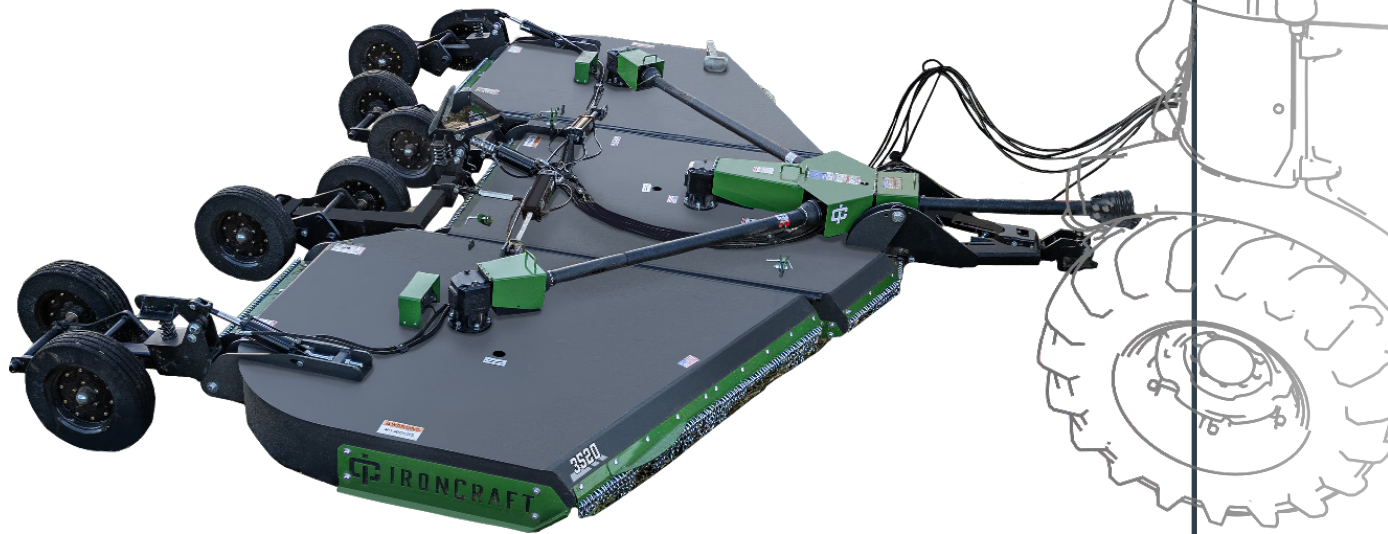




3520 SERIES

FLEX-WING ROTARY CUTTER



USE AND MAINTENANCE GUIDE

540 RPM	1000 RPM
16,600 FPM	17,400 FPM



Scan QR code for a digital version of this manual
Read and understand the manual. This manual provides information
and procedures to safely operate and maintain the Rotary Cutter.



April 2024

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REGISTER THIS PRODUCT

WWW.IRONCRAFTUSA.COM/WARRANTY/REGISTER-WARRANTY/

PURCHASE DATE

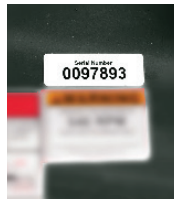
DEALER NAME

ADDRESS

PHONE NUMBER

MODEL

SERIAL



The serial number decal is located on the left front of the center deck.



"WHY WOULD I WANT TO REGISTER MY MACHINE?"

HERE'S THE LOWDOWN. YOU NEED TO REGISTER YOUR NEW PRODUCT WITHIN 30 DAYS OF DELIVERY. WITHOUT REGISTRATION, YOUR WARRANTY CLAIMS WILL NOT BE HONORED.

Registering your machine means you get the full benefits of the warranty terms we offer.

Scan this QR code to our warranty page and select the "REGISTER" tab for an easy-peasy process.

You'll be glad you did.



THANK YOU

Dear Owner:

Congratulations on your choice of a IronCraft flexwing rotary cutter. This equipment has been designed and manufactured to meet the needs of discerning users.

Many features incorporated into this rotary cutter are the result of suggestions made by customers like you. Read this manual carefully to learn how to operate the rotary cutter safely and how to set it to provide maximum cutting efficiency.

By following the operating instructions, in conjunction with a good maintenance program, your IronCraft rotary cutter will provide many years of trouble-free service.

Sincerely,

 **IRONCRAFT™**

The IronCraft Team

INTRODUCTION

1.1 SAFE OPERATION

Safe, efficient, and trouble-free operation of your rotary cutter requires that you, and anyone else who will be using or maintaining the unit, read and understand the information contained within the Owner's Manual.

Use this manual for frequent reference and to pass on to new operators or owners.



WARNING

READ AND UNDERSTAND MANUAL



To prevent personal injury or even death, be sure you read and understand all of the instructions in this manual and other related OEM equipment manuals! The rotary cutter, if not used and maintained properly, can be dangerous to users unfamiliar with its operation. Do not allow operating, maintaining, adjusting, or cleaning of this rotary cutter until the user has read this manual and has developed a thorough understanding of the safety precautions and functions of the unit.

This rotary cutter is designed for the specific purpose of cutting grass, weeds, and brush. DO NOT modify or use this rotary cutter for any application other than that for which it was designed.

Rotary cutters maintained or operated improperly or by untrained personnel can be dangerous; exposing the user and/or bystanders to possible serious injury or death.

1.2 SAFETY SHIELDS

Some of the illustrations in this manual may show the equipment with safety shields removed for clarity. Never operate the rotary cutter unless all safety shields are in place.



WARNING

CUTTING OR ENTANGLEMENT HAZARD



Operating the rotary cutter without the safety shields can result in physical injury or death. Make sure all shields are properly installed before operating the rotary cutter. This equipment should never be operated with any safety shielding removed.

1.3 SPECIFICATIONS

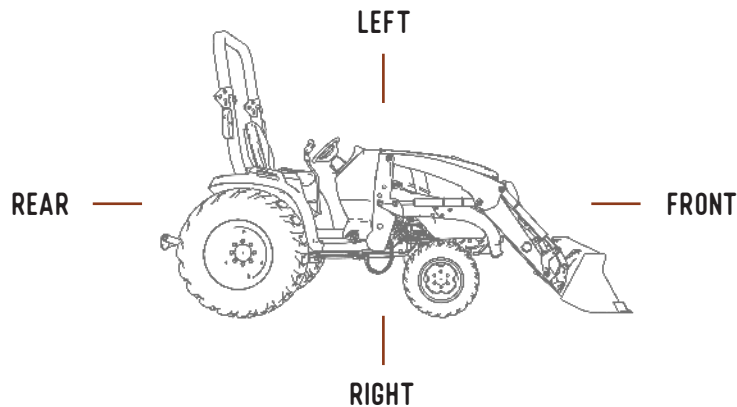
MODEL	3520
CUTTING WIDTH	20'
CUTTING HEIGHT	2" to 15"
OVERALL WIDTH	249"
TRANSPORT WIDTH	94" (108" w/. Tandems)
HITCH	Swivel Pivot Self Leveling
UNDERNEATH DECK	Heavily Braced
MINIMUM TRACTOR PTO	80 HP
DECK THICKNESS	10 GA Center / 7 GA Wings
SIDE SKIRT	1/4" x 13.5"
APPROX. WEIGHT	8700 LBS w/ six 26" Laminated Tire
APPROX. TONGUE WEIGHT	2700 LBS
BLADES	1/2" x 4" Uplift
BLADE TIP SPEED	Blade Tip Speed
BLADE OVERLAP	2.6"
PTO DRIVELINE	ASAE Cat 6
WING DRIVELINE	ASAE Cat 6
WING FLEX	22° Down / 100° Up
SPLITTER GEARBOX RATING	275 HP
OUTBOARD GEARBOX RATING	225HP
GEARBOX WARRANTY	5 Year Limited
MACHINE WARRANTY	1 Year Limited
CUTTING CAPACITY	4.0"
CUTTER SUSPENSION	2 Heavy Duty springs positioned on the center tail wheel axle & 1 Heavy Duty Spring on Each Wing Tailwheel Assy
SAFETY TOW CHAIN	Standard Assy
CHAIN GUARDS	Standard
SKID SHOES	Replaceable
WHEEL OPTIONS	26" Laminated Tire 26" Foam Filled Aircraft Tires 29" Pneumatic Aircraft Tires

1.4 INTENDED USAGE

Do not use this rotary cutter for any other purpose than its intended use of cutting grass, weeds, and brush.

1.5 OPERATOR ORIENTATION

The directions left, right, front, and rear, as mentioned throughout this manual, are as seen from the tractor operator's seat and facing in the direction of travel.



1.6 PRODUCT IMPROVEMENTS

Because IronCraft maintains an ongoing program of product improvement, we reserve the right to make improvements in design or changes in specifications without incurring any obligation to install them on units previously sold.

1.7 DISPOSAL OF EQUIPMENT AT END OF USEFUL LIFE

The IronCraft rotary cutter has been designed for the specific purpose of cutting grass, weeds, and brush. When this unit is no longer capable of doing its designed purpose, it should be dismantled and scrapped. Do not use any materials or components from this unit for any other purpose.

1.8 UNANSWERED QUESTIONS

If you have any questions not answered in this manual or require additional copies or the manual is damaged, please contact your dealer or:

IronCraft
P.O. Box 968
7 Rocky Mount Road
Athens, TN 37303

Phone: (423) 405-5150
Fax: (423) 334-0023

The manual is also available for download at:
www.IronCraftco.com. (Navigate to the 3515 page for the manual link.)

SAFETY INFORMATION

2.1 GENERAL

Safety of the operator and bystanders is one of the main concerns in designing and developing a new piece of equipment. Designers and manufacturers build in as many safety features as possible. However, every year many accidents occur which could have been avoided by a few seconds of thought and a more careful approach to handling the equipment.

Most work-related accidents are caused by failure to observe basic safety rules or precautions. An accident can often be avoided by recognizing potentially hazardous situations before an accident occurs. As you assemble, operate, or maintain the rotary cutter (unit), you must be alert to potential hazards. You should also have the necessary training, skills, and tools to perform any assembly or maintenance procedures.

Improper operation and maintenance of this unit could result in a dangerous situation that could cause injury or death.

If you have any questions not answered in this manual or require additional copies or the manual is damaged, please contact your dealer or: IronCraft, P.O. Box 968, 7 Rocky Mount Road, Athens, TN 37303, Phone: (423) 405-5150, Fax: (423) 334-0023



WARNING

Do not assemble, operate, or maintain the unit until you read and understand the information contained in this manual.



NOTICE

Safety precautions and warnings are provided in this manual and on the unit. If these hazard warnings are not heeded, bodily injury or death could occur to you or to other persons.

IronCraft cannot anticipate every possible circumstance that might involve a potential hazard. The warnings in this manual and on the unit are, therefore, not all-inclusive. If a method of assembly, operation, or maintenance not specifically recommended by us is used, you must satisfy yourself that it is safe for you and for others. You should also ensure that the unit will not be damaged or be made unsafe by the methods that you choose.

The information, specifications, and illustrations in this manual are based on the information that was available at the time this material was written and can change at any time without notice.

2.2 SAFETY ALERT SYMBOLS



SAFETY ALERT SYMBOL

This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

This manual contains DANGERS, SAFETY INSTRUCTIONS, CAUTIONS, IMPORTANT NOTICES, and NOTES which must be followed to prevent the possibility of improper service, damage to the equipment, personal injury, or death. The following key words call the readers' attention to potential hazards.

HAZARD CLASSIFICATIONS

Hazards are identified by the "Safety Alert Symbol" and followed by the signal word "DANGER", "WARNING", or "CAUTION".



DANGER

Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. This signal word is limited to the most extreme situations.



WARNING

Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION

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



NOTICE

Indicates a situation which may cause damage to equipment or property. Messages are not related to personal injury.



SAFETY INSTRUCTIONS




















Indicates specific safety-related instructions or procedures.


Note: Contains additional information important to a procedure.

2.3 SAFETY ICON NOMENCLATURE

Pictorial icons signal a type of hazard and warn of personal protection issues, prohibited actions, and hazard avoidance.


PERSONAL PROTECTION / IMPORTANT INFORMATION

-  Read the manual
-  Maintenance procedure
-  Damaged hazard label
-  Eye protection
-  Fire extinguisher
-  First aid kit
-  Hand protection
-  Head protection
-  Hearing protection
-  Inspect equipment
-  OEM parts only
-  Protective shoes
-  Remove key
-  Set parking brake
-  Think safety
-  Transmission in park
-  Stop engine
-  Use proper support
-  Use proper tools

 Use two people when lifting heavy objects

 Visibility


 Rollover protection

 Wear seat belt


 Weight rating


 Clear vision

PROHIBITED ACTIONS


 Do not alter or modify


 Use proper tools

 Do not weld

 No alcohol

 No drugs


 No smoking

 No young children


 No riders

HAZARD AVOIDANCE

   Crush hazard


 Crush hazard (chock wheels)

 Crush hazard (foot)

 Defective or broken part


 High-pressure fluid hazard


 Explosive force hazard

 Explosive separation hazard


 Crush hazard


 Fire Hazard

 Cutter blade contact hazard (hand)


 Cutter blade contact hazard (foot)


 Lifting hazard

 Hose damage


 Pinch point hazard


 Projectile hazard

 Rollover protection


 Safety alert symbol

 Safety shields

 Sharp object hazard

 Slipping Injury

 Pressure hazard

 Tripping injury

 Falling hazard

GENERAL SAFETY INSTRUCTION

The owner/operator is responsible for the SAFE use and maintenance of the rotary cutter. Make sure anyone who is operating, maintaining, or working around the rotary cutter is familiar with the operating and maintenance procedures and related SAFETY information contained in this manual. This manual will take you step-by-step through your working day and alerts you to all good safety practices that should be used while using the rotary cutter.

In addition to the design features of the rotary cutter, including safety signs, accident prevention is dependent upon the awareness, concern, prudence, and proper training of the people involved in the operation, maintenance, and storage of the rotary cutter.

In addition to this safety section, refer also to safety messages and instructions in each of the appropriate sections of the rotary cutter manual.

These general safety instructions apply to the overall use and maintenance of the rotary cutter.

More specific instructions on safety are found in the operation, maintenance, and storage sections of this manual. Refer to these sections before performing any of these tasks.



WARNING

Failure to comply with the following safety instructions can and will result in serious injury and possibly even death if they are not understood and followed.



WARNING



PROVIDE USER WITH LITERATURE

IronCraft rotary cutter owners must provide operator instructions to anyone using the rotary cutter before use, and at least annually thereafter. Refer to “OSHA Training Requirements”.



STAY CLEAR

Clear the area of people, especially small children, before using the rotary cutter. Under no circumstances should young children be allowed to work with or around the rotary cutter.



IMPAIRED USER HAZARD

Do not attempt to assemble, operate, or maintain this rotary cutter under the influence of drugs or alcohol. Consult your doctor before using this rotary cutter while taking prescription medications.



CRUSH HAZARD

Do not allow anyone to ride on the tractor or the rotary cutter. Falling or crushing hazards can result in severe injuries or death.



FALLING HAZARD

Do not allow riders on the hitch, tractor, or rotary cutter at any time. Falling can result in severe injuries or death.



NO UNAUTHORIZED MODIFICATIONS

Do not modify the rotary cutter or safety devices. Do not weld on the unit. Unauthorized modifications may impair its function and safety. Personal injury or death can result from unauthorized modifications.



If the rotary cutter has been altered in any way from the original design, IronCraft does not accept any liability for injury or warranty.



DAMAGED PARTS HAZARD

Do not use the rotary cutter if any parts are damaged. If the rotary cutter has a defect, immediately stop using it and remedy the problem before continuing.



THROWN OBJECTS HAZARD

Rotary cutter can throw objects up to 300 feet. To avoid serious injury or death:

Keep all thrown object shielding in place. Inspect area for potential thrown objects before cutting.

Do not operate the rotary cutter with the deck or wings raised.

SAFETY SHIELDS

Some illustrations in this manual show the equipment with safety shields removed to provide a better view. This equipment should never be operated with any necessary safety shielding removed.



CAUTION

The following safety instructions are provided to help prevent potential injury. Not following these instructions may lead to injury.



PERSONAL PROTECTION EQUIPMENT



When using this rotary cutter, wear appropriate personal protective equipment. This list may include, but is not limited to:



- Protective shoes with slip-resistant soles
- Protective goggles, glasses, or a face shield
- Protective clothing and gloves
- Safety vest (when operating near roads)
- Hearing protection



CRUSH HAZARD

The tractor should be equipped with a Roll Over Protective Structure (ROPS) and a seat belt. A crushing hazard can occur if the driver is ejected from the seat while the tractor is in motion. Fasten the seat belt whenever the tractor is moving.



EAR PROTECTION

Wear suitable ear protection during prolonged exposure to excessive noise.



HEARING LOSS

Prolonged Exposure To Loud Noise May Cause Permanent Hearing Loss!

Working environments with noise-producing equipment can cause partial to permanent hearing loss. We recommend using hearing protection any time noise levels exceed 80 decibels (dB). Noise levels over 85 dB, on a long-term basis, can cause severe hearing loss. Noise levels over 90 dB over a period of time can cause permanent and even total hearing loss.

Hearing loss from loud noise is cumulative over a lifetime without hope of natural recovery.



SAFETY INSTRUCTIONS

The following safety instructions are provided to help prevent injury or limit equipment damage.



SAFETY SIGNS

Replace any missing or hard-to-read safety signs or instructional labels. Use care when washing or cleaning the rotary cutter.

Replacement safety sign locations and part numbers are provided in this manual and are available from an authorized dealer parts department or the factory.



FIRST AID KIT

Have a first aid kit available for use should the need arise and know how to use it.



FIRE EXTINGUISHER

Have a fire extinguisher available for use should the need arise and know how to use it.



THINK SAFETY!

Work SAFELY!

2.4 TRAINING

Anyone who will be using and/or maintaining the rotary cutter must read, clearly understand, and follow ALL safety, operation, and maintenance information presented in this manual, other related OEM manuals, and the safety signs

If you do not understand any information in this manual, see your dealer or contact IronCraft before proceeding.

Do not use or allow anyone else to use this rotary cutter until all information has been reviewed. Annually review this manual before the season start-up.

Make periodic reviews of SAFETY and OPERATION of the rotary cutter a standard practice. An untrained operator is not qualified to use this rotary cutter.

2.5 OSHA TRAINING REQUIREMENTS

The following training requirements have been taken from Title 29, Code of Federal Regulations Part 1928.57 (a) (6). www.osha.gov.

Operator instructions. At the time of initial assignment and at least annually thereafter, the employer shall instruct every employee who operates an agricultural tractor and implements in the safe operating practices and servicing of equipment with which they are or will be involved, and of any other practices dictated by the work environment.

2.6 FEDERAL LAWS AND REGULATIONS

IMPORTANT FEDERAL LAWS AND REGULATIONS

CONCERNING EMPLOYERS, EMPLOYEES AND OPERATORS

This sections is intended to explain in broad terms the concept and effect of the following federal laws and regulations. It is not intended as a legal interpretation of the laws and should not be considered as such.

U.S. PUBLIC LAW 91-596 (The Williams-Steiger Occupational Safety and Health Act of 1970) OSHA

This Act Seeks:

“ ... to assure so far as possible every working man and woman in the nation safe and healthful working conditions and to preserve our human resources ... “

DUTIES

Sec. 5(a) Each Employer -

1. shall furnish to each of its employees employment and a place of employment which are free from recognized hazards that are causing or are likely to cause death or serious physical harm to its employees.
2. shall comply with occupational safety and health standards promulgated under this Act.
 - b. Each employee shall comply with occupational safety and health standards and all rules, regulations, and orders issued pursuant to this Act which are applicable to his or her own actions and conduct.

OSHA REGULATIONS

Current OSHA regulations state in part: “At the time of initial assignment and at least annually thereafter, the employer shall instruct every employee in the safe operation and servicing of all equipment with which the employee is, or will be involved.” These will include (but are not limited to) instructions to:

Keep all guards in place when the machine is in operation;

Permit no riders on equipment;

Stop engine, disconnect the power source, and wait for all machine movement to stop before servicing, adjusting, cleaning, or unclogging the equipment, except where the machine must be running to be properly serviced or maintained, in which case the employer shall instruct employees as to all steps and procedures which are necessary to safely service or maintain equipment.

Make sure no one is within 300 feet of machinery before starting the engine, engaging power, or operating the machine.

EMPLOYEE TRACTOR OPERATING INSTRUCTIONS:

1. Securely fasten your seat belt if the tractor has a ROPS.
2. Where possible, avoid operating the tractor near ditches, embankments, and holes.
3. Reduce speed when turning, crossing slopes, and on rough, slick, or muddy surfaces.
4. Stay off slopes too steep for safe operation.
5. Watch where you are going, especially at row ends, on roads, and around trees.
6. Do not permit others to ride.
7. Operate the tractor smoothly - no jerky turns, starts, or stops.
8. Hitch only to the drawbar and hitch points recommended by tractor manufacturers.
9. When tractor is stopped, set brakes securely and use park lock if available.

CHILD LABOR UNDER 16 YEARS OLD

Some regulations specify that no one under the age of 16 may operate power machinery. It is your responsibility to know what these regulations are in your own area or situation. (Refer to U.S. Dept. of Labor, Employment Standard Administration, Wage & Home Division, Child Labor Bulletin #102).

2.7 SIGN-OFF FORM

IronCraft follows the general Safety Standards specified by the Farm Equipment Manufacturers Association (FEMA), and the American National Standards Institute (ANSI). Anyone who will be using and/or maintaining the hydraulic reservoir system must read and clearly understand ALL safety, operation and maintenance information presented in this manual.

Do not use or allow anyone else to use this rotary cutter until all information has been reviewed. Annually review this manual before the season start-up.

Make periodic reviews of SAFETY and OPERATION of the rotary cutter a standard practice. An untrained operator is not qualified to use this rotary cutter.

This sign-off sheet at the end of this manual is provided for your record keeping to show that all personnel who will be working with the equipment have read and understand the information in this Operator's Manual and Parts Book and have been instructed in the operation of the equipment.

2.8 OPERATION SAFETY

Refer to "User Safety Training" for safety recommendations related to using the rotary cutter. All applicable safety recommendations in other sections should also be followed.

2.9 TRANSPORTING SAFETY

Refer to the "Transporting Safety (Road)" for safety recommendations related to transporting the rotary cutter. All applicable safety recommendations in other sections should also be followed.

2.10 STORAGE SAFETY

Refer to the "Storage Safety" for safety recommendations related to storing the rotary cutter. All applicable safety recommendations in other sections should also be followed.

2.11 MAINTENANCE SAFETY

Refer to the "Maintenance Safety" for safety recommendations related to maintaining the rotary cutter. All applicable safety recommendations in other sections should also be followed.

SAFETY SIGNS AND INSTRUCTIONAL LABELS

3.1 GENERAL INFORMATION

The types of safety signs (hazard labels) and instructional labels, along with their locations on the equipment, are shown in the following illustrations. Good safety practices require that you familiarize yourself with the various safety signs, the type of warning, and the area or particular operation related to that area that requires your SAFETY AWARENESS.

THINK SAFETY! WORK SAFELY!

Pay close attention to the safety signs and instructional labels attached to the tractor and the rotary cutter. Duplicate safety signs, which are attached to the rotary cutter, can also be found in this section. If the rotary cutter is missing a label or one is unreadable, replace the label before using the rotary cutter.

SAFETY SIGNS AND INSTRUCTIONAL LABELS



SAFETY SIGNS

- Keep safety signs or instructional labels clean and legible at all times. Use a clean, damp cloth to clean safety decals.
- Replace any missing or hard-to-read safety signs or instructional labels.
- Use care when washing or cleaning the equipment not to remove or damage the labels. When using a pressure washer to clean the unit, avoid spraying too close to decals; high-pressure water can enter through very small scratches or under edges of decals causing them to peel or come off.
- Locations for the labels and replacement part numbers are shown in this section.
- Replacement parts must have replacement labels attached during installation and/or before the reservoir system is used.
- Labels are available from your authorized dealer at no charge.

