



IRONCRAFT

X-TREME TREE REAPER BRUSH CUTTER



OPERATION AND MANUAL

Read and understand the manual. This manual provides information and procedures to safely operate and maintain the X-treme Tree Reaper Brush Cutter.

MODELS: TRBC172760 | TRBC172772 | TRBC172778



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August 2023

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INTRODUCTION

1.1 WELCOME

Congratulations on your choice of an IronCraft Brush Cutter. This equipment has been designed and manufactured to meet the needs of discerning users. Many features incorporated into this brush cutter are the result of suggestions made by customers like you.

Read this manual carefully to learn how to operate the brush 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 brush cutter will provide many years of trouble-free service.

1.2 SAFE OPERATION

Safe, efficient, and trouble-free operation of your brush 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.

Upon reading this manual, all users should sign the "Safety Acknowledgement Form" at the end of this manual. Please record your model and dealer information on page 5. You will be asked to provide this information when ordering parts or requesting service. If you need more information on this product, contact your local dealer or visit www.ironcraftusa.com.



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 brush 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 brush cutter until the user has read this manual and has developed a thorough understanding of the safety precautions and functions of the unit. This brush cutter is designed for the specific purpose of clearing brush. DO NOT modify or use this brush cutter for any application other than that for which it was designed. Brush cutters maintained or operated improperly or by untrained personnel can be dangerous; exposing the user and/or bystanders to possible serious injury or death.



**STORE THIS MANUAL IN THE DOCUMENT
CANISTER ATTACHED TO THIS MACHINE.**



1.3 SPECIFICATIONS

	16-26 GPM		17-27 GPM	
MODEL	72" - TRBC162672		72" - TRBC172772	78" - TRBC172778
LENGTH	80" (203.2 cm)			
HEIGHT	24" (60.96 cm)			
WEIGHT (LB)	1,800	2,100	1,800	2,100
CASE DRAIN	no		yes	
MSS/ CTL LIFT WEIGHT (LB)	6,500			
MSS/CTL LIFT CAPACITY (LB)	2,200			
MSS/CTL POWER	>75 HP			
GEAR OIL	85W-140 5EP			
CUT CAPACITY	5"			
BLADE CONFIG.	3			
REPLACEABLE WEAR SKIDS	yes			
MULCHING TEETH # (OPTIONAL)	12			

Specifications subject to change without notice.

1.4 REGISTER THIS PRODUCT

PURCHASE DATE

DEALER NAME

ADDRESS

PHONE NUMBER

MODEL

SERIAL



"WHY WOULD I WANT TO REGISTER MY MACHINE?" YOU ASK. IT'S A VALID QUESTION. WE USED TO ASK OURSELVES THE SAME THING...

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 code for an easy-peasy registering process. You'll be glad you did.



<https://www.ironcraftusa.com/warranty/register-warranty/>


SAFETY INFORMATION

2.1 INTRODUCTION

The following terms are used interchangeably throughout this manual.

X-TREME TREE REAPER BRUSH CUTTER	SKID STEER	OPERATOR
implement, attachment, rotary cutter, machine, brush cutter, cutter	skid steer loader, skid steer tractor, loader, prime mover	user, personnel

The X-treme Tree Reaper Brush Cutter is designed and manufactured with safety in mind. However, improper use and operator error can result in death or serious injury. It is important that you read and fully understand the safety instructions and operating procedures presented in this manual before operating this cutter. Accident prevention is a combination of good judgement, common sense, awareness and proper training!



BEFORE YOU OPERATE THIS BRUSH CUTTER:

1. KNOW how to safely operate your skid steer loader.
2. READ and UNDERSTAND the safety instructions and operating procedures contained in this manual.
3. ACKNOWLEDGE your understanding of all safety instructions presented in this manual by signing the “Safety Acknowledgement Form” at the end of this manual.

Although every effort has been made to ensure a safe product, every possible circumstance that could pose a potential hazard cannot be anticipated. The safety warnings in this manual and on this product, are therefore not all-inclusive.


In addition to the safety messages presented in this section, you must also read and understand the safety messages presented in the other sections of this manual.

2.2 SAFETY ALERT SYMBOLS




This is the safety alert symbol and will be accompanied with a descriptive pictorial. 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. Hazards are identified by the “Safety Alert Symbol” and followed by a signal word such as “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 that equipment or property damage can result if instructions are not followed.

SAFETY INSTRUCTIONS
Safety instructions (or equivalent) signs indicate specific safety-related instructions or procedures.

Note: Contains additional information important to a procedure.

2.3 SAFETY PICTOGRAMS

Pictograms are graphic symbols meant to alert you of a potential hazard. Read and understand the hazard description for each of these symbols.

	PINCH HAZARD: Keep clear of skid steer and brush cutter machine to prevent death or serious injury from pinching of moving parts.
	FLYING DEBRIS HAZARD: ONLY operate this machine using a skid steer that has a shatter proof cab to prevent death or serious injury from objects being thrown.
	OPERATING MANUAL: Operators must read and understand the safety instructions in the operating manual to prevent death or serious injury.
	EYE PROTECTION & CARDBOARD: Operators and maintenance personnel must wear proper eye protection and use cardboard or wood to investigate hydraulic leaks to prevent death or serious injury from being injected with high pressure hydraulic fluid.
	HIGH PRESSURE FLUID INJECTION HAZARD: Operators and maintenance personnel must not place fingers or hands directly over a hydraulic leak to prevent death or serious injury from being injected with high pressure hydraulic fluid.
	NO BYSTANDERS: DO NOT operate this machine near bystanders. Bystanders must stay back at least 300 feet from the machine to prevent death or injury from objects being thrown.
	CRUSH HAZARD: DO NOT place any part of the body under the machine or skid steer arms to prevent death or serious injury from being crushed.
	SAFETY CHAIN: Must be installed to prevent the mower deck from being raised more than 2 feet from ground level.

2.4 GENERAL SAFETY INSTRUCTIONS


Below are general safety instructions that relate to the overall operation and maintenance of this machine. It is important that you read and understand each message to prevent serious injury or death.





	ALWAYS watch for overhead power lines.		INSTALL this brush cutter on a skid steer loader equipped with a thermoplastic polycarbonate door panel and side panels only.
	DO NOT place hands or feet under mower deck while blades are spinning.		PREVENT the skid steer loader and implement from rolling forward, by stopping the engine and setting the parking brake when exiting the skid steer loader.
	NEVER operate this brush cutter when bystanders are within 300 feet of your work area. Flying debris could cause serious injury or death.		MISSING OR DAMAGED HARDWARE Replace missing or damaged hardware prior to using this machine.
	NEVER position your body or limbs under an unsupported cutter deck.		DO NOT allow children to play on or around this equipment at any time. Store this implement in an area not frequented by children.
	DO NOT allow this machine to contact buildings, utilities, large rocks or tree stumps or you may lose control of the skid steer loader.		ALWAYS wear the proper personal protection equipment while operating or servicing this machine.
	DO NOT allow riders on the skid steer loader or on this attachment.		NEVER operate or service this machine with bare feet, sandals, or other light footwear.
	NEVER use drugs or alcoholic beverages while operating or servicing this machine.		ALWAYS use eye protection while operating or servicing this machine.
	ALWAYS operate this attachment during daylight or well-lit areas.		DO NOT speed! Keep your driving speed between 2 and 5 mph.
	ALWAYS wear work gloves when handling cutter blades as they are often very sharp.		DO NOT operate this machine during lightning or severe weather conditions.

SAFETY SIGNS AND LABELS

3.1 SAFETY DECALS

The safety decals affixed to this machine are in place to keep you safe. DO NOT ignore these decals. Read and understand each decal's safety message. The following safety decals are affixed to this machine:

1.  **SCAN TO VIEW OWNER'S MANUALS**
2.

⚠ DANGER	THROWN OBJECTS HAZARD Bystanders must stay back 300 feet from machine while blades are rotating.	 Brush cutters can fling rocks, debris and other objects at high speeds over great distances, which could result in death or serious injury to bystanders.  Safety chain must be installed before operating.
⚠ WARNING	HIGH PRESSURE FLUID HAZARD Escaping hydraulic fluid under pressure will penetrate body tissue causing serious injury or death. Seek immediate medical care with this type of injury.	 Check that all hoses and fittings are tight before applying pressure.  Relieve pressure before servicing or removing hoses.  DO NOT use your bare hand when checking for leaks. Always use cardboard.  Wear proper eye protection when checking for leaks or when servicing the hydraulic system.
	FALLING OBJECT HAZARD To prevent serious injury or death, ensure attachment is securely connected to the skid steer loader before raising the loader arms.	 This attachment must be properly connected and secured to the skid steer loader per OEM instructions.
	READ OWNER'S MANUAL Failure to follow operating instructions could result in serious injury or death.	 Read and understand the owner's manual before operating or servicing this machine.
3.

