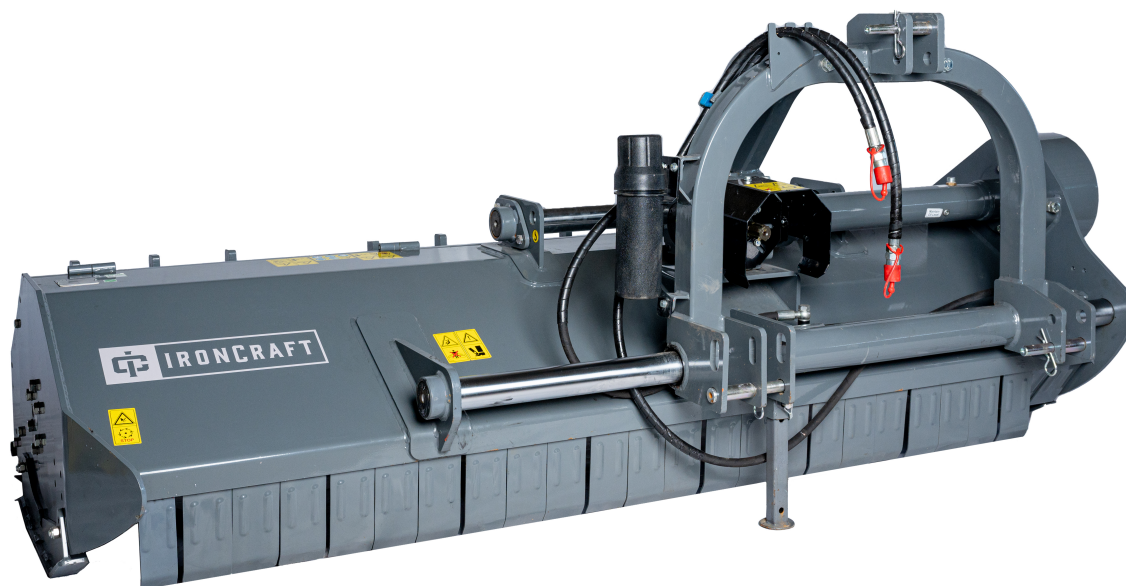




**Contact your Authorized Ironcraft Dealer
for all your parts needs**

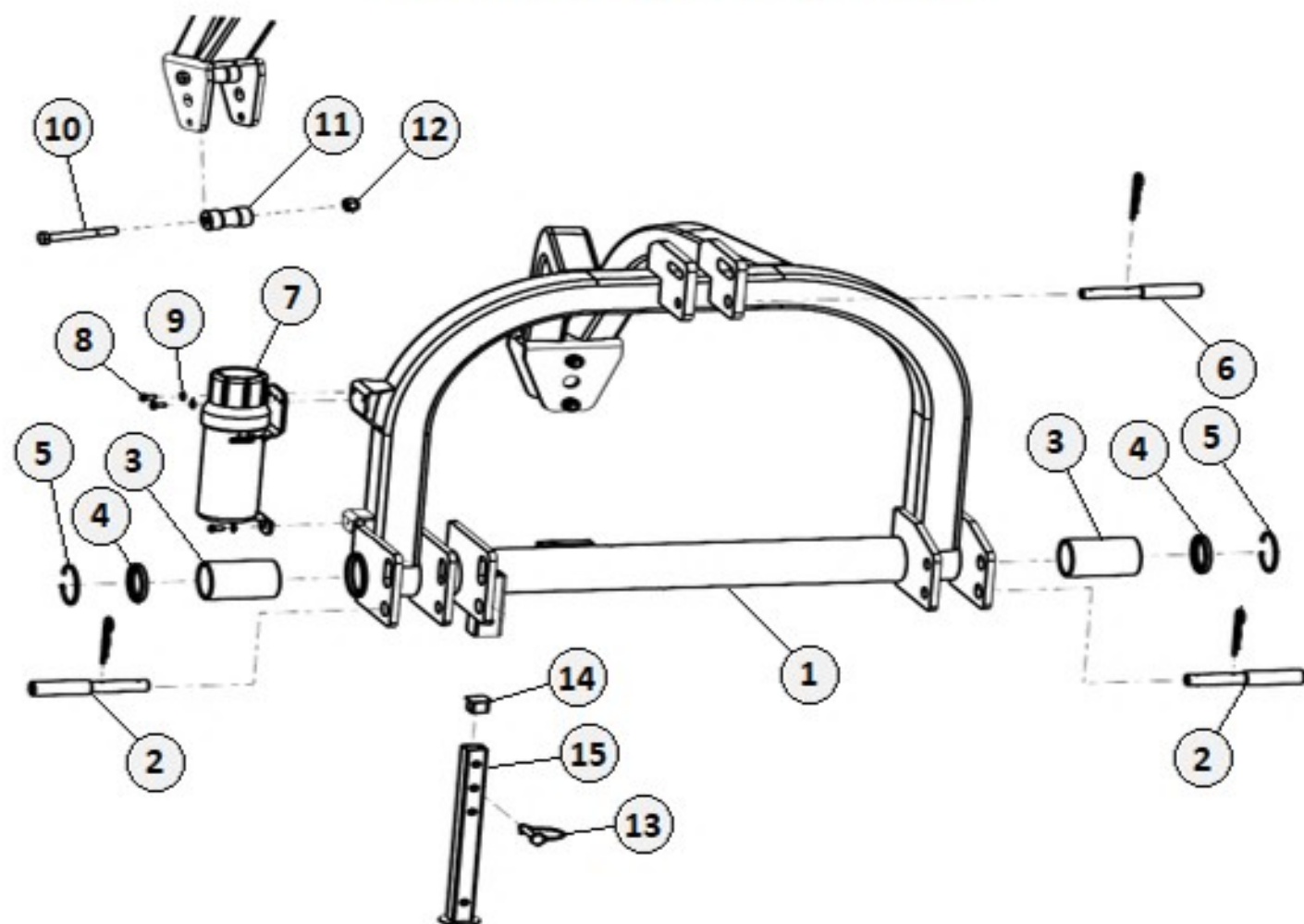


BPF SERIES FLAIL MOWER PARTS MANUAL

Specifications

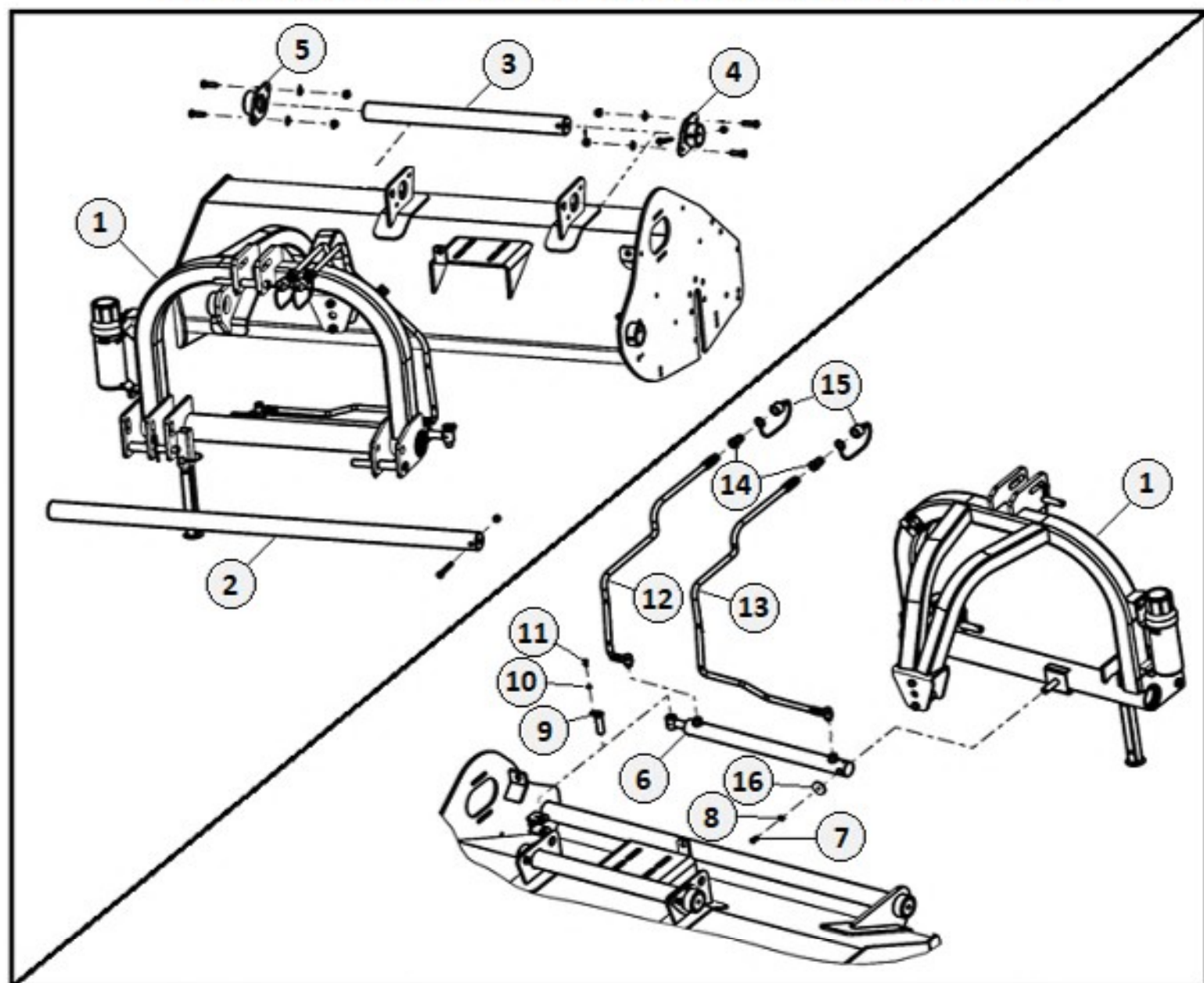
		BPF225	BPF250
Overall size L x W x H	mm	1194 X 2450 X 990	1194 X 2700 X 990
	(inch)	(47 X 96 X 39)	(47 X 106 X 39)
Working width	mm (inch)	2230 (88)	2480 (98)
Recommended tractor HP	HP	50-100	50-100
3 Point Hitch Type		Cat-II	Cat-II
No. Of Hammer	Nos	20	24
PTO input speed	Rpm	540	540
Rotor speed	Rpm	2146	2146
Side transmission		4 Belt XPB type	5 Belt XPB type
Side shift (max)	mm	467	467
Rotor diameter	mm	170	170
