

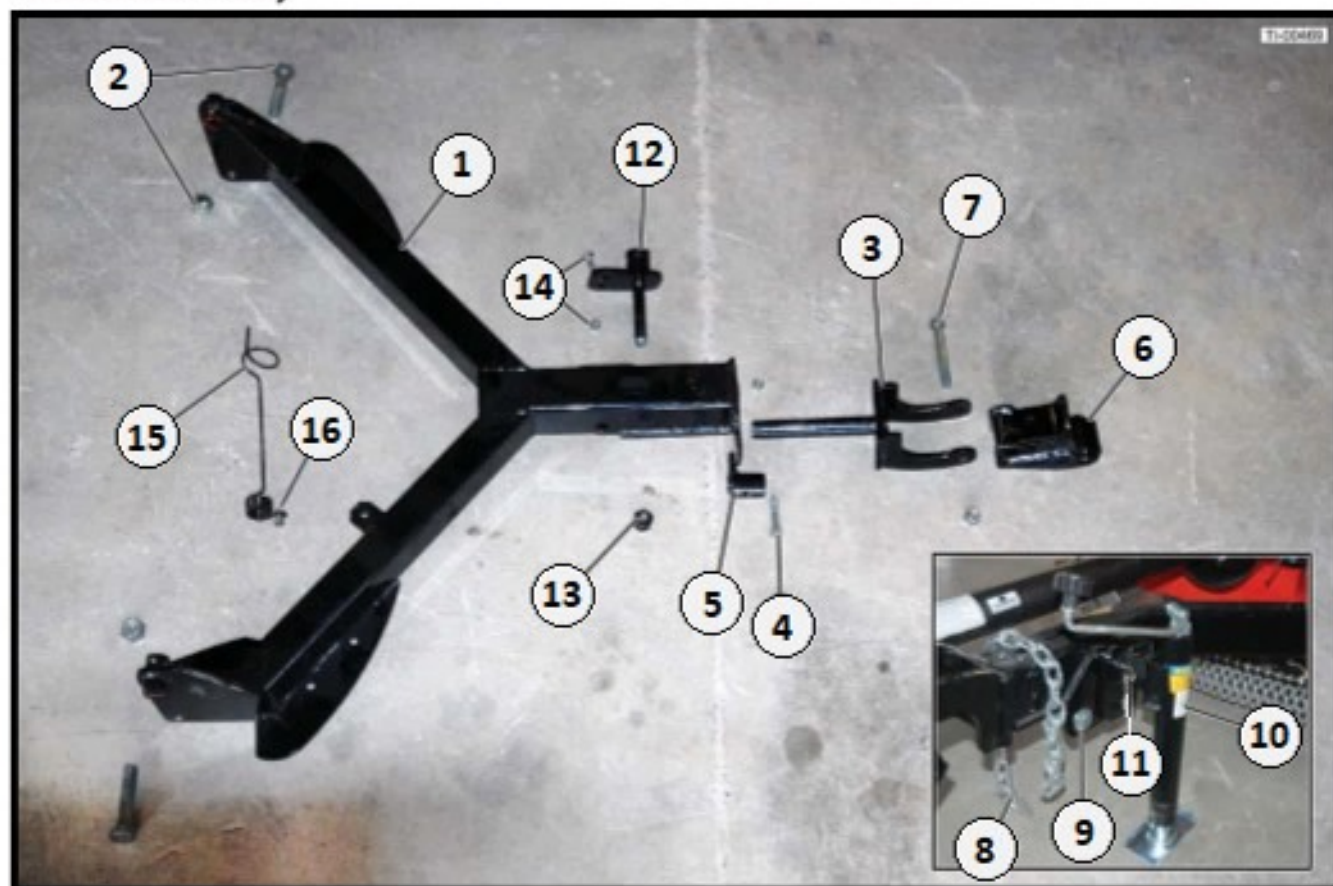
# IRONCRAFT

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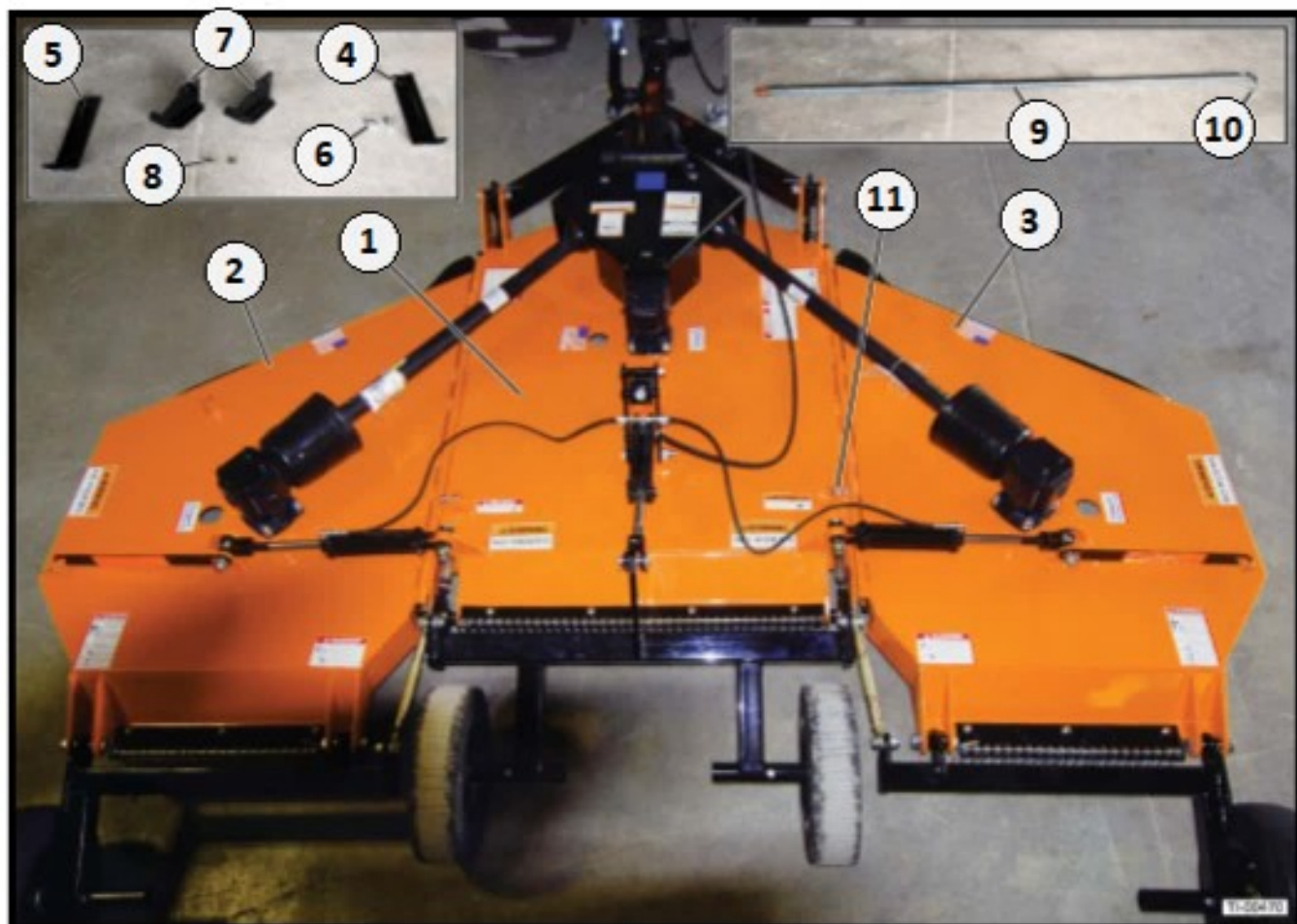