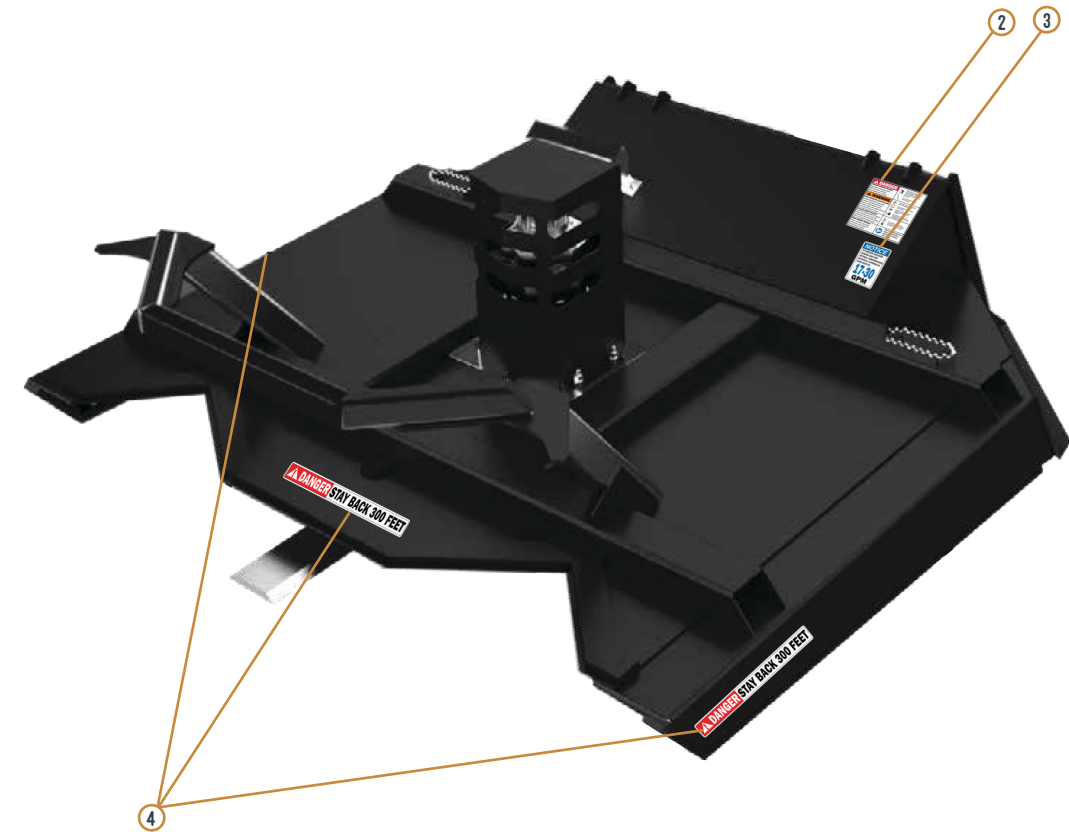
NOTICE
TO PREVENT MACHINE DAMAGE AND FOR OPTIMAL PERFORMANCE, MAINTAIN A HYDRAULIC FLOW RATE OF:
17-30
GPM
4.

⚠ DANGER	STAY BACK 300 FEET
-----------------	---------------------------

⚠ SAFETY INSTRUCTIONS

- Decals must be kept clean and legible at all times.
- Operators must inspect the machine for safety decals.
- Replace missing, worn or damaged decals immediately.
- Use care when cleaning the machine. When using a hot pressure washer make sure water jet is not too close to the decal as this may cause the decal to peel.
- When replacing parts, be sure safety decals are in place prior to using the machine.
- Make sure metal surface is dry and free of dirt and grease before applying a new decal to this machine.
- Contact your local dealer to order replacement decals.

3.2 SAFETY SIGN LOCATIONS

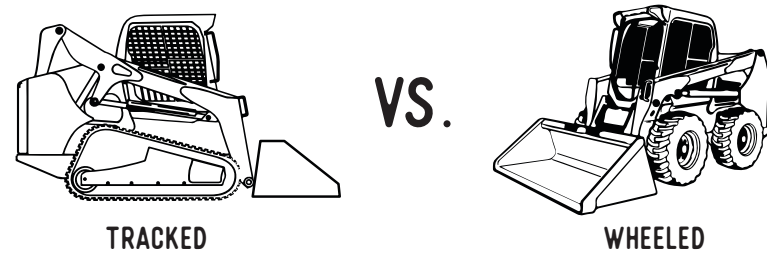


ITEM	TYPE	DESCRIPTION	QTY.
1	INSTRUCTIONAL	Scan to View Owner's Manual (not shown)	1
2	DANGER	Danger Combo Label	1
3	DANGER	Auxiliary Hydraulic Flow Not to Exceed Notice Label Note: When ordering, choose the proper decal for your model.	1
4	DANGER	Stay Back 300 Feet Warning Label	3

3.3 SKID STEER LOADER REQUIREMENTS

NOTICE

A skid steer equipped with tracks (COMPACT TRACK LOADER) will provide superior stability in this application.



WARNING

Ensure your skid steer loader is in good operating condition. The brush cutter should only be used on skid steer loaders that meet the following requirements:

REQUIREMENTS

Impact Resistant Cab Enclosure

Follow the operating instructions in your skid steer operator's manual.

PERSONAL PROTECTIVE EQUIPMENT (PPE) REQUIREMENTS



All operators should wear hearing protection, safety glasses, hand protection and dust mask while operating this machine.

OPERATING PROCEDURES

4.1 UNPACKING YOUR BRUSH CUTTER

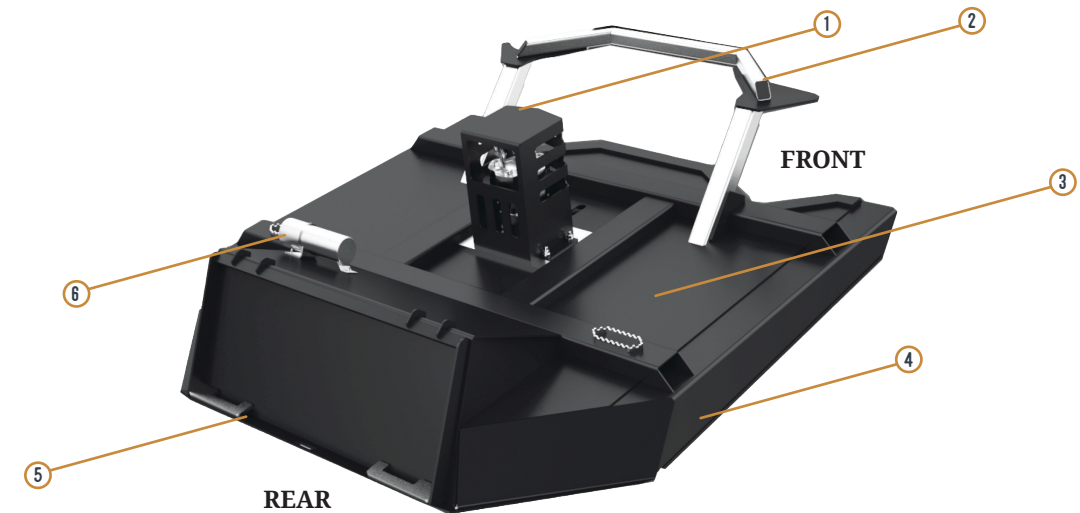
Your attachment arrives from the factory strapped to a wood pallet, and requires no final assembly. Use a pair of tin snips to remove the steel strapping.



CAUTION

Shipping straps are under great tension, and could lash out uncontrollably when cut causing injuries to your body or bystanders. Wear safety glasses and gloves while removing the steel straps.

4.2 NOMENCLATURE



ITEM	DESCRIPTION
1	Motor Cover
2	Push Bar
3	Deck Weldment
4	Wear Skid
5	Universal Skid Steer Attachment Bracket
6	Manual Holder

Note: Model shown above without front grill.

4.3 HOW TO MOUNT BRUSH CUTTER

Refer to your skid steer operator's manual for specific instructions on how to mount and dismount your attachment.

GENERAL ATTACHMENT METHOD

1. Enter operator's cab and start skid steer loader.
2. Tilt the skid steer loader quick attach coupler slightly down and drive forward to the rear of the cutter until the top edge of the quick attach coupler connects into the attachment bracket (Figure 4.2a).
3. Slightly tilt the skid steer quick attach coupler up until the coupler and attachment bracket fully engage (Figure 4.2b).
4. Activate the coupler pin mechanism to lock the pins into the attachment bracket. If your skid steer does not have this mechanism, shut skid steer engine off and exit the cab.
5. Push the skid steer quick attach locking levers down until you can see the coupler pins extend into the slots on the attachment bracket.



WARNING

To avoid serious injury or death, ensure coupler pins fully extend through the slots on the attachment bracket and that levers are down in the locked position to prevent cutter from detaching from prime mover.

NOTICE

To keep contaminants from entering the hydraulic system, use a clean cloth to wipe away dirt and grease from the hydraulic couplers.

6. Connect hydraulic hoses and the case drain hose to the auxiliary supply couplers located on your skid steer loader lift arm.



WARNING

To avoid serious injury or death from flying objects, install safety chain to limit the height of the brush cutter.

7. Install the safety chain so the cutter deck is below eye level of the operator while seated in the operator's seat. You should not be able to see the blades while seated in the operator's seat (Figure 4.2c).

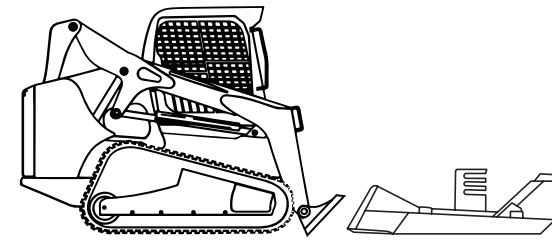


Figure 4.2a Cutter Mounting

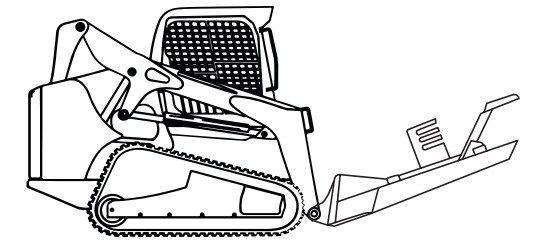


Figure 4.2b Coupler to Bracket

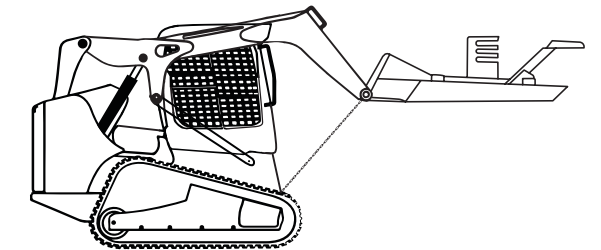
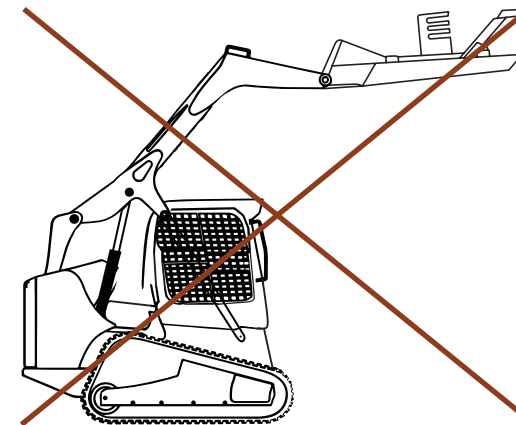


Figure 4.2c - Safety Chain

4.4 DISMOUNTING BRUSH CUTTER

1. Turn off auxiliary hydraulic circuit; relieve hydraulic pressure.
2. Park skid steer on a flat and level surface then lower brush cutter to the ground.
3. Set parking brake and disengage lock pins using the lock lever switch (if installed).
4. Turn off skid steer engine.
5. Disconnect hydraulic hoses.
6. Pull latch handles to disengage lock pins.
7. Re-enter cab and start skid steer engine.
8. Tilt mounting coupler forward until mounting bracket is free from mounting plate.
9. Drive skid steer backward to clear cutter.