Rotor swing diameter	mm	410	410
Approx Weight	Kg/lbs	800(1763)	865(1907)

TOP MAST COMPONENTS



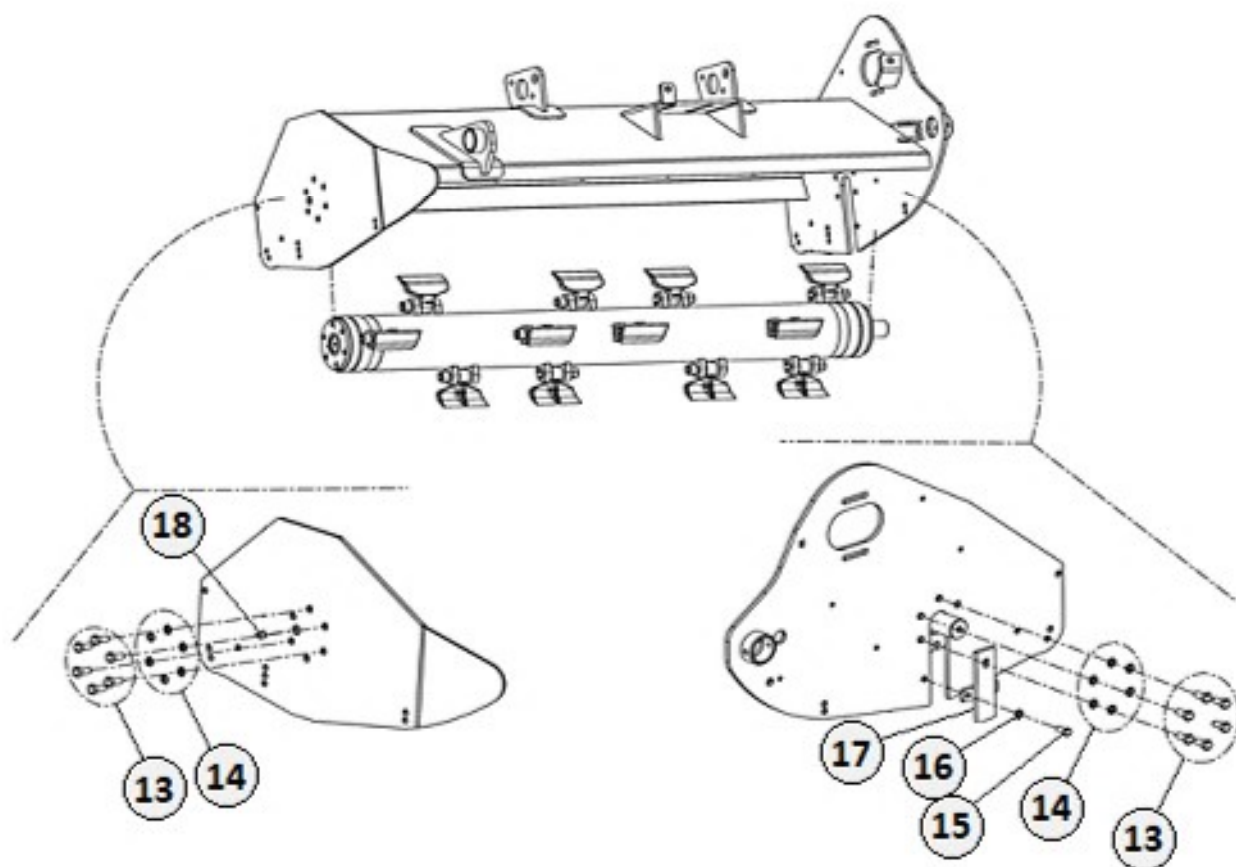
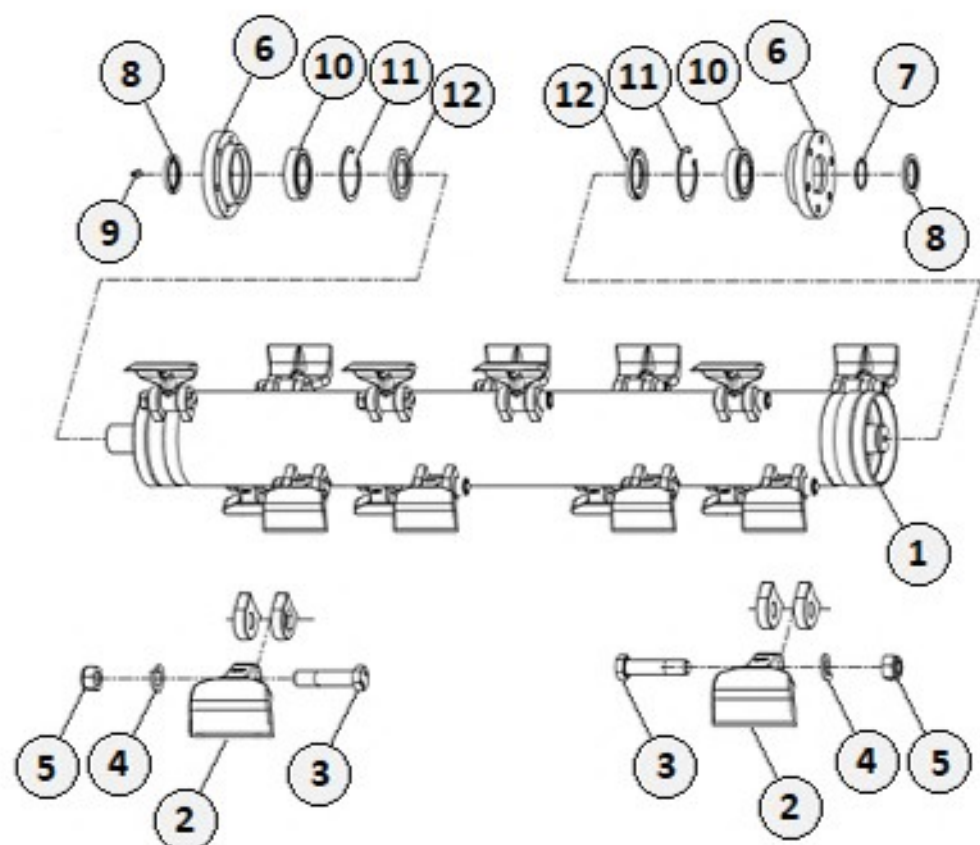
	PART #	DESCRIPTION	QTY
1	SK17590	TOP MAST	1
2	SK17444	LOWER STEP PIN CAT-1 / II	2
3	SK17591	GUIDE BAR BUSHING	2
4	SK17284	OIL SEAL 75 X 60 X 8	2
5	SK25216	CIRCLIP INTERNAL 75 X 2.5	2
6	SK17445	TOP STEP PIN CAT-I / II	1
7	SK26030	MANUAL BOX COVER	1
8	SK8190	HEX BOLT M8 X 1.25 X 15	3
9	SK8064	PLAIN WASHER	3
10	SK17593	HEX BOLT M14 X 2 X 115 (HT) (8.8)	2
11	SK17592	GUIDE BAR ROLLER	2
12	SK1574	NYLOCK NUT M14 X 2	2
13	SK14267	SQ. SNAP PIN M10 X 70	1
14	SK14266	SQ. PLASTIC CAP 32mm	1
15	SK17442	STAND	1