# 1912 SERIES 12-FT FLEX WING CUTTER PARTS MANUAL

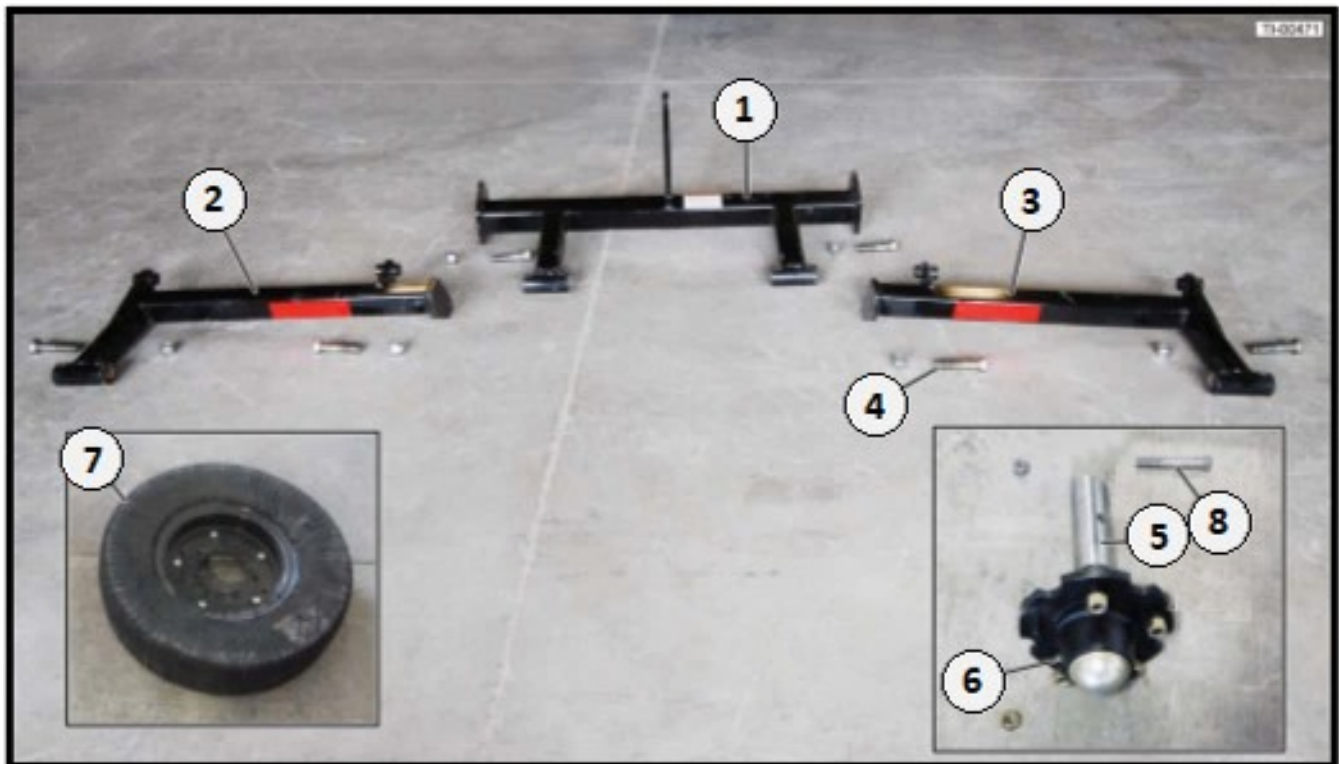
## 12.1 Hitch Assembly



Item	Part #	Description	Qty
1	191208	Hitch Frame	1
2	920006	Bolt & Locknut Kit 1"-8 x 4-1/2"	2
3	191211	Receiver Swivel	1
4	191213	Bolt & Locknut Kit 1/2"x 2-1/2"	1
5	191212	Swivel Sleeve	1
6	191214	Swivel Head	1
7	150047	Bolt & Locknut Kit 3/4"x 6"	2
8	191526	Safety Chain	1
9	110071	Bolt & Locknut Kit 5/8"x 2-1/2"	1
10	180024	Jack Stand	1
11	180025	Jack Stand Pin	1
12	191215	Jack Pivot Plate Adjuster	1
13	191256	Locknut 3/4" for Adjuster	1
14	120011	Carriage Bolt & Nut Kit 1/2"x1-1/2" (6-Pack)	1
15	191209	Hose Holder Spring	1
16	191210	Bolt & Locknut Kit 1/2"x1-1/2"	1

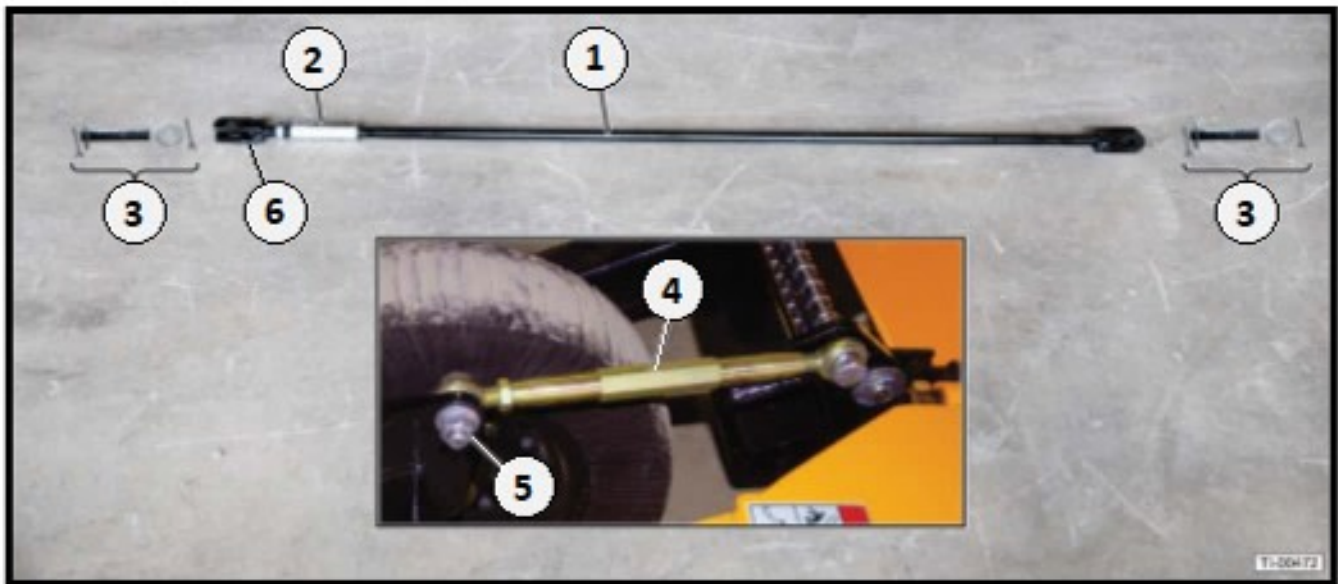


Item	Part #	Description	Qty
1	191260	12-ft Center Deck Only with Decals - BLUE	1
	191261	12-ft Center Deck Only with Decals - GREEN	
	191262	12-ft Center Deck Only with Decals - GREY	
	191263	12-ft Center Deck Only with Decals - ORANGE	
	191264	12-ft Center Deck Only with Decals - RED	
	191265	12-ft Center Deck Only with Decals - YELLOW	
	191382	12-ft Center Deck Only with Decals - BLACK	
2	191266	12-ft Left Wing Deck Only with Decals - BLUE	1
	191267	12-ft Left Wing Deck Only with Decals - GREEN	
	191268	12-ft Left Wing Deck Only with Decals - GREY	
	191269	12-ft Left Wing Deck Only with Decals - ORANGE	
	191270	12-ft Left Wing Deck Only with Decals - RED	
	191271	12-ft Left Wing Deck Only with Decals - YELLOW	
	191383	12-ft Left Wing Deck Only with Decals - BLACK	
3	191272	12-ft Right Wing Deck Only with Decals - BLUE	1
	191273	12-ft Right Wing Deck Only with Decals - GREEN	
	191274	12-ft Right Wing Deck Only with Decals - GREY	
	191275	12-ft Right Wing Deck Only with Decals - ORANGE	
	191276	12-ft Right Wing Deck Only with Decals - RED	
	191277	12-ft Right Wing Deck Only with Decals - YELLOW	
	191384	12-ft Right Wing Deck Only with Decals - BLACK	
4	191241	Skid Shoe - Left	1
5	191242	Skid Shoe - Right	1
6	120011	Carriage Bolt & Locknut Kit 1/2"x 1-1/2" (6-Pack)	1
7	191232	Skid Shoe - Center	2
8	120011	Carriage Bolt & Locknut Kit 1/2"x 1-1/2" (6-Pack)	4
9	191233	Center / Wing Connector Rod	2
10	191234	Bolt & Locknut Kit 3/8"x 1-1/2" for Conn. Rod	2
11	110015	Bolt & Locknut Kit 5/8"x 2" for Wing Stop Adj.	2



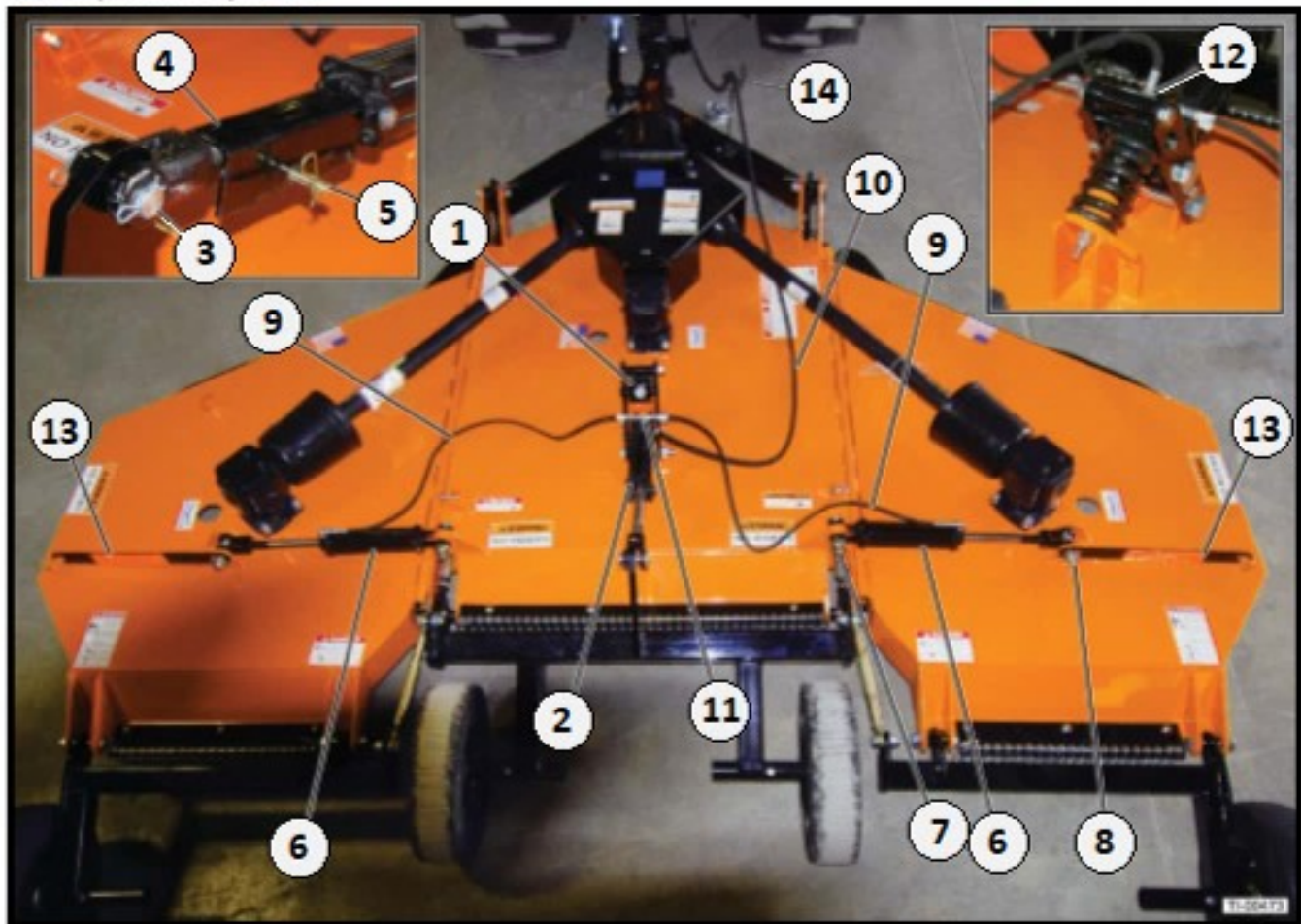
Item	Part #	Description	Qty
1	191244	Center Tailwheel Tube	2
2	191245	Left Tailwheel Tube	1
3	191246	Right Tailwheel Tube	1
4	920006	Bolt & Locknut Kit 1"-8 x 4-1/2"	6
5	180038	Tailwheel Hub / Spindle Assembly	4
6	110021	Zerk Fitting	4
7	180040	Laminated Wheel 20"	4
	191380	Aircraft Tire 26 x 6.6 x 10 (Not Shown)	4
8	180039	Bolt & Locknut Kit 1/2"x 3-1/2"	4