4.5 HOW TO START AND STOP YOUR BRUSH CUTTER

X-TREME TREE REAPER BRUSH CUTTER CONTROLS

Your brush cutter is designed to run off the skid steer loader's auxiliary hydraulic system, and is activated and deactivated by a control in the operator's cab. The height and tilt functions of your brush cutter are operated with the control handles or pedals in the cab. Consult your skid steer operator's manual for instructions regarding these functions.

HYDRAULIC FLOW REQUIREMENTS

When operating the cutter, set the skid steer engine RPM to a speed that will produce the required flow. Your skid steer dealer can measure the flow available on your machine and recommend a throttle setting that is compatible with this attachment.

NOTICE

DO NOT exceed the designed flow rate (GPM) of your brush cutter. Place a check mark in the box next to your cutter model:

TRBC1626 = 16–26 GPM

TRBC1727 = 17–27 GPM

STARTING THE BRUSH CUTTER



WARNING

To avoid serious injury or death from thrown objects and flying debris, ensure no bystanders are within 300 feet of the work area before starting this brush cutter.

01

MOUNT THE BRUSH CUTTER

Complete steps 1-7 on page 14.

SET ENGINE

Set skid steer engine RPM to slightly above idle.

02

03

ACTIVATE

Activate skid steer auxiliary hydraulic circuit.

FULL THROTTLE

Once brush cutter ramps up to speed, increase skid steer engine to full throttle. Ensure cutter is running smoothly.

04

NOTICE

If brush cutter vibrates while increasing RPM's, switch off the auxiliary hydraulic circuit and investigate the cause. Refer to the Troubleshooting Chart on page 34.

STOPPING THE BRUSH CUTTER

- 01 RAISE THE CUTTER SLIGHTLY**
and set skid steer engine RPM to idle.
- 02 SWITCH OFF**
the auxiliary hydraulic circuit.
- 03 ALLOW TIME**
for the cutter to slow down.



WARNING

After switching off the auxiliary hydraulic circuit, keep hands and feet clear of the cutter deck until blade rotation has come to a complete stop.

4.6 INITIAL USE PROCEDURE

NOTICE

Before operating brush cutter, check the hydraulic fluid level in the skid steer and add oil if necessary.

NOTICE

Make sure the case drain hose is properly attached to the prime mover's case drain connection (high flow models). Warranty may be void if attachment is run without the case drain hose connected. Excessive hydraulic pressure can blow out seals and damage the motor.

Verify that hydraulic hoses are securely locked into the skid steer hydraulic couplers before starting the brush cutter.

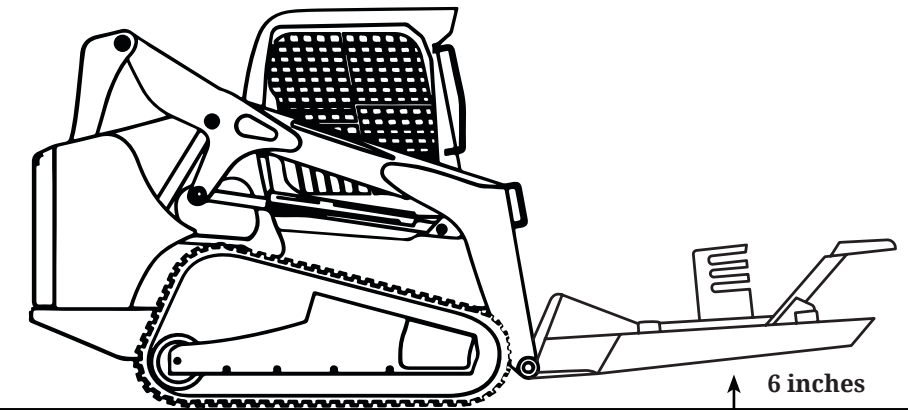


Figure 4.6: After starting skid steer, lift attachment 6 inches off the ground surface



WARNING

To avoid serious injury by hydraulic fluid injection into your skin, never use your hand or other body parts to locate a hydraulic leak. Detect leaks with a piece of wood or card board.



4.7 GENERAL OPERATING TIPS

LEARN

what the cutter head looks like in a level position when you are seated in the skid steer. Knowing what a level cutter head looks like will prevent you from damaging the cutter blades if you cut too close to the ground.

SLOW

the skid steer if the engine “bogs” down or the cutter speed is too slow because of too much load.

LISTEN AND FEEL

If you feel a strong vibration while cutting, slow the skid steer and see if the vibration stops. If not, stop the cutter, turn off the skid steer engine and investigate the cause. Refer to the “Troubleshooting Chart” on page 34.

ALWAYS

be aware of your surroundings and pay attention to obstacles and terrain in front of you.



WARNING

Cutting tree branches with the cutter in an elevated position could result in Death or Serious Injury if the skid steer becomes unstable. Always use brush cutter with the safety chain installed.

ADJUSTING CUTTER HEIGHT & LEVEL

Use the skid steer loader’s lift and tilt controls to adjust brush cutter height and level. Refer to your skid steer operator’s manual for instructions on these controls.



WARNING

To avoid serious injury or death from flying branches and debris, install safety chain to limit the height of the brush cutter.

NOTICE

When cutting dense or heavy material, adjust the level of the cutter deck so the front of the cutter is 1 inch lower than the back of the cutter. This will prevent material from “balling”.

4.7 GENERAL OPERATING TIPS CONT.



CAUTION

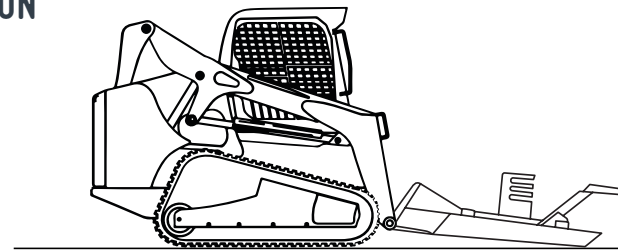
Use care when operating on uneven terrain or any type of sloped surface. Keep your cutter low to the ground when working in these conditions to avoid a roll over that could result in Minor or Serious Injury.

BEFORE CUTTING

1. Always inspect work area before starting the cutter. Locate and mark any utilities, steel posts, rocks or any other objects that could damage the brush cutter during operation. NEVER assume the work area is safe.
2. Operate the skid steer loader at a safe speed that will allow you to watch the area ahead of the cutter & loader.
3. Ensure skid steer engine RPMs are sufficient to deliver the required hydraulic flow to the brush cutter.

CUTTING GROUND LEVEL VEGETATION

Raise the rear of the brush cutter approximately 4 inches above ground level. The deck should be slightly sloping downward away from the operator.

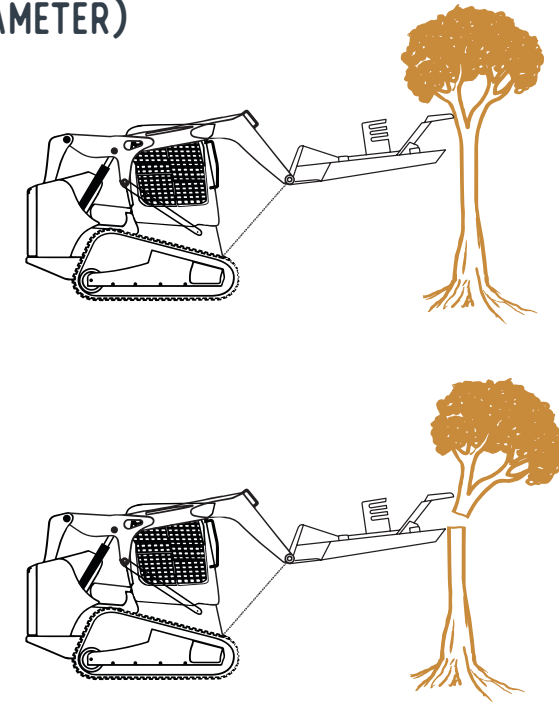


CAUTION

When cutting trees beware of the direction of fall to avoid the tree from crashing on to your skid steer loader.

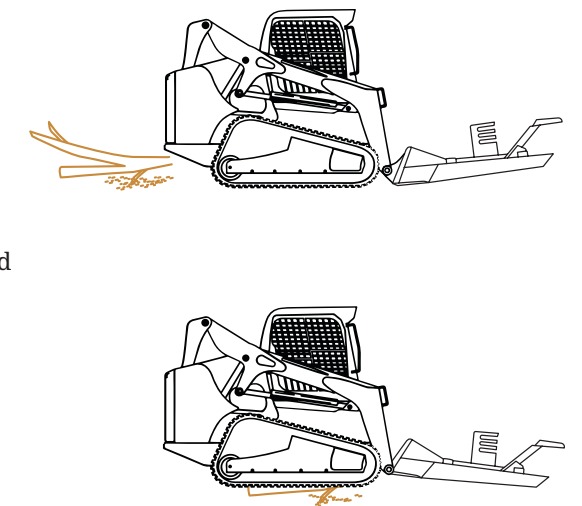
CUTTING SMALL TREES (UP TO 7" DIAMETER)

1. Tilt the front of the deck 1 to 2 feet above horizontal. Note: Safety chain will limit height of the cutter deck.
2. Slowly drive into the tree to allow the push bar to bend the tree while cutting.
3. Lower the skid steer arms and repeat step #2 until tree is cut to desired height.



