 Std	18
13	005360		Washer, Lock 1/2 ZN	18
14	021630		Nut, Hex 1/2-13 GR5 ZN	1
15	523580		Key, Square 5/16 x 1-1/2	2
16	343280		Roller, 5 Inch OD, 0.62 Dia	28
17	516560		Roller, Rubber 4.0 Dia	2
18	990610		Standoff, 0.62 x 1.00	24
19	262620		Bolt, HHCS 5.8-11 x 1-1/2	2
20	020440		Bolt, HHCS 5.8-11 x 8	30
21	I124589		Washer, Lock 5/8 Reg	6
22	JN144798		Nut, Hex 5/8-11 GR5 ZN	4
23	990680		Trunion, Wheel Retainer	4
24	516650		Bolt, HHCS 5/8-11 x 5-1/2	1
25	E672388		Arm, Torque, LH	1
26	517540		Bolt, HHCS 5/16-18 x 3-1/4	1
27	517550		Strap, Inlet Flap	1
28	254060		Flap, Rubber, Inlet	6
29	023620		Bolt, CRG 5/16-18 x 1 SSN ZN	11
30	023630		Washer, Lock 5/16 x 37/64	11
31	523950		Nut, Hex 5/16-18 GR5 ZN	1
32	005900		Flap, Rubber, Elev. End	4
33	022920		Bolt, HHCS 5/16-18 GR5 ZN	4
34	523610		Washer, Flat 5/16 Std	4
35	526490		Bolt, SHCS (Hex), 5/15-24	2
36	025670		Cap, Roller Seal	1
37	527360		Nut, 5/16 Lock	1
38	527370		Grate, Upper Wldt, RH	1
39	527520		Grate, Upper Wldt, LH	1
40	527530		Grate Wldt, RH, Trans	1
41	527540		Grate Wldt, Outer, Trans	1
42	527570		Grate Wldt, Short	1
43	006690		Grate Wldt, End	2
46	031870		Bolt, 3/8-16 x 1-1/4 GR5 ZN	8
49	011370		Bolt, HHCS 1/2-13 x 3-3/4	4
50	021190		Bolt, HHCS 3/8-16 x 1-1/2	4
51	021180		Washer, Flat 3/8 Std	6
52	027260		Washer, Lock 3/8 x 11/16	6
53	030470		Nut, Hex 3/8-16 GR5 ZN	6
			Bolt, CRG 1/2-13 x 1-1/4	6

FERRIS WHEEL



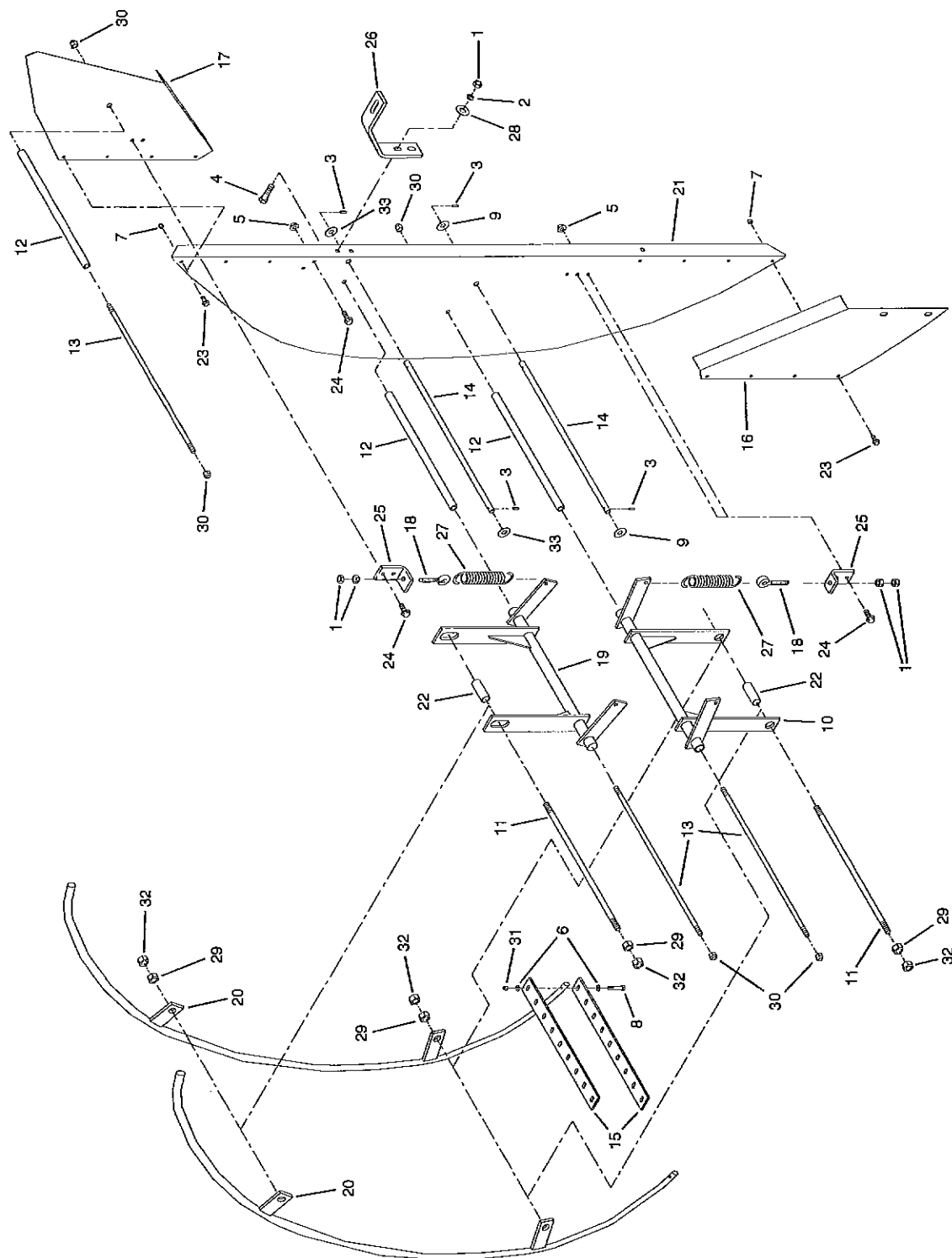
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FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	519640	Ferris Wheel, 6812, (523480)	1
2	519650	Support Wldt, RH F Wheel	1
3	519630	Tube Wldt, Upper FW	1
4	519800	Tube Wldt, Frt Upper FW	1
5	523790	Filler, Lower FW	1
6	523800	Holder, Chain Guide	1
7	523810	Bar, UHMW, Chain Guide	1
8	523820	Filler, RH Rear	1
9	290890	Bolt, U 1/2-13 x 2-1/16 x 3	1
10	343280	Roller Rubber 4.0 Dia	1
11	413970	Roller Assy, Wheel Retainer,	2
12	I271729	Bolt, HHCS 5/8-11 x 3 - 1/2	3
13	I124589	Nut, Hex 5/8 - 11 Gr5 Zn	4
14	020430	Washer, Flat 5/8 Std	4
15	020440	Washer, Lock 5/8 Reg	4
16	035210	Washer, Flat 5/8	10

FERRIS WHEEL (CONTINUED)

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
17	005360		Nut, Hex 1/2 - 13 Gr5 Zn	28
18	005370		Washer, Lock 1/2 Zn	28
19	005200		Washer, Flat 1/2 Std	8
21	032840		Bolt, CRG 3/8-16 x 3/4	4
22	J03H1558		Bolt, CRG 3/8-16 x 1-1/2	2
23	021180		Washer, Lock 3/8 x 11/16	7
24	021190		Washer, Flat 3/8 Std	2
25	027260		Nut, Hex 3/8-16 Gr5 Zn	6
27	523770		Flap, F. Wheel Shield	1
28	523870		Shield, FW Drive	1
29	028230		Screw, THMS 5/16-18 x 3/4	5
30	030030		Bolt, HHCS 5/16-18 x 1-1/4	2
31	023620		Washer, Lock 5/16 x 37/64	7
32	023630		Nut, Hex 5/16-18 Gr5 Zn	7
33	022920		Washer, Flat 5/16 Std	2
34	468370		Bolt, U 1/2 x 3.0 x 4.25 Zn	13
35	43370D		Chain Assy, Wheel Drive	1
36	433240		Roller Assy, Wheel Guide	2
37	JN144757		Nut, Wheel 1-8 Guide	2
38	990920		Bolt, HHCS 1-8 x 4-1/2 Gr5	2
39	523520		Motor, Hyd 18.7, 2000, 7/8 Dr	1
-39A	384850		Kit, Seal 2000 Motor	1
40	523720		Bracket, Take Up, F Whl	1
41	523760		Sprocket, Assy, 1.258, 14T	1
42	JAN142341		Sprocket Assy, 8T	1
43	028330		Bolt, HHCS 5/8-11 x 4-1/2	1
44	JN147291		Bushing, 0.875 x 0.656 x 0.62	2
45	035210		Washer, Flat 5/8	8
46	023950		Bolt, HHCS 1/2-13 x 2 Gr5	2
47	005360		Nut, Hex 1/2-13 Gr5 Zn	2
48	005370		Washer, Lock 1/2 Zn	2
49	I124589		Nut, Hex 5/8-11 Gr5 Zn	2
50	431750		Wheel Wldt, Half	2
51	431860		Connector, Rod, 0.56 Dia	14
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	01256D		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
61	990620		Bolt, HHCS 5/8-11 x 2 Gr5 Zn	2
62	I124589		Nut, Hex 5/8-11 Gr5 Zn	2
63	020440		Washer, Lock 5/8 Reg	2
64	020430		Washer, Flat 5/8 Std	10

RETAINER

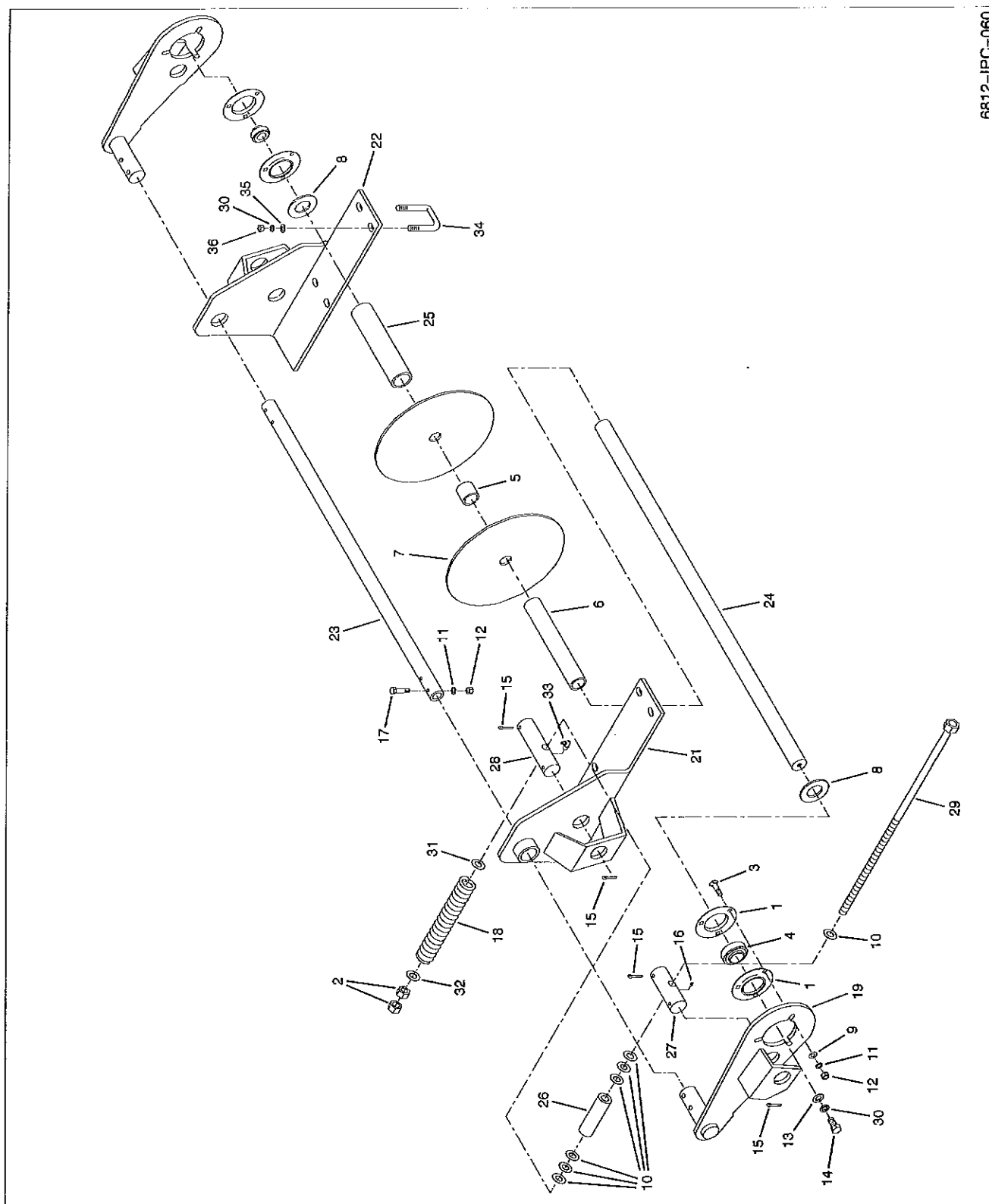


6812-IPC-061

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, L.H. Upper Retainer	1
17	520240		Side Weld, R.H. 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	2

STRIPPER

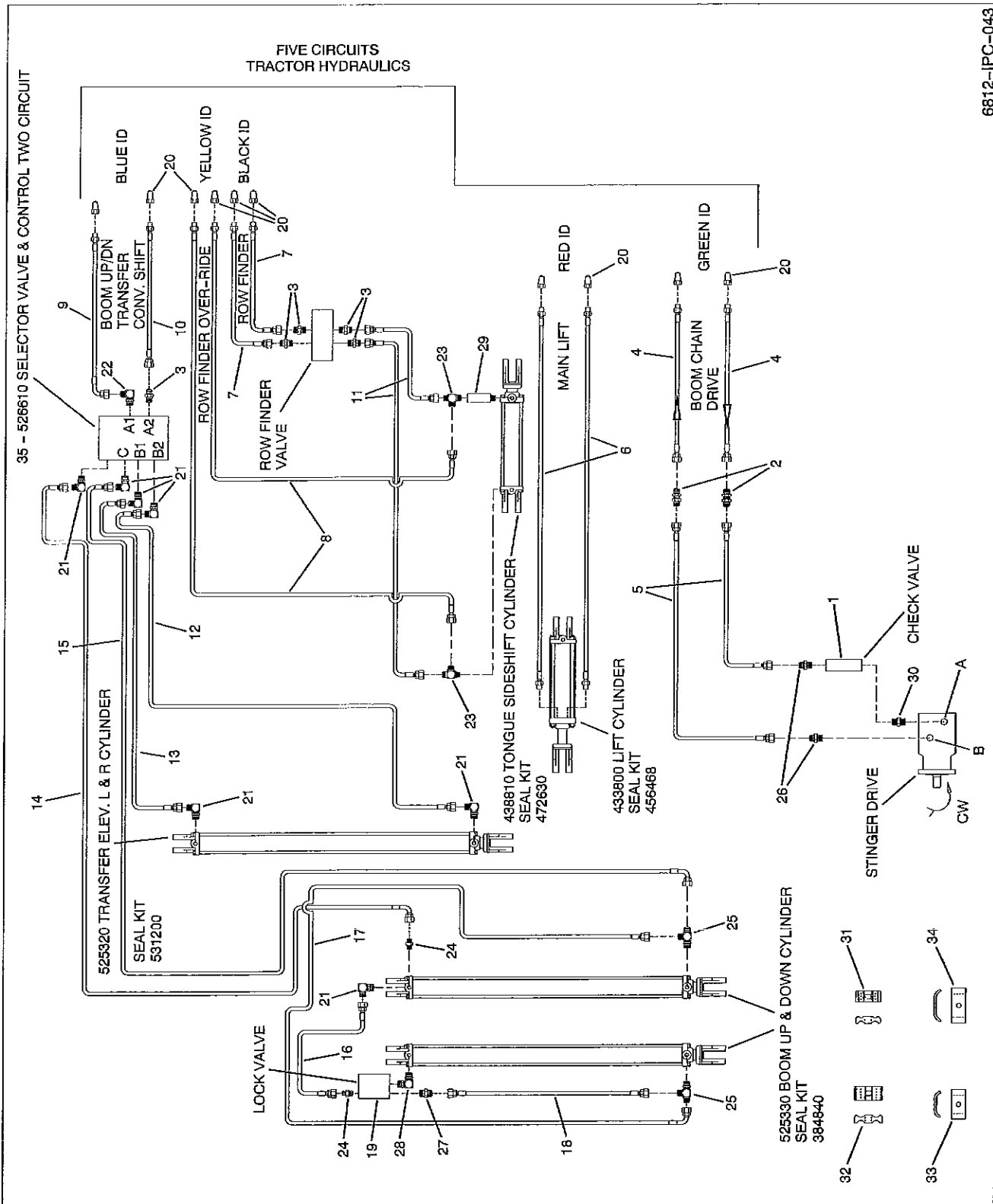


6812-IPC-060

STRIPPER

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	E281004		Stripper, 6812, (432550)	
2	I124589		Flangette, Brg. 3 Hole	4
3	J03H1558		Nut, Hex 5/8-11 Gr5 Zn	4
4	JJD9275		Bolt, CRG. 3/8-16 x 1.5 Gr5	6
			Bearing, Ball 1.38 x 2.83 x 0.74	2
5	432590		Spacer, Rotary Stripper	10
6	432570		Spacer, 1.90 OD x 1.52 ID x 10.8	1
7	JN144896		Disk, Rotary Stripper	11
8	R61502		Washer, Flat 1-3/8 STD	2
9	I120394		Washer, Flat 3/8 SAE	6
10	020430		Washer, Flat 5/8 STD	6
11	021180		Washer, Lock 3/8 Zn	10
12	023060		Nut, Lock 3/8-16 Gr5 Zn	10
13	I486801R1		Washer, Flat 17/32 x 2 x 1/4	2
14	010730		Bolt, HHCS 1/2-13 x 1.25	2
15	114370		Pin, Cotter 1/4 x 2 Zn	8
16	115590		Zerk, 1/4-28 Taper Drive	2
17	037630		Bolt, HHCS 3/8-16 x 2.5 Gr5	4
18	258560		Spring, Compr. 1.31 x 1.88	2
19	415140		Arm Wldt., RH Stripper	1
20	415150		Arm Wldt., LH Stripper	1
21	415160		Mount Wldt., RH Stripper	1
22	415170		Mount Wldt., LH Stripper	1
23	432560		Tube, Torque Stripper	1
24	432580		Axle, Disk Mount Stripper	1
25	433090		Spacer, 1.9 OD x 1.52 ID x 9.05	1
26	462130		Stop, Stripper Tube	2
27	415220		Pivot, Center Arm Strip	2
28	415230		Pivot, Center Mount Strip	2
29	415240		Bolt Wldt., 5/8 x 23 x 12 TH0	2
30	005370		Washer, Lock 1/2 Zn	4
31	I21905R1		Washer, 21/32 x 1-3/4 x 1/4	2
32	340310		Washer, 21/32 x 2 x 1/4	2
33	1100756		Zerk, 1/4-28 x 90 Degree	2
34	290890		Bolt, U 1/2-13 x 2.06 x 3.0	2
35	005200		Washer, Flat 1/2 STD Zn	4
36	005360		Nut, Hex 1/2-13 Gr5 Zn	4

TRACTOR HYDRAULIC CIRCUITS



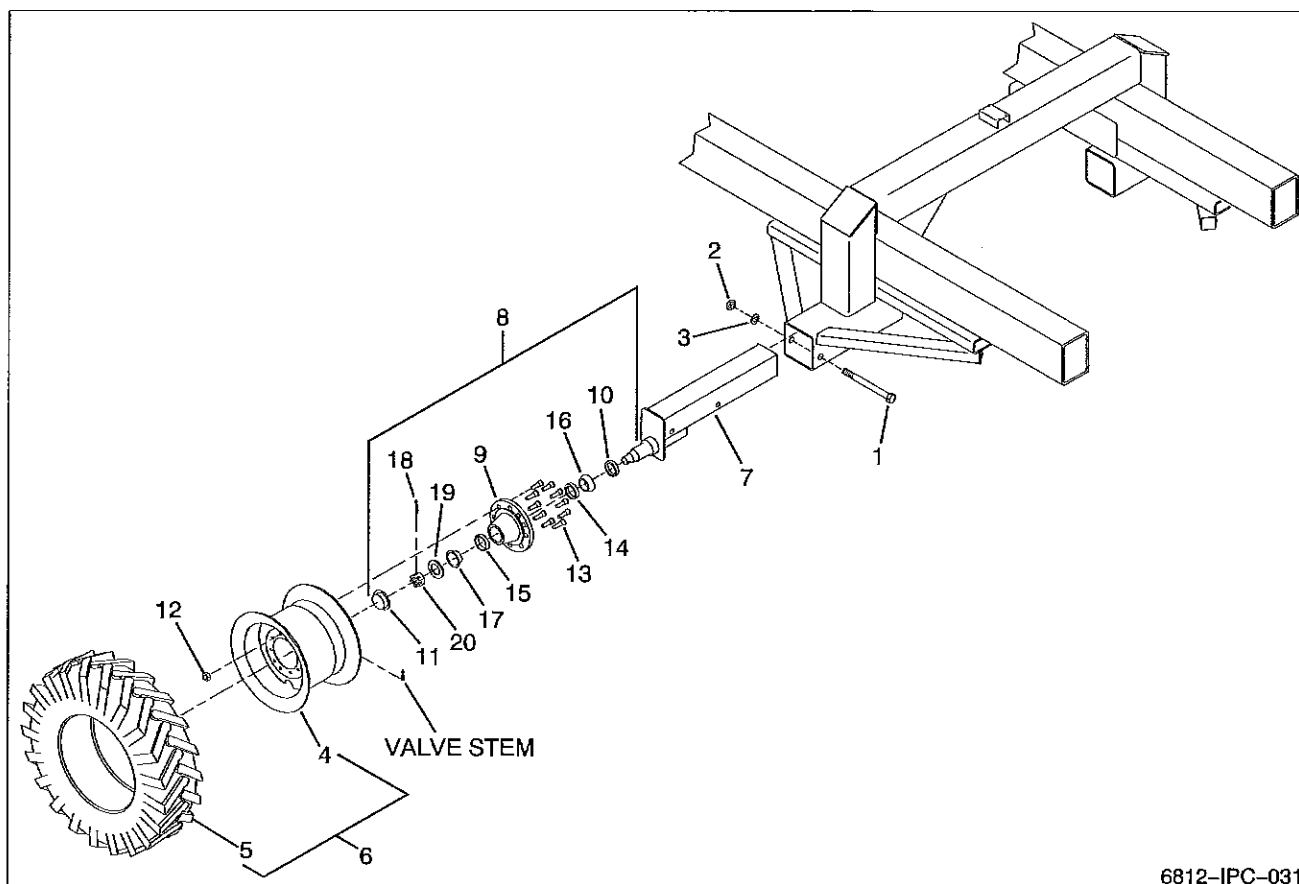
TRACTOR HYDRAULIC CIRCUITS

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			Tractor Hydraulic Circuits, 6812, (530580)	
1	530340		Check Valve #10 ORB	1
2	530350		Adapter, Bulkhead F-7/8-14JIC	2
3	530180		Adapter, STR.M-3/4-16JICXM-3/4-160R8	5
4	529930		Hose, Hyd. 5/8 x 172	2
5	529940		Hose, Hyd 5/8 x 335	2
6	529950		Hose, Hyd 1/2 x 130	2
7	529960		Hose, Hyd 1/2 x 168	2
8	529970		Hose, Hyd 1/2 x 126	2
9	530040		Hose, Hyd 1/2 x 146	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
17	530110		Hose, Hyd 1/4 x 127	1
18	530100		Hose, Hyd 1/4 x 26	1
19	530360		Valve, Lock	1
20	I1285718C2		Male Tractor Conn. x 7/8 ORB	10
21	I2185128		Adapter, 90, M-9/18JICXM-3/4-1600RB	7
22	530210		Adapter, 90, M-3/4-16JICXM-3/4-1600RB	1
23	530200		Adapter, Tee (2)M-3/4-16JICX(I)M-1/2NPT	2
24	528160		Fitting, Hyd. Str. 6MJX x 8MBO	2
25	530250		Adapter, Tee, (2)M-9/16-18JICX(I)M-3/4-1600RB	2
26	I2185062		Adapter, Str. M-7/8-14JICX7/8-14ORM	2
27	530240		Adapter, Str. M-9/16-18JICXM-9/16-1800RB	1
28	530260		Adapter, 90, (2)M-3/4-1600RM w/ Nut	1
29	419140		Restrictor, 1/2-14 M To F w/0.062R	1
30	530600		Adjustable O-Ring Hex Nipple	1
31	527690		Clamp, Small Plastic	AR
32	527700		Clamp, LG Plastic	AR
33	527670		Bar, Short	AR
34	527680		Bar, Long	AR
35	526610		Selector Valve and Control (2 Circuit)	1
			Serviceable Parts for 526610 Selector Valve and Control	
-35A	531210		Valve Block w/Coil	1
-35B	531220		Switch, V Back w/Wire	1
-35C	397030		Coil, Solenoid	1

