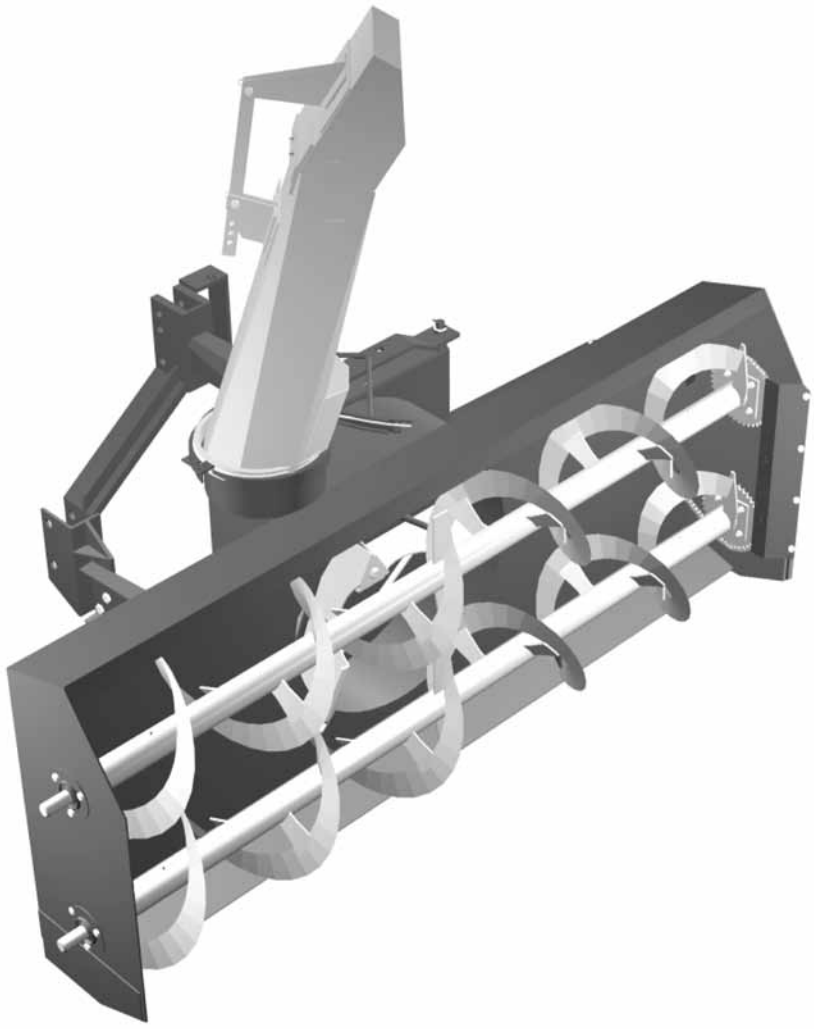
ALLIED

by Farm King

OPERATOR AND PARTS MANUAL

Snowblower

Model 1080



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Manufacturer's statement: for technical reasons Buhler Industries Inc. reserves the right to modify machinery design and specifications provided herein without any preliminary notice.
Information provided herein is of descriptive nature. Performance quality may depend on soil fertility, applied agricultural techniques, weather conditions and other factors.

Introduction

Allied has years of snowblower manufacturing expertise and thousands of acreages, farms and cities depend on Allied snowblowers. PTO-driven Allied snowblowers attach to 3-point hitch. A hitch system, which is quick-hitch compatible, is standard on all models. This snowblower is supplied with category 2 pins as well as conversion bushings to category 3.

A 7" or 10" commercial truck loader chute is available as an option on the 108" models. There are two 108" models - the YC1080C has a 1000 rpm gearbox and the YC1080D features a 540 rpm drive system. Adjustable cup type skid shoes are standard on all models. This model has a 4 blade fan and Hydraulic Spout Control as standard equipment. Shear bolt protection is provided at the sprocket to the main auger, and is easily accessed by removing wing nuts and cover at the back of the housing. There is a shear bolt on the auger and on the PTO shaft to protect the machine from damage if a large object is picked up. Any smaller objects in the snow will be thrown with it and could cause serious injury. Do not allow anyone stand behind the tractor or in the area of the discharged snow.

Keep this manual handy for frequent reference. All new operators or owners must review the manual before using the equipment and at least annually thereafter. Contact your Allied Dealer if you need assistance, information, or additional copies of the manual. Visit our website at www.buhlerindustries.com for a complete list of dealers in your area.