## 12.4 Leveling Rods & Turnbuckles



Item	Part #	Description	Qty
1	191228	Leveling Rod 56.50"	2
2	191229	Leveling Rod Adjuster	2
3	191230	Pin, Washers & Cotter pin Kit – for Leveling Rod	4
4	191231	Turnbuckle	2
5	110070	Bolt & Locknut Kit 5/8"x 2-1/2" for Turnbuckle	4
6	191283	Short Leveling Rod 5.75"	2

## 12.5 Hydraulic System

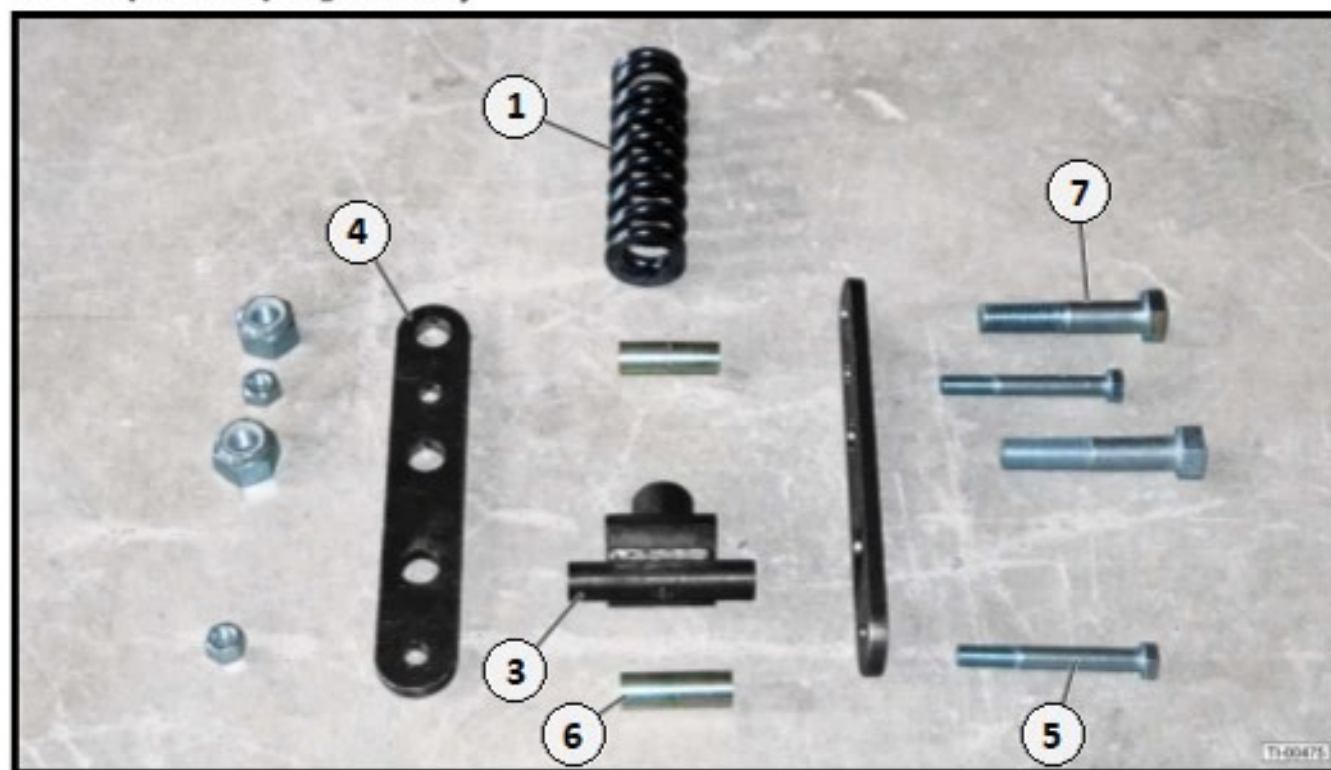


Item	Part #	Description	Qty
1	191217	*Suspension Spring Assembly	1
2	191225	Hydraulic Lift Cylinder	1
3	191529	Cyl. Pin & Hairpin Kit – 3-1/2"	1
4	191531	Cyl. Transport Lock Bracket	1
5	310034	Pin with Clip – for Transport Lock Brkt.	1
6	191226	Hydraulic Wing Cylinder	2
7	191539	Cyl. Pin (Inside 5") – for Wing Cyl.	2
8	191240	Cyl. Pin (Outside 5-1/2") – for Wing Cyl.	2
9	191236	Hydraulic Hose 57" – for Wing Lift	2
10	191237	Hydraulic Hose 144" – for Main Lift	1
11	191238	Hyd. Tee	2
12	191239	Flow Restrictor 3/8"	2
13	191227	Wing Fold Lock Bar with Clip	2
14	191209	Spring Hose Holder	1

\*For Parts see separate page

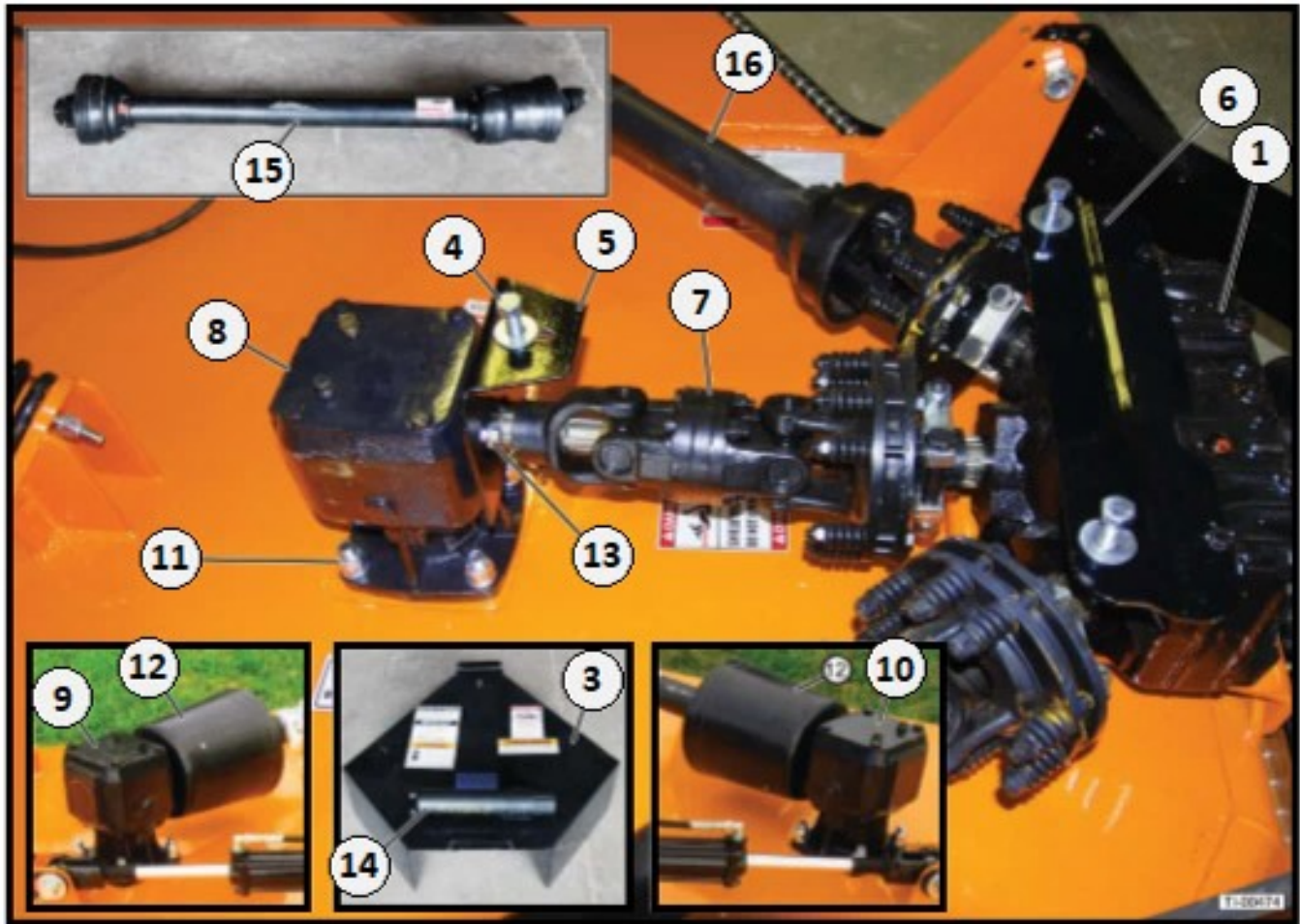
### 191290 Complete Hyd. Hose & Fitting Kit