SELF CONTAINED HYDRAULIC CIRCUITS

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
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-/16JICXM-3/4NPT	1
14	530000		Adapter, M-1-1/16-12JICXM-3/4NPT	2
15	529990		Adapter, 90, 1-1/16-12JICMX7/8-140RM	2
16	529920		Adapter, Str. 1-1/16-12JICMX1-1/16-120RM	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, 1-5/16-12JICMX1-5/16-120RBM	1
22	530330		Adapter, 90, 1-5/16JICMX1-1/4 NPTM, 90 Degree Elbow	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

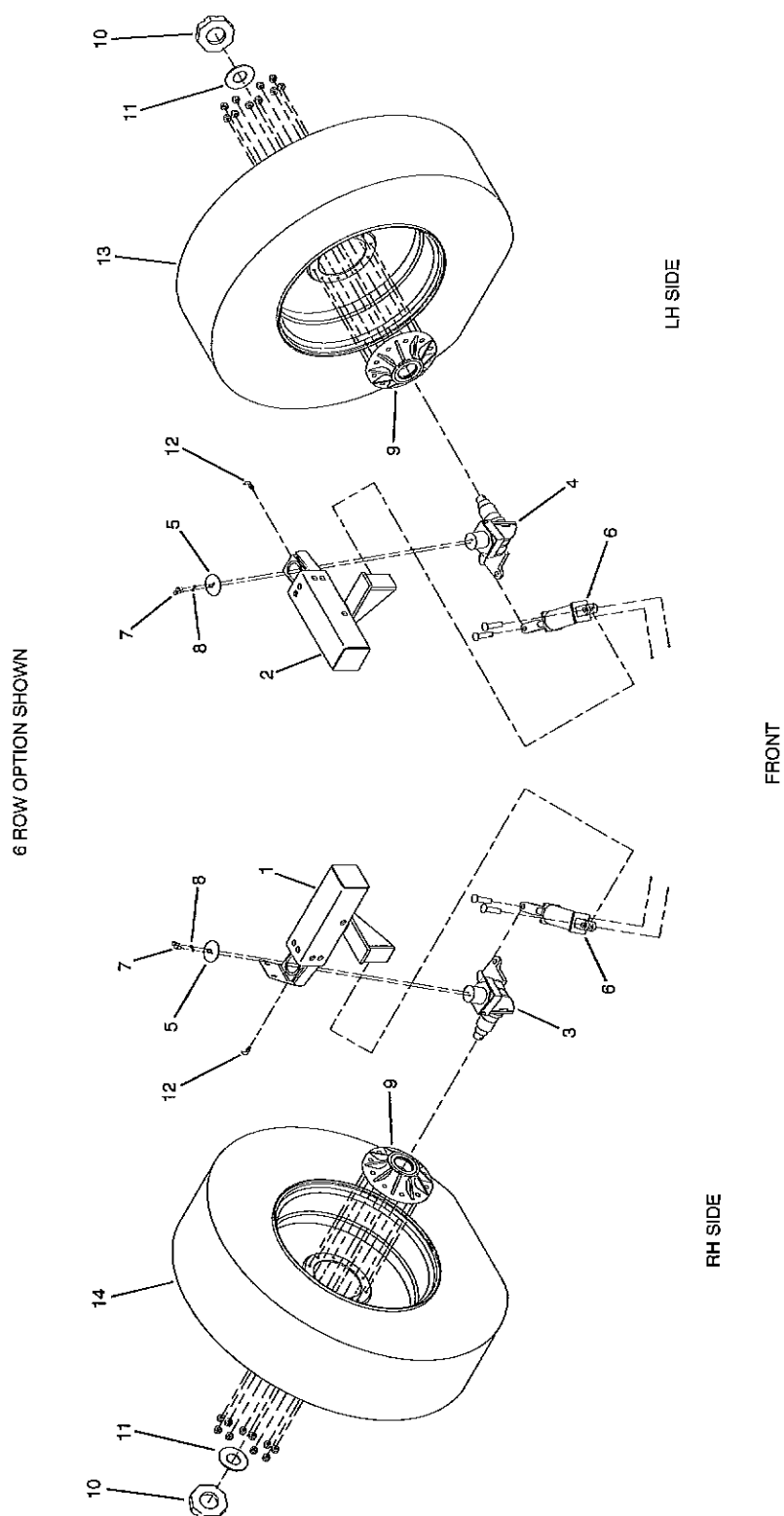
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CARRIER WHEEL ASSEMBLY

6812-IPC-031

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	525050		Carrier Wheel Assembly, 6812, (517880)	1
2	J14H824		Bolt, HHCS 1.25-7 x 10 GR5	1
3	E829047		Nut, Hex 1.25-7 GR5	1
4	522050		Washer, Lock 1.25 x 2-0.05 x 31	1
5	521920		Wheel 32 x 21, 10-13.19, 11.05	1
6	524980		Tire, 24.5-32, 12 Ply, S AT	1
6A	524990		Wheel and Tire Assembly (RH)	1
			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

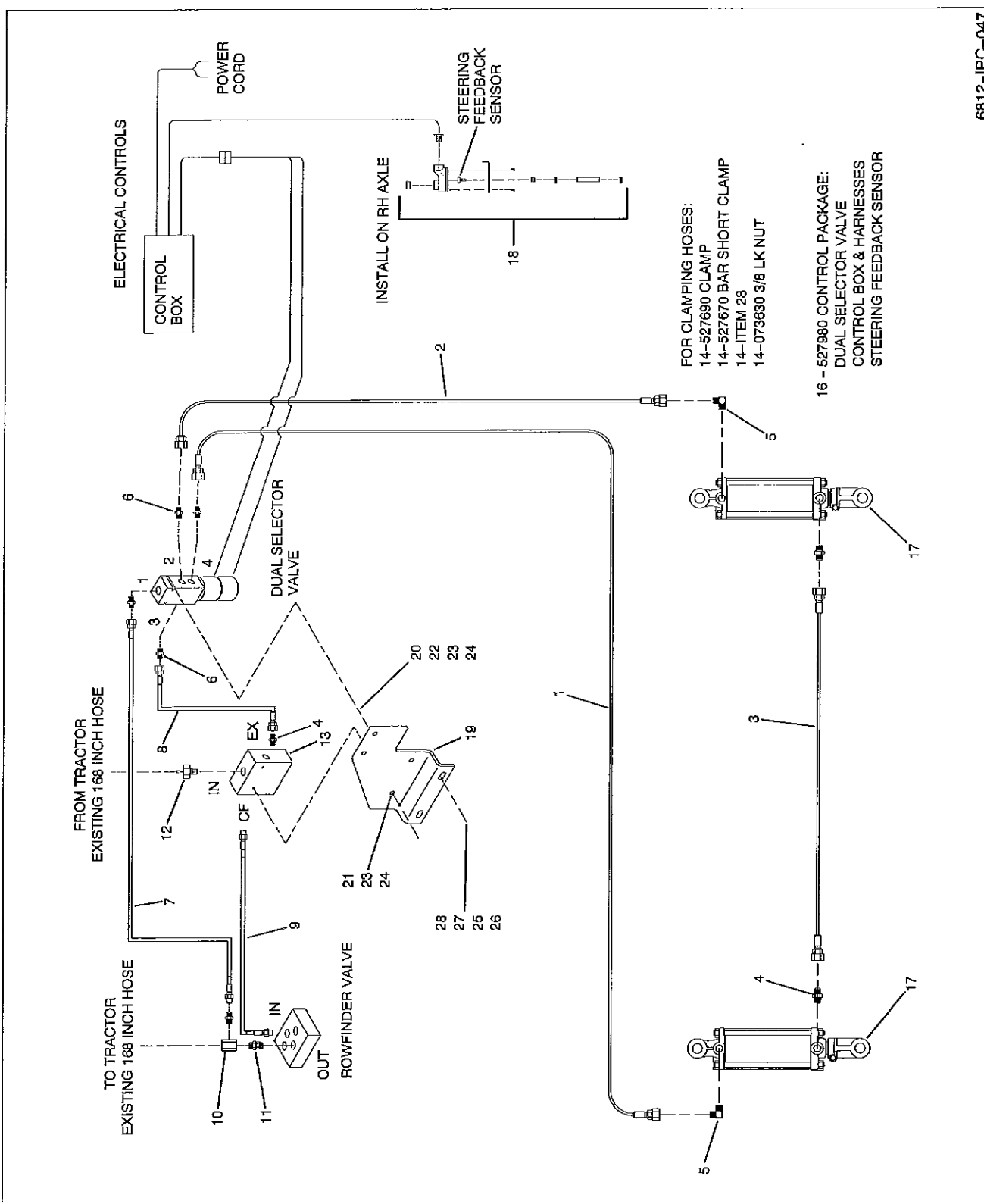
6812-IPC-048



OPTIONAL STEERING ASSEMBLY

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
	517890		Wide Option For 6R28/30 or 8R22	
1	526310		Spindle Supt Wldt, 8Row (RH)	1
2	520530		Spindle Supt Wldt, 8Row (LH)	1
3	526190		Spindle Wldt, (RH)	1
4	526200		Spindle Wldt (LH)	1
5	528220		Retainer Wldt, Top Kingpin	2
6	482510		Cylinder, Hyd	2
7	012260		Bolt, HHCS 3/8-16 x 1	4
8	021180		Washer, Lock	4
9	522060		Hub Assembly, 10 Bolt (See Carrier Wheel Assembly for Parts)	2
10	522120		Nut, Castle, 2-12	2
11	522130		Washer, Flat	2
12	1100756		Fitting, 1/4-28 90 deg.	2
13	524980		Wheel and Tire Assembly (LH)	1
14	524990		Wheel and Tire Assembly (RH)	1
	522050		* Wheel 32 x 21, 10-13.19, 11.05	1
	521920		* Tire, 24.5-32, 12 Ply, S At	1
	527970		Narrow Option For 6R22/24	
1	526060		Spindle Supt Wldt, 8Row (RH)	1
2	526070		Spindle Supt Wldt, 8Row (LH)	1
3	526190		Spindle Wldt, (RH)	1
4	526200		Spindle Wldt (LH)	1
5	528220		Retainer Wldt, Top Kingpin	2
6	482510		Cylinder, Hyd	2
7	012260		Bolt, HHCS 3/8-16 x 1	4
8	021180		Washer, Lock	4
9	522060		Hub Assembly, 10 Bolt (See Carrier Wheel Assembly for Parts)	2
10	522120		Nut, Castle, 2-12	2
11	522130		Washer, Flat	2
12	1100756		Fitting, 1/4-28 90 deg.	2
13	527950		Wheel and Tire Assembly (LH)	1
14	527960		Wheel and Tire Assembly (RH)	1
	527940		* Wheel 16 x 38, 11-13.19, 11.05	1
	527930		* Tire, 480/80R38, Ultra Torq	1

HYDRAULIC STEERING COMPONENTS



6812-IPC-047

HYDRAULIC STEERING COMPONENTS

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
			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 Str	3
5	528150		Fitting, Hyd 90	2
6	528160		Fitting, Hyd Str	5
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	1
11	JAN131153		Connector Assy	1
12	423800		Fitting, Hyd	1
13	006300		Flow Control, Full Range	1
14	527690		Clamp	AR
14	527670		8ar Short Clamp	AR
14	073630		Nut, 3/8 Lock	AR
14	J03H1558		Bolt, CRG 3/8-16 x 1-1/2	AR
16	527980		Control Package	1
17	482510		Cylinder, Hyd	2
18	528210		Box Assembly	1
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	4
23	027660		Nut, Hex 1/4-20	4
24	029440		Washer, Lock	4
25	021180		Washer, Lock	2
26	027260		Nut, Hex 3/8-16	2
27	021190		Washer, Flat	2
2B	J03H1558		Bolt, CRG 3/8-16 x 1-1/2	2

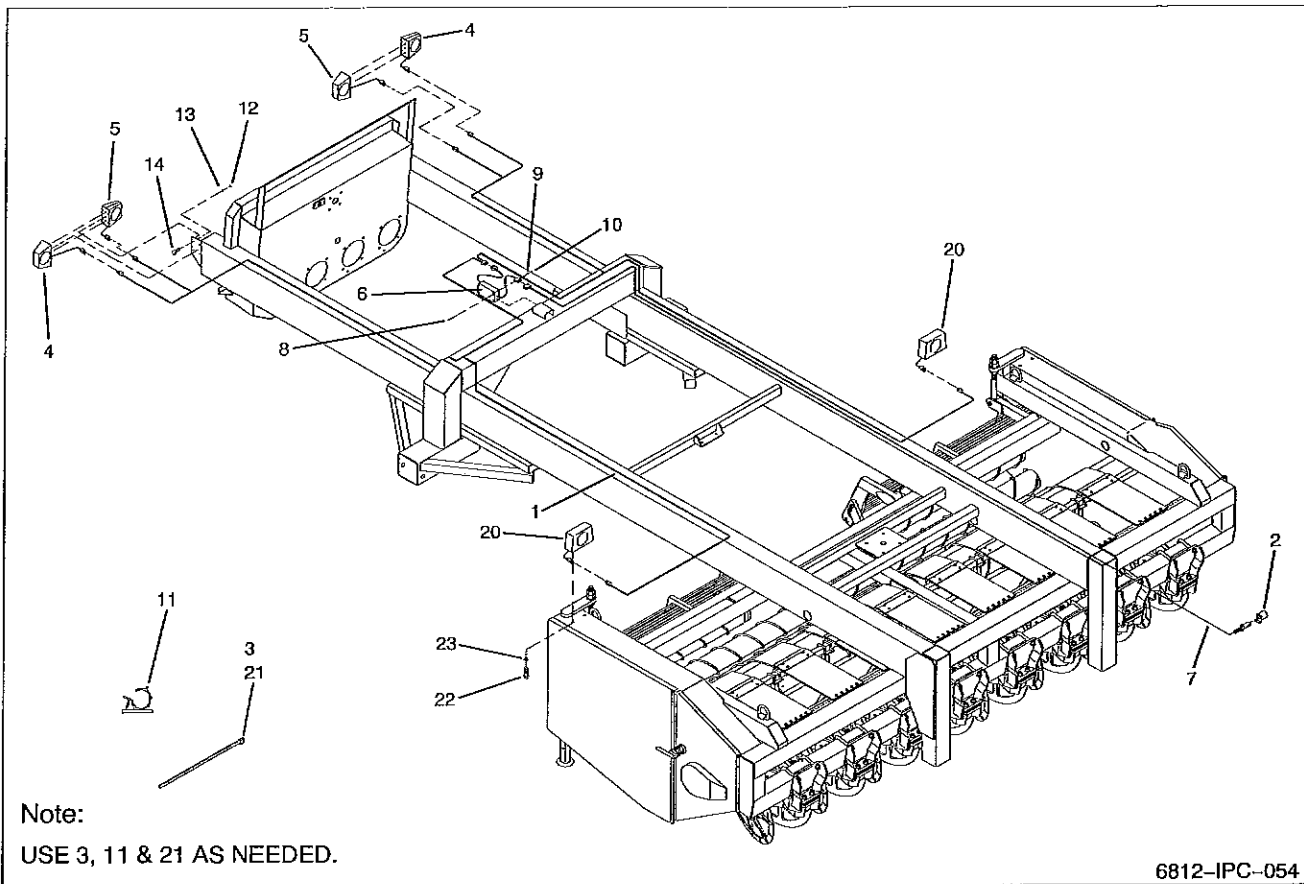
SAFETY LIGHTS

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

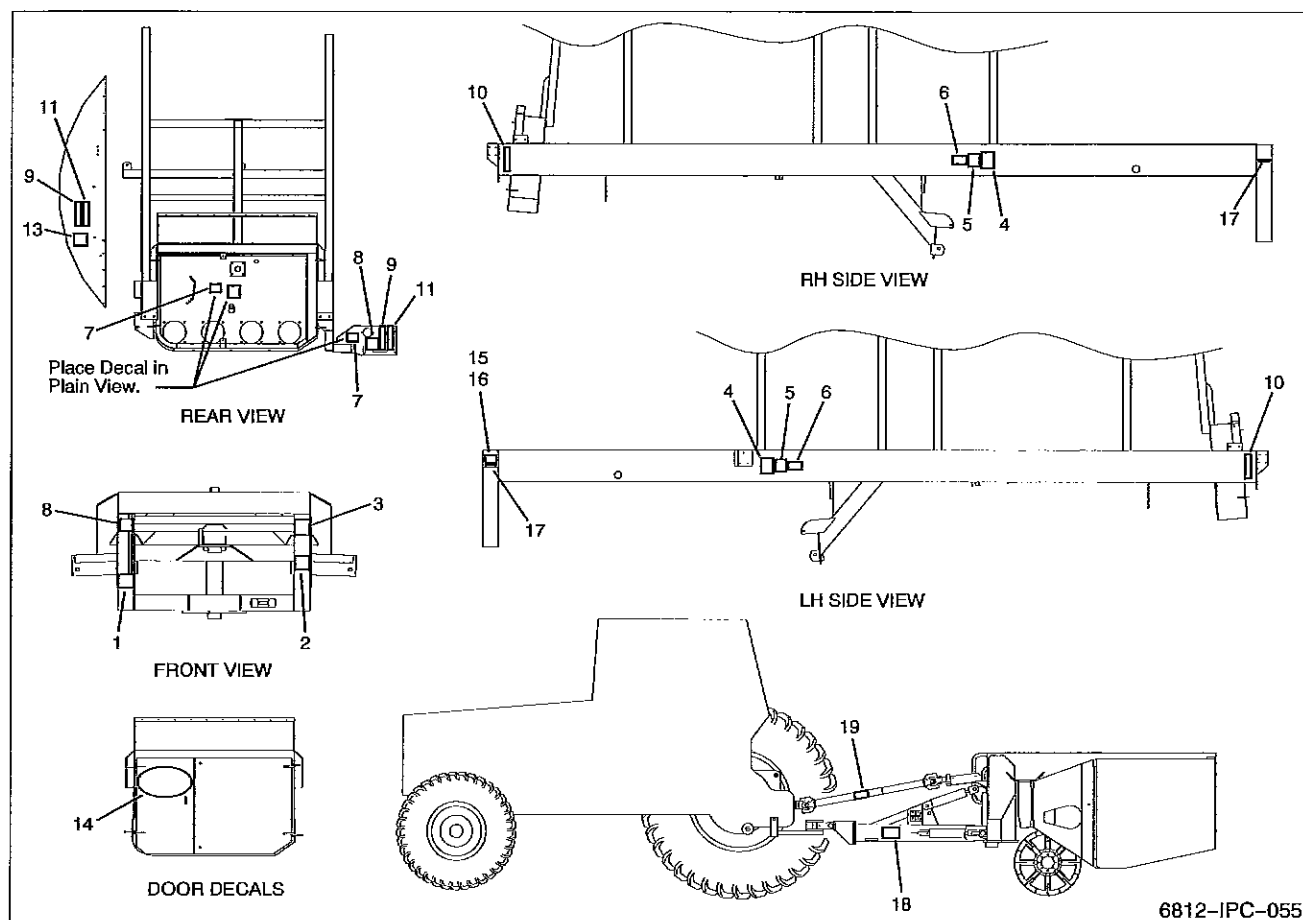


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	345420		Harvester Decals, 6812, (530810)	1
2	346310		Decal, Rowfinder Instructions	1
3	368040		Decal, Warning High Pressure Fluid	1
4	467400		Decal, Caution Safety Instructions	1
5	467410		Decal, Warning Flying Object	2
6	467420		Decal, Danger Rotating Roll	2
7	467430		Decal, Warning Riders Falling	2
8	467450		Decal, Danger Shield Missing	2
9	476450		Decal, Warning Moving Part	1
10	476460		Tape, Red Reflector	2
11	476470		Tape, Yellow Reflector	2
13	510730		Tape, Red-Orange Reflector	2
14	519480		Decal, Warning Ferris Wheel	1
15	355500		Decal, Art's-Way Logo	1
16	204510		Tag, Serial Number	1
17	133420		Nail, 1/4 Grip	4
18	467460		Patent Pending	2
19	226860		Decal, Caution, Hitch	1
			Decal, Danger, Rotating Driveline	1

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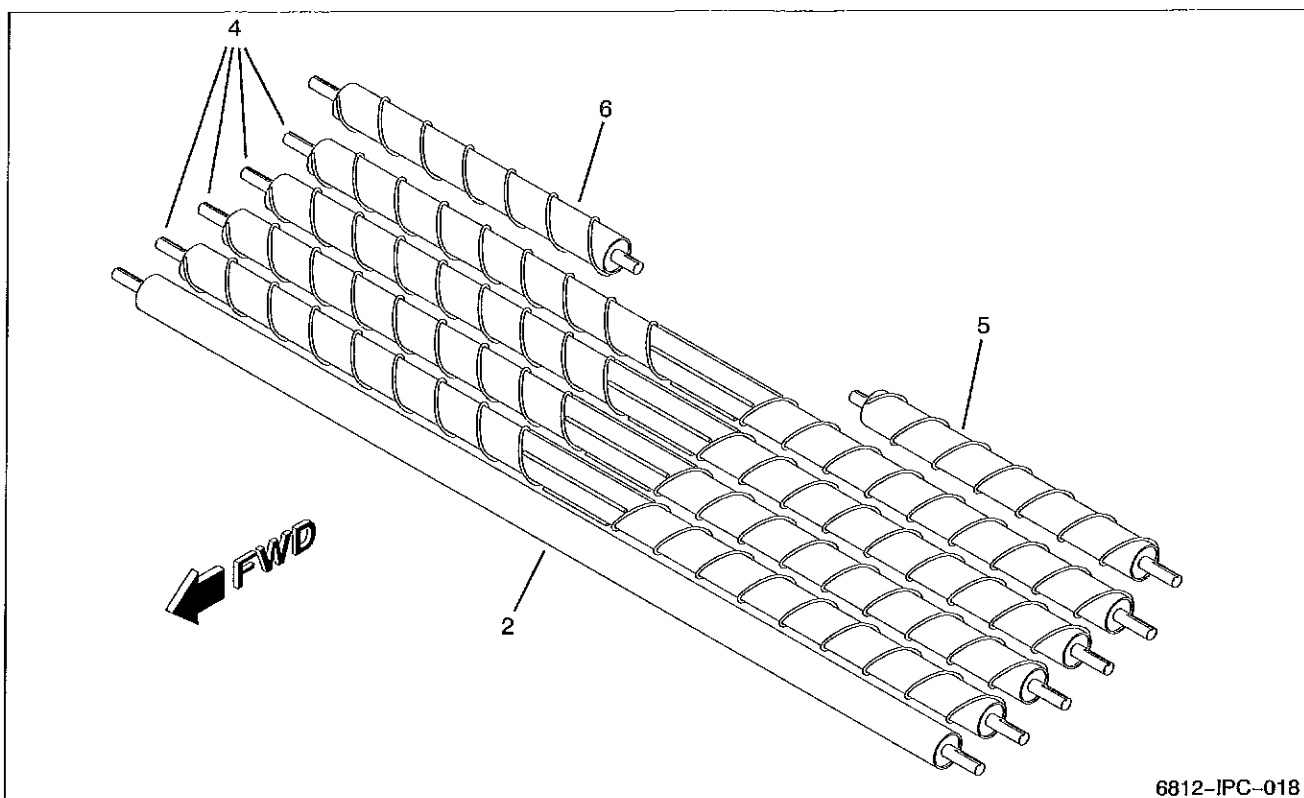
SECTION 2: HEAD ASSEMBLIES

6 ROW 22/24 NON-ADJUSTABLE (6R22/24)

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

8 ROW 28/30 NON-ADJUSTABLE (8R28/30)

12 ROW 22 NON-ADJUSTABLE (12R22)

ROLLER GROUPING (6R22/24)

6812-IPC-018

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
-1	525740	Roller Grouping, Smooth 6R22/24 Head				1
2	527160	* Roll Wldt, 6.62 x 136.50 6R22				1
-3	525810	Grabroll Grouping, Steel 6R22/24 Head				1
4	527130	* Roll Weld, Conveyor Steel 6R22 (#1-#4)				4
5	527140	* Roll Weld, Diverter 6R22 LH 6812				1
6	527150	* Roll Weld, Diverter 6R22 RH 6812				1