3.2 HOW TO INSTALL REPLACEMENT SAFETY SIGNS



NOTICE

Do not install the signs if the temperature is below 50°F (10°C).

1. Clean and dry the installation area.
2. Determine the exact position before you remove the backing paper.
3. Remove the backing paper.
4. Align the sign over the specified area and carefully press the sign to the part/frame.

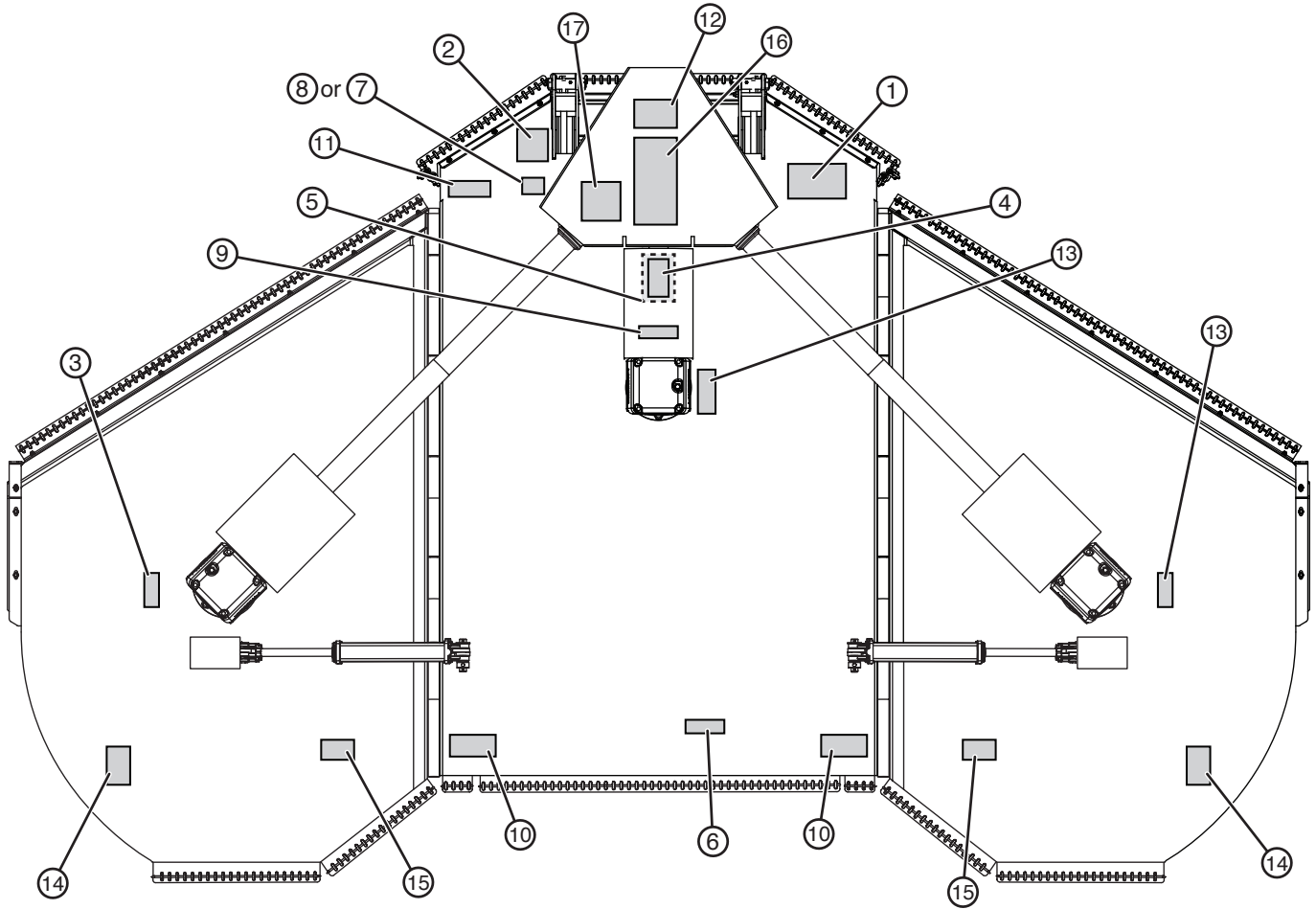


NOTICE

Small air pockets can be pierced with a pin and smoothed out using the piece of backing paper.

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3.3 SAFETY DECAL LOCATIONS



REF	DESCRIPTION	QTY.
1	1 DANGER Follow Safety Messages	1
2	2 DANGER Maintain Shields and Deflectors	1
3	3 INSTRUCTIONAL Blade Rotation (CCW)	2
4	4 DANGER Rotating Driveline, Keep Away, Outer Shield Tube	1
5	5 DANGER Shield Missing, Do Not Operate	1
6	6 WARNING Use Paper or Cardboard to Check for Leaks	1
7*	WARNING PTO Speed 540 RPM	1
8*	WARNING PTO Speed 1000 RPM	1
9	WARNING Keep Mower Deck Clear of Debris	1
10	WARNING No Riders	4
11	SERIAL Serial Number	1
12	INSTRUCTIONAL Made In the USA	1
13	INSTRUCTIONAL Blade Rotation (CW)	1
14	DANGER Keep Away - Thrown Objects	2
15	DANGER Stay Clear	2
16	WARNING Do Not Transport at Speeds Over 20 MPH	1
17	INSTRUCTIONAL 5 Year Gearbox Limited Warranty	1

* Use item 7 or 8, as appropriate.

3.3.1 CUTTER DECK SAFETY DECALS

1.

⚠ DANGER

1. Make certain drivelines are of the correct length and securely attached. **IMPROPER SERVICE UNDER PTO DISC COUPLER FAILURE CAN CAUSE INJURY OR DEATH.** (See Operator's Manual for procedure.)
2. Make certain that driveline shields are **INSTALLED CORRECTLY** and **TURN FREELY** to prevent injury or death from entanglement.
3. Make certain that driveline is installed correctly on TRACTOR PTO SHAFT. Drive shaft must be in full contact with PTO shaft. Do not use PTO RPM unless specifically marked otherwise.

2.

⚠ DANGER

BEFORE FOLLOWING SAFETY MESSAGES AND OPERATING INSTRUCTIONS, PLEASE READ THE OPERATOR'S MANUAL FOR THIS IMPLEMENT. FAILURE TO DO SO CAN CAUSE INJURY OR DEATH.

1. Read the operator's manual for this implement.
2. Read the operator's manual for the tractor.
3. Read the operator's manual for the PTO.
4. Read the operator's manual for the driveline.

3.

BLADE ROTATION

4.

⚠ DANGER

ROTATING DRIVELINE CONTACT CAN CAUSE DEATH KEEP AWAY!

DO NOT OPERATE WITHOUT

- All driveline guards, tractor and equipment shields in place
- Drivelines securely attached at both ends.
- Driveline guards that turn freely on driveline

5.

⚠ DANGER

SHIELD MISSING DO NOT OPERATE

⚠ DANGER

6.

⚠ WARNING

Use paper or cardboard to check for leaks. NEVER USE YOUR HAND. If oil penetrates skin, gangrene or other serious injury could occur. **GET IMMEDIATE MEDICAL ATTENTION.** See Operator's manual.

7.

⚠ WARNING

OPERATE THIS MACHINE AT **540 RPM** TRACTOR PTO SPEED ONLY

Overspeeding PTO may cause component failure with resulting injury.

8.

⚠ WARNING

OPERATE THIS MACHINE AT **1000 RPM** TRACTOR PTO SPEED ONLY

Overspeeding PTO may cause component failure with resulting injury.

9.

⚠ WARNING

Keep Mower Deck Clear of Debris

There is a risk of Fire when dry material accumulates and contacts heat generated from rotating components. See Operator's Manual for fire prevention.

10.

⚠ WARNING

NO RIDERS

11.

Serial Number

0010001

12.

MADE IN THE USA WITH U.S. & IMPORTED PARTS

13.

BLADE ROTATION

14.

⚠ DANGER

KEEP AWAY - THROWN OBJECTS

- Inspect the area before mowing for potential mower hazards. Remove or avoid all foreign objects such as wire, cable, metal objects, and all other foreign material.
- Foreign material can be thrown from the mower and cause serious bodily injury to the operator and passersby.
- Do Not let rotating blades contact solid objects like rocks, posts, curbs or guard rails.
- Operate only if all Guards-Deflectors are in place and in good condition.
- Do Not operate with Mower or Wing raised off the ground.
- Stop mowing if Passersby enter the area of thrown objects. (See Operator's Manual)
- Stay away from rotating blades. Keep hands and feet away from rotating blades.
- Do Not approach mower until all motion has stopped.

15.

⚠ DANGER

- Stay clear when removing transport strap and lowering or raising wing.
- Component failure or accidental operation of controls may cause wing to fall suddenly and cause **BODILY INJURY OR DEATH.**
- Cylinders with instructions installed must be checked with all for wings to lower slowly and safely. Lock wings up securely for transporting.
- Do not operate mower with wings raised when passersby are in the area.
- Contact with Exposed Rotating Blades and/or being hit by thrown objects may cause **INJURY OR DEATH.**

16.

NOTICE TO OWNER

An OPERATOR'S MANUAL (with Repair Parts Listing) and a WARRANTY REGISTRATION CARD were attached to this implement during final inspection at the factory. If they were not attached at the time of purchase, please contact your selling dealer at once.

1. Read and understand Manual before operating the implement.
2. Complete, sign, and mail the Warranty Registration Card to today.

IMPORTANT

REQUIRED FOR JACK SHAFT UNIT SUGGESTED FOR STANDARD SHAFT

Attach Safety Chain securely as per ASAE D338

⚠ WARNING

1. DO NOT transport it speeds above 20 mph. Exceeding 20 mph decreases braking ability and may cause loss of control and serious personal injury.
2. ONLY transport behind a properly sized and equipped tractor. NEVER tow behind a truck or other motor vehicle. ALWAYS properly fasten the implement safety tow chain to the tractor.
3. Reduce speed on inclines, while turning and when towing in adverse conditions.
4. ENSURE a DMV emblem can be clearly seen from behind the vehicle. Turn ON the tractor flashing warning lights when transporting.

17.

5 YEAR

GEARBOX LIMITED WARRANTY

NOMENCLATURE

4.1 DESCRIPTION AND INTENDED USE

The rotary cutter is designed for heavy-duty applications such as weeds, grass, and brush up to 4.0" diameter. The cutter uses three spindles with two free-swinging blades each, which reduce the shock of impact when a stationary object is contacted. Slip clutches protect the gearboxes and driveline from damage. Standard equipment includes driveline shields, gearbox shields, and front and rear chain discharge shields.



4.1.1 OWNER/OPERATOR MANUAL STORAGE



ALWAYS STORE THE OWNER/OPERATOR MANUAL AND OTHER OPERATING MATERIALS IN THE DOCUMENT STORAGE TUBE LOCATED ON THE FRONT GEARBOX SHIELD.



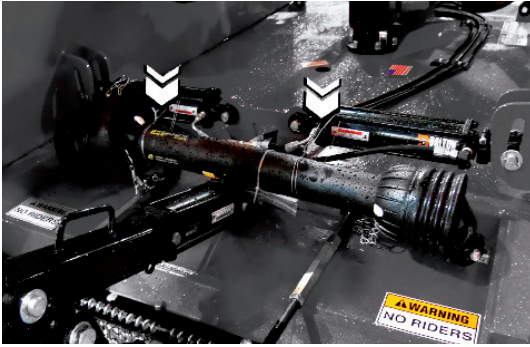
ASSEMBLY

5.1 TOOLS REQUIRED

TOOLS REQUIRED
Wrenches, 1/2", 5/8", 3/4", 1-1/8", 1-3/8", 1-1/2"
Ratchet with extension and sockets as above

5.2 ASSEMBLY PROCEDURE

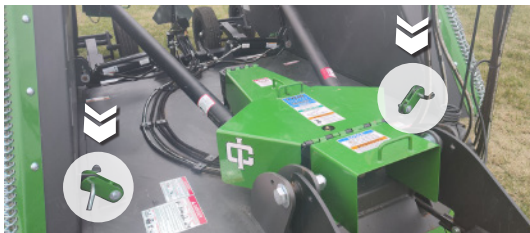
1. Cut the wires holding the driveline to the cutter. Set the driveline aside for now.



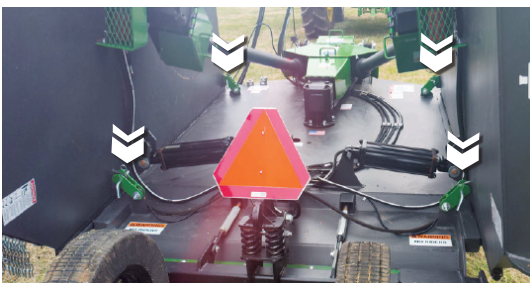
3. Remove the pins and washers.



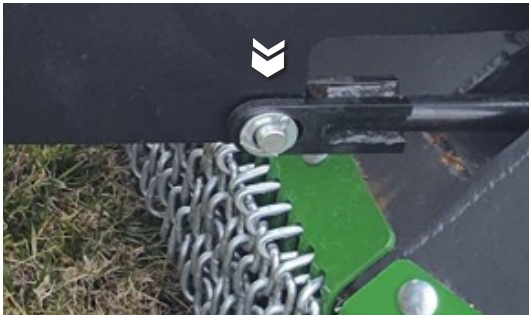
2. Verify that the wing uplock pins are in place. (4 Places)



4. Rotate the hitch forward using a suitable lifting device. The lifting device may be attached to the safety chain.



5. Install the pins and washers previously removed in Step 3, in the front of the leveling rods through the slot in the hitch.



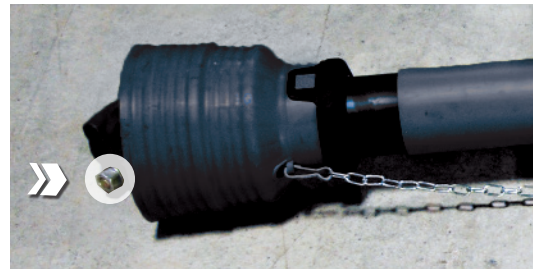
6. Loosen the bolt and nut on the hose rack. Stand the rack up and tighten the bolt and nut.



7. Remove the jack from its storage location on the left wing and install it on the lug on the left side of the hitch.



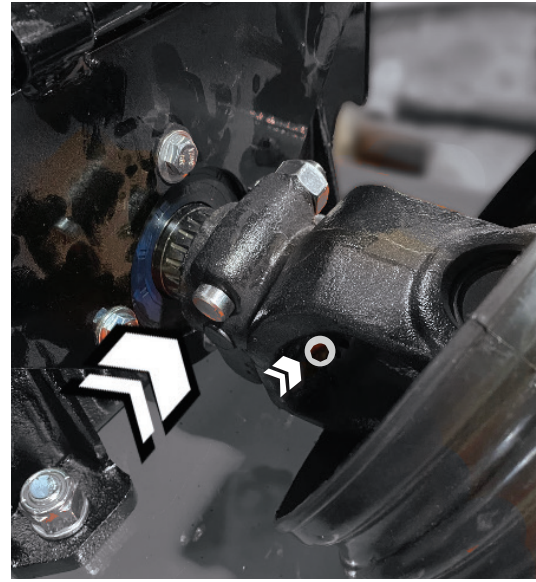
8 Remove the retaining bolt from the front driveline.



9. Raise the front gearbox cover.



10. Install the driveline onto the gearbox input shaft. Insert the retaining bolt and tighten the locknut securely.



WARNING CRUSH HAZARD

If the retaining bolt is not present, the driveline may separate from the gearbox, causing serious injury or death. Do not omit the retaining bolt. Tighten the locknut securely.

11. Attach the safety chain on the driveline guard to the gearbox cover.

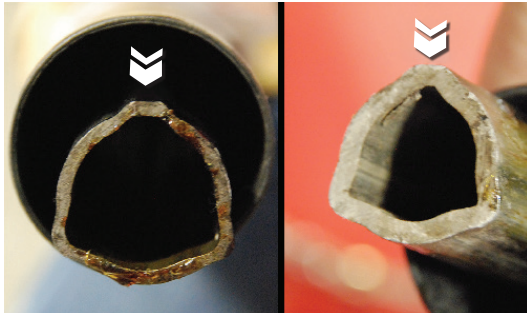


12. Separate the two halves of the driveline.

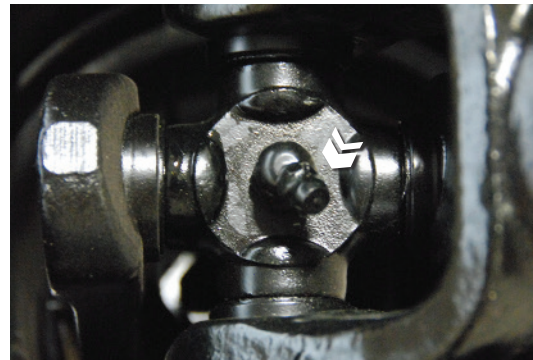
13. Apply a bead of grease around the end of the inner drive shaft.



15. Slide the front driveline half over the rear half. Align the square rib on the mating halves to engage.



16. Apply grease to the zerks on the U-joint crosses.



5.3 FINAL ASSEMBLY AND LEVELING

Attach the rotary cutter to the tractor. Follow the procedure in “6.3 Attaching to Tractor”.



NOTICE

Quick disconnect hydraulic couplers are not supplied with the unit. If desired, these may be procured from a local equipment dealer.

5.3.1 LEVELING THE CENTER DECK

1. With the cutter attached to the tractor, disengage the PTO and park on a level, hard surface. Place the tractor gear selector in park or set the parking brake.
2. Cycle the wheel lift cylinder several times to purge any trapped air and charge the hydraulic cylinder.

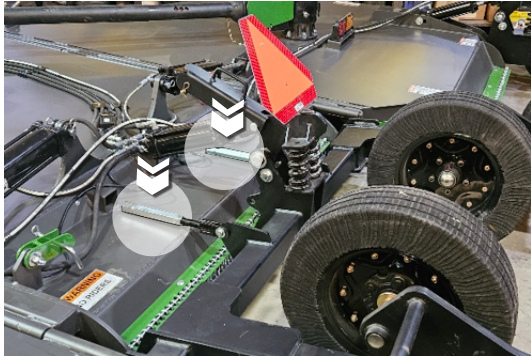


NOTICE

The lift cylinder must not be bottomed out during this procedure, or the leveling rods may become bent.



3. Use the hydraulics to adjust the cutter height until the front of the skid shoes are two to three inches off the ground.



4. Adjust the nuts to have equal amounts of tension.



WARNING

UNEXPECTED MOVEMENT

The cutter is shipped with the wings in the upright position. If the wing uplock pins are not in place, and the banding between the tailwheel tubes is cut, the wings will free-fall due to air in the hydraulic system. To avoid death or serious injury from being struck by a wing, stay clear of the wings. Purge all air from the hydraulic system, and do not remove the wing uplock pins until necessary to do so.

5. Cut the banding between the tailwheel tubes. The tailwheels will swing freely when the banding is cut. Stand clear to avoid being struck by a tailwheel.



WARNING

STAY CLEAR

The tailwheels will swing freely when the banding is cut. To avoid injury from being struck by a tailwheel, stay clear of the tailwheels.

5.3.2 LEVELING THE WING DECKS

The Hydraulic Tailwheel Assemblies utilize phasing hydraulic cylinders. This enables all of the tailwheels assemblies to self adjust based on pressure in the system.

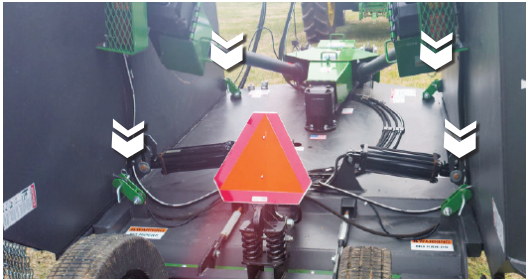
1. Start the tractor and cycle the wing lift control lever several times to purge any trapped air and charge the hydraulic cylinders.



NOTICE

The cutter does not have a hydraulic reservoir and therefore can deplete the oil in the tractor's reservoir during initial charging of the cylinders. Check the tractor's hydraulic oil reservoir after this initial setup and add oil as necessary.

2. Remove the wing uplock pins. (4 Places)



3. To prevent loss, lay the lock-bracket back until hitting the stop, then install the pins in the hole for safe storage.



WARNING CRUSH HAZARD

Hydraulic or mechanical failure can allow a wing to drop suddenly without warning. Do not allow anyone to walk under or stand near a raised wing when the uplock pins are removed.

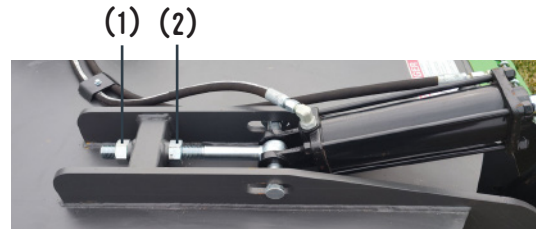


4. Lower the wings.



NOTICE

It is normal for the wings to lower or raise at different rates.



5. If necessary, raise and lower the wings until all air is purged from the system, then lower the wings to the operating position.
6. Check the tractor's hydraulic fluid reservoir and top off if necessary.
7. Check wing tops to see if they are level with the top of the center deck. If the outer edge of either wing top is higher or lower than the center deck, then that wing should be leveled as follows:

- a. If the outer wing edge is higher than the center deck, loosen jam nut (1) and rotate jam nut (2) counterclockwise to lower outer wing edge until wing is level. Tighten jam nut (1&2) to the correct torque when level.
- b. If outer wing edge is lower than the center deck, loosen jam nut (1) and rotate jam nut (2) clockwise to raise outer wing edge until wing is level. Tighten jam nut (1&2) to the correct torque when level.

5.4 CHECKING THE DRIVELINE LENGTH

Before operating the rotary cutter, make sure the driveline will not bottom out or become disengaged. Bottoming out occurs when the inner shaft penetrates the outer housing until the assembly can shorten no more. Bottoming out can cause serious damage to the tractor PTO by pushing the PTO into the tractor and through the support bearings or downward onto the PTO shaft, breaking it off. A broken driveline can cause personal injury.

1. Attach the rotary cutter to the tractor. Do not attach the driveline. Keep the driveline out of the way of moving parts.
2. Raise and lower the rotary cutter to determine the maximum and minimum

distance between the tractor PTO shaft and the gearbox input shaft. If the distance is too large, the driveline will be too short for proper engagement. If the distance is too small, the driveline may bottom out in operation and damage the rotary cutter or tractor.

There must be at least six inches of engagement at the rotary cutter's lowest possible point of operation, and the driveline must not bottom out when raised to the maximum height possible. If the driveline is too short, please call your IronCraft dealer for a longer driveline. If the driveline is too long, follow the instructions for shortening the driveline.

5.5 SHORTENING THE DRIVELINE

1. Move the rotary cutter up and down to get the shortest possible distance between the tractor PTO shaft and the gearbox input shaft. Shut down the tractor PTO shaft and the gearbox input shaft. Shut down the tractor leaving the rotary cutter in the position of shortest distance. Securely block the rotary cutter in position.
2. Separate the driveline into two halves and connect them to the tractor PTO and gearbox.
3. Place the driveline halves parallel to one another to determine how much to shorten the driveline.
4. Each section should end approximately 3" short of reaching the universal joint shield on the opposite section. If too long, measure 3" back from the universal joint shield and mark on the opposite section.
5. Repeat Step 4 for the other half of the drive.
6. Raise and lower the rotary cutter to determine the position with the greatest distance between the PTO shaft and the gearbox input shaft. Shut down the tractor leaving the rotary cutter in the position of greatest distance. Securely block the rotary cutter in position.
7. Hold the driveline sections parallel to each other and check for minimum 6" overlap. If the driveline has been marked for cutting, the overlap will be the distance between the two marks. If the driveline has less than the minimum overlap, do not use. Contact your IronCraft dealer.



