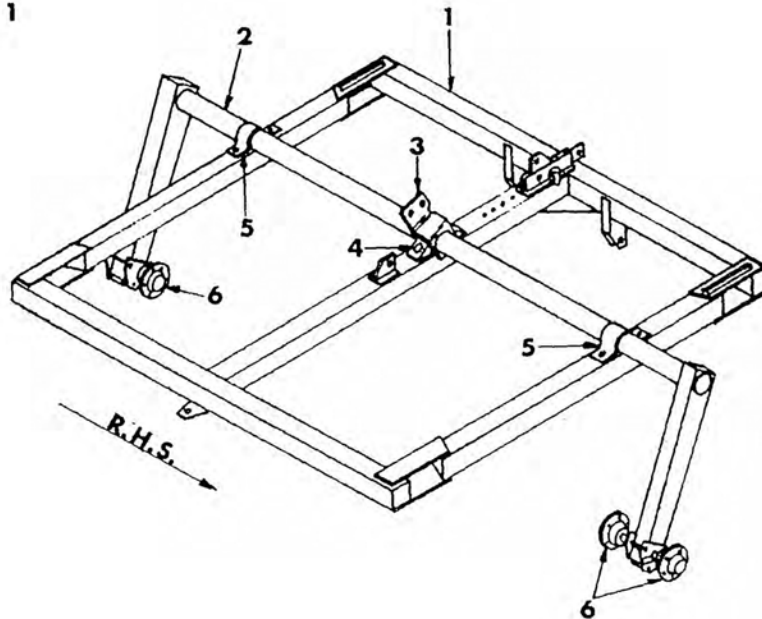


ILL. 1

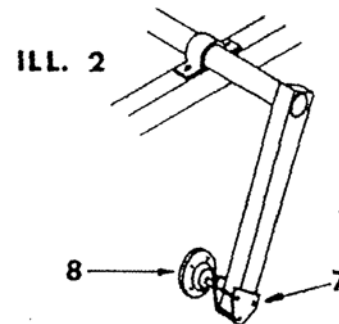


ASSEMBLY INSTRUCTIONS

1. See ILL. 1. Raise frame, arrow 1, approximately 30" (732mm) from ground and block securely.
2. See ILL. 2. Lay rockshaft, arrow 2, over frame. Position rockshaft so that cylinder arm, arrow 3, is on the right hand side of frame center beam. Fasten rockshaft to frame with 3 bearings, arrow 4 and 5, the center bearing, arrow 4, is reinforced with gussets. Bolt each bearing to frame with two (2) 3/4" x 5-1/2" (70mm x 140mm) bolts. Tighten bolts.

3. ATTACHING HUB ASSEMBLIES

- a) DUAL WHEELS – See ILL. 1. Fasten 2 hub assemblies, arrow 6, to bottom of each rockshaft wheel leg with three (3) 5/8" x 6" (92mm x 152mm) bolts. Tighten bolts.
- b) SINGLE WHEELS – See ILL. 2. For smaller Discs equipped with single wheels, the hub assembly, arrow 8, must be fastened to inside of each wheel leg. Fasten hub assembly to wheel with backing plate, arrow 7, and three (3) 5/8" x 6" (92mm x 152mm) bolts. Tighten bolts.



4. See ILL. 1. Install a grease fitting in bearings, arrow 4 and 5.



CAUTION: USE ADEQUATE MANPOWER OR A HOIST TO LIFT HEAVY COMPONENTS IN PLACE. ATTEMPTING TO LIFT HEAVY COMPONENTS BY YOURSELF COULD CAUSE SERIOUS INJURY.

Assembly Instruction continued:

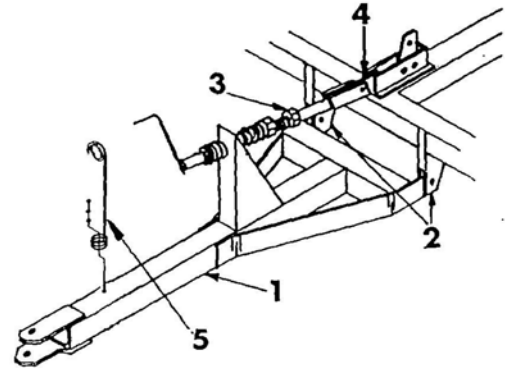
5. ATTACHING HITCH ASSEMBLY – SEE ILL. 3.