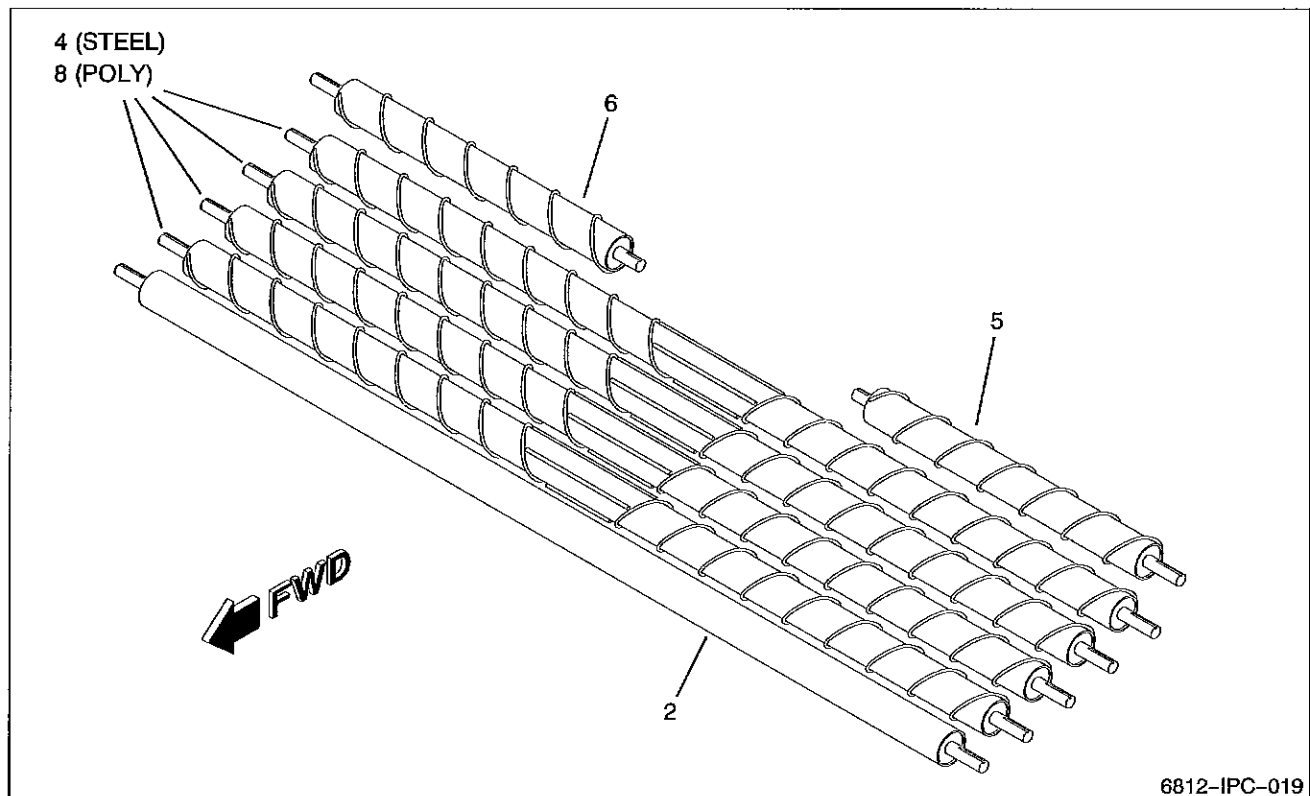
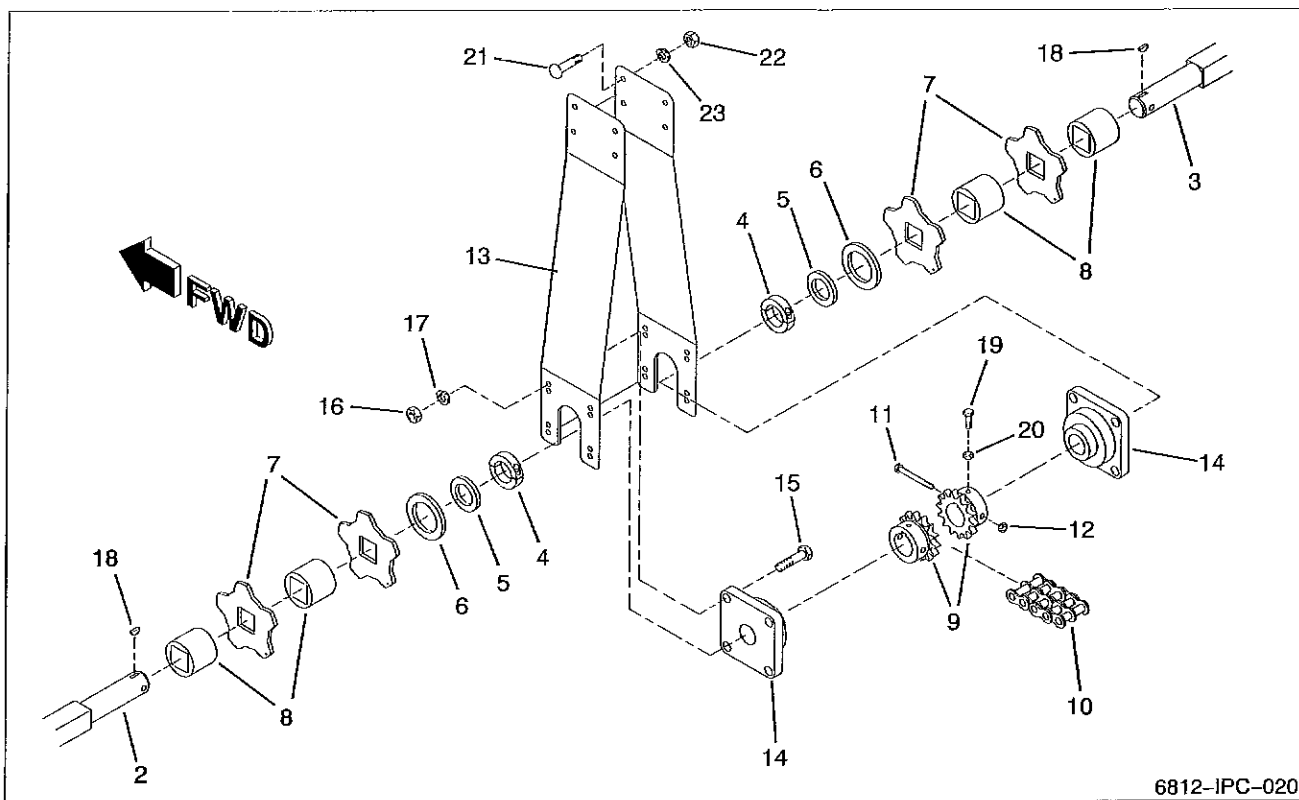
6 ROW 28/30 ADJUSTABLE AND 8 ROW 22 ADJUSTABLE**ROLLER GROUPING – SMOOTH AND GRABROLL (6R28/30, 8R22)**

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
-1	525750	Roller Grouping, Smooth				1
2	503440	* Roll Wldt, Smooth, 6.62 OD x 170.5				1
-3	525820	Grabroll Grouping, Steel				1
4	521870	* Roll Wldt, Conv. Steel 6R30/8R22 (#1-#4)				4
5	521890	* Roll Wldt, Diverter Steel 6R30/8R22 LH				1
6	521900	* Roll Wldt, Diverter Steel 6R30/8R22 RH				1
-7	525850	Grabroll Grouping, Poly				1
8	525870	* Roll Wldt, Conveyor Poly 6R30/8R22 (#1-#4)				4

6 ROW 28/30 ADJUSTABLE AND 8 ROW 22 ADJUSTABLE

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



6812-IPC-020

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
-1	525780		Roller Grouping, Star	1
2	524190		* Shaft, LH Star Roll 1.75 x 89.00	1
3	524200		* Shaft, RH Star Roll 1.75 x 91.53 Drive	1
4	287700		* Lock Collar, Split 1.75 Bore	4
5	E126034		* Bushing, Mach 1-7/8 x 2-7/8 x 10 GA PLN	4
6	E126201		* Bushing, Mach 2.5 x 3.87 x 0.134	4
7	475490		* Plate, Star	56
8	287600		* Spacer, Rubber	54
9	287610		* Sprocket, H60B14 1.78 Bore	2
10	163770		* Chain, 60-2 14 Pitches Incl Conn	1
11	340360		* Bolt, HHCS 3/8-16 x 3-1/2 Gr8 ZN	2
12	I359783C1		* Nut, Lock 3/8 Gr8 Hex Top 2-Way	2
13	520630		* Mount Wldt, Center Brg Mtg	1
14	522960		* Bearing, Flg 4H, 1.75, Wide, Ecc, Triple	2
15	023950		* Bolt, HHCS 1/2-13 Gr5 ZN	8
16	005360		* Nut, Hex 1/2-13 Gr5 ZN	8
17	005370		* Washer, Lock 1/2 ZN	8
18	231950		* Key, Woodruff (1222-1), 3/8 x 2-3/4	2
19	R61566		* Screw, SQHSS 3/8-16 x 3/4 Knurled BL0+	2
20	I124829		* Nut, Jam 3/8-16 Finished Hex Gr5 ZN	2
21	023110		* Bolt, HHCS 5/8-11 x 2-1/2 Gr5 ZN	4
22	I1245B9		* Nut, Hex 5/8-11 Gr5 ZN	4
23	020440		* Washer, Lock 5/8 Reg x 1-5/64 x 5/32 ZN+	4

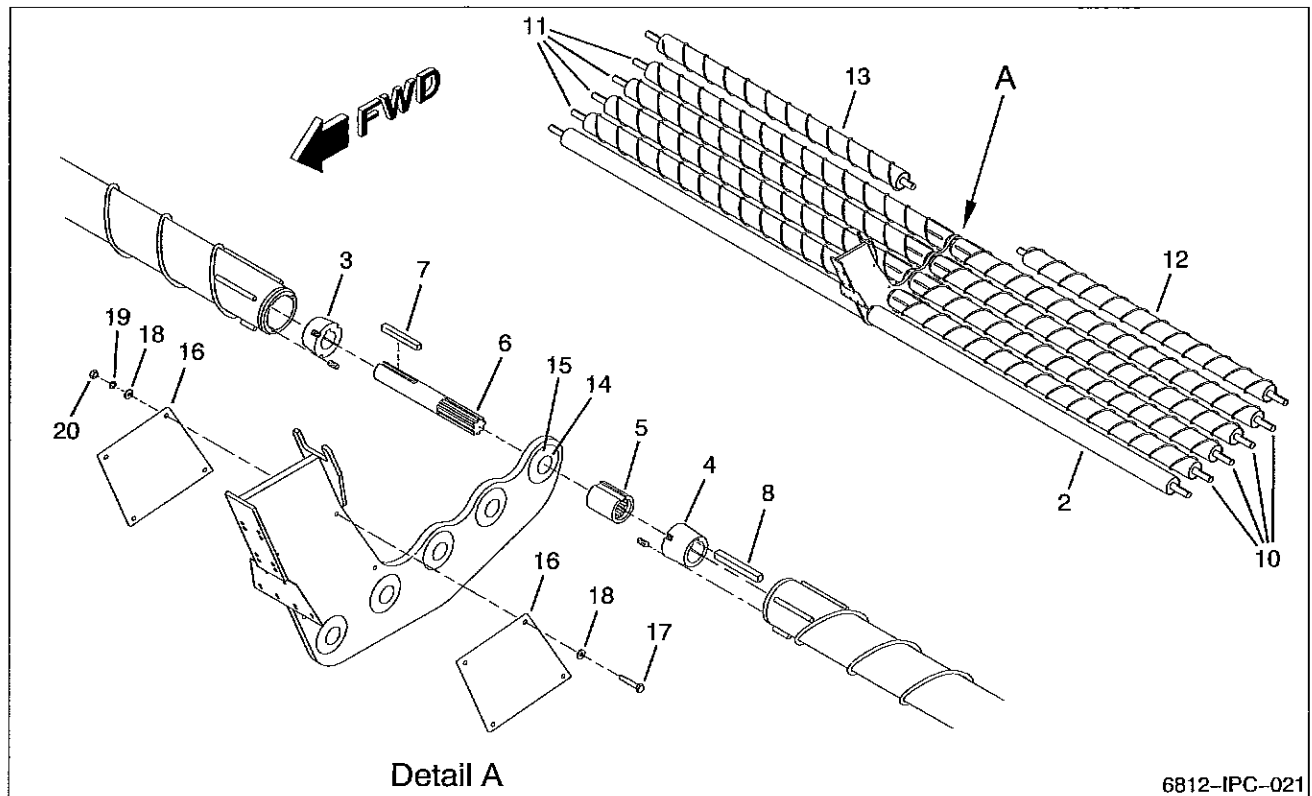
8 Row 28/30 Non-Adjustable**ROLLER GROUPING – SMOOTH AND GRABROLL (8R28/30)**

FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
-1	525760		Roller Grouping, Smooth 8R28/30 Head	
2	527110		* Roll Wldt, Smooth, 5 Inch Sch40 x 111.50	2
3	524350		* Bushing Taper Lock 3030 1-3/4 Bore 3/8 KW	1
4	524360		* Bushing Taper lock 3030 2-3/4 Bore 5/8 KW	1
5	524390		* Sleeve, Shaft 1-3/4-27 Spl ID x 2.75 OD 5/8 KW	1
6	524400		* Shaft, 1-3/4 Dia 3/8 KW 1-3/4-27 Spl x 10.00	1
7	030380		* Key, Square 3/8 x 3	1
8	524150		* Key, Square 5/8 x 3	1
-9	525830		Grabroll Grouping, Steel 8R28/30	
10	527070		* Roll Wldt, Conveyor Steel 8R30 LH (#1-#4) 6812	4
11	527080		* Roll Wldt, Conveyor Steel 8R30 RH (#1-#4) 6812	4
12	527090		* Roll Wldt, Diverter 8R30 LH 6812	1
13	527100		* Roll Wldt, Diverter 8R30 RH 6812	1
14	522920		* Bearing, Ball 1-3/4 Wide SOD Ecc Tri	5
15	520880		* Holder, Bearing (In Weldment)	5
16	521980		* Sheet, UHMW CTR Head	2
17	007080		* Bolt, HHCS 1/2-13 x 2-1/2 Gr5 ZN	4
18	005200		* Washer, Flat 1/2 Std	8
19	005370		* Washer, Lock 1/2 ZN	4
20	005360		* Nut, Hex 1/2-13 Gr5 ZN	4

8 ROW 28/30 Non-ADJUSTABLE

ROLLER GROUPING – STAR ROLLER (8R28/30)

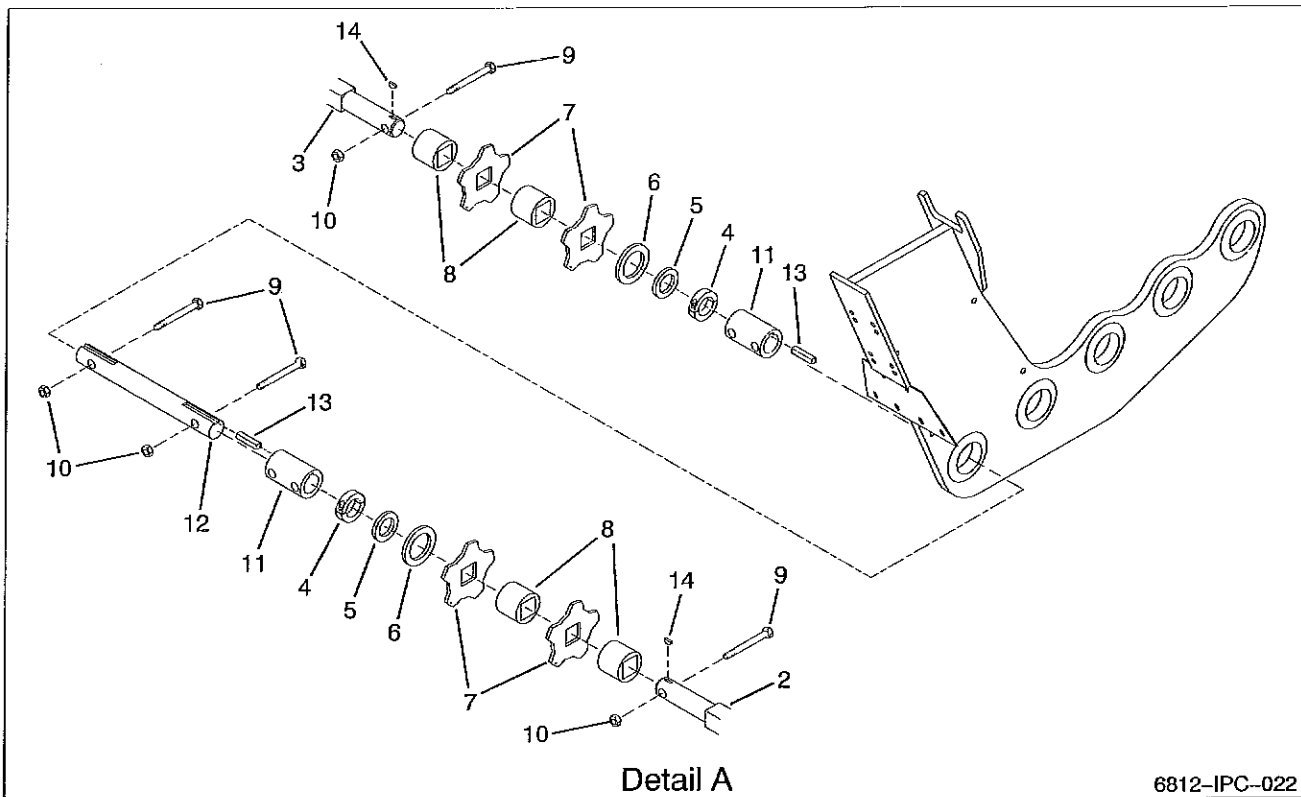


FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		*	*	*	*	
-1	525790	Roller Grouping, Star Roller 8R28/30 Head				1
2	524210	* Shaft, LH Star Roll 1.75 x 118.00				1
3	524220	* Shaft, RH Star Roll 1.75 x 120.53 Drive				1
4	287700	* Lock Collar, Split 1.75 Bore				2
5	E126034	* Bushing, Mach 1-7/8 x 2-7/8 x 10 GA PLN				2
6	E126201	* Bushing, Mach 2.5 x 3.87 x 0.134				2
7	475490	* Plate, Star				74
8	287600	* Spacer, Rubber				74
9	340360	* Bolt, HHCS 3/8-16 x 3-1/2 Gr8 ZN				4
10	I359783C1	* Nut, Lock 3/8 Gr8 Hex Top 2-Way				4
11	524130	* Coupler Shaft 3.0 OD x 1.75 ID .38 KW				2
12	524140	* Shaft, Ctr 1.75 Dia x 10.00 .38 KW				1
13	036940	* Key, Square 3/8 x 3-1/2				2
14	231950	* Key, Woodruff (1222-1), 3/8 x 2-3/4				2
-15	R61566	* Screw, SQHSS 3/8-16 x 3/4 Knurled BLO				2

ROLLER GROUPING – SMOOTH AND GRABROLL (12R22)

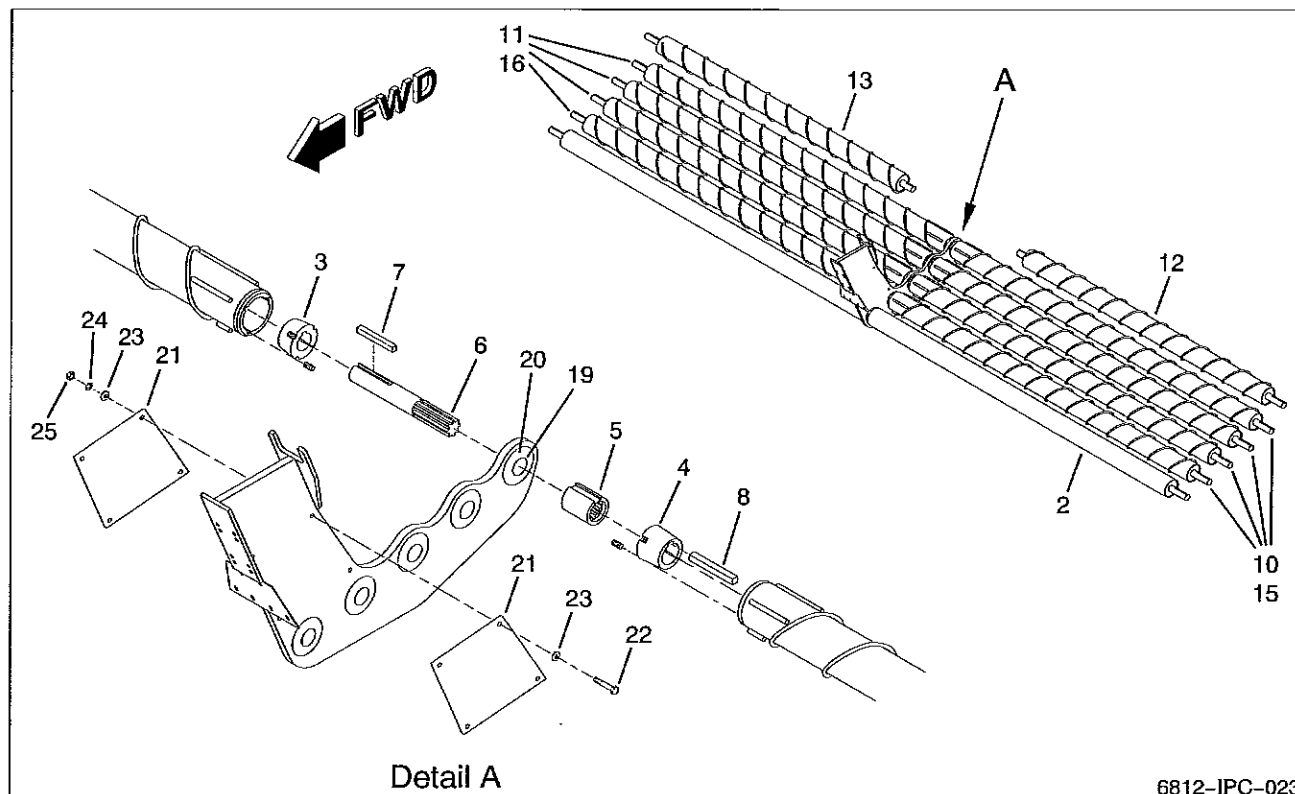
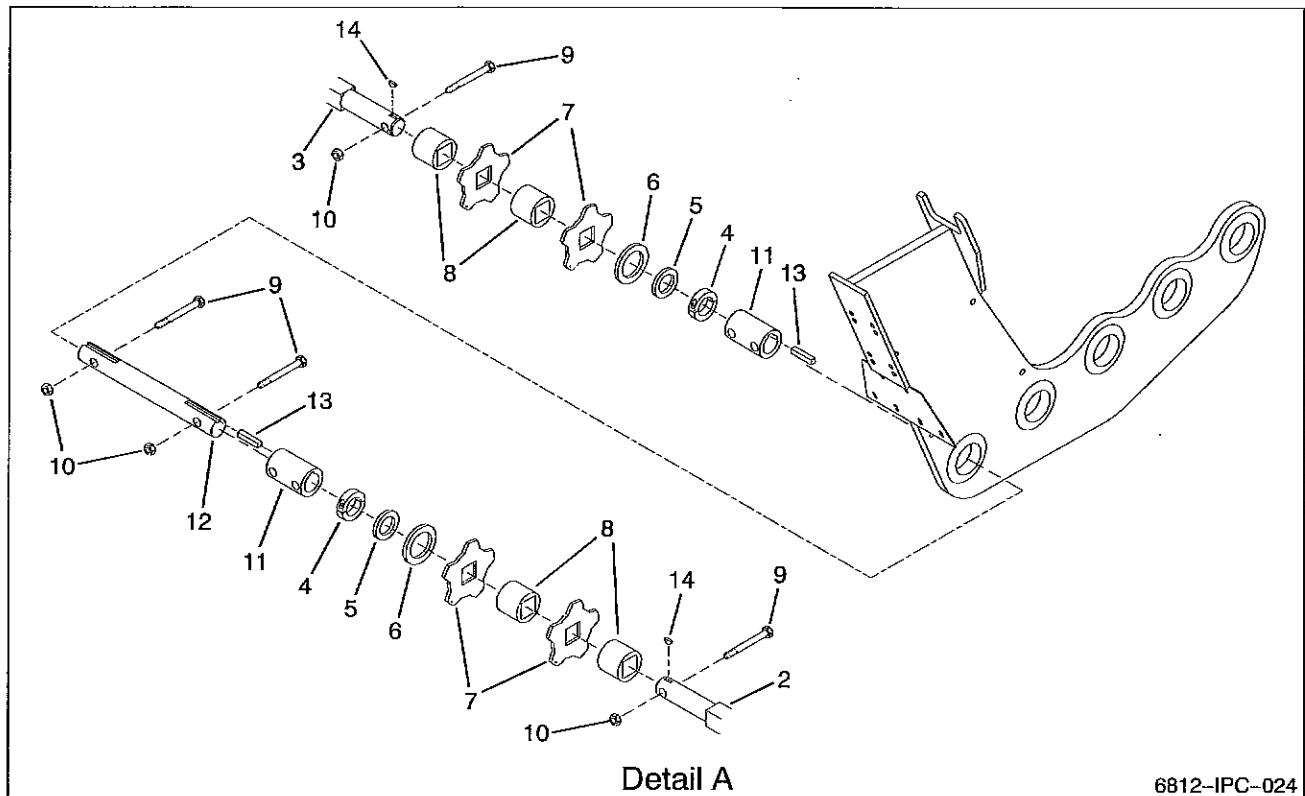