Note: The optional mulching teeth teeth should be installed to achieve the best cutting results.

4. With the tree branches on the ground, tilt the front of the cutter deck up and drive forward of the branches.
5. Tilt the front of the cutter deck down and back drag the cutter over the branches.
6. Repeat steps #4 and #5 as necessary.



Note: The X-treme Tree Reaper Brush Cutter is designed to cut trees up to 7 inches thick. Use the push bar to push tree while cutting.

MAINTENANCE PROCEDURES

5.1 MAINTENANCE OVERVIEW

The maintenance procedures described in this manual should only be carried out by qualified mechanics who have been trained to repair this machine.

Some procedures require special tools and skills to complete. DO NOT attempt to repair or perform service work on this machine unless you have the skills and tools to do so. Contact your local dealer for maintenance and repair services.

WELDING REPAIRS

Contact your dealer before performing any type of welding repair to this cutter, as this may void warranty.

All authorized welding repairs must be performed by qualified welders in accordance to the American Welding Society (AWS) standards. Welding procedures performed by unqualified welders may deem this cutter unsafe to operate.

PARTS

Only use genuine IronCraft OEM replacement parts on this machine. IronCraft will not be liable for any damages or injuries caused by the use of after market parts on this machine.

SAFETY INSTRUCTIONS

Obey the following safety instructions when servicing or repairing this machine.



WEAR

proper Personal Protective Equipment (PPE) while working on this machine, which may include safety glasses, hard hats, steel toe boots, gloves, etc.



WEAR

a welding helmet when welding to protect your eyes, face and neck from flash burn, ultra-violet radiation and heat.



ENSURE

all jack stands, lifts and hoists are in good working condition and have the rated load capacity to support the load.



SERVICE

If servicing is performed while the brush cutter is attached to the skid steer, turn engine off, set parking brake and chock wheels to prevent skid steer from moving.



ONLY

perform service work in a well-lit area.



ALLOW

the machine to cool down before servicing this machine. Hot oils can burn your skin.



NEVER

work under an unsupported cutter deck.

NOTICE

Improper maintenance or modifications to the design or performance of this machine will void the warranty.

5.2 MAINTENANCE SCHEDULE

The IronCraft brush cutter attachment will provide years of dependable service if routine maintenance procedures are performed. The maintenance tasks listed below are based on normal operating conditions. More frequent maintenance may be necessary with intense use or when operating in adverse environmental conditions.

MAINTENANCE TASK	BEFORE EACH USE	WEEKLY	YEARLY
Check skid steer loader hydraulic fluid level. Add fluid as necessary.	✓		
Check that all fasteners (nuts, bolts, washers, pins, keepers) are in place. Tighten as necessary, and replace damaged and missing fasteners	✓		
Inspect and replace any worn, torn, or missing safety decals.	✓		
Inspect hydraulic plumbing (hoses and connectors) for damage or leakage. Repair or replace hydraulic items as necessary.	✓		
Check condition of cutter blades. Sharpen or replace as necessary.	✓	✓	✓
Check oil level in bearing housing. Add fluid as necessary.		✓	
Change oil in bearing housing after 50 hours of first time use, then every 1,000 hours or yearly.			✓
Wash brush cutter.		✓	
Check cutter for major scratches and dings. Sand and repaint these areas to prevent rust damage. Use a paint formulated for farm equipment which can be found at your local hardware store.			✓

MAINTENANCE LOG

Document all maintenance and service activities performed on this brush cutter using the maintenance log included at the end of this manual.

5.3 STORAGE TIPS

To get years of quality use out of your brush cutter, follow these tips when storing your brush cutter:



THOROUGHLY WASH

then dry your brush cutter. Ensure brush cutter is free of debris, dirt, grime and grease.



STORE

your brush cutter in a dry area such as in a shed or garage.



COVER

your brush cutter with a waterproof tarp if storing outside.

5.4 BLADE ASSEMBLY MAINTENANCE PROCEDURES

BOLT TORQUE REQUIREMENTS

- Apply and maintain proper torque on all bolts.
- Torque values are based on dry conditions. Do not grease or oil bolts.
- Wipe bolts clean and apply Loctite Green 290 before tightening bolts.
- Use a torque wrench to assure the proper amount of torque is being applied to the bolt.



420 FT-LBS	Torque Value - Blade Holder Bolts (3/4 x 2-3/4 Inch UNF)
110 FT-LBS	Torque Value - Blade Bolts (1/2 - 13 UNC 2 - 1/4 Inch HEX)

Note:

1. Follow the directions as shown on the product.
2. When removing bolts it may be necessary to apply localized heat of at least 250 deg C to the nut or bolt.

TOOLS & EQUIPMENT REQUIREMENTS

To complete the maintenance procedures described in this section, you may need the following tools:

- 1/2 inch drive breaker bar
- 3/4 inch impact socket
- 1/2 inch impact socket
- Tapping hammer
- 1/2 inch drive torque wrench
- Nylon prybar set
- Lifting device (overhead crane hoist, forklift)
- Safety stands
- Chocks for skid loader (when performing services to cutter that is attached to skid loader)



WARNING

To avoid serious injury or death only use jacks, hoists, lifts and tools that have the capacity for the job. Use certified safety stands rated to support the applicable load.



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



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. are tight. Check all hoses and lines to make sure they are in good position before applying pressure to the system.

5.5 BLADE HOLDER REMOVAL

REMOVAL PROCEDURE – BRUSH CUTTER ATTACHED TO SKID STEER

1. Raise the skid steer arms and install skid steer lift arm lock.



DANGER

To prevent a crushing death by the skid steer arms, a lift arm lock must be installed on the skid steer hydraulic piston by a second person before the operator can exit the skid steer cab. Refer to your skid steer operator's manual for lift arm lock installation procedures.

2. Shut off hydraulic flow to the brush cutter, and release pressure from the auxiliary hydraulic circuit.
3. TURN OFF skid steer engine, SET parking brake, and CHOCK skid steer tracks/tires to prevent skid steer from moving.
4. Secure the front end of the cutter deck by using an overhead hoist and chain.
5. Support the blade holder with a hoist, lift table or fork lift so the blade holder doesn't fall during removal.
6. Remove the six 3/4 inch diameter hex bolts that secure the holder to the gearbox shaft and let the blade holder rest onto the lift. If the blade holder fails to separate, use a wedge breaker tool to help separate the blade holder from the gearbox flange.

5.6 BLADE HOLDER INSTALLATION

INSTALLATION PROCEDURE



WARNING

To avoid serious injury or death from being crushed, use a lifting device that is rated to support the blade holder during installation.

1. Align the bolt holes in the blade holder with the bolt holes on the gearbox flange.
2. The blade holder must be seated flat against the gearbox flange before proceeding to the next step.
3. Install the six 3/4 inch diameter grade 8 hex bolts and torque to 420 ft-lbs.

5.6 BLADE REMOVAL



CAUTION

Cutter blades are sharp and could cut you if mishandled. ALWAYS wear protective gloves and footwear when handling cutter blades.

BLADE REMOVAL PROCEDURE – BRUSH CUTTER ON THE GROUND

With the brush cutter on the ground:

1. Ensure the hydraulic hoses are disconnected from the skid steer couplers.
2. Rotate the blade holder until the 1/2" blade holder nuts are visible in the access opening.
3. Remove the hex nuts, washers and bolts.
4. Carefully pull the blade from the holder.
5. Remove the 2" bushing.
6. Remove the 1/2" bolts and remove the blade.
7. Repeat step #2 and #3 for the remaining blades.
8. Loosen the capscrews by rotating the blade carrier until the capscrews are visible in the top access opening.
9. After all four blade carrier capscrews are loosened, position one of the blades in the access opening and remove the three capscrews securing the blade to the blade carrier. Remove blade.

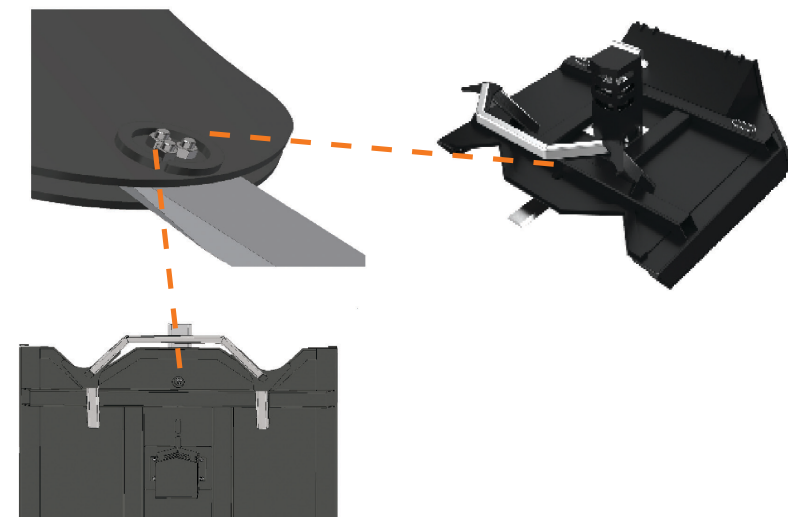


Figure 5.6 Blade Holder Access Opening

5.7 BLADE SHARPENING AND REPLACEMENT NOTES

- When sharpening the blades, be careful not to overheat the blade steel causing the blade material to become brittle and prone to early failure.
- Grind each blade to the similar shape and size so as to not create a set of mismatched blades. Mismatched blades will cause vibration
- ALWAYS sharpen or replace cutter blades as set.
- NEVER mix and match used blades with new blades as they will cause the brush cutter to be unbalanced and result in a vibration that may cause damage to other brush cutter parts.
- Install blades in the same orientation they were in when removed.
- Opposing blades must be installed in the same orientation.
- Flip all blades at the same time if you wish to use the blades opposing edges.

