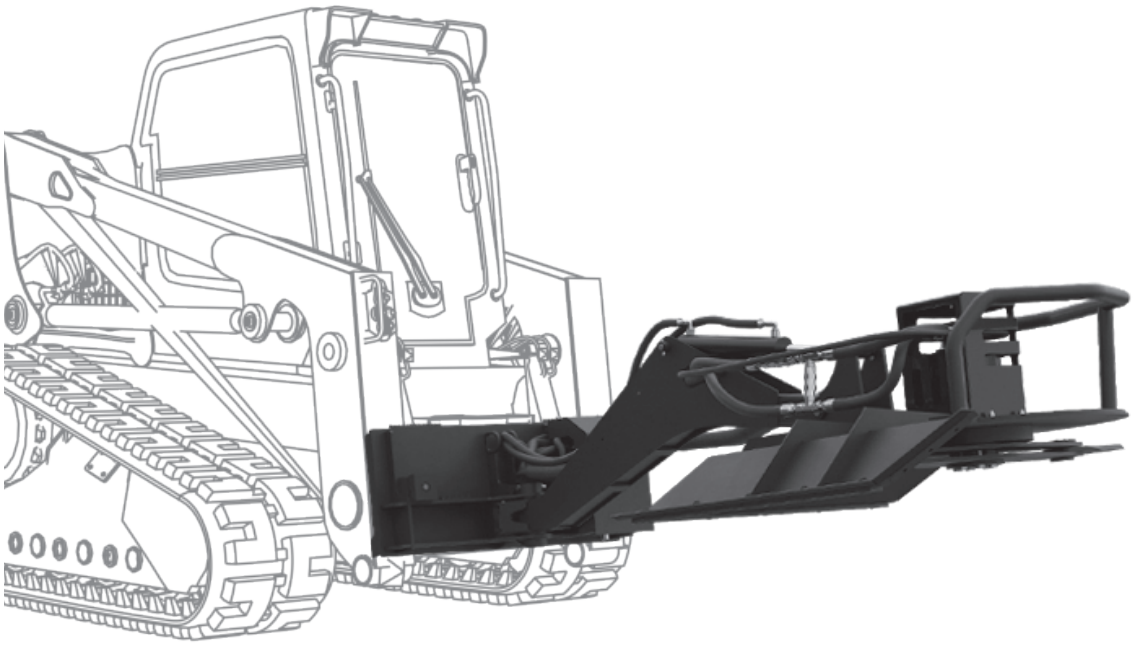
IRONCRAFT

SWING BOOM
BRUSH CUTTERS



OPERATION AND PARTS MANUAL

Read and understand the manual. This manual provides information and procedures to safely operate and maintain the Swing Boom Brush Cutter.

AUG 2026

REGISTER YOUR PRODUCT

IRONCRAFT

423-405-5150

MODEL		WEIGHT	
PART		HP RANGE	
SERIAL			
HYDRAULIC PRESSURE		HYDRAULIC FLOW	

WWW.IRONCRAFTUSA.COM

Please see the inside of the back cover for instructions of where to find your model and serial number.

⚠WARNING

To prevent personal injury or even death, be sure you read and understand all the instructions in this manual and other related OEM equipment manuals! This attachment 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 attachment until the user has read this manual and has developed a thorough understanding of the safety precautions and functions of the unit. DO NOT modify or use this attachment for any application other than that for which it was designed. Attachments 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.



Purchase Date:	
Dealer Name:	
Address:	
Phone Number:	

WELCOME

Thank you for choosing IRONCRAFT. This attachment has been designed and manufactured to meet the needs of discerning users. We are committed to providing you with a heavy duty product that will provide years of satisfaction and safe operation.

This manual will provide instructions on how to safely operate and maintain this attachment. All users must read and understand this manual before operating this attachment. Upon reading this manual, all users should sign the “Safety Acknowledgment Form” at the end of this manual.

Please record your model and dealer information on the inside front cover. 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.*

Sincerely,

ironCraft

MODEL SERIES	SWING BOOM SBC	PISTON MOTOR SWING BOOM (SBCNS)
GPM	14-20 GPM; 3,000 PSI (Optional) 16-26 GPM	17-30 GPM; 4,000 PSI
CASE DRAIN	NONE REQUIRED	REQUIRED
BLADES	2	2
VERTICAL REACH	16 FEET	16 FEET
HORIZONTAL REACH	8 FEET	8 FEET
CUT CAPACITY	3”	4”
WIRING HARNESS	UNIVERSAL, 7 PIN, 8 PIN OR 14 PIN	UNIVERSAL, 7 PIN, 8 PIN OR 14 PIN

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TABLE OF CONTENTS

INTRODUCTION & MODEL COMPARISON.....3

WARRANTY DISCLAIMERS.....5

SECTION 2 SAFETY INFORMATION

2.0 Safety Terms.....6
2.1 Safety Symbols.....7-8
2.2 Safety Decals.....9-10
2.3 Skid Steer Tractor Requirements.....10
2.4 General Safety Instructions.....11
2.5 Federal Laws & Regulations.....12

SECTION 3 OPERATING PROCEDURES

3.0 Unpacking Your Swing Boom Brush Cutter.....13
3.1 Pre-Operating Checklist.....13
3.2 How to Connect Swing Boom Brush Cutter.....14-15
3.3 Connecting the Electrical Harness.....16
3.4 Paddle Controller Installation.....16-17
3.5 Swing Boom Cutter Controls.....17-18
3.6 First Time Use.....19-20
3.7 Cutting Operations.....20-22
3.8 How to Disconnect the Swing Boom Brush Cutter.....22

SECTION 4 MAINTENANCE PROCEDURES

4.0 Maintenance Overview.....23
4.1 Maintenance Schedule.....24
4.2 Maintenance Log Instructions.....25
4.3 Storage Tips.....25
4.4 Torque Specification Table & Instructions.....26
4.5 Torque Equipment Requirements.....26-27
4.6 Blade Holder Removal.....27-28
4.7 Blade Holder Installation.....28
4.8 Blade Removal.....29
4.9 Blade Sharpening & Replacement.....30
4.10 Blade Installation.....31
4.12 Bearing Housing & Gearbox Maintenance.....32-33

SECTION 5 TROUBLESHOOTING

5.0 Troubleshooting Chart.....34-35

SECTION 6 SPECIFICATIONS

6.0 Specification Chart.....36

SECTION 7 PARTS INFORMATION

7.0 Parts Information Form.....37
7.1 Three Bolt Blade Retention System.....38-39
7.2 SBCNS Detailed Parts Diagram With Part Numbers.....40
7.3 SBCNS Prior To 428698 Parts Diagram With Part Numbers.....41
7.4 SBCNS With Hydraulics Parts Diagram.....42
7.5 Parts Diagram-Hydraulic Connection & Flow Diagram.....43
7.6 Parts Diagram-Electrical Diagrams.....44-45

SECTION 8 WARRANTY INFORMATION

8.0 Warranty Statement.....46

SECTION 9 SAFETY ACKNOWLEDGMENT FORMS......47

SECTION 10 MAINTENANCE LOGS.....48

APPENDIX A OLD STYLE BLADE INSTALLATION 49-50

APPENDIX B HOW TO FIND YOUR MODEL & SERIAL NUMBER.....51

IMPORTANT WARRANTY DISCLAIMERS

ATTENTION: If your attachment has control valves, cylinders, gearboxes, or motors and they are opened or disassembled, the WARRANTY for that item WILL IMMEDIATELY BE VOIDED!

GEAR OIL STATEMENT: *If applicable in your attachment, check gear oil before each use:*

We recommend using 85-140 grade gear oil, for use with all our gear boxes, and bearing housings which is separate from the hydraulic fluid used to move your attachment or machine.

(Exception: gear oil used in mulchers is Shell Omala S2 GX 150!)

HYDRAULIC FLUID STATEMENT: Check your machine's hydraulic level and add hydraulic fluid if necessary before each use. Inspect for leaks, and repair if necessary. **Always use your machine's manufacturer recommended hydraulic fluid in your machine**! Fluid must be clean and debris free. If damage occurs from debris in hydraulic fluid flowing from your machine to our attachment it will VOID the warranty on any cylinders, motors, couplers, manifolds &/or valves (relief, lock, selector, check and flow control) downline from that flow.

NOTE: If your attachment requires a case drain, the warranty WILL BE immediately voided if the attachment is ran without it. Please refer to specifications sheet on page 36 of this manual.

WARNING: This product can expose you to chemicals including benzene and mineral oils, which are known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov.

SECTION 2

SAFETY INFORMATION

The following terms may be used interchangeably throughout this manual.

Term	Alternate Terms Used
Swing Boom Brush Cutter	implement, attachment, swing boom, swing boom cutter, machine, brush cutter, cutter
Machine	skid steer loader, skid steer, loader, prime mover, tractor
Operator	user, personnel

This Swing Boom 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 brush cutter. Accident prevention is a combination of good judgment, common sense, awareness and proper training!

⚠ BEFORE YOU OPERATE THIS SWING BOOM BRUSH CUTTER:

KNOW how to safely operate your skid steer loader.

READ and UNDERSTAND the safety instructions and operating procedures contained in this manual.

ACKNOWLEDGE your understanding of all safety instructions presented in this manual by signing the “Safety Acknowledgment 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 warnings presented 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.

This manual and the decals on this machine use safety symbols, hazard labels, pictograms and color coded signal words to alert you to potential hazards that may cause severe injury or death if a safety instruction is ignored.



SAFETY ALERT SYMBOL - This symbol is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

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

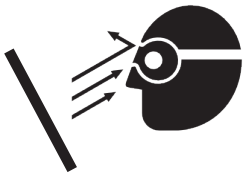
Indicates a situation which may cause damage to equipment or property.
Messages are not related to personal injury.

Safety Instructions

Indicates specific safety-related instructions or procedures.

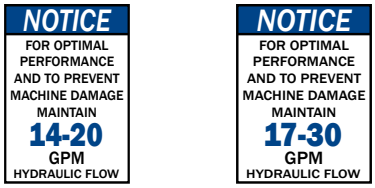
2.1 SAFETY SYMBOLS

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

Pictogram	Description
	**PINCH HAZARD**: Keep clear of machine and Swing Boom Brush Cutter attachment to prevent death or serious injury from pinching of moving parts.
	**FLYING DEBRIS HAZARD**: ONLY operate this attachment using a machine 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 attachment 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 attachment or machine arms to prevent death or serious injury from being crushed .
	AMPUTATION HAZARD: Keep hands and feet away from cutting blades. Do not operate without guards in place. Turn off engine before servicing.

The safety decals affixed to this machine are to keep you safe. DO NOT ignore these decals.

Read and understand each decal's safety message. Follow these Safety Decal Instructions:

REF	DESCRIPTION	LABEL	QTY
1	DANGER STAY BACK LABEL		4
2	8X8 DANGER COMBO		1
3	AUXILIARY HYDRAULIC FLOW NOT TO EXCEED NOTICE LABEL		1
4	MADE IN THE USA		1

**WHEN ORDERING, CHOOSE THE PROPER DECAL FOR YOUR MODEL*

CONTACT YOUR LOCAL DEALER TO ORDER REPLACEMENT DECALS

⚠ **Decals must be kept clean and legible at all times.**

⚠ **Operators must inspect the attachment for safety decals.**

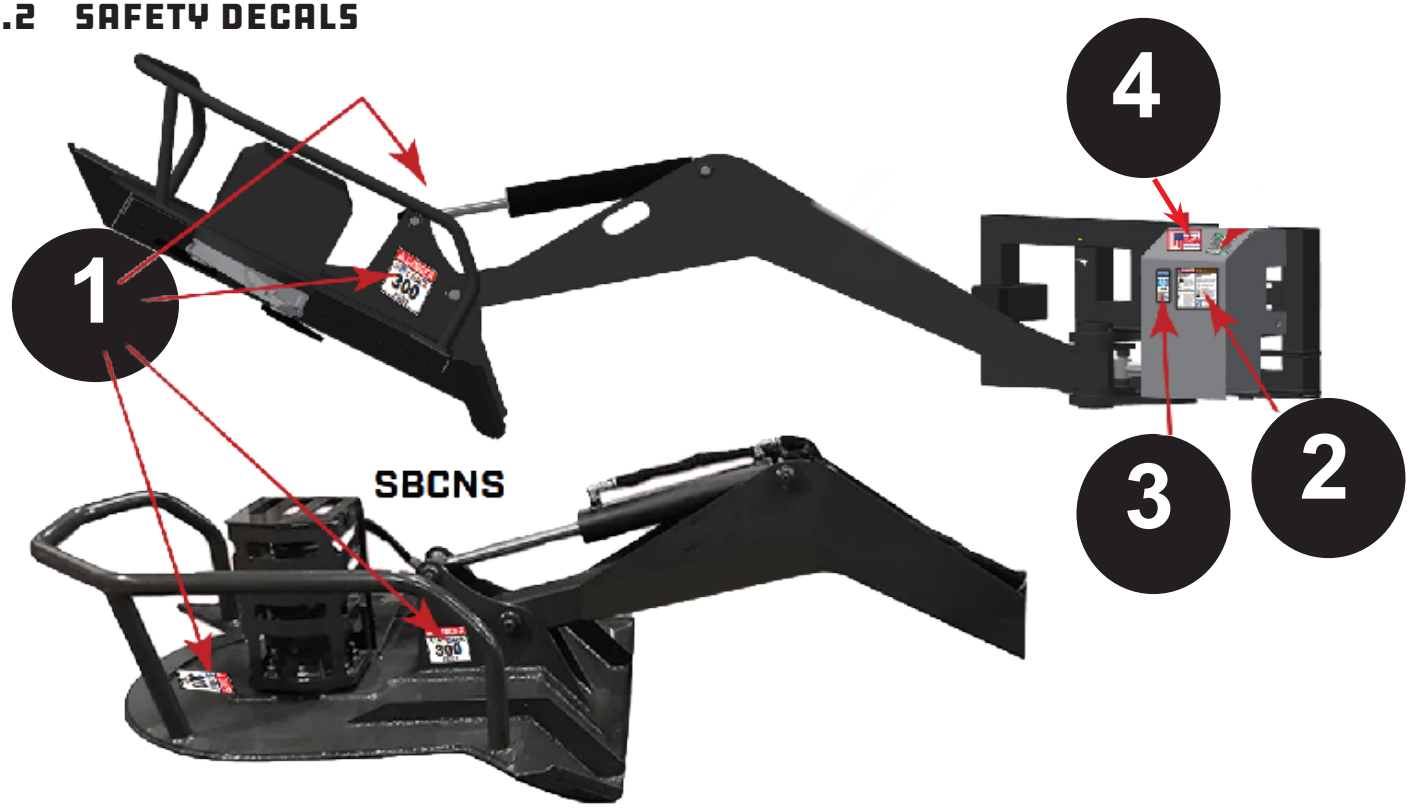
⚠ **Replace missing, worn or damaged decals immediately.**

⚠ **Use care when cleaning the attachment. When using a hot pressure washer to clean this attachment make sure water jet is not too close to the decal as this may cause the decal to peel.**

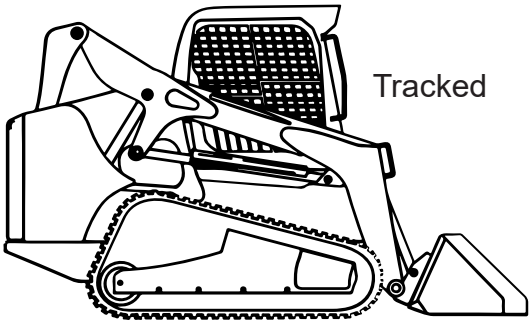
⚠ **When replacing parts, be sure safety decals are in place prior to using the machine.**

⚠ **Make sure metal surface is dry and free of dirt and grease before affixing decals to this machine.**

2.2 SAFETY DECALS



2.3 SKID STEER LOADER REQUIREMENTS



Tracked

VS.