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
-1	525770		Roller Grouping, Smooth 12R22 Head	
2	527120		* Roll Wldt, Smooth, 6.62 OD x 127.5	2
3	524350		* Bushing Taper Lock 3030 1-3/4 Bore 3/8 KW	1
4	524360		* Bushing Taper lock 3030 2-3/4 Bore 5/8 KW	1
5	524390		* Sleeve, Shaft 1-3/4-27 Spl ID x 2.75 OD 5/8 KW	1
6	524400		* Shaft, 1-3/4 Dia 3/8 KW 1-3/4-27Spl x 10.00	1
7	030380		* Key, Square 3/8 x 3.00	1
8	524150		* Key, Square 5/8 x 3.00	1
-9	525840		Grabroll Grouping, Steel 12R22	
10	527D10		* Roll Wldt, Conveyor Steel 12R22 LH (#1-#4)	4
11	527020		* Roll Wldt, Conveyor Steel 12R22 RH (#1-#4)	4
12	527030		* Roll Wldt, Diverter 12R22 LH 6812	1
13	527040		* Roll Wldt, Diverter 12R22 RH 6812	1
-14	525860		Grabroll Grouping , Poly 12R22	
15	525880		* Roll Wldt, Conveyor Poly 12R22 LH (#1-#4)	4
16	525890		* Roll Wldt, Conveyor Poly 12R22 RH (#1-#4)	4
19	522920		* Bearing, 8all 1-3/4 Wide SOD Ecc Tri	5
20	520880		* Holder, Bearing (In Weldment)	5
21	521980		* Sheet, UHMW CTR Head	2
22	007080		* Bolt, HHCS 1/2-13 x 2-1/2 Gr5 ZN	4
23	005200		* Washer, Flat 1/2 Std	8
24	005370		* Washer, Lock 1/2 ZN	4
25	005360		* Nut, Hex 1/2-13 Gr5 ZN	4

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12 Row 22 Non-Adjustable

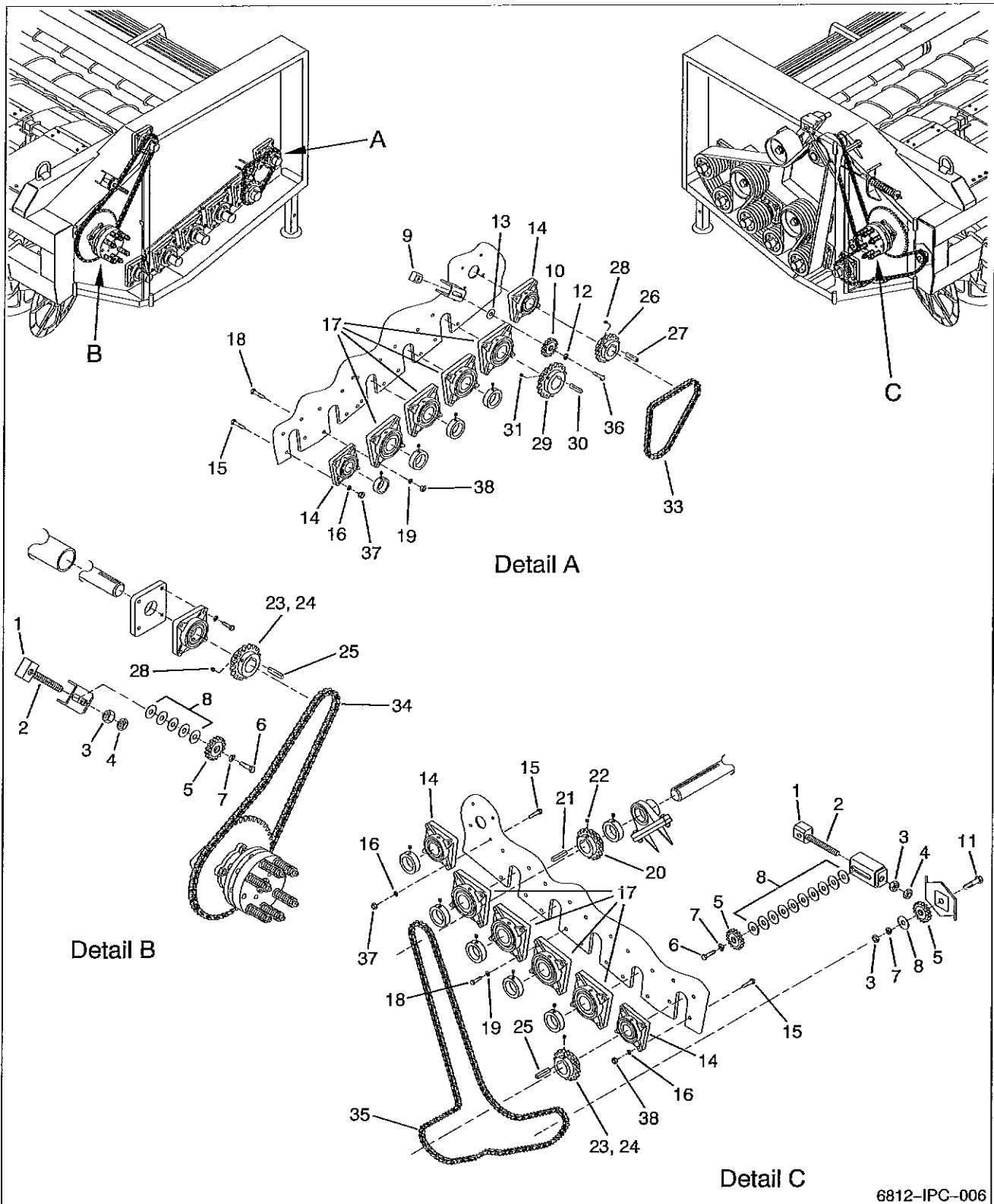
ROLLER GROUPING – STAR ROLLER (12R22)



6812-IPC-024

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
-1	525800	Roller Grouping, Star 12R22 Head				
2	524230	* Shaft, LH Star Roll 1.75 x 134.00				1
3	524240	* Shaft, RH Star Roll 1.75 x 136.53 Drive				1
4	287700	* Lock Collar, Split 1.75 Bore				2
5	E126034	* Bushing, Mach 1-7/8 x 2-7/8 x 10 GA PLN				2
6	E126201	* Bushing, Mach 2.50 x 3.87 x 0.134				2
7	475490	* Plate, Star				86
8	287600	* Spacer, Rubber				86
9	340360	* Bolt, HHCS 3/8-16 x 3-1/2 Gr8 ZN				4
10	I359783C1	* Nut, Lock 3/8 Gr8 Hex Top 2-Way				4
11	524130	* Coupler, Shaft 3.00 OD x 0.38 KW				2
12	524140	* Shaft, Ctr 1.75 Dia x 10.00 x 0.38 KW				1
13	036940	* Key, Square 3/8 x 3-1/2				2
14	231950	* Key, Woodruff (1222-1) 3/8 x 2-3/4				2
-15	R61566	* Screw, SQHSS 3/8-16 x 3/4 Knurled BLO				2

6 Row 22/24 Non-Adjustable,
PADDLE SHAFT DRIVES (6R22/24)

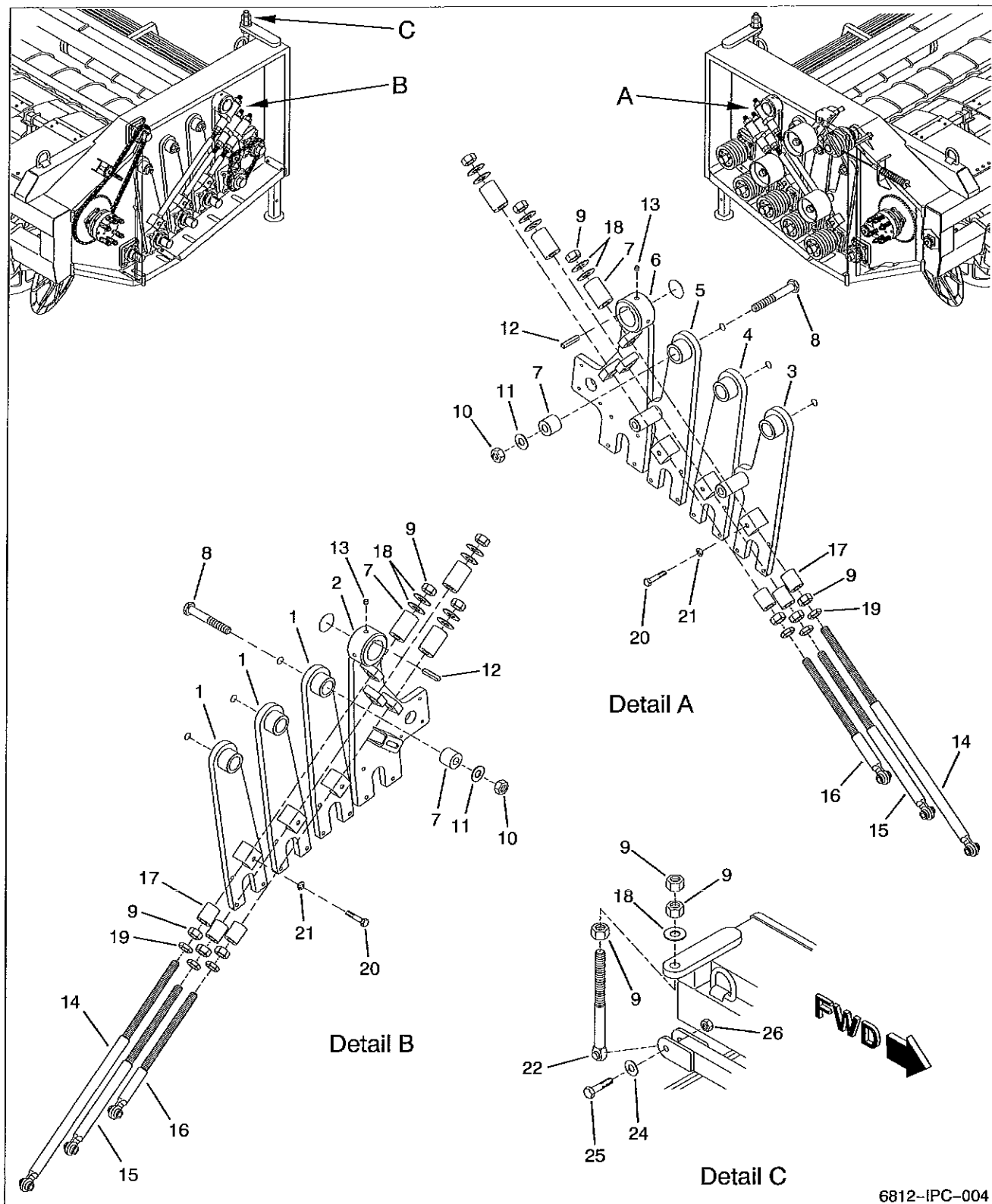


**6 ROW 22 NON-ADJUSTABLE,
PADDLE SHAFT DRIVES**

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		* * * *				
1	518070	Block, Idler Adjustment				2
2	518080	Rod, Threaded, 3/4-10 x 5.50				2
3	J14H794	Nut, Hex, 3/4-10 Gr5 ZN				3
4	E552038	Nut, Jam, 3/4-10 Hex Gr5 ZN				2
5	240550	Sprocket, Idler, 80-12T w/ Washer				3
6	990570	Bolt, HHCS, 3/4-10 x 3 Gr5 ZN				2
7	036800	Washer, Lock, 3/4 SAE (Med) x 1-17/64 x 3/16 ZN				4
8	I131017	Washer, Flat, 3/4 SAE 13/16 x 1-15/32 x 9/64 ZN				20
9	518380	Slide, Idler Tensioner				1
10	E366013	Sprocket, Idler 60B13 with 5/8 Mtg.				1
11	G146921	Bolt, CRG, 3/4-10 x 3 Gr5 ZN				1
12	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+				1
13	035210	Washer, Flat, 5/8 SAE 21/32 x 1-5/16 x 3/32 ZN+				6
14	522960	Bearing, FLG, 4H, 1.75, Wide, Ecc, Triple				4
15	463750	Bolt, CRG, 1/2-13 x 1-3/4 Gr5 ZN				16
16	005370	Washer, Lock, 1/2 ZN				16
17	522970	Bearing, FLG, 4H, 2.00 (Lg), Wide, Ecc, Triple				8
18	287880	Bolt, CRG, 5/8-11 x 1-3/4 Gr5 ZN				32
19	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+				32
20	523940	Sprocket, 80B1B 2.00 Bore 0.50 Keyway				1
21	167920	Key, Square, 3/8 x 2-1/2				1
22	1070124	Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO				1
23	E741066	Sprocket, 80Q18				2
24	288070	Bushing, Split Taper, Q1 1-3/4				2
25	167920	Key, Square, 3/8 x 2-1/2				2
26	523920	Sprocket, 60B25 1.75 Bore 0.375 Keyway				1
27	021530	Key, Square, 3/8 x 2				1
28	1070121	Screw, HSSS, 3/8-16 x 3/4 Nylon Lock BLO				2
29	523930	Sprocket, 60B25 2.00 Bore 0.50 Keyway				1
30	R66305	Key, Square, 1/2 x 2				1
31	1070124	Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO				1
33	261980	Chain, Roller, RC60 50 Pitches				1
34	523980	Chain, Roller, RC80 81 Pitches				1
35	523990	Chain, Roller, RC80 133 Pitches				1
36	990650	Bolt, HHCS, 5/8-11 x 3 Gr5 ZN				1
37	005360	Nut, Hex 1/2-13 Gr5 ZN				16
38	I124589	Nut, Hex 5/8-11 Gr5 ZN				32

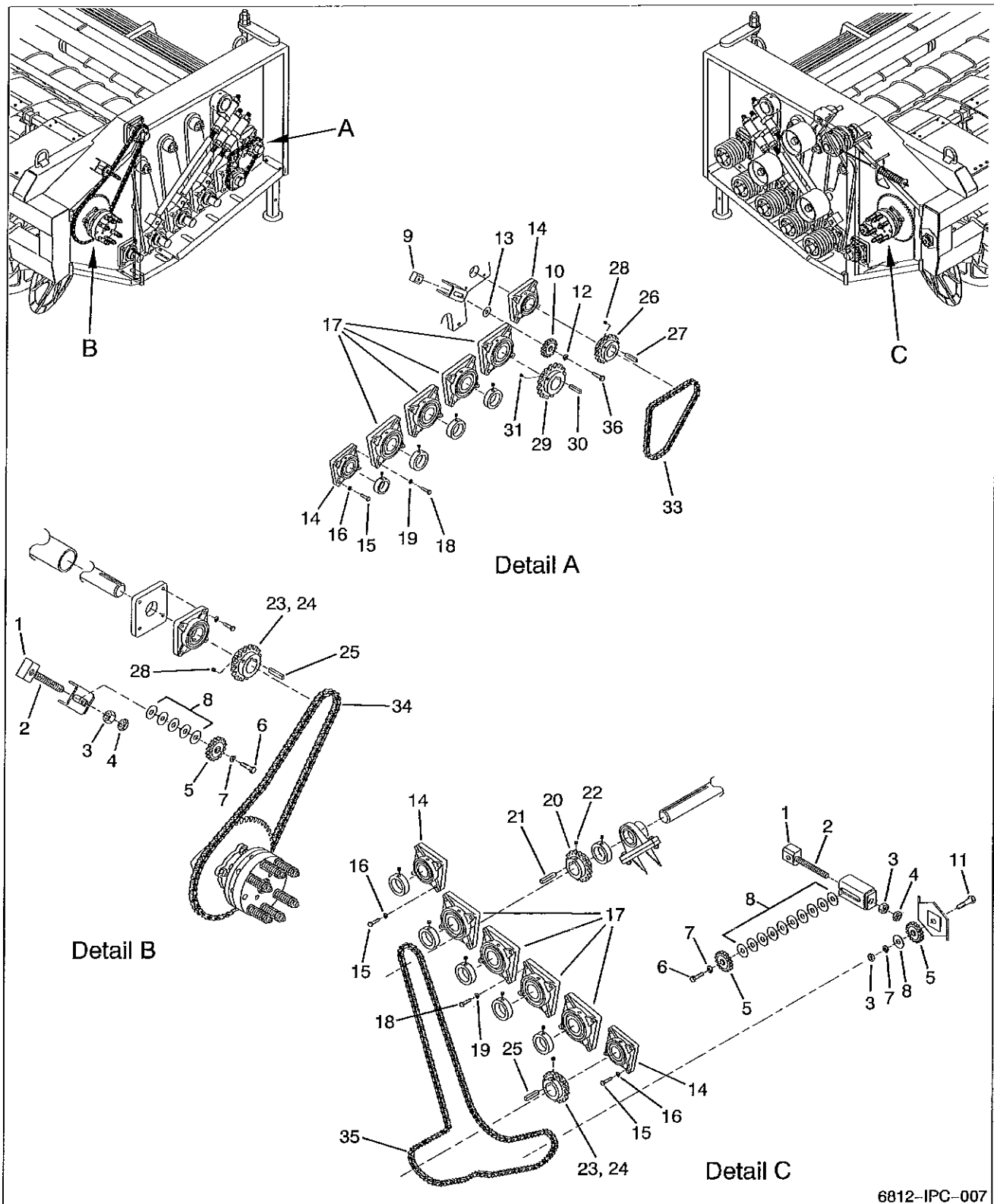
6 ROW 28/30 AND 8 ROW 22 ADJUSTABLE

CONVEYOR ROLLERS TO HEAD (6R28/30, 8R22)



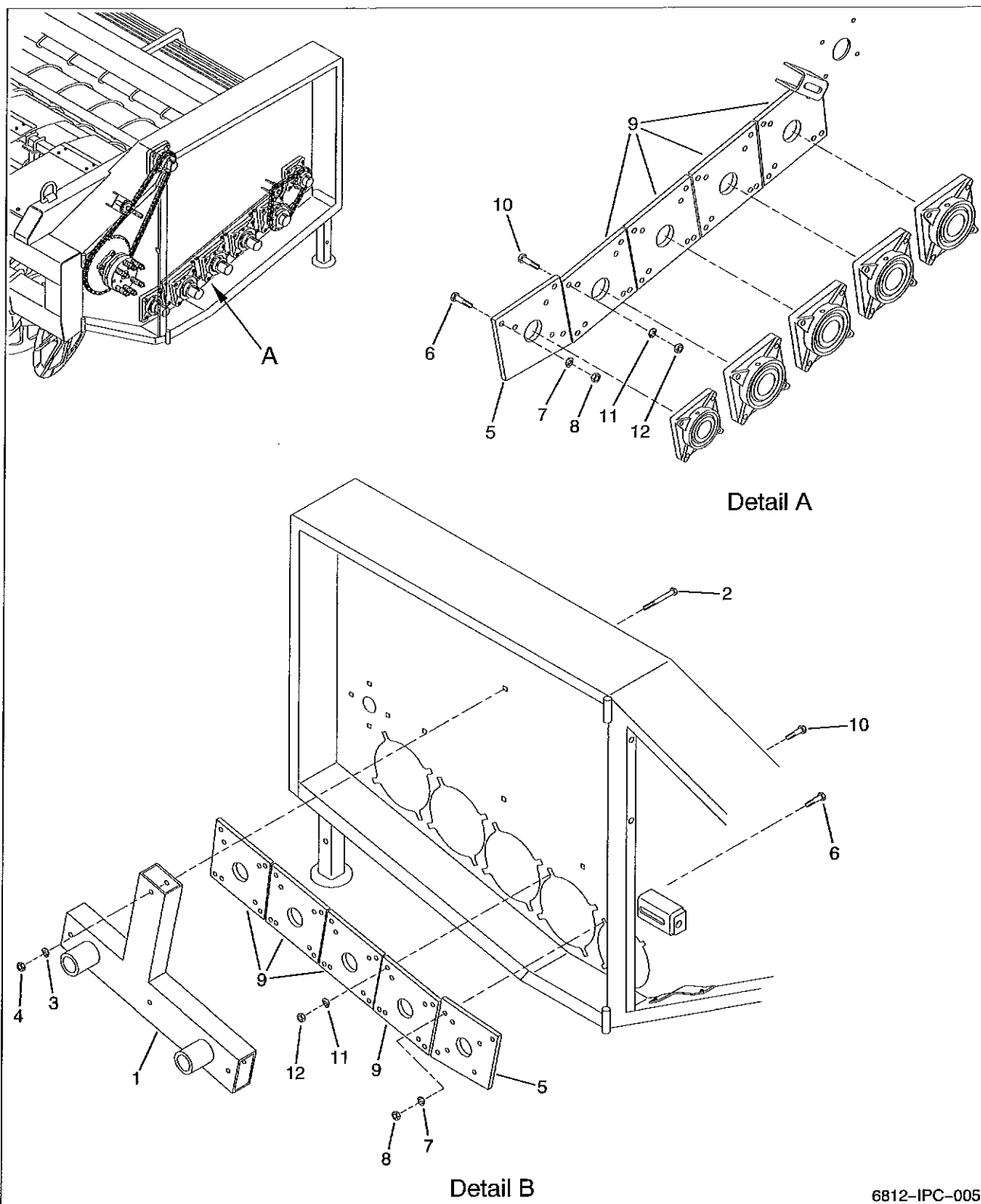
**6 ROW 28/30 AND 8 ROW 22 ADJUSTABLE
CONVEYOR ROLLERS TO HEAD**

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		*	*	*	*	
1	518210	Arm Wldt, Head G.R. Adj LH 1ST-3RD				3
2	518220	Arm Wldt, Head G.R. Adj LH 4 TH				1
3	518230	Arm Wldt, Head G.R. Adj RH 1 ST				1
4	518240	Arm Wldt, Head G.R. Adj RH 2 nd				1
5	518250	Arm Wldt, Head G.R. Adj RH 3 rd				1
6	518260	Arm Wldt, Head G.R. Adj RH 4 th				1
7	518340	Pad, Flex Polyurethane 1.00 x 2.00 x 3.00				12
8	991060	Bolt, HHCS 1-8 Gr5 ZN				6
9	J14H805	Nut, Hex 1-8 x 5 Gr5 ZN				18
10	990510	Nut, Lock 1-8 Hex				6
11	990720	Washer, Flat 1 STD 1-1/16 x 2-1/2 x 5/32+				6
12	E388049	Key, Square 1/2 x 3				2
13	1070124	Screw, HSSS 1/2-13 x 3/4 Nylon Lock BLO				6
14	518390	Link Wldt, 1-8 Thd 0.75ID x 36.72				2
15	518400	Link Wldt, 1-8 Thd 0.75ID x 26.56				2
16	518410	Link Wldt, 1-8 Thd 0.75ID x 19.53				2
17	518460	Spacer, Linkage 1.125 x 1.75 OD x 2.44				6
18	1107389	Washer, Flat 1 SAE 1-1/16 x 2 x 1/8 ZN+				18
19	E552123	Nut, Jam 1-8 Hex				6
20	990570	Bolt, HHCS 3/4-10 x 3 Gr5 ZN				10
21	036800	Washer, Lock 3/4 SAE Med x 1-17/64 x 3/16 ZN				10
22	517720	Link Wldt, 1-8 Thd 0.75ID x 17.5				2
24	990710	Washer, Flat 3/4 STD 13/16 x 2 9/64 ZN				2
25	990590	Bolt, HHCS 3/4-10 x 4 Gr5 ZN				2
26	1100328	Nut, Lock 3/4-10 Gr5 ZN Thin Nylon Hex				2