NOTICE

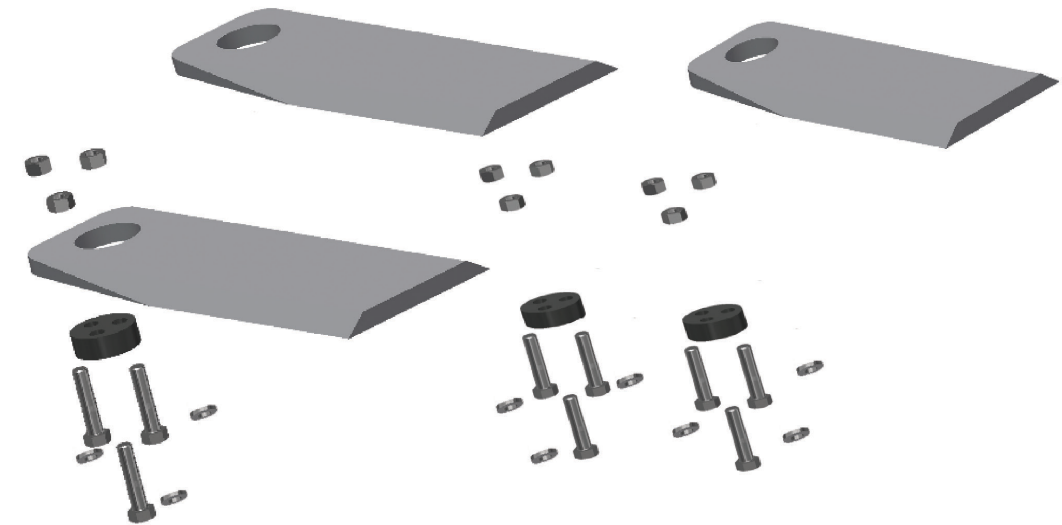
Blades must be installed as a set to ensure proper balance of the blade holder. Improper balance will cause vibrations that could result in component failure.

5.8 BLADE INSTALLATION

BLADE INSTALLATION PROCEDURE – BRUSH CUTTER ON THE GROUND

1. Insert blade bushing into the blade.
2. Place blade and bushing into position on the blade holder.
3. Install the three blade bolts and blade nuts. Note: Blade bolts are installed from the bottom up, with the blade nuts visible in the deck access opening
4. Repeat steps #1 thru #3 for the remaining blades.
5. Torque bolts to 110 ft-lbs.crews by rotating the blade carrier until the capscrews are visible in the top access opening.

Note: Replacement blades are sold as a set and come pre-balanced from the factory.



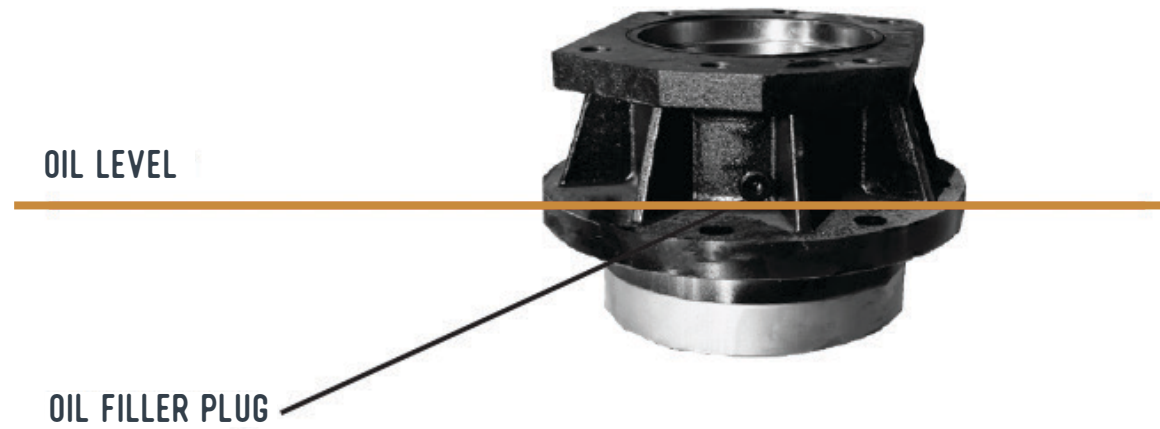
5.9 BC-65 DRIVE BEARING HOUSING MAINTENANCE

NOTICE

Maintenance procedures for the drive bearing housing require special tools and skills. DO NOT attempt to service drive bearings or gear boxes unless you have the tools and skills to do so.

CHECKING FLUID LEVEL

1. Check the oil level weekly. Refill with 85W-140 5EP grade gear oil.
2. Level the top of the cutter deck.
3. Check the oil level by removing the oil filler plug. The oil level should be to the bottom of the oil filler plug.



NOTICE

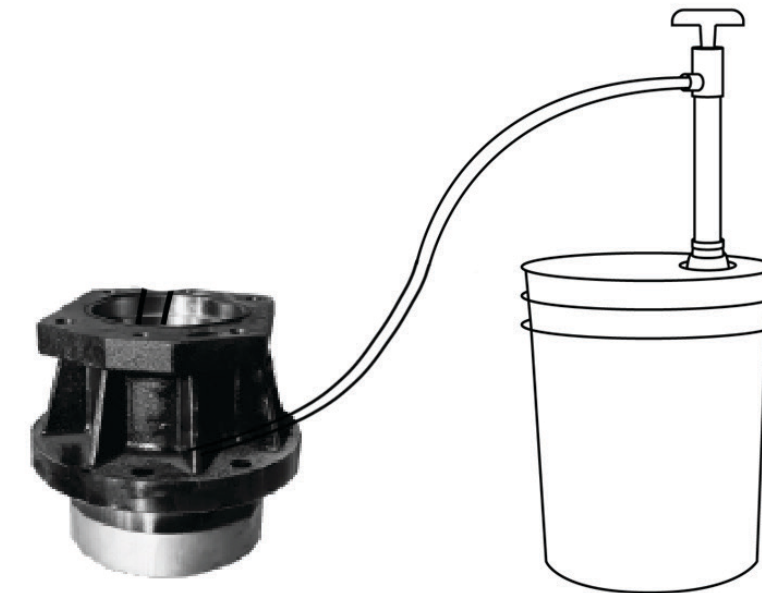
The initial oil should be changed after 50 hours of operation under load. Subsequent oil changes should take place after every 1000 hours of operation. More frequent oil changes may be necessary if operating this cutter in extreme hot conditions.

BC-65 OIL CHANGE PROCEDURE

1. Remove oil filler plug and insert one end of a discharge hose into the oil filler port and the other end into an approved waste oil container.
2. Using a fluid removal pump, remove the old oil from the gear box unit.
3. Refill with 85W-140 5EP grade gear oil until fluid level is up to the bottom of the oil filler port. Make sure the deck is level when filling the gear oil.
4. Reinstall oil filler plug.

NOTICE

Properly dispose of used oil. Visit www.Earth911.com to search for the nearest used oil recycling center near you.



TROUBLESHOOTING

PROBLEM	CAUSE	RESOLUTION
Cutter bogs down or loses power	Deck is not leveled properly	Refer to page 21 for leveling information
	Foreign material is “balling” under deck	Slightly tilt the deck forward and remove foreign material
	Bearing Failure - (To diagnose this cause, shutoff hydraulic flow to cutter then slowly rotate the blade holder assembly and listen for bearing noise)	See dealer for bearing housing service; replace Bearing Housing
	Cutter speed too slow or ground speed too fast	Increase engine RPMs and reduce ground speed
	Oil flow too slow	Look for hydraulic leaks, and repair Repair or replace bearing housing
Excessive Vibration	Missing, loose, damaged or unbalanced blades	Replace blade holder
	Blade Holder Damaged Bearing Failure	Repair or replace bearing housing
Blades dull too quickly or are breaking too easily	Blades are receiving excessive shock loads from contacting solid objects (rocks, steel pipes, etc.)	Clear cutting area of solid objects, avoid solid objects, raise cutter height to clear exposed rock surfaces
Hydraulic oil level drops during operation	Hydraulic motor leak, or leaks in prime mover’s hydraulic system	Investigate and repair leaks
Blades do not rotate when flow is activated	Hydraulic motor or bearing housing failure	Contact dealer for repair service
	Hydraulic lines disconnected	Connect hydraulic lines to skid steer couplers Ensure hoses are locked in place
	Problem with skid steer hydraulic controls	Contact skid dealer for diagnosis and repair

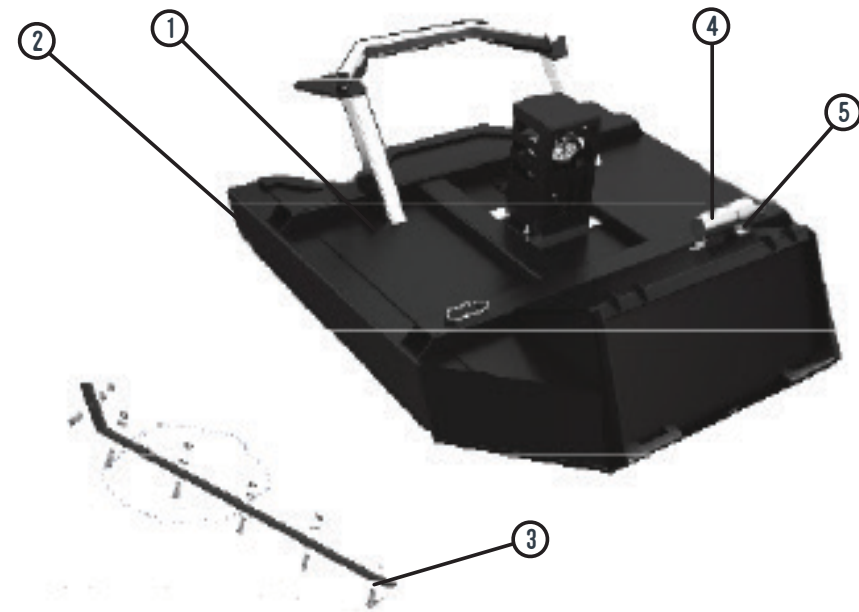
PARTS INFORMATION

Factory fresh parts specifically designed for your implement are readily available.