## 12.6 Suspension Spring Assembly



Item	Part #	Description	Qty
--	191217	Suspension Spring Assy (Includes Items 1 thru 7)	1
1	191218	Spring	1
2	191219	Bolt, Washer & Locknut Kit 1/2"x 9" – for Spring Not Shown	1
3	191220	Spring Hold Down Bracket	1
4	191221	Spring Arm Bracket	2
5	191222	Bolt & Locknut Kit 5/8"x 5-1/2" – for Spring Bracket	2
6	191223	Spacer 3-1/2" – for Bracket Bolt	2
7	191224	Bolt & Locknut Kit 1" x 6" for Spring Arm Bracket	2

## 12.7 Driveline

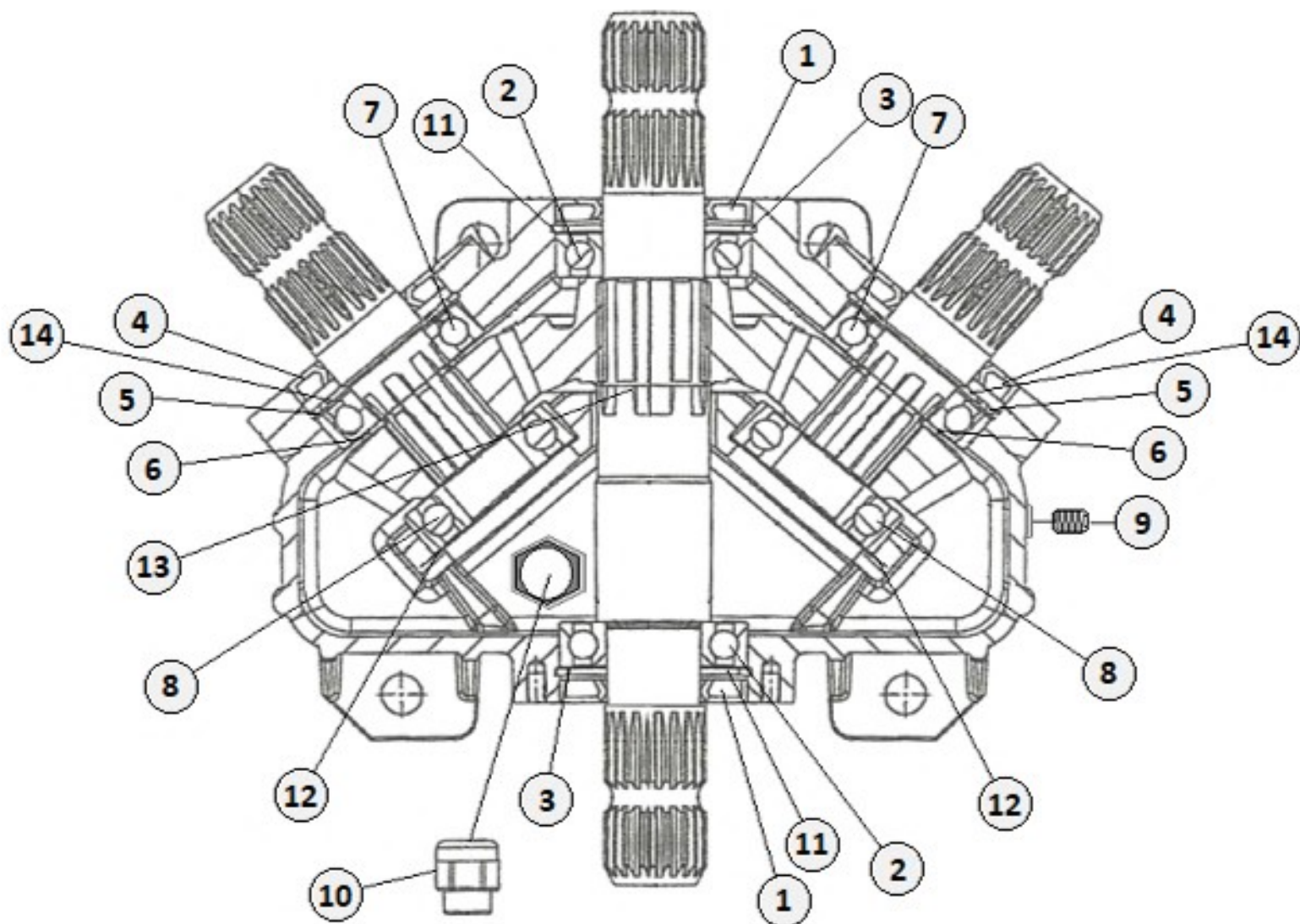


Item	Part #	Description	Qty
1	191501	Splitter Gearbox – 540 RPM	1
2	110004	*Bolt, Lockwasher & Locknut Kit 5/8" x 2" – for Splitter G/Box	4
3	191200	Shield – for Splitter Gearbox	1
4	110069	Bolt Kit 1/2" x 2" – for Splitter G/Box Shield	4
5	191201	Rear Shield Brkt. – for Splitter G/Box	1
6	191202	Front Shield Brkt. – for Splitter G/Box	1
7	191203	Splitter Cross Shaft	1
8	191204	Gearbox – Center Outboard 540 RPM	1
9	191204	Gearbox – Left Outboard 540 RPM	1
10	191206	Gearbox – Right Outboard 540 RPM	1
11	110071	Bolt, Lockwasher & Locknut Kit 5/8" x 2-1/2" – for Outboard G/box	12
12	120001	Shield – for Outboard G/Boxes	3
13	110006	Bolt & Washer Kit 5/16" x 1/2" – for Outboard G/Box Shield (4-Pack)	3
14	110034	Document Holder with Screws	1
15	191255	C.V. Driveline	1
16	191254	Driveline – for LH & RH Wing	2

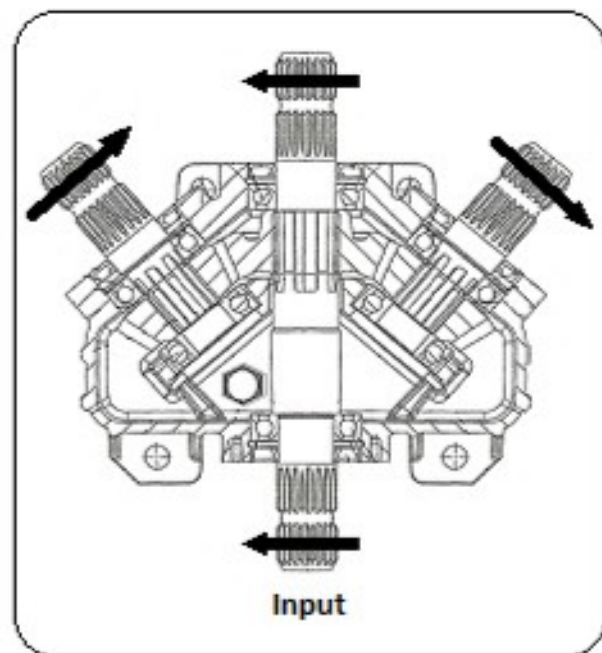
\*Not Shown



# 540-RPM SPLITTER GEARBOX COMPONENTS



Item	Part #	Description	Qty
1	551060	Input Oil Seal 45 x 85 x 10	2
2	551061	Input Bearing 6209 – for Thru Shaft	2
3	551062	Snap Ring 85 x 88.5 x 3	2
4	551063	Output Seal 45 x 80 x 10	2
5	551064	Snap Ring 80 x 83.5 x 2.5	2
6	551065	Snap Ring 40 x 37.5 x 2.5	2
7	551066	Bearing 6208	2
8	551067	Bearing 6307	2
9	551068	Check Plug 3/8"	2
10	551069	Breather Plug 1/2"	1
11	551070	Shim Kit 70.3 x 84.7	2
12	551071	Shim Kit 69.0 x 79.9	2
13	551073	Snap Ring 47 x 45.5 x 1.5	1
14	551072	Shim Kit 65.3 x 79.7	2