NOTICE

If the driveline is the correct length, omit the following Steps 8 - 9 and proceed to Step 10.

8. Clamp a driveline section in a well-padded vice to prevent damage to the shield. Cut off the shield where marked. Using the cut off section of the shield as a guide, cut the shaft the same amount. Repeat for the other driveline section.
9. File and clean the cut ends of both drive halves. Remove all chips and filings.
10. Apply multi-purpose grease around the inner driveline section. Slide the drive halves over each other several times to distribute the grease. Install the driveline on tractor and rotary cutter. Make certain the driveline shielding is in place and in good condition.
11. Set the tractor lift control stop to a position that will prevent the driveline from contacting the front edge of the rotary cutter deck when the rotary cutter is fully raised.



NOTICE

Do not use the rotary cutter if proper driveline engagement cannot be obtained through these methods. Contact your IronCraft dealer.

OPERATION

6.1 USER SAFETY TRAINING

Refer to “General Safety Instruction” for user safety training requirements.

WARNING




ROLL AWAY HAZARD

Before leaving the tractor seat, make sure the engine is stopped, the transmission is placed in park, the key is removed, and the parking brake is set.

 The weight of the tractor, plus the rotary cutter if it rolls onto a person, can cause serious crushing injury or death.

CRUSH HAZARD


 The tractor should be equipped with a Roll Over Protective Structure (ROPS) and a seat belt. A crushing hazard can occur if the driver is ejected from the seat while the tractor is in motion. Fasten the seat belt whenever the tractor is moving.

The rotary cutter is top heavy when the wings are raised. To avoid injury or death from rollover, use caution when transporting over uneven surfaces and slow down for turns.

THROWN OBJECT HAZARD

 For non-agricultural use, OSHA, ASAE, SAE, and ANSI standards require the use of chain guards or other protective guards at all times.

THROWN OBJECT HAZARD

Cutters can throw objects up to 300 feet. To avoid serious injury or death:

1. Keep all thrown object shielding in place.
2. Inspect area for potential thrown objects before cutting.
3. Do not operate rotary cutter with the deck raised.

STAY CLEAR

Clear the work area of all unnecessary people and obstructions to prevent personal injury.

CUTTER BLADE CONTACT HAZARD (hand)

To avoid serious injury or death, keep away from rotating blades. Do not put hands under cutter deck.

CUTTER BLADE CONTACT HAZARD (foot)

To avoid serious injury or death, keep away from rotating blades. Do not put feet under rotary cutter deck.



WARNING

CRUSH HAZARD



Hydraulic or mechanical failure can allow a wing to drop suddenly without warning. Do not allow anyone to walk under or stand near a raised wing when the uplock pins are removed.



WARNING

ENTANGLEMENT HAZARD



Operating the rotary cutter without the driveline shields can result in physical injury or death from entanglement. Make sure all shields are properly installed before operating the rotary cutter. This equipment should never be operated with any safety shielding removed.



SAFETY INSTRUCTIONS

The following safety instructions are provided to help prevent injury or limit equipment damage.



TRAIN UNFAMILIAR USERS

It is the rotary cutter owner's responsibility to make sure any person using the rotary cutter, especially if it is loaned or rented, has been thoroughly trained on its proper and safe use.



USERS

who have not read and understood all operating and safety instructions are not qualified to use the rotary cutter.



TRAIN ALL NEW USERS

and review instructions annually with existing users.



UNTRAINED USERS

expose themselves and bystanders to possible serious injury or death.



PHYSICALLY-ABLE

Be certain only physically-able persons will use the rotary cutter.



ELDERLY

If the elderly are assisting with the work, their physical limitations need to be recognized and accommodated.



NO CHILDREN

Never allow children to operate equipment.



SAFETY INSTRUCTIONS



FIRE HAZARD

Clippings are flammable. To reduce the risk of fire:

1. Do not operate near fires.
2. Keep rotary cutter deck clear of clippings and debris.



FIRE EXTINGUISHER

Carry a fire extinguisher on the tractor at all times.



NOTICE

Wing cutting blades may become locked together (overlapped) when the wings are raised for transport. Operating the cutter in this condition will result in severe deck vibration. Inspect the wings for locked blades prior to lowering the wings. Use a pry bar or other tool to free any locked blades.

6.2 TRACTOR REQUIREMENTS



WARNING

TRACTOR OWNER/OPERATOR MANUAL



Always refer to the tractor owner's manual to ensure compatibility and maximum safety.

The tractor used to operate the cutter must have the power to lift, pull, and operate the Power Take Off (PTO) at the cutter's rated speed while traveling at a ground speed between 2 and 5 MPH.

The power required to operate the cutter is determined by the tractor PTO horsepower. Operating the cutter with a tractor that does not have adequate power may damage the tractor engine.

Operating the cutter with a tractor that does not meet the following requirements may cause tractor or cutter damage and be a potential danger to the operator and passersby.

Always review the "controls" section of the tractor operator's manual to be familiar with the location, settings, and function of the tractor controls. Be familiar with all controls before using this equipment.

MODEL 351S

Recommended Min. HP	80
---------------------	----

6.2.1 EQUIPMENT AND CAPABILITIES




REQUIREMENTS
Approved Roll-Over Protective Structure (ROPS) or ROPS cab and seat belt.
Tractor Safety Devices; Slow Moving Vehicle (SMV) emblem, lighting, PTO master shield.
Front end weight, as needed, to maintain 20% weight on front axle.
To reduce the risk of grass fires, do not operate the cutter on a tractor with an underframe exhaust.

6.2.2 TRACTOR SAFETY DEVICES

If transporting or operating the tractor and implement near a public roadway, the tractor must be equipped with proper warning lighting and a Slow Moving Vehicle (SMV) emblem which are clearly visible from the rear of the unit. Lights and a SMV emblem must be attached directly to the implement if the visibility of the tractor warning signals are obscured.

Maintain all manufacturer equipped safety shields and guards. Always replace shields and guards that were removed for access to connect, service, or repair the tractor or implement. Never operate the tractor PTO with the PTO master shield missing or in the raise position.

6.2.3 ROPS AND SEAT BELT

WARNING

ROLLOVER HAZARD

To avoid serious injury or death from falling off tractor, equipment runover, rollover, or crushing:

1. Use ROPS equipped tractor.
2. Keep ROPS locked in the UP position.
3. Only operate the equipment when seated in the tractor seat.
4. Always fasten seat belt when operating the tractor and rotary cutter.
5. The unit is top heavy when the wings are folded. Use caution when transporting over uneven terrain and slow down for turns.

The tractor must be equipped with a Roll Over Protective Structure (ROPS) (tractor cab or roll bar) and seat belt to protect the operator from falling off the tractor,

especially during a roll-over where the driver could be crushed and killed. Only operate the tractor with the ROPS in the raised position and seat belt fastened.

6.2.4 POWER TAKE-OFF (PTO)

This rotary cutter is available in versions to operate at a PTO speed of 540 RPM or 1000 RPM. Most tractors operate at either 540 or a combination of 540 and 1000 RPM PTO speeds. The operating speed of the rotary cutter and tractor can be determined by the number of splines on the driveline yoke and PTO output shaft.

Those operating at 540 RPM will have a 6-spline shaft, and those operating at 1000 RPM will have a 20 or 21-spline shaft.

Refer to the tractor Operator's Manual for instructions to change PTO speeds on models that operate at more than one speed.

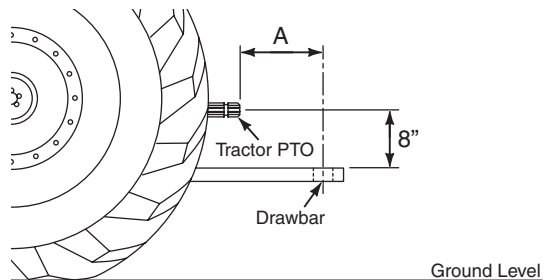
If operating an older model tractor where the tractor's transmission and PTO utilize one

master clutch, an over-running clutch must be used between the PTO output shaft and the driveline of the rotary cutter. An authorized tractor dealer can provide the over-running clutch and its installation, if needed.

DO NOT use a PTO adapter to attach a nonmatching implement driveline to a tractor PTO. Use of an adapter can double the operating speed of the implement, resulting in excessive vibration, thrown objects, and blade and implement failure. Adapter use will also change the working length of the driveline exposing unshielded driveline areas. Serious bodily injury and/or equipment failure can result from using a PTO adapter. Consult an authorized dealer for assistance if the implement driveline does not match the tractor PTO.

6.2.5 DRAWBAR

The distance between the drawbar hitch pin hole and the end of tractor PTO shaft must be set according to the PTO operating speed. The distance from the top of the drawbar to the PTO shaft must be 8". PTO damage may occur if these dimensions vary more than 1".



DRAWBAR LENGTH CHART	
PTO	DIMENSION A
540 RPM	14"
1000 RPM, 21 spline, 1-3/8" shaft 16"	16"
1000 RPM, 20 spline, 1-3/4" shaft	20"

6.3 ATTACHING TO TRACTOR

Use caution when connecting the rotary cutter to the tractor. The rotary cutter should be securely resting at ground level or setting on blocks. Keep hands and feet from under the deck and clear of pinch points between the tractor drawbar and rotary cutter hitch.



WARNING

CRUSH HAZARD



Crush hazard between hitch and implement. Do not allow anyone to stand between the hitch and implement during hook-up operations.

1. Use the jack to adjust the hitch to the height of the tractor drawbar.
2. Board the tractor and start the engine. Back the tractor up to the cutter hitch until the holes in the drawbar and clevis are aligned.
3. Turn off the tractor engine and dismount.
4. Insert a 7/8" or larger high strength drawbar pin through the clevis and drawbar holes and install retaining pin. Do not use a homemade or shop made pin.



WARNING

CRUSH HAZARD



Unexpected separation of the cutter from the tractor can cause death or serious injury. Use only an OEM high strength drawbar pin. Do not use a homemade or shop made pin.

5. See diagram for correct hitch clevis orientation.
6. Connect the hitch safety chain to the tractor drawbar cage.
7. Retract the jack, remove the locking pin, move the jack to its storage location on the cutter deck, and secure it with the locking pin.
8. Pull back on collar (1) on the tractor end of the driveline.

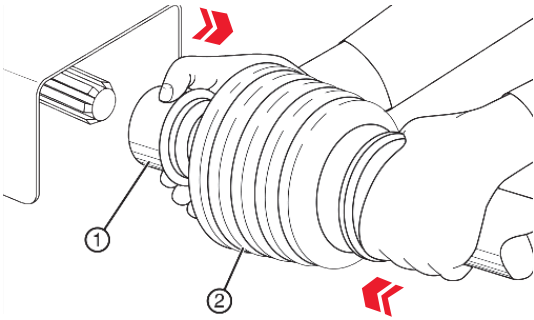


HITCH SUPPORT
IS UP

CLEVIS HINGE
IS UP

DUCK BILL
IS DOWN

9. Push the driveline onto the tractor PTO shaft until the collar snaps forward.



10. Pull back on driveline guard (2) to check that the driveline is latched. Do not pull back on the collar, as this will release the driveline.

11. Attach the safety chain on the driveline guard to the tractor.

WARNING

ENTANGLEMENT HAZARD

Operating the tractor PTO without the driveline shields can result in physical injury or death from entanglement. Make sure all driveline shields are properly installed before operating the PTO. Make sure all motion has stopped before attaching or detaching the driveline.

12. Inspect the hydraulic hoses to ensure they are in good condition and clean the fittings. Route the hydraulic hoses through the hose rack and attach to the tractor's hydraulic ports. Make sure the hoses are adequately supported so they cannot come in contact with other parts or the ground.

13. Make sure the driveline has adequate clearance through the full range of cutter height adjustment. Adjust tractor drawbar height and/or length if there is interference. See "6.2.5 Drawbar" for correct drawbar dimensions.

6.4 SETTING THE ROTARY CUTTER

Properly setting the rotary cutter is essential for efficient and safe operation. A properly set rotary cutter will make a more uniform cut, distribute clippings more evenly, require minimal tractor work, and

follow the contour of uneven terrain. The two adjustments to make before cutting are:

- Leveling front-to-back
- Cutting height



NOTICE

Avoid very low cutting heights. Striking the ground with the blades causes damaging shock loads and will cause damage to the rotary cutter and drive. Blades contacting the ground may cause objects to be thrown out from under the cutter deck. Avoid operating the rotary cutter at a height which causes the blades to contact the ground.

6.4.1 LEVELING FRONT-TO-BACK

1. Locate the tractor and cutter on a flat, level surface and use the hydraulics to adjust the cutter height until the front skid shoes are two to three inches off the ground.
2. Shorten or lengthen the leveling rods, as needed, until the front of the deck is level with the rear of the deck. Lengthening the leveling rods raises the back of the cutter.
 - a. Operating the rotary cutter with the deck approximately 3/4" higher in the rear than the front will allow the rotary cutter to cut

the grass only once and requires less work from the tractor.

- b. Operating the rotary cutter with the deck approximately 3/4" higher in the front than the rear will increase mulching of the grass or crop material.
 - c. Operating the rotary cutter at any position other than level with the ground will result in a slightly uneven cut.
3. Adjust the leveling rods to have equal amounts of tension.

6.4.2 SETTING THE CUTTING HEIGHT

The rotary cutter should be operated at the highest position, which will give the desired cutting results. This will help prevent the blades from striking the ground, increasing blade life, and reducing stress on the rotary cutter and tractor.

1. Park the tractor and rotary cutter on level ground.

2. Using the tractor hydraulic cylinder control lever, position the front of the rotary cutter with the side skids 1" lower than the desired cut height. For example, for a 3" cut, position the skids 2" from the ground. Set the control lever stop at this position to maintain this height when raising and lowering the cutter.

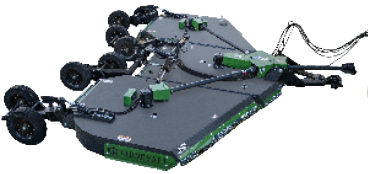
6.5 INITIAL SETUP CHECKLIST

(PRIOR TO USING FOR THE FIRST TIME)

Efficient and safe operation of the rotary cutter requires that every user read and understand the operational instructions and all related safety instructions outlined in this manual.

This checklist is provided for the user/owner. It is important for both personal safety and to maintain the mechanical condition of the rotary cutter that this checklist is followed.

START HERE



01

SAFETY SIGNS

Verify all safety signs are in place and legible. Refer to “3.3 Safety Sign Locations”.

ROTARY CUTTER IS PROPERLY MOUNTED

Make sure the rotary cutter is properly attached to the drawbar. Refer to “6.3 Attaching to Tractor”.

02



03

DRIVELINE

Make sure the driveline is attached to the tractor PTO, and safety chains are installed. Refer to “6.3 Attaching to Tractor”.

HARDWARE

Make sure all hardware is properly installed and tightened. Refer to “9.11 Bolt Torque Requirements”.

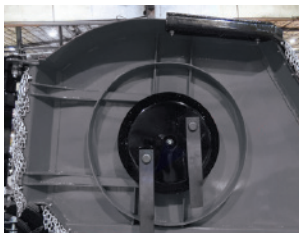
04



05

BLADES

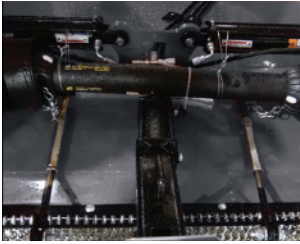
Check that the blades are sharp. Refer to “9.6 Blade Servicing”.



BLADE CARRIER

Make sure the blade carrier nuts are tight and the cotter pins installed. Refer to “9.7 Blade Carrier Removal”.

06



07

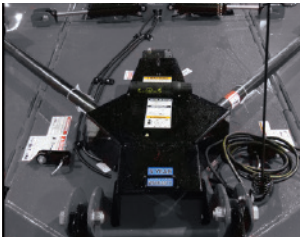
ZERKS

Lubricate all grease zerks. Refer to “9.3 Greasing”.

DRIVELINE SLIP JOINT

Lubricate driveline slip joints. Refer to “9.3 Greasing”.

08



09

SAFETY SHIELDS

Make sure all safety shields and guards are properly installed. Refer to “5.2 Assembly Procedure”.

GEARBOX GREASE LEVEL

Check the gearbox oil level. Refer to “9.4 Gearbox Lubrication”.

10



11

TAILWHEELS

Check the tailwheels for damage. Make sure the tailwheel support bolts are tight.

CUTTER HEIGHT

Check the cutting height. Adjust if needed. Refer to “6.4.2 Setting the Cutting Height”.

12



6.6 MACHINE BREAK-IN

Although there are no operational restrictions on the rotary cutter when used for the first time, it is recommended that the following mechanical items be checked:

MAINTENANCE TASK	CHECK AFTER OPERATING FOR	
	30 MIN	10 HOUR
Tighten all fasteners if necessary.	✓	
Lubricate all grease fittings.	✓	
Go to the normal servicing and maintenance schedule, as defined in the Maintenance Section.		✓

6.7 PRE-OPERATION CHECKLIST

Before each use of the rotary cutter, the following areas should be checked.

CHECKLIST BEFORE EACH USE	✓
Make sure the rotary cutter is positively attached to the tractor drawbar. Refer to “6.3 Attaching to Tractor”	
Make sure the hydraulic hoses are undamaged, are secured on the hose rack, and cannot contact the tractor when turning or drag on the ground.	
Use only an appropriately-sized tractor to pull the rotary cutter. Refer to “6.2 Tractor Requirements”.	
Make sure the driveline is attached to the tractor PTO. Refer to “6.3 Attaching to Tractor”	
Make sure all safety shields and guards are properly installed.	
Check the blade bolts and blade pan nuts. Refer to “9.6 Blade Servicing”	
Inspect wing blade carriers and blades for locked blades prior to lowering the wings. Use a pry bar or other tool to separate locked blades.	
Check the condition of the blades.	
Check the cutting height. Adjust if needed. Refer to “6.4.2 Setting the Cutting Height”	
Inspect the overall rotary cutter for potential problems or damage. Do not use the rotary cutter if it needs repairs of any type.	
Make sure the driveline CV joint, U-joints, and slip joints are greased. Refer to “9.5 Driveline Lubrication”.	
Check oil levels in gearboxes.	

6.8 GENERAL OPERATING PROCEDURE

Although the rotary cutter is easy to use, each operator should review this section to familiarize themselves with the detailed safety and operating procedures.

1. Operate the rotary cutter only in conditions where you have clear visibility in daylight or with adequate artificial lighting. Never operate the rotary cutter in darkness or foggy conditions where you cannot clearly see at least 300 feet in front and to the sides of the tractor and rotary cutter. Make sure that you can clearly see and identify passersby, steep slopes, ditches, drop-offs, overhead obstructions, debris, and foreign objects. If you are unable to clearly see these type of items, discontinue operating the cutter.
2. Clear the area of bystanders, especially small children.
3. Clear the area to be cut of stones, branches, debris, and any hard objects that may be thrown. Never operate the rotary cutter in an area that you have not inspected and removed debris or foreign material. Mark the location of objects that cannot be removed.
4. Do not operate the rotary cutter, or drive the tractor into material that is burning, or areas that recently burnt and may contain hot spots. Burning material, sparks, and coals could be thrown from the rotary cutter to areas of vegetation that might ignite. Tire damage can occur when driving over hot material. Oil and grease on the tractor and rotary cutter could ignite, resulting in equipment destruction. Carry a fire extinguisher on the tractor at all times to extinguish possible fires encountered. Do not operate the rotary cutter on a tractor with an underframe exhaust.
5. Raise the rotary cutter fully and remove the transport lock. Fasten the transport lock around a leveling rod to prevent its loss. Lower the rotary cutter to operating height.
6. Remove the wing uplock pins and replace them in the storage location. Lower the wings.
7. Engage the PTO at low engine RPM, then raise PTO speed to 540 or 1000 RPM, as appropriate.
8. Begin cutting at a slow speed, then increase to a speed that gives a clean cut without lugging the engine. Do not operate above 5 MPH.
9. Never allow blades to contact solid objects like rocks, posts, wire, curbs, guardrails, or the ground while mowing.
10. When you get to the end of a pass, slightly raise the rotary cutter (2-4") before turning. Never raise the rotary cutter entirely while the blades are turning. If the rotary cutter must be raised higher than 12" from ground level, disengage the tractor PTO and wait for all blade rotation to come to a complete stop before proceeding to raise the rotary cutter.
11. When turning, the angle between the tractor and rotary cutter must not exceed 80°. This extreme angle is intended for intermittent use only. Plan your cutting to minimize extreme turning angles. Sharp turns can cause premature failure of the joints and put pressure on the tractor PTO shaft, and could cause extensive mechanical damage to the rotary cutter and tractor.

12. Large, dense, or wet vegetation may need to be cut in two or more passes to achieve a uniform cut. In such conditions, raise the cutting height to 12" or more on the first pass. Then lower the rotary cutter to the desired height and mow the vegetation a second time. If possible, select a cutting direction that is at a 90 degree angle to the first pass to reduce streaking for a more uniform cut.
13. Stay alert and watch for trees, low hanging limbs, power lines, and other overhead obstacles while operating. Use care to avoid hitting these items.
14. Avoid cutting in reverse. Instead, disengage the PTO, wait for the blades to stop, and raise the deck. Back up into the area to be cut. Lower the deck, engage the PTO, and cut forward. Do not back the rotary cutter into solid objects. The joint where the hitch attaches to the deck will pivot upward, allowing the front edge of the deck to contact the driveline. Check to make sure there are no persons behind the rotary cutter, and use extreme care when maneuvering in reverse.
15. Always cross steep ditches and banks at a diagonal. Never cross straight across and never back into a steep ditch or bank. Cutting over ditches and backing up hills can "Bottom Out" the driveline. Bottoming out is when the driveline shaft has shortened to the point it is pressing against the gearbox and tractor PTO shafts. Once a driveline has bottomed out, it cannot be shortened anymore without causing serious damage to the tractor PTO components, cutter gearbox, and driveline.
16. Do not operate a pull-type cutter at an angle exceeding 25 degrees up or down or at any angle that will force the driveline to bind and/or hit the tractor drawbar.
17. Whenever using a rotary cutter in dry grass, be aware that a thrown metal object can create a spark against the blade or metal deck housing. Take extra precautions in this type of dry situation to prevent fires.

6.9 CHAIN SHIELDING

IronCraft installs full chain shielding as standard equipment on all flex-wing rotary cutters.



WARNING PROJECTILE HAZARD



The chain shielding is designed to reduce the risk of thrown objects.

The rotary cutter deck and protective devices cannot prevent all objects from escaping the blade enclosure in every mowing condition. It is possible for objects to ricochet and escape, traveling as much as 300 feet.

Death or serious injury can result from being struck by a thrown object. Do not operate the cutter if the chain shielding is missing or damaged.

1. Full chain shielding must be installed when operating in populated areas or other areas where thrown objects could injure people or damage property.
2. If the chain shielding is missing or damaged, operation must be stopped until it can be repaired or replaced.
3. Inspect chain shielding each day of operation and replace any broken or missing chains, as required.

6.10 RIGHT OF WAY (ROADWAY) MOWING

Use double chain guards for highway, right-of-way, parks, greenbelt mowing, or all other mowing where human dwellings, vehicles, or livestock could be within 300 feet of the cutter.