HYDRAULIC TOP MAST & GUIDE BAR ASSEMBLY



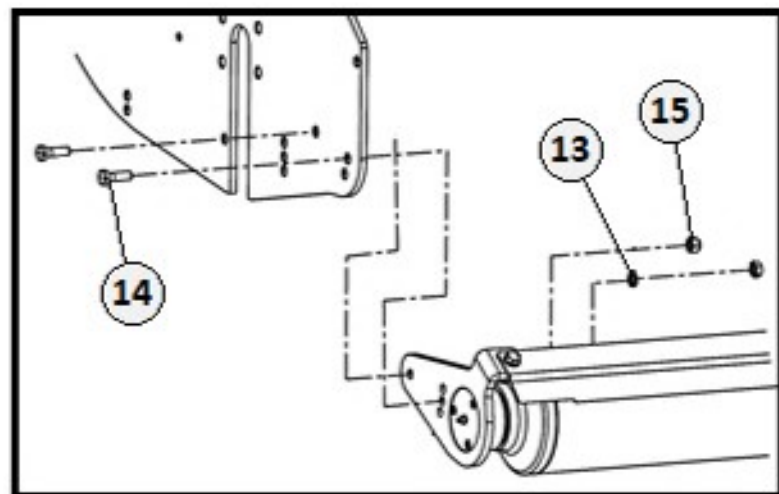
	PART #	DESCRIPTION	Qty
1	SK17590	TOP MAST	1
2	SK17581	LARGE GUIDE BAR	1
3	SK17582	SMALL GUIDE BAR	1
4	SK17587	LH GUIDE BAR BUSHING	1
5	SK17586	RH GUIDE BAR BUSHING	1
6	SK17632	HYD. JACK	1
7	SK8040	HEX BOLT M8 X 1.25 X 20	1
8	SK1303	SPRING WASHER 8mm	1
9	SK17499	JACK LOCK PIN	1
10	SK19013	SPRING WASHER 6mm	1
11	SK19157	HEX BOLT M6 X 1 X 16	1
12	SK17188	HYDRAULIC LINE 78-3/4"	1
13	SK17189	HYDRAULIC LINE 94-1/2"	1
14	SK8290	QUICK COUPLING 1/2"- MALE	2
15	SK18269	QRC PLASTIC CAP 1/2"- FEMALE	2
16	SK17487	WASHER 44 X 10.5 X 4	1