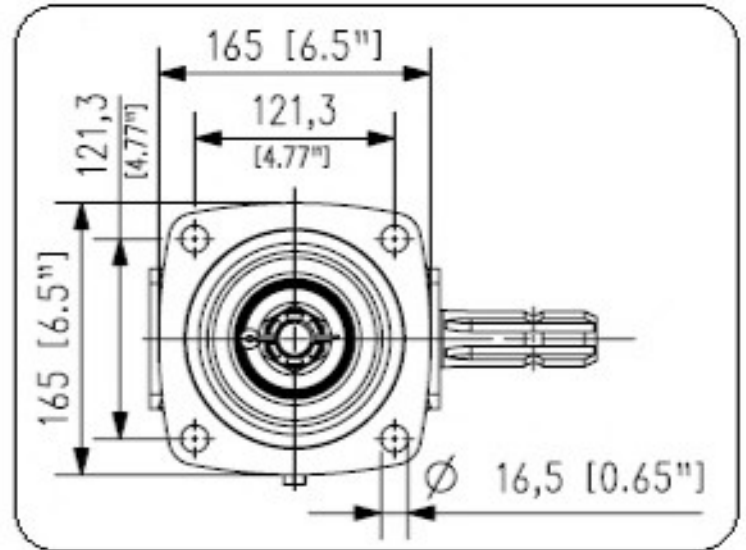
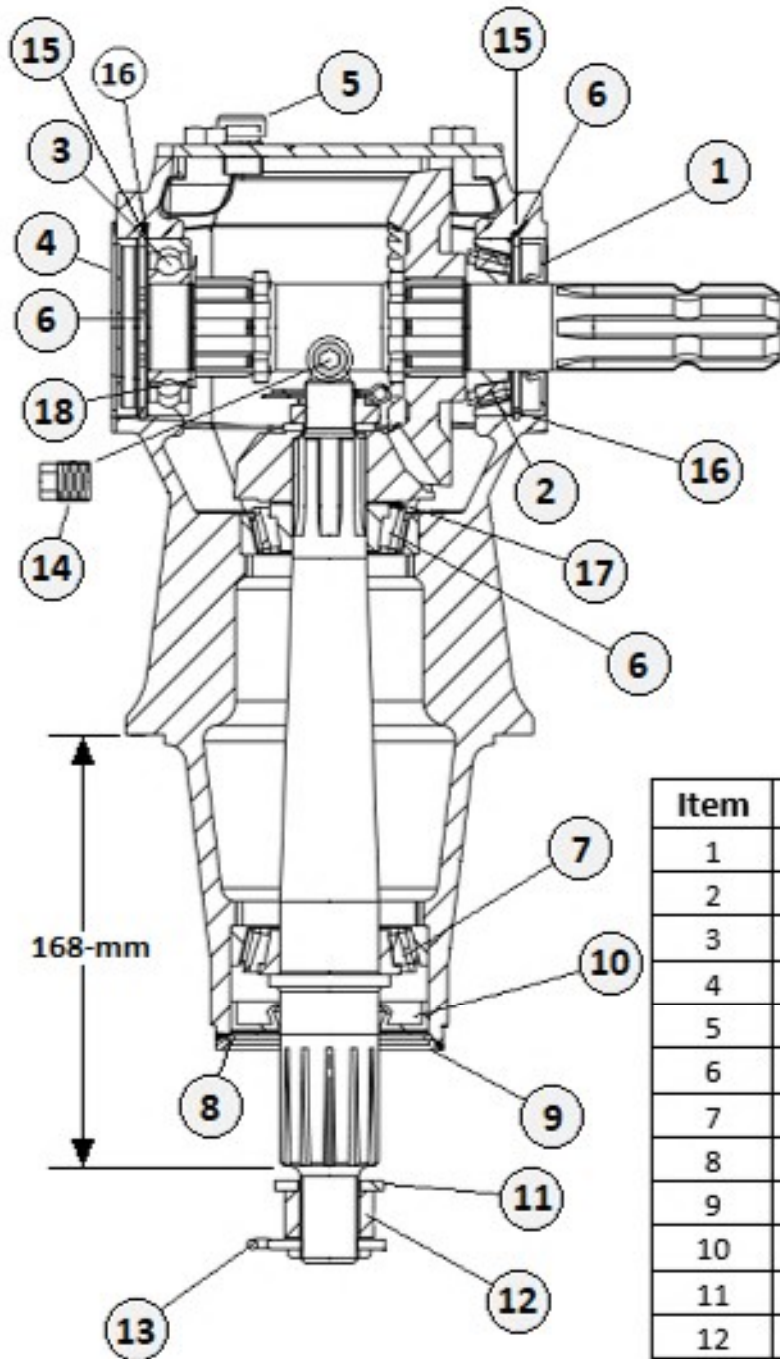
**191501 - COMPLETE GEARBOX 540-RPM**

**140 (ISO 460) Gearoil Recommended**  
**Fill level 61-oz. (1.83-qt)**

# OUTBOARD GEARBOX COMPONENTS

## Center Deck / Left Wing Deck

(Comer 9.240.802.00)



Item	Part #	Description	Qty
1	551080	Input Seal 35 x 72 x 10	1
2	551081	Input Bearing 30207 – Front	1
3	551082	Input Bearing 6207 – Rear	1
4	551083	Oil Cap Plug 72 x 10	1
5	551084	Breather Plug 3/8"	1
6	551085	Output Bearing 30306 – Top	1
7	551086	Output Bearing 30208 – Bottom	1
8	551087	Protective Flat Washer	1
9	551088	Snap Ring 81 x 82.8 x 2	1
10	551089	Output Seal 40 x 80 x 12	1
11	551090	Flatwasher 25 x 44 x 4	1
12	551091	Castle Nut M24 x 2	1
13	551092	Cotter Pin M5 x 50	1
14	551093	Oil Plug 3/8"	1
15	551094	Snap Ring 72 x 75 x 2.5	2
16	551096	Shim Kit 60.3 x 71.7	2
17	551095	Shim Kit 30.3 x 44	1
18	551097	Shim 35.3 x 48 x 2	1

140 (ISO 460) Gearoil Recommended  
Fill level 86-oz. (2.58-Qt)

## 191204 - Complete Gearbox

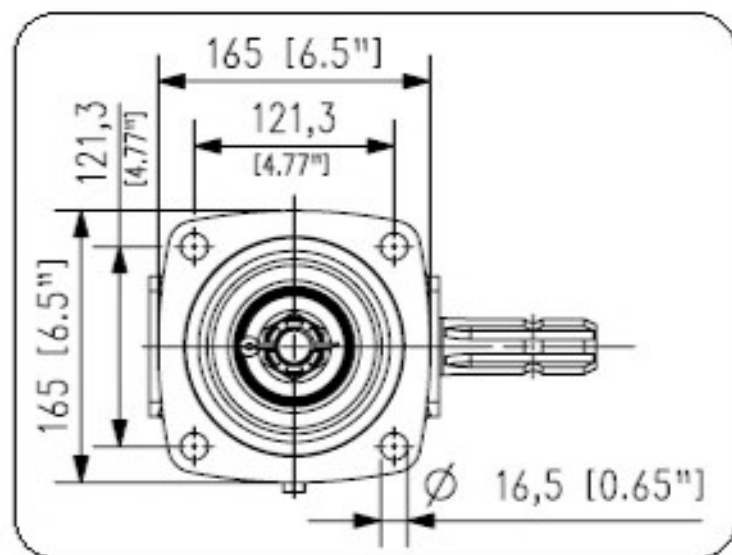
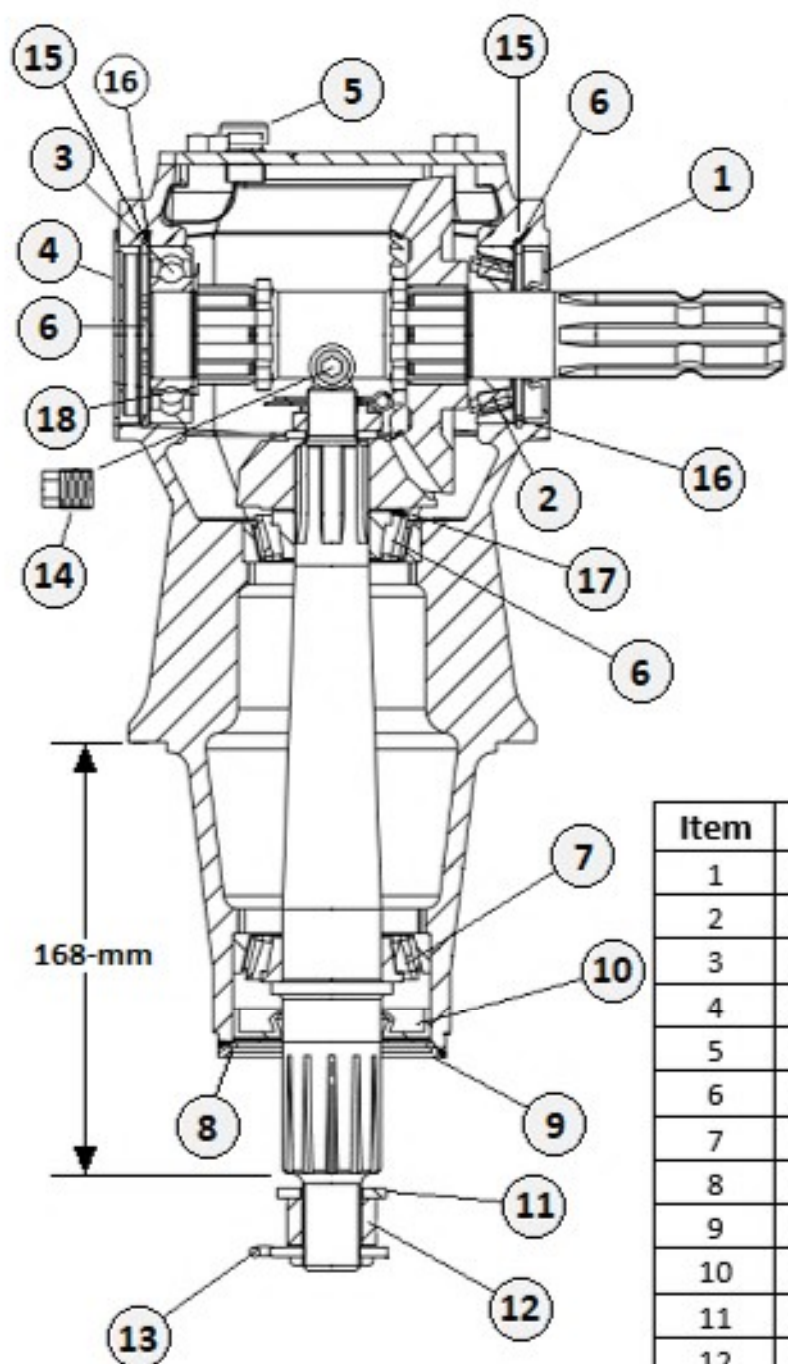
(Comer 9.240.802.00)

Note: Production Models stopped using 02-22-21

# OUTBOARD BEARBOX COMPONENTS

## RH - Wing Deck

(Comer 9.240.805.00)