NO SHIELDING IS 100% EFFECTIVE IN PREVENTING THROWN OBJECTS. TO REDUCE THE POSSIBILITY OF INJURY:

1. Maintain rotary cutter shielding in good operational condition.
2. Inspect the condition of the thrown object guards, cutter side skirts, and skid shoes daily: Replace or repair worn or damaged guards.
3. Inspect the condition of the blades and blade bolts daily. Replace any cracked, worn, bent or damaged blades. Always replace blade bolts and lockwashers when replacing blades. Make sure the blade bolts are properly tightened.
4. Raise cutting height to 6" minimum.
5. Never allow blades to contact solid objects like rocks, posts, wire, curbs, guardrails, or the ground while mowing.

ROTARY CUTTERS CAN THROW OBJECTS 300 FEET OR MORE UNDER ADVERSE CONDITIONS.

1. To avoid serious injury or death from thrown objects, inspect the area thoroughly for potential thrown objects and remove them before cutting.
2. Remove debris, rocks, wire, cable, metal objects, and other foreign material from area.
3. Wire, cable, rope, chains, and metal objects can be thrown or swung outside the deck with great velocity.
4. Mark the location of objects that cannot be removed.

STOP MOWING IF PASSERSBY ARE WITHIN 300 FEET UNLESS:

1. All thrown object shielding including front and rear deflectors, chain guards, steel guards, bands, side skirts, and skid shoes are in place and in good condition when mowing.
2. Mower sections or wings are adjusted to be close and parallel to ground without exposing blades.
3. Mowing area has been inspected and foreign materials and debris have been removed.
4. Passersby are inside an enclosed vehicle.

6.11 DETACHING FROM TRACTOR

1. Disengage the PTO and wait for blade rotation to come to a complete stop. Raise the rotary cutter with the tractor hydraulics, and install the transport lock on the lift cylinder.



NOTICE

Make sure the blades have completely stopped before raising the wings for transport. Gearbox and driveline damage may result if the blades are turning when the wings are raised.

2. Raise the wings with the tractor hydraulics and install the wing lock pins. (4 Places)
3. Park the tractor, place the transmission in park or neutral, and apply the parking brake. Lower the rotary cutter onto blocks placed under the front skid shoes. Shut down the engine, remove the key, and move the cylinder operating levers in both directions to relieve hydraulic pressure. Wait for all motion to come to a complete stop before exiting the tractor.
4. Make sure the rotary cutter is resting securely on the ground or blocks, and chock the wheels before attempting to disconnect it from the tractor. Use extreme care to keep feet and hands from under the rotary cutter and clear of any pinch points caused by the tractor drawbar and rotary cutter hitch.
5. Remove the jack from the cutter deck and secure it to the hitch by fully inserting the locking pin through the jack and the hitch bracket. Use the jack to raise the cutter hitch to the height needed to disconnect the clevis from the drawbar.
6. Disconnect the hydraulic hoses from the tractor. Store the hoses on the cutter deck.



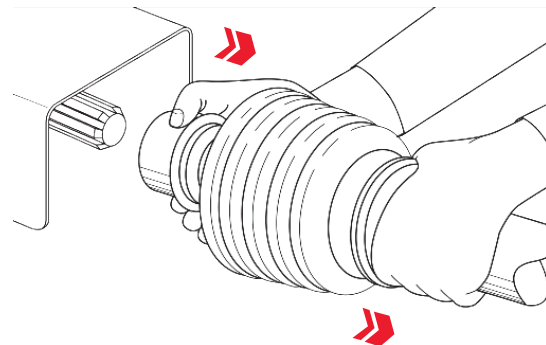
CAUTION

EXPLOSIVE SEPARATION HAZARD



Be sure all hydraulic pressure is relieved before disconnecting hydraulic line or fittings between the Rotary Cutter and the tractor hydraulic system.

7. Disconnect the driveline safety chain and hitch safety chain.
8. Pull back on the collar on the tractor end of the driveline. See image right.
9. Slide the driveline off the tractor PTO shaft and secure it up off the ground.
10. Remove the hitch pin and drive the tractor away from the rotary cutter.



TRANSPORTING

7.1 TRANSPORTING SAFETY (ROAD)



WARNING

Failure to understand and follow these safety instructions can and will result in serious injury and possibly even death.



TRACTOR OWNER/ OPERATOR MANUAL

Always refer to the tractor owner's manual to determine its compatibility and maximum safety.



OPERATING THE TRACTOR

Before attaching the rotary cutter to the tractor, be familiar with its controls and how to stop it quickly in the event of an emergency. Read and understand this manual and the one provided with your tractor before transporting the rotary cutter.



FALL AND CRUSH HAZARD

Do not allow riders on the rotary cutter or tractor.



MAXIMUM TRANSPORTING SPEED

Do not exceed 15 MPH when transporting the rotary cutter. Slow down for corners and rough terrain.



VISIBILITY

Clean reflectors, SMV or SIS sign, and lights before towing. Make sure all the lights and reflectors required by highway and transport authorities are in place and can be seen clearly by all overtaking and oncoming traffic.



REGULATIONS

Make sure all local, state, and federal regulations, regarding the transport of equipment on public roads and highways, are met. Check with the local authorities regarding transporting the rotary cutter on public roads. Obey all applicable laws and regulations.



ROLLOVER PROTECTION

The tractor should be equipped with a Roll Over Protective Structure (ROPS) and a seat belt.



The unit is top heavy when the wings are folded. Use caution when transporting over uneven surfaces and slow down for turns.



THROWN OBJECT HAZARD

Before transporting, make sure the PTO is disengaged and all blade movement has stopped.



SAFETY INSTRUCTIONS

The following safety instructions are provided to help prevent injury or limit equipment damage.



DRIVE SAFELY

Be a safe and courteous driver. Anticipate what other drivers will do and drive accordingly.



ALLOW EXTRA DISTANCE

Apply brakes early. Leave extra distance between your vehicle and the one(s) ahead to provide adequate stopping space. Extra distance will be required to stop the vehicle.



CLEAR VISION

Remove all objects from the area that would prevent clear vision of the complete work area or would present an obstacle when moving the rotary cutter.



HITCH ATTACHMENT

Be sure the rotary cutter is securely attached to the tractor and in good operating condition before using.



WORKING TAILLIGHTS

Make sure lights on the tractor are working properly.



ADDITIONAL LIGHTING

For rotary cutters without lights, install additional lights on the rear of the tractor to safeguard against rear-end collisions. Daybreak and dusk are particularly dangerous and rear pilot vehicles are recommended. Rotary cutters without lights should be transported on public roads only during daylight hours.



HAZARD FLASHERS

Use hazard flashers on the tractor when transporting unless prohibited by law.



RIGHT-OF-WAY

When travelling below the posted speed limit, keep to the right and yield the right-of-way to allow faster traffic to pass.



NOTICE

Laminated sectional tires are designed for conditions where puncture-proof performance is required and the rotary cutter will not be transported for long distances on roadways. Transport speed for laminated tires should not exceed 15 MPH. Excessive speed can cause damage to the machine and tire sections.

7.2 TRANSPORTING

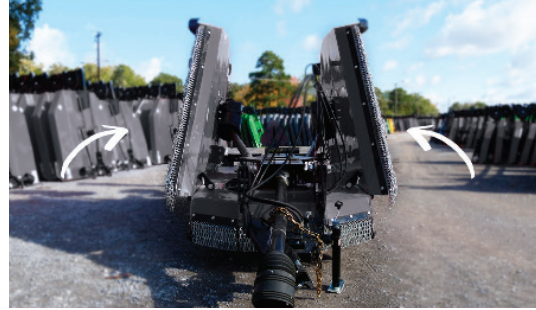
1. Make sure the safety chain from the rotary cutter is attached to the tractor drawbar cage. The safety chain should be long enough for tight turns. Don't allow the chain to drag on the pavement because it will wear the chain links, causing an unsafe condition.
2. Prior to towing, make sure the brakes, brake lights, running lights, turn signals, and hazard lights on the tractor are operating correctly.
3. Raise the rotary cutter with the tractor hydraulics. Lower the transport lock onto the cylinder and insert the pin to lock the transport lock in place.



4. Make sure the jack stand is secured in the storage location.



5. Fold the wings onto the wing rests.



6. Install the wing fold uplock pins and retaining pins. (4 Places)



WARNING

PINCH POINT HAZARD



Do not place hands or fingers between moving and/or stationary parts. The weight of the unit will easily cause serious bodily injury.



CRUSH HAZARD

When folding the wings, make sure to install both wing uplock pins.



7. Transport to the work site following all applicable regulations and all the safety instructions in this manual.



WARNING

CRUSH HAZARD



The rotary cutter is top heavy when the wings are raised. To avoid injury or death from rollover, use caution when transporting over uneven surfaces and slow down for turns.

STORAGE

8.1 STORAGE SAFETY

At the end of the season, the rotary cutter should be thoroughly inspected and prepared for storage. Repair or replace any worn or damaged components to prevent any unnecessary downtime at the beginning of the next season.



WARNING

ROLLOVER HAZARD



The rotary cutter is top heavy when the wings are raised. To avoid injury or death from rollover, store the cutter on a firm, level surface.



CAUTION

PERSONAL INJURY HAZARD



Store the rotary cutter in an area away from human activity. To prevent the possibility of serious injury, do not permit children to play on or around the stored rotary cutter.



NOTICE

To prevent damage to the rotary cutter, store it in a dry, level area.

8.2 PLACING IN STORAGE

1. Remove all entangled vegetation.
2. Thoroughly wash the rotary cutter with a pressure washer or water hose to remove all clippings, dirt, mud, or debris.
3. Raise the rotary cutter with the tractor hydraulics, and install the transport lock on the lift cylinder.
4. Raise the wings with the tractor hydraulics and install the wing uplock pins and their retaining pins.
5. Select an area that is dry, level, and free of debris (inside a building is ideal). Move the rotary cutter to its storage area. Disconnect the rotary cutter from the tractor following the procedure in “6.11 Detaching From Tractor”.
6. Lubricate all grease points. Make sure all grease cavities have been filled with grease to remove any water residue from washing.
7. Touch up all paint nicks and scratches to prevent rusting.



NOTICE

Wing cutting blades may become locked together (overlapped) when the wings are raised for transport or storage. Operating the cutter in this condition will result in severe deck vibration. Inspect the wings for locked blades prior to lowering the wings. Use a pry bar or other tool to free any locked blades.

8.3 REMOVING FROM STORAGE

1. Attach the rotary cutter to the tractor following the procedure in “6.3 Attaching to Tractor”.
2. Before placing the rotary cutter back into service, replace any worn or defective parts and perform the Pre-Operation Checklist.

SERVICE AND MAINTENANCE

9.1 MAINTENANCE SAFETY



WARNING

Failure to comply with the following safety instructions can and will result in serious injury and possibly even death.



PERSONAL PROTECTION EQUIPMENT



Wear close fitting and belted clothing to avoid getting caught in moving parts. Wear personal protection equipment (PPE), which may include hard hat, safety glasses, safety shoes, gloves, etc. , appropriate for the work site and working conditions.



DISCONNECT DRIVELINE

To prevent injury due to possible unexpected movement, disconnect the driveline from the tractor PTO before performing any maintenance procedure.



DAMAGED PARTS HAZARD

Do not use the rotary cutter if any parts are damaged. If the rotary cutter is believed to have a defect which could cause it to work improperly, immediately stop using it and remedy the problem before continuing.



SAFETY SHIELDS AND DEVICES

When completing a maintenance or service function, make sure all safety shields and devices are installed before placing the rotary cutter in service.



NO UNAUTHORIZED MODIFICATIONS



Do not modify the rotary cutter or safety devices. Do not weld on the unit. Unauthorized modifications may impair its function and safety and will void the warranty.

If the rotary cutter has been altered in any way from the original design, the manufacturer does not accept any liability for injury or warranty.



CRUSH HAZARD

The wings may drop unexpectedly if the uplock pins are not installed. To avoid serious injury or death from crushing, always make sure the uplock pins and their retaining pins are properly installed whenever the wings are raised.



The rotary cutter is top heavy when the wings are raised. To avoid injury or death from rollover, make sure the cutter is on a firm, level surface.



WARNING

Failure to comply with the following safety instructions can and will result in serious injury and possibly even death.



TRAPPED AIR HAZARD

When installing, replacing, or repairing hydraulic system cylinders or parts, make sure that the entire system is charged and free of air before resuming operations. Failure to bleed the system of all air can result in improper machine operation, causing severe injury.



ZERO PRESSURE

Relieve pressure from the hydraulic system before servicing or disconnecting from the tractor.



EXPLOSIVE SEPARATION HAZARD

Replace any worn, cut, abraded, flattened, or crimped hoses.



HIGH-PRESSURE HAZARD

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.



HIGH-PRESSURE FLUID HAZARD



Keep all hydraulic lines, fittings, and couplers tightly secured and free of leaks.

DO NOT use your bare hand to check for potential leaks. Always use a board or cardboard when checking for a leak.

Escaping hydraulic fluid under pressure, even a pinhole size leak, can penetrate body tissue, causing serious injury and possible death. If fluid is injected into your skin, it must be treated immediately by a doctor familiar with this type of injury.



SAFETY INSTRUCTIONS

The following safety instructions are provided to help prevent injury or limit equipment damage.



SAFETY EQUIPMENT

A fire extinguisher and first aid kit should be readily accessible while performing maintenance on this equipment.



CLEAN WORK AREA

Do not leave tools lying around the work area. Follow good shop practices. Keep service area clean and dry. Be sure electrical outlets and tools are properly grounded. Use adequate light.



USE THE RIGHT TOOLS

Use the correct tools, jacks, hoists, or other tools that have the capacity for the job.



PROPER SUPPORT

Use certified safety stands rated to support the load when working beneath the rotary cutter, or performing repairs, service, or maintenance.



The rotary cutter weighs 5200 lbs. Before working underneath, place it on a minimum of four jack stands, with a load rating of at least 3000 lbs. each.

Do not position the jack stands under wheels, axles, or wheel supports, as they may rotate and cause the rotary cutter to fall.

Make sure the jack stands are stable and the rotary cutter deck is approximately level. Test the stability of the rotary cutter before working underneath.

If the rotary cutter is attached to the tractor, set the brakes, remove the key, chock the tractor wheels, and block the rotary cutter before working underneath.

9.2 WELDING REPAIRS



NOTICE

Before performing any type of welding repair to the rotary cutter, contact IronCraft for approval. Repair welding must be done with care and with procedures that may be beyond the capabilities of the ordinary welder.



WARNING



PROJECTILE HAZARD

Do not attempt to weld on the blades. They are hardened and will crack or otherwise be damaged, causing failure and possible serious injury or death from thrown blades.



WARNING

PERSONAL INJURY HAZARD

Repairs or modifications to the rotary cutter can result in serious injury or death should these repairs fail.



NOTICE

Anyone performing a welding repair should be certified in accordance to the American Welding Society (AWS) standards.

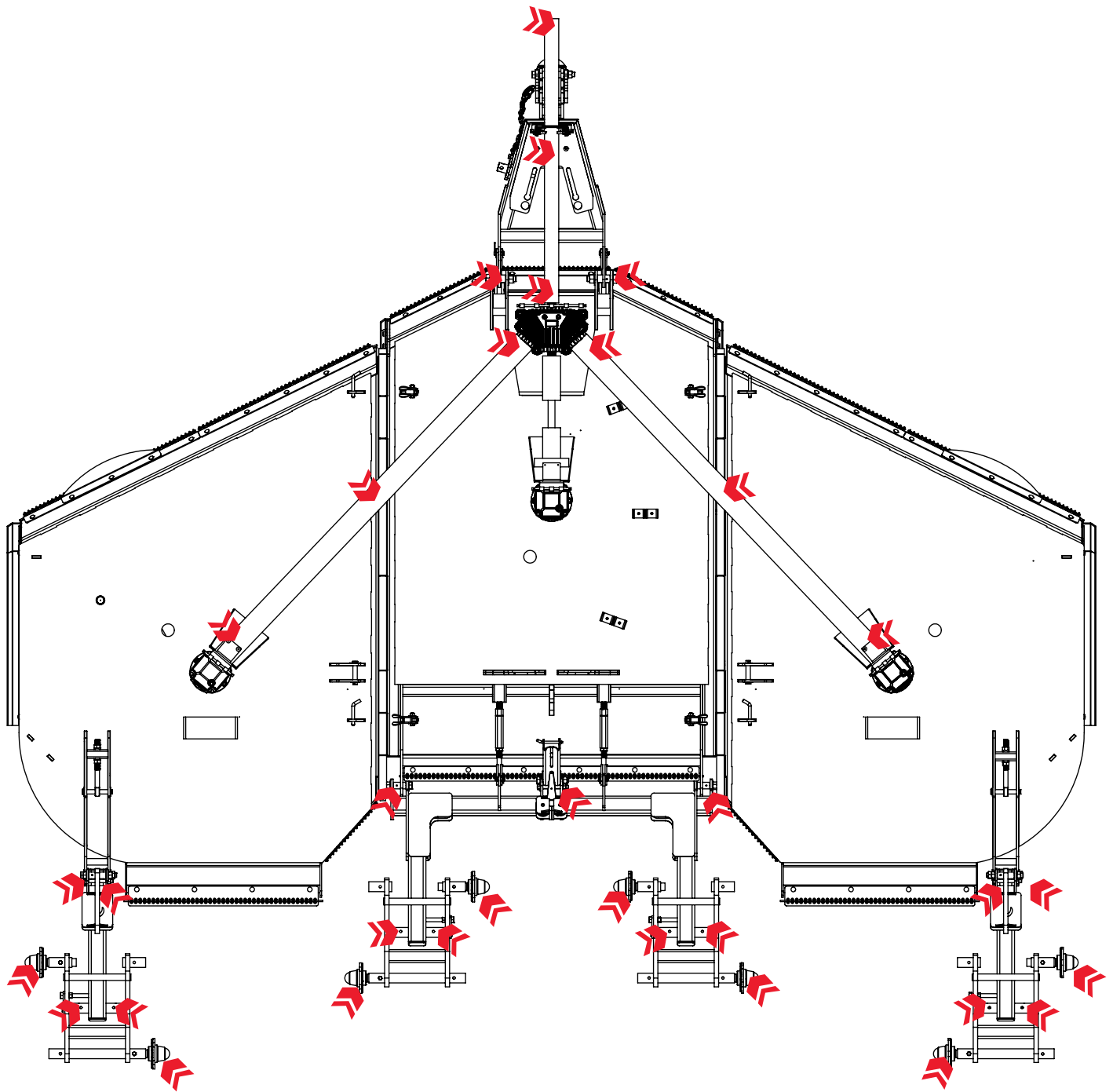
9.3 GREASING

See the diagram for the location of all grease zerks.

LOCATION	QTY.
Receiver Swivel	2
PTO Shaft	2
Hitch Pivot	2
Splitter Cross Shaft	2
Wing Drivelines (each)	3
Wing Tailwheel Pivot – under side (each)	1
Wing Tailwheel Suspension Pivot (each)	2
Center Tailwheel Pivot	3
Center Tailwheel Suspension Pivot	1
Tailwheel Hubs	8
Walking Tandem Pivot (w/optional walking tandem)	8

Use an SAE multipurpose high-temperature grease with extreme pressure (EP) performance. Also acceptable is an SAE multipurpose lithium base grease.

1. Always use a handheld grease gun for all greasing.
2. Wipe grease zerks with a clean cloth before greasing to avoid injecting dirt and grit.
3. Apply grease until new grease can be seen coming out of the joint.
4. Do not let excess grease collect on or around parts, particularly when operating in sandy areas.
5. Replace broken grease zerks immediately.
6. If any grease zerk will not take grease, remove and clean it thoroughly. Also clean the lubricant passageway. Replace the zerk if necessary.



9.4 GEARBOX LUBRICATION

The gearboxes are filled at the factory. Lubrication levels need to be checked by both the dealer and by the customer. If there is evidence of leakage, the grease level should be checked. If required, grease should be added until it comes to the proper level. **Recommended lubricant is SAE 140 Gearoil.**

SPLITTER GEARBOX CAPACITY	OUTBOARD GEARBOX CAPACITY
58 ounces	49 ounces



NOTICE

Make sure the rotary cutter is level when checking the grease in the gearbox.



NOTICE

Overfilling the gearbox will cause pressure to build up and cause the seals to leak.

9.5 DRIVELINE LUBRICATION

Lubricate all driveline slip joints, U-joint crosses, and the center driveline CV joint before initial use and every eight operating hours thereafter.

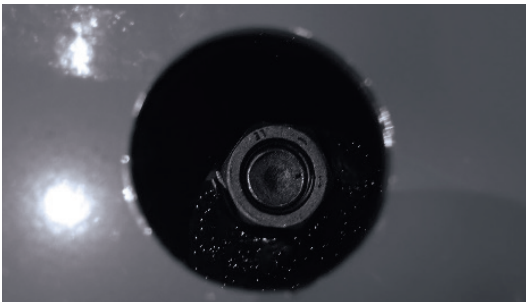
1. Lower the rotary cutter to the ground, disconnect the center driveline from the tractor PTO shaft, and slide the halves apart but do not disconnect from each other.
2. Apply a bead of grease completely around male half where it meets female half. Slide drive halves over each other several times to distribute grease.
3. Disconnect the wing drivelines from the splitter gearbox and repeat Step 2 for each wing driveline.
4. Rotate the front driveline safety shield until the holes in the shield match up with the grease zerks in the CV joint and U-joint.
5. Apply grease to all accessible grease zerks.
6. Rotate the driveline shield 180° until the holes on the opposite side align with the remaining grease zerks, and apply grease.
7. Repeat for the U-joint at the rear of the center driveline, and at both ends of the wing drivelines.
8. Grease the zerks on the splitter cross shaft.
9. Re-connect the drivelines, close the front gearbox shield, and install the retaining pins.

9.6 BLADE SERVICING

Inspect blades before each use to determine that they are properly installed and in good condition. If any blade is bent, excessively nicked, worn, or has any other damage, replace both blades on the spindle. Small nicks can be ground out when sharpening. Manually rock the blade carriers to check for any looseness. Recheck torque every fifty hours. Retighten any loose parts.

9.6.1 BLADE REMOVAL

To remove the blades for sharpening or replacement, remove the nut and lockwasher from the blade bolt through the inspection hole in the deck of the mower near the gearbox.



9.6.2 BLADE INSTALLATION

When installing blades, be sure to check the blade bolt pivot diameter for wear. Replace the bolt if worn more than 1/4 inch at any point. Tighten nut to 600 ft. lbs.

Always use a new lockwasher and nut when replacing the blade bolt.

Make sure blades are installed with the cutting edge in the direction of rotation. The left and center spindles rotate counterclockwise as viewed from above the deck. The right spindle rotates clockwise as viewed from above the deck.

9.6.3 BLADE SHARPENING



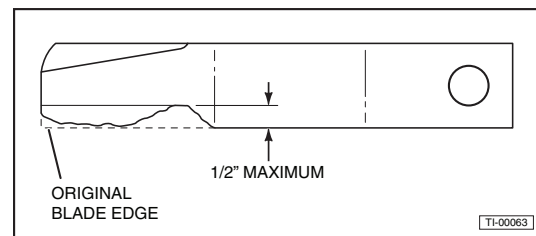
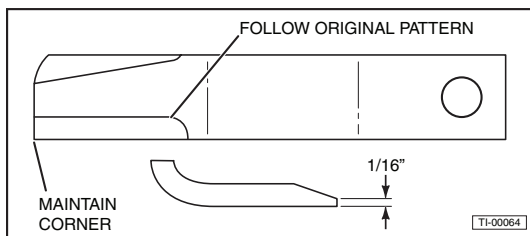
CAUTION SHARP OBJECT HAZARD



The grinder may catch on the blade during sharpening, propelling it forcefully. To prevent the possibility of serious injury, make sure blades are secured against movement while sharpening.