Wheeled

A Tracked Skid Steer or Compact Track Loader (CTL) will provide superior stability in this application.

Machines must have impact resistant polycarbonate windshield, door, and side windows.

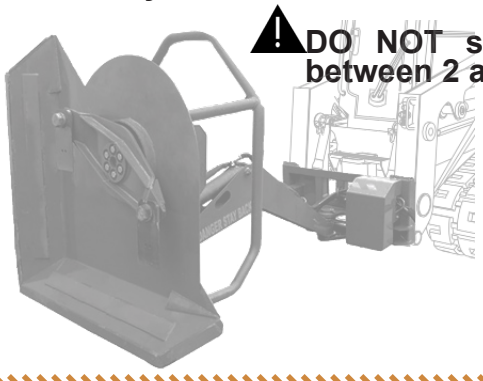
⚠WARNING **A screen structure is recommended over the windows and door to prevent injury or even fatal accident to the operator.**

The Swing Boom Brush Cutters should only be used on machines that meet the following requirements:

Skid Steer	SBC/SBCNS
Min. Lift Capacity	1,800 lbs
Min. lbs. with Cutter Removed	6,500 lbs
Engine HP	Minimum 64 HP
Electrical Connector	12V Power Source

MAKE SURE YOU FOLLOW THE GENERAL SAFETY INSTRUCTIONS THAT RELATE TO THE OVERALL OPERATION AND MAINTENANCE OF THIS ATTACHMENT. IT IS IMPORTANT THAT YOU READ AND UNDERSTAND EACH OF THESE MESSAGES TO PREVENT SERIOUS INJURY OR DEATH.

- **NEVER use drugs or alcoholic beverages while operating or servicing this attachment.**
- **ALWAYS operate this attachment during daylight or well-lit areas.**
- **MUST USE impact resistant polycarbonate windshield, door, and cab side windows on host machine.**
- **To prevent the machine and attachment from rolling forward, stop the engine and set the parking brake when exiting the machine.**
- **Inspect attachment for loose or missing hardware prior to using this machine.**
- **DO NOT allow children to play on or around this attachment at any time. Store this attachment in an area not frequented by children.**
- **ALWAYS wear the proper personal protection equipment while operating or servicing this attachment. NEVER operate or service this attachment with bare feet, sandals, or other light footwear.**
- **ALWAYS wear work gloves when handling cutter blades as they are often very sharp.**
- **ALWAYS use eye protection while operating or servicing this attachment.**
- **ALWAYS watch for overhead power lines.**
- **DO NOT place hands or feet under mower deck while blades are spinning.**
- **NEVER operate this Swing Boom Brush Cutter when bystanders are within 300 feet of your work area. Flying debris could cause serious injury or death.**
- **NEVER position your body or limbs under an unsupported cutter deck.**
- **NEVER leave equipment unattended with the engine running, or with this attachment in a raised position.**
- **DO NOT allow this attachment to contact buildings, utilities, large rocks or tree stumps or you may lose control of the machine.**
- **DO NOT operate this attachment during lightning or severe weather conditions.**
- **DO NOT allow riders on the machine or on this attachment.**
- **DO NOT speed! Keep your driving between 2 and 5 mph.**



2.5 FEDERAL LAWS & REGULATIONS

IMPORTANT FEDERAL LAWS AND REGULATIONS CONCERNING EMPLOYERS, EMPLOYEES, AND OPERATORS

This section 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... "

Sec. S(a) Each Employer – **DUTIES**

(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 MACHINE OPERATING INSTRUCTIONS:

1. Securely fasten your seat belt if the machine has the capability.
2. Where possible, avoid operating the machine 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 machine smoothly - no jerky turns, starts, or stops.
8. Hitch only to the drawbar and hitch points recommended by machine manufacturers.
9. When machine 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).

SECTION 3

OPERATING PROCEDURES

Your attachment may arrive from the factory strapped to a wood pallet and requires no final assembly. Use a steel band cutting tool to remove the steel straps.

⚠ CAUTION

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

3.1 PRE-OPERATING CHECKLIST

Pre-Operating Checklist	
☐	Swing Boom Cutter is securely attached to the machine.
☐	Make sure to lubricate ALL grease points with #2 Lithium grease.
☐	Hydraulic hoses are connected and locked to the machine hydraulic couplers with no signs of hydraulic oil leaks present.
☐	Electrical Harness is connected to the machine from attachment.
☐	Blades are in working condition and securely attached to the blade holder and all bolts and nuts are tight.
☐	No material, ropes, wire, etc. is obstructing the blades and blade holder assembly.
☐	The area of operation is clear of bystanders and any obstacles that could damage the equipment or injury to the operator.
☐	The operator is of good health and not under the influence of any mind altering substances or alcohol.
☐	Safety labels are present and legible.

3.2 HOW TO CONNECT SWING BOOM BRUSH CUTTER

GENERAL ATTACHMENT METHOD

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

This attachment method refers specifically to skid steers. For all other attachment instructions, refer to the Original Equipment Manufacturer (OEM) for instructions.

1. Ensure the hydraulic lines are clear from the front side of the Swing Boom Cutter's attachment bracket and that the levers on the skid steer Quick Attach Coupler are in the unlocked position.
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 hooks under the lip of the attachment bracket. See figure 3.2a below.
3. Slightly tilt the skid steer Quick Attach Coupler upward until the Swing Boom Cutter attachment bracket is flat against the skid steer Quick Attach Coupler. See figure 3.2a below.

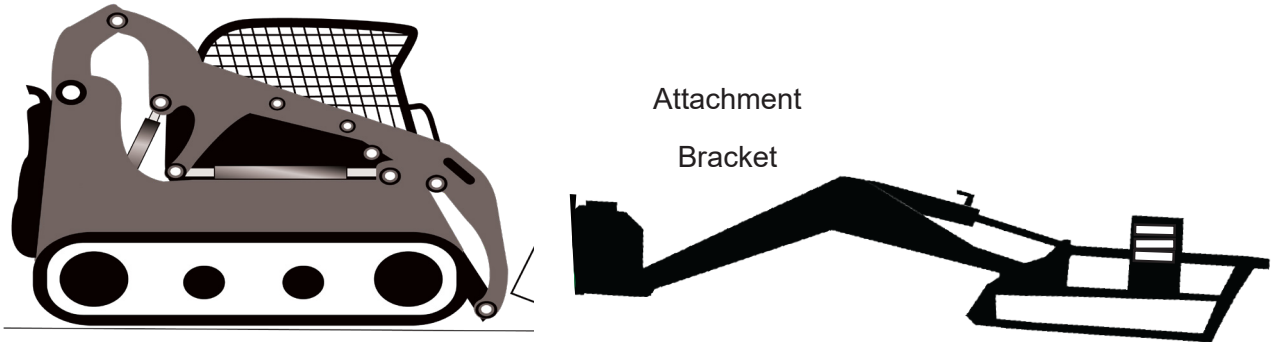


FIGURE 3.2A – SKID STEER QUICK ATTACH COUPLER TO ATTACHMENT BRACKET

4. Activate your skid steer's lever lock switch to lock the pins into the Swing Boom cutter's attachment bracket. If your skid steer does not have this switch, manually lock the pins as shown in Figure 3.2b below.

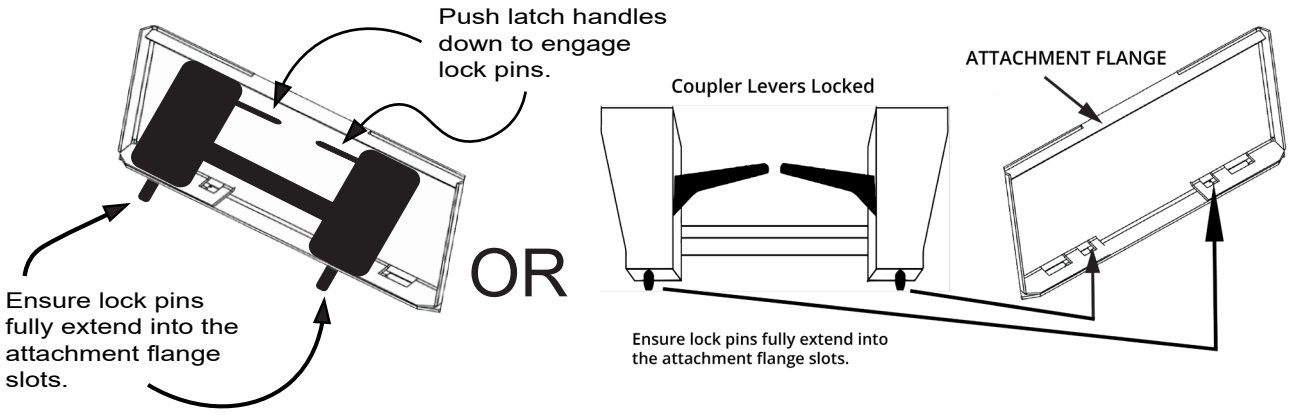


FIGURE 3.2B QUICK ATTACH COUPLER LOCKED TO ATTACHMENT BRACKET

⚠WARNING

To avoid serious injury or death, ensure locking 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 machine.

NOTICE

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

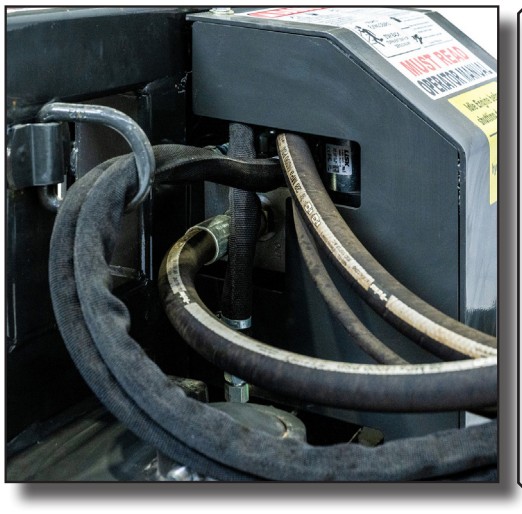
5. Connect the attachment hydraulic hoses and the case drain hose (SBCNS model only) to the auxiliary supply couplers located on your machine loader lift arm.

NOTICE

Check that hydraulic hoses are locked into the machine's couplers with the preferred output auxiliary port corresponding to the correct input line on the attachment before use.

Check the hose routing through the full range of intended motion before operating attachment. It is the reponsibility of the owner/operator to make sure the hoses are routed correctly and are not pinched.

Please refer to our "Hydraulic Fluid and Oil Statement" on Page 5 for gear oil or hydraulic fluid instructions.



HYDRAULIC FLOW REQUIREMENTS

When operating this attachment, set the machine engine RPM to a speed that will produce the required auxiliary flow. Your machine dealer can measure the flow available on your machine and recommend a throttle or auxiliary flow setting that is compatible with this attachment. DO NOT EXCEED the designated flow rate (GPM) as damage to hydraulic components can occur.

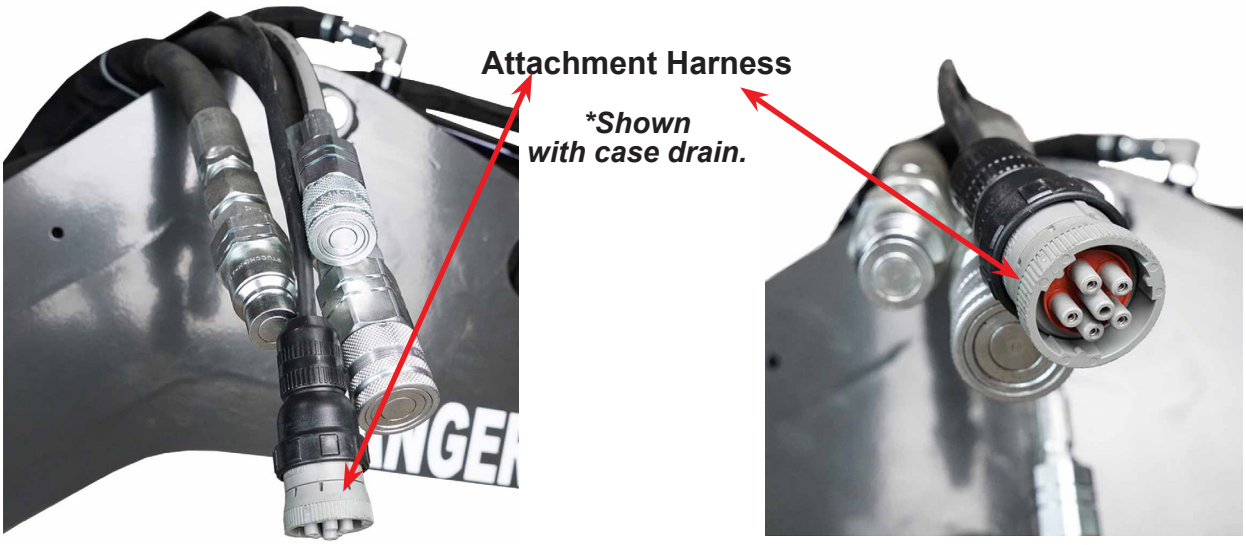
⚠WARNING

DO NOT operate the Swing Boom Brush Cutter if you (the Operator) can see the cutter blades from the bottom side. If the operator can see the cutter blades, the back of the cutter is raised TOO HIGH.