The directions left, right, front and rear, as mentioned throughout this manual, are as seen facing in the direction of travel of the implement.

Safety

Safety Instructions

Remember, YOU are the key to safety. Good safety practices not only protect you, but also the people around you. Make these practices a working part of your safety program. Be certain that everyone operating this equipment is familiar with the recommended operating and maintenance procedures and follows all the safety precautions. Most accidents can be prevented. Do not risk injury or death by ignoring good safety practices.

The alert symbol is used throughout this manual. It indicates attention is required and identifies hazards. Follow the recommended precautions.

The safety alert symbol means...
ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

	CAUTION	The caution symbol indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.
	WARNING	The Warning Symbol indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.
	DANGER	The Danger Symbol indicates an imminently hazardous situation that, if not avoided will result in death or serious injury. This signal word is to be limited to the most extreme situations, typically for machine components that, for functional purposes, cannot be guarded.

General Safety Instructions

- Have a first-aid kit available for use and know how to use it.
- Have a fire extinguisher available, stored in a highly visible location, and know how to use it.
- Wear appropriate protective gear. This list may include but is not limited to:
  - hard hat
  - protective shoes with slip resistant soles
  - protective glasses or goggles
  - heavy gloves
  - wet weather gear
  - hearing protection
  - respirator or filter mask
- Read and understand the Operator's Manual and all safety signs before operating, servicing, adjusting, repairing, or unplugging the equipment.
- Do not attempt any unauthorized modifications to your Farm King product as this could affect function or safety, and could affect the life of the equipment.
- Never start or operate the snowblower except from the operator's station on the power unit.
- Inspect and clean the working area before operating.
- Keep hands, feet, clothing, and hair away from moving parts.
- Ensure bystanders are clear of the area before operating.

Start-Up Safety

- Do not let inexperienced operators or children run this equipment.
- Place all tractor and machine controls in neutral before starting.
- Operate only with ROPS and seatbelt equipped tractors.
- Do not operate inside a building unless there is adequate ventilation.
- Ensure all shields are in place and in good condition before operating.
- Stay clear of PTO shaft and machine when engaging PTO.

Operation Safety

- Do not permit riders.
- Do not wear loose fitting clothing during operation.
- Do not allow anyone other than the operator close to the Auger when in operation.
- Stay clear of snowblower augers.
- Stay clear of snowblower discharge chute. Rocks or debris can be picked up and thrown.
- Never operate equipment in the raised position.

Transport Safety

- Review Transport Safety instructions in tractor manual before moving.
- Check with local authorities regarding transport on public roads. Obey all applicable laws and regulations.
- Make sure the SMV (Slow Moving Vehicle) emblem and all the lights and reflectors that are required by the local highway and transport authorities are in place, are clean, and can be seen clearly by all overtaking and oncoming traffic.
- Never have the equipment in operation during transport.
- Always travel at a safe speed.

Service and Maintenance Safety

- Stop engine, set brake, remove ignition key, and wait for all moving parts to stop before servicing, adjusting, repairing, or unplugging.
- Support the equipment with blocks or safety stands before working beneath it.
- Follow good shop practices including:
  - keep service area clean and dry
  - be sure electrical outlets and tools are properly grounded
  - use adequate light for the job.
- Use only tools, jacks, and hoists of sufficient capacity for the job.
- Replace and secure all shields removed during servicing before operating.
- Use heavy leather gloves to handle sharp objects.
- Check hydraulics regularly for leaks. Use cardboard to look for leaks, and use hand and eye protection.
- Relieve pressure on hydraulic system before repairing or adjusting.

Storage Safety

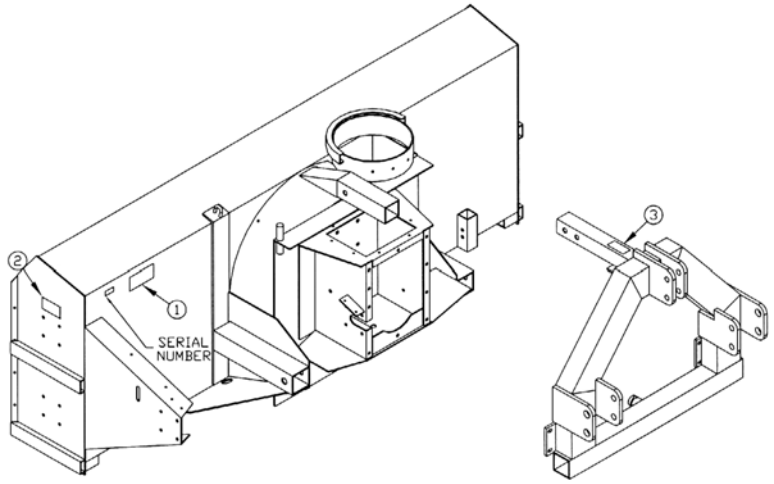
- Store the unit in an area away from human activity.
- Do not permit children to play on or around the stored machine.
- Support the frame on stands and blocks to provide a secure base.