When sharpening blades, always sharpen both blades at the same time and grind the same amount on each blade to maintain balance. Unbalanced blades will cause excessive vibration, which can damage gearbox bearings. Vibration may also

cause structural cracks to the rotary cutter. Follow the original sharpening pattern. Do not sharpen blades to a razor edge, leave a 1/16" blunt edge. Do not sharpen the back side of the blade. Do not heat and pound out the edge.



Replace the blades when worn more than 1/2" from the original edge. Always replace blades in pairs.

9.7 BLADE CARRIER REMOVAL

1. Remove the cotter pin and loosen the castle nut on the gearbox shaft. Do not remove the nut until the blade carrier is loosened.
2. Use a suitable two jaw gear puller to pull the carrier off the tapered gearbox shaft.
3. If a gear puller is not available, insert a bar through the blade bolt access the hole with the end against the blade carrier. Strike the opposite end of the bar sharply. Rotate the blade carrier 180 degrees and repeat until the carrier breaks loose.
4. Remove the castle nut and the blade carrier.

9.8 BLADE CARRIER INSTALLATION

1. Clean the splines on both the blade carrier and the output shaft.
2. Position the carrier on the gearbox output shaft and install the castle nut. Tighten the nut to a minimum 450 ft. lbs.
3. Strike the carrier near the hub several times with a heavy hammer to seat the hub. Use care not to strike the nut or the end of the shaft.
4. Retighten the nut to 700 ft. lbs.
5. Install the cotter pin and spread the tangs.

9.9 SLIP CLUTCH OPERATIONAL CHECK

The rotary cutter is equipped with three slip clutches, with one located in front of each spindle gearbox. The slip clutches serve as overall protection for the tractor, driveline, and gearboxes. Even though new clutch assemblies are “run-in” and checked for torque prior to shipment, readjustment may be advisable if the clutch has been exposed to weather for an extended period of time. The clutch facing and plates should be inspected for rust and/or corrosion. After the rotary cutter has been stored for thirty days or more, perform the following check:

1. Make a trial run in the heaviest operating conditions expected. If any clutch slips noticeably, tighten the eight adjusting bolts no more than 1/2 turn between trial runs until the clutch slippage is reduced.
2. Scribe a mark across the clutch facing of each slip clutch. When subjected to shock loads, a separation of the marks will assure that the clutch setting is correct.



NOTICE

Check the clutches periodically during the first hour of operation for excessive heat build-up due to unexpected slippage.

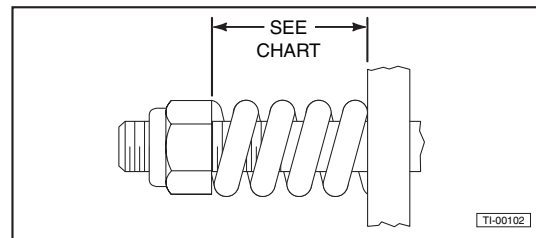
If a clutch is being rebuilt (new facing and/or plates), it is necessary to “run-in” these parts prior to final adjustment. The plates should be thoroughly cleaned and free of foreign material, as well as being checked for warping with a straight edge. Warped plates cannot be adjusted properly and will not hold. To accomplish the “run-in” after assembly, follow this procedure:

1. Tighten all the adjusting bolts evenly until the clutch cannot be slipped by hand.
2. With the blade carrier locked in a stationary position, operate with the PTO at idling speed (approximately 100 RPM), until evidence of heating is noted. Do not allow the clutch to overheat.
3. Discontinue operation and allow the clutch to cool completely.
4. After the clutch has cooled, tighten all the adjusting bolts evenly and proceed with the regular clutch adjusting procedures, as described above.

9.10 SLIP CLUTCH ADJUSTMENT

The slip clutches are factory preset to the correct torque for protecting the implement and tractor. Periodic adjustment is recommended. Should adjustment be needed, follow this procedure:

1. Check to be sure all spring lengths are the same. Initial spring length is shown in the chart.
2. If necessary, adjust the nut on any spring that is unequal. Adjust all eight spring retaining nuts 1/3 of a turn (two flats on a nut) and check clutch slippage.
3. If further adjustment is necessary, adjust in 1/3 turn increments. Adjust only to provide sufficient torque to prevent slippage under normal conditions. Occasional slippage is normal for drive train protection. If satisfactory results cannot be obtained, consult your authorized dealer.



CLUTCH SPRING LENGTH CHART	
EG/COMER	BONDIOLI & PAVESI
1.27" (32.2mm)	1.15" (29.3mm)
1.28" (32.4mm)	1.12" (28.5mm)



NOTICE

Do not overtighten and cause the spring to become solid, as this will cause shaft failure.

9.11 BOLT TORQUE REQUIREMENTS

It is extremely important to apply and maintain proper torque on all bolts. Use a torque wrench to assure the proper amount of torque is being applied to the fastener.

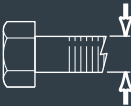
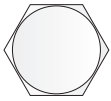


Start all bolts or nuts by hand to prevent cross threading.

Torque figures indicated in the chart are used for non-greased or non-oiled threads unless otherwise specified. Therefore, do not grease

or oil bolts or cap screws unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

The chart gives correct torque values for various bolts and cap screws. Tighten all bolts to the torque specified in the chart unless otherwise noted. Check tightness of bolts periodically, using the bolt torque chart as a guide. Always replace hardware with the same Grade bolt.

STANDARD TORQUE VALUES

 BOLT DIAMETER	ENGLISH BOLT TORQUE SPECIFICATIONS*					
	GRADE 2		GRADE 5		GRADE 8	
		NO MARKING		3 RADIAL LINES		6 RADIAL LINES
						
	FT LBS.	N-m	FT LBS.	N-m	FT LBS.	N-m
1/4"	6	8	9	12	12	17
5/16"	10	13	19	25	27	36
3/8"	20	27	33	45	45	63
7/16"	30	41	53	72	75	100
1/2"	45	61	80	110	115	155
9/16"	60	95	115	155	165	220
5/8"	95	128	158	215	220	305
3/4"	165	225	290	390	398	540
7/8"	170	230	420	570	650	880
1"	225	345	630	850	970	1320



WARNING EQUIPMENT FAILURE



The torque value for bolts and capscrews are identified by their head markings. Replacing higher "Grade" bolts (Grade 5) with lower Grade bolts will lead to equipment failure and can result in injury or death. Always use replacement bolts with the same Grade markings as the removed bolt.

9.12 SERVICE RECORD

The period recommended is based on normal operating conditions. Severe or unusual conditions may require more frequent lubrication or oil changes. **Copy this page to continue record.**

MAINTENANCE TASK	HOURS AND SERVICED BY									
	EVERY USE									
Grease tailwheel zerks before every use.										
EVERY 8 HOURS										
Make sure blade bolts are tightened to proper torque. Refer to "9.6.2 Blade Installation"										
Make sure all retainer clips and cotter pins are in place.										
Inspect the cutting blades for wear and damage. Refer to "9.6.3 Blade Sharpening"										
Grease the driveline CV joint, U-joints and slip joints. Refer to "9.5 Driveline Lubrication"										
EVERY 50 HOURS										
Check blade carrier nut torque. Refer to "9.6.2 Blade Installation"										
Grease all lubrication points. Refer to "9.3 Greasing"										
ANNUALLY										
Grease all lubrication points. Refer to "9.3 Greasing"										
Make sure all fasteners are properly tightened.										
Check cutter deck, gearboxes, and driveline for damage.										
Inspect the cutting blades for wear and damage. Refer to "9.6.3 Blade Sharpening"										
Make sure the hitch pivot bolts and hitch pin are in good condition. Do not use homemade or shop made pins.										
Make sure the slip clutch is functioning properly. Refer to "9.9 Slip Clutch Operational Check"										
Inspect the hitch and clevis for wear and damage.										
Wash the rotary cutter.										

TROUBLESHOOTING

10.1 TROUBLESHOOTING CHART

PROBLEM	CAUSE	RESOLUTION
Uneven cut.	Excessive ground speed.	Reduce ground speed.
	Blades worn, dull, or bent.	Replace blades.
	Improper height adjustment.	Adjust rotary cutter height. Refer to “6.4.2 Setting the Cutting Height”
	Low tractor tire pressure on one side.	Adjust tire pressure. (Refer to OEM manual).
	Turning too fast.	Reduce ground speed when turning.
	Tractor tires pushing grass down.	Adjust your tractor wheel spacing. (Refer to OEM manual).
	Damaged cutter pan.	Repair or replace as necessary.
Uncut material.	Excessive ground speed.	Reduce ground speed.
	RPM too low.	Maintain rated PTO RPM.
Windrowing.	Material heavy and lush.	Raise the front of rotary cutter relative to the rear. Refer to “6.4 Setting the Rotary Cutter”
	Excessive ground speed.	Reduce ground speed.
	Conditions too wet.	Wait for conditions to dry. Reduce ground speed.
Grass cut lower in center of swath than at edge.	Height of rotary cutter lower at rear or front.	Adjust rotary cutter height and attitude so that rear and front are within 1/2” of same height.
Streaking conditions in swath.	Blades dull.	Sharpen or replace blades.
	Blades unable to cut that part of grass pressed by path of tractor tires.	Slow ground speed of tractor but maintain rated PTO RPM. Cutting lower will help.
	Conditions too wet for mowing.	Allow grass to dry before mowing.

PROBLEM	CAUSE	RESOLUTION
Material discharges from cutter unevenly; bunches of material along swath.	Material too high and too much material.	Reduce ground speed but maintain rated tractor PTO RPM or make two passes over material.
		Raise rotary cutter for the first pass and lower to desired height for the second and cut at 90° to first pass.
		Raise rear of rotary cutter high enough to permit material to discharge but not so high as to cause conditions listed above.
	Grass wet.	Allow grass to dry before mowing. Reduce ground speed but maintain rated tractor PTO RPM. Cutting lower will help.
	Rear of rotary cutter too low, trapping material under cutter.	Adjust rotary cutter height and attitude.
Rotary cutter will not cut all the time. (Slip clutch drive only)	Slip clutch slipping.	Adjust slip clutch. Refer to “9.10 Slip Clutch Adjustment”
	Burnt or damaged clutch facing.	Rework clutch or replace according to OEM manual.
Blade bolts working loose.	Bolts not tightened.	Tighten bolts. Refer to “9.6 Blade Servicing”
	Bolt hole elongated or oversized.	Replace blade carrier Refer to “9.7 Blade Carrier Removal”
	Lockwasher broken.	Replace lockwasher. Refer to “9.6 Blade Servicing”
Gearbox noisy.	Low lubricant level.	Add grease. Refer to “9.4 Gearbox Lubrication”
	Worn bearing.	Replace bearing.
Gearbox leaking.	Damaged oil seal.	Replace seal.
	Bent shaft.	Replace gearbox.
	Oil seal not sealing in the housing.	Replace seal or use a sealant on O.D. of seal.
	Oil level too high.	Drain to proper level.
	Gasket damaged.	Replace gasket.
	Bolts loose.	Tighten bolts.
Gearbox overheating.	Low on lubricant.	Fill to level plug.
	Improper type of lubricant.	Replace with proper lubricant. Refer to “9.4 Gearbox Lubrication”
	Excessive trash build-up around gearbox.	Remove trash.

PROBLEM	CAUSE	RESOLUTION
Excessive vibration.	Blades are not free to swing.	Check bushing and blade movement.
	Blades are out of balance.	Check blades for damage or replace blades. Refer to "9.6 Blade Servicing"
Unusual noise.	Loose blade bolts or worn bushings.	Tighten bolts, check bushings for wear and change as needed. Refer to "9.6 Blade Servicing"
	Bent blade carrier, blades.	Replace blade carrier or blades. Refer to "9.7 Blade Carrier Removal"
	Deck bent, causing blades to contact deck.	Straighten deck.
Driveline will not telescope.	Improper lubrication.	Grease driveline. Refer to "9.5 Driveline Lubrication"
	Driveline twisted.	Replace driveline. Caution operator not to strike ground with blades.
	Driveline bent.	Driveline too long. Replace and shorten to proper length. Refer to "5.5 Shortening the Driveline"
	Shields damaged.	Replace shields.
Driveline twisted.	Over torqued.	Do not allow blades to contact ground.
		Replace driveline.
	Not maintaining correct PTO speed.	Maintain rated PTO RPM.

WARRANTY

For up to date warranty information visit our website www.ironcraftusa.com/warranty



LIMITED WARRANTY

Ironcraft products are warranted to be free from defects in workmanship or materials for a period of 12 months from the initial sale, lease or rental date.

WARRANTY EXCLUSIONS

This warranty does not cover normal wear items, including but not limited to: bearings, hoses, ground engaging parts such as teeth, blades, cutting edges, pilot bits, auger teeth and broom bristles. This warranty does not cover maintenance, service or adjustments. This warranty does not cover damage due to misuse, negligence, accidents, improper maintenance or modifications of this product. This warranty is void if any components have been disassembled, i.e., pumps, gear boxes or motors. Specially modified attachments built by IronCraft X-treme Attachments to meet your customers' needs shall not be warranted by Construction Implement Depot, Inc. This warranty does not cover replacement parts not supplied by IronCraft, Inc.

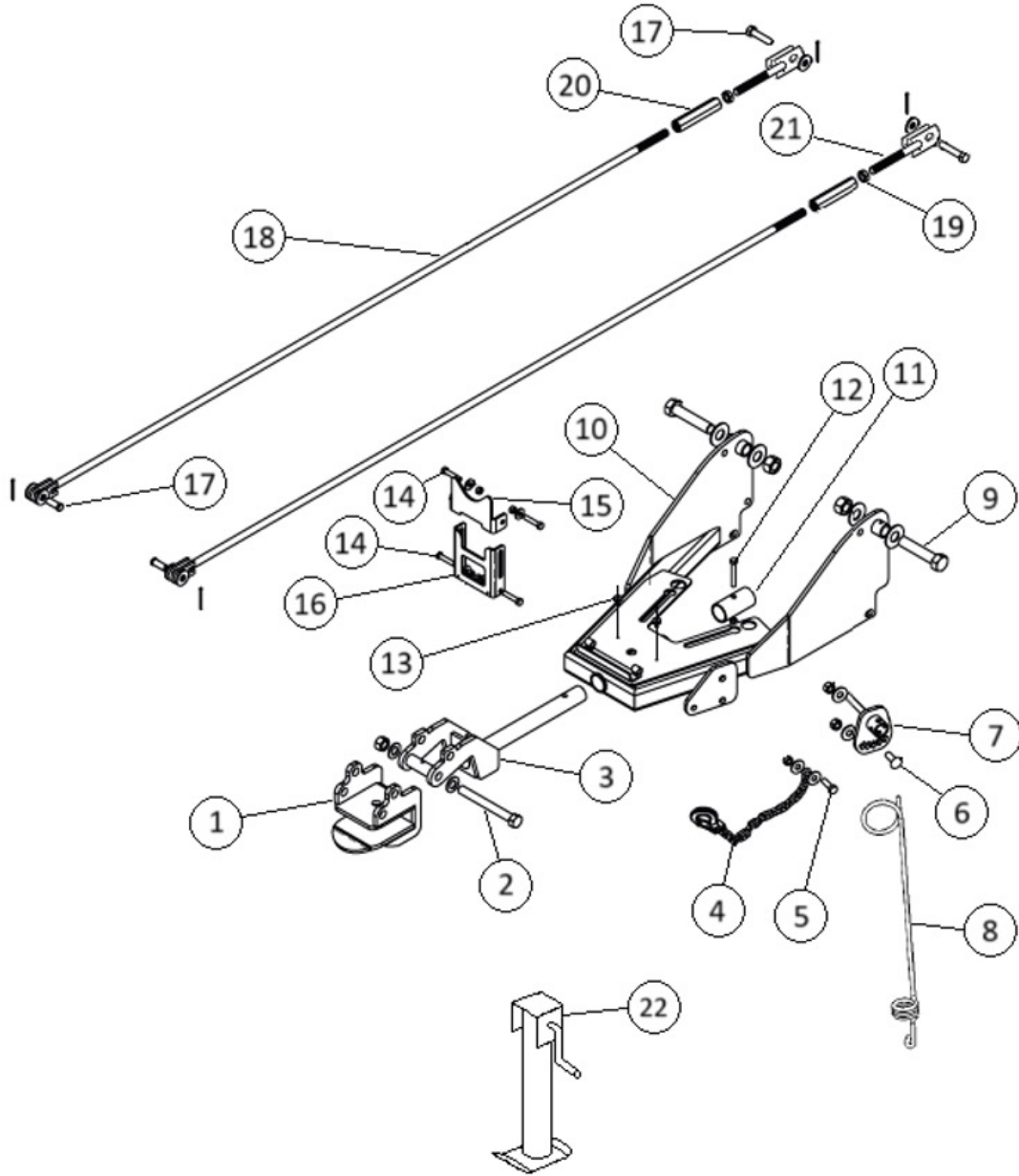
WARRANTY STATEMENT

Our obligation under this Limited Warranty shall be solely limited to repairing or replacing any part (see non-covered items above) free of charge that, according to our judgment, show evidence of a defect in quality of workmanship or materials for the stated 12 month warranty period. All defective parts must be routed directly to IronCraft with freight or delivery charges to be prepaid. This limited warranty shall not be interpreted to render IronCraft liable for any injury or damage to persons, businesses or property of any kind nor expenses or losses incurred for labor, supplies, substitute machinery rental or for any other reason. Repair or replacement parts are subject to the supply conditions at the time of repair or replacements, which may directly affect our ability to obtain material and/or replacement parts. IronCraft reserves the right to make improvements in design or changes in specifications at any time without incurring any obligations to owners of previously purchased products. No one but IronCraft is allowed to alter, modify or enlarge this warranty nor the exclusions, limitations and reservation at any time.

PARTS

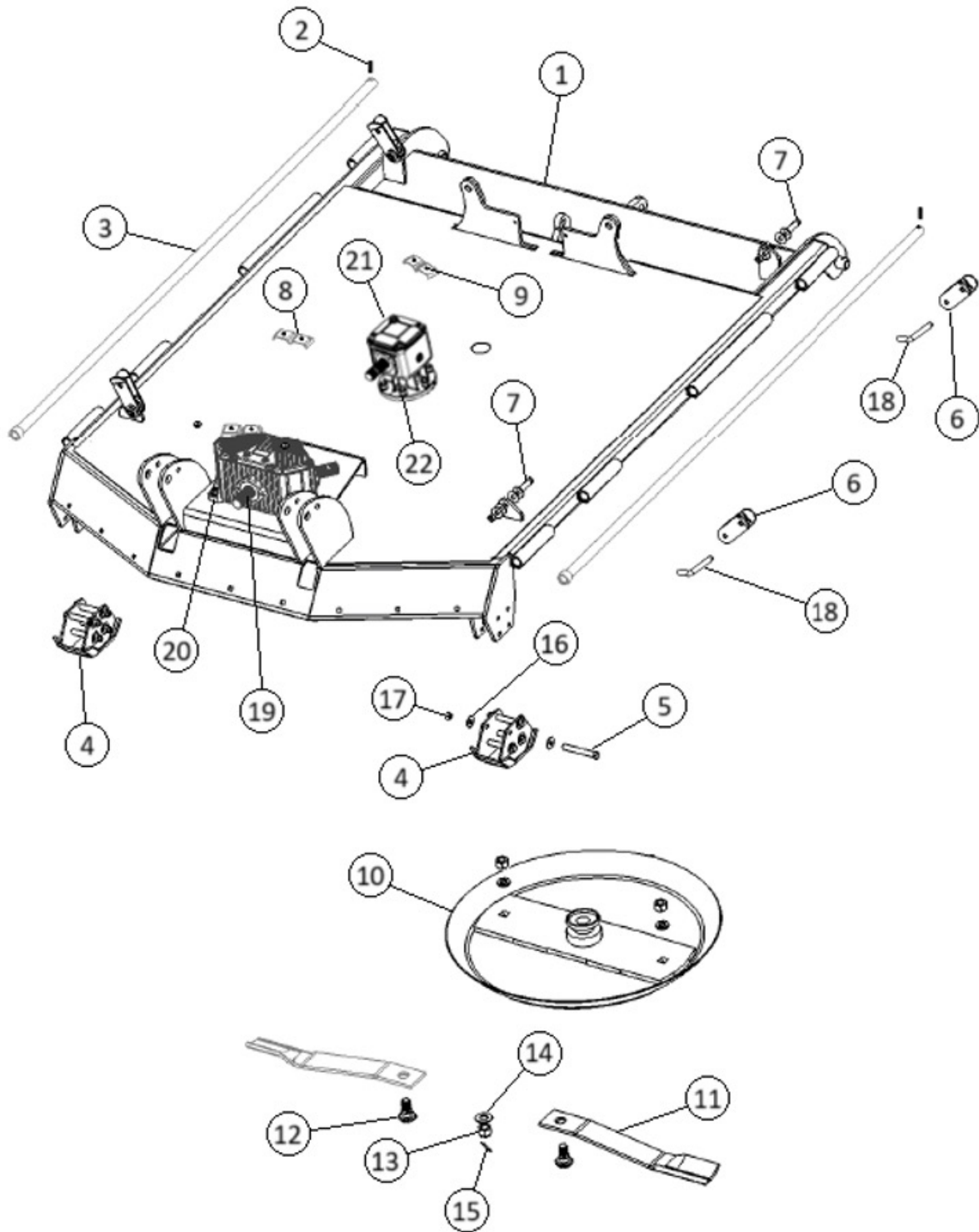
Replacement parts are available from your authorized Dealer Parts Department or from IronCraft.
The following pages contain a list of serviceable parts for the IronCraft 3520 flex-wing rotary cutter.