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

**6 ROW 28/30 ADJUSTABLE, AND 8 ROW 22 ADJUSTABLE
PADDLE SHAFT DRIVES**

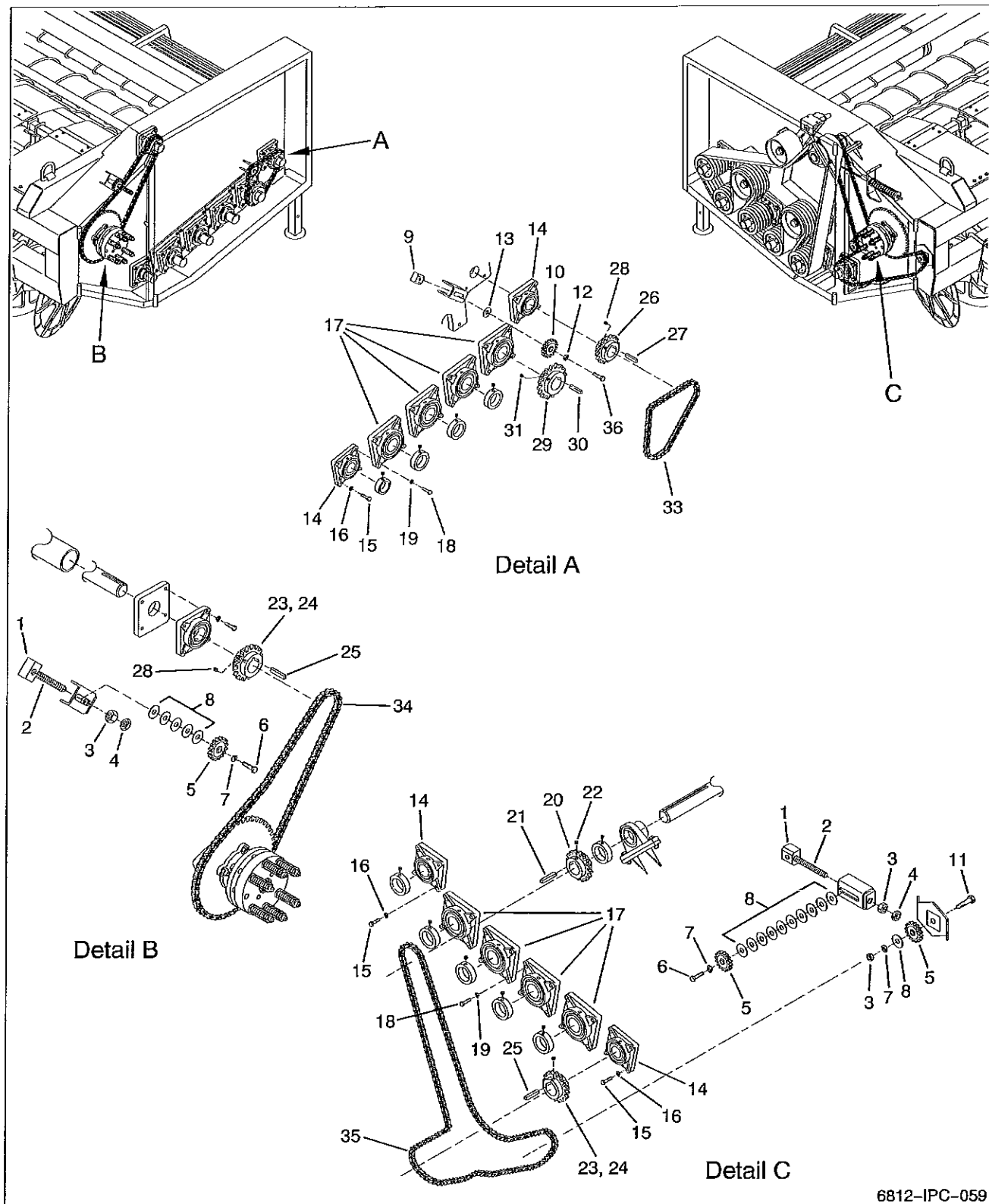
FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	518070		Block, Idler Adjustment	2
2	518080		Rod, Threaded, 3/4-10 x 5.50	2
3	J14H794		Nut, Hex, 3/4-10 Gr5 ZN	3
4	E552038		Nut, Jam, 3/4-10 Hex Gr5 ZN	2
5	240550		Sprocket, Idler, 80-12T w/ Washer	3
6	990570		Bolt, HHCS, 3/4-10 x 3 Gr5 ZN	2
7	036800		Washer, Lock, 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	4
8	I131017		Washer, Flat, 3/4 SAE 13/16 x 1-15/32 x 9/64 ZN	20
9	518380		Slide, Idler Tensioner	1
10	E366013		Sprocket, Idler 60B13 with 5/8 Mtg.	1
11	G146921		Bolt, CRG, 3/4-10 x 3 Gr5 ZN	1
12	020440		Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+	1
13	035210		Washer, Flat, 5/8 SAE 21/32 x 1-5/16 x 3/32 ZN+	6
14	522960		Bearing, FLG, 4H, 1.75, Wide, Ecc, Triple	4
15	1770500		Bolt, HHCS, 1/2-13 x 1-3/4 Gr5 ZN	16
16	005370		Washer, Lock, 1/2 ZN	16
17	522970		Bearing, FLG, 4H, 2.00 (Lg), Wide, Ecc, Triple	8
18	025100		Bolt, HHCS, 5/8-11 x 1-3/4 Gr5 ZN	32
19	020440		Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+	32
20	523940		Sprocket, 80B18 2.00 Bore 0.50 Keyway	1
21	167920		Key, Square, 3/8 x 2-1/2	1
22	1070124		Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO	1
23	E741066		Sprocket, 80Q18	2
24	288070		Bushing, Split Taper, Q1 1-3/4	2
25	167920		Key, Square, 3/8 x 2-1/2	2
26	523920		Sprocket, 60B25 1.75 Bore 0.375 Keyway	1
27	021530		Key, Square, 3/8 x 2	1
28	1070121		Screw, HSSS, 3/8-16 x 3/4 Nylon Lock BLO	2
29	523930		Sprocket, 60B25 2.00 Bore 0.50 Keyway	1
30	R66305		Key, Square, 1/2 x 2	1
31	1070124		Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO	1
33	261980		Chain, Roller, RC60 50 Pitches	1
34	523980		Chain, Roller, RC80 81 Pitches	1
35	523990		Chain, Roller, RC80 133 Pitches	1
36	990650		Bolt, HHCS, 5/8-11 x 3 Gr5 ZN	1

CONVEYOR ROLLERS TO HEAD (8R28/30, 12R22)

6812 Sugar Beet Harvester – Section 2: Head Assemblies
8 ROW 28/30 AND 12 ROW 22 NON-ADJUSTABLE
CONVEYOR ROLLERS TO HEAD

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FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	520650	Mount Wldt, Idler, Fixed Head	1
2	J03H1852	Bolt, CRG, 1/2-13 x 4 Gr5 ZN	4
3	005370	Washer, Lock, 1/2 ZN	4
4	005360	Nut, Hex, 1/2-13 Gr5 ZN	4
5	520710	Plate, Front Bearing Mtg, Fixed Head	2
6	E096046	Bolt, CRG, 1/2-13 x 1-1/2 Gr5 ZN	8
7	005370	Washer, Lock, 1/2 ZN	8
8	005360	Nut, Hex, 1/2-13 Gr5 ZN	8
9	520700	Plate, Rear Bearing Mtg, Fixed Head	8
10	250140	Bolt, CRG, 5/8-11 x 1-1/2 Gr5 ZN	32
11	020440	Washer, Lock 5/8 (Reg), 1-5/64 x 5/32 ZN+	32
12	I124589	Nut, Hex 5/8-11 Gr5 ZN	32

8 ROW 28/30 NON-ADJUSTABLE, AND 12 ROW 22 NON-ADJUSTABLE**PADDLE SHAFT DRIVES (8R28/30, 12R22)**

**8 ROW 28/30 NON-ADJUSTABLE, AND 12 ROW 22 NON-ADJUSTABLE
PADDLE SHAFT DRIVES**

FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	518070	Block, Idler Adjustment	2
2	518080	Rod, Threaded, 3/4-10 x 5.50	2
3	J14H794	Nut, Hex, 3/4-10 Gr5 ZN	3
4	E552038	Nut, Jam, 3/4-10 Hex Gr5 ZN	2
5	240550	Sprocket, Idler, 80-12T w/ Washer	3
6	990570	Bolt, HHCS, 3/4-10 x 3 Gr5 ZN	3
7	036800	Washer, Lock, 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	4
8	I131017	Washer, Flat, 3/4 SAE 13/16 x 1-15/32 x 9/64 ZN	20
9	518380	Slide, Idler Tensioner	1
10	E366013	Sprocket, Idler 60B13 with 5/8 Mtg.	1
11	G146921	Bolt, CRG, 5/8-11 x 3 Gr5 ZN	1
12	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+	1
13	035210	Washer, Flat, 5/8 SAE 21/32 x 1-5/16 x 3/32 ZN+	6
14	522960	Bearing, FLG, 4H, 1.75, Wide, Ecc, Triple	4
15	1770500	Bolt, HHCS, 1/2-13 x 1-3/4 Gr5 ZN	16
16	005370	Washer, Lock, 1/2 ZN	16
17	522980	Bearing, FLG, 4H, 2-7/16, Wide, Ecc, Triple	8
18	025100	Bolt, HHCS, 5/8-11 x 1-3/4 Gr5 ZN	32
19	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+	32
20	523940	Sprocket, 80B18 2.00 Bore 0.50 Keyway	1
21	167920	Key, Square, 3/8 x 2-1/2	1
22	1070124	Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO	1
23	E741066	Sprocket, 80Q18	2
24	288070	Bushing, Split Taper, Q1 1-3/4	2
25	167920	Key, Square, 3/8 x 2-1/2	2
26	523920	Sprocket, 60B25 1.75 Bore 0.375 Keyway	1
27	021530	Key, Square, 3/8 x 2	1
28	1070121	Screw, HSSS, 3/8-16 x 3/4 Nylon Lock BLO	2
29	524020	Sprocket, 60B25 2.44 Bore 0.50 Keyway	1
30	R66305	Key, Square, 1/2 x 2	1
31	1070124	Screw, HSSS, 1/2-13 x 3/4 Nylon Lock BLO	1
33	261980	Chain, Roller, RC60 50 Pitches	1
34	523980	Chain, Roller, RC80 81 Pitches	1
35	523990	Chain, Roller, RC80 133 Pitches	1
36	990650	Bolt, HHCS, 3/4-10 x 3 Gr5 ZN	1

ALL HEAD ASSEMBLIES

CONVEYOR ROLLERS TO HEAD

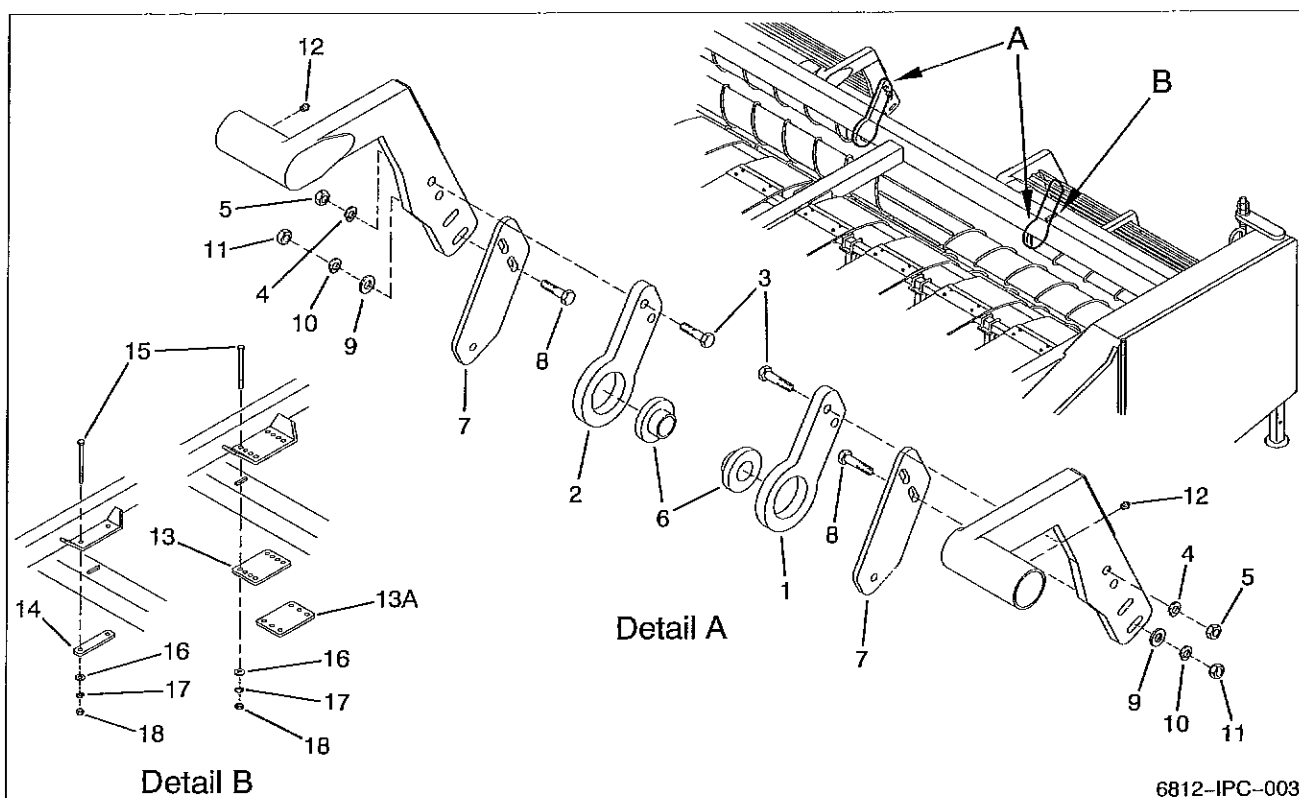


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	519220		Arm Wldt, LH Diverter Support	1
2	519230		Arm Wldt, RH Diverter Support	1
3	990570		Bolt, HHCS 3/4-10 x 3 Gr5 ZN	4
4	036800		Washer, Lock 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	4
5	J14H794		Nut, Hex 3/4-10 Gr5 ZN	4
6	522920		Bearing, Ball 1-3/4 Wide SOD, Ecc, Tri	2
7	519260		Plate, Conveyor Support	2
8	275710		Bolt, CRG 5/8-11 x 3 Gr5 ZN	4
9	020430		Washer, Flat 5/8 (Std) x 11/16 x 1-3/4 x 9/64 ZN	4
10	020440		Washer, Lock 5/8 (Reg) x 1-5/64 x 5/32 ZN+	4
11	I124589		Nut, Hex 5/8-11 Gr5 ZN	4
12	115590		Fitting, Zerk 1/4-22 Taper Thread	4
13	520350		Plate, Rear Head Mtg, 8 Hole (Non-Adjustable Heads)	2
13A	520360		Plate, Rear Head Mtg, 6 Hole (Adjustable Heads)	2
14	520370		Plate, Front Head Mtg, 2 Hole	4
15	991050		Bolt, HHCS, 3/4-10 x 8-1/2 Gr5 ZN	20/24*
16	I131017		Washer, Flat, 3/4 SAE x 13/16 x 1-15/32 x 9/64 ZN	40/48*
17	036800		Washer, Lock, 3/4 SAE (Med) x 1-17/64 x 3/16 ZN	20/24*
18	J14H794		Nut, Hex, 3/4-10 Gr5 ZN	20/24*

Non-Adjustable Heads / Adjustable Heads *

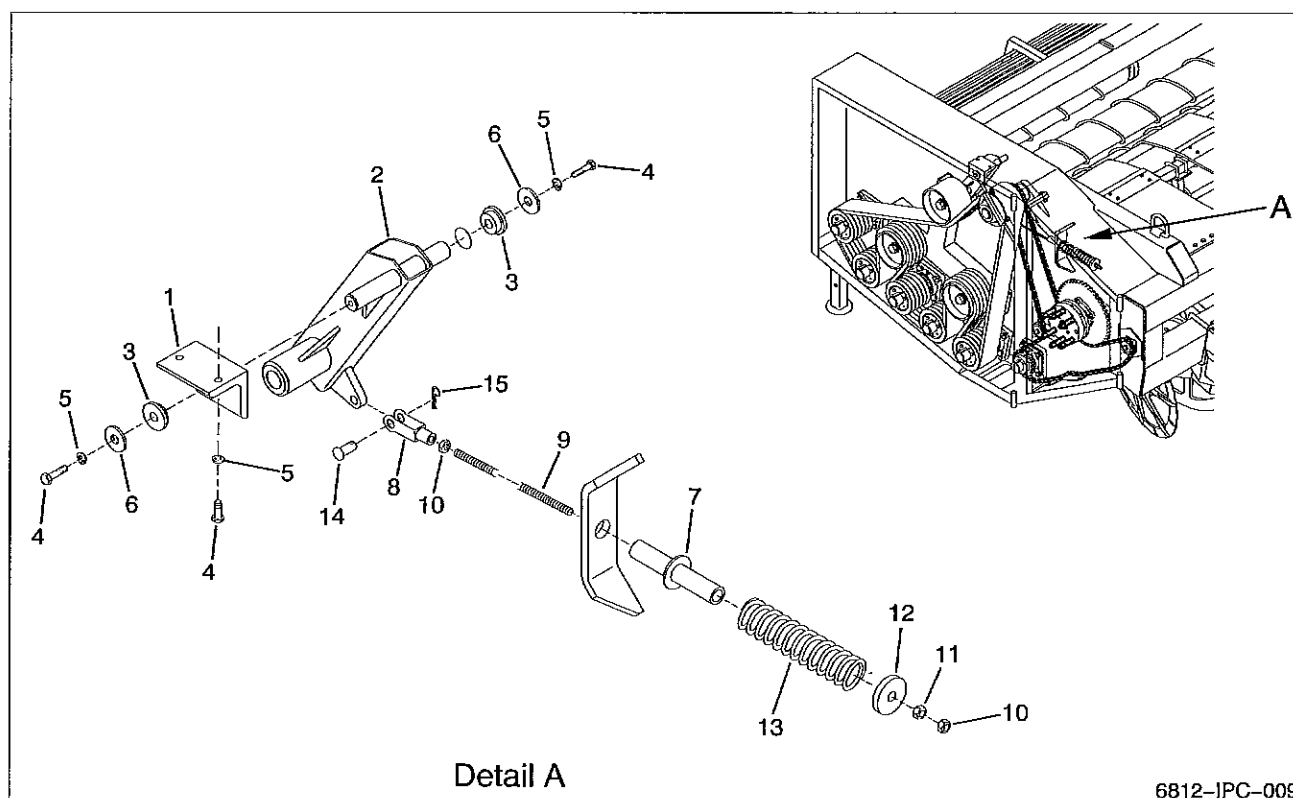
IDLER ARM CONVEYOR ROLLER DRIVE (8R28/30, 12R22)

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		* * * *				
1	518060	Angle, Tensioner Arm, Mtg				1
2	520720	Arm Wldt, Belt Tensioner, Wide				1
3	522600	Bushing, Oilite, 1 x 1-1/4 x 3/4 Flg				2
4	012260	Bolt, HHCS, 3/8-16 x 1 Gr5 ZN				4
5	021180	Washer, Lock, 3/8 x 11 16 x 3/32 ZN+++				4
6	169280	Washer, Flat, 13/32 x 1-1/2 x 1/8 ZN				2
7	518130	Guide Wldt, Tensioner				1
8	513841	Yoke Wldt, Threaded, 1/2-13 (GREEN)				1
9	486990	Rod, Threaded, 1/2-13 x 25.50				1
10	114380	Nut, Jam, 1/2-13 Hex Gr5 ZN				2
11	005360	Nut, Hex, 1/2-13 Gr5 ZN				1
12	I48601R1	Washer, Flat, 17/32 x 2 x 1/4 NT Gr1 ZN				1
13	JN109877	Spring, Compression, 1.12 x 1.84 x 7.84 (8R28/30, and 12R22)				1
14	1071212	Pin, Clevis, 1/2 x 1-1/2 ZN+				1
15	124350	Pin, Cotter, 1/8 x 1-1/2 ZN+				1

6 ROW 28/30 ADJUSTABLE, AND 8 ROW 22 ADJUSTABLE

IDLER ARM CONVEYOR ROLLER DRIVE (6R22/24, 6R28/30, 8R22)

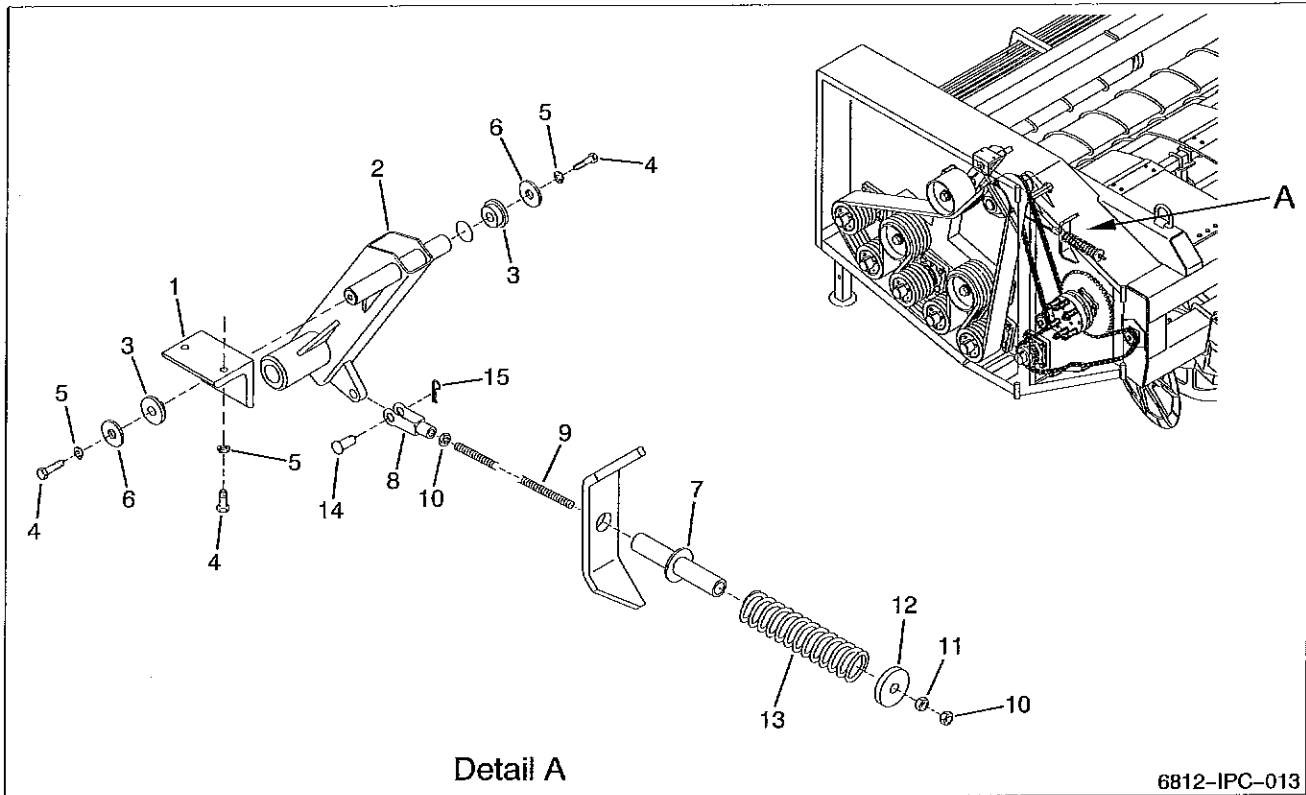
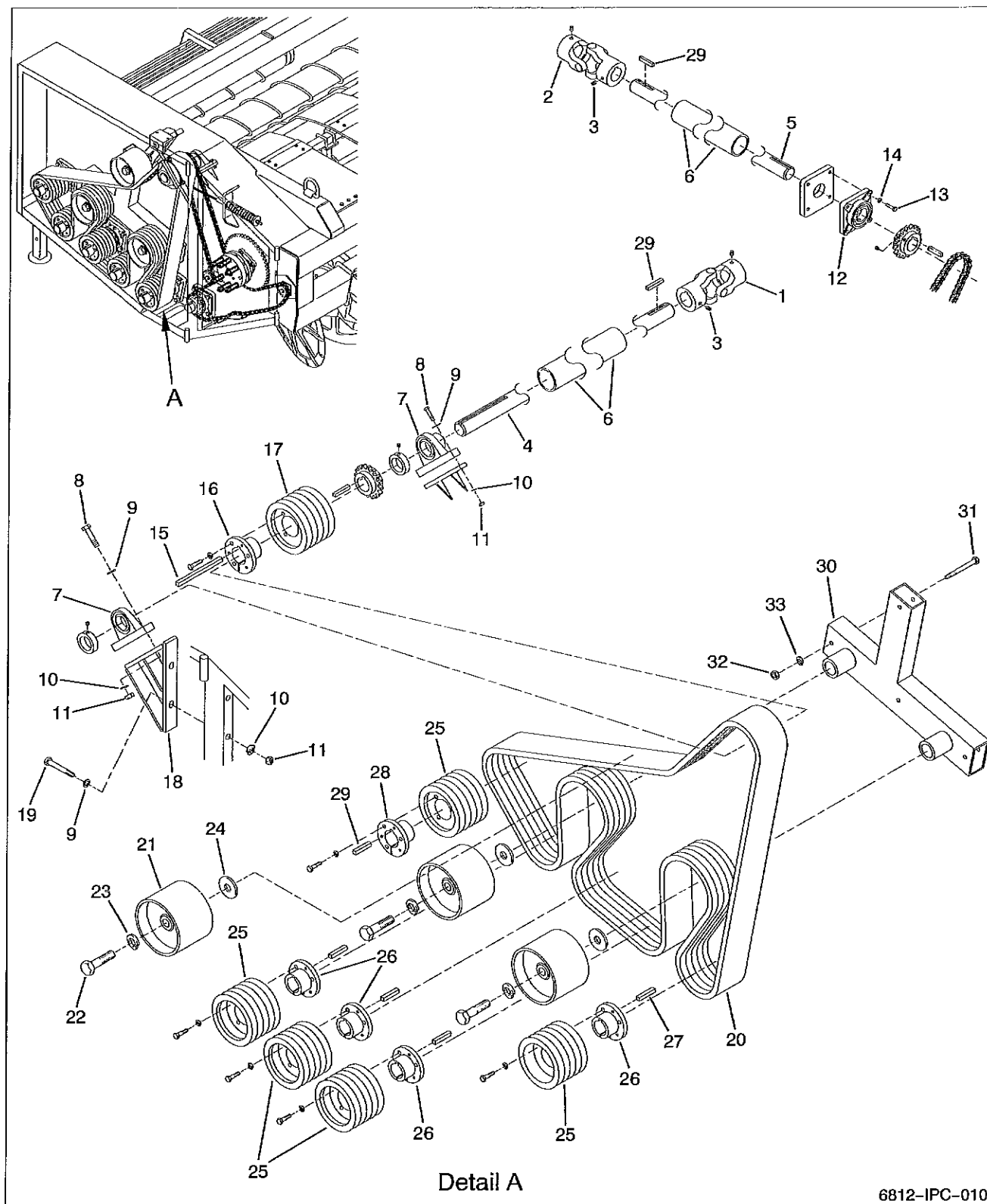


FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		* * * * *				
1	518060	Angle, Tensioner Arm, Mtg				1
2	520720	Arm Wldt, Belt Tensioner, Wide				1
3	522600	Bushing, Oilite, 1 x 1-1/4 x 3/4 Flg				2
4	012260	Bolt, HHCS, 3/8-16 x 1 Gr5 ZN				4
5	021180	Washer, Lock, 3/8 x 11 16 x 3/32 ZN+++				4
6	169280	Washer, Flat, 13/32 x 1-1/2 x 1/8 ZN				2
7	518130	Guide Wldt, Tensioner				1
8	513841	Yoke Wldt, Threaded, 1/2-13 (GREEN)				1
9	486990	Rod, Threaded, 1/2-13 x 25.50				1
10	114380	Nut, Jam, 1/2-13 Hex Gr5 ZN				2
11	005360	Nut, Hex, 1/2-13 Gr5 ZN				1
12	I48601R1	Washer, Flat, 17/32 x 2 x 1/4 NT Gr1 ZN				1
13	231000	Spring, Compression, 1.62 x 7.25				1
14	1071212	Pin, Clevis, 1/2 x 1-1/2 ZN+				1
15	124350	Pin, Cotter, 1/8 x 1-1/2 ZN+				1