LOWER back frame of the Swing Boom Cutter deck to avoid being hit by flying debris!

3.3 CONNECTING THE ELECTRICAL HARNESS

Connect the electrical attachment harness from the Swing Boom Cutter to the electrical bulkhead connector mounted on the machine loader arm or using the universal harness connected to a 12V power source. A *universal, 7, 8, or 14 pin* pigtail harness adapter is available to make this connection. See Electrical Drawings, on pages 44-45 for more information.



3.4 PADDLE CONTROLLER INSTALLATION

If your machine **does not** have an auxiliary electrical connector, you will use the paddle controller to control the tilt and swing functions of the Swing Boom Cutter**.**

> **NOTICE**
>
> To prevent possible equipment damage, it is recommended that the paddle controller is installed by a qualified technician who is familiar with your machine's electrical system.

TO INSTALL PADDLE CONTROLLER:

1. Place the paddle controller on the seat inside the machine cab and route the power source cable that extends from the left side of the paddle controller to a point where the red wire with fuse can be connected to a 12V power source and black wire connected to the ground.

2. Route the control cable that extends from the right side of the controller box through the cab and up to the back of the loader pivot arm, then down the arms to a point near the hydraulic couplers. *Note: Secure this cable using plastic cable ties along the inside of the loader arm to prevent cable from being snagged by tree branches or other debris.*

3. Check that the cable is free of tension when raising and lowering the machine arms.

4. Appropriately secure universal control box so that damage does not occur.

⚠WARNING

To avoid unwanted attachment movement that may result in serious injury, shut the machine off and avoid contact with the controller to prevent unexpected movement when exiting the machine.

3.5 SWING BOOM CUTTER CONTROLS

To operate the Swing Boom Cutter controls the machines auxiliary hydraulic system must be activated. To swing or tilt the cutter head you will use your machine's auxiliary controller or the paddle controller attached to your leg.



Typical Machine Auxiliary Electric Controller



Paddle Controller

NOTE: When using the controls to swing the boom or tilt the cutter head, the cutter speed will slow down. The cutter will resume its normal operating speed once the swing or tilt action has stopped.

3.5 SWING BOOM CUTTER CONTROLS CONT.

SWING FUNCTION

The Swing Boom Cutter rotates 90° to the right of the machine's mounting point. Use the LEFT or RIGHT buttons on the controllers to stop the boom anywhere between 0° and 90°.

While the swing function does rotate 90°, it is recommended to run the attachment all the way to the right (touching the stop), or directly in front so as to maintain visibility and decrease the chance of hitting a hard object and damaging the swing cylinder or other area of the attachment.

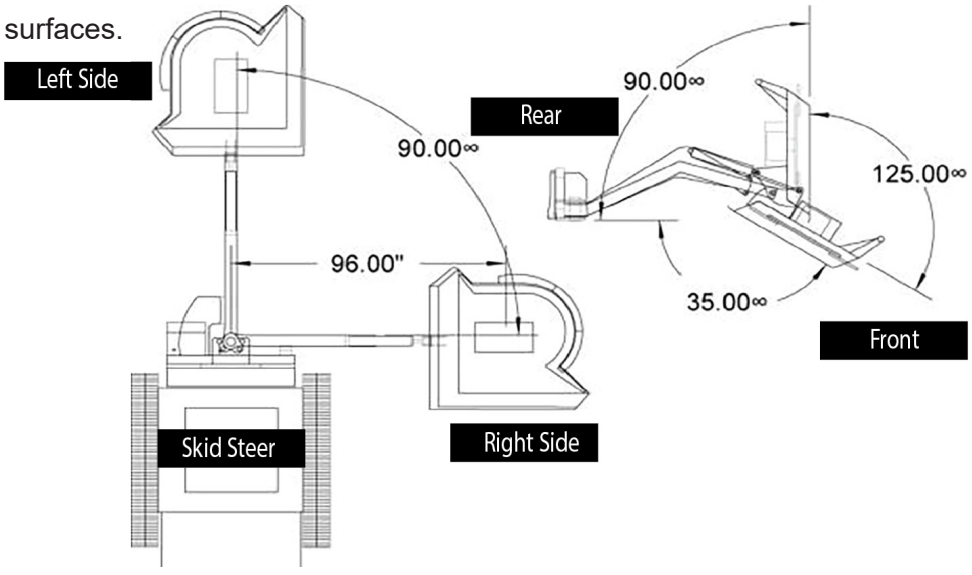
⚠ DANGER

To prevent serious injury, amputation, or death from debris, spinning blades or boom, keep all persons and objects 300 feet from the work area while attachment is operating.

⚠ CAUTION **With the Swing Boom swung at 90°, you must be aware of any obstacles and terrain around the cutter head and around your machine. Lack of awareness may cause the machine or Swing Boom Cutter to strike obstacles that may result in serious injury or damage to equipment.**

TILT FUNCTION

The Swing Boom Cutter deck can tilt up 90° from the horizontal position and tilt down 35° from the horizontal position. Use the UP and DOWN buttons on your machine's auxiliary electric controller, or paddle controller to tilt the cutter head. The tilt function is used for cutting on sloped terrain surfaces.



NOTICE

Before operating Swing Boom Cutter, check the hydraulic fluid level in the machine and add fluid if necessary. *Please refer to our "Hydraulic Fluid and Oil Statement" on Page 5 for gear oil or hydraulic fluid instructions.*

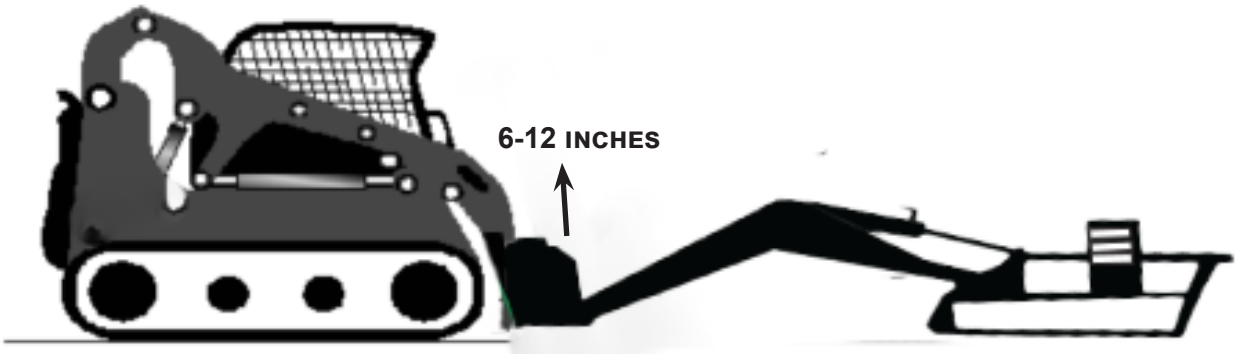
⚠WARNING (This only applies to the Piston Motor Swing Boom Cutter.)

Make sure the case drain hose is properly attached to the prime mover's case drain connection.

DO NOT operate this attachment WITHOUT the case rain hose attached.

Warranty WILL BE be void if attachment is ran without the case drain hose connected. Excessive hydraulic pressure can blow out seals and damage the motor.

Verify that hydraulic hoses are securely locked to the machine hydraulic couplers before starting the attachment.



After starting the machine, lift attachment 6-12 inches off the ground surface:

1. Set machine engine RPM to just above idle and flip the auxiliary hydraulic switch to the ON position.

2. Swing the boom to the right using the machine's auxiliary electrical controls, or by holding down the RT button on the paddle controller.

3. Tilt the cutter deck down by using the machine's auxiliary controls or by holding down the DN button on the paddle controller. Be careful not to nose the deck into the ground with the blades rotating.

4. Then tilt the cutter deck up by using the machine's auxiliary controls or holding down the UP button on the paddle controller.

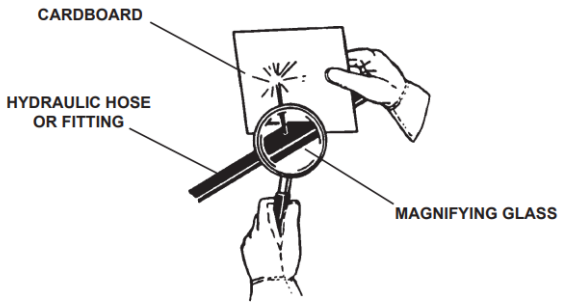
5. Swing the boom left to the straightforward position using the machine's auxiliary controls or holding down the LT button on the paddle controller.

3.6 FIRST TIME USE CONT.

6. Allow the cutter to run for 30 seconds to purge air from the system, then switch off the auxiliary hydraulic flow and allow cutter blades to come to a complete stop.

⚠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 cardboard. Flesh injected with Hydraulic fluid may develop gangrene or other permanent disabilities.



7. Lower the Swing Boom Brush Cutter to the ground, set the parking brake, shut off machine engine and exit the cab.

8. Check the hydraulic fluid level in the machine, add manufacturer recommended fluid if necessary.

9. Inspect the Swing Boom Brush Cutter's hydraulic hoses & connectors for noticeable leaks. Fix before continuing.

3.7 CUTTING OPERATIONS

GENERAL OPERATING TIPS

1. LEARN what the cutter head looks like in a level position when you are seated in the machine. Knowing what a level cutter head looks like will prevent you from damaging the cutter blades if you cut too close to the ground.
2. SLOW down the machine if the engine "bogs" down or if the cutter speed is too slow because of too much load.
3. LOOK, LISTEN, and FEEL for any abnormal vibrations or noises. If you see, hear, or feel a strong vibration or abnormal noise while cutting, slow the machine down and see if the vibration stops. If not, stop the Swing Boom Cutter, lower the attachment, turn off the machine engine and investigate the cause. Refer to the "Troubleshooting Chart" on pages 34-35 of this manual.
4. ALWAYS be aware of your surroundings and pay attention to obstacles and terrain in front of you.

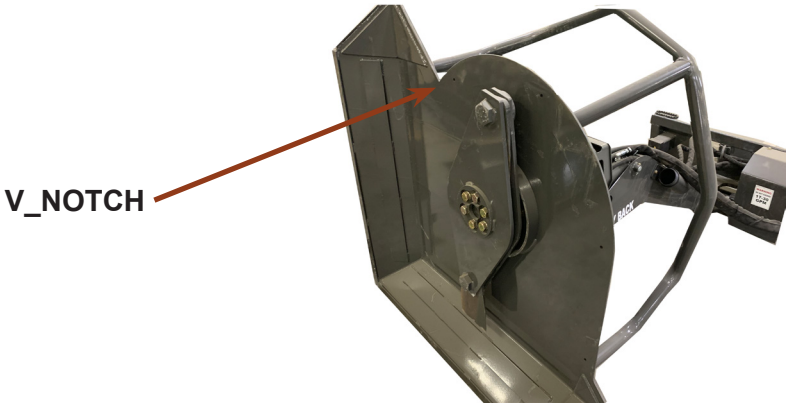
NOTICE

If the Swing Boom Cutter abnormally vibrates while increasing RPM's, switch off the auxiliary hydraulic circuit and investigate the cause. See pages 34-35 for Troubleshooting.

⚠ CAUTION

NEVER use your cutter to push, pull, lift or move any type of object or vehicle. DO NOT use this brush cutter to "push" down trees. The new style Swing Boom Cutter can cut down small trees up to 4" in diameter. (Old Style can cut up to 3" trees.) To cut down small trees, place the tree trunk inside the "V-NOTCH" at the front of the cutter.

Your Swing Boom Cutter is designed to cut vegetation with the cutter head in the vertical or horizontal position. Vertical cuts are great for widening pathways, roadways and other access areas. Horizontal cuts are great for cutting around ponds or road embankments.



*Old Style Blade Holder Shown

⚠ WARNING

Vertical or Horizontal cutting can disperse flying debris over a large area and cause death or serious injury to bystanders. DO NOT operate this Swing Boom Cutter when bystanders are within 300 feet of this machine.

⚠ CAUTION

Use Extreme Caution when operating on uneven terrain or any type of sloped surface and when operating the Swing Boom Brush Cutter in an elevated position. Be aware of the center of gravity when using the Swing Boom Cutter to avoid a roll over accident that could result in serious injury or death.

⚠ DANGER

To prevent from being electrocuted and killed, watch out for overhead electrical lines when operating the cutter boom.



3.7 CUTTING OPERATIONS CONT.

TO CUT VERTICALLY OR HORIZONTALLY:

1. Raise the machine arms.
2. Tilt the Swing Boom Cutter deck to the vertical or horizontal (closely level with the ground) position.
3. Keep the boom straight out in front of you or swing the boom to the right (all the way to the stop) adjusting the cutter deck to the desired cutting position.
4. While moving forward, raise and lower the machine arms to trim branches or other material.

NOTICE

ANALYZE the fall path of large branches or objects before cutting to avoid contact with the machine and/or Swing Boom Cutter.

When trimming around ponds or embankments use the host machine control functions to adjust the deck with the terrain.

NOTICE

If the cutter speed slows down, reduce your travel speed and allow the cutter to reach the proper rotating speed. Mowing TOO fast in thick vegetation could result in “balling” of the material underneath the cutter deck resulting in a loss of cutting efficiency.

3.8 HOW TO DISCONNECT SWING BOOM BRUSH CUTTER

DISCONNECTING BRUSH CUTTER

1. Park machine on a flat and level surface then lower Swing Boom Cutter with cutter deck in the vertical position, to the ground.
2. Turn off auxiliary hydraulic circuit; relieve hydraulic pressure by moving the joysticks back and forth or pressing the hydraulic relief valve (if applicable).
3. Set parking brake and disengage lock pins using the lock lever switch (if installed skip #7).
4. Turn off machine engine.
5. Disconnect hydraulic hoses and connect together or install dust caps to prevent contaminants from entering the hydraulic system.
6. Disconnect electrical wiring harness.
7. If machine is equipped with manual latch handels, pull latch handles to disengage lock pins.
8. Re-enter cab and start machine engine and press the pin unlock button to disengage lock pins in quick attach.
9. Tilt mounting coupler forward until Quick Attach Coupler is free from mounting bracket.
10. Drive machine backward to clear cutter.

SECTION 4

MAINTENANCE PROCEDURES

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.