- a) Fasten hitch assembly, arrow 1, to frame hitch lugs, arrow 2, with two (2) 1" (25.4mm) diameter pins. Secure pin with cotter pins.
- b) Fasten crank link, arrow 3, of hitch assembly to lug, arrow 4, at center of frame with one pin. Secure pin with cotter pin.

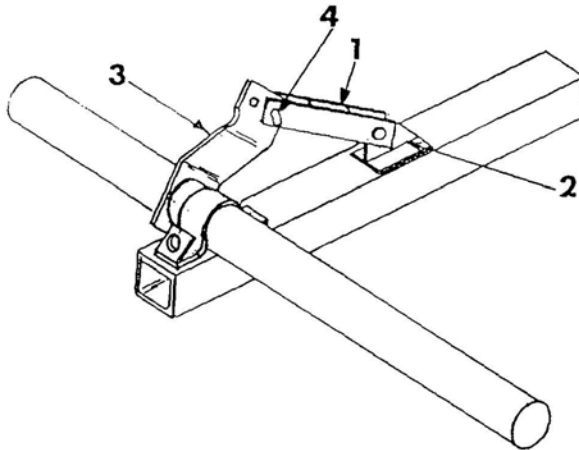
6. See ILL. 3. Fasten hose support, arrow 5, to bolt welded to top of hitch tongue with one (1) 11/16" (17mm) I.D. flatwasher, one (1) 5/8" (16mm) nut.

7. Bolt wheel and tire assembly to hub assemblies and tighten bolts.

ILL. 3



ILL. 4



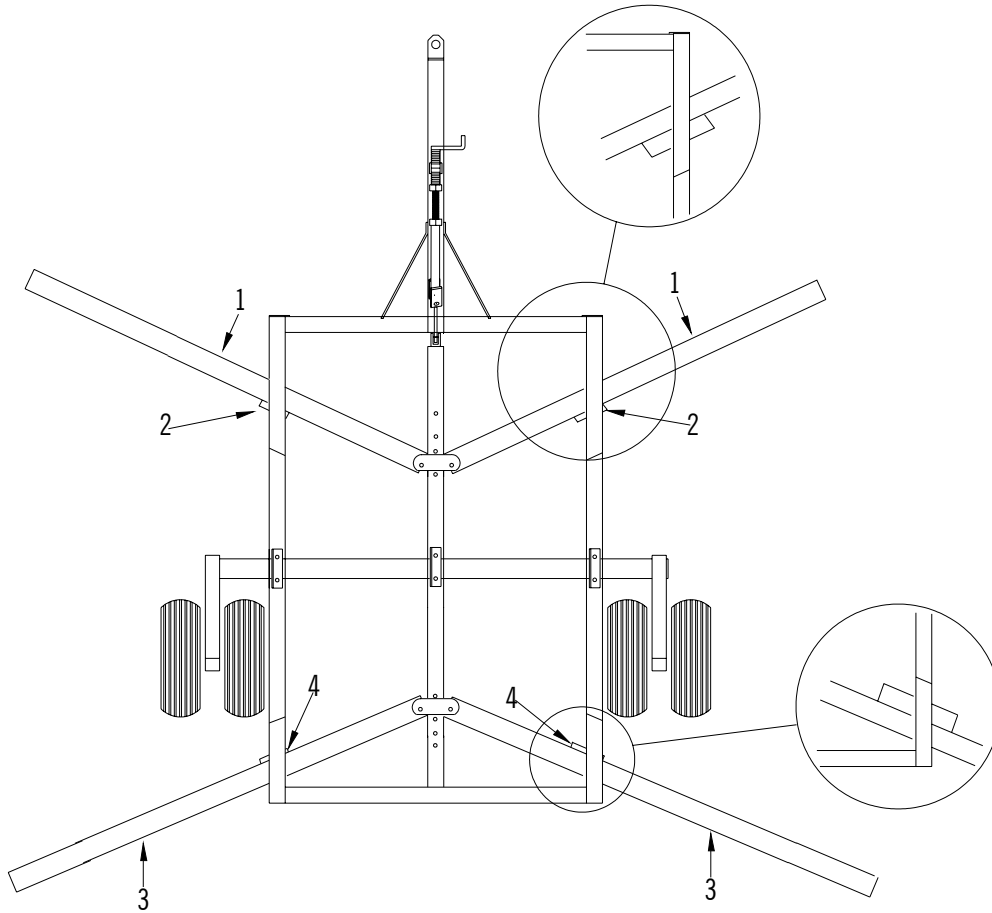
8. See ILL. 4. Fasten lock-up strap arrow 1, to lug, arrow 2, on frame with one (1) 1" x 3" (25mm x 76mm) bolt. Use round hole in lock-up strap to frame.