Safety Signs

- The following illustration shows the approximate location and detail of safety signs.
- Keep all safety signs clean and legible and replace any that are damaged or missing.
- When original parts are replaced, any safety signs affixed to those parts should be replaced as well. Replacement safety signs are available from your local dealer.

Installation

- To install safety signs, ensure the installation area is clean and dry. Decide on the exact position before you remove the backing paper. Remove the smallest portion of the split backing paper and align over the specified area. Carefully press in place.
- Slowly peel back the remaining paper and smooth the remaining portion in place. Small air pockets can be pierced with a pin and smoothed out.
- Replace safety signs immediately should they become damaged, torn or illegible. Obtain replacements from your authorized dealer using the part numbers shown.



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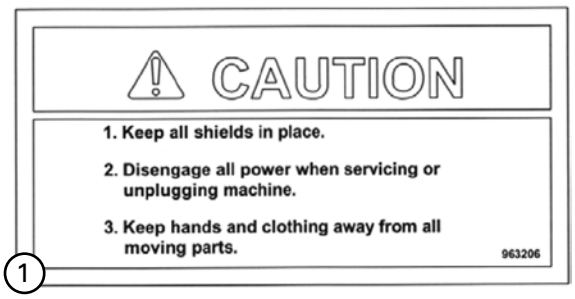
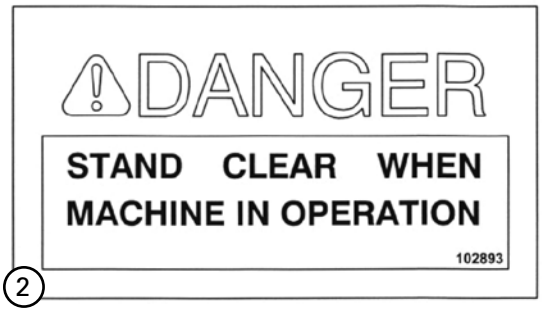
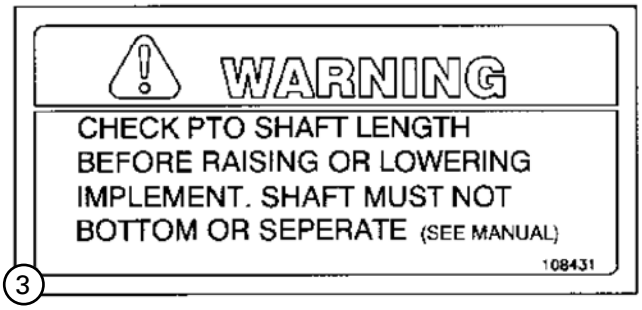






Assembly Instructions

1. Hitch Assembly: With lower hitch tubes (#3) turned as shown in drawing, slide them into the sleeves welded to the main body. These tubes are adjustable to two different positions. The correct position for each individual tractor will be determined when mounting the snowblower on the tractor (see section 4). Start with the tubes pulled out to the last hole. These tubes are connected to the snowblower with a 1-1/4" x 5-1/2" pin (#6) and a hair pin clip (#12). Slide the three-point hitch (#2) into the top sleeve on the snowblower body and hold in place with a 1" x 4-3/8" pin (#7) and a hair pin clip (#12). Bolt the bottom of the hitch to the ends of the hitch tubes using 1/2" x 2" hex bolts, lock washers, flat washers and hex nuts.

2. Spout Assembly: Mount the discharge spout (#64 or #73) using the spout clamp (#22) bolted to the spout ring on the snowblower. Lubricate the spout ring and clamp. Mount the 5" stroke cylinder (#68) on the spout as shown in the drawing.

CAUTION

The ports in the cylinder are both 9/16" orb. Be sure that the bottom edge of the deflectors are properly fitted in the guides before using the hydraulic control.