ROTOR ASSEMBLY

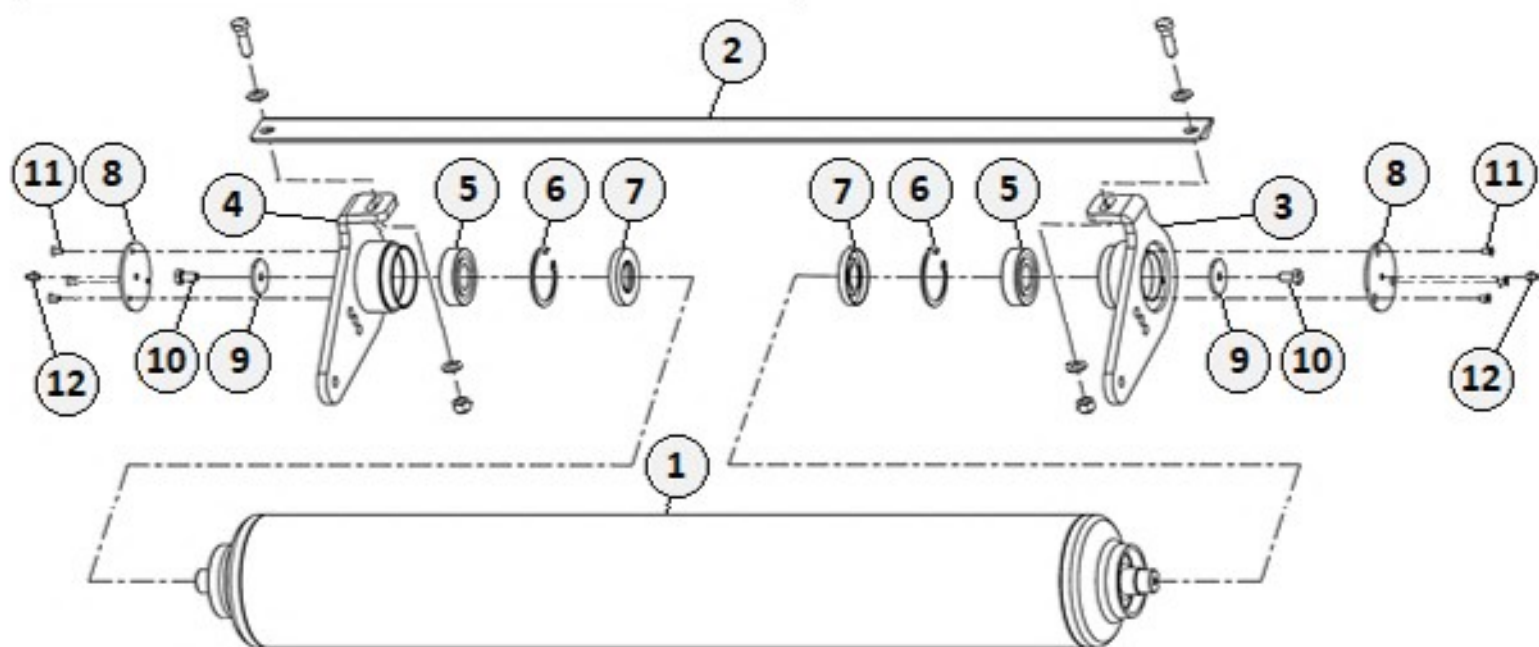


ROTOR ASSEMBLY

	PART #	DESCRIPTION	QTY
1	SK17610	ROTOR (BPF-225)	1
	SK17958	ROTOR (BPF-250)	1
2	SK17067	HAMMER BLADE (BPF-225)	20
	SK17067	HAMMER BLADE (BPF-250)	24
3	SK17521	HEX BOLT M20 X 25 X 1 (10.9) (BPF-225)	20
	SK17521	HEX BOLT M20 X 25 X 1 (10.9) (BPF-250)	24
4	SK25548	SPRING WASHER M20 (BPF-225)	20
	SK25548	SPRING WASHER M20 (BPF-250)	24
5	SK9017	NYLOCK NUT M20 X 2.5 (BPF-225)	20
	SK9017	NYLOCK NUT M20 X 2.5 (BPF-250)	24
6	SK17611	SHAFT HOUSING	2
7	SK25099	CIRCLIP EXTERNAL 50mm	1
8	SK17288	OIL SEAL 50 X 68 X 8	2
9	SK20272	GREASE ZERK M10 X 1.50	1
10	SK17287	BEARING 22210	2
11	SK3027	CIRCLIP INTERNAL 90mm	2
12	SK14122	OIL SEAL 55 X 90 X 10	2
13	SK17280	HEX BOLT M14 X 2 X 30 (8.8)	12
14	SK1272	PLAIN WASHER 14mm	12
15	SK8169	HEX BOLT M12 X 1.75 X 25	1
16	SK1306	SPRING WASHER M12	1
17	SK17628	ROTOR SUPPORT PLATE	1
18	SK20188	GREASE ZERK M6 X 1	1