12.1 HITCH/LEVELING ROD COMPONENTS



HITCH/LEVELING ROD COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	300009-BK	CLEVIS HITCH	1
2	80010577	1"-8 x 9" HEX BOLT Gr. 5	1
	81000017	1" SAE FLATWASHER	2
	82010009	1" NYLOCK NUT Gr. 5	1
3	300008-BK	SWIVEL HITCH	1
4	83000100	SAFETY TOW CHAIN	1
5	80010346	5/8" x 2 HEX BOLT Gr. 5	1
	81010006	5/8" FLATWASHER	1
	82010006	5/8" NYLOCK NUT Gr. 5	1
6	80040302	3/4" x 2" CARRIAGE BOLT Gr. 5	1
	81010007	3/4" FLATWASHER	1
	82010007	3/4" NYLOCK NUT Gr. 5	1
7	300027-BK	JACK LUG	1
8	191209	SPRING HOSE HOLDER	1
9	80010684	1-1/4"-7 x 6" HEX BOLT Gr. 5	2
	81010011	1-1/4" FLATWASHER	4
	82010011	1-1/4" NYLOCK NUT Gr. 5	2
10	350048-BK	A-FRAME WELDMENT	1
11	3050011-BK	SWIVEL HITCH COLLAR	1
12	80010259	1/2" x 3-1/2" HEX BOLT Gr. 5	1
	81010004	1/2" FLATWASHER	1
	82010004	1/2" NYLOCK NUT Gr. 5	1
13	83070000	MAGNET KIT	2
14	80010251	1/2" x 2-1/2" HEX BOLT Gr. 5	4
	81010004	1/2" FLATWASHER	4
	82010004	1/2" NYLOCK NUT Gr. 5	4
15	3010110-BK	PTO HOLDER	1
16	3010076-BK	PTO HOLDER – ADJUSTMENT BRACKET	1
17	351509	CLEVIS PIN W/WASHERS & COTTER PIN	4
18	350045	LONG LEVELING ROD	2
19	82080009	1" JAM NUT	2
20	3580021	LEVELING ROD ADJUSTER	2
21	350046-BK	SHORT LEVELING ROD	2
22	3580008	TONGUE JACK (7000-lbs)	1

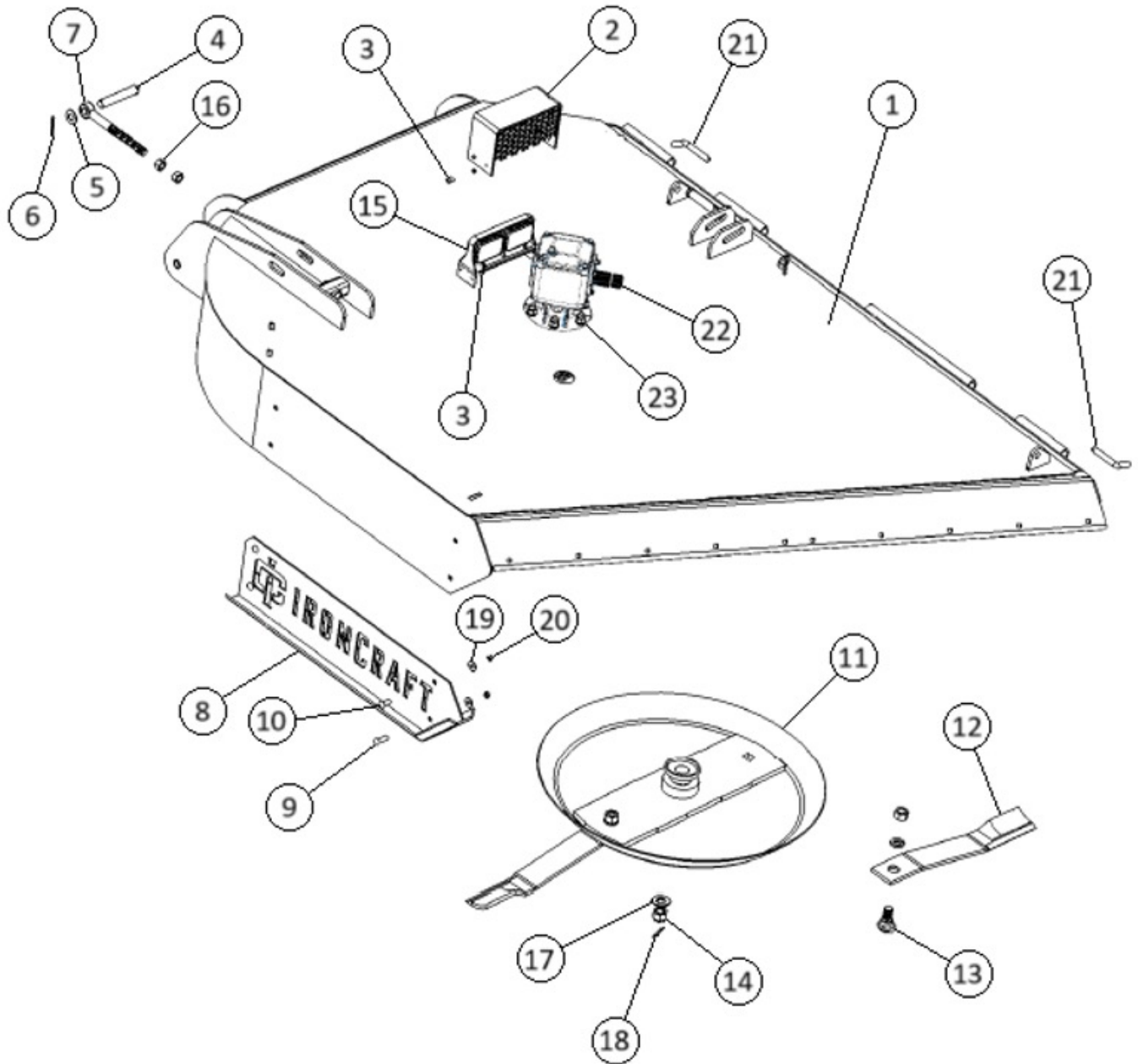
12.2 CENTER DECK COMPONENTS



CENTER DECK COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	350000-GR	CENTER DECK WELDMENT	1
2	351510	SPRING ROLL PIN 3/8" x 1-3/4"	2
3	350027	HINGE ROD	2
4	300012	CENTER SKID SHOE WELDMENT (Specify Color)	2
5	80010374	5/8" x 5-1/2" HEX BOLT Gr. 5	8
6	300037	DECK LOCK (Specify Color)	4
7	80000251	1/2" x 2-1/2" HEX BOLT Gr. 2	4
	81000014	5/8" SAE FLATWASHER	16
	82000004	5/8" NYLOCK NUT Gr. 2	4
8	3010111-BK	HOSE HOLDER	3
9	351511	SELF TAPPING SCREW 1/4"-14 x 1-1/2"	3
10	300055-BK	STUMP JUMPER WELDMENT	1
11	3580004	CW ROTATION BLADE (Sold as Pair)	1
12	351526	BLADE BOLT KIT (Sold as Pair)	1
13	191369	CASTLE NUT M30 x 2	1
14	551106	FLATWASHER M30	1
15	191370	COTTER PIN M6.3 x 63	1
16	81000014	5/8" SAE FLATWASHER	16
17	82000006	5/8" NYLOCK NUT Gr. 2	8
18	83030010	BENT PIN 5/8" W/R-CLIP	4
19	3580016	SPLITTER GEARBOX 540-RPM	A/R
	3580012	SPLITTER GEARBOX 1000-RPM	A/R
20	80010350	5/8" x 2-1/2" HEX BOLT Gr. 5	4
	81020014	5/8" LOCKWASHER	4
	82010006	5/8" NYLOCK NUT Gr. 5	4
21	191310	CENTER GEARBOX 540-RPM	A/R
	3580009	CENTER GEARBOX 1000-RPM	A/R
22	80010411	3/4" x 2-1/2" HEX BOLT Gr. 5	6
	81020016	3/4" LOCKWASHER	6
	82010007	3/4" NYLOCK NUT Gr. 5	6

A/R = AS REQUIRED

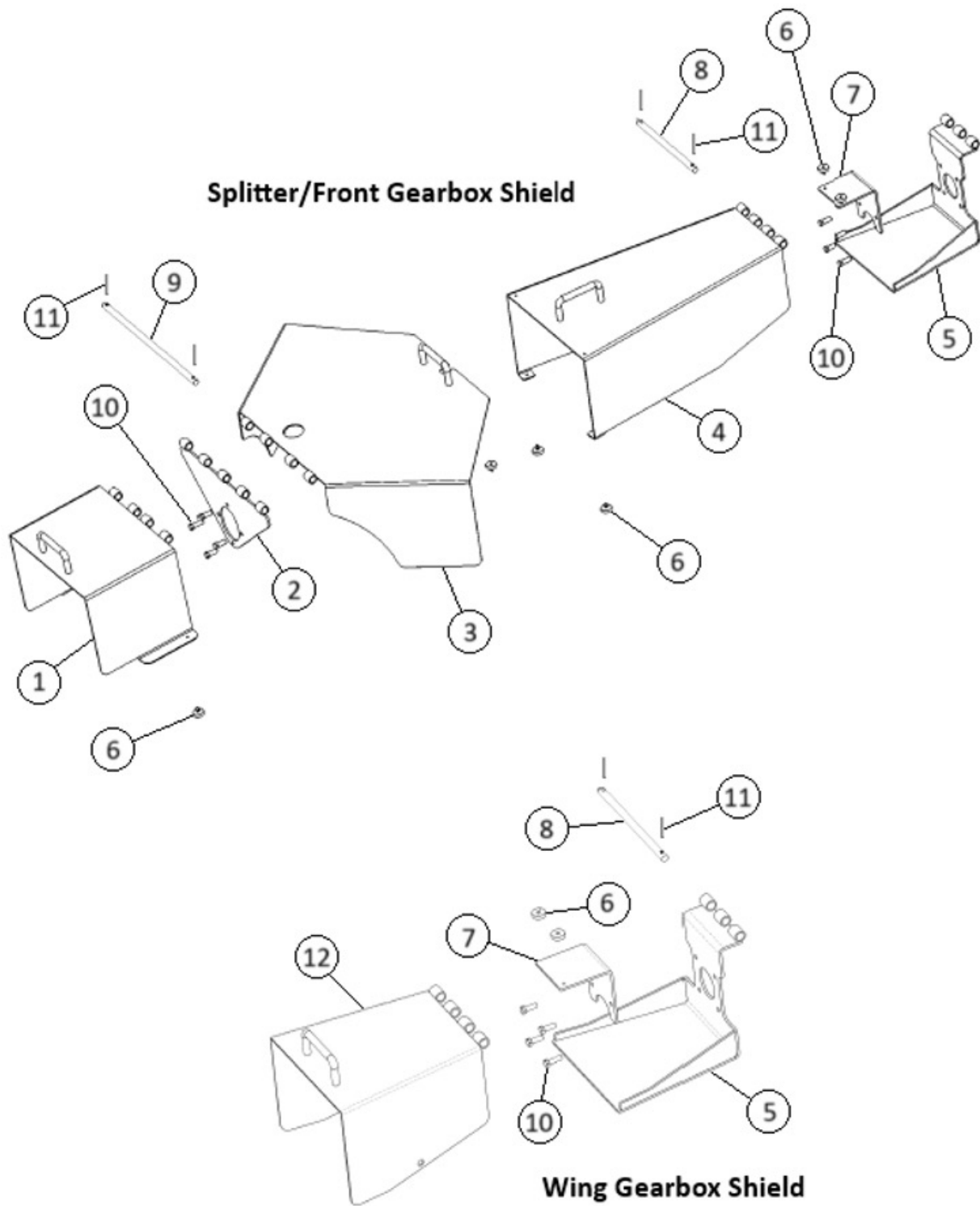
12.3 WING DECK COMPONENTS



CENTER DECK COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	350009-GR	LEFT WING DECK WELDMENT	A/R
	350013-GR	RIGHT WING DECK WELDMENT (RH Shown)	1
2	350052	TAIL LIGHT COVER (Specify Color)	1
3	80010010	1/4"-20 FULL THREADED HEX BOLT Gr. 5	4
	82010000	1/4"-20 NYLOCK NUT Gr. 5	4
4	83030015	CLEVIS PIN 1" x 6-1/2"	1
5	81000017	1" SAE FLATWASHER	2
6	83040001	3/16" x 2-1/2" COTTER PIN	1
7	3580017	EYE BOLT 1" x 9"	1
8	350029	RH - WING SHKID SHOE (Specify Color) - Shown	1
	350047	LH - WING SKID SHOE (Specify Color)	1
9	80040201	LOWER - CARRIAGE BOLT 1/2" x 2" Gr. 5	2
10	80040197	UPPER - CARRIAGE BOLT 1/2" x 1-1/2" Gr. 5	2
11	300055-BK	CENTER STUMP JUMPER WELDMENT	1
12	3580004	RH - (CW) ROTAION BLADE (Sold as Pair) - Shown	1
	3580005	LH - (CCW) ROTATION BLADE (Sold as Pair)	1
13	351526	BLADE BOLT KIT (Sold as Pair)	1
14	191369	CASTLE NUT M30 x 2	1
15	191650	LIGHT KIT	1
16	82040009	1"-8 HEX NUT Gr. 5	
17	551106	FLATWASHER M30	1
18	191370	COTTER PIN M6.3 x 63	1
19	81010004	1/2" FLATWASHER	4
20	82010004	1/2" NYLOCK NUT	4
21	83030010	BENT PIN 5/8" W/R-CLIP	2
22	191309	RH - WING GEARBOX 1000 RPM	A/R
	3580014	RH - WING GEARBOX 540 RPM	A/R
	3580011	LH - WING GEARBOX 1000 RPM	A/R
	3580015	LH - WING GEARBOX 540 RPM	A/R
23	80010411	3/4" x 2-1/2" HEX BOLT Gr. 5	6
	81020016	3/4" LOCKWASHER	6
	82010007	3/4" NYLOCK NUT Gr. 5	6

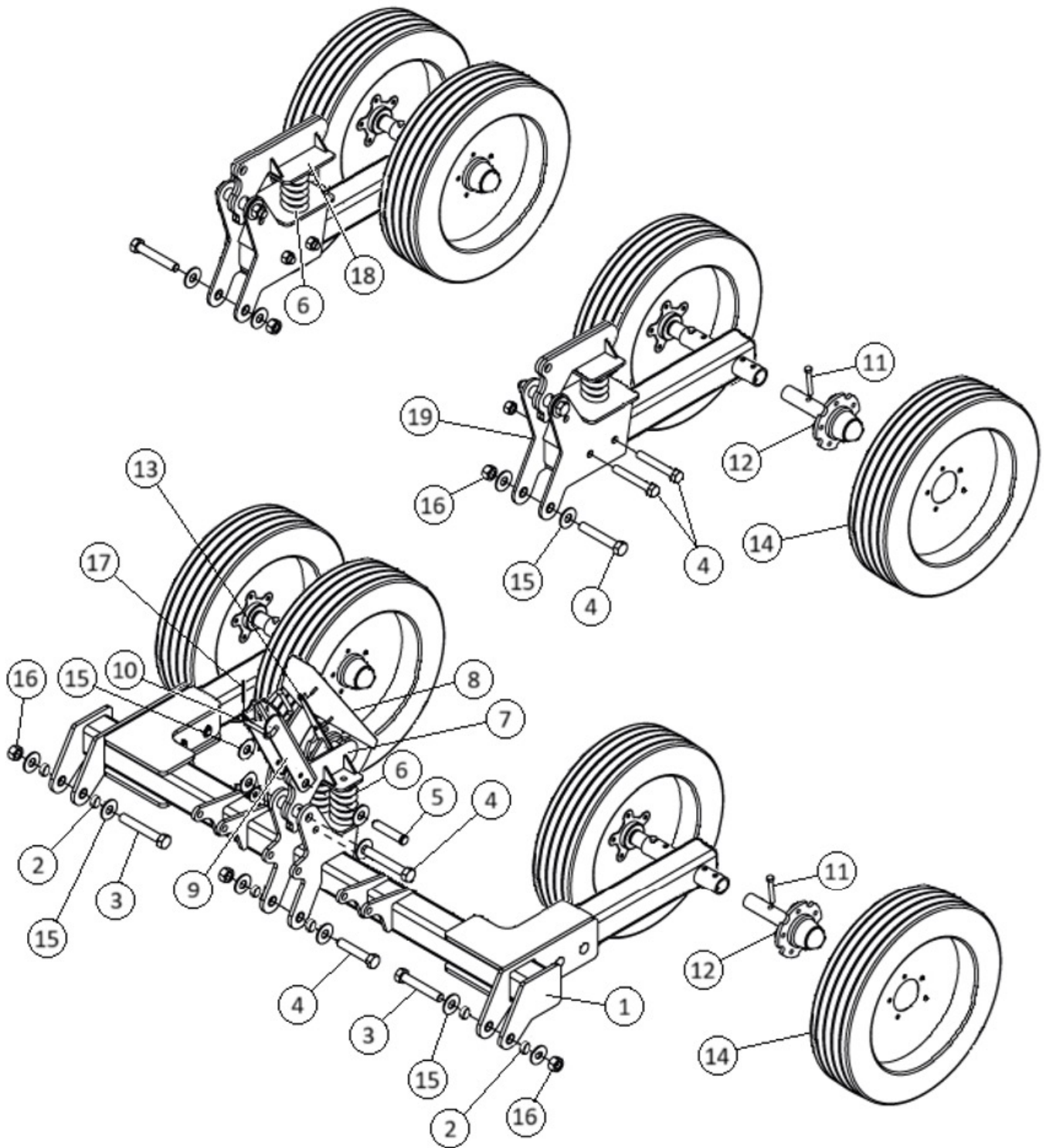
A/R = AS REQUIRED

12.4 GEARBOX SHIELD COMPONENTS



GEARBOX SHIELD COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	350006	C.V. SHIELD (Specify Color)	1
2	350015-BK	SPLITTER SHIELD MOUNT	1
3	350031	SPLITTER SHIELD - FRONT (Specify Color)	1
4	350030	SPLITTER SHIELD – REAR (Specify Color)	1
5	350033-BK	SPLITTER SHIELD REAR HINGE	1
6	83070000	MAGNET KIT	6
7	3510083-BK	GEARBOX SHIELD MAGNET BRACKET	1
8	3530002	SHIELD HINGE ROD	2
9	3530003	SHIELD HINGE ROD	1
10	80100026	HEX BOLT M8 x 25	12
	81000009	5/16" FLATWASHER	12
	81020009	5/16" LOCKWASHER	12
11	83050113	SPRING ROLL PIN 3/16" x 3/4"	6

12.5 STANDARD WHEEL LIFT COMPONENTS

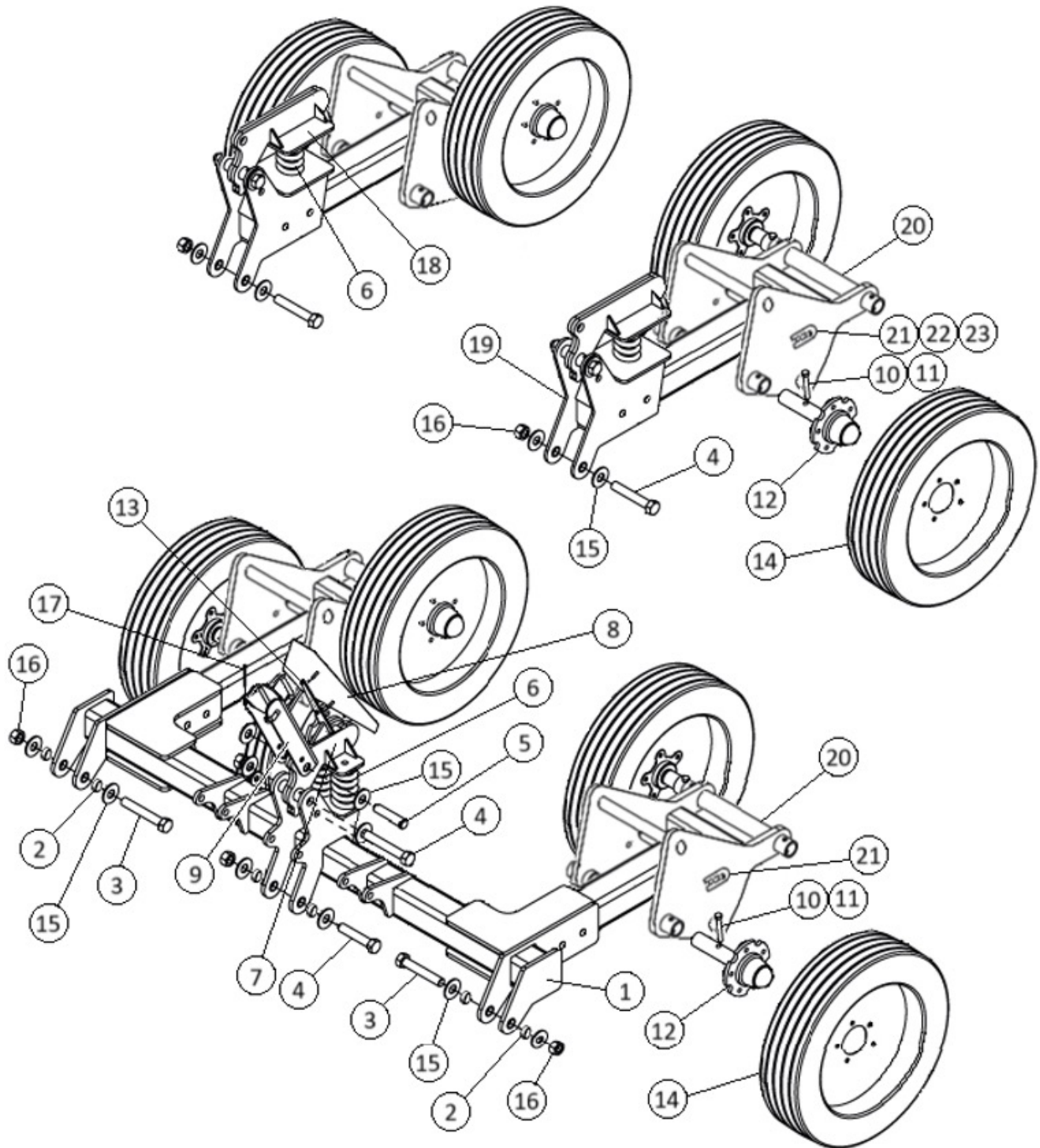


STANDARD WHEEL LIFT COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	350004-BK	CENTER WHEEL LIFT WELDMENT	1
2	83060000	TAILWHEEL BUSHING	6
3	80010557	1"-8 x 6" HEX BOLT Gr. 5	2
4	80010561	1"-8 x 6-1/2" HEX BOLT Gr. 5	9
5	83030009	CLEVIS PIN 1" x 4-1/2"	1
6	191218-BK	SUSPENSION SPRING	4
7	300006-BK	CENTER LIFT CYLINDER BRACKET	1
8	191651	SMV SIGN	1
9	300037-BK	TRANSPORT CYLINDER LOCK	1
10	83030011	BENT PIN 1/2" x 4-1/2" W/R-CLIP	1
11	80010259	1/2" x 3-1/2" HEX BOLT Gr. 5	8
	82010004	1/2" NYLOCK NUT	8
12	351522	HUB & SPINDLE ASSY	8
13	80000010	1/4"-20 FULLY THREADED HEX BOLT Gr. 2	2
	81020008	1/4" LOCKWASHER	2
	82000000	1/4"-20 NYLOCK NUT	2
14	300038	26" LAMINATED WHEEL& TIRE	A/R
	300057	AIRCRAFT TIRE 27" x 7.75" x 15" (Foam Filled)	A/R
	300058	AIRCRAFT TIRE 27" x 7.75" x 15" (Pneumatic)	A/R
*Note	*300048	26" AIRCRAFT TIRE (Foam Filled)	A/R
*Note	*300049	29" AIRCRAFT TIRE (Pneumatic) – Shown	A/R
15	81010009	1" FLATWASHER	14
16	82010009	1"-8 NYLOCK NUT	14
17	351514	COTTER PIN 1/8" x 2"	1
18	350023-BK	WING TAILWHEEL LIFT CYLINDER BRACKET	2
19	350044-BK	WING TAILWHEEL ARM WELDMENT	2