⚠WARNING **Only use genuine Original Equipment Manufacturer (OEM) replacement parts on this attachment. We will not be liable for any damages or injuries caused by the use of after market parts on this attachment.**

NOTICE

Improper maintenance or modifications to the design or performance of this attachment will void the warranty. ONLY use genuine replacement parts on this attachment.

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.**

⚠ **If servicing is performed while the Swing Boom Cutter is attached to the machine, lower the attachment to the ground, turn engine off, set parking brake and chock wheels to prevent machine from moving.**

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

⚠ **Wear a welding helmet when welding to protect your eyes, face and neck from flash burn, ultra-violet radiation and heat. Only perform service work in a well-lit area.**

⚠ **Allow the attachment to cool down before servicing this attachment.**

⚠ **NEVER work under an unsupported Swing Boom Cutter deck.**

4.1 MAINTENANCE SCHEDULE.

This Swing Boom 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

MAINTENANCE TASK	BEFORE EACH USE	WEEKLY	YEARLY
Check host machine's hydraulic fluid level. Add manufacturer recommended fluid as necessary. *Please refer to our "Hydraulic Fluid and Oil Statement" on Page 5 for gear oil or hydraulic fluid instructions.*	X		
Check that all fasteners (nuts, bolts, washers, pins, keepers) are in place. Tighten as necessary.	X		
Lubricate all grease points with #2 Lithium grease.	X		
Inspect and replace any worn, torn, or missing safety decals.	X		
Inspect hydraulic hoses and connectors for damage or leakage. Repair or replace hydraulic items as necessary.	X		
Check condition of cutter blades. Sharpen or replace as necessary. ***We recommend replacing the bushing & bolts with the blades.***	X		
Check for gearbox or bearing house gear oil leaks. Repair and add oil as necessary.	X		
Wash brush cutter.		X	
Change 85-140 oil in gearbox or bearing house. *Change oil after 50 hours of first time use, then every 1000 hours or yearly.			X 1,000 HRS
Check brush cutter for major scratches & dings. Sand and repaint these areas to prevent rust damage. *Contact the manufacturer for approved OEM paint for your attachment.			X

DANGER

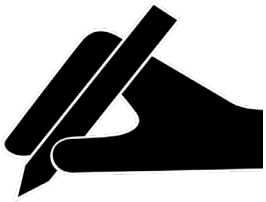
Use extreme caution while diagnosing electrical connections and solenoid valve function as the boom could suddenly activate and cause severe injury or death. NEVER stand in the path of the boom's swing.

DANGER

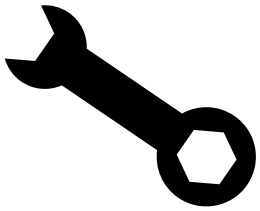
ONLY service this attachment on stable, even terrain. NEVER park on sloped terrain to avoid being struck and killed or seriously injured by the unexpected rolling or movement of the attachment or machine.

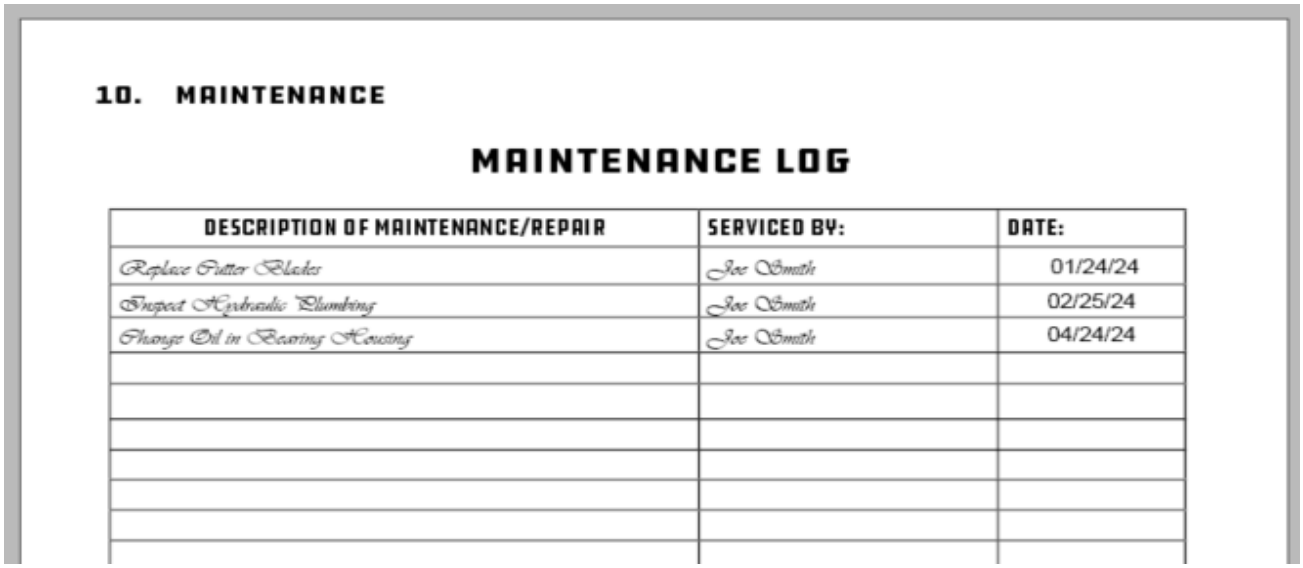
4.2 MAINTENANCE LOG INSTRUCTIONS

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



MAINTENANCE LOG





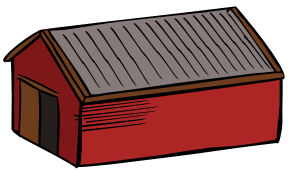
10. MAINTENANCE

MAINTENANCE LOG

DESCRIPTION OF MAINTENANCE/REPAIR	SERVICED BY:	DATE:
Replace Cutter Blades	Joe Smith	01/24/24
Inspect Hydraulic Plumbing	Joe Smith	02/25/24
Change Oil in Bearing Housing	Joe Smith	04/24/24

4.3 STORAGE TIPS

To get years of quality use out of your Swing Boom Cutter, follow these tips when storing your cutter for the season:

	Ensure cutter is free of water, debris, dirt and grease.
	Store your cutter in a dry shed or garage.
	When storing your cutter for the season, cover with a weather proof tarp to protect it from the elements.

4.4 TORQUE SPECIFICATION TABLE AND INSTRUCTIONS

BOLT TORQUE INSTRUCTIONS

1. Apply and maintain proper torque on all bolts.
2. Use lubricated torque values when applying Loctite. **Do not grease or oil bolts.**
3. Wipe bolts clean and use Loctite 635 or equivalent before tightening bolts. May need curing activator.
4. Use a torque wrench to assure the proper amount of torque is being applied to the bolt.
5. **MUST CURE 72 HOURS BEFORE USE TO PREVENT LOOSENING OF BOLTS.**

TORQUE VALUES

SAE GRADE 8

	DRY lb.-ft.	LUBRICATED lb.-ft.
1/4”	12	9
5/16”	24	18
3/8”	45	35
1/2”	110	80
3/4”	380	280
7/8”	600	450
1”	910	680
1 1/4”	1820	1360
1 1/2”	3162	2688

4.5 TORQUE EQUIPMENT REQUIREMENTS

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 pry bar set
- Safety stands
- **Loctite 635 or Equivalent-MUST CURE 72 HRS**
- Lifting device (overhead crane hoist, forklift)



NOTE:

When removing bolts with Loctite, it will be necessary to apply localized heat of at least 250 degrees Celsius or to 482 degrees Fahrenheit to loosen bolts.

LOCTITE 635 TECHNICAL SPECIFICATIONS FOR BONDING, CURING, REMOVAL AND INSTALLATION CAN BE FOUND HERE:
https://next.henkel-adhesives.com/

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.

PERSONAL PROTECTIVE EQUIPMENT (PPE) REQUIREMENTS

BOLT TORQUE REQUIREMENTS



4.6 BLADE HOLDER REMOVAL

DANGER

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

DANGER

ONLY service the cutter on stable, even terrain. NEVER park on sloped terrain to avoid being struck and killed or seriously injured by the unexpected rolling or movement of the machine..

NOTICE

ALWAYS release the hydraulic system pressure from the auxiliary hydraulic circuit prior to removing the blade holder.

4.6 BLADE HOLDER REMOVAL CONT.

⚠ CAUTION

When performing this procedure alone, rig a pair of choker slings through the blade holder and connect to an overhead hoist. This will prevent the blade holder from falling on to you causing injury to your body.

REMOVAL PROCEDURE - BRUSH CUTTER ATTACHED TO MACHINE

1. Place the Swing Boom attachment below an overhead hoist if available.
2. Position the cutter deck in a vertical position on the ground to gain access to the blade holder (Figure 4.4a below)
3. If the Swing Boom Cutter is attached to the machine shut off hydraulic flow to the cutter, and release pressure from the auxiliary hydraulic circuit.
4. Turn OFF machine engine, SET parking brake, and CHOCK machine wheels to prevent machine from moving.
5. Rig a pair of choker slings through the blade holder and connect to an overhead hoist. Keep tension on the slings to prevent the blade holder from falling once the bolts are removed.
6. Remove the **six 3/4 inch hex bolts** that secure the holder to the mounting flange. If the blade holder fails to separate, use a wedge breaker tool to help separate the blade holder from the mounting flange.
7. Use the hoist to place the blade holder on a suitable work surface.

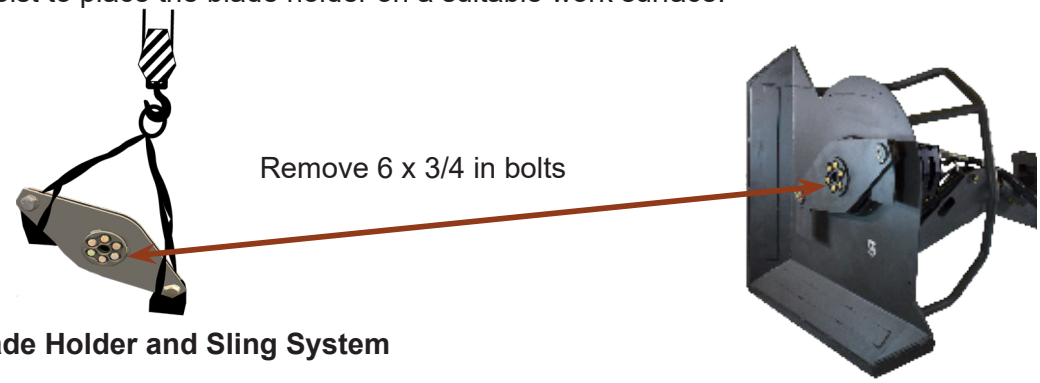


Figure 4.4a Blade Holder and Sling System

4.7 BLADE HOLDER INSTALLATION

INSTALLATION PROCEDURE

NOTICE

Use a hoist, lift table or forklift to support the blade holder during installation.

1. Align the hole in the blade holder to the mounting flange and fully seat the holder onto the flange.
2. Tap the blade holder with a rubber hammer to ensure full engagement. The blade holder must be properly aligned and seated on the mounting flange before proceeding to the next step.
3. **Lubricate the six 3/4 inch diameter grade 8 hex bolts with Loctite 635 or equivalent.**
4. Torque bolts to **280 ft.-lbs** as per torque specifications on the Torque Chart on page 26.

NOTICE

This procedure requires special tools and skills. DO NOT attempt to remove or sharpen blades if you do not have the tools or skills. Take your cutter to your local dealer for blade services.

⚠ CAUTION

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

BLADE REMOVAL PROCEDURE

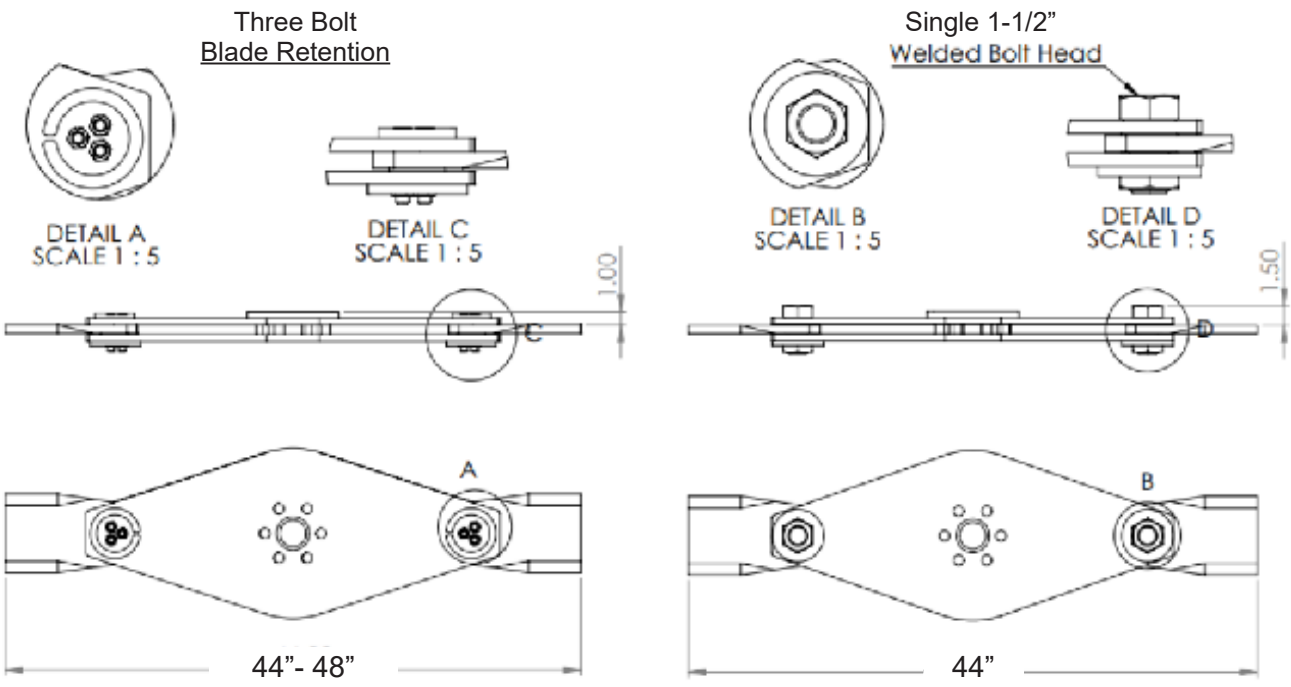
PLEASE NOTE: For Single Welded Bolt blade retention, please refer to Appendix A at the end of this manual.