Item	Part #	Description	Qty
1	551080	Input Seal 35 x 72 x 10	1
2	551081	Input Bearing 30207 – Front	1
3	551082	Input Bearing 6207 – Rear	1
4	551083	Oil Cap Plug 72 x 10	1
5	551084	Breather Plug 3/8"	1
6	551085	Output Bearing 30306 – Top	1
7	551086	Output Bearing 30208 – Bottom	1
8	551087	Protective Flat Washer	1
9	551088	Snap Ring 81 x 82.8 x 2	1
10	551089	Output Seal 40 x 80 x 12	1
11	551090	Flatwasher 25 x 44 x 4	1
12	551091	Castle Nut M24 x 2	1
13	551092	Cotter Pin M5 x 50	1
14	551093	Oil Plug 3/8"	1
15	551094	Snap Ring 72 x 75 x 2.5	2
16	551096	Shim Kit 60.3 x 71.7	2
17	551095	Shim Kit 30.3 x 44	1
18	551097	Shim 35.3 x 48 x 2	1

140 (ISO 460) Gearoil Recommended  
Fill level 86-oz. (2.58-Qt)

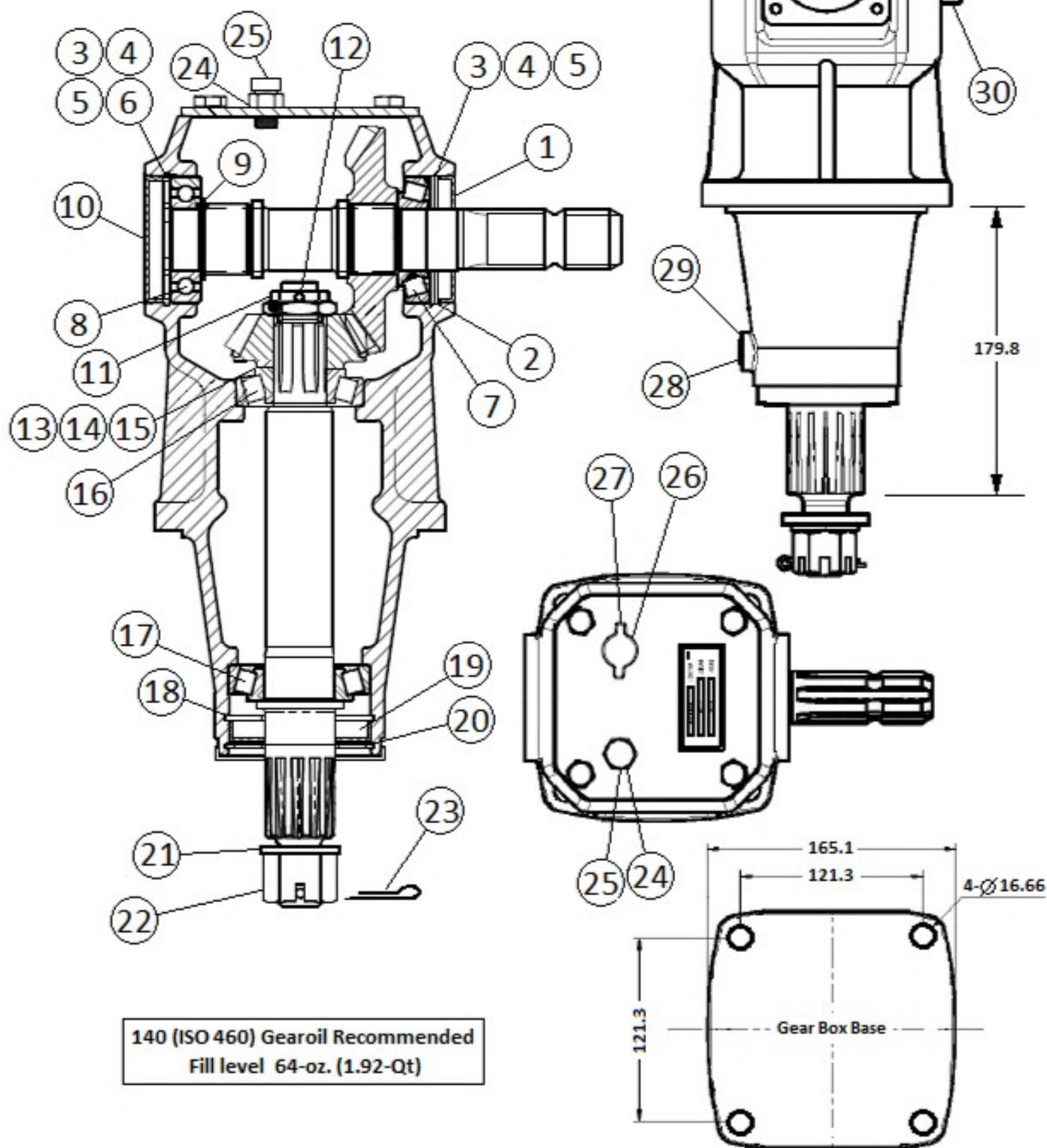
## 191206 - Complete Gearbox

(Comer 9.240.805.00)

Note: Production Models stopped using 02-22-21

**Center & LH Wing Gearbox #191304 (RG40-A)  
RH Wing Gearbox #191306 (RG40-O)**

**Note: Production Models Started using 02-22-21**



**140 (ISO 460) Gearoil Recommended  
Fill level 64-oz. (1.92-Qt)**

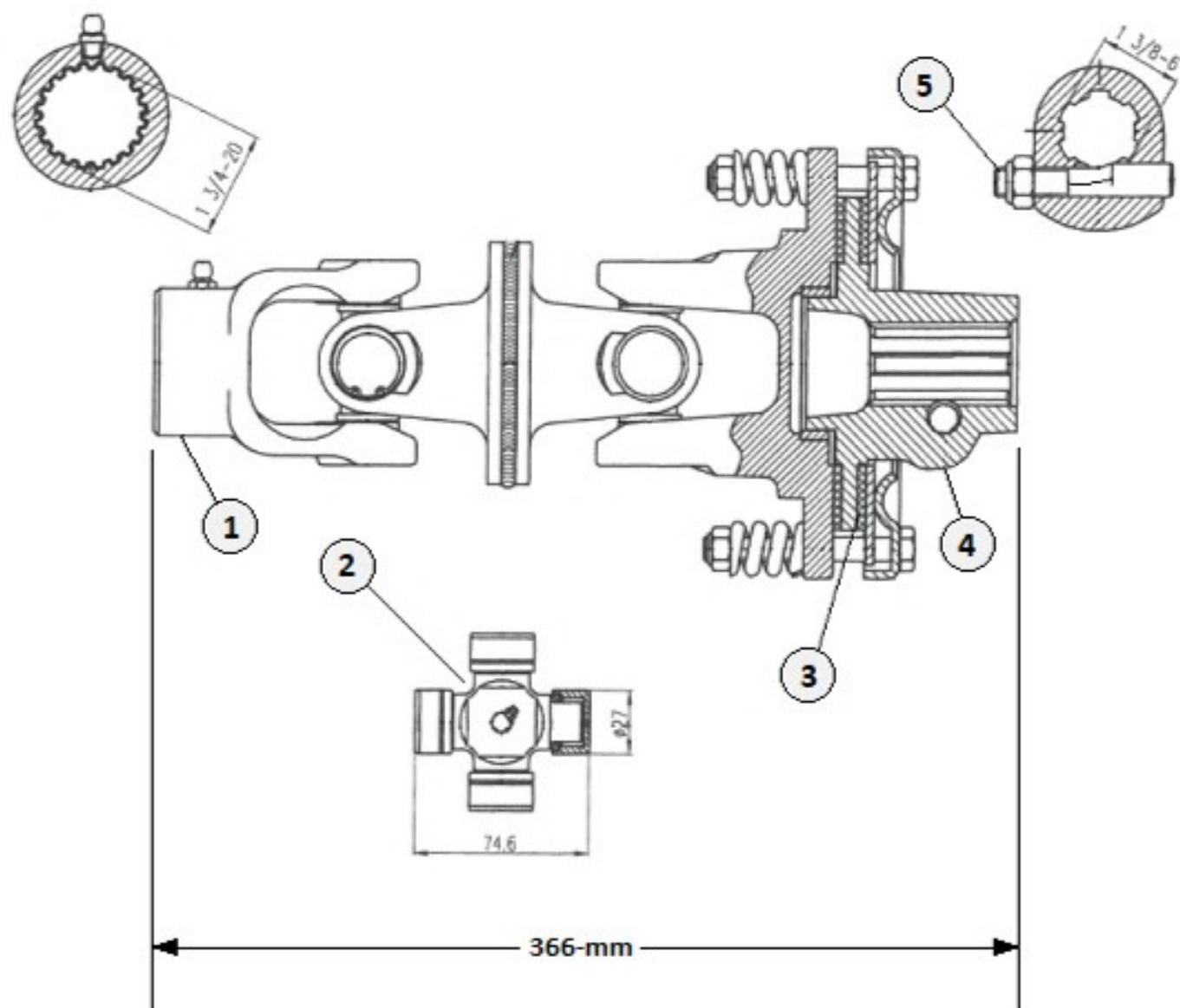
**Center & LH Wing Gearbox #191304 (RG40-A)**  
**RH Wing Gearbox #191306 (RG40-O)**