For hassle free service and to ensure you receive the correct parts for your implement, please provide your dealer with the following information.

MODEL	
SERIAL NUMBER	
GPM REQUIREMENTS	
DATE OF OWNERS MANUAL (Bottom Right Corner of Cover Page)	
PARTS DIAGRAM PAGE NUMBER	
PART DESCRIPTION	
REFERENCE NUMBER	
QUANTITY DESIRED	
SHIP TO INFORMATION	
BILL TO/PAYMENT INFORMATION	

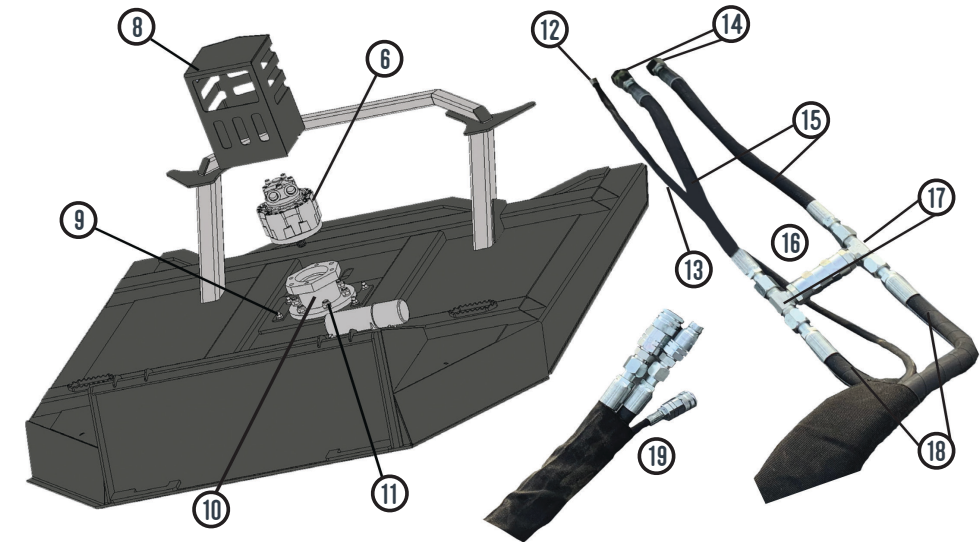
Use Genuine Parts from IronCraft.



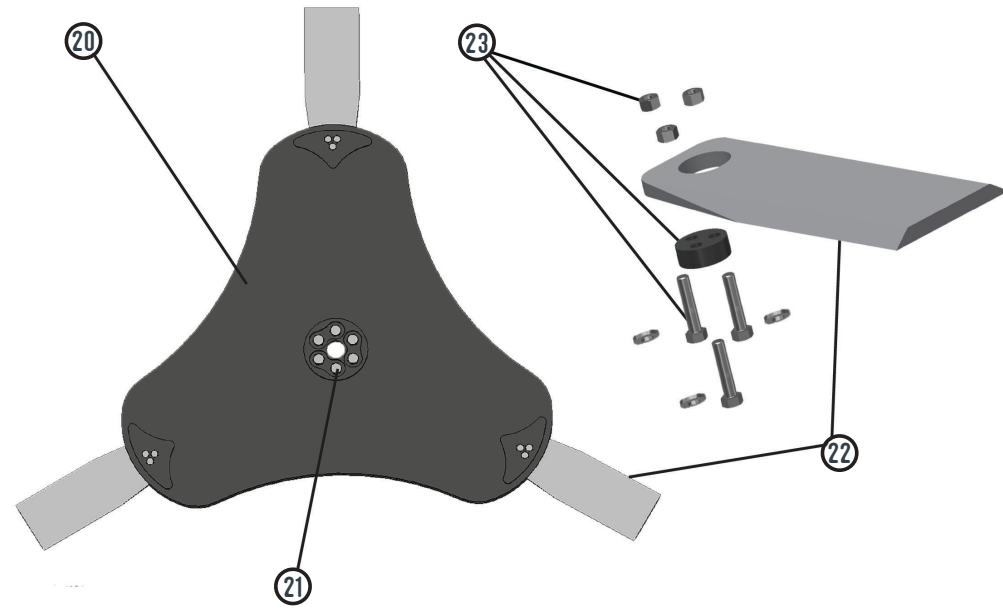
CUTTER DECK			
REF	DESCRIPTION	QTY.	PART #
0	Front Grill (Optional)		
1	Deck Weldment	1	
2	Bolt On Shoes (Wear skids)	2	CID4004 - 72" CID4005 - 78"
3	Wear Skid Hardware Set: (12) 5/8 x 1.25 Inch carriage bolts, (12) 5/8" flat washers, (12) 5/8" lock washers, (12) 5/8" Hex nuts	1	
4	Owner's Manual Document Canister	1	CID9007
5	Canister Holder Hardware Set: (3) 1/4" - 20 UNC -1" bolts, (3) 1/4" lock nuts, (3) 1/4" washers	1	



The front grill provides additional durability and gives a more aggressive look.

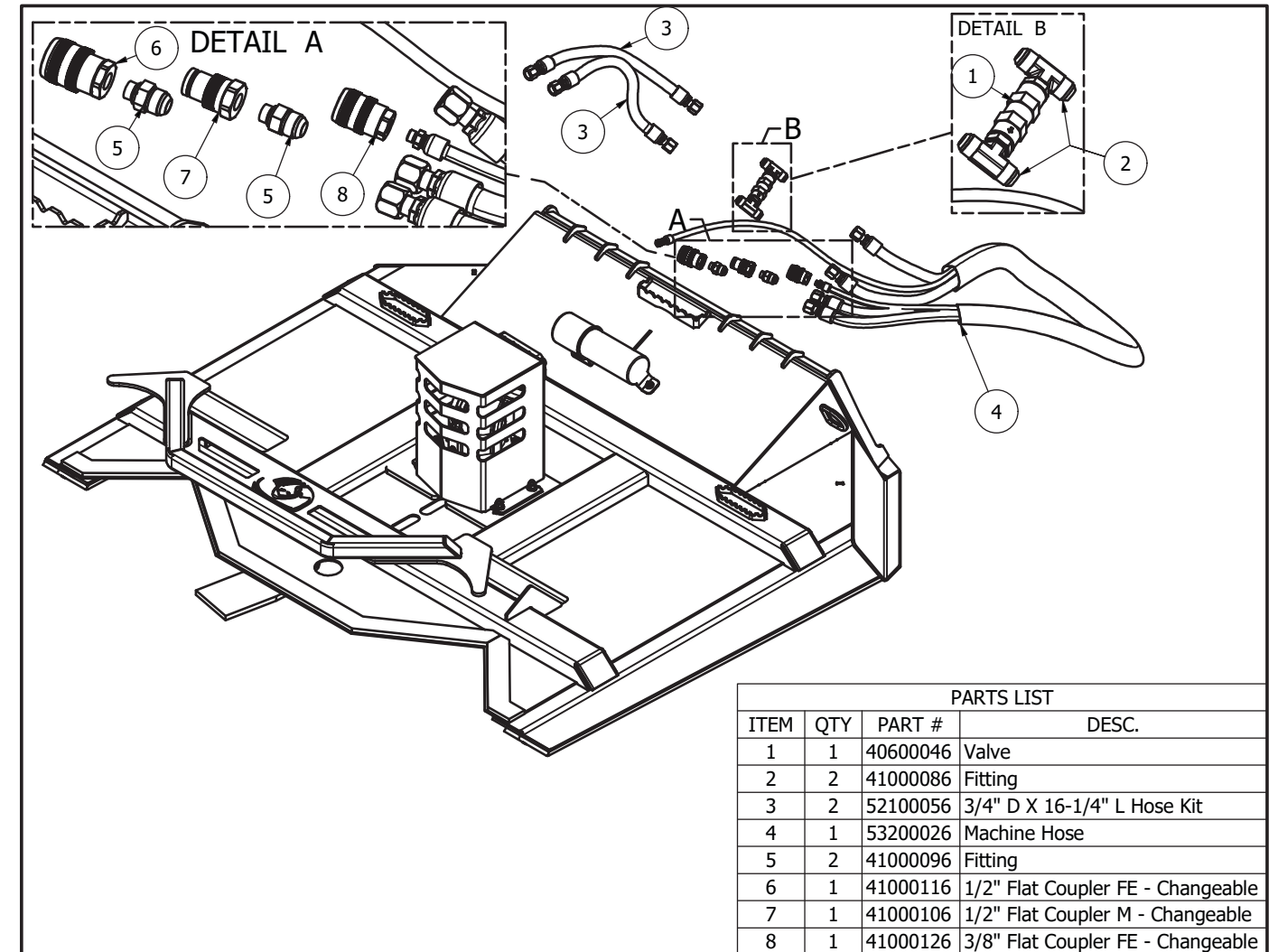


MOTOR AND HYDRAULICS			
REF	DESCRIPTION	QTY.	PART #
6	Motor (Radial Piston Motor)	1	CID3001
NOT SHOWN	Motor Box Hardware Set: (4) SHC M14-2-65 bolts, (4) M14 Nuts, (8) M14 Lock Washers	1	-
8	Motor Cover	1	CID4007
9	Motor Cover Hardware Set: (4) Hex bolts 1/2 -13 UNC 1.5 Inch, (4) 1/2" Hex nuts, (4) 1/2" flat washers	1	-
10	Gearbox (BC65)	1	CID3098
11	Gearbox Hardware Set: (6) SHC 3/4 10 UNC - 2.75 bolts, (6) 3/4" hex nuts, (6) 3/4" split washers, (6) 3/4" flat washers	1	-
12	JIC Adapter (motor to case drain hose)	2	HY1068
13	Case drain hose	1	CID1009
14	JIC Adapter (motor to hose)	2	HY1007
15	Hose (Motor to H-Valve assembly)	2	CID1117
16	H-Valve assembly (one way check with tees) 3/4"	1	CID3047
17	Tees	2	HY1105
18	Hose (H-Valve assembly to main quick disconnect) 3/4"	2	CID1010
19	Main quick disconnect set 3/4"	1	CID8004