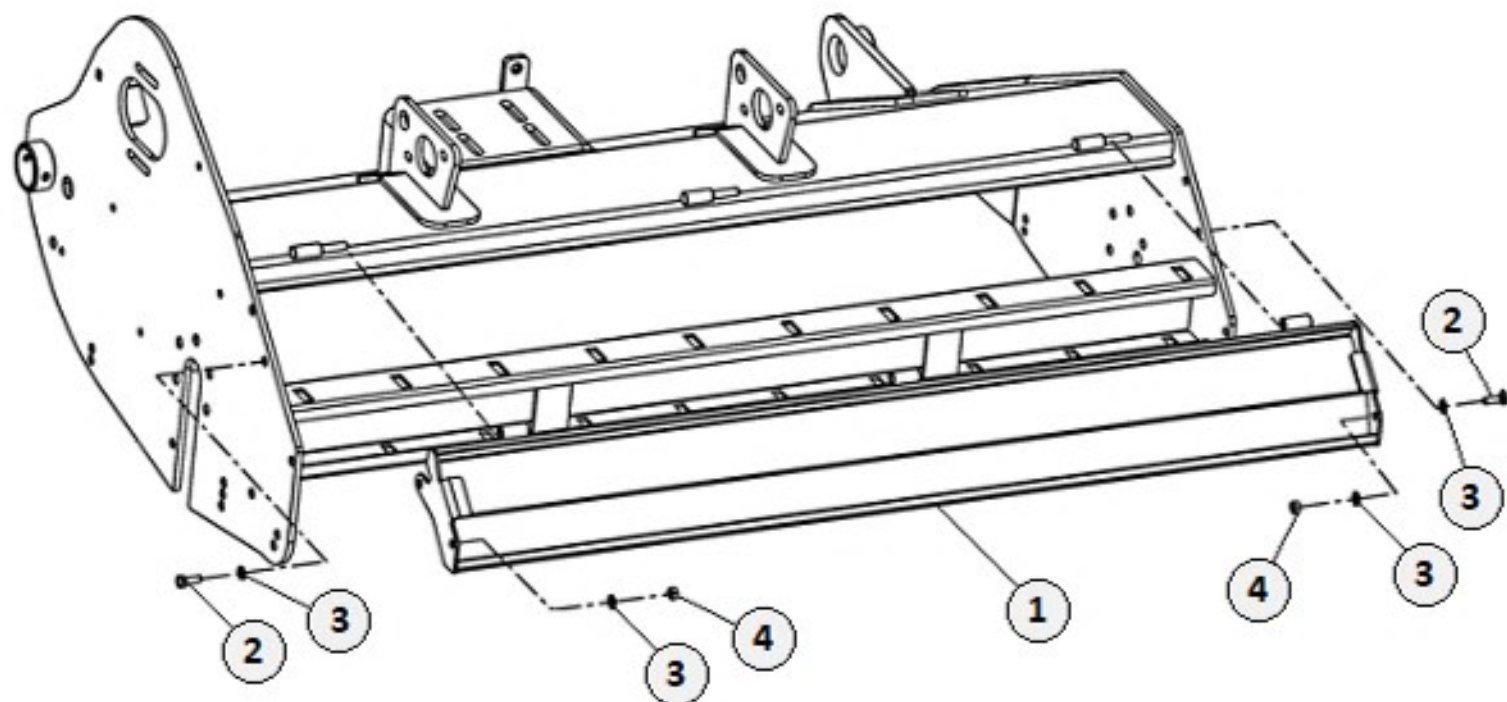


LEVELLER COMPONENTS

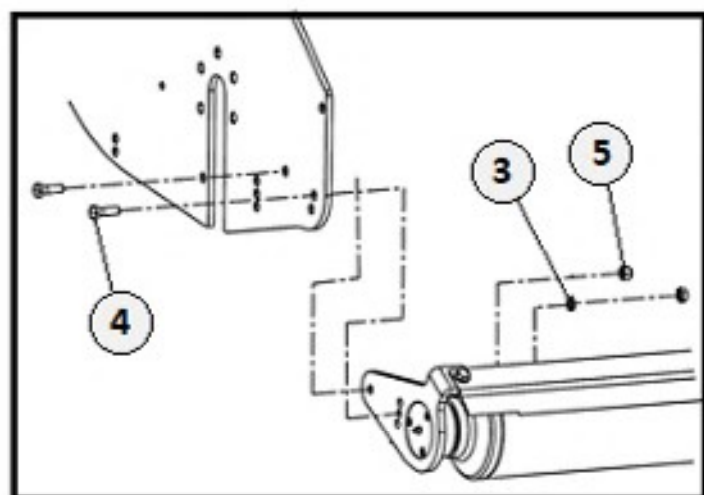
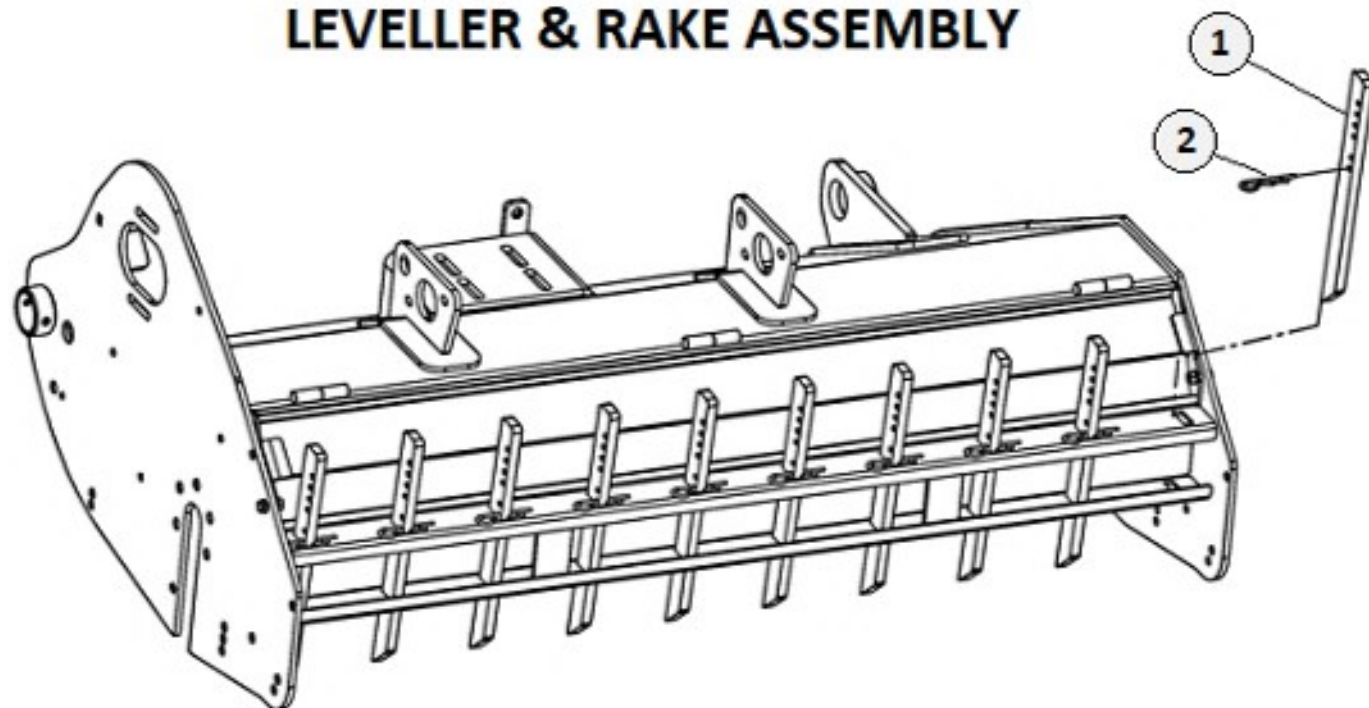


	PART #	DESCRIPTION	Qty
1	SK17597	LEVELLER PIPE (BPF-225)	1
	SK17953	LEVELLER PIPE (BPF-250)	1
2	SK17599	SCRAPER (BPF-225)	1
	SK17954	SCRAPER (BPF-250)	1
3	SK17481	LH ADJUSTMENT PLATE	1
4	SK17480	RH ADJUSTMENT PLATE	1
5	SK17285	BEARING 1306	2
6	SK1002	CIRCLIP INTERNAL 72mm	2
7	SK1001	OIL SEAL 35 X 72 X 10	2
8	SK17482	DUST COVER PLATE	2
9	SK17487	WASHER 44 X 10.5 X 4	2
10	SK17276	HEX BOLT M10 X 1.50 X 20 (8.8)	2
11	SK17286	CSK BOLT M6 X 1 X 12	6
12	SK20148	GREASE ZERK M8 X 1.25	2
13	SK1306	LOCKWASHER 12mm	4
14	SK17433	HEX BOLT M12 X 1.75 X 40 (HT) (8.8)	4
15	SK17273	HEX NUT M12 X 1.75	4

DECK SHUTTER FRAME ASSEMBLY

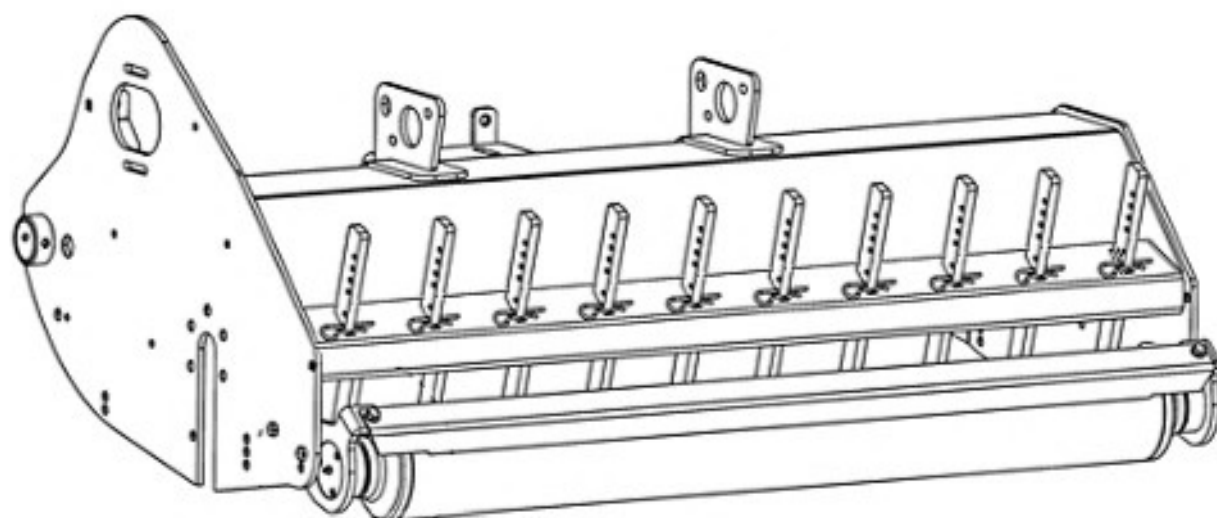


	PART #	DESCRIPTION	Qty
1	SK17728	SHUTTER (BPF-225)	1
	SK17959	SHUTTER (BPF-250)	1
2	SK3340	HEX BOLT M10 X 1.50 X 30 (8.8)	2
3	SK8078	PLAIN WASHER 10mm	2
4	SK1299	HEX NUT M10 X 1.50	2