3. Hydraulic Spout Swivel:

   - Bolt the cylinder arm base (#17) to the bottom of the hitch using 5/8" x 2" hex bolt, lock washers and hex nuts. **NOTE:** There are three sets of holes. The hole used to bolt on this base must match with the holes used to assemble the hitch in the hitch tubes (i.e. 1st hole, second hole, etc.)
   - Mount the spout swivel (#16) onto the swivel pin welded to the back corner of the fan housing using a 1-1/4" i.d. flat washer (#31) and a 1/4" x 1-3/4" cotter pin (#32).
   - Wrap cable (#18) around spout and clamp to the ends of the swivel using 3/8" cable clamps (#19).
   - With the spout turned forward and the swivel arm centered with the spout, clamp the cable to the spout cable anchor using another cable clamp. Ensure that the spout is not jammed and that there is no slack in the cable.
   - Use a standard 8" stroke cylinder (20-1/4" min., 28-1/2" max. pin centers).

4. Mounting Blower on Tractor

   - Mount the blower on a tractor with a category 2 or 3 standard hitch or a category 3 quick hitch. The hitch as two holes both at the top of the hitch and at each lift arm. When using a quick hitch, the pins must be in the inside set of holes. Use the outside set of holes with a standard three-point hitch. The lift arm pins also have a narrow spacing for category 2 and a wide spacing for category 3.
   - Using tape or a bright colored marking pen, mark on the outer shields of the PTO the position where the shaft is completely pushed together and the position where you have a 4" overlap. Watch these marks when moving the blower through all possible operating angles to see that the PTO shaft stays within this range. Slide the hitch in if necessary to keep the PTO shaft in this operating range. Do not forget to change the position of the cylinder arm (#17) by the same distance that you move the hitch.

- With the engine on the tractor shut off, attach the PTO shaft. The tractor end has a 1-3/8" 21 spline end with a spring loaded locking collar. The snowblower end has a clamp style yoke with a 3/8" keyway. Slide the yoke onto the 1-3/4" jackshaft with the 3/8" key supplied. Lock the yoke in place with the 5/8" x 3-1/4" bolt and lock nut fitted through the groove in the gearbox shaft. After tightening the bolt, insert and tighten the 3/8" socket set screw supplied.
- Always check to see that both ends of the PTO shaft are securely attached every time the snowblower is used. This should always be done with the tractor engine off.

Operation Instructions

1. Do not operate the blower in the fully raised position. The three-point hitch on some tractors raises high enough to cause the PTO shaft to bind. This can cause damage to the PTO shaft and/or to the hitch and pins.
2. Depth of the cut can be partially controlled by tilting the blower forward or backward. Adjust the top link of the tractor hitch so the snowblower is just slightly tilted back when resting on the ground.

CAUTION

Excessive backward tilt may cause the “U” joints to flutter resulting in PTO shear bolt failure.

3. The snowblower hitch should mount on three types of tractor hitches. A standard category 2 uses the pins supplied without bushings. A standard category 3 uses the pins supplied with the bushings. A category 3 quick hitch uses the pins with bushings on the inside holes (holes are exactly 19" apart measured up and down.)
4. Adjust the lower link sway chains or blocks on the tractor to restrict movement of the blower when operating.
5. The snowblowers may be purchased with either of two available spouts. Both spouts have hydraulically controlled spout deflectors. The standard spout should be suitable for all general snow blowing applications. The truckloader spout was designed to blow snow directly onto the back of a truck. The maximum height of the truck side you blow over should be approximately 10 feet.
6. Run the blower at low RPM to check operation before blowing snow.
7. The snowblower has shear bolts to protect the tractor and blower in case a large object enters the blower. The PTO shaft uses two 3/8" x 1" (grade 2) hex bolts as shear bolts. The auger uses one 5/16" x 1-1/4" (grade 5) hex bolt as a shear bolt. Shear bolts should be fastened with a lock nut. These bolts must be kept tight to prevent wear of the bolt and bolt holes.
8. Never run PTO shaft at over 1000 RPM.
9. Chain Tension: Slack on the lower side of the chain should be 3/8" to 1/2"
10. Lubrication:
    - The spout clamps and rings should be periodically lubricated with gun grease. This is particularly important on the truckloader spout which turns harder than the standard spout due to the length and weight.
    - PTO shaft universal joints and splined slide should be greased daily.
    - Regularly oiling the chain will significantly increase the life of the chain.
    - The grease fitting on the hydraulic spout swivel arm and discharge spout should be kept lubricated.
    - Use any 80-90 gear oil or multigrade with 80 minimum in the gearbox up to the level plug height.