*NOTE: NO LONGER USED ON PRODUCTION MODELS AFTER 04-03-2024

A/R = AS REQUIRED

12.6 (OPTIONAL) TANDEM WHEEL LIFT COMPONENTS

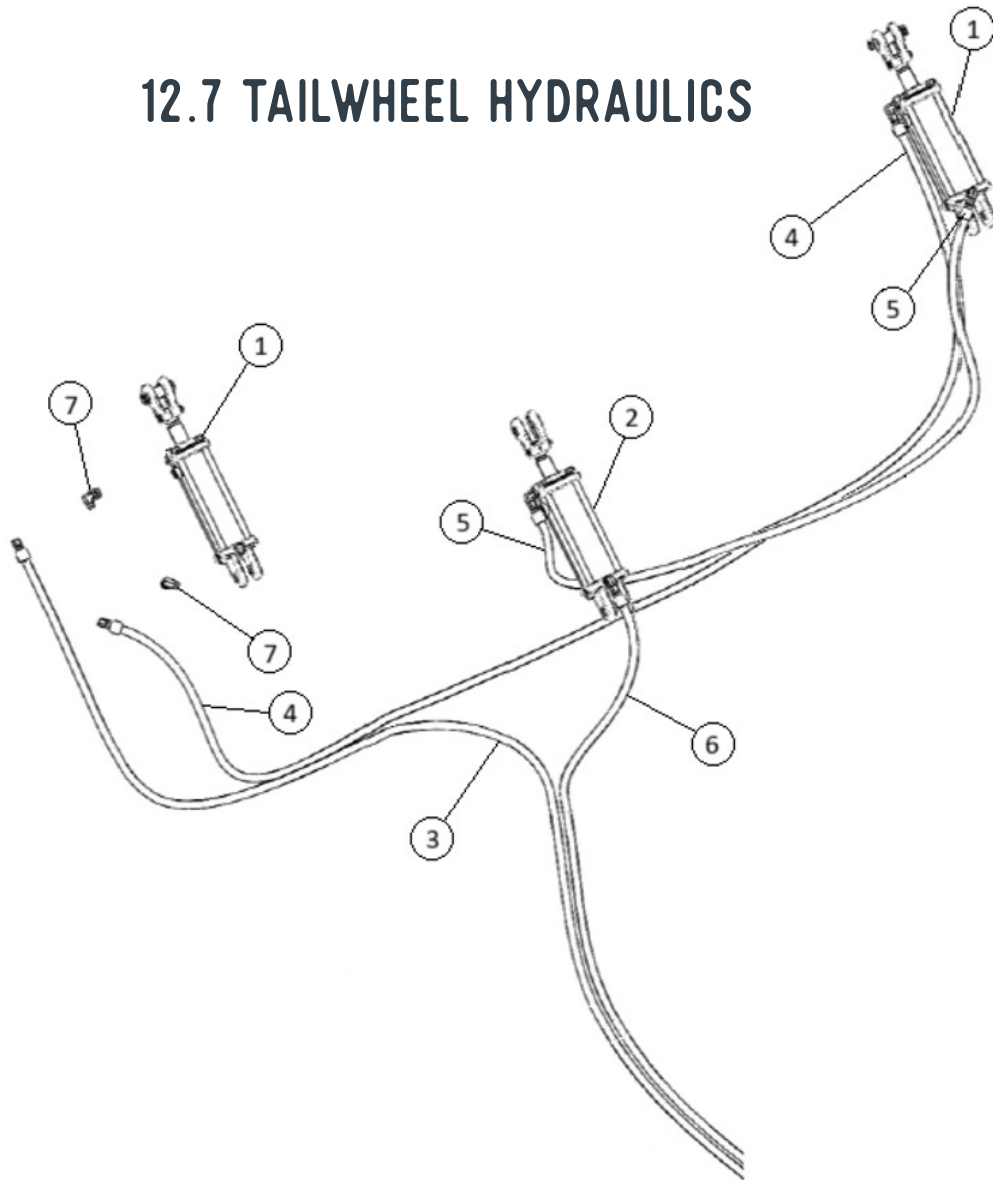


TANDEM WHEEL LIFT COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	350004-BK	CENTER WHEEL LIFT WELDMENT	1
2	83060000	TAILWHEEL BUSHING	6
3	80010557	1"-8 x 6" HEX BOLT Gr. 5	2
4	80010561	1"-8 x 6-1/2" HEX BOLT Gr. 5	9
5	83030009	CLEVIS PIN 1" x 4-1/2"	1
6	191218-BK	SUSPENSION SPRING	4
7	300006-BK	CENTER LIFT CYLINDER BRACKET	1
8	191651	SMV SIGN	1
9	300037-BK	TRANSPORT CYLINDER LOCK	1
10	83030011	BENT PIN 1/2" x 4-1/2" W/R-CLIP	1
11	80010259	1/2" x 3-1/2" HEX BOLT Gr. 5	8
	82010004	1/2" NYLOCK NUT	8
12	351522	HUB & SPINDLE ASSY	8
13	80000010	1/4"-20 FULLY THREADED HEX BOLT Gr. 2	2
	81020008	1/4" LOCKWASHER	2
	82000000	1/4"-20 NYLOCK NUT	2
14	300038	26" LAMINATED WHEEL& TIRE	A/R
	300057	AIRCRAFT TIRE 27" x 7.75" x 15" (Foam Filled)	A/R
	300058	AIRCRAFT TIRE 27" x 7.75" x 15" (Pneumatic)	A/R
*Note	*300048	26" AIRCRAFT TIRE (Foam Filled)	A/R
*Note	*300049	29" AIRCRAFT TIRE (Pneumatic) – Shown	A/R
15	81010009	1" FLATWASHER	14
16	82010009	1"-8 NYLOCK NUT	14
17	351514	COTTER PIN 1/8" x 2"	1
18	350023-BK	WING TAILWHEEL LIFT CYLINDER BRACKET	2
19	350044-BK	WING TAILWHEEL ARM WELDMENT	2
20	350019-BK	TANDEM AXLE WELDMENT	4
21	350050	TANDEM PIVOT PIN	4
22	80010410	3/4" x 2-1/2" FULLY THREADED HEX BOLT Gr. 5	4
23	82010007	3/4" NYLOCK NUT	4

*NOTE: NO LONGER USED ON PRODUCTION MODELS AFTER 04-03-2024

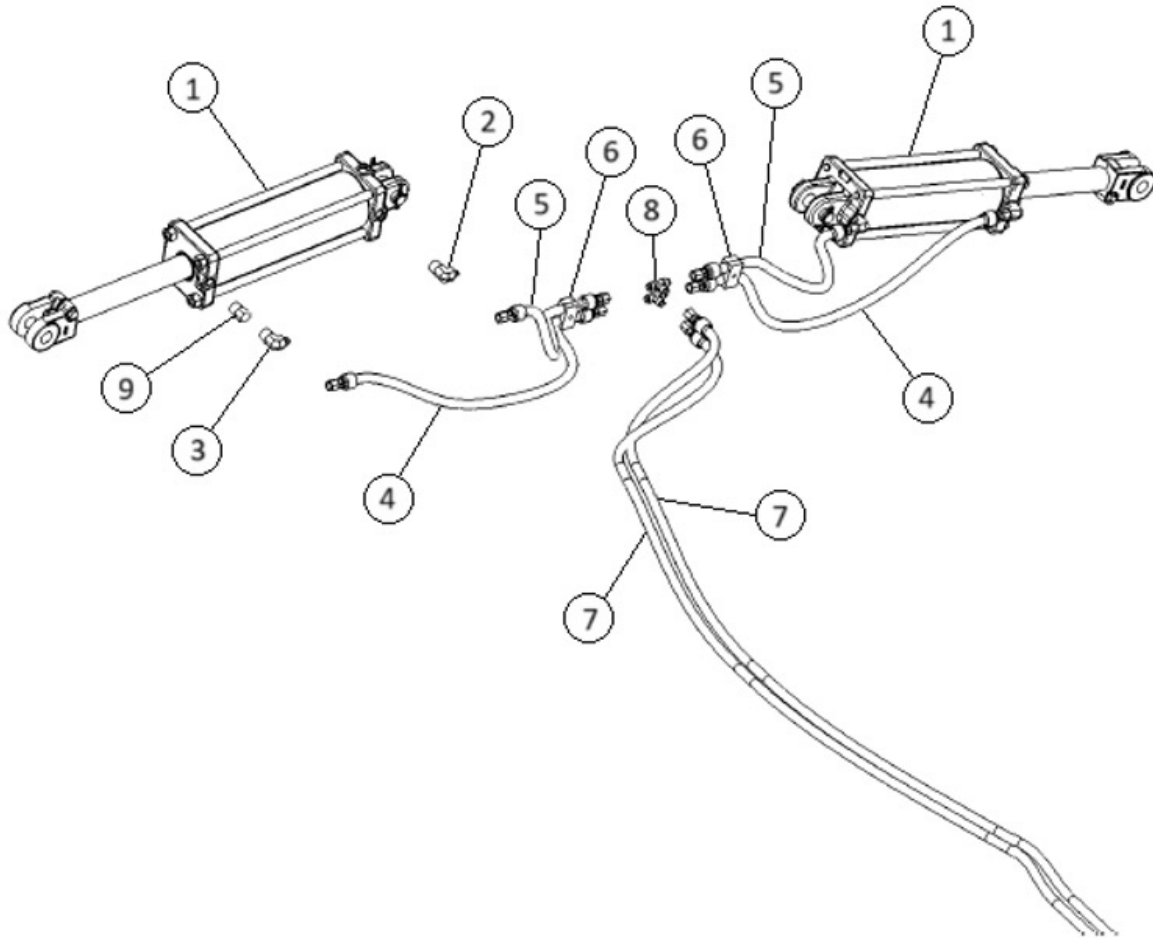
A/R = AS REQUIRED

12.7 TAILWHEEL HYDRAULICS



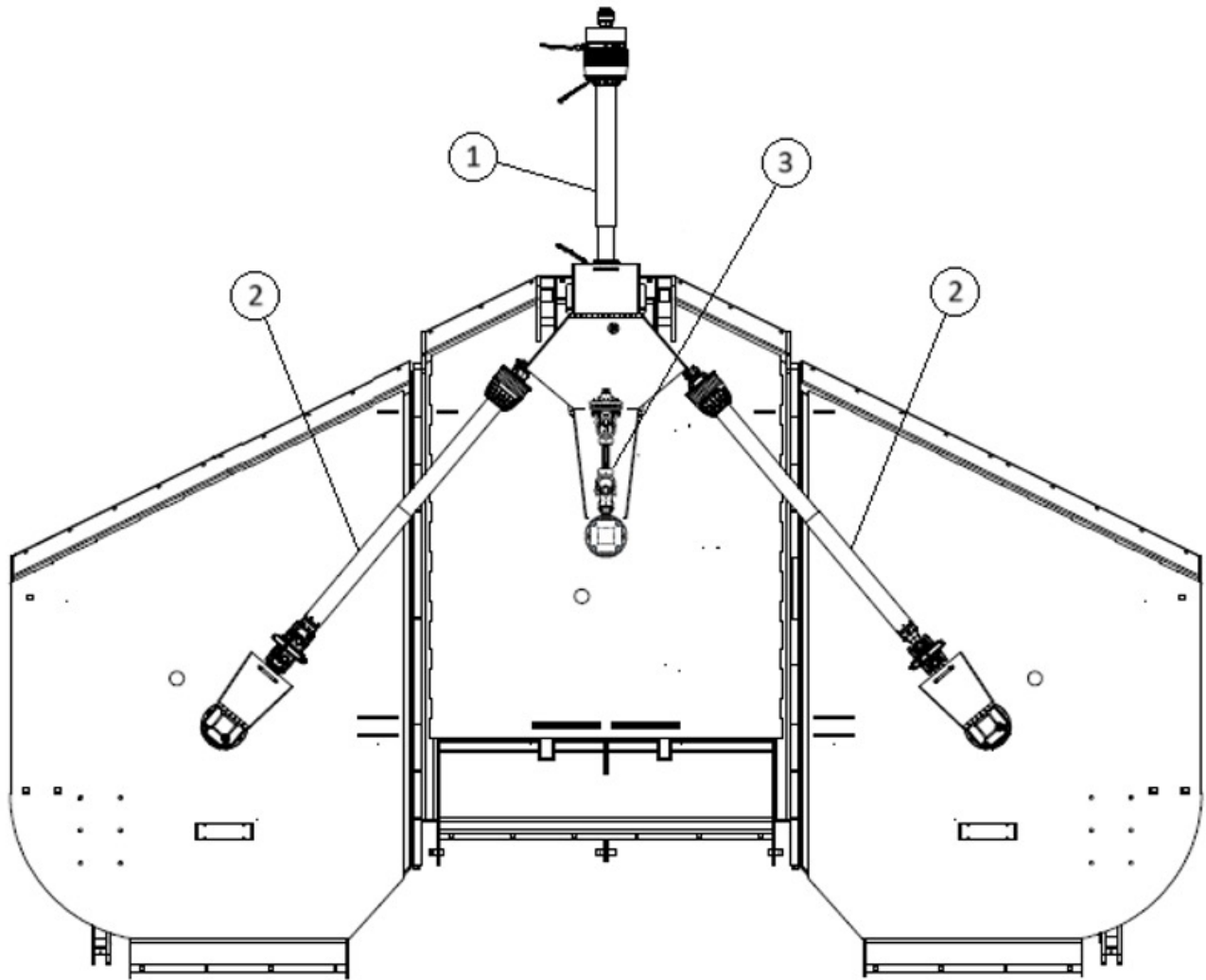
TAILWHEEL HYDRAULICS			
ITEM	PART #	DESCRIPTION	QTY
1	3580001	3" x 8" PHASING CYLINDER	2
2	3580003	3-1/2" x 8" PHASING CYLINDER	1
3	350054	349" HYDRAULIC HOSE	1
4	350055	244" HYDRAULIC HOSE	1
5	350056	129" HYDRAULIC HOSE	1
6	350053	228" HYDRAULIC HOSE	1
7	84000072	3/8" HIC MALE x #8 SAE MALE ELBOW	6

12.8 WING HYDRAULICS



WING HYDRAULICS			
ITEM	PART #	DESCRIPTION	QTY
1	3580025	4" x 12" HYDRAULIC CYLINDER – SAE	2
2	84000078	90-DEGREE RESTRICTOR ELBOW (6MJ – 8M ORB)	2
3	84000072	3/8" JIC x #8 SAE MALE ELBOW	2
4	350058	28" HYDRAULIC HOSE	2
5	350057	12" HYDRAULIC HOSE	2
6	3580023	5/8" TWIN HOSE CLAMP	2
	3580024	CLAMP PLATE	2
7	350053	228" HYDRAULIC HOSE	2
8	84000004	6MJ TEE (Not Bulk Head)	2
9	84000080	ADAPTER (Used on certain cylinders)	2

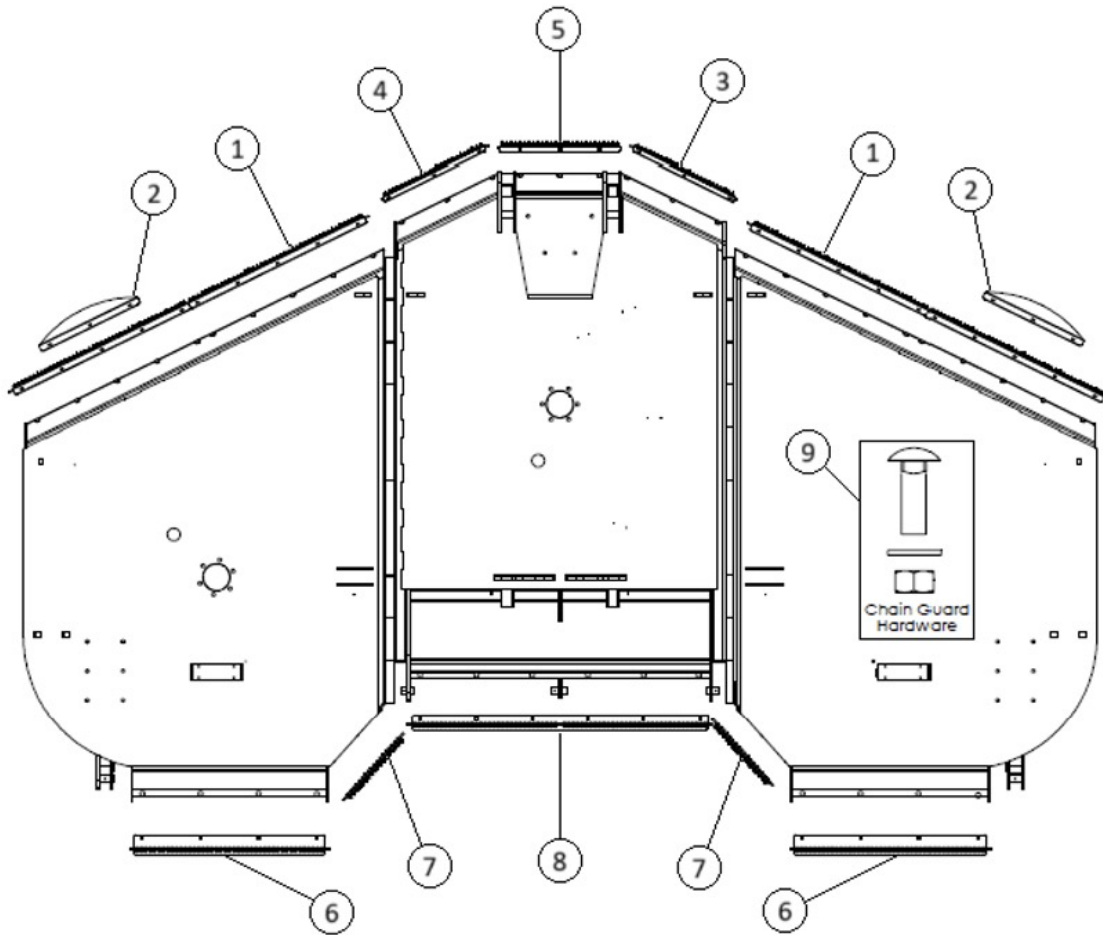
12.9 DRIVELINE ASSEMBLY BY LOCATION



DRIVELINE ASSEMBLY			
ITEM	PART #	DESCRIPTION	QTY
1	191560	C.V. DRIVELINE 540-RPM 1-3/8" Tractor 6-Spline	A/R
	191563	C.V. DRIVELINE 1000-RPM 1-3/4" Tractor 20-Spline	A/R
	191564	C.V. DRIVELINE 1-3/8" Tractor 21-Spline	A/R
2	3580006	WING DRIVELINE	2
3	3580027	CROSS SHAFT	1

A/R = AS REQUIRED

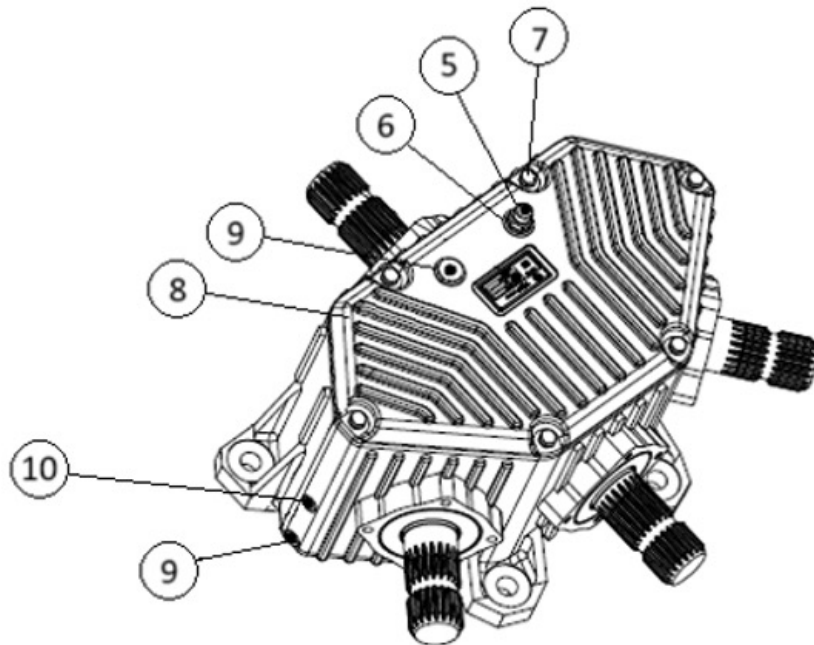
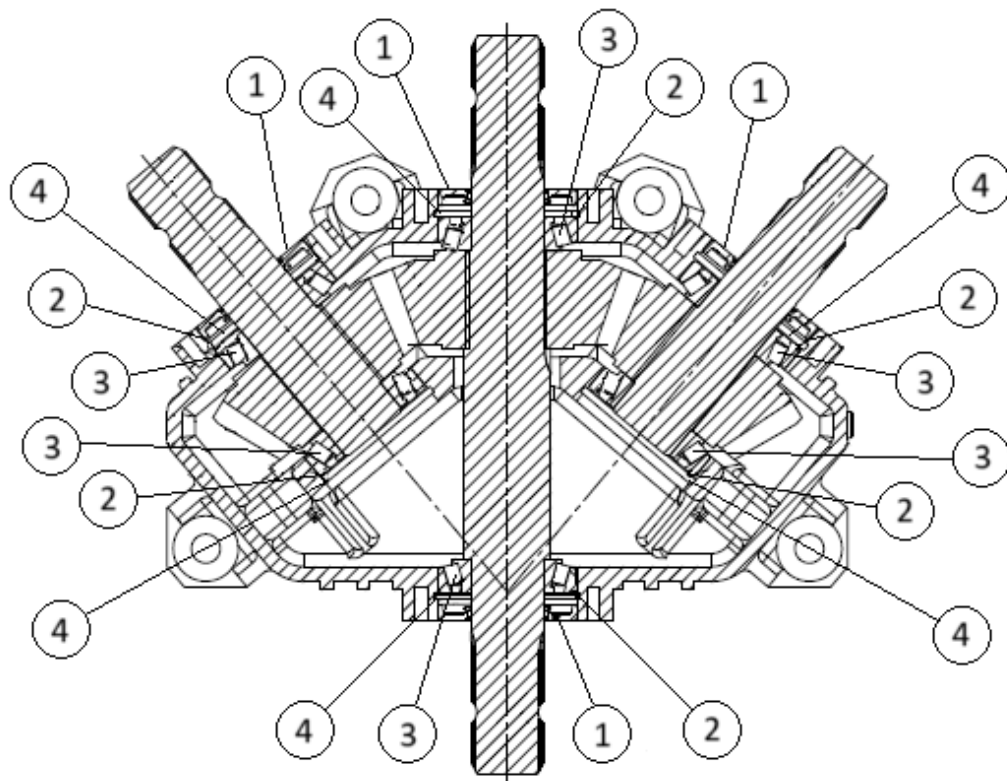
12.10 CHAIN GUARDS BY LOCATION



CHAIN GUARDS			
ITEM	PART #	DESCRIPTION	QTY
1	350036	FRONT WING CHAIN GUARD ASSY (Specify Color)	2
2	3510053	WING SAFETY GUARD (Specify Color)	2
3	350034	RH-FRONT CENTER CHAIN GUARD ASSY (Specify Color)	1
4	350035	LH-FRONT CENTER CHAIN GUARD ASSY (Specify Color)	1
5	300030	FRONT CENTER CHAIN GUARD ASSY (Specify Color)	1
6	350038	REAR WING CHAIN GUARD ASSY (Specify Color)	2
7	350037	REAR INNER WING CHAIN GUARD ASSY (Specify Color)	2
8	350039	REAR CENTER CHAIN GUARD ASSY (Specify Color)	1