1. Remove the blade holder as described in Section 4.6 of this manual.

2. Remove the three bolts and nuts that secure the blade to the blade holder. (See Detail A below.)

3. Drive the bolt shank from the blade and blade holder, being careful not to let the blade fall onto your feet.

4. Repeat steps 2-3 for the second and third bolts.



4.9 BLADE SHARPENING AND REPLACEMENT NOTES

Blade Sharpening and Replacement

- **Sharpen cutter blades with the appropriate tool.**
- **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 or severe distortion of blade or blade holder may result in excess vibration or unbalancing which could result in damage to your attachment.**
- **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.**
- **For models with 2 sided blades, flip hydraulic lines going into the hydraulic motor if you wish to use the blades opposing edges.**
- **You MUST reinstall the bushing prior to re-bolting the bushing. DO NOT REPLACE with any other hardware!**
- **We recommend changing the bushing and bolts each time the blades are replaced.**

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.

BLADE INSTALLATION PROCEDURE

NOTICE

The blade bolt threads must extend beyond the nut, with the nut seated flush in the recessed hole.

1. Line up the blade parts as demonstrated below.
2. With the bottom weldment lying flat on a secure surface as shown on the following page, insert the three (3) bolts on each end from the bottom up.
3. Add your blade bushing.
4. Place the blades in the line of assembly as shown.
5. Place the top weldment on top of the assembly, line-up and make sure the bolts are lined up accordingly.
6. Apply Loctite 635 or equivalent to the end of each bolt and finger tighten the six nuts on the ends of the bolts.
7. Torque the 1/2” blade bolt to the value shown in the torque table on page 26 of this manual.

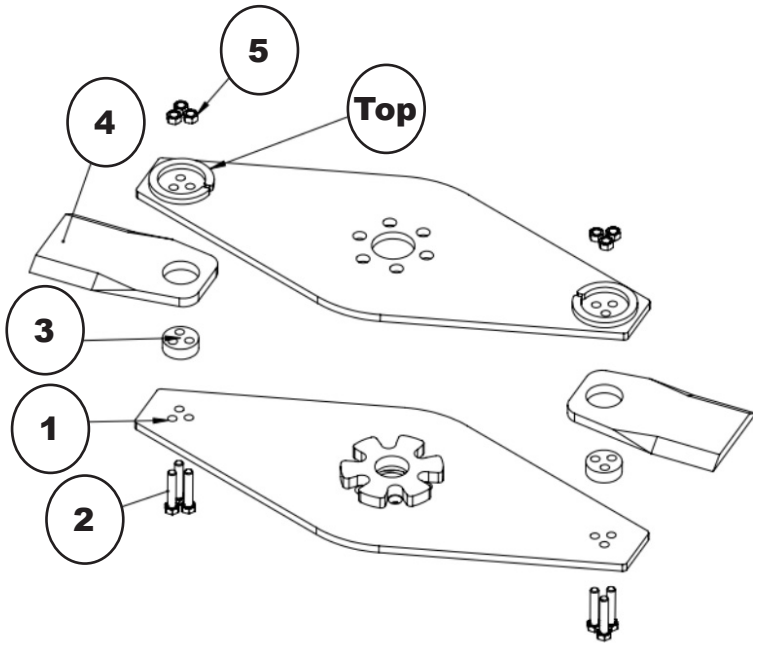


Figure 4.10a Blade Assembly

4.11 BEARING HOUSING AND GEARBOX MAINTENANCE

NOTICE

Maintenance procedures for the drive bearing housing and gearbox require special tools and skills. **DO NOT** disassemble or modify the gearbox as this will void the warranty.

Contact your dealer for any gearbox repair work.

Swing Boom Cutter 17-30 GPM (SBCNS Models)

The SBCNS model has a bearing housing unit attached to a direct drive piston motor.

CHECK OIL LEVEL:

1. Check for damaged or leaking seals.
2. The oil level in the bearing house must be checked before each use.

   Refill with 85-140 grade gear oil only.
3. CHECK the oil level by removing the oil filler plug and oil breather plug. The oil level should be at the bottom of the breather plug.

   See Figures 4.12a & 4.12b

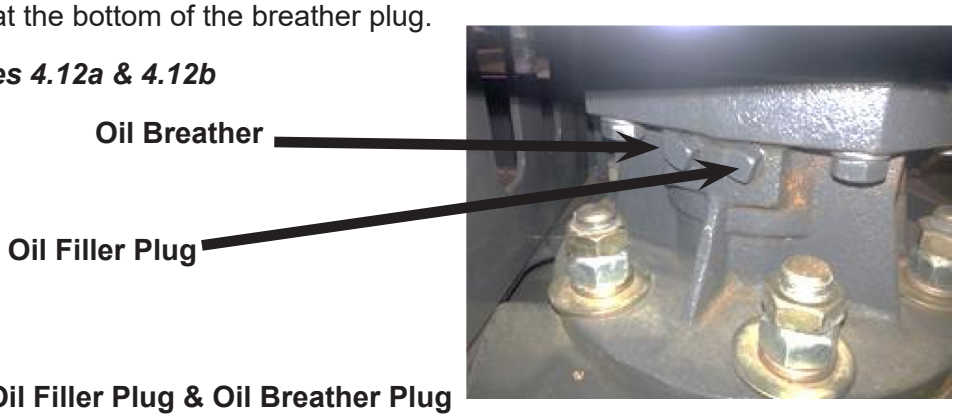


Figure 4.12a Oil Filler Plug & Oil Breather Plug

Swing Boom Cutter 14-20 GPM (SBC Models)

The SBC model has a right-angle gearbox coupled to a hydraulic motor.

CHECK OIL LEVEL:

1. Check for damaged or leaking seals.
2. Locate the oil filler plug and remove it. *See example on page 33.*
3. CHECK the oil level which should be at the mid height of the input shaft.***See Figure 4.12c***
4. If low, **refill with 85-140 grade gear oil.** Check the oil level before each use.
5. Reinstall oil filler plug.

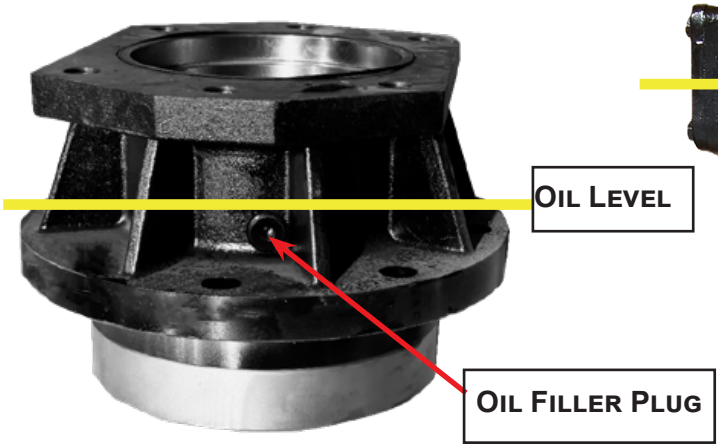


Figure 4.12b 17 - 30 Gearbox

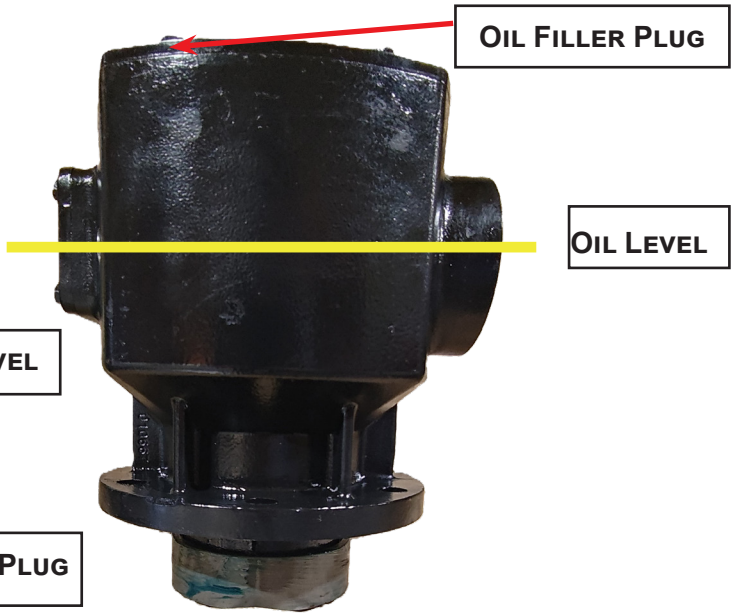


Figure 4.12c 14 - 20 Gearbox

NOTICE

The initial oil should be changed after 50 hours of operation under load for the gearbox or bearing house. 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 heat conditions.

GEARBOX OIL CHANGE PROCEDURE

1. Remove oil filler plugs.
2. Using an oil removal pump, insert one end of a discharge hose into the gearbox (SBC Model) or bearing housing (SBCNS Model) oil filler ports. Then place the other end into an approved waste oil container.
3. Remove the used oil from the bearing housing or gearbox.
4. Refill the bearing housing or gearbox with **85-140 5EP grade gear oil.**
5. Remove the breather plug on the bearing housing and check that oil level is at the bottom of the hole. The gear box oil level should be at the approximate level shown in ***Figure 4.12b & 4.12c***.
6. 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.

SECTION 5

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Cutter bogs down or loses power.	Deck is not leveled properly causing improper cutting angle as well as ground engagement.	Maintain proper cutting angle directly parallel with the ground.
	Foreign material is “balling” or wrapping around blade holder.	Remove foreign material from under the deck.
	Bearing failure-(To diagnose, shut off hydraulic flow to cutter then slowly rotate the blade holder assembly & listen for bearing noise.)	See dealer for bearing housing service; replace bearing housing.
	Cutter speed too slow or ground speed to fast.	Increase RPMs and reduce ground speed.
	Hydraulic fluid flow too slow.	Look for hydraulic leaks & inspect check valve for debris in H-valve hose assembly. Repair or replace.
Excessive or abnormal vibration.	Missing, loose or damaged blades.	Tighten loose blades and/or replace missing or damaged bushings, bolts and blades.
	Stuck blades.	Inspect for debris inhibiting movement of blades. Remove the debris. Disassembly may be needed
	Blade holder damaged.	Replace blade holder.
	Bearing failure.	Repair or replace bearing housing.
	Debris or material wrapped around or lodged in blade holder.	Remove debris or material after blades come to a complete stop.
Blades dull too quickly or are chipping.	Blades are receiving excessive shock loads from contacting solid objects (rocks, steel pipes, etc.)	Clear the cutting area of solid objects, raise cutter height to clear exposed rock surfaces.
Hydraulic fluid level goes down during operation.	Hydraulic motor leak, or leaks in prime mover’s hydraulic system.	Investigate and repair leaks.
Cylinder(s) do not open or close when auxilary hydraulic system is activated or move very slowly.	Quick disconnects not connected or fully seated.	Check & reconnect Quick Disconnect
	Hydraulic hose loose, disconnected or damaged.	Check for loose, disconnected, or damaged hose. Tighten or replace.

PROBLEM	POSSIBLE CAUSE	SOLUTION
Blades do not rotate when flow is activated.	Steps to Fix (In Order): 1. No Hydraulic fluid flow or incorrect flow direction. 2. Inspect for check valve failure. 3. Check for hydraulic motor failure. 4. Check for gearbox or bearing housing failure.	1. Check machine auxiliary hydraulic function or reverse flow direction. 2. Replace check valve. 3. Disconnect motor from gearbox or bearing housing then turn blade holder by hand. Motor failure is suspected if blade holder moves freely. Replace motor. 4. With motor removed and if blade holder does not turn freely, gearbox has failed. Repair or replace gearbox or bearing housing. Contact Dealer for instruction.
Blades turn, but cannot tilt or swing the cutter.	No electrical power to controller or solenoid valves. Solenoid valves are no longer functioning properly. Cylinder(s) damaged or bypassing. Broken cylinder connecting pin(s) to deck or arm.	Check all electrical connections for power and consult the machine manufacturer's manual for issues with host machine. Inspect solenoid valves for proper function or contamination. Repair or replace if damaged. Replace seals or cylinder(s). Replace cylinder connecting pin(s).
Pins could be prematurely wearing or breaking.	Not greasing pins frequently enough. Cutter receiving excessive shock loads from ramming or contacting solid objects (rocks, concrete, steel pipes).	Grease pins before each use and repeat every 8 hours or less while using in extreme conditions. Clear or mark area of solid objects, or raise the cutter height to clear exposed solid surfaces.
Gearbox or bearing housing leaking gear oil.	Wire or other debris wrapped around bottom of gearbox or bearing housing output flange damaging the seal. Motor over-pressured by pinching hydraulic hoses or knocking hydraulic hoses off machine auxiliary ports with trees or other debris causing blown out shaft seal in motor and/or gearbox/bearing housing.	Avoid wire/mesh fencing, or any other type of objects which could wind around gearbox/bearing housing output flange and damage seal. Avoid any debris contacting or hitting hoses and take care hoses are routed to avoid pinching or snagging. Make sure Quick Disconnects are locked once attached.

SECTION 6

SPECIFICATIONS

MODEL SERIES	SWING BOOM SBC	PISTON MOTOR SWING Boom(SBCNS)
GPM	14-20 GPM; 3,000 PSI (Optional) 16-26 GPM	17-30 GPM; 4,000 PSI
MIN. / CTL POWER	64 HP	64 HP
CASE DRAIN	NONE REQUIRED	REQUIRED
BLADES	2	2
VERTICAL REACH	16 FEET	16 FEET
HORIZONTAL REACH	8 FEET	8 FEET
CUT WIDTH	48 INCH	48 INCH
CUT CAPACITY	3 INCH	4 INCH
WIRING HARNESS	UNIVERSAL, 7 PIN, 8 PIN OR 14 PIN	UNIVERSAL, 7 PIN, 8 PIN OR 14 PIN
MIN. MACHINE / CTL LIFT CAPACITY	1,800 LBS	1,800 LBS
MIN. MACHINE / CTL LIFT WEIGHT	6,500 LBS	6,500 LBS
WEIGHT	1,400 LBS	1,400 LBS



SECTION 7

PARTS INFORMATION

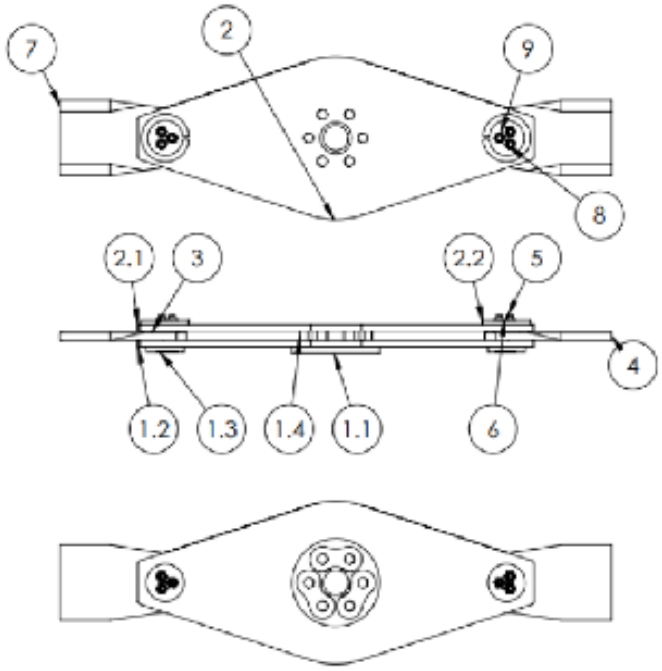
Factory OEM parts specifically designed for your implement are readily available.