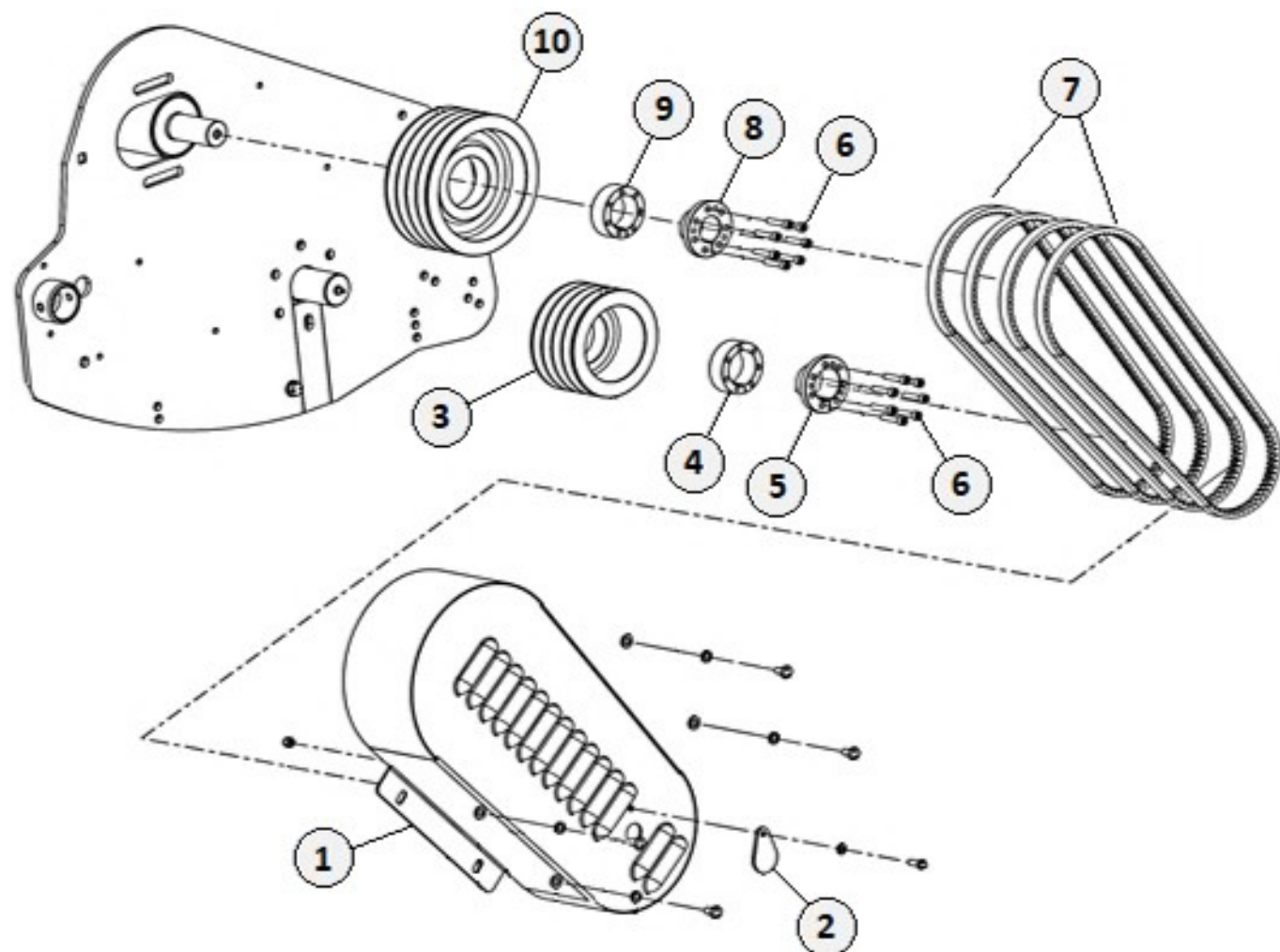


	PART #	DESCRIPTION	QTY
1	SK17475	RAKE 40 X 16 X 120	A/R
2	SK23068	HAIRPIN D5 X 100	A/R
3	SK1306	LOCKWASHER 12mm	4
4	SK17433	HEX BOLT M12 X 1.75 X40 (8.8)	4
5	SK17273	HEX NUT M12 X 1.75	4