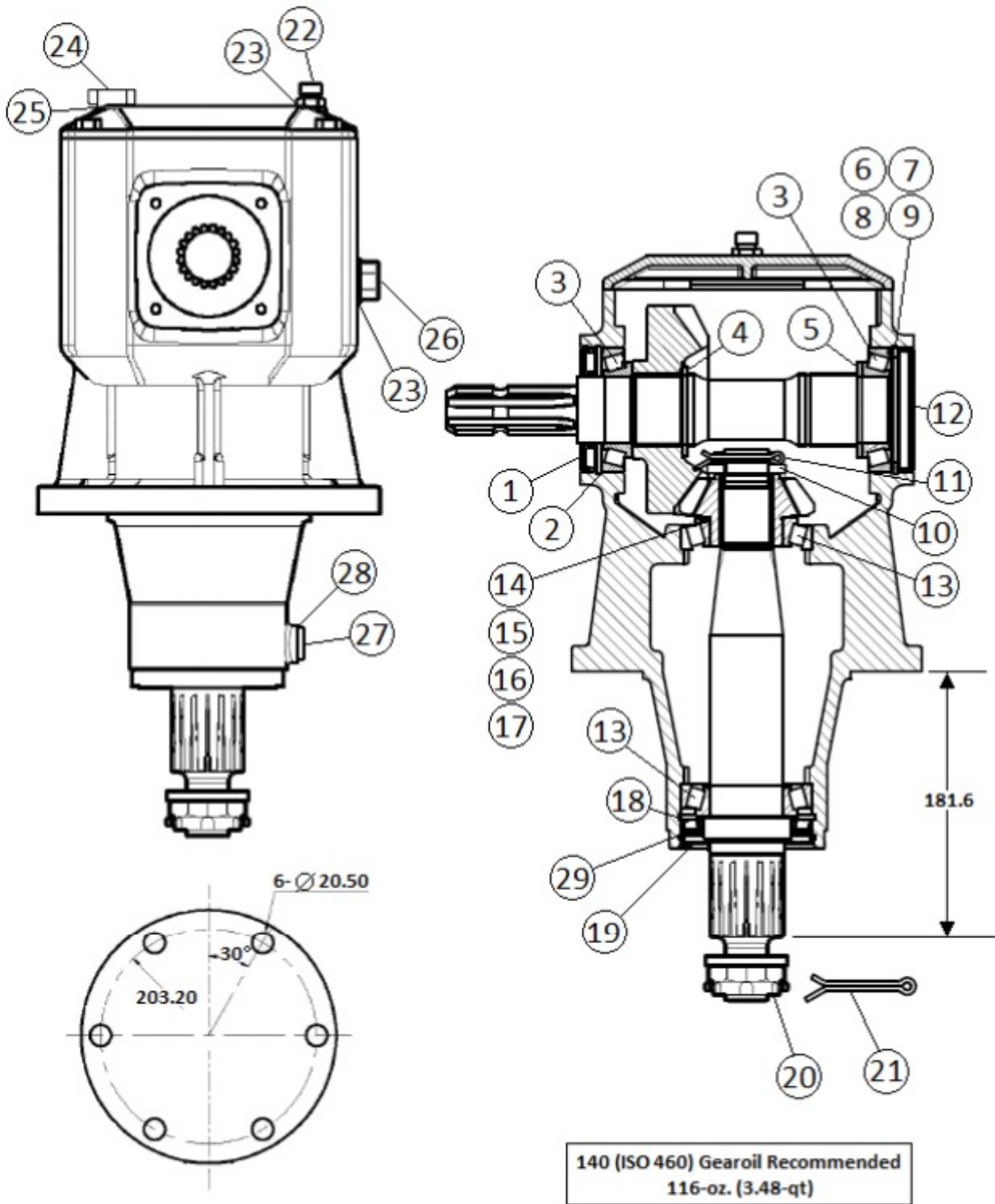
A/R = AS REQUIRED

12.11 GTM SPLITTER GEARBOX



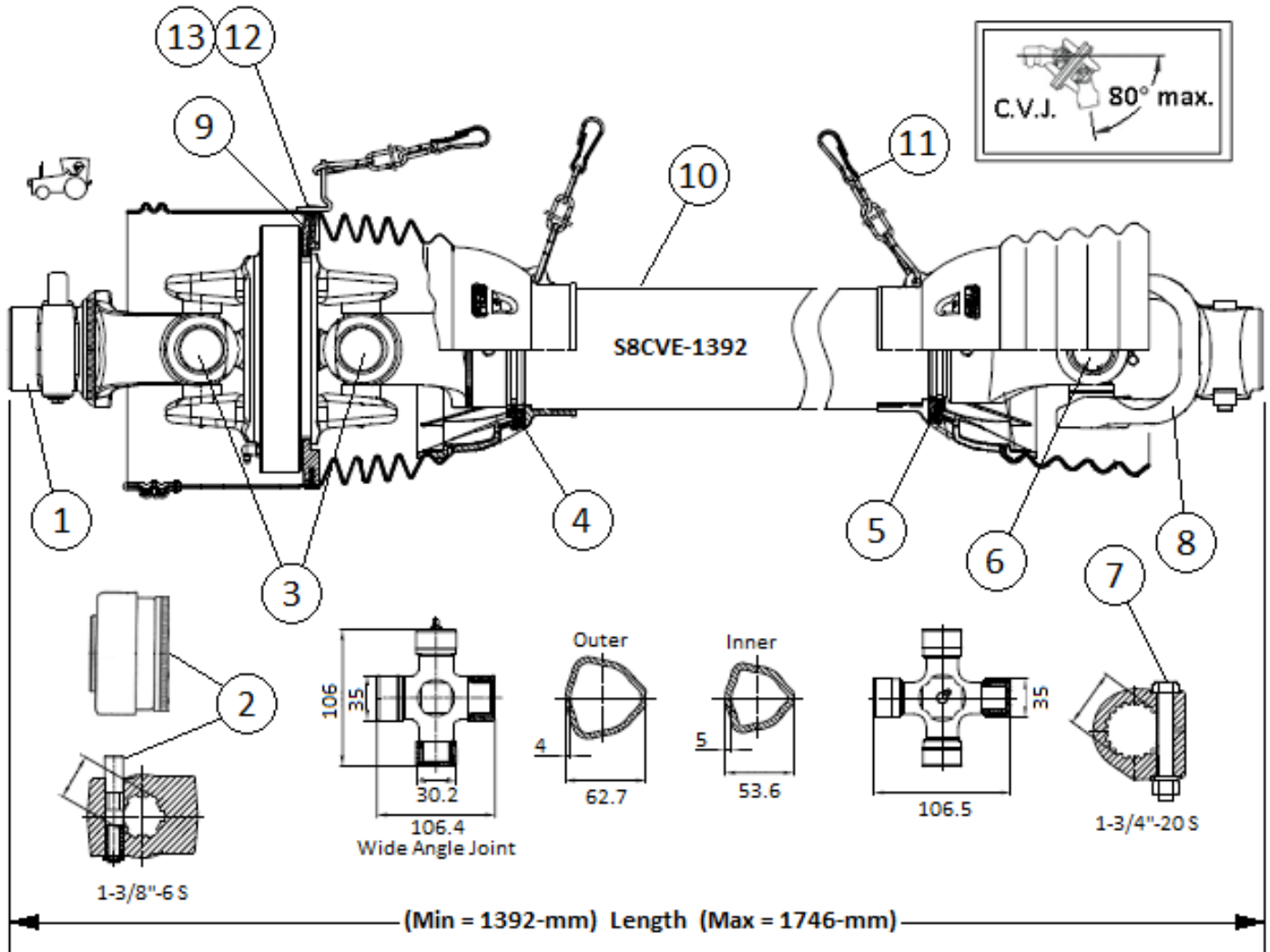
GTM SPLITTER GEARBOX			
ITEM	PART #	DESCRIPTION	QTY
1	191350	DOUBLE LIP OIL SEAL 45 x 85 x 10	4
2	191406	SNAP RING 85 x 4	4
	191355	ADJ. WASHER 84.5 x 73 x 0.3	6
	191400	ADJ. WASHER 84.5 x 73 x 0.1	12
	191358	ADJ. WASHER 84.5 x 73 x 1	6
3	191352	ROLLER BEARING 30209	7
4	191351	SNAP RING 85 x 3	6
5	191371	VENT PLUG M16 x 1.5	1
6	191372	SEAL WASHER FOR PLUG 16.2 x 19.9 x 1.5	1
7	191401	HH FLANGED BOLT M8 x 30 WITH TEETH	6
8	191402	TOP COVER PLATE	1
9	191392	INNER HEXAGON – SOLID PLUG 3/8-18NPT	3
10	191405	OIL SITE GLASS 3/8"-NPT	1
	3580016	COMPLETE GEARBOX 540-RPM (Ratio 1:1.2)	
	3580012	COMPLETE GEARBOX 1000-RPM (Ratio 1.2:1)	

12.12 OUTBOARD GEARBOX COMPONENTS



OUTBOARD GEARBOX COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	191350	DOUBLE LIP SEAL 45 x 85 x 10	1
2	191351	SNAP RING 85 x 3	2
3	191352	TAPERED ROLLER BEARING 30209	2
4	191353	SNAP RING 50 x 3	1
5	191354	FLAT WASHER 45.3 x 65 x 2.5	1
6	191355	ADJUSTING SHIM 84.5 x 73 x 0.3	4
7	191356	ADJUSTING SHIM 84.5 x 73 x 0.4	4
8	191357	ADJUSTING SHIM 84.5 x 73 x 0.5	2
9	191358	ADJUSTING SHIM 84.5 x 73 x 1	2
10	191359	CASTLE NUT M30 x 1.5	1
11	191360	COTTER PIN 5 x 63	1
12	191361	OIL CAP PLUG 85 x 10	1
13	191362	TAPERED ROLLER BEARING 30210	2
14	191363	ADJUSTING WASHER 50.2 x 61.8 x 0.3	4
15	191364	ADJUSTING WASHER 50.2 x 61.8 x 0.4	4
16	191365	ADJUSTING WASHER 50.2 x 61.8 x 0.5	1
17	191366	ADJUSTING WASHER 50.2 x 61.8 x 1	1
18	191367	SNAP RING 90 X 3	2
19	191368	DUST CAP	1
20	191369	CASTLE NUT M30 x 2	1
21	191370	COTTER PIN 6.3 x 63	1
22	191371	VENT PLUG M16 x 1.5	1
23	191372	PLUG WASHER 16.2 x 19.9 x 1.5	2
24	191373	OIL LEVELER	1
25	191374	OIL LEVELER WASHER	1
26	191375	OIL PLUG M16 x 1.5	1
27	191376	SOLID PLUG – CS HEX 9/16”	1
28	191377	O-RING 11.2 x 2	1
29	191379	DOUBLE LIP SEAL 60 x 90 x 10	1
	191310	COMPLETE CENTER DECK GEARBOX 540 RPM	
	3580009	COMPLETE CENTER DECK GEARBOX 1000 RPM	
	191309	COMPLETE RH-WING GEARBOX 540 RPM	
	3580014	COMPLETE RH-WING GEARBOX 1000 RPM	
	3580015	COMPLETE LH-WING GEARBOX 540 RPM	
	3580011	COMPLETE LH-WING GEARBOX 1000 RPM	

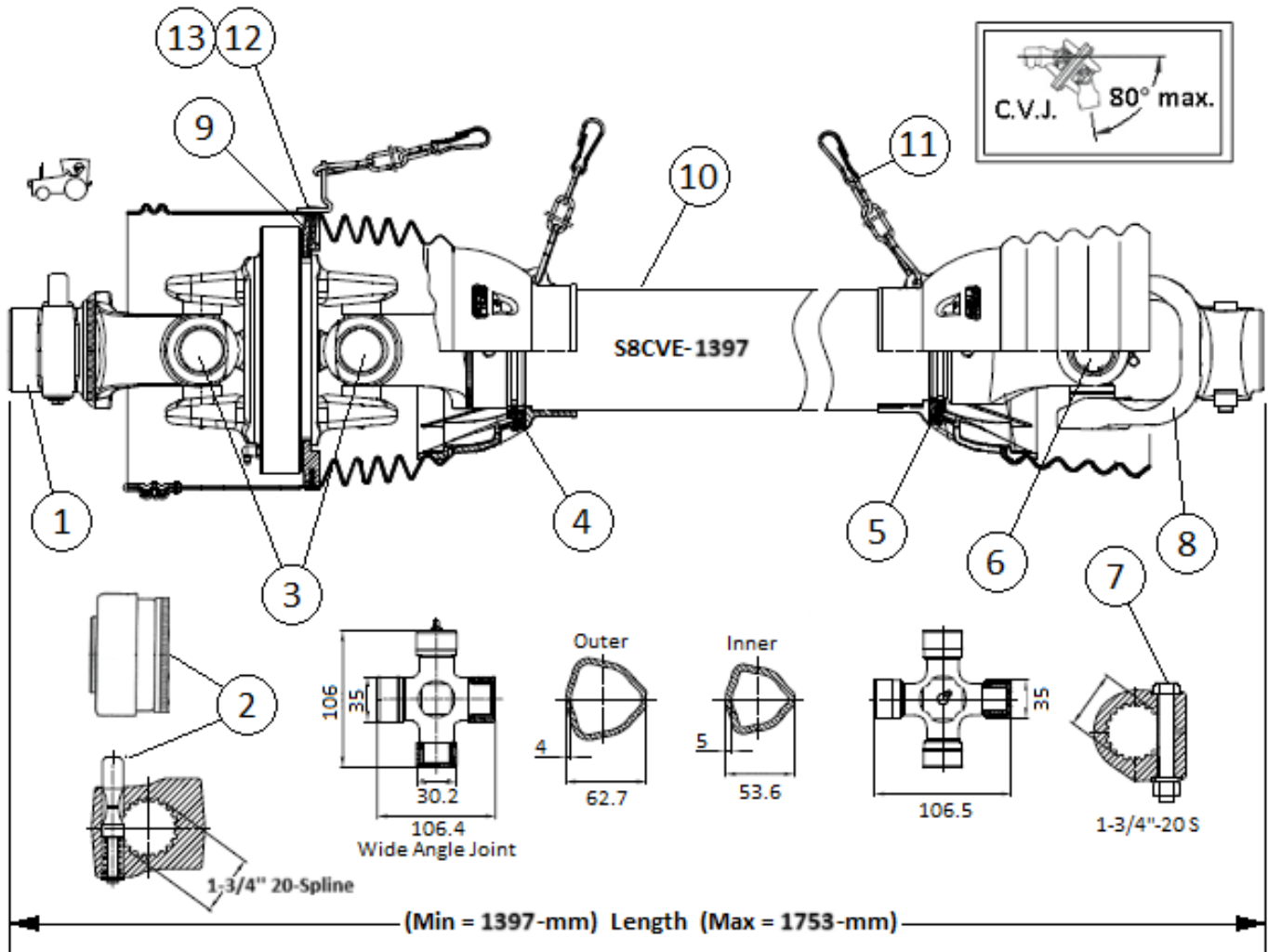
12.13 R & W – C.V. S8CVE-1392 (540-RPM 6-SPLINE)



R & W – C.V. S8CVE-1392 (540-RPM 6-SPLINE)			
ITEM	PART #	DESCRIPTION	QTY
1	552156	TRACTOR YOKE W/PUSH PIN 1-3/8" 6-S	1
2	552157	PUSH PIN KIT	1
	552091	PULL COLLAR KIT (Note: Used on Earlier Models)	A/R
3	552158	CROSS KIT 30.2/106 – 35/106.4	2
4	552159	OUTER PLASTIC SHIELD BEARING	1
5	552160	INNER PLASTIC SHIELD BEARING	1
6	552161	CROSS KIT 35/106.5	1
7	552162	BOLT W/NUT & LOCKWASHER M16 X 90	1
8	552163	GEARBOX YOKE 1-3/4" 20-S	1
9	552164	C.V. SHIELD BEARING	1
10	552165	COMPLETE SHIELD	1
11	552166	SAFETY CHAIN	3
12	552167	CLIP FOR SAFETY CHAIN	1
13	552168	SELF TAPPING SCREW M8 x 16	1
	191560	Complete – C.V. Driveline 540-RPM 6-S	

A/R = AS REQUIRED

12.14 R & W – C.V. S8CVE-1397 (1000-RPM 20-SPLINE)

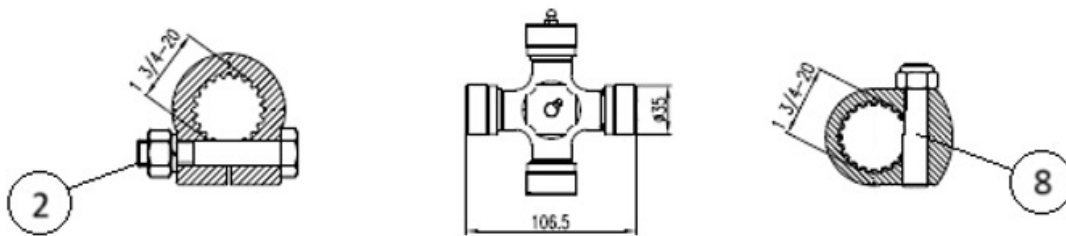
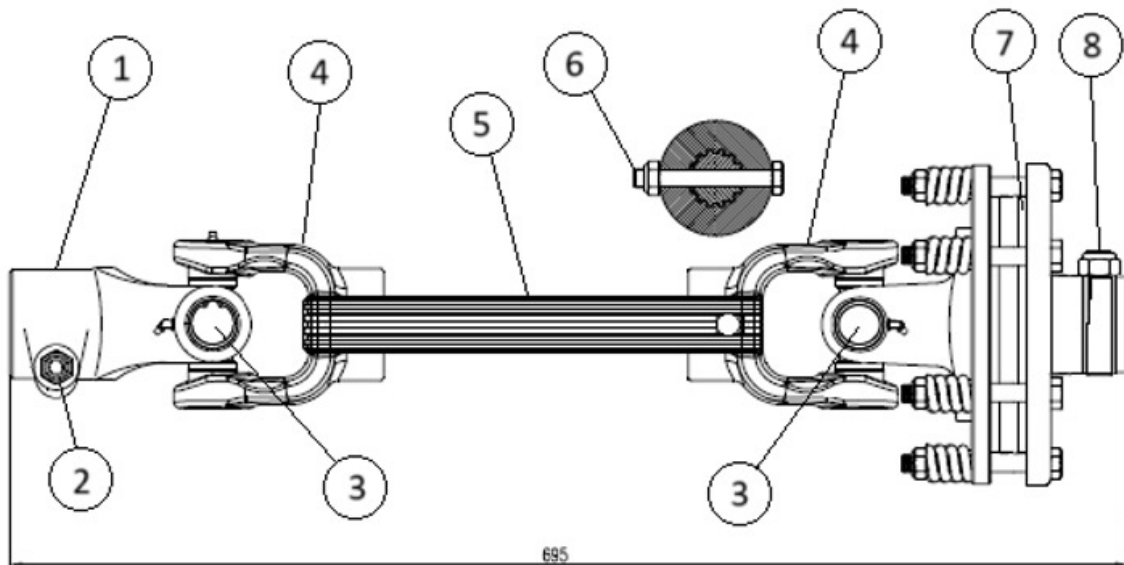


R & W – C.V. S8CVE-1397 (1000-RPM 20-SPLINE)

ITEM	PART #	DESCRIPTION	QTY
1	—	TRACTOR YOKE W/PUSH PIN 1-3/4" 20-SPLINE	NA
	—	TRACTOR YOKE W/PUSH PIN 1-3/8" 21-SPLINE	NA
2	552157	PUSH PIN KIT	1
	552091	PULL COLLAR KIT (Note: Used on Earlier Models)	A/R
3	552158	CROSS KIT 30.2/106 – 35/106.4	2
4	552159	OUTER PLASTIC SHIELD BEARING	1
5	552160	INNER PLASTIC SHIELD BEARING	1
6	552161	CROSS KIT 35/106.5	1
7	552162	BOLT W/NUT & LOCKWASHER M16 X 90	1
8	552163	GEARBOX YOKE 1-3/4" 20-S	1
9	552164	C.V. SHIELD BEARING	1
10	552165	COMPLETE SHIELD	1
11	552166	SAFETY CHAIN	3
12	552167	CLIP FOR SAFETY CHAIN	1
13	552168	SELF TAPPING SCREW M8 x 16	1
	191563	Complete – C.V. Driveline 1000-RPM 20-S	

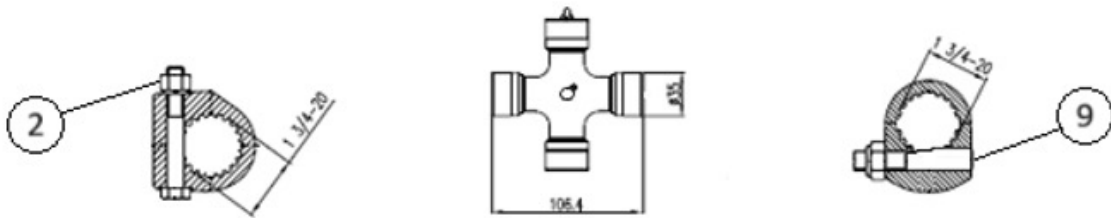
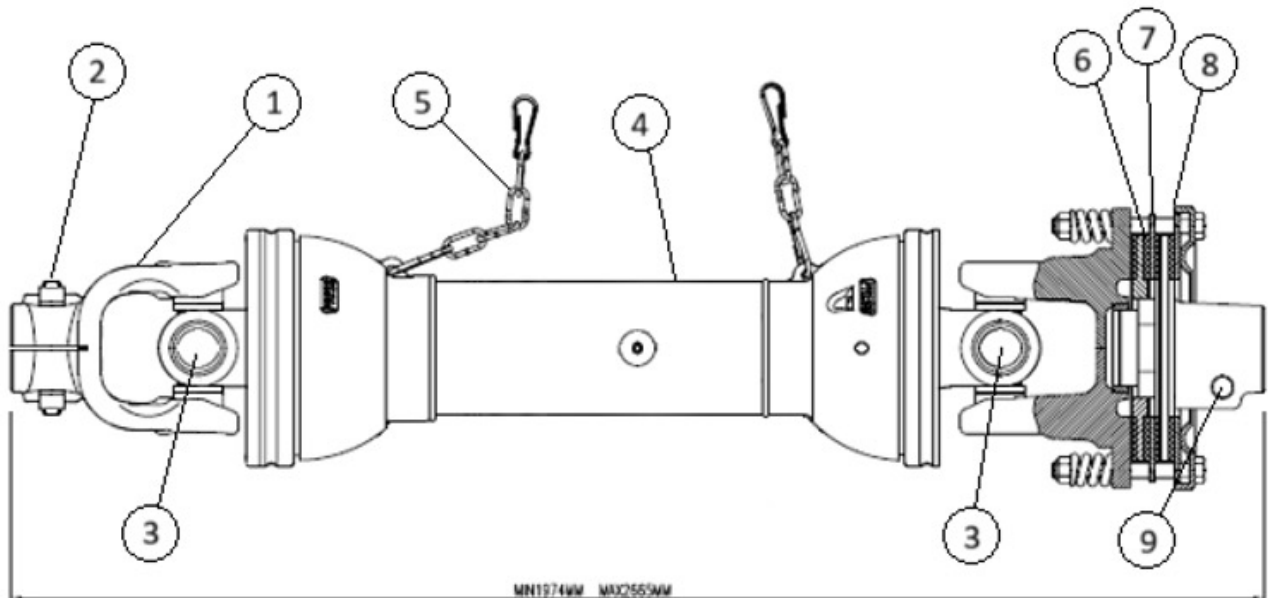
A/R = AS REQUIRED

12.15 CROSS SHAFT COMPONENTS



CROSS SHAFT COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	3580030	YOKE 1-3/4" 20-SPLINED	1
2	3580031	HEX BOLT M16 x 90 W/NUT & LOCKWASHER	1
3	3580032	CROSS KIT #8	2
4	3580033	INNER YOKE	1
5	3580034	SPLINED SHAFT #8	1
6	3580035	HEX BOLT M10 x 95 W/NUT	1
7	3580036	CLUTCH LINING (2-Pack)	1
8	3580037	ECCENTRIC PIN 16 x 85 W/NUT	1
3580027		COMPLETE CROSS SHAFT S8ECLE-695	

12.16 WING DRIVELINE COMPONENTS



WING DRIVELINE COMPONENTS			
ITEM	PART #	DESCRIPTION	QTY
1	3580030	YOKE 1-3/4" 20-Spline	1
2	3580031	HEX BOLT M16 x 90 W/NUT & LOCKWASHER	1
3	3580032	CROSS KIT #8	2
4	3580043	COMPLETE SHIELD	1
5	552005	SAFETY CHAIN	2
6	3580036	CLUTCH LINING (2-Pack)	1
7	3580040	INTERNAL DISC	1
8	3580041	PRESSURE PLATE	1
9	3580037	ECCENTRIC PIN 16 x 85 W/NUT	1
3580006		COMPLETE WING DRIVELINE S8ECL-1974	



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Revised April 10, 2024 8:28 PM
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