9. See ILL. 4. Raise frame on wheels and fasten lock-up, arrow 1, to rear hole in cylinder arm, arrow 3, with pin arrow 4. Secure pin with hair pin cotter. This will place the rockshaft in lock-up position.



CAUTION: SUPPORT MAIN FRAME AND WING FRAME SECURELY BEFORE ASSEMBLING COMPONENTS. HEAVY FRAME COULD CAUSE SERIOUS INJURY IF THEY FELL. WHEN ASSEMBLING DISC USE ALGNIING PUNCH TO LINE UP HOLES. KEEP FINGERS OUT OF HOLES.

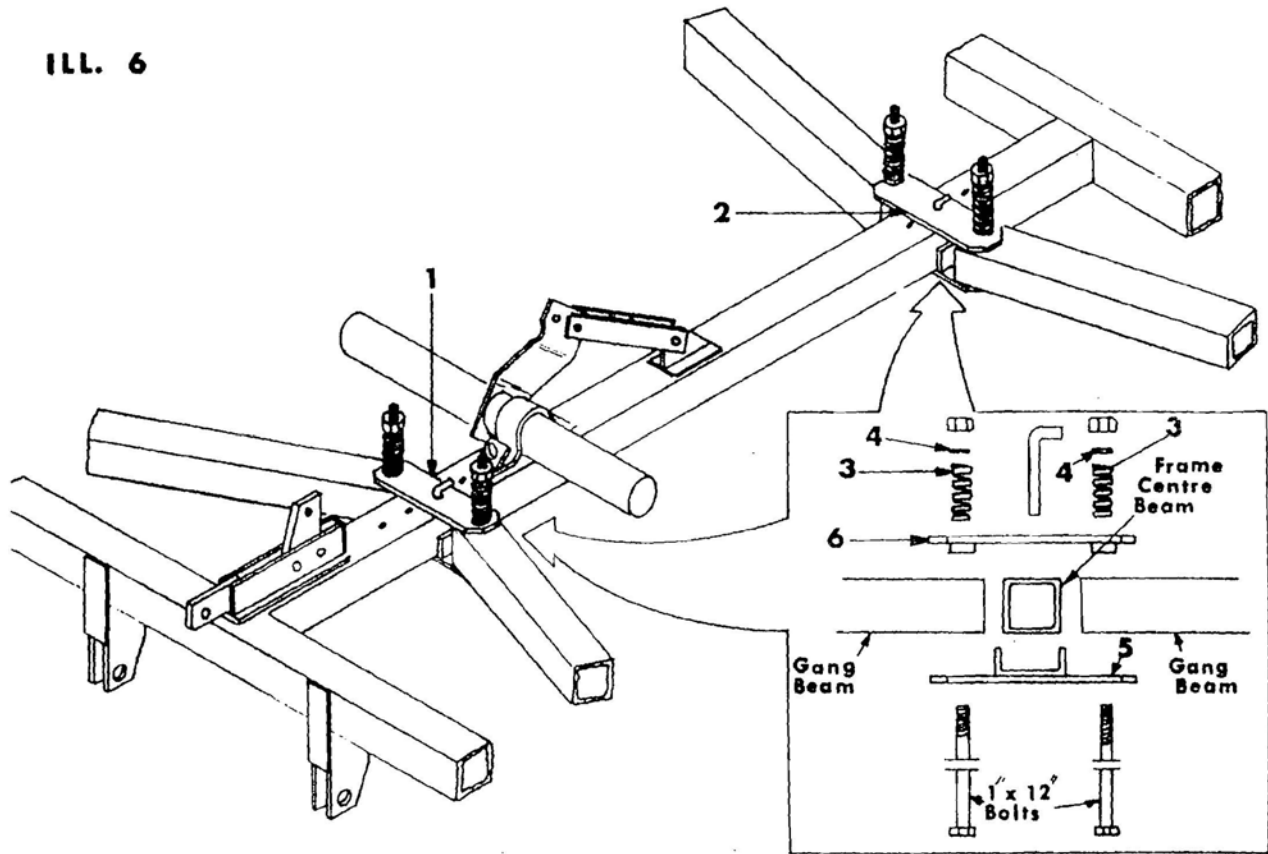
ILL. 5



NOTE: See Gang Beam Chart on Page 20 to determine gang beam lengths for the size of your Disc.

10. See ILL. 5. Install the 2 short gang beams, arrow 1, through the front side openings of frame. The front gang beams must be positioned so that the stabilizing bracket, arrow 2 (welded to each gang beam) is facing rear of Disc.
11. See ILL. 5. Install the 2 long gang beams, arrow 3, through the rear side openings of frame. The rear gang beams must be positioned so that the stabilizing bracket, arrow 4 (welded to each gang beam) is facing rear of Disc.