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

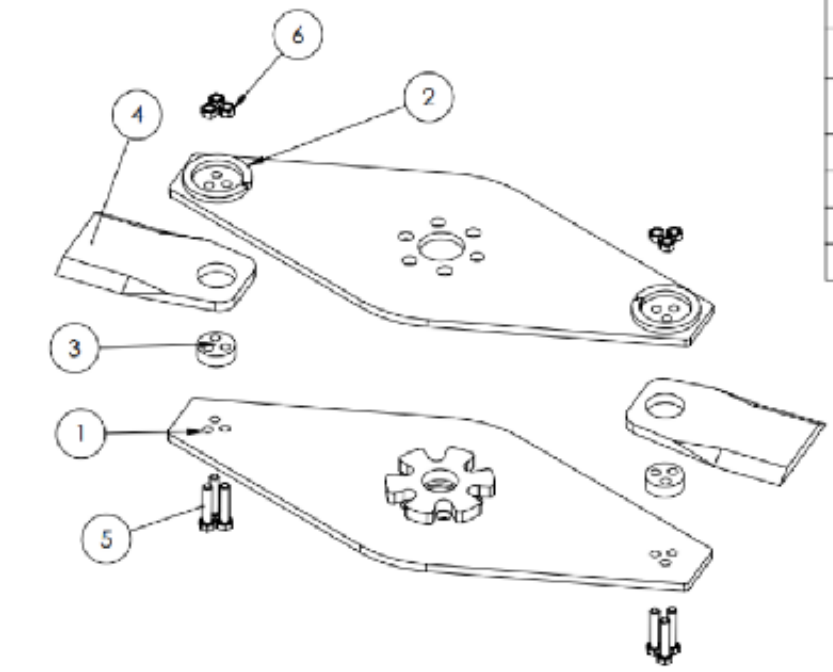
Model Number	
Serial Number	
GPM Requirements	
Date of Owners Manual (Bottom Left Corner of Cover Page)	
Parts Diagram Page Number	
Part Description	
Reference #	
Quantity Desired	
Ship To Information	
Bill To / Payment Information	

7.1 THREE BOLT BLADE RETENTION SYSTEM

44” Three Bolt Blade Retention System



ITEM NO.	PART NUMBER	QTY.
1	SBC-2BLD-44-Bottom-Weldment	1
1.1	XBC-BoltGuard	1
1.2	SBC-BladeHolder-44-GR50	1
1.3	SBC-BoltHeadProtector	2
1.4	XBC-BladHldr-Spacr	1
2	SBC-2BLD-44-Top-Weldment	1
2.1	SBC-BladeHolder-44-GR50	1
2.2	TRBC-NutProtector	2
3	-PI-REAPERBUSHING	2
4	20100056	2
5	50F225HCS9Y	6
6	50FNST0Z	6



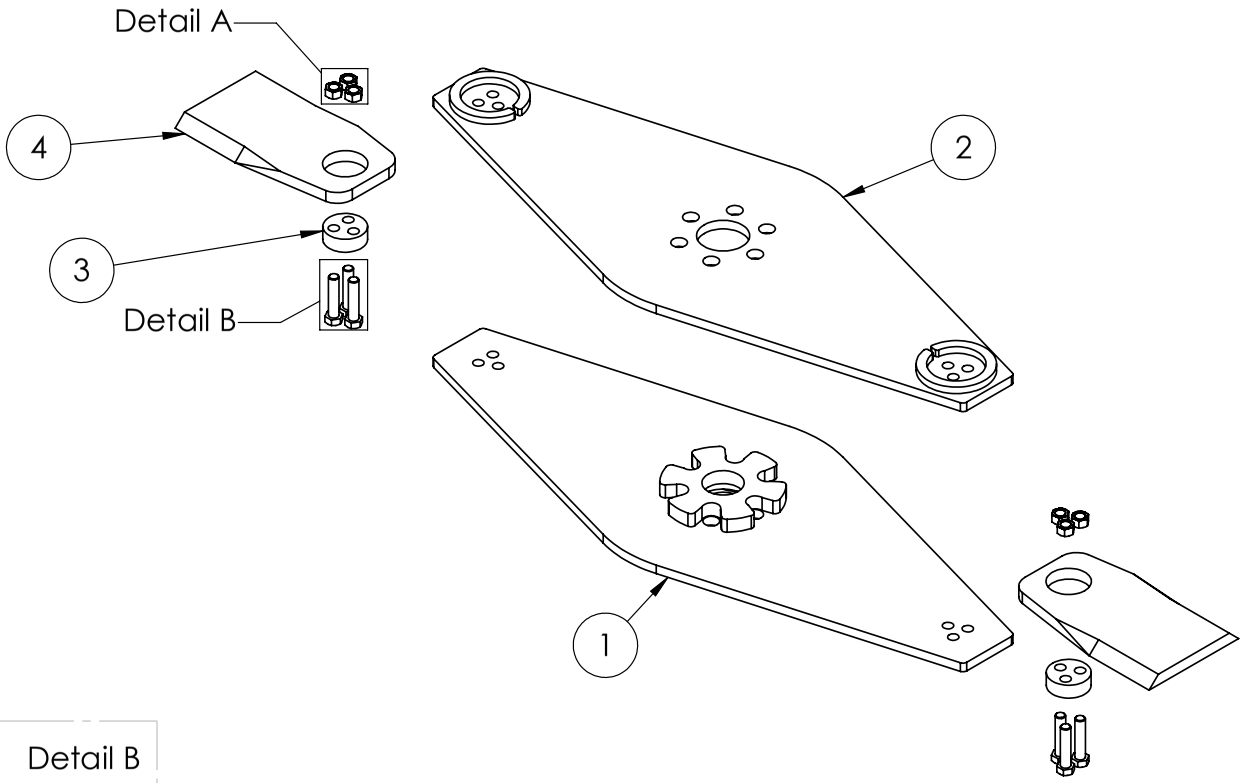
ITEM NO.	PART NUMBER	QTY.
1	SBC-2BLD-44-Bottom-Weldment	1
2	SBC-2BLD-44-Top-Weldment	1
3	-PI-REAPERBUSHING	2
4	20100056	2
5	50F225HCS9Y	6
6	50FNST0Z	6

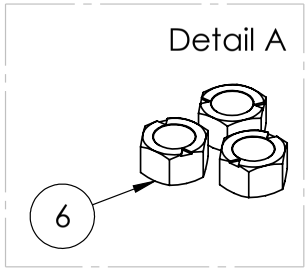
Single Welded Bolt Diagram - Call for Part Details

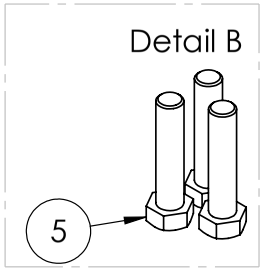
SINGLE WELDED BOLT DIAGRAM - CALL FOR PART DETAILS

ITEM	Part #	DESCRIPTION	QTY.
1	50100946	Bottom Blade Holder Weldment	1
2	50100956	Top Blade Holder Weldment	1
3	10400046	Blade Bushing	2
4	20100076	Blade	2
5	11200286	1/2"-20 x 2 1/4" Hex Bolt L9	6
6	11200296	1/2"-20 Lock Nut GR C	6