11. Periodically check all bolts for tightness. The bolt holding on the fan and the bearing bolts are of particular importance.

DANGER

Always stop blowing for servicing or unplugging. The PTO should be disengaged before dismounting from the tractor.

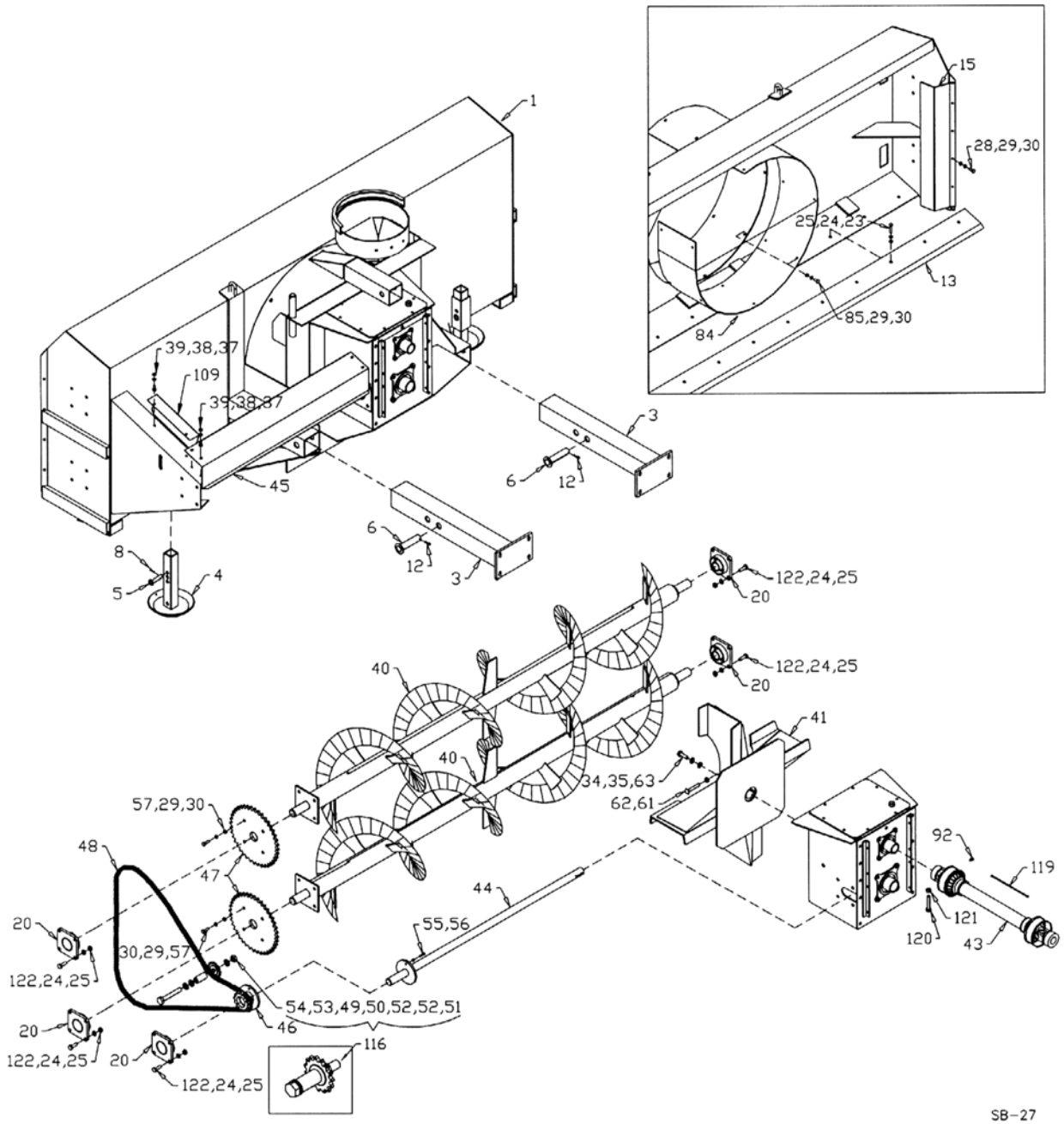
12. Shear Sprocket: The shear sprocket (#46) should be checked at the beginning of every season to make sure it will spin freely. Clean to loosen if necessary.