Note: Production Models Started using 02-22-21

<b>Item</b>	<b>Part #</b>	<b>Description</b>	<b>Qty</b>
1	191320	DOUBLE LIP SEAL 35 X 72 X 10	1
2	191321	SNAP RING 72 X 2.5	2
3	191322	ADJUSTING WASHER 62 X 71.8 X 0.1	2
4	191323	ADJUSTING WASHER 62 X 71.8 X 0.3	2
5	191324	ADJUSTING WASHER 62 X 71.8 X 0.5	2
6	191325	ADJUSTING WASHER 62 X 71.8 X 1	1
7	191326	TAPERED ROLLER BEARING 30207	1
8	191327	BALL BEARING 6207	1
9	191328	FLAT WASHER 35.2 X 45 X 2	1
10	191329	SOLID OIL SEAL PLUG 72 X 10	1
11	191330	CASTLE NUT M20 X 1.5	1
12	191331	COTTER PIN 4 X 40	1
13	191332	ADJUSTING WASHER 30.3 X 42 X 0.1	2
14	191333	ADJUSTING WASHER 30.3 X 42 X 0.3	1
15	191334	ADJUSTING WASHER 30.3 X 42 X 0.5	1
16	191335	TAPERED ROLLER BEARING 30306	1
17	191336	TAPERED ROLLER BEARING 30208	1
18	191337	SNAP RING 80 X 2.5	2
19	191338	DOUBLE LIP SEAL 40 X 80 X 12	1
20	191339	WASHER 40.1 X 79.9 X 1	1
21	191340	FLAT WASHER 25 X 44 X 4	1
22	191341	CASTLE NUT M24 X 2	1
23	191342	COTTER PIN 5 X 50	1
24	191343	VENT PLUG M16 X 1.5	1
25	191344	WASHER FOR PLUG 16.2 X 19.9 X 1.5	2
26	191345	SEALED WASHER – OIL LEVELER	1
27	191346	OIL LEVELER EZ40 M16 X 1.5	1
28	191347	SOLID PLUG 9/16"-18UNF	1
29	191348	O-RING 11.2 X 2	1
30	191349	OIL PLUG M16 X 1.5	1

Note: Production Models Started using 02-22-21

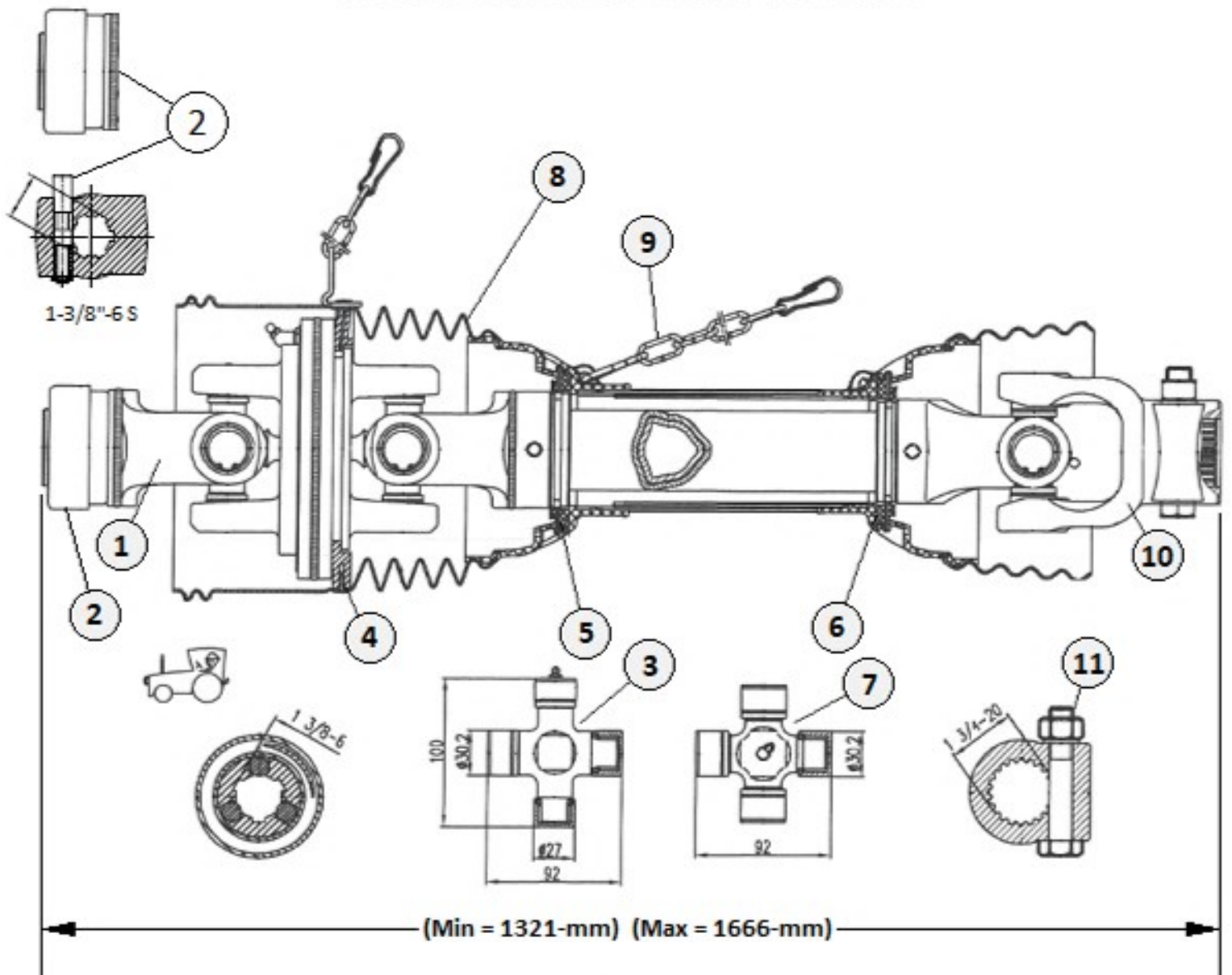
# CENTER DECK DRIVELINE COMPONENTS



## 191203 - COMPLETE DRIVELINE

Item	Part #	Description	Qty
1	552070	Gearbox Yoke 1-3/4" 20-Spline	1
2	552071	Cross Kit 27 x 74.6	2
3	552072	Clutch Lining (2-Pack)	1
4	552073	Complete Slipclutch	1
5	552074	Eccentric Pin with Nut	1

## C.V. DRIVELINE COMPONENTS

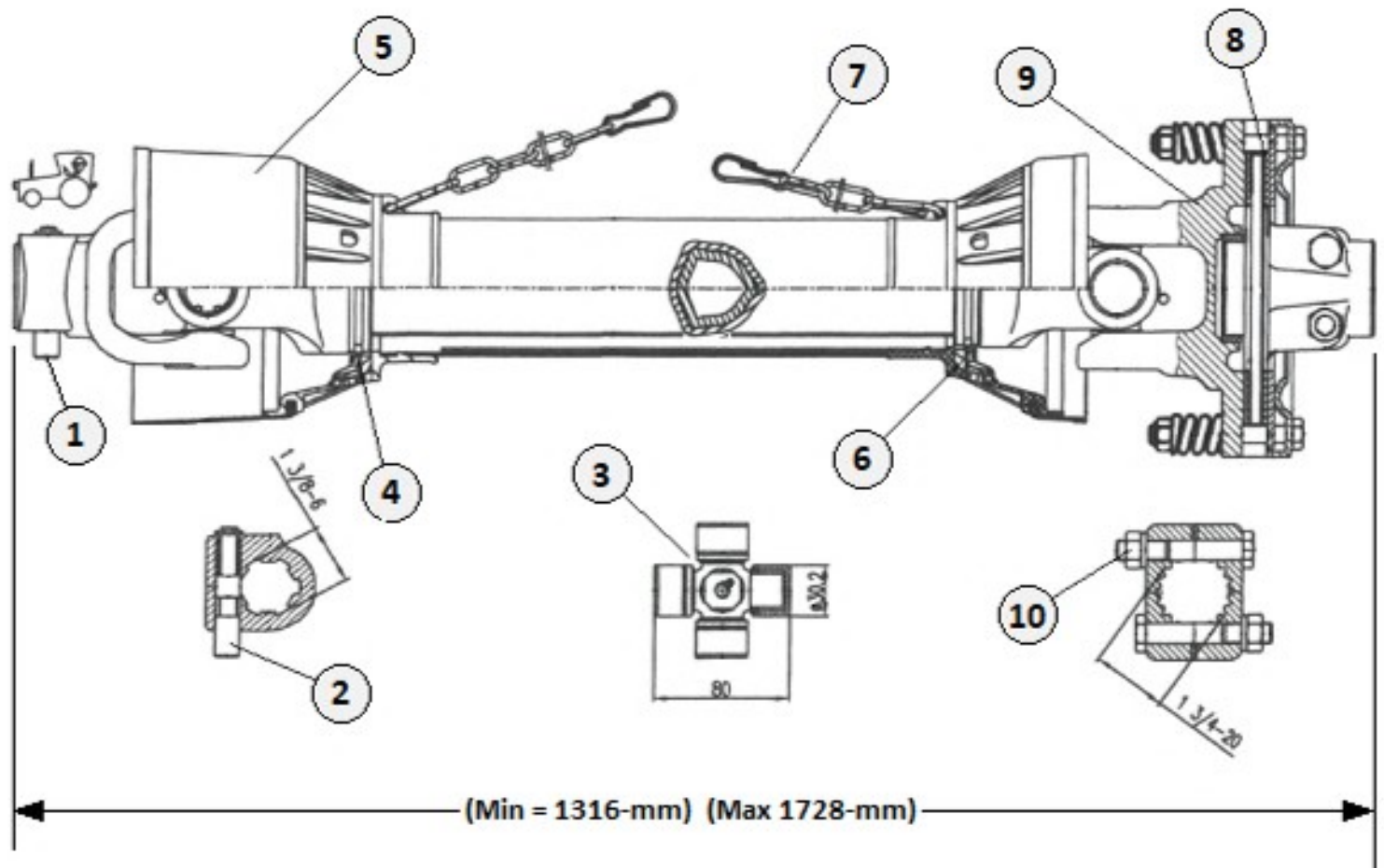


Item	Part #	Description	Qty
1	552090	Tractor Yoke with Pull Collar – 1-3/8" 6-Spline	1
2	552091	Pull Collar for Yoke	A/R
	552051	Push Pin Kit	A/R
3	552092	Cross Kit 27 / 30.2 x 100	2
4	552093	Fixed Ring for C.V. Shield	1
5	552094	Outer Plastic Shield Bearing	1
6	552095	Inner Plastic Shield Bearing	1
7	552096	Cross Kit 30.2 x 92	1
8	552097	Complete Safety Shield	1
9	552005	Safety Chain	3
10	552098	Yoke 1-3/4" 20-Spline	1
11	552099	Lock Bolt with Nut	1