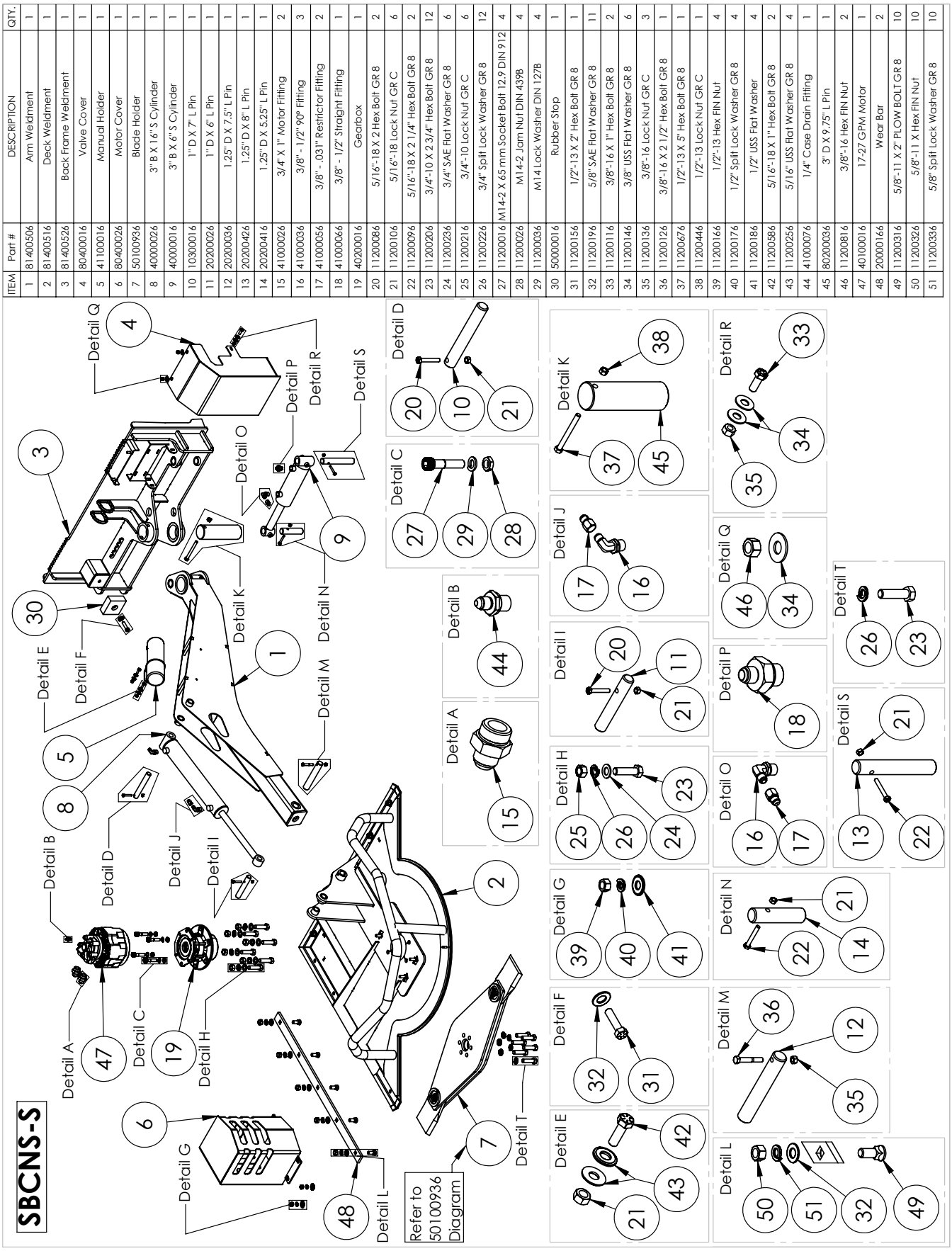
50100936



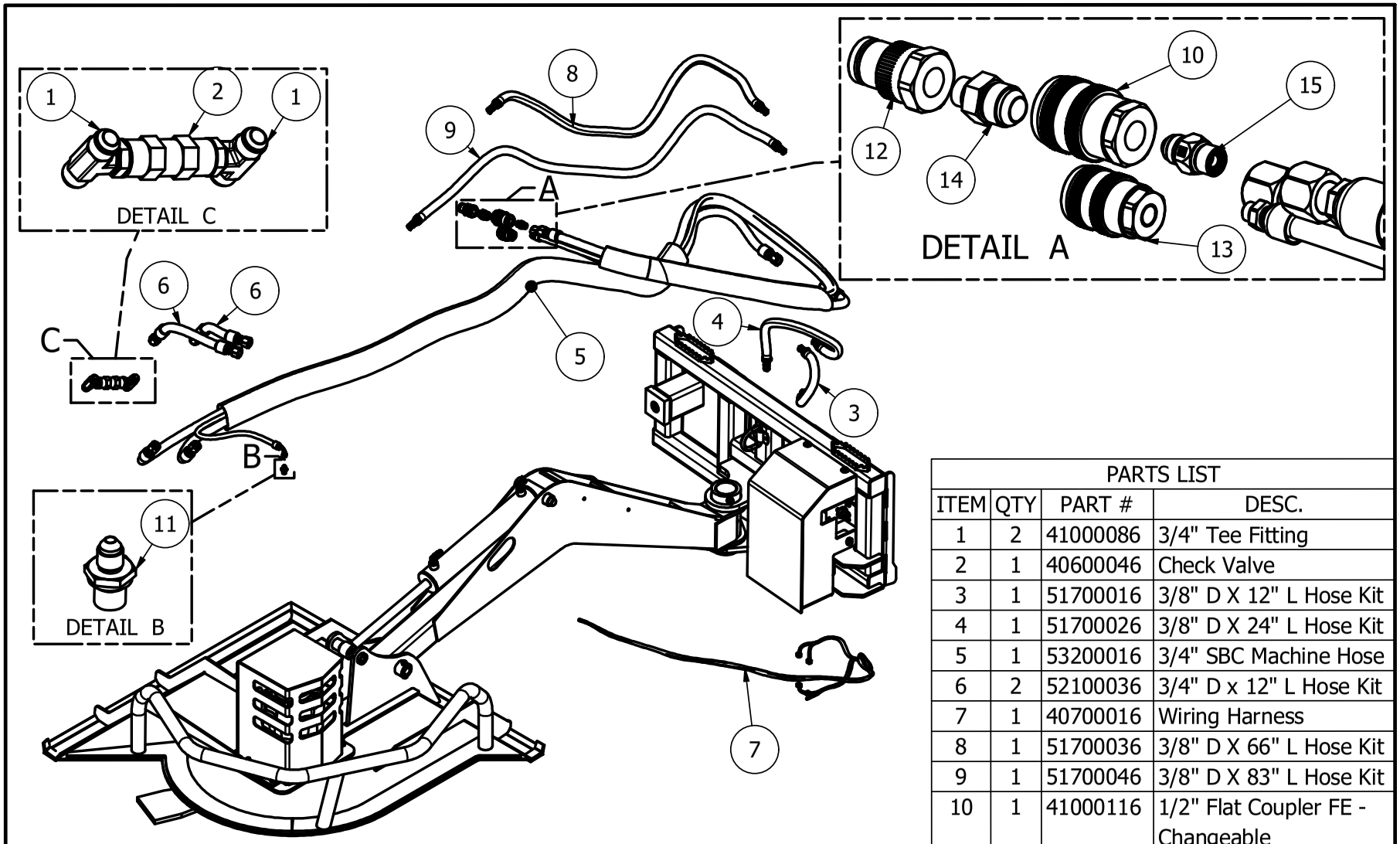




7.2 SBCNS DETAILED PARTS DIAGRAM WITH PART NUMBERS



ITEM	Part #	DESCRIPTION	QTY.
1	81400506	Arm Weldment	1
2	81400516	Deck Weldment	1
3	81400526	Back Frame Weldment	1
4	80400016	Valve Cover	1
5	41100016	Manual Holder	1
6	80400026	Motor Cover	1
7	50100936	Blade Holder	1
8	40000026	3" B X 16" S Cylinder	1
9	40000016	3" B X 6" S Cylinder	1
10	10300016	1" D X 7" L Pin	1
11	20200026	1" D X 6" L Pin	1
12	20200036	1.25" D X 7.5" L Pin	1
13	20200426	1.25" D X 8" L Pin	1
14	20200416	1.25" D X 5.25" L Pin	1
15	41000026	3/4" X 1" Motor Fitting	2
16	41000036	3/8" - 1/2" 90° Fitting	3
17	41000056	3/8" - .031" Restrictor Fitting	2
18	41000066	3/8" - 1/2" Straight Fitting	1
19	40200016	Gearbox	1
20	11200086	5/16"-18 X 2 Hex Bolt GR 8	2
21	11200106	5/16"-18 Lock Nut GR C	6
22	11200096	5/16"-18 X 2 1/4" Hex Bolt GR 8	2
23	11200206	3/4"-10 X 2 3/4" Hex Bolt GR 8	12
24	11200236	3/4" SAE Flat Washer GR 8	6
25	11200216	3/4"-10 Lock Nut GR C	6
26	11200226	3/4" Split Lock Washer GR 8	12
27	11200016	M14-2 X 65 mm Socket Bolt 12.9 DIN 912	4
28	11200026	M14-2 Jam Nut DIN 439B	4
29	11200036	M14 Lock Washer DIN 127B	4
30	50000016	Rubber Stop	1
31	11200156	1/2"-13 X 2" Hex Bolt GR 8	1
32	11200196	5/8" SAE Flat Washer GR 8	11
33	11200116	3/8"-16 X 1" Hex Bolt GR 8	2
34	11200146	3/8" USS Flat Washer GR 8	6
35	11200136	3/8"-16 Lock Nut GR C	3
36	11200126	3/8"-16 X 2 1/2" Hex Bolt GR 8	1
37	11200676	1/2"-13 X 5" Hex Bolt GR 8	1
38	11200446	1/2"-13 Lock Nut GR C	1
39	11200166	1/2"-13 Hex FIN Nut	4
40	11200176	1/2" Split Lock Washer GR 8	4
41	11200186	1/2" USS Flat Washer	4
42	11200586	5/16"-18 X 1" Hex Bolt GR 8	2
43	11200256	5/16" USS Flat Washer GR 8	4
44	41000076	1/4" Case Drain Fitting	1
45	80200036	3" D X 9.75" L Pin	1
46	11200816	3/8"-16 Hex FIN Nut	2
47	40100016	17-27 GPM Motor	1
48	20000166	Wear Bar	2
49	11200316	5/8"-11 X 2" PLOW BOLT GR 8	10
50	11200326	5/8"-11 X Hex FIN Nut	10
51	11200336	5/8" Split Lock Washer GR 8	10

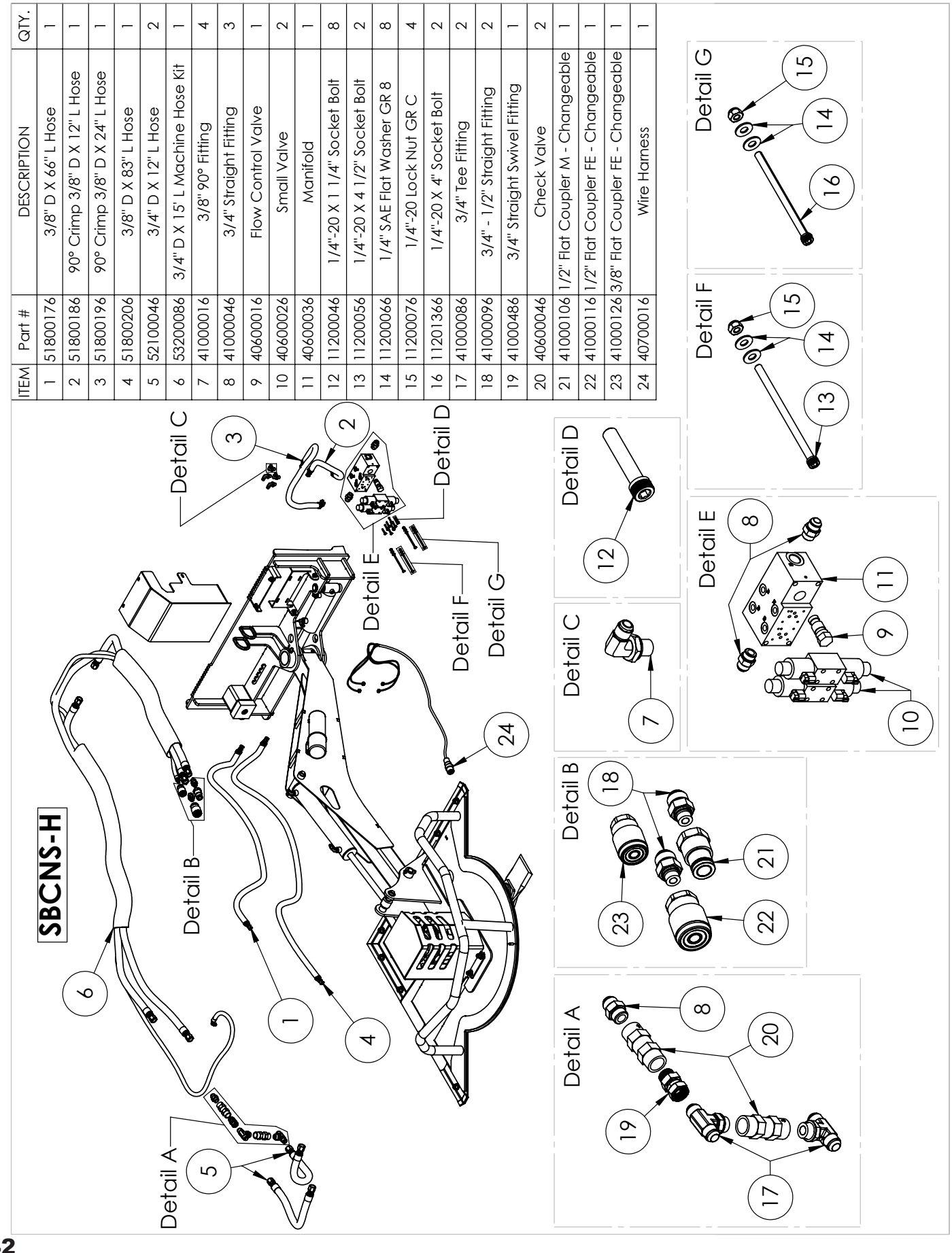


***** Use this diagram for SBCNS-S models *****
with the serial number before #428698

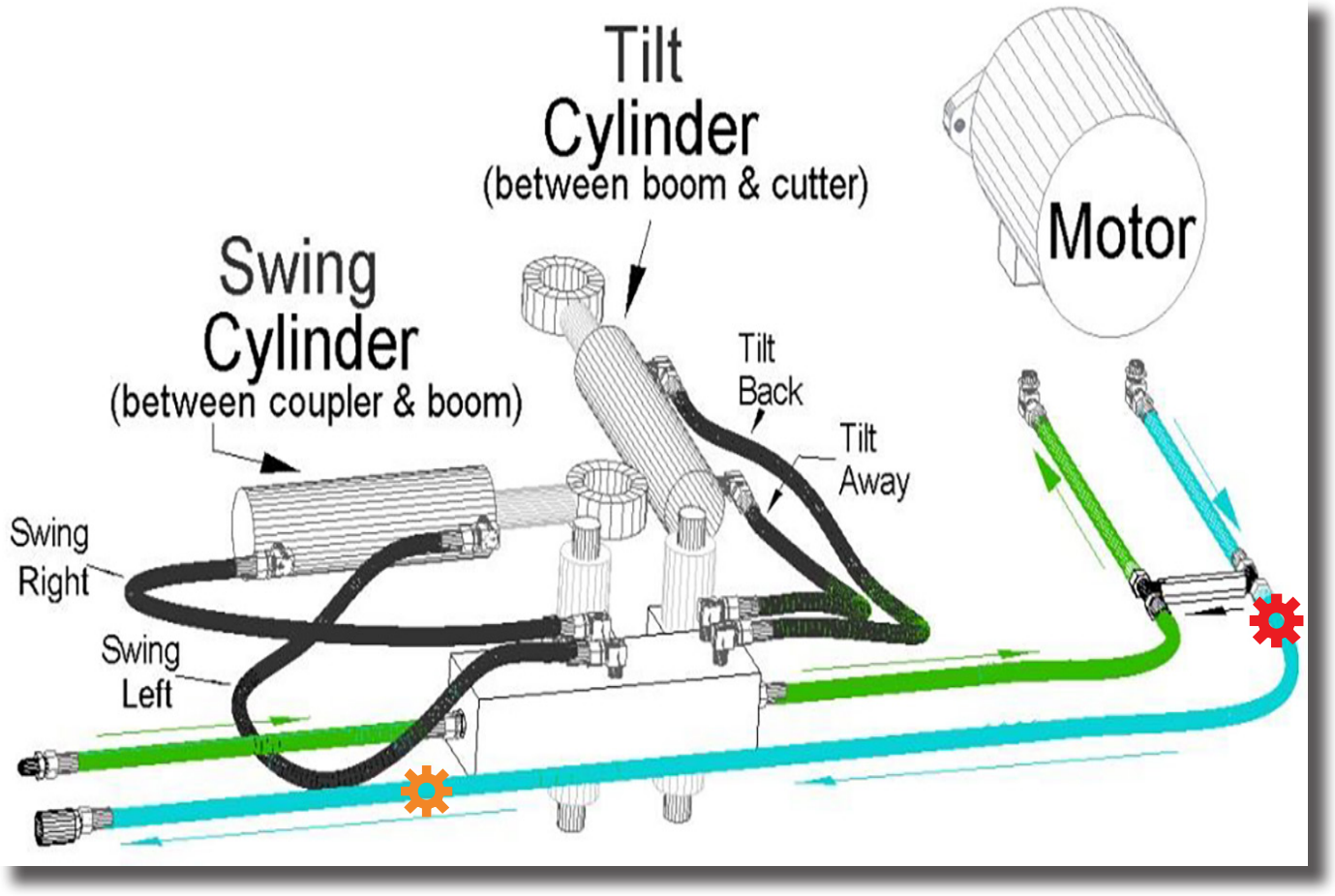
PARTS LIST			
ITEM	QTY	PART #	DESC.
1	2	41000086	3/4" Tee Fitting
2	1	40600046	Check Valve
3	1	51700016	3/8" D X 12" L Hose Kit
4	1	51700026	3/8" D X 24" L Hose Kit
5	1	53200016	3/4" SBC Machine Hose
6	2	52100036	3/4" D x 12" L Hose Kit
7	1	40700016	Wiring Harness
8	1	51700036	3/8" D X 66" L Hose Kit
9	1	51700046	3/8" D X 83" L Hose Kit
10	1	41000116	1/2" Flat Coupler FE - Changeable
11	1	41000076	1/4" Case Drain Fitting
12	1	41000106	1/2" Flat Coupler M - Changeable
13	1	41000126	3/8" Flat Coupler FE - Changeable
14	1	41000096	1 1/16" - 3/4" Fitting
15	1	40600056	3/4" Straight Fitting

7.4 SBCNS WITH HYDRAULICS PARTS DIAGRAM

ITEM	Part #	DESCRIPTION	QTY.
1	51800176	3/8" D X 66" L Hose	1
2	51800186	90° Crimp 3/8" D X 12" L Hose	1
3	51800196	90° Crimp 3/8" D X 24" L Hose	1
4	51800206	3/8" D X 83" L Hose	1
5	52100046	3/4" D X 12" L Hose	2
6	53200086	3/4" D X 15' L Machine Hose Kit	1
7	41000016	3/8" 90° Fitting	4
8	41000046	3/4" Straight Fitting	3
9	40600016	Flow Control Valve	1
10	40600026	Small Valve	2
11	40600036	Manifold	1
12	11200046	1/4"-20 X 1 1/4" Socket Bolt	8
13	11200056	1/4"-20 X 4 1/2" Socket Bolt	2
14	11200066	1/4" SAE Flat Washer GR 8	8
15	11200076	1/4"-20 Lock Nut GR C	4
16	11201366	1/4"-20 X 4" Socket Bolt	2
17	41000086	3/4" Tee Fitting	2
18	41000096	3/4" - 1/2" Straight Fitting	2
19	41000486	3/4" Straight Swivel Fitting	1
20	40600046	Check Valve	2
21	41000106	1/2" Flat Coupler M - Changeable	1
22	41000116	1/2" Flat Coupler FE - Changeable	1
23	41000126	3/8" Flat Coupler FE - Changeable	1
24	40700016	Wire Harness	1