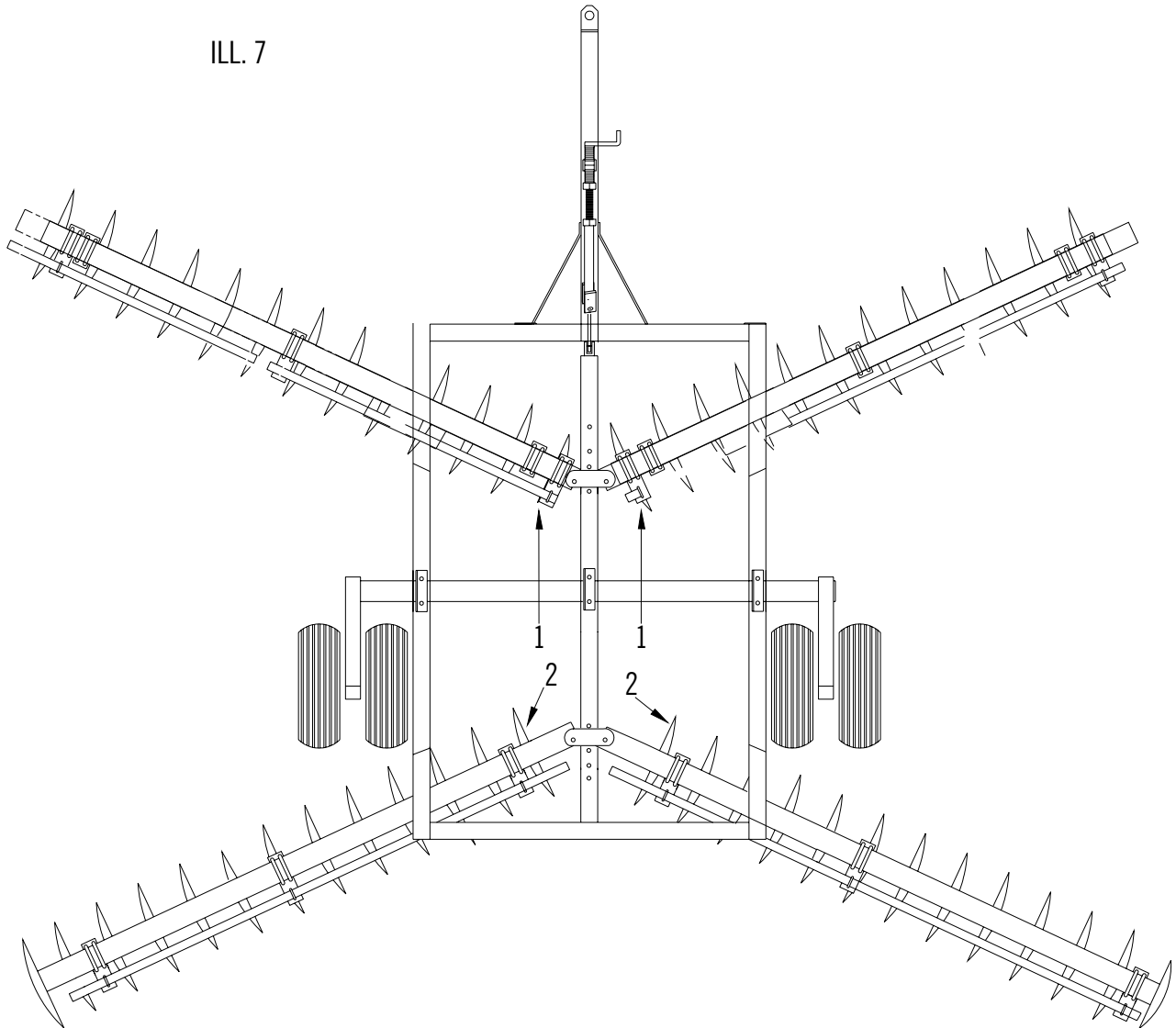
ILL. 6



12. See ILL. 6. Fasten one spring assembly, arrow 1 and 2, over each set of holes in center beam of frame. When fastening spring assembly to frame, place gang beams between top and bottom plate of spring assembly. Fasten each gang beam to spring assembly with one (1) 1" x 12" (25mm x 305mm) bolt. Install bolt from bottom of spring assembly.

Next place spring, arrow 3, over each 1" x 12" (25mm x 305mm) bolt. Then place washer arrow 4, over each spring and secure bolt with nut. Be sure spring assembly plate with weld-on channel, arrow 5, is located on bottom side of frame. Also be sure the top plate, arrow 6, of spring assembly is positioned with weld-on spacer facing down. Pin front spring assembly in third hole from rear. Pin rear spring assembly in third hole from front.

ILL. 7



13. ATTACHING GANG ASSEMBLIES – See ILL. 7.

NOTE: See Disc gang arrangements on pages 16 to 20, to determine proper gang arrangement for your Disc.

- a) Roll rear gang assemblies in place under rear gang beams. Position gangs as shown above. See Disc gang arrangement to determine which are the rear gangs.



CAUTION: ALWAYS PLACE TRACTOR CONTROLS IN NEUTRAL AND LOCK BRAKES WHEN HITCHING DISC TO TRACTOR. TRACTOR COULD ROLL BACKWARDS WHEN HITCHING DISC.

attaching gang assemblies continued:

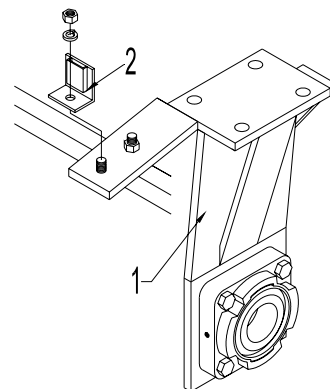