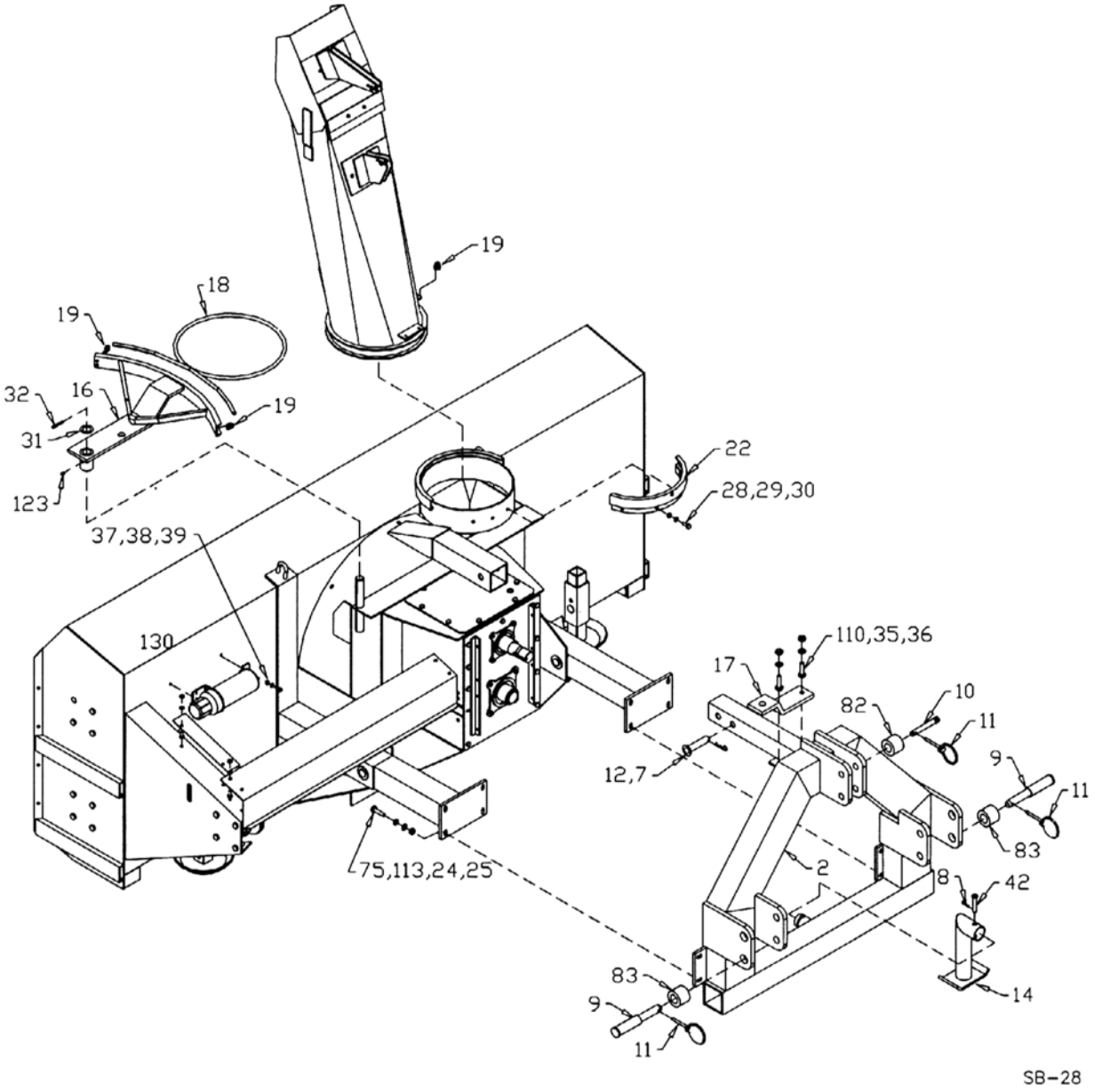
13. When replacing bearings or tightening a loose bearing collar, always tighten collar in the direction of shaft rotation using a center punch or a similar tool.

CAUTION

Avoid raising or lowering snowblower under load. Doing so can create excessive end pressure on the PTO shaft which could lead to bearing failure on the snowblower.