A/R = As Required

**191255 - COMPLETE C.V. DRIVELINE (540-RPM)**

# WING DRIVELINE COMPONENTS

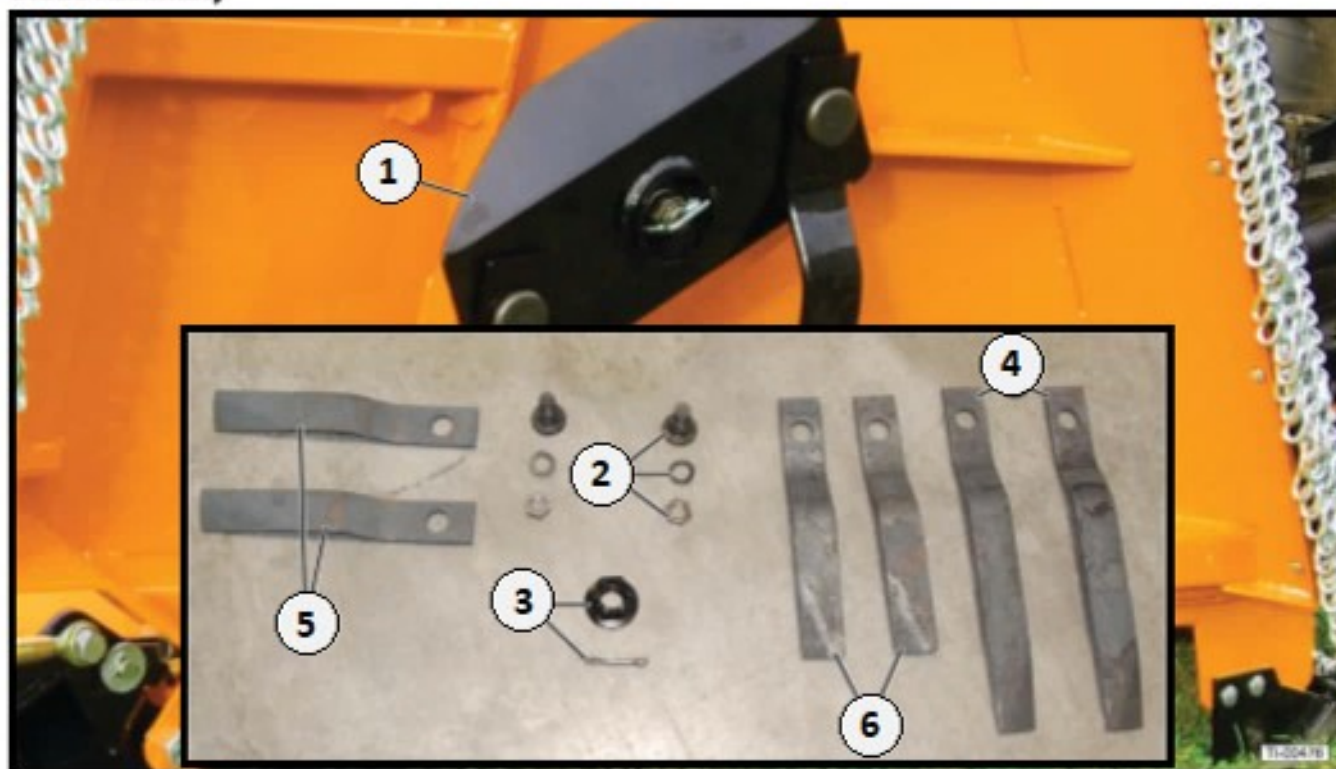


## 191254 - COMPLETE DRIVELINE

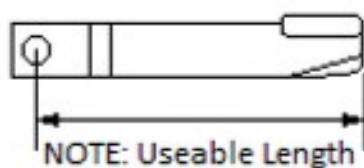
Item	Part #	Description	Qty
1	552075	Tractor Yoke 1-3/8" with Push Pin	1
2	552076	Push Pin Kit	1
3	552077	Cross Kit 30.2 x 80	2
4	552078	Outer Plastic Shield Bearing	1
5	552079	Complete Safety Shield	1
6	552080	Inner Plastic Shield Bearing	1
7	552005	Safety Chain	2
8	552082	Clutch Lining (2-Pack)	1
9	552083	Complete Slipclutch	1
10	552084	Lock Bolt with Nut	1



## Blade Assembly

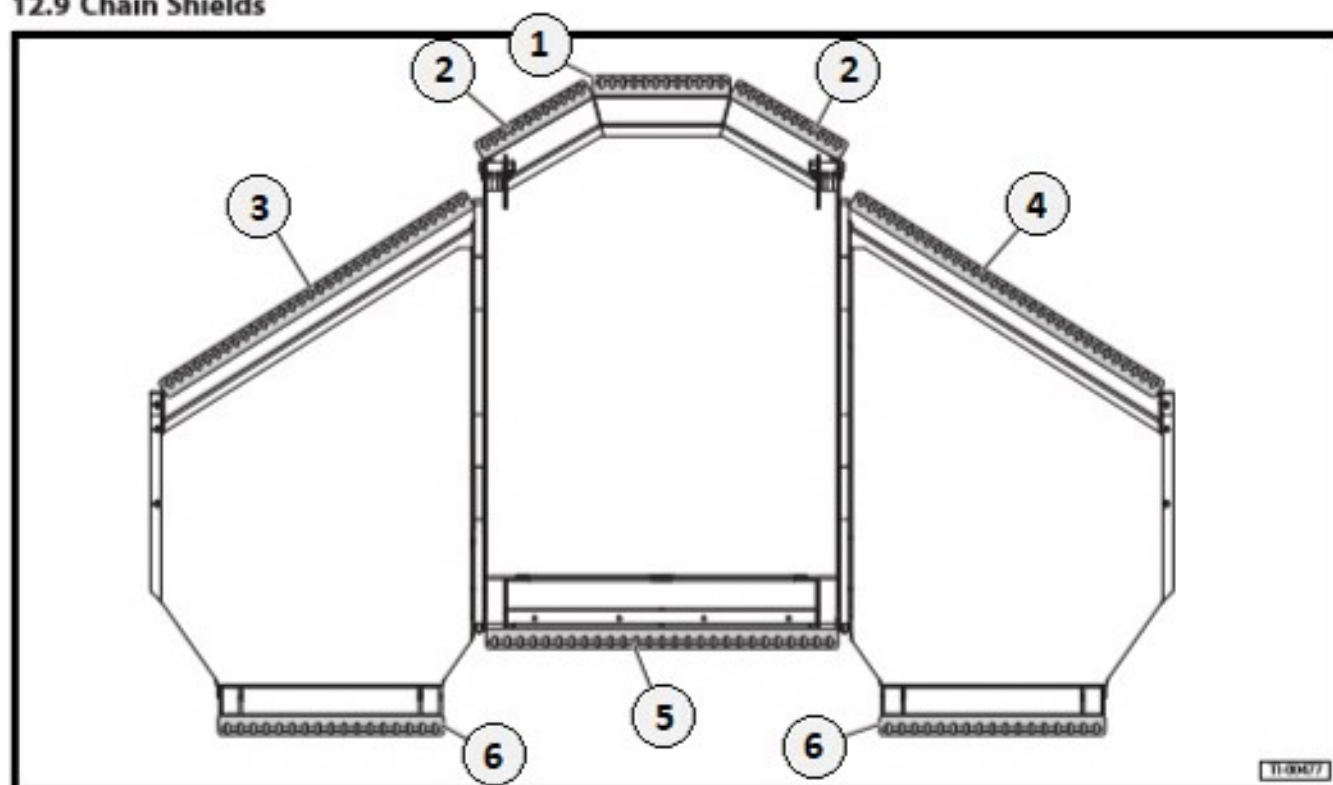


Item	Part #	Description	Qty
1	191207	Blade Carrier (Shown)(Bolt Holes 15.50" Ctr to Ctr)	3
	191381	Blade Carrier - Pan Type (Not Shown)(Bolt Holes 15.50" Ctr to Ctr)	3
2	110012	Blade Bolt, Lockwasher & Nut (2-Pack)	6
3	191247	Blade Carrier Retainer Kit 1" Fine Thread Nut & 1/8" Cotter	3
4	T-60	Cutter Blades – Center (Sold in Pairs) Useable Length 22"	1
5	T-48R	Cutter Blades – Left Wing Reverse Rotation (Sold in Pairs) Useable Length 16"	1
6	T-48	Cutter Blades – Right Wing (Sold in Pairs) Useable Length 16"	1



NOTE: Uses 1-11/16" Socket size for Blade Bolt Nut

## 12.9 Chain Shields



Item	Part #	Description	Qty
--	CG-19120	Complete Chain Shield Kit (Includes Items 1,2,3,4,5,6,7)	1
1	CG-19121	Chain Shield – Front Center Deck	1
2	CG-19122	Chain Shield – LH & RH Front Center Deck	2
3	CG-19123	Chain Shield – LH Front Wing Deck	1
4	CG-19124	Chain Shield – RH Front Wing Deck	1
5	CG-19125	Chain Shield – Rear Center Deck	1
6	CG-19126	Chain Shield – LH & RH Rear Wing Deck	2
7	191253	*Bolt & Nut Kit – for Shields (10-Pack)	A/R

\*Not Shown

A/R = As Required