7.5 PARTS DIAGRAM-HYDRAULIC CONNECTION & FLOW DIAGRAM

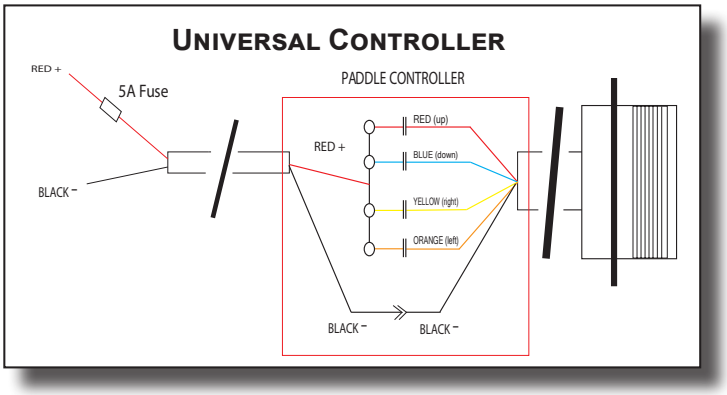


Depending on your model you'll have an inline check valve either here ⚙ **or here.** ⚙

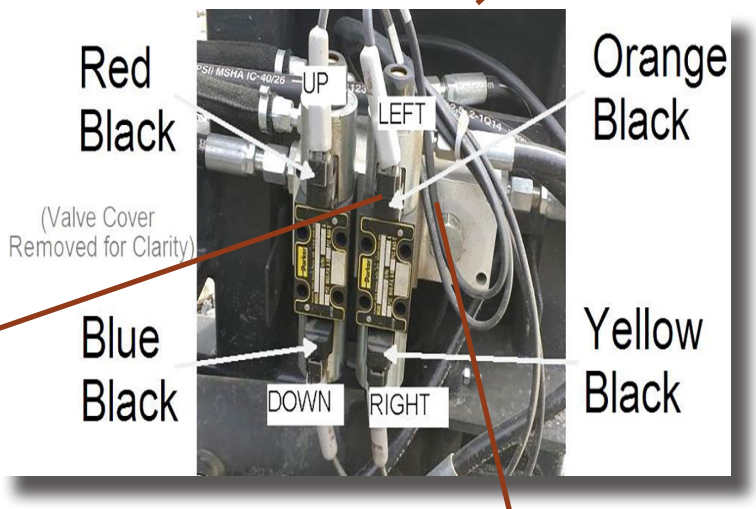
This valve protects your attachment from back flow.

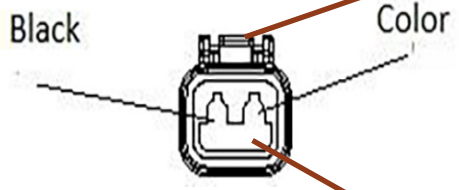
7.6 PARTS DIAGRAM-ELECTRICAL DIAGRAMS

ELECTRICAL DIAGRAMS



Valve Manifold on Cutter

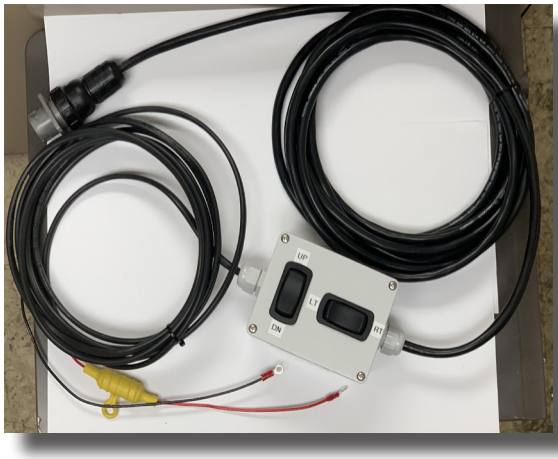




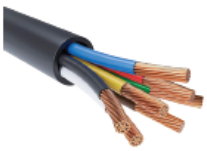
Attachment Harness



Universal Paddle Controller and Cable



Bulkhead coupler to 7 pin, 8 pin, or 14 pin wire harness to skid steer arm or bulk-head coupler to universal paddle control cable connected to 12V power source.



WIRE COLOR CODES
FOR ELECTRICAL HARNESS PINOUTS

ASV — 8 PIN
- A=BLACK (GROUND)
- B=ORANGE
- G=YELLOW
- C=BLUE
- D=RED

GEHL — 14 PIN
- B=BLACK
- C=ORANGE
- D=YELLOW
- E=RED
- F=BLUE

NEW HOLLAND — 14 PIN
- B=BLACK
- C=ORANGE (LEFT)
- D=YELLOW (RIGHT)
- E=BLUE (DOWN)
- F=RED (UP)

TAKEUCHI — 14 PIN
- B=BLACK
- C=RED
- E=YELLOW
- D=BLUE
- F=ORANGE

Kubota — 14 PIN
- B=BLACK (GOUND)
- C=RED
- D=BLUE
- G=YELLOW
- H=ORANGE
- E=MOMENTARY HOT
- F=MOMENTARY HOT

Bobcat — S MODELS 14 PIN
- B=BLACK
- E=ORANGE
- F=YELLOW
- G=BLUE
- H=RED

CAT — D MODELS 14 PIN
- B=BLACK
- F=BLUE
- E=RED
- C=YELLOW
- D=ORANGE
- J=MOMENTARY HOT
- K=MOMENTARY HOT

CASE — 14 PIN
- B=BLACK
- C=ORANGE
- D=YELLOW
- E=BLUE
- F=RED

KIOTI — 14 PIN
- B=BLACK (GROUND)
- C=RED (UP)
- D=BLUE (DOWN)
- G=ORANGE (LEFT)
- H=YELLOW (RIGHT)
- E=MOMENTARY HOT
- F=MOMENTARY HOT

JCB — 14 PIN
- B=BLACK
- C=RED
- D=BLUE
- E=YELLOW
- F=ORANGE

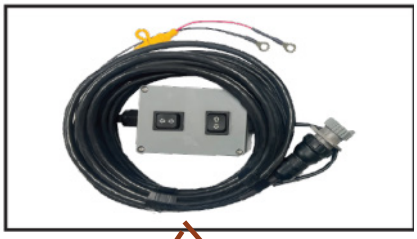
ASV — 14 PIN
- C=RED
- D=BLUE
- E=ORANGE
- F=YELLOW
- B=BLACK

JOHN DEERE — G OR D MODELS 14 PIN
- A=BLACK
- C=RED
- D=BLUE
- E=YELLOW
- G=ORANGE



7 Pin Harness

Electrical Control Diagram





Universal Wiring Harness



8 & 14 Pin Harness

SECTION 8

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.

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/

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

SECTION 9

SAFETY ACKNOWLEDGMENT

ATTENTION ALL OPERATORS: Print your name, sign and date in the boxes below to acknowledge that you have read and fully understand the safety instructions presented in this manual, and have been trained on how to safely operate this attachment.

OPERATOR NAME	SIGNATURE	DATE

SECTION 10

MAINTENANCE LOGSHEETS

Use this log sheet to document all routine maintenance and repair services performed on this machine.

DESCRIPTION OF MAINTENANCE/REPAIR	SERVICED BY:	DATE:

APPENDIX A

WELDED 1-1/2" BOLT BLADE REMOVAL

NOTICE

This procedure requires special tools and skills. DO NOT attempt to remove or sharpen blades if you do not have the tools or skills. Take your cutter to your local dealer for blade services.

⚠ CAUTION

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

BLADE REMOVAL PROCEDURE

1. Remove the blade holder as described in Section 4.6 of this manual.

2. Use a cutting torch or grinder with a cut off wheel to remove the weld bead around the bolt head. DO NOT cut into the blade holder. (See Figure A1 below)

⚠ CAUTION

Wear proper protective equipment while using a cutting torch and grinder tool to prevent injuries from flying hot metal pieces. DO NOT use a cutting torch during windy conditions or near dry vegetation to prevent a catastrophic brush fire.

3. After carefully cutting the weld bead around the bolt head to allow the bolt to rotate, use a wrench to turn the bolt until loose from nut.

4. Drive the bolt shank from the blade and blade holder, being careful not to let the blade fall onto your feet.

5. Repeat steps 2-4 for the second bolt.

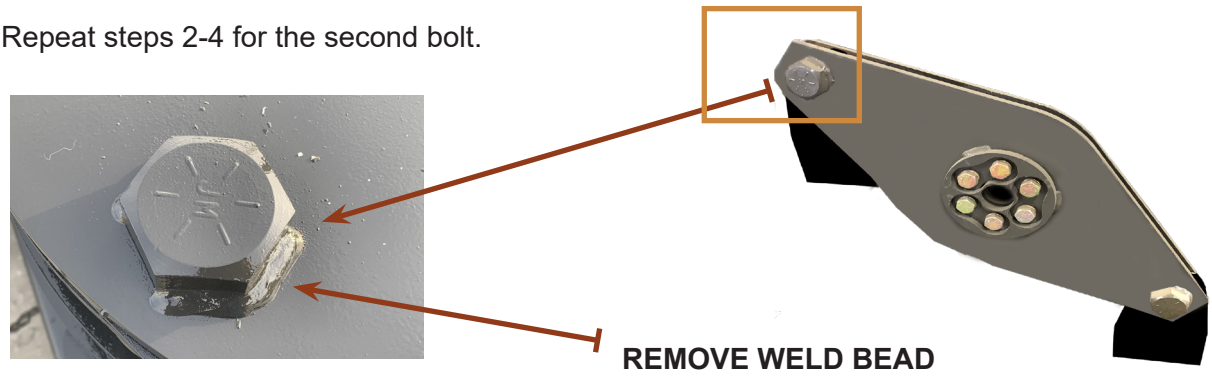


Figure A1 Blade Holder Bolt Weld Bead Removal

A. WELDED 1-1/2" BOLT BLADE REMOVAL

BLADE INSTALLATION PROCEDURE

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.

1. Completely remove the old weld bead to ensure a flat smooth surface for the new bolt head to mate to.
2. Place nut in the recessed hole on top of blade holder and insert blade with bushing in between top and bottom plates so the bushing hole aligns with the plate holes..
3. Insert new blade bolt up through the holes in the blade holder and bushing and tighten into the nut.
4. Torque the blade bolt to the value shown in the torque table on page 26 of this manual.
5. Weld the outside of the bolt head as shown in Figure A1 on page 51.

NOTICE

The blade bolt threads should be flush with the nut or slightly beyond the nut, with the nut seated flush in the recessed hole.

⚠WARNING

DO NOT weld the bolt head unless the nut is firmly seated into the recessed hole. ***See Figure A2 below*.**



Figure A2 Bolt Thru Nut

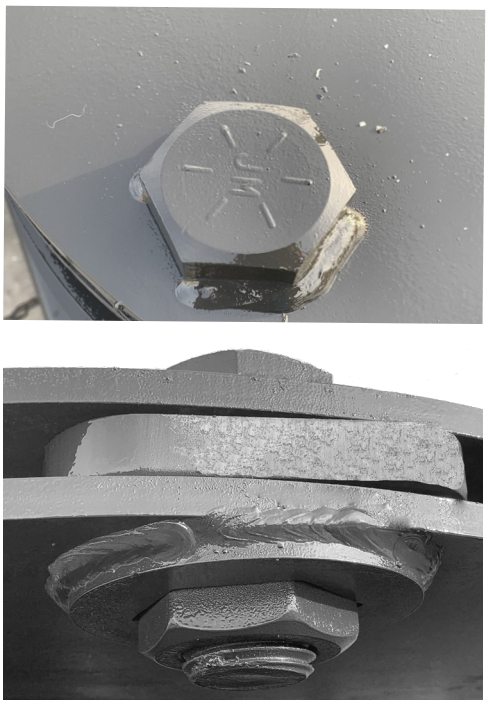


Figure A3 Bolt Head Bead Weld & Assembly

APPENDIX B

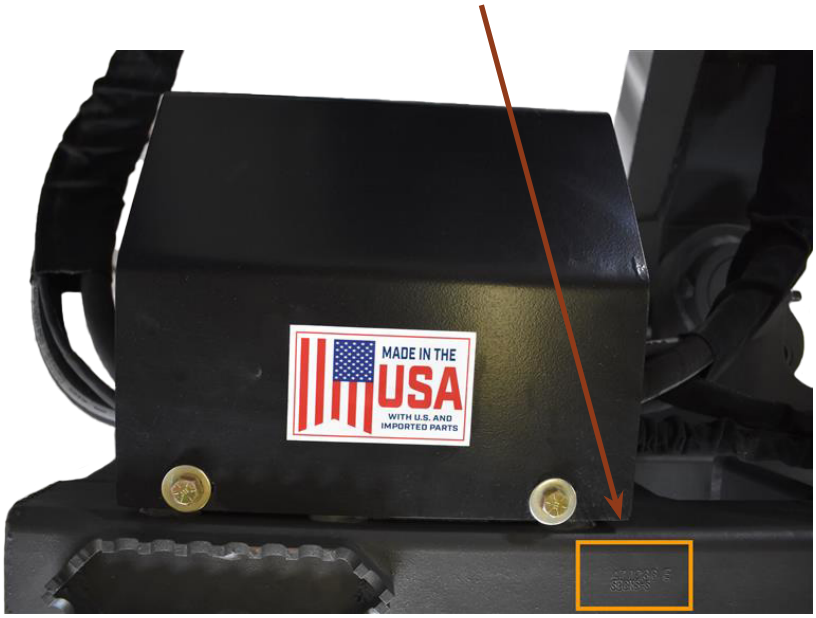
FINDING YOUR MODEL AND SERIAL NUMBER

The Model and Serial numbers will be in one of (4) places and will either be etched into the attachment or on a Data Plate.

Instructions: Stand at the back of the attachment facing the attachment mounting bracket and look in the following locations:

2) Top- left or right

3) Back-left or right



PLEASE NOTE: The Model and Serial number may be etched or on a Data Plate.

Disclaimer: Any critical changes made to this manual by individuals outside the manufacturer's authorized personnel are doing so at their own risk. The manufacturer cannot be held legally responsible for any consequences, damages, or liabilities resulting from such modifications. It is advised to adhere strictly to the original manual provided by the manufacturer for optimal performance, safety, and reliability.

IRONCRAFT

7 ROCKY MT RD

Athens, Tennessee 37303

(P) 423-405-5150

(F) 423-405-5904

WWW.IRONCRAFTUSA.COM

FARM EQUIPMENT MANUFACTURERS ASSOCIATION
FEMA

Revised August 2026
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