Snowblower Drawings

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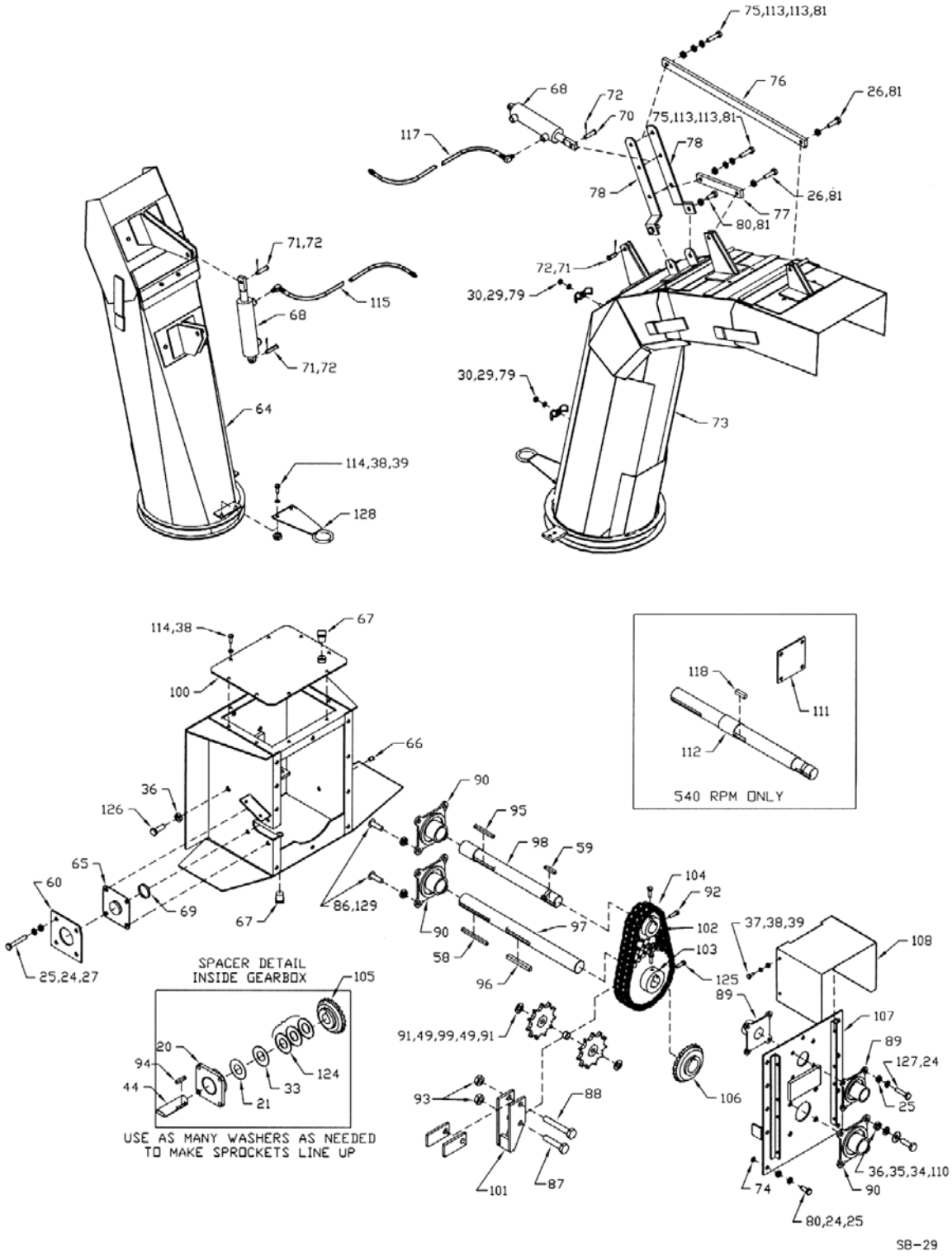
Snowblower Gearbox and Spouts Drawing



When Ordering Parts

Always give your dealer the Model, Color and Serial Number of your machine to assist them in ordering and obtaining the correct parts. Use the exploded view and tabular listing of the area of interest to exactly identify the required part.