*NOTE: A/R= AS REQUIRED

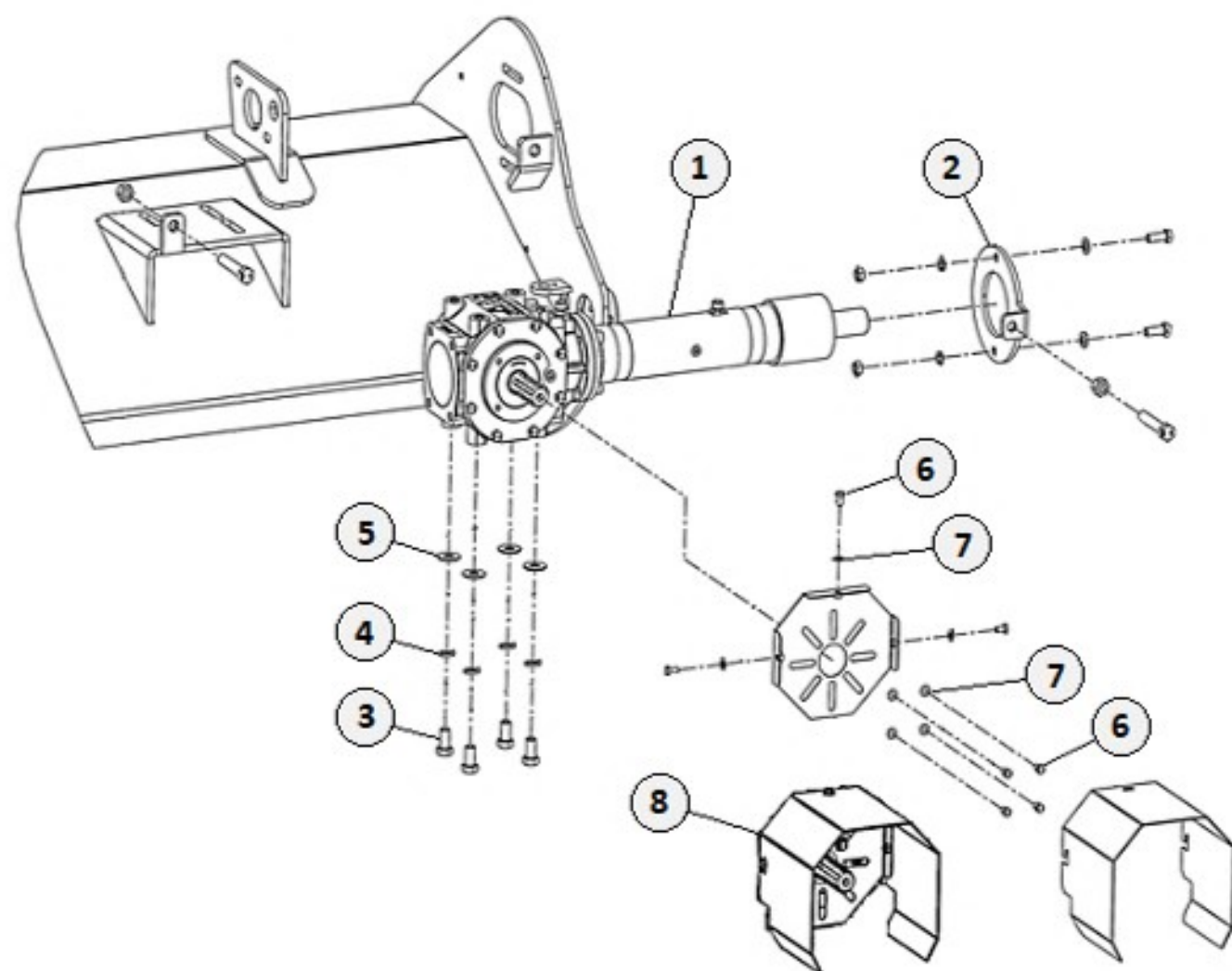


TRANSMISSION COMPONENTS



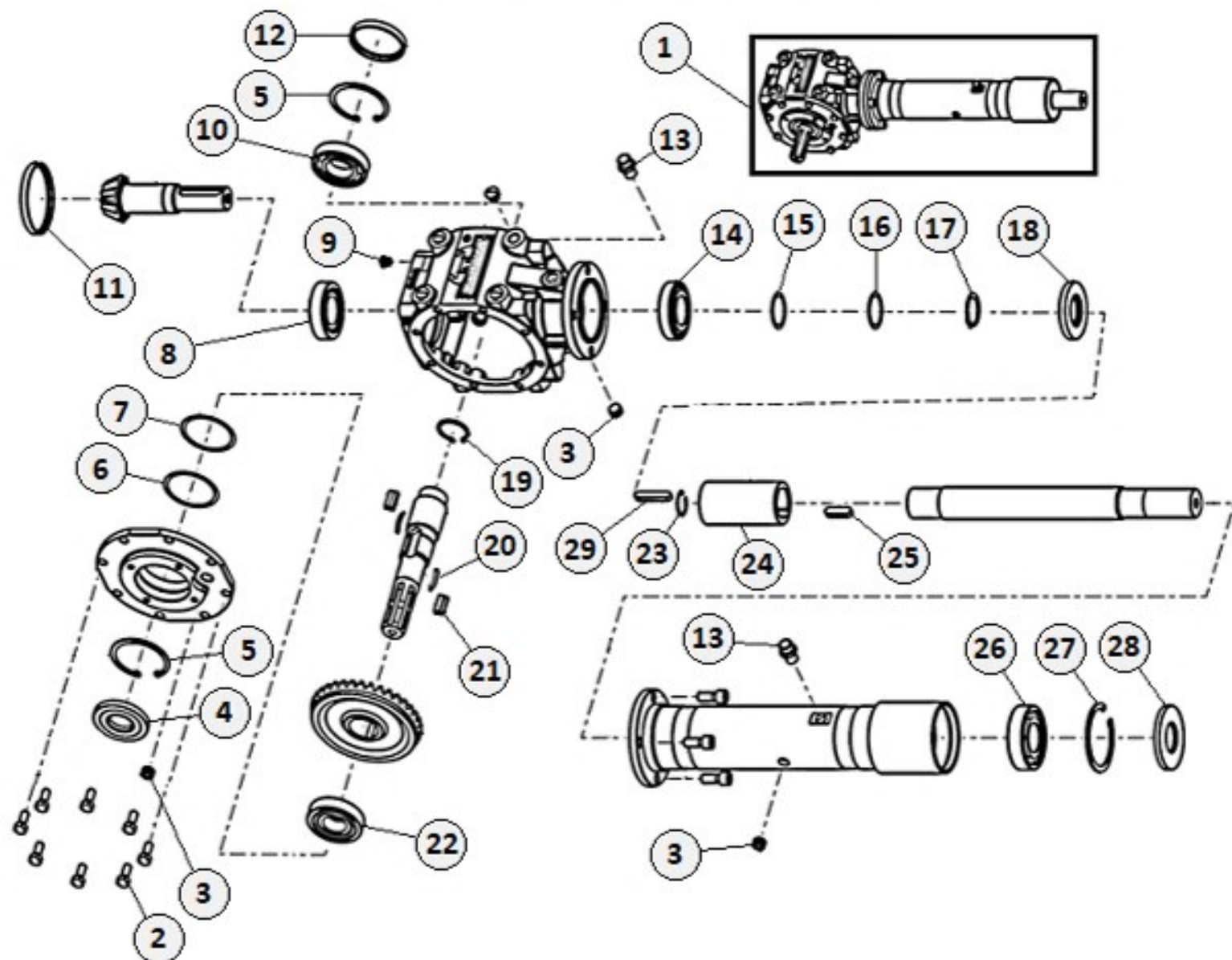
	PART #	DESCRIPTION	QTY
1	SK17450	BELT COVER	1
2	SK17165	GREASE ZERK COVER	1
3	SK17332	LOWER PULLEY 4-GROOVE	1
4	SK17497	LOWER INNER CLAMP 50mm	1
5	SK17498	LOWER OUTER CLAMP 50mm	1
6	SK17035	ALLEN BOLT M8 X 1.25 X 35 (8.8)	14
7	SK17704	V-BELT SET XPN1400 (4NOS)	1
8	SK17036	UPPER INNER CLAMP	1
9	SK17037	UPPER OUTER CLAMP	1
10	SK17331	UPPER PULLEY 4-GROOVE	1

GEARBOX MOUNTING PLATE & SHIELDING



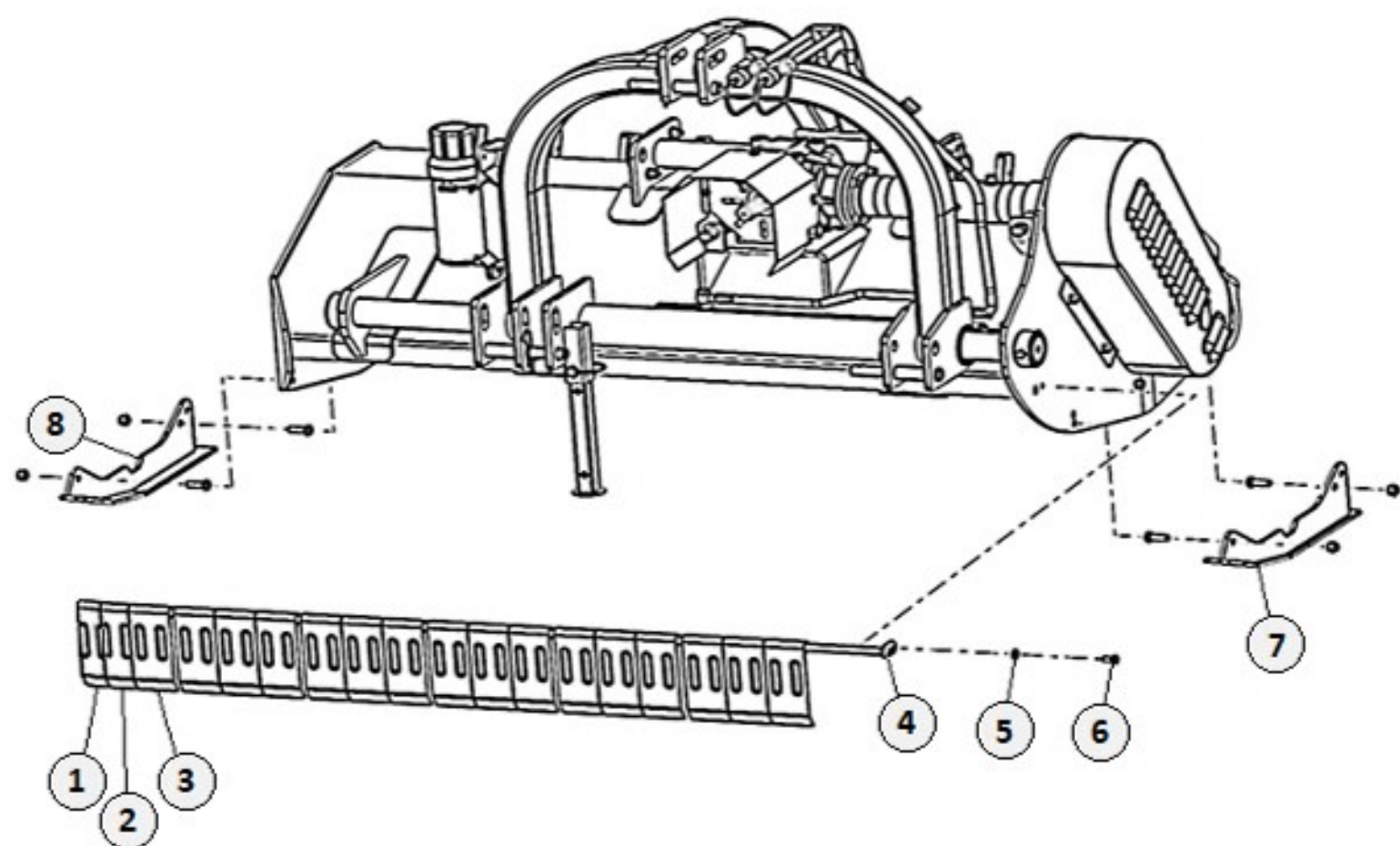
	PART #	DESCRIPTION	Qty
1	SK17614	GEARBOX ASSY (BPF-225)	1
2	SK17627	HOUSING CLAMP	1
3	SK8202	HEX BOLT M16 X 2 X 30	4
4	SK1308	SPRING WASHER 16mm	4
5	SK1078	PLAIN WASHER 16mm	4
6	SK8190	HEX BOLT M8 X 1.25 X 15	7
7	SK8064	PLAIN WASHER 8mm	7
8	SK17559	PTO SHIELD ASSY	1