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6 ROW 22/24 NON-ADJUSTABLE

CONVEYOR ROLLER DRIVES (6R22/24)



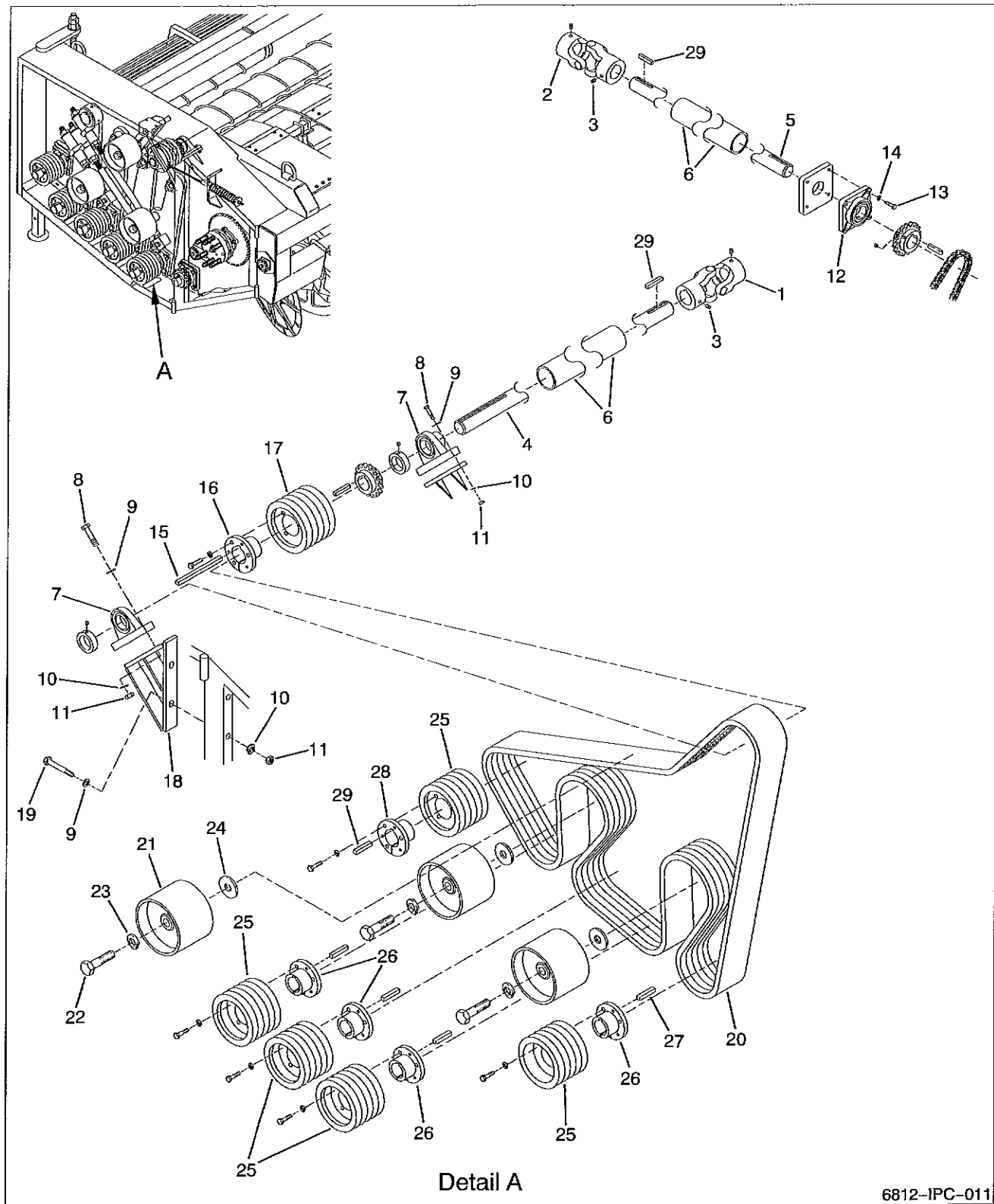
6812 Sugar Beet Harvester – Section 2: Head Assemblies
6 ROW 22/24 NON-ADJUSTABLE
CONVEYOR ROLLER DRIVES

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FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		* * * *				
1	286520	U-Joint, 1-3/4 x 1-3/4 R8				1
2	439110	U-Joint, 1-3/4 x 2, 2500				1
3	218660	Screw, HSSS, 3/8-16 x 3/8 BLO				4
4	522500	Shaft, RH Drive, 2.0 (Dia) x 62.50				1
5	522490	Shaft, LH Drive, 1-3/4 (Dia) x 59.00				1
6	525990	Shield, Spin, 2.40 (OD) x 46.5				2
7	522950	Bearing, P8, 2 (Lg), Wide, Ecc, Triple				2
8	275710	Bolt, CRG, 5/8-11 x 3 Gr5 ZN				4
9	020430	Washer, Flat, 5/8 (Std) 11/16 x 1-3/4 x 9/64 ZN				10
10	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+				6
11	I124589	Nut, Hex, 5/8-11 Gr5 ZN				6
12	522960	Bearing, FLG 4H, 1.75, Wide, Ecc, Triple				1
13	014770	Bolt, HHCS, 1/2-13 x 1-1/2 Gr5 ZN				4
14	005370	Washer, Lock, 1/2 ZN				4
15	E407000	Key, Square, 1/2 X 5				1
16	251220	Bushing, QD SF, 2 Bore. 1/2 KW				1
17	522170	Sheave, 5 Grv 5V, 7.5 (OD), SF Bushing				1
18	523630	Mount Wldt, Bearing, RH Drive				1
19	028330	Bolt, HHCS, 5/8-11 x 4-1/2 Gr5 ZN				2
20	522220	Belt, Banded, 5-5V2000				1
21	518600	Sheave Assy, Idler, 1.25 (ID) x 6.00 (OD) x 5.00 (W)				3
	518610	* Sheave Wldt, Flat 6.62 OD				1
	523010	* Bearing, Insert 1-1/4 COD				1
	E642D27	* Ring, Snap				1
22	522610	Bolt, HHCS, 1-1/4-7 x 3-1/2 Gr8 ZN				3
23	E829047	Washer, Lock, 1-1/4 x 2-3/64 x 5/16 ZN				3
24	E829022	Washer, Flat, 1-1/4 x 1-3/8 x 2-1/2 SAE				3
25	522160	Sheave, 5 Grv 5V, 6.3 (OD), SK Bushing				5
26	346340	Bushing, QD SK, 2 Bore				4
27	R66305	Key, Square, 1/2 x 2				6
28	R37960	Bushing, QD SK, 1-3/4 x 3/8				1
29	021530	Key, Square, 3/8 x 2				2
30	520650	Mount Wldt, Idler				1
31	J0341852	Bolt, CRC 1/2-13 x 4 ZN				4
32	005360	Nut, Hex 1/2-13 ZN				4
33	005370	Washer, Lock 1/2 ZN				4

6 ROW 28/30 ADJUSTABLE AND 8 ROW 22 ADJUSTABLE

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



6812 Sugar Beet Harvester – Section 2: Head Assemblies
6 ROW 28/30 ADJUSTABLE AND 8 ROW 22 ADJUSTABLE
CONVEYOR ROLLER DRIVES

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FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	286520	U-Joint, 1-3/4 x 1-3/4 RB	1
2	439110	U-Joint, 1-3/4 x 2, 2500	1
3	218660	Screw, HSSS, 3/8-16 x 3/8 BLO	4
4	520390	Shaft, RH Drive 2.0 Dia x 79.50	1
5	520380	Shaft, LH Drive 1-3/4 Dia x 76.00	1
6	525980	Shield, Spin 2.40 OD x 63.5	2
7	522950	Bearing, PB, 2 (Lg), Wide, Ecc, Triple	2
8	275710	Bolt, CRG, 5/8-11 x 3 Gr5 ZN	4
9	020430	Washer, Flat, 5/8 (Std) 11/16 x 1-3/4 x 9/64 ZN	10
10	020440	Washer, Lock, 5/8 (Reg) x 1-5/64 x 5/32 ZN+	6
11	I124589	Nut, Hex, 5/8-11 Gr5 ZN	6
12	522960	Bearing, FLG 4H, 1.75, Wide, Ecc, Triple	1
13	014770	Bolt, HHCS, 1/2-13 x 1-1/2 Gr5 ZN	4
14	005370	Washer, Lock, 1/2 ZN	4
15	E407000	Key, Square, 1/2 X 5	1
16	251220	Bushing, QD SF, 2 Bore. 1/2 KW	1
17	522170	Sheave, 5 Grv 5V, 7.5 (OD), SF Bushing	1
18	523630	Mount Wldt, Bearing, RH Drive	1
19	028330	Bolt, HHCS, 5/8-11 x 4-1/2 Gr5 ZN	2
20	522220	Belt, Banded, 5-5V2000	1
21	518600	Sheave Assy, Idler, 1.25 (ID) x 6.00 (OD) x 5.00 (W)	3
	518610	* Sheave Wldt, Flat 6.62 QD	1
	523010	* Bearing, Insert 1-1/4 CQD	1
	E642027	* Ring, Snap	1
22	522610	Bolt, HHCS, 1-1/4-7 x 3-1/2 Gr8 ZN	3
23	E829047	Washer, Lock, 1-1/4 x 2-3/64 x 5/16 ZN	3
24	E829022	Washer, Flat, 1-1/4 x 1-3/8 x 2-1/2 SAE	3
25	522160	Sheave, 5 Grv 5V, 6.3 (OD), SK Bushing	5
26	346340	Bushing, QD SK, 2 Bore	4
27	R66305	Key, Square, 1/2 x 2	6
28	R37960	Bushing, QD SK, 1-3/4 x 3/8	1
29	021530	Key, Square, 3/8 x 2	2

8 ROW 28/30 NON-ADJUSTABLE AND 12 ROW 22 NON-ADJUSTABLE

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

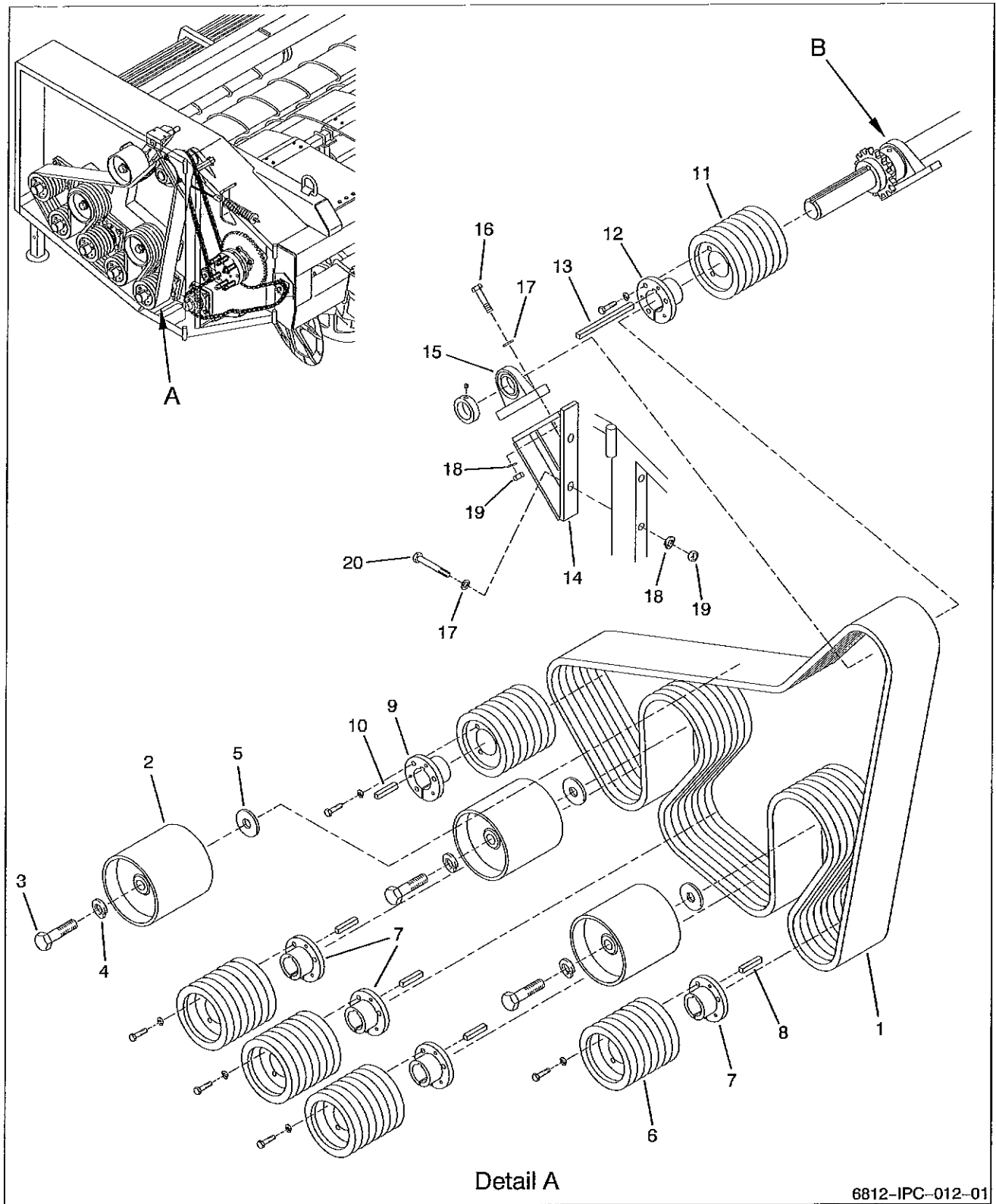
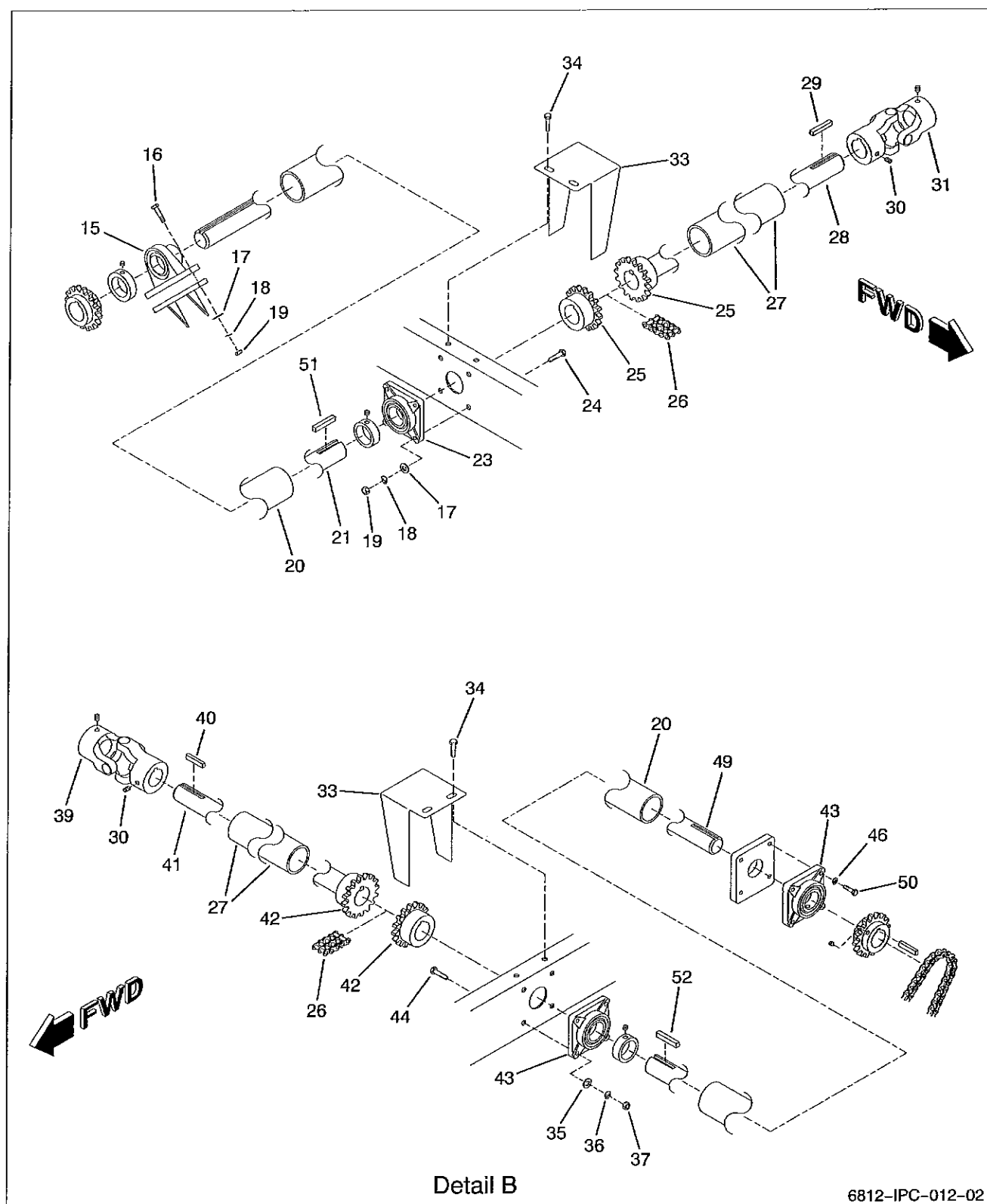


FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
1	522230		Belt, Banded, 8-5V2000	1
2	520760		Sheave Assy, Idler, 1.25 (ID) x 6.00 (OD) x 7.00	3
	520770		* Sheave Wldt, Flat 6.62 OD	1
	523010		* Bearing, Insert 1-1/4 COD	2
	E642027		* Ring, Snap	2
3	522860		Bolt, HHCS, 1-1/4 x 5-1/2 Gr8 ZN	3
4	E829047		Washer, Lock, 1-1/4 x 2-3/64 x 5/16 ZN	3
5	E829022		Washer, Flat, 1-1/4 (SAE), 1-3/8 x 2-1/2	3
6	522180		Sheave, 8 Grv 5 V, 7.10 (OD) SF Bushing	5
7	522200		Bushing, OD SF, 2.44 Bore	4
8	531100		Key, Step 1/2 to 5/8 x 2	4
9	234760		Bushing, OD SF, 1-3/4 x 3/8	1
10	021530		Key, Square, 3/8 X 2	1
11	522190		Sheave, 8 Grv 5V, 8.50 (OD), E Bushing	1
12	251230		Bushing, OD E, 2 Bore, 5/8 KW	1
13	424010		Key, Square, 1/2 X 7-1/4	1
14	523630		Mount Wldt, Bearing, RH Drive	1
15	522950		Bearing, PB, 2.00 (Lg), Wide, Ecc, Triple	1
16	275710		Bolt, CRG, 5/8-11 x 3.00 Gr5 ZN	2
17	02043D		Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN	4
18	020440		Washer, Lock, 5/8 (Reg), 1-5/64 x 5/32 ZN+	4
19	I124589		Nut, Hex, 5/8-11 Gr5 ZN	4
20	028330		Bolt, HHCS, 5/8-11 x 4-1/2 Gr5 ZN	2

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



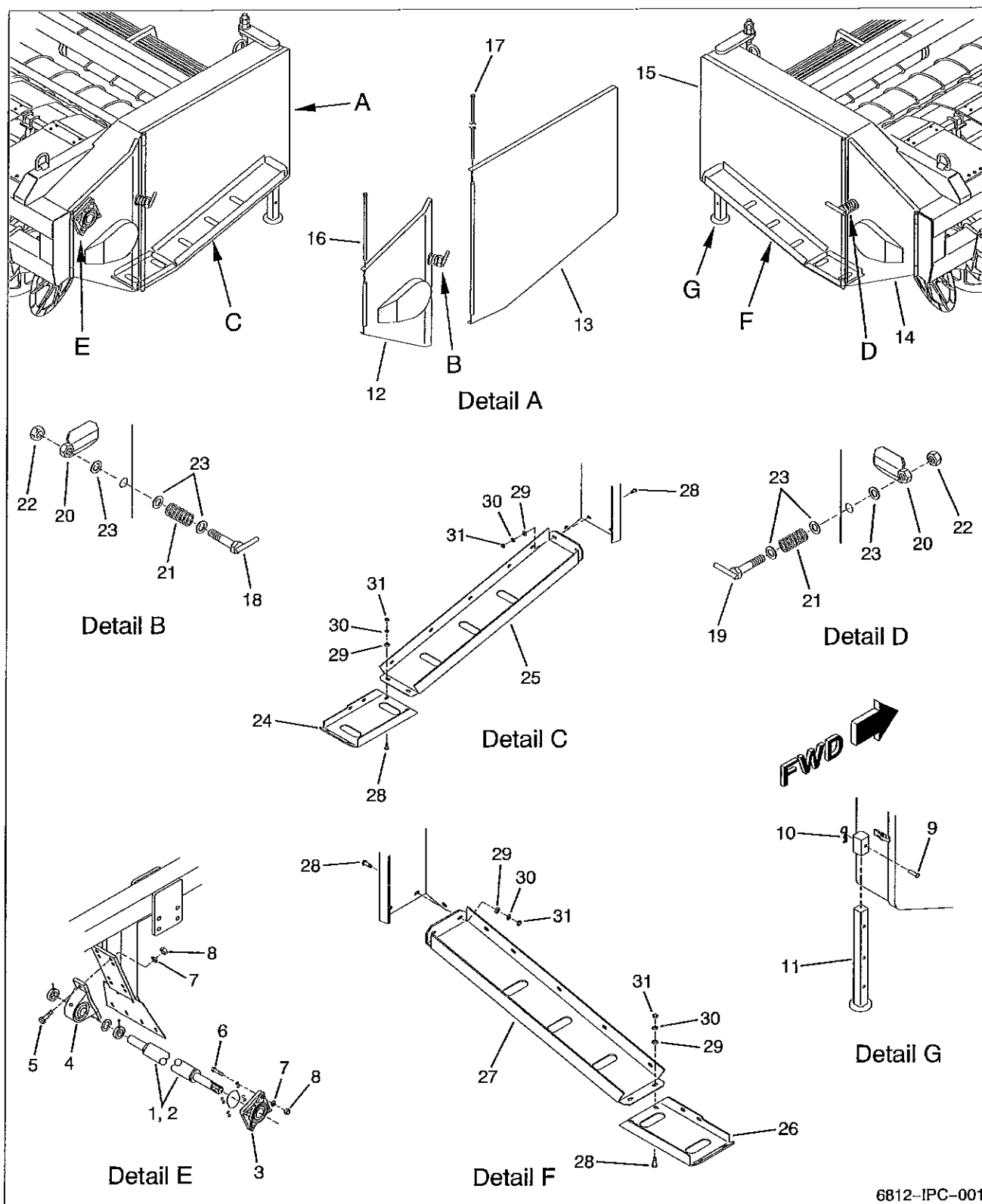
6812 Sugar Beet Harvester – Section 2: Head Assemblies
8 Row 28/30 NON-ADJUSTABLE AND 12 ROW 22 NON-ADJUSTABLE
CONVEYOR ROLLER DRIVES

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FIG ITEM	PART NUMBER	1 2 3 4 * * * *	NOMENCLATURE	UNITS PER ASSY
15	522950		Bearing, PB, 2.00 (Lg), Wide, Ecc, Triple	1
16	275710		Bolt, CRG, 5/8-11 x 3.00 Gr5 ZN	2
17	020430		Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN	6
18	020440		Washer, Lock, 5/8 (Reg), 1-5/64 x 5/32 ZN+	6
19	I124589		Nut, Hex, 5/8-11 Gr5 ZN	6
20	525940		Shield, Outer Spin, 2.40 (OD) x 53.50	2
21	522520		Shaft, RH Drive, Outer, 2.00 (Dia) x 78.25	1
23	522970		Bearing, FLG 4H, 2.00 (Lg), Wide, Ecc, Triple	1
24	990620		Bolt, HHCS, 5/8-11 x 2.00 Gr5 ZN	4
25	502850		Sprocket, 60B14, Bored to 2.00 ID	2
26	163770		Chain, 60-2, 14 Pitches, Incl Conn	2
27	525950		Shield, Inner Spin, 2.40 (OD) x 45.00	2
28	522540		Shaft, RH Drive, Inner, 2.00 (Dia) x 49.12	1
29	E388073		Key, Square, 1/2 x 1-1/2	2
30	218660		Screw, HSSS, 3/8-16 x 3/8 BLO	12
31	439110		U-Joint, 1-3/4 x 2.00, 2500	1
33	524120		Shield, Head Drive Coupler	2
34	JN71292		Bolt, HXHD, 5/16-18 x 1/2 FLG Gr5 ZN	4
35	005200		Washer, Flat 1/2 (STD) 9/16 x 1-3/8 x 7/64 ZN+	8
36	005370		Washer, Lock 1/2 ZN	4
37	005360		Nut 1/2-13 Gr5 ZN	4
39	286520		U-Joint, 1-3/4 RB x 1-3/4 RB	1
40	D06670		Key, Square, 3/8 x 1-1/2	2
41	522530		Shaft, LH Drive, Inner, 1-3/4 (Dia) x 49.12	1
42	367100		Sprocket, 60B14, 1.75 Bore w/Keyway	2
43	522960		Bearing, FLG 4H, 1.75, Wide, Ecc, Triple	2
44	023950		Bolt, HHCS, 1/2-13 x 2.00 Gr5 ZN	4
49	522510		Shaft, LH Drive, Outer, 1-3/4 (Dia) x 71.50	1
50	014770		Bolt, HHCS, 1/2-13 x 1-1/2 Gr5 ZN	4
51	R66305		Key, Square, 1/2 x 2	2
52	021530		Key, Square, 3/8 x 2	2