- b) To attach the rear gangs, jack up the front of Disc frame, pivoting frame on wheels until rear gang beams touch the gang bearing hangers. Fasten each bearing hanger to gang beam with two (2) U-bolts per bearing hanger. Leave U-bolts loose. Remove jack.
- c) Roll front gang assemblies in place under front gang beam, position gangs as shown above. See Disc gang arrangement to determine which are the front gangs.
To attach the front gangs, jack up rear of Disc frame, pivoting frame on wheels until front gang beams touch the gang bearing hangers. Fasten each bearing hanger to gang beam with two (2) U-bolts per bearing hanger. Leave U-bolts loose. Remove jack.
- d) See ILL. 7. Adjust front gangs so that the inside blade, arrow 1, of each gang, is as close as possible to the center of the Disc. If front gangs are positioned too far apart, the center ridge will be too large for the center tooth to remove.
- e) WING TYPE DISC ONLY – Adjust the spacing between gang assemblies. This spacing should be the same as the spacing the blades in the gang assemblies.
- f) IMPORTANT – Tighten the U-bolts of the outside bearing hanger of each gang first. Be sure the second and third hanger are sitting square with the gang beam before tightening U-bolts.
NOTE: Scraper bar U-bolts may have to be loosened to square bearing hangers.

IF BEARING HANGERS ARE NOT SITTING SQUARE BEFORE TIGHTENING U-BOLTS, THRUST WILL BE BUILT INTO THE BEARINGS AND THE LIFE OF THE BEARING WILL BE SHORTENED.