BLADE HOLDER AND BLADES			
REF	DESCRIPTION	QTY.	PART #
20	Blade Holder Assembly: 3 Blade Clover Leaf	1	CID1300
21	Blade Holder Hardware Set: [(6) 3/4" x 2-3/4 UNF blade holder bolts, (6) 3/4" flat washers]	6	-
22	Blades (double beveled)	3	CID8038
23	Blade Hardware Set: [(9) 1/2" - 13 UNC- Grade 9 2.25 Hex bolts, (3) 2" bushings, (9) 1/2" Hex nuts, (9) 1/2" Lock Washers]	1	-
NOT SHOWN	Cutting teeth (5/8") Optional	12	CID8000
NOT SHOWN	Cutting teeth nuts (5/8") Optional	12	CID8000

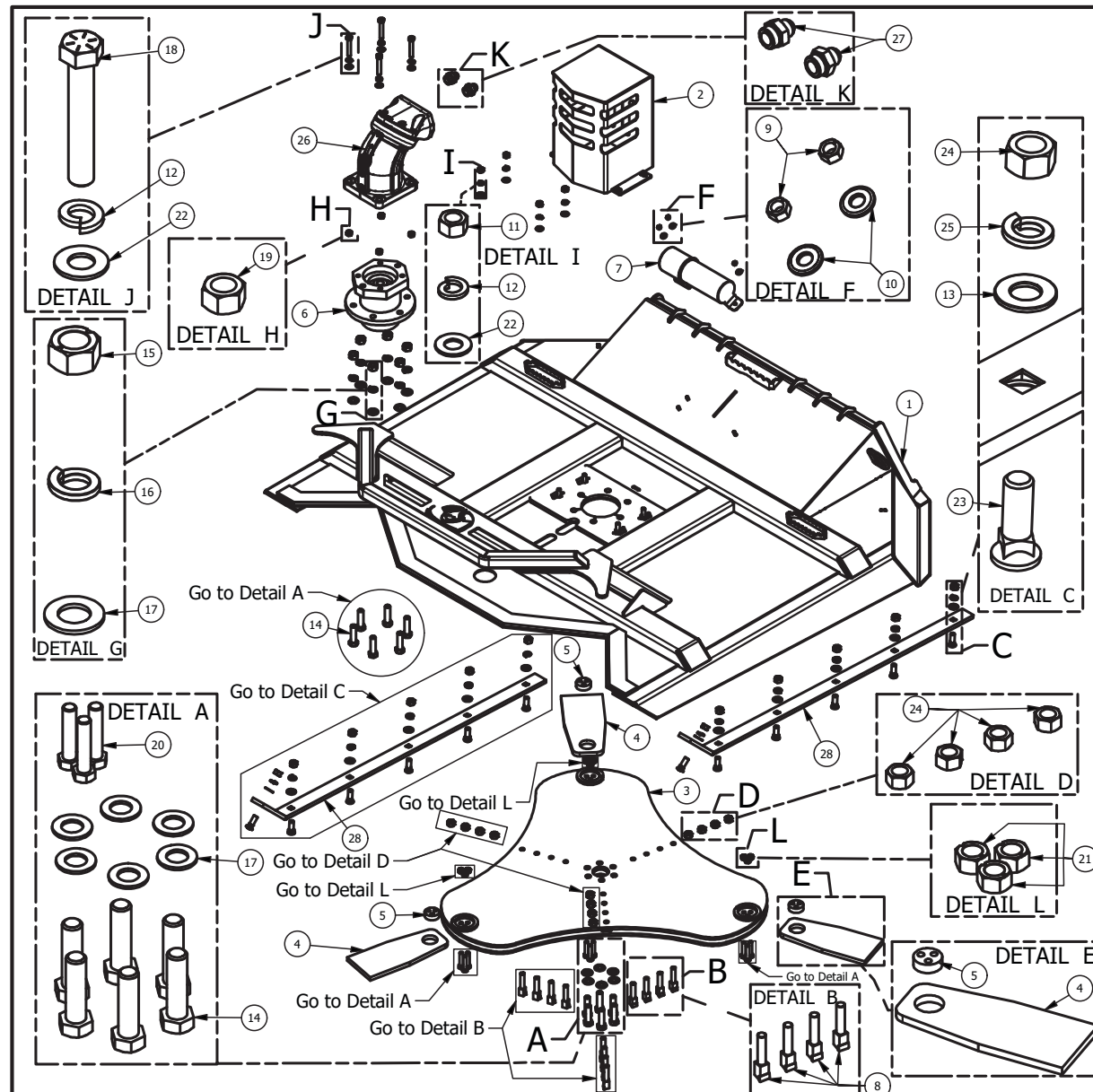
PARTS LIST



PARTS LIST			
ITEM	QTY	PART #	DESC.
1	1	40600046	Valve
2	2	41000086	Fitting
3	2	52100056	3/4" D X 16-1/4" L Hose Kit
4	1	53200026	Machine Hose
5	2	41000096	Fitting
6	1	41000116	1/2" Flat Coupler FE - Changeable
7	1	41000106	1/2" Flat Coupler M - Changeable
8	1	41000126	3/8" Flat Coupler FE - Changeable

PART	QTY/ PARENT	REL OPR DESC	DESC
31CNST0Z	3	Assembly - Side 1	5/16-18 STOVER LOCKNUT GR C ZNC
31NWUS8Y	3	Assembly - Side 1	5/16 USS FLAT WASHER GR 8 Z/YEL
50C300HCS8Y	4	Assembly - Side 1	1/2-13 X 3 HEX C/S GR 8 Z/YEL
50CNFH0Z	4	Assembly - Side 1	1/2-13 HEX FIN NUT ZNC
50CNFH8Y	4	Assembly - Side 1	1/2-13 HEX FIN NUT GR 8 Z/YEL
50F225HCS9Y	9	Assembly - Side 1	1/2-20 X 2 1/4 HEX C/S L-9 Z/YEL
50FNST0Z	9	Assembly - Side 1	1/2-20 STOVER LOCKNUT GR C ZNC
50NLOC8Y	4	Assembly - Side 1	1/2 SPLIT LOCKWASHER GR 8 Z/YEL
50NLOC8Y	4	Assembly - Side 1	1/2 SPLIT LOCKWASHER GR 8 Z/YEL
50NWSA8Y	4	Assembly - Side 1	1/2 SAE F/W GR 8 Z/YEL
62C200BPL8	12	Assembly - Side 1	5/8-11 X 2 PLOW BOLT GR 8
62CNFH0Z	12	Assembly - Side 1	5/8-11 HEX FIN NUT ZNC
62CNFH0Z	12	Assembly - Side 1	5/8-11 HEX FIN NUT ZNC
62NLOC8Y	12	Assembly - Side 1	5/8 SPLIT LOCKWASHER GR 8 Z/YEL
62NWSA8Y	12	Assembly - Side 1	5/8 SAE F/W GR 8 Z/YELLOW
75C275HCS8Y	6	Assembly - Side 1	3/4-10 X 2 3/4 HEX C/S GR 8 Z/YEL
75C275HCS8Y	6	Assembly - Side 1	3/4-10 X 2 3/4 HEX C/S GR 8 Z/YEL
75CNST0Z	6	Assembly - Side 1	3/4-10 STOVER LOCKNUT GR C ZNC
75NLOC8Y	6	Assembly - Side 1	3/4 SPLIT LOCKWASHER GR 8 Z/YEL
75NWSA8Y	6	Assembly - Side 1	3/4 SAE F/W GR 8 Z/YELLOW
75NWSA8Y	6	Assembly - Side 1	3/4 SAE F/W GR 8 Z/YELLOW
CID2317	9	Assembly - Side 1	85W-140 THIS IS BULK NOW (55 Gal Drum)
CID3001-P	1	Assembly - Side 1	F10-90 BENT AXIS MOTOR
CID3098	1	Assembly - Side 1	BC65-SAE-C MDH 65 EQUIV Gearbox
CID8000	12	Assembly - Side 1	3/4" square Threaded Tooth - BC Mulching
CID9011	1	Assembly - Side 1	Owners Manual Canister
HY1007	2	Assembly - Side 1	6400-12-16
SVBAPC-TRBC-WearBar-72-F	2	Assembly - Side 1	72" Severe & Reaper Brush Cutter Replaceable Wear Bar - Formed
TRBC-BladeBushing	3	Assembly - Side 1	Reaper Brush Cutter Blade Bushing
TRBC-LF-3BldMH72-Subassm- bly	1	Assembly - Side 1	TRBC-LF-3BldMH72-Subassm- bly
TRBC-Piston-17-27-1/2-F-Reg- Hose	1	Assembly - Side 1	TRBC-Piston-17-27-1/2-F-RegHose
XBC-LowflowBlade	3	Assembly - Side 1	Brush Cutter LowFlow Blade 60-72 HD/XT
XBC-PistonMotorCover-sub	1	Assembly - Side 1	17-30, 27-35 Piston Motor Cover Subassem
CID2322	5	Powder - Side 1	DARK GRAY