GEARBOX COMPONENTS



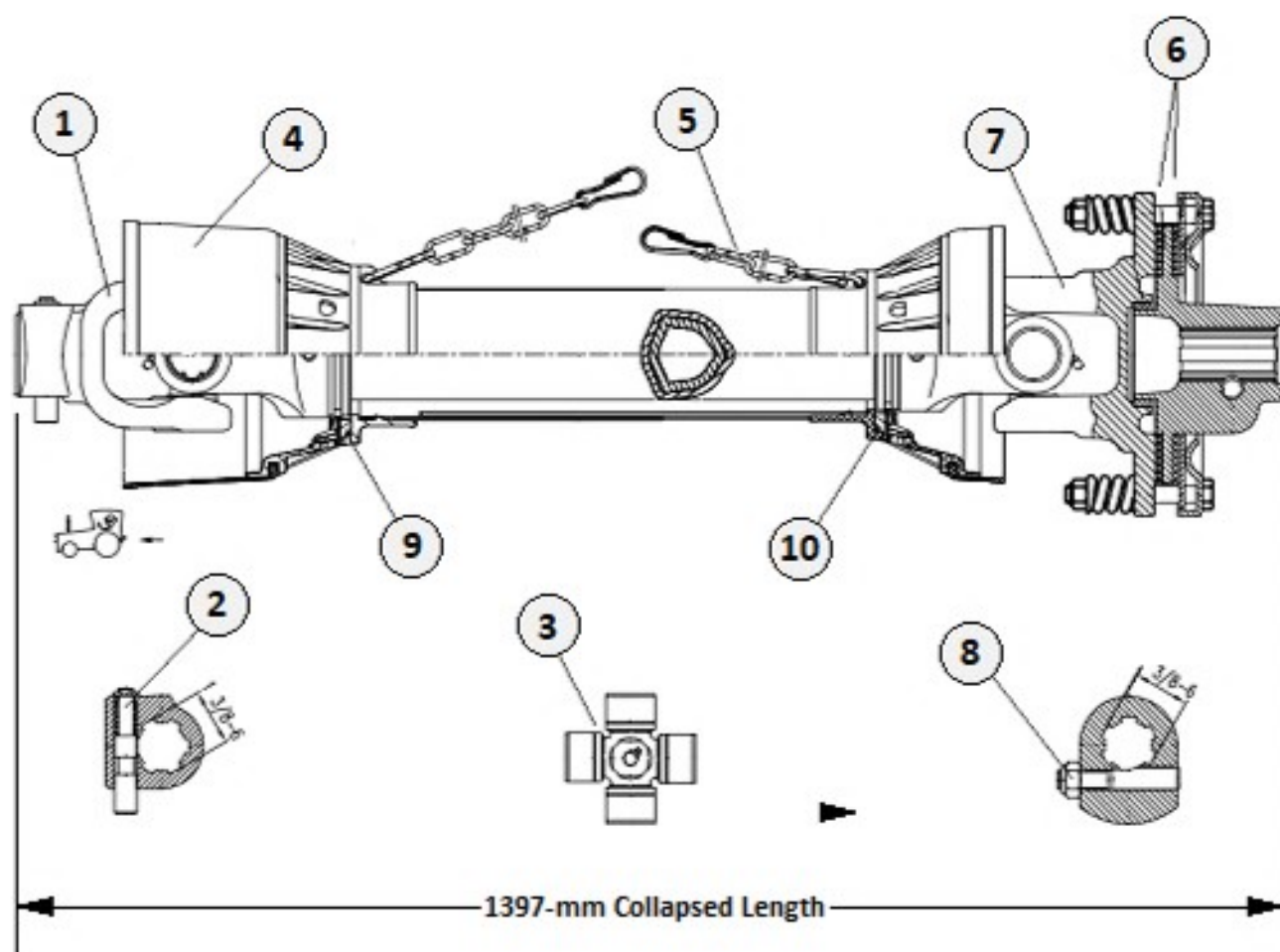
Item	Part #	Description	QTY	Item	Part#	Description	QTY
1	SK17614	GEARBOX ASSY (BPF-225)	1	16	SK17622	SHIM 50 X 40.5 X 0.3	1
2	SK10088	HEX BOLT M10 X 1.50 X 25	8	17	SK8027	CIRCLIP EXTERNAL 40mm	1
3	SK17258	CONICAL HEAD BOLT 3/8"	3	18	SK8154	OIL SEAL 40 X 80 X 10	1
4	SK17329	OIL SEAL 35 X 80 X 10	1	19	SK1044	CIRCLIP EXTERNAL 42mm	1
5	SK1130	INTERNAL CIRCLIP 80mm	2	20	SK17076	LEAF SPRING	2
6	SK17623	SHIM 79.8 X 69 X 0.2	1	21	SK17230	RATCHET 28mm	2
7	SK17624	SHIM 79.8 X 69 X 0.3	1	22	SK14177	BEARING 30307	1
8	SK14149	BEARING 32208	1	23	SK17083	CIRCLIP INTERNAL 32mm	1
9	SK17675	PLASTIC CAP M12 X 1.75	4	24	SK17025	SHAFT CONNECTOR	1
10	SK7033	BEARING 6208	1	25	SK11076	PARALLEL KEY 12 X 8 X 40	1
11	SK17620	OIL SEAL 100 X 10	1	26	SK8036	BEARING 6308	1
12	SK17633	OIL SEAL 80 X 10	1	27	SK3027	CIRCLIP INTERNAL 90mm	1
13	SK14311	BREATHER PLUG 3/8"	2	28	SK17026	OIL SEAL 90 X 40 X 8	1
14	SK1022	BEARING 30208	1	29	SK11077	PARALLEL KEY 10 X 8 X 56	1
15	SK17621	SHIM 50 X 40.5 X 0.2	1				

FRONT GUARD & SKID SHOE ASSEMBLY



	PART #	DESCRIPTION	Qty
1	SK17458	OUTSIDE FRONT PLATE	1
2	SK17459	INSIDE FRONT PLATE	1
3	SK17456	FRONT CTR PLATE (BPF-225)	24
	SK17456	FRONT CTR PLATE (BPF-250)	27
4	SK17601	PLATE ROD (BPF-225)	1
	SK17955	PLATE ROD (BPF-250)	1
5	SK8078	PLAIN WASHER 10mm	1
6	SK17276	HEX BOLT M10 X 1.50 X 20 (8.8)	1
7	SK17500	LH SHID SHOE	1
8	SK17501	RH SKID SHOE	1

SLIPCLUTCH DRIVELINE COMPONENTS



	DESCRIPTION	Item #	Qty
1	TRACTOR YOKE 1-3/8" W/PUSH PIN	552020	1
2	PUSH PIN KIT	552021	1
3	CROSS KIT	552023	2
4	COMPLETE SAFETY SHIELD	552024	1
5	SAFETY SUPPORT CHAINS	552005	2
6	CLUTCH LINING (PACK OF 2)	552025	1
7	COMPLETE SLIP CLUTCH	552026	1
8	ECCENTRIC PIN WITH NUT - KIT	552027	1
9	OUTER PLASTIC SHIELD BEARING	552028	1
10	INNER PLASTIC SHIELD BEARING	552029	1
	COMPLETE SC DRIVELINE	150037	