14. See ILL. 8. VERY IMPORTANT
Loosen all the bolts which fasten the bearings to the bearing hangers, arrow 1. Turn the Disc blades to allow the bearings to align themselves. Tighten all bolts.

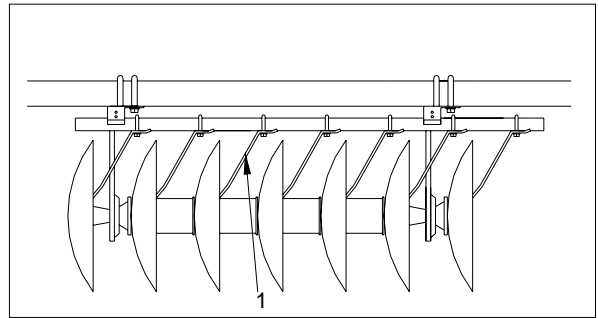
This will ensure proper bearing alignment, increasing bearing life.

ILL. 8



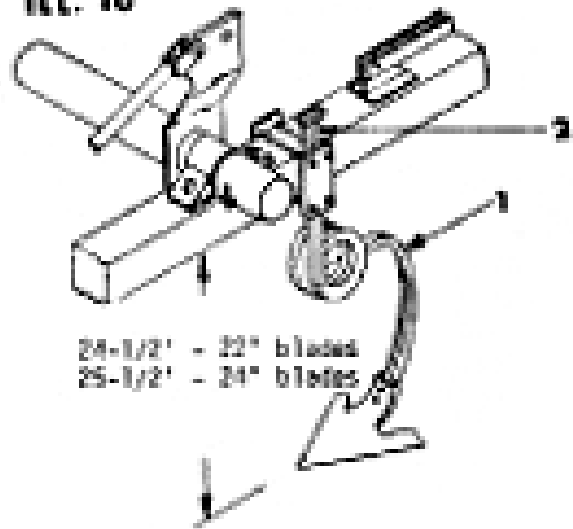
15. See ILL. 9. Adjust Disc scrapers, arrow 1, so that the scrapers are in contact with Disc blades.

ILL. 9



16. See ILL. 10. Clamp center tooth assembly, arrow 1 to side of center tube of frame with two (2) clamp plates and four (4) 5/8" x 7-1/2" (15.7mm x 191mm) bolts. Locate center tooth between lock-up lug and rockshaft. Clamp upright, arrow 2, of center tooth to left hand side of frame so that the point of shovel is on center of frame.

ILL. 10



See ILL. 10 for height of center tooth for each side of blade.

17. See ILL. 10. Assembly one (1) 3-1/2" x 8" (88.9mm x 203.2mm) hydraulic cylinder, arrow 3, to lug, arrow 4, and rockshaft arm, arrow 5. Secure each end of cylinder with one (1) 1" x 3-1/2" (25.4mm x 88.9mm) cylinder pin. Position cylinder with ports facing up. Secure each pin with one (1) cotter pin.
18. See ILL. 10. Install two (2) 1/2" (12.7mm) N.P.T. x 90 degree street elbow, arrow 6 and 7, in cylinder ports. After tightening, elbow should face front of disc.
19. See ILL. 10. Connect one (1) 1/2" x hydraulic hose, shaft end elbow, arrow 6. Connect one (1) 1/2" x hydraulic hose bottom port elbow, arrow 7.
20. See ILL. 10. Thread hydraulic hose through hose support at front of hitch.



CAUTION:

DO NOT DISCONNECT HYDRAULICALLY OPERATING COMPONENTS WHEN THERE IS PRESSURE WITHIN THOSE COMPONENTS. HYDRAULIC COMPONENTS UNDER PRESSURE MAY CAUSE PARTS AND HYDRAULIC FLUID TO FLY OUT AT A HIGH VELOCITY, WHICH COULD CAUSE SERIOUS INJURY.

HYDRAULIC OIL ESCAPING UNDER PRESSURE HAS SUFFICIENT FORCE TO CAUSE SERIOUS INJURY.

CHECK HYDRAULIC HOSES PERIODICALLY FOR SIGNS OF RUPTURE.