31C100HCS8Y	3	Welding - Side 1	5/16-18 X 1in HEX C/S GR 8 Z/YEL
50C137HCS8Y	4	Welding - Side 1	1/2-13 X 1 3/8 HEX C/S GR 8 Z/YEL
CID6500	1	Welding - Side 1	D-RING with 2 hole mounting bracket
CID-FrmdStep-F	4	Welding - Side 1	CID-FrmdStep-F
QA-Cshape-1	2	Welding - Side 1	CID QA C Shape - Single hole - side 1
QA-SolidTopCatch-1	1	Welding - Side 1	CID Solid Top Catch - side 1
SVBAPC-Channel-72-F	2	Welding - Side 1	72" Severe Brush Cutter Blade Channel - Formed
SVBAPC-FrontDeckCorner-72	2	Welding - Side 1	72" Severe Brush Cutter Front Deck Corner
SVBAPC-MiddleChannel-72-F	2	Welding - Side 1	72" Severe Brush Cutter Blade Channel Middle - Formed
SVBAPC-TRBC-CenterDeck- Brace	1	Welding - Side 1	72" & 78" Severe & Reaper Brush Cutter Center Deck Brace
SVBAPC-TRBC-DeckCorner- 72-L-F	1	Welding - Side 1	72" Severe & Reaper Brush Cutter Deck Corner - Left - Formed
SVBAPC-TRBC-DeckCorner- 72-R-F	1	Welding - Side 1	72" Severe & Reaper Brush Cutter Deck Corner - Right - Formed
SVBAPC-TRBC-PusherCap	2	Welding - Side 1	Severe & Reaper Brush Cutter Pusher Cap
SVBAPC-TRBC-PusherMiter- Cap	2	Welding - Side 1	Severe & Reaper Brush Cutter Pusher Miter Tube Cap
SVBAPC-TRBC-PusherTubeCap	2	Welding - Side 1	Severe & Reaper Brush Cutter Pusher Tube Cap
SVBAPC-TRBC-QAPlate-F	1	Welding - Side 1	Severe & Reaper Brush Cutter QA Plate - Formed
SVBAPC-TRBC-QASide	2	Welding - Side 1	Severe & Reaper Brush Cutter QA Side
SVBAPC-TRBC-QA-SideCatch	2	Welding - Side 1	Severe & Reaper Brush Cutter QA Side Catch
SVBAPC-TRBC-QA-TopCatch- Brace	6	Welding - Side 1	Severe & Reaper Brush Cutter QA Top Catch Brace
SVBAPC-TRBC-RearDeck- Brace	4	Welding - Side 1	Severe & Reaper Brush Cutter Rear Deck Brace
SVBAPC-TRBC-RearDeck-F	1	Welding - Side 1	Severe & Reaper Brush Cutter Rear Deck - Formed
SVBAPC-TRBC-SideDeckBrace	2	Welding - Side 1	72" & 78" Severe & Reaper Brush Cutter Side Deck Brace
SVBAPC-TRBC-Step-F	1	Welding - Side 1	Severe & Reaper Brush Cutter Step - Formed
TRBC-Deck-72	1	Welding - Side 1	72" Reaper Brush Cutter Deck
TRBC-DeckSide-72-L-F	1	Welding - Side 1	72" Reaper Brush Cutter Deck Side - Left - Formed
TRBC-DeckSide-72-R-F	1	Welding - Side 1	72" Reaper Brush Cutter Deck Side - Right - Formed
TRBC-Grill-F	1	Welding - Side 1	Reaper Brush Cutter Grill - Formed
TUBE-2x2x.1875-56.125-1-F	1	Welding - Side 1	2" x 2" Square Tubing 3/16" Wall - 56.125" Long - Side 1 - Tree Reaper & Severe BC - Formed
TUBE-3x3x.25-19-miter-1	2	Welding - Side 1	3x3 Square Tube 1/4 Wall - 19" - Miter on both sides - Side 1
XBC-1727-GboxPlte	1	Welding - Side 1	Xtreme Brush cutter 17-27 Gearbox plate
XBC-InsideDeckBrc	2	Welding - Side 1	X-Treme Brush Cutter Flat bar deck brace



PARTS LIST				PARTS LIST			
ITEM	QTY	PART #	DESC.	ITEM	QTY	PART #	DESC.
1	1	81400046	Deck Weldment	15	6	11200216	3/4"-10 Lock Nut GR C
2	1	80400026	Motor Cover	16	6	11200226	3/4" Split Lock Washer GR 8
3	1	50100026	Blade Holder (Mulching Teeth)	17	12	11200236	3/4" SAE Flat Washer GR 8
4	3	20100016	Blade	18	4	11200266	1/2"-13 X 3" Hex Bolt GR 8
5	3	20200046	Blade Bushing	19	4	11200276	1/2"-13 Hex FIN Nut GR 8
6	1	40200026	Gearbox	20	9	11200286	1/2"-20 X 2 1/4" Hex Bolt GR L-9
7	1	41100016	Manual Holder	21	9	11200296	1/2"-20 Lock Nut GR C
8	12	10500016	Mulching Teeth	22	8	11200306	1/2 SAE Flat washer GR 8 Z/YEL
9	3	11200106	5/16"-18 Lock Nut GR C	23	12	11200316	5/8"-11 X 2" Plow Bolt GR 8
10	3	11200256	5/16"-18 USS Flat Washer GR 8	24	24	11200326	5/8"-11 Hex FIN Nut
11	4	11200166	1/2"-13 Hex FIN Nut	25	12	11200336	5/8" Split Lock Washer GR 8
12	8	11200176	1/2" Split Lock Washer GR 8	26	1	40100026	17-27 GPM Motor
13	12	11200196	5/8 SAE Flat Washer GR 8	27	2	41000026	Motor Fitting
14	12	11200206	3/4"-10 X 2 3/4" Hex Bolt GR 8	28	2	20000016	Wear Bar

LIMITED WARRANTY

IronCraft (the Manufacturer) warrants, only to the original Purchaser, this equipment will be free from defects in material and workmanship, under normal use and service, for one (1) year from the date of purchase providing this equipment is purchased for individual use only. **Commercial use of this equipment is not covered under any warranty.** This warranty does not apply to any equipment which has been damaged or which has been subjected to change, misuse, negligence, abnormal wear and tear, alterations, tampering, or failure to follow operating instructions. This warranty does not cover any product or parts not manufactured by IronCraft.

IronCraft brush cutters have a five (5) year Limited Warranty* on gearbox components provided they have been properly maintained** and have not been subjected to abuse or misuse except as limited below.

* Gearbox warranty limitations:

- i. Warranty is one (1) year for seals unless seals are damaged from debris wrapped around the input and or output shaft of the gearbox. After one year, seals are considered to be wearing parts, and the replacement is the owner's responsibility.
- ii. Gearboxes that are subject to warranty may be replaced with new or rebuilt gearboxes at the discretion of IronCraft
- iii. Shearbolts must be approved Grade 2, 1/2" x 3" shearbolts.

**NOTE: "properly maintained" specifically includes, but is not limited to:

- i. Running gearboxes with the proper amount of correct lubricant.
- ii. Adjusting slip clutches correctly to provide proper protection for gearbox components and drive line.

Under this warranty, the Manufacturer will repair or replace any part which the Manufacturer determines has failed during the period of the warranty due to defects in material or workmanship. After written approval by the manufacturer, the equipment or defective part must be returned to IronCraft.

Warranty coverage and performance is expressly conditioned upon the return of the completed registration form to: IronCraft, 7 Rocky Mt Rd, Athens, Tennessee 37303. Registration can be found on our website www.ironcraftusa.com

IronCraft reserves the right to make improvements and changes in specifications without notice or obligation to modify previously sold units. The Owner's Manual describes the proper assembly procedures for your implement and furnishes operating and maintenance recommendations to help you obtain long and satisfactory service.

PURCHASER'S EXCLUSIVE REMEDY FOR BREACH OF WARRANTY, OTHER DEFECT, OR CONDUCT GIVING RISE TO LIABILITY SHALL BE THE REPAIR OR REPLACEMENT OF THE PRODUCT SOLD, AND THE MANUFACTURER UNDER NO CIRCUMSTANCES SHALL BE LIABLE FOR ECONOMIC LOSS OR INCIDENTAL OR CONSEQUENTIAL DAMAGES. THE MANUFACTURER DISCLAIMS ALL IMPLIED WARRANTIES, INCLUDING THE WARRANTY OF MERCHANTABILITY AND FITNESS FOR PURPOSE.

Purchaser and IronCraft hereby (a) submit to the non-exclusive jurisdiction of the courts of competent jurisdiction in Meigs County, Tennessee, and the United State District Court for the Eastern District of Tennessee for resolution of any dispute concerning this Limited Warranty or the rights or obligations of Purchaser and/or IronCraft; (b) agree that any litigation commenced in Tennessee in connection with this Limited Warranty shall be venued in either the Meigs County, Tennessee District

Court, or the United States District Court, Eastern District of Tennessee, Southern Division, and (c) waive any objection it may have as to any such action or proceeding brought in such court that such court is an inconvenient forum. Nothing herein shall limit the right of Purchaser or IronCraft (or the right of any permitted successor or assign of either) to bring proceedings against the other in the courts of any other jurisdiction wherein any assets of such other party may be located.

REGISTER

This registration form must be filled out within 30 days of delivery to the purchaser or future warranty claims will not be honored.

www.ironcraftusa.com/warranty/register-warranty/



MAKE CLAIM

This form is for dealer use only. Do not use for warranty labor or parts reimbursement.

www.ironcraftusa.com/warranty/claim-warranty/



REIMBURSEMENT

This form is for dealer use only. Apply for warranty labor or parts reimbursement here.

<https://www.ironcraftusa.com/warranty/reimbursement-form/>





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Athens, Tennessee 37303



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(F) 423-405-5904

WWW.IRONCRAFTUSA.COM



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