6 ROW 22/24 NON ADJUSTABLE, 6 ROW 28/30 ADJUSTABLE, AND 8 ROW 22 ADJUSTABLE

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

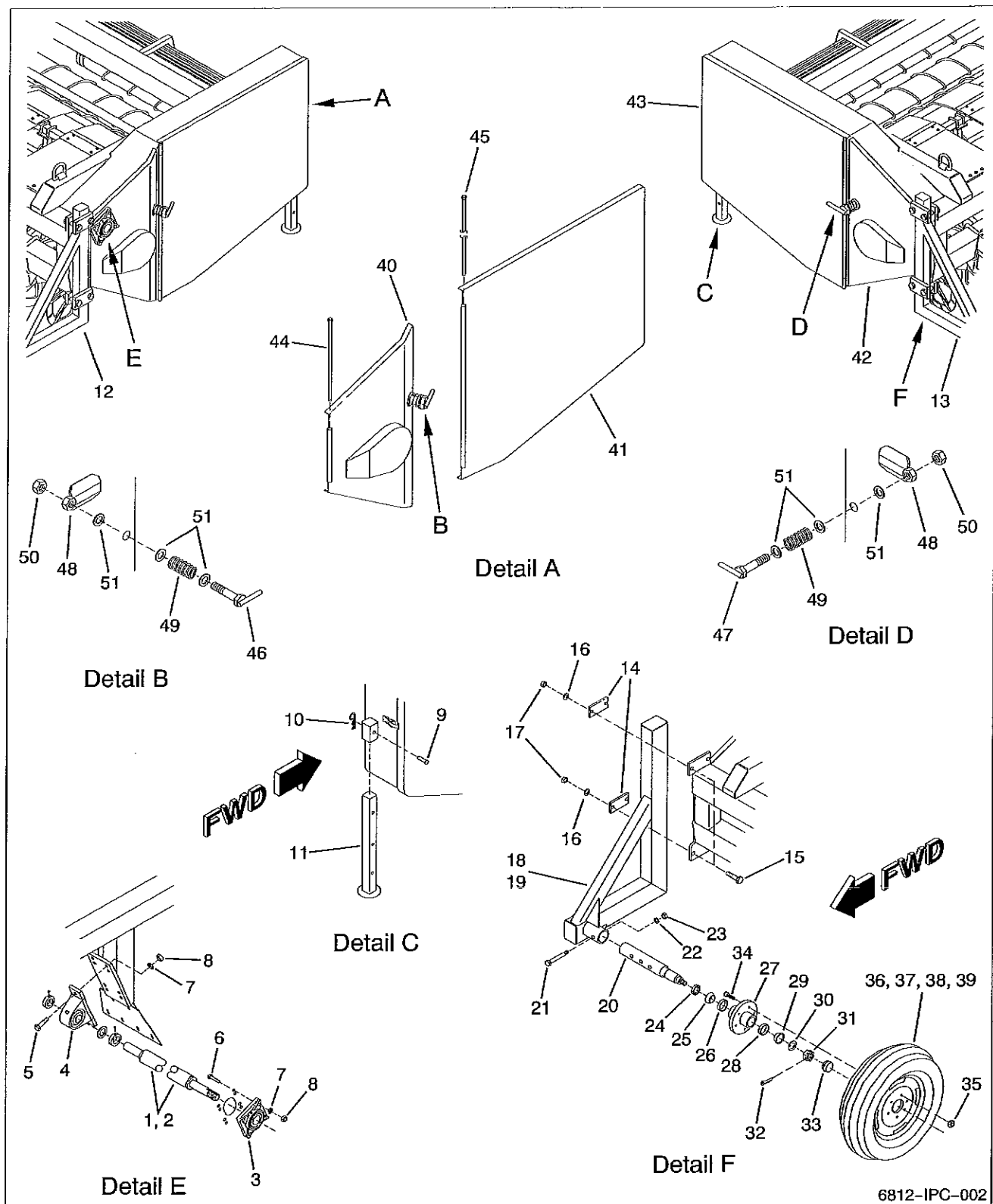


**6 ROW 22/24 NON-ADJUSTABLE, 6 ROW 28/30 ADJUSTABLE, AND 8 ROW 22 ADJUSTABLE
HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS AND STANDS**

FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	523210	Shaft Wldt, Paddle Drive 77.00 Long (6R22/24)	2
2	523200	Shaft Wldt, Paddle Drive 94.00 Long (6R28/30, 8R22)	2
3	522970	Bearing, FLG 4H, 2 (Lg), Wide, Ecc, Triple	2
4	522950	Bearing, PB, 2 (Lg), Wide, Ecc, Triple	2
5	E096058	Bolt, HHCS, CRG 5/8-11 X 2-1/2 SN Gr5 ZN	4
6	275710	Bolt, CRG 5/8-11 x 3 Gr5 ZN	8
7	020440	Washer, Lock 5/8 Reg x 1-5/64 x 5/32 ZN+	12
8	I124589	Nut, Hex 5/8-11 Gr5 ZN	12
9	216830	Pin, Clevis 5/8 x 3 ZN	2
10	E580035	Pin, Hair 1/8 x 2-3/8 OAL Cotter	2
11	519070	Stand Wldt, Head	2
12	518670	Door Wldt, Head, LH Front	1
13	518680	Door Wldt, Head, LH Rear	1
14	518690	Door Wldt, Head, RH Front	1
15	518700	Door Wldt, Head, RH Rear	1
16	518710	Pin Wldt, Front Door	2
17	518720	Pin Wldt, Rear Door	2
18	518830	Handle Wldt, Door Latch, LH, 5/8 x 4	1
19	518840	Handle Wldt, Door Latch, RH, 5/8 x 4-1/2	1
20	518850	Latch Wldt, Door	2
21	518900	Spring, Comp, 0.94 (OD) x 14 (Ga) x 2.00	2
22	I124589	Nut, Hex, 5/8-11 Gr5 ZN	2
23	020430	Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN	6
24	518630	Panel, Lower Middle, LH	1
25	518640	Panel, Lower Rear, LH	1
26	518650	Panel, Lower Middle, RH	1
27	518660	Panel, Lower Rear, RH	1
28	J03H1558	Bolt, CRG, 3/8-16 x 1-1/2 SSN Gr5 ZN	26
29	021190	Washer, Flat, 3/8 (STD), 7/16 x 1 x 5/64 ZN+	26
30	021180	Washer, Lock, 3/8 x 11/16 x 3/32 ZN+++	26
31	027260	Nut, Hex, 3/8-16 Gr5 ZN	26

8 Row 28/30 Non-Adjustable, AND 12 Row 22 Non-Adjustable

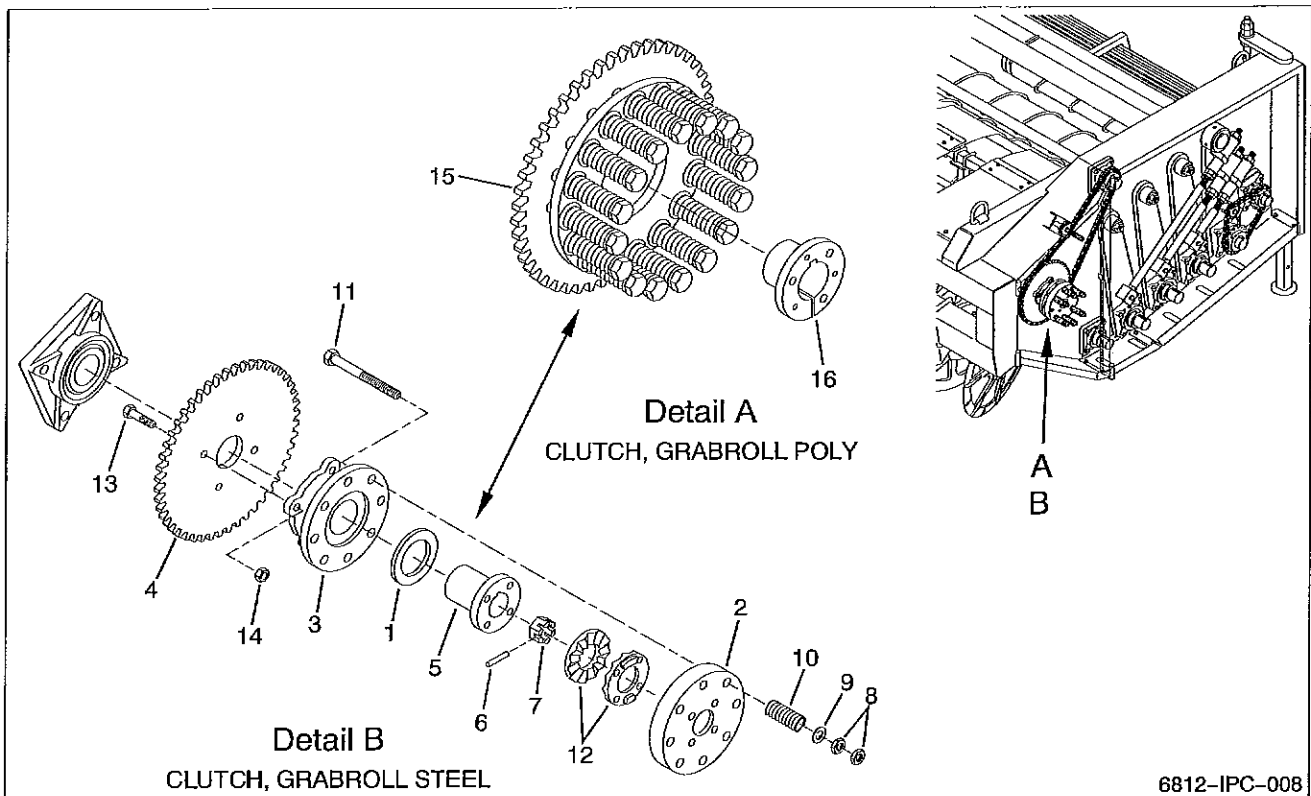
HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS AND STANDS (8R28/30, 12R22)



**8 ROW 28/30 NON-ADJUSTABLE, AND 12 ROW 22 NON-ADJUSTABLE
HEAD FRAME, PADDLE SHAFTS, PANELS, DOORS AND STANDS**

FIG ITEM	PART NUMBER	NOMENCLATURE				UNITS PER ASSY
		1	2	3	4	
		* * * *				
1	523190	Shaft Wldt, Paddle Drive 123.00 Long (8R28/30)				2
2	523180	Shaft Wldt, Paddle Drive 139.00 Long (12R22)				2
3	522970	Bearing, FLG 4H, 2 (Lg), Wide, Ecc, Triple				2
4	522950	Bearing, PB, 2 (Lg), Wide, Ecc, Triple				2
5	E096058	Bolt, HHCS, 3/4-10 x 2 Gr5 ZN				4
6	275710	Bolt, CRG 5/8-11 x 3 Gr5 Zn				8
7	020440	Washer, Lock 5/8 (Reg), 1-5/64 x 5/32 ZN+				12
8	I124589	Nut, Hex 5/8-11 Gr5 ZN				12
9	216830	Pin, Clevis 5/8 x 3 ZN				2
10	E580035	Pin, Hair 1/8 x 2-3/8 OAL Cotter				2
11	519070	Stand Wldt, Head				2
12	520930	Carrier Wheel Assembly, LH 6812				1
13	520940	Carrier Wheel Assembly, RH 6812				1
14	520801	Plate, Carrier Mtg				4
15	023550	Bolt, HHCS 3/4-10 x 5 Gr5 ZN				8
16	036800	Washer, Lock 3/4 SAE (Med) x 1-17/64 x 3/16 ZN				8
17	J14H794	Nut, Hex 3/4-10 Gr5 ZN				8
18	520950	* Frame Wldt, LH Carrier Wheel				1
19	520960	* Frame Wldt, RH Carrier Wheel				1
20	523380	* Spindle, Carrier Wheel				1
21	I271729	* Bolt, HHCS 5/8-11 x 3-1/2				1
22	020440	* Washer, Lock 5/8				1
23	I124589	* Nut, Hex 5/8-11				1
24	121130	* Seal, 2.12 x 3.06 x 0.50				1
25	007600	* Bearing, Cone 1.62				1
26	018930	* Inner Cup				1
27	007590	* Hub, 6 Bolt				1
28	018860	* Outer Cup				1
29	012630	* Bearing, Cone 1.25				1
30	020720	* Washer, Flat 13/16 x 1-3/4 x 3/16				1
31	020710	* Nut, Slotted 3/4-16				1
32	026630	* Pin Cotter 5/32 x 1-1/2				1
33	035420	* Cap, Hub 2-1/2				1
34	046700	* Bolt, Stud 9/16-18 x 2-1/8				6
35	046710	* Nut, Wheel 9/16-18				6
36	500770	* Wheel & Tire Assembly				1
37	U51900004	* * Wheel, 15 x 10 LB, 6-6-4.62, 3800#				1
38	I1980927C1	* * Tire, 11L-15 8 Ply TL Util				1
39	164420	* * Stem Valve Core & Cap				1
40	518670	Door Wldt, Head, LH Front				1
41	518680	Door Wldt, Head, LH Rear				1
42	518690	Door Wldt, Head, RH Front				1
43	518700	Door Wldt, Head, RH Rear				1
44	518710	Pin Wldt, Front Door				2
45	518720	Pin Wldt, Rear Door				2
46	518830	Handle Wldt, Door Latch, LH, 5/8 x 4.00				1
47	518840	Handle Wldt, Door Latch, RH, 5/8 x 4-1/2				1
48	518850	Latch Wldt, Door				2
49	518900	Spring, Comp, 0.94 (OD), 14 Ga x 2.00				2
50	I124589	Nut, Hex, 5/8-11 Gr5 ZN				2
51	020430	Washer, Flat, 5/8 (STD), 11/16 x 1-3/4 x 9/64 ZN				6

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

LIFTER GROUPING – STRUT ASSEMBLY

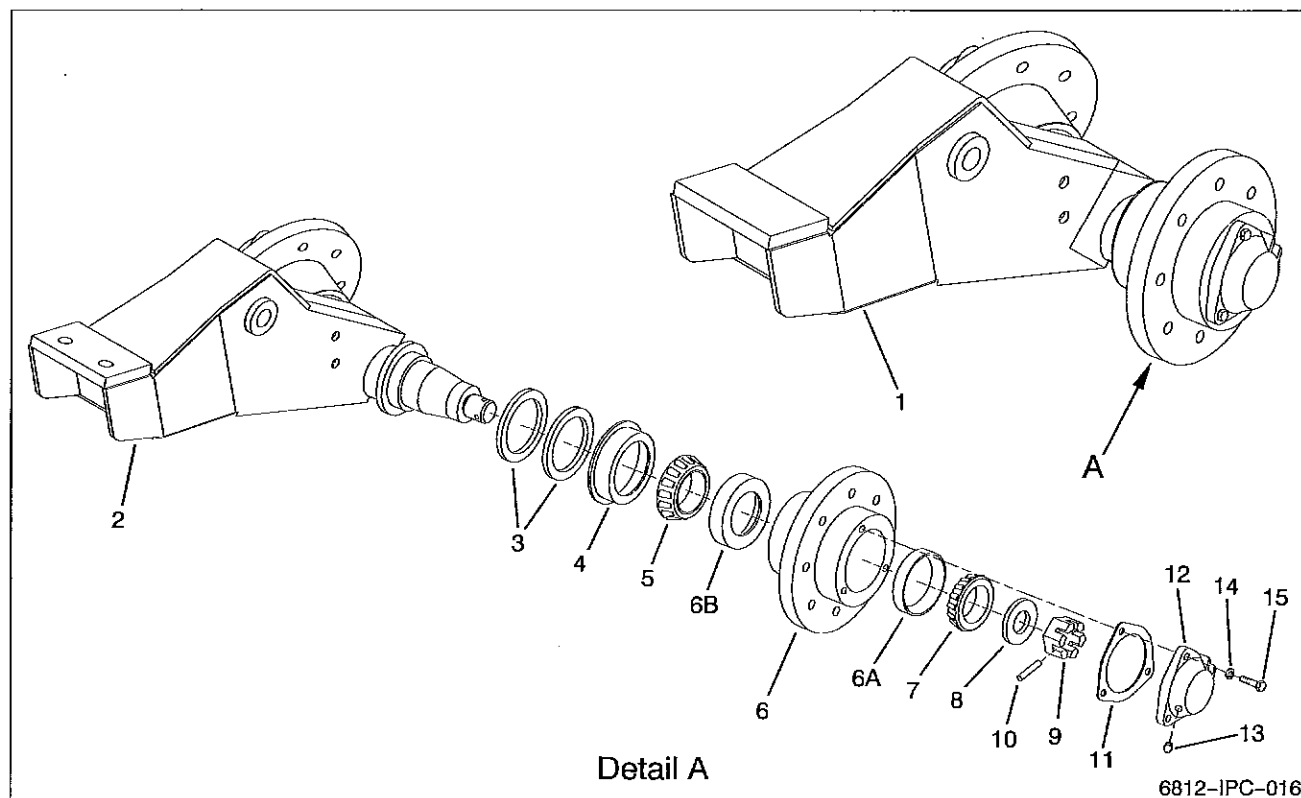


FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521780	Strut Assembly, Flexible Pivot	1
2	521820	* Strut Wldt, Pivot Flex	1
3	263170	* Washer, Felt	4
4	263160	* Retainer, Felt	2
5	261640	* Cone Bearing, TM#28985 2.38 ID	2
6	267430	* Hub Assembly, Strut	2
-6A	E072462	* * Cup, Bearing	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

LIFTER GROUPING -- FIXED STRUTS

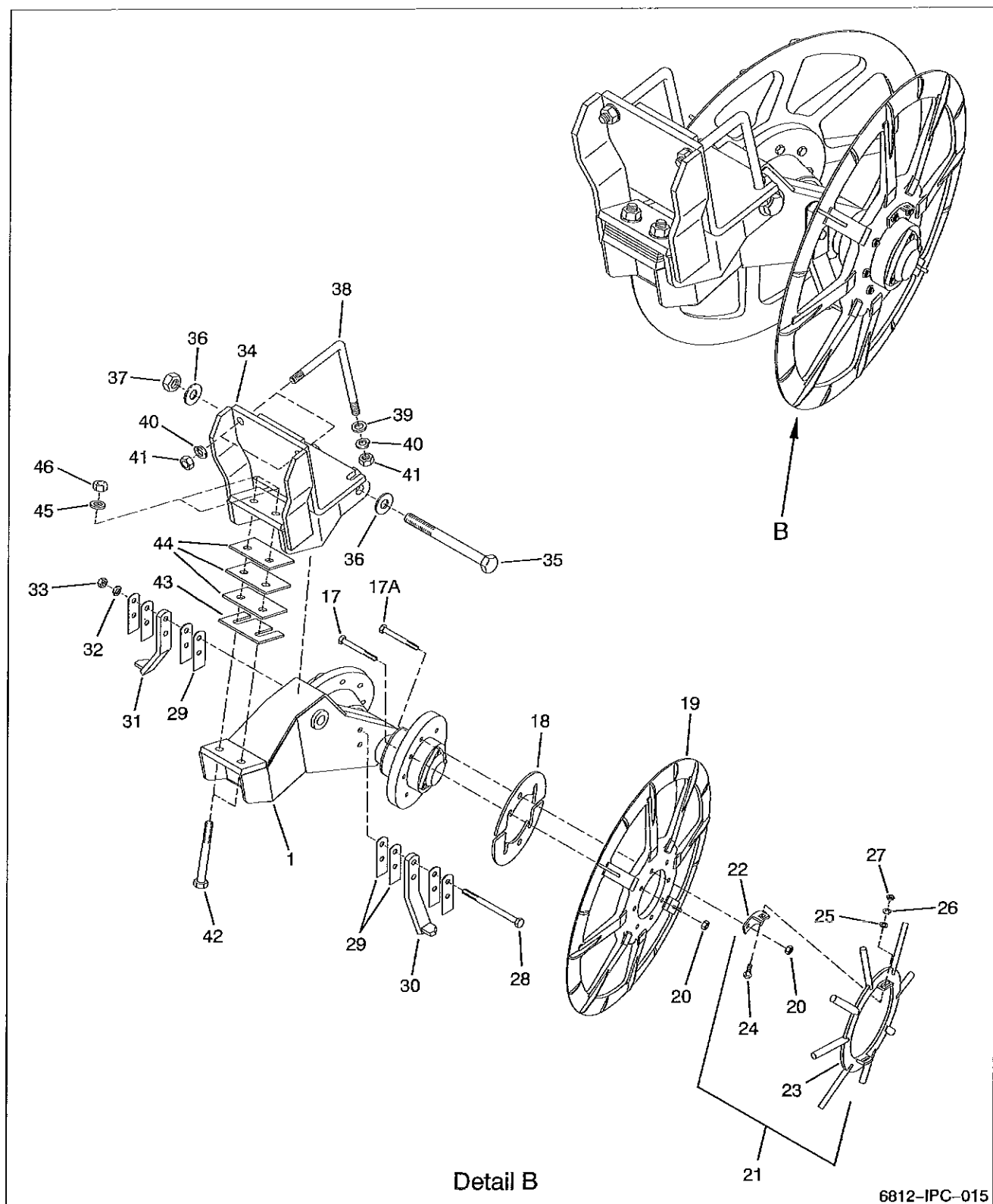


FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521780	Strut Assembly, Flexible Pivot	1
17	031580	Bolt, 1/2-13 x 2-3/4 HHCS Gr5 ZN	8
17A	990840	Bolt, 1/2-13 x 3 HHCS Gr5 ZN (used w/Close-up)	8
18	26B570	Spacer, Beet Wheel (As Required – 6 Maximum)	8
19	491750	Wheel Lifter Machining 2000	2
20	127B90	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	036B00	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

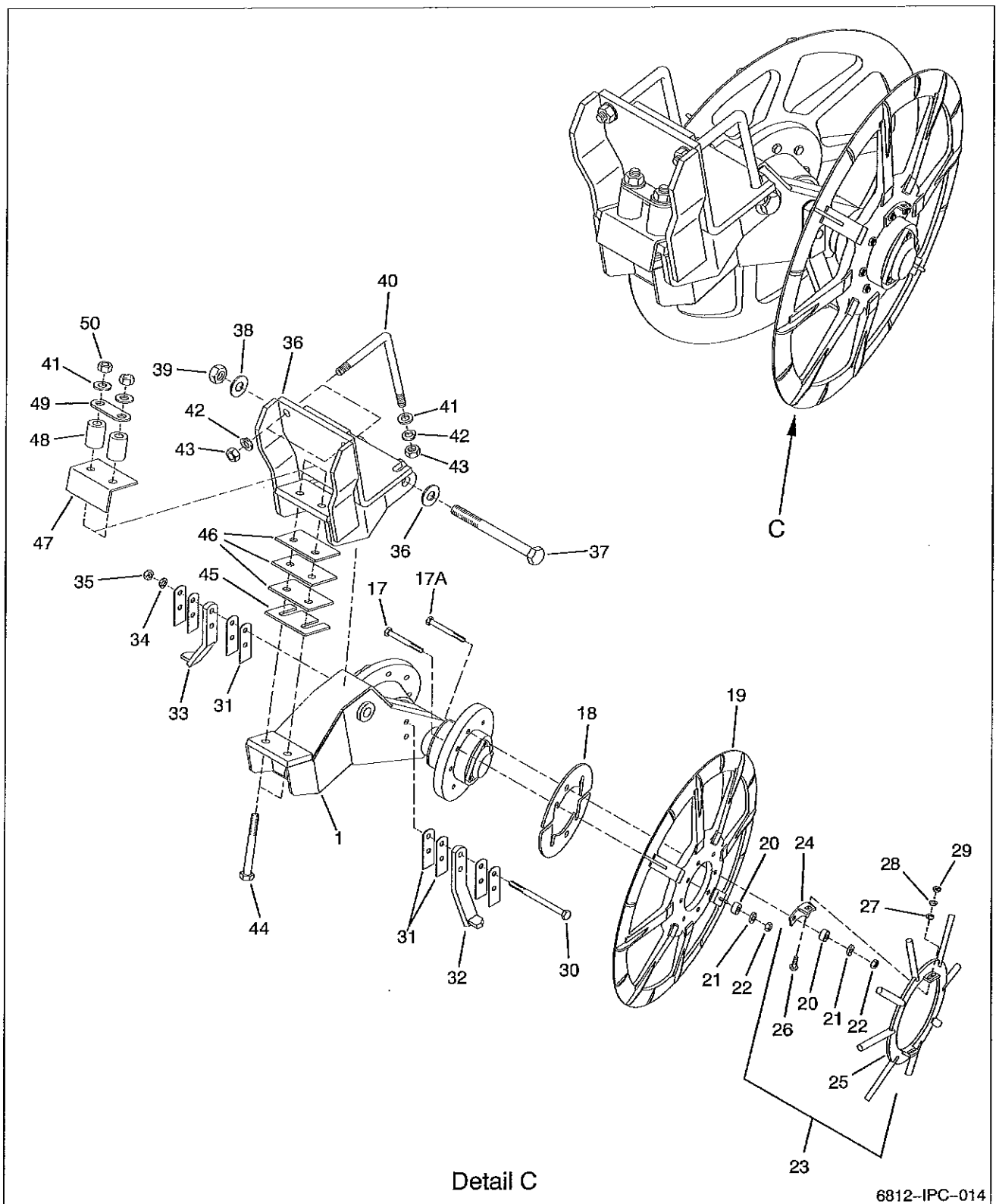


FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	521780	Strut Assembly, Flexible Pivot	1
17	038560	Bolt, 1/2-13 x 4.0 HHCS Gr5 ZN	8
17A	340300	Bolt, 1/2-13 x 4.25 HHCS Gr5 ZN (used w/Close-up)	8
18	268570	Spacer, Beet Wheel	8
19	491750	Wheel Lifter Machining 2000	2
20	267710	Pad, Flex 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

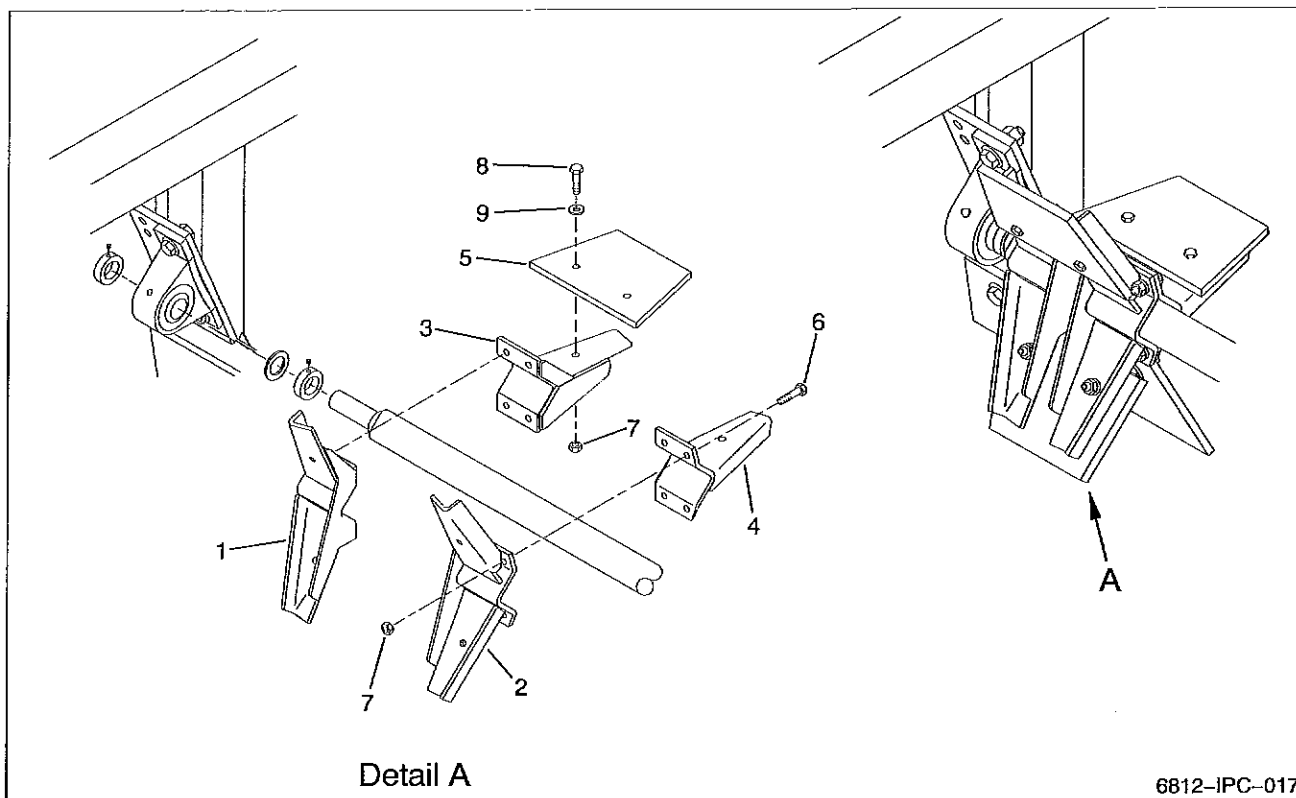
PADDLES TO PADDLE SHAFT (ALL HEADS)

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

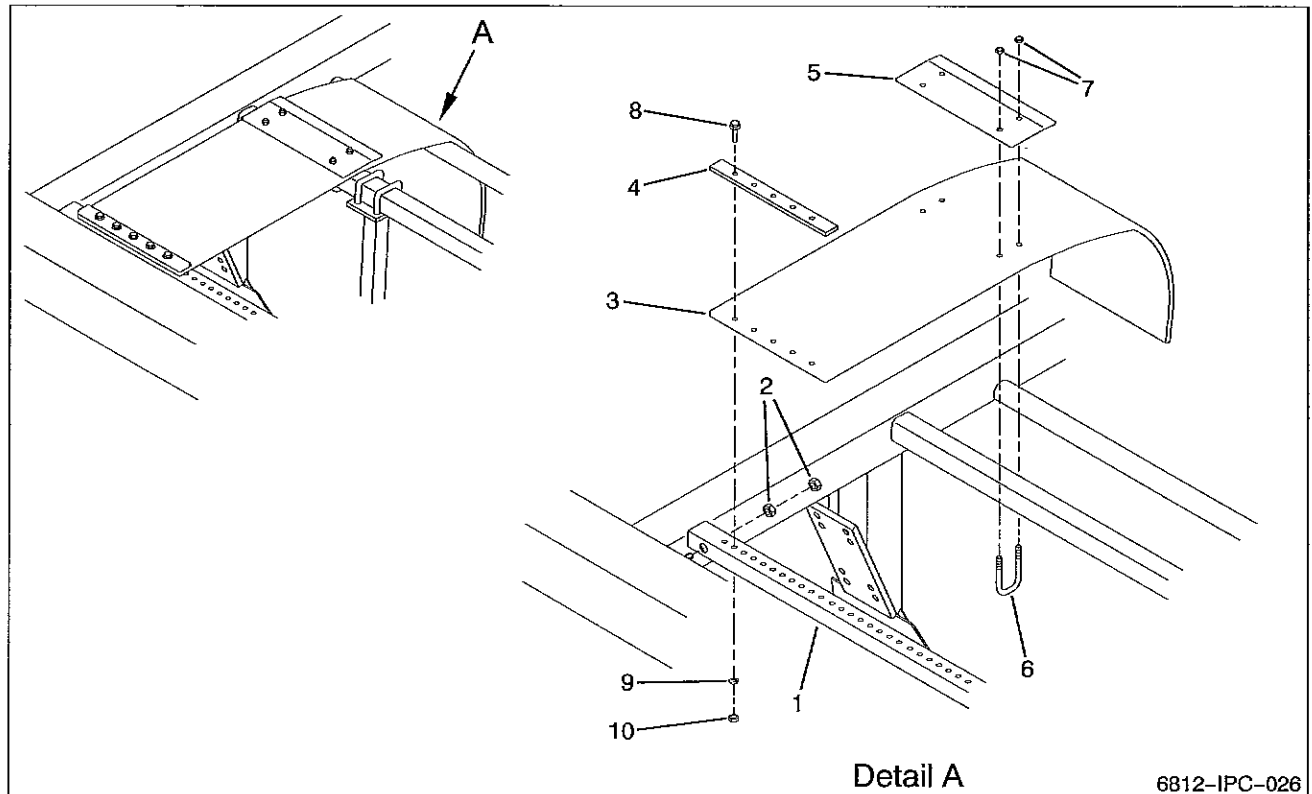
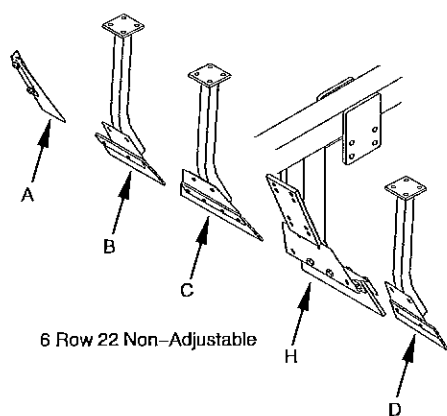
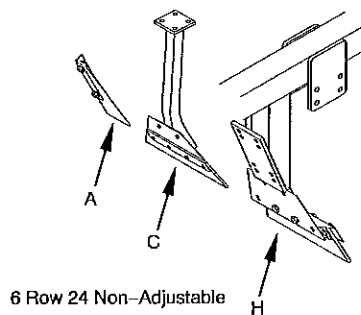
COVERS TO HEAD (ALL HEADS)

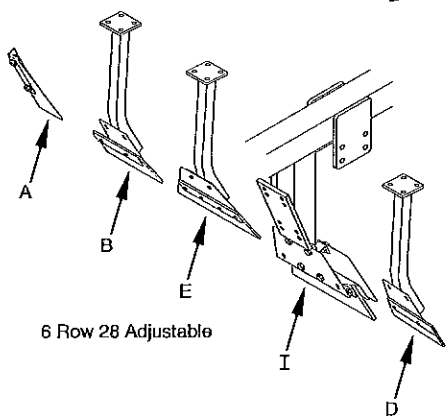
FIG ITEM	PART NUMBER	NOMENCLATURE	UNITS PER ASSY
		1 2 3 4 * * * *	
1	521440	Tube, Cover Mtg 1.5 Sq x 62.0 (6R22/24)	2
1	520410	Tube, Cover Mtg 1.5 Sq x 82.50 (6R28/30 or 8R22)	2
1	521430	Tube, Cover Mtg 1.5 Sq x 103.0 (8R28/30)	2
1	521420	Tube, Cover Mtg 1.50 Sq x 122.00 (12R22)	2
2	J14H794	Nut, Hex 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)

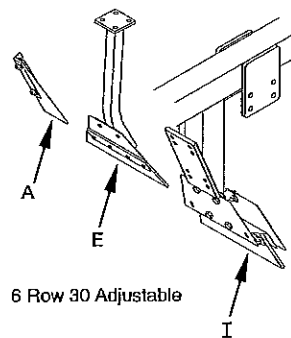
6 Row 22 Non-Adjustable



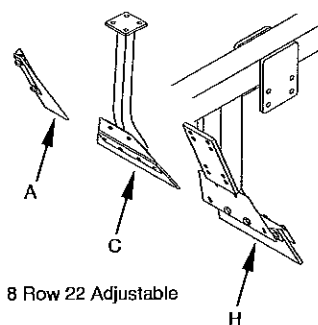
6 Row 24 Non-Adjustable



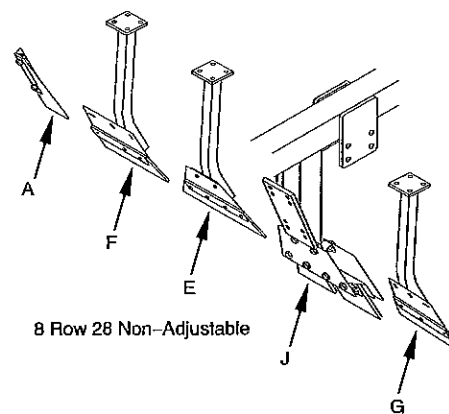
6 Row 28 Adjustable



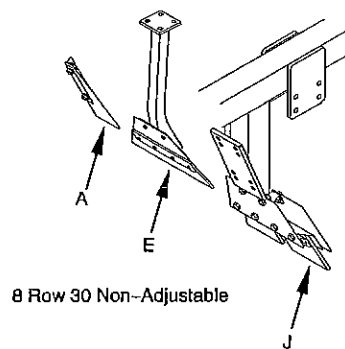
6 Row 30 Adjustable



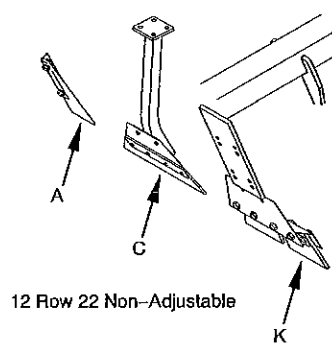
8 Row 22 Adjustable



8 Row 28 Non-Adjustable



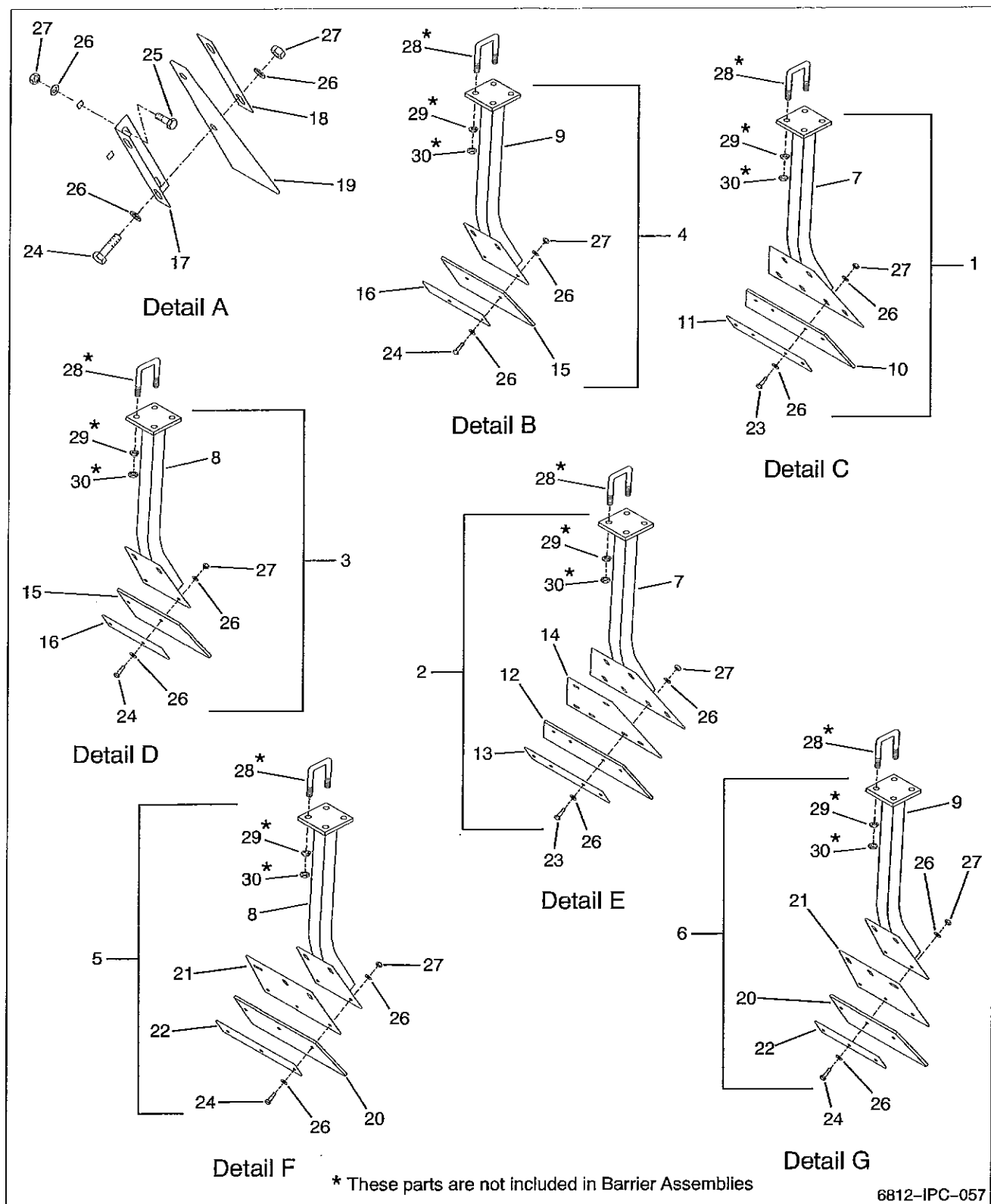
8 Row 30 Non-Adjustable



12 Row 22 Non-Adjustable

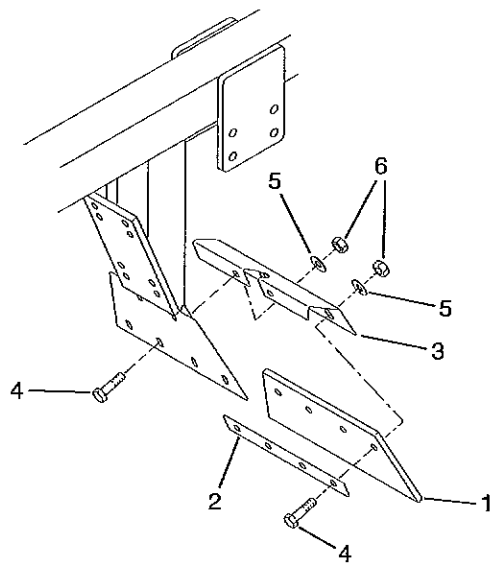
BARRIER ARRANGEMENTS (ALL HEADS)

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

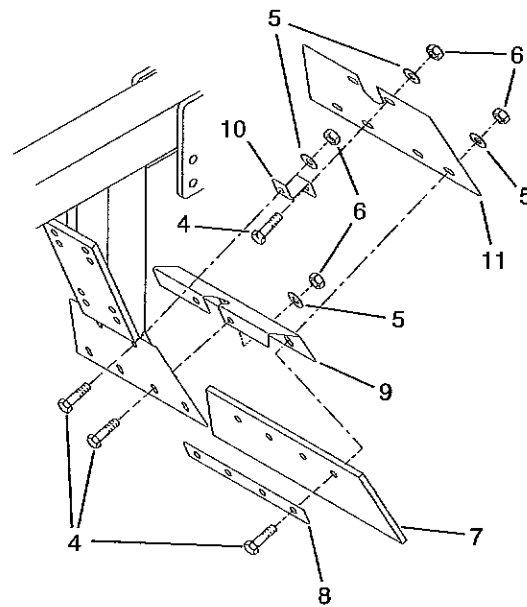
BARRIER DETAILS (ALL HEADS)

BARRIER DETAILS (ALL HEADS)

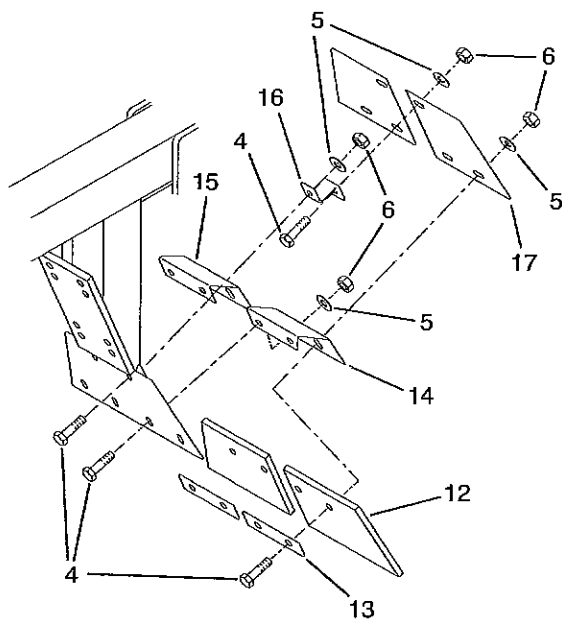
FIG ITEM	PART NUMBER	NOMENCLATURE
		1 2 3 4 * * * *
1	446320	Barrier Assembly, Center
2	446330	Barrier Assembly, Center
3	446280	Barrier Assembly, Left
4	446360	Barrier Assembly, Right
5	530920	Barrier Assembly, Left
6	530930	Barrier Assembly, Right
7	446310	Barrier Wldt
8	446340	Barrier Wldt
9	446350	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	J03H155B	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)

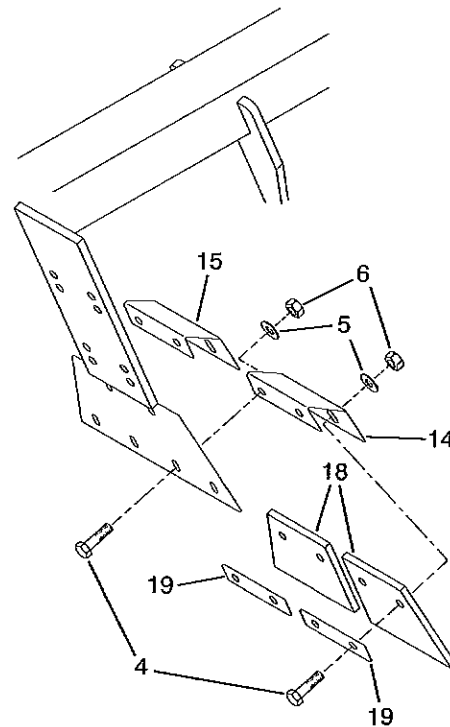
Detail H
6R22/24 OR 8R22



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

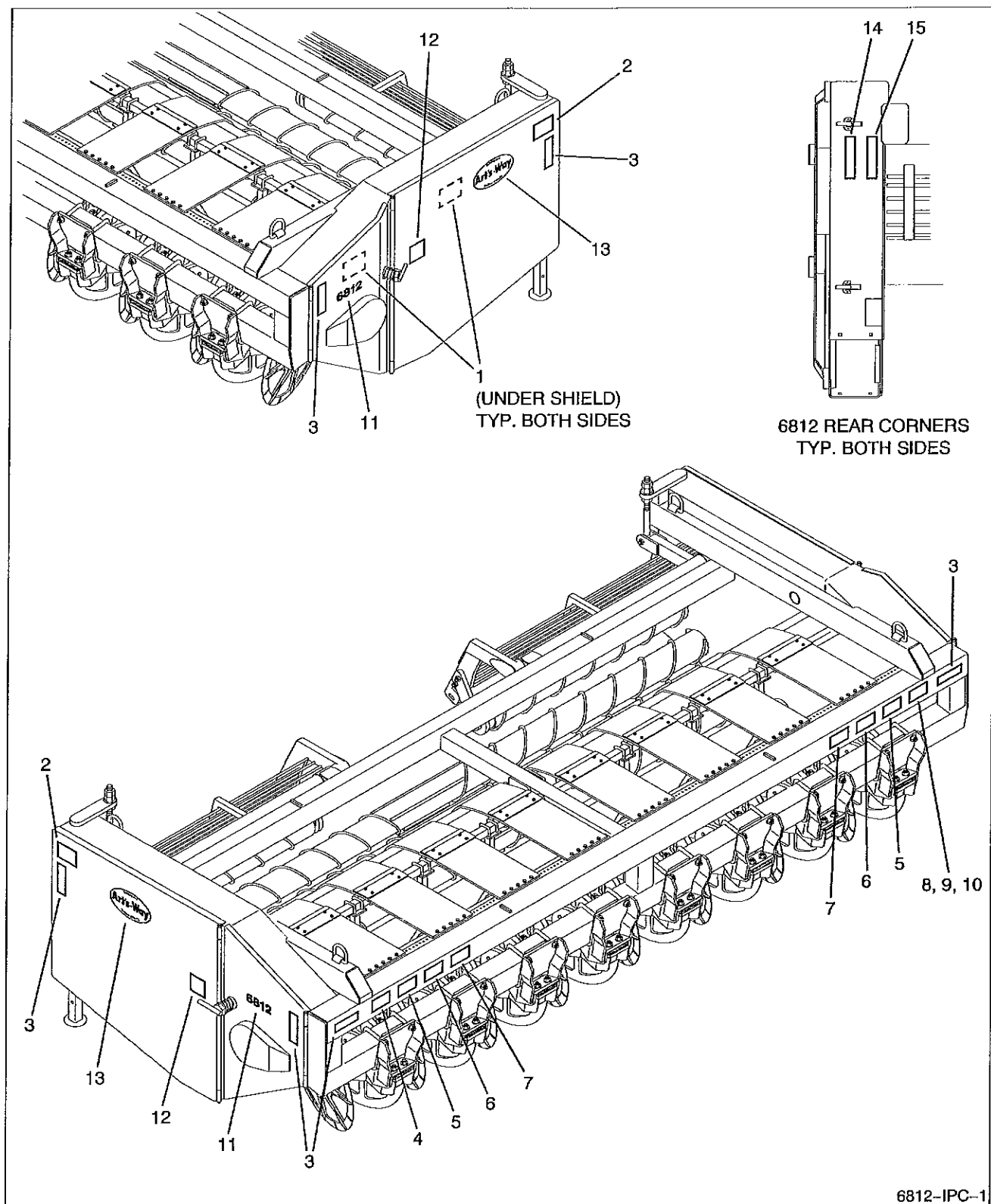


FIG ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 * * * *	UNITS PER ASSY
1	467430	Decal, Danger, Shield Missing	4
2	467470	Decal, Warning, Overhead Hazard	1
3	476460	Tape, Yellow, Retro-Reflective	6
4	467440	Decal, Danger, Electrocution	1
5	467410	Decal, Danger, Rotating Roll Hazard	2
6	467400	Decal, Warning, Thrown Object Hazard	2
7	46742D	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

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