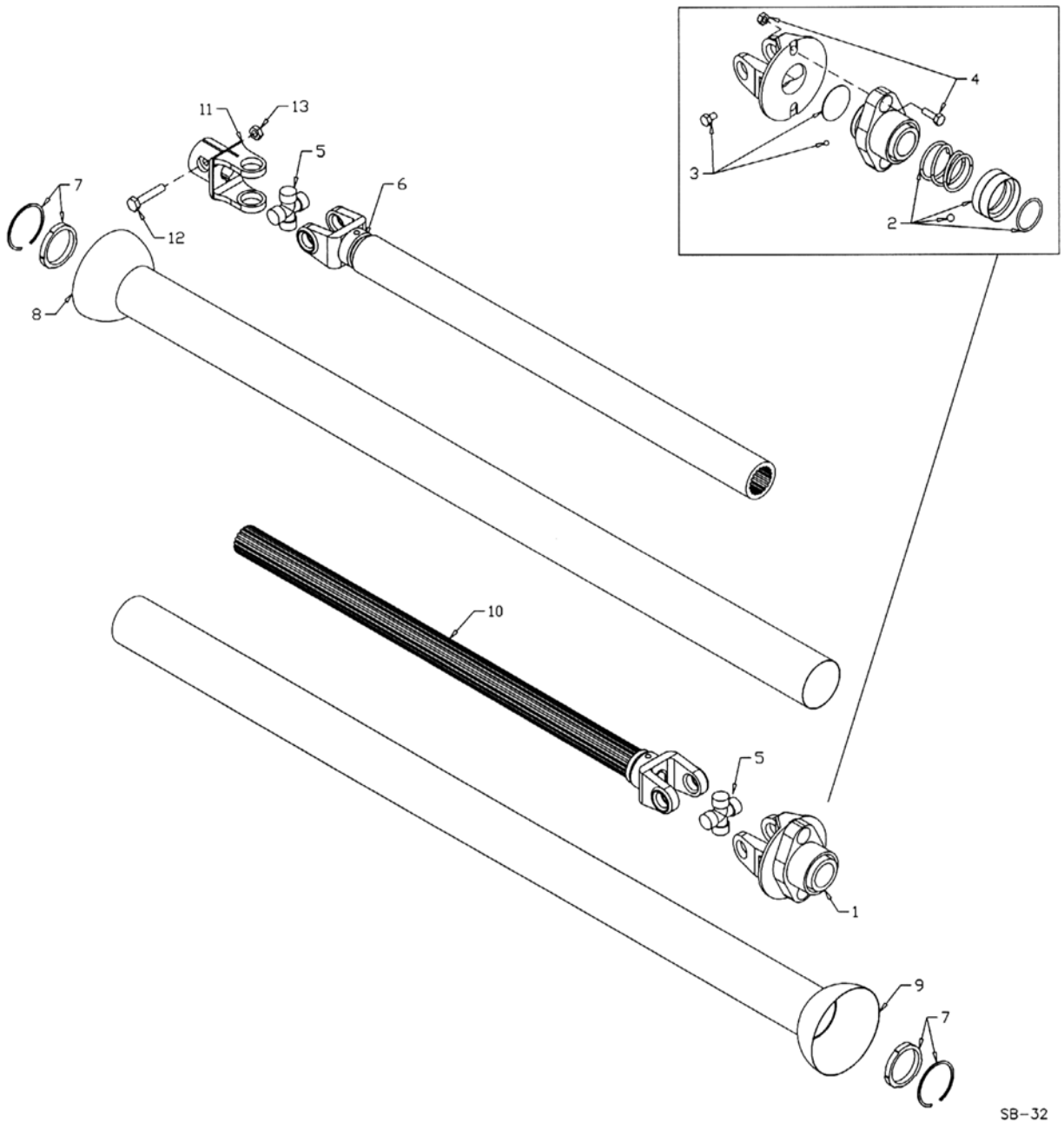
Item	Part Number	Description
1	906491A	Main Body Weldment
2	FX9244	3-point Hitch Weldment (902129)
3	965307A	Lower Hitch Tube (4" SQ. x 29-1/2")
4	902407	Skid Plate Weldment
	F6707	Skid Plate Bundle
5	900712	Skid Pin
6	965205A	Lower Hitch Tube Pin (1-1/4" x 5-1/2")
7	965206A	Upper Hitch Tube Pin (1" x 4-3/8")
8	961012	#16 Hair Pin Clip
9	967461	Lift Pin Cat 2-3
10	965910	Top Lift Pin (Category.2)
11	965911	7/16" Linch Pin
12	12779	#9 Hair Pin Clip
13	965209A	Cutting Edge
14	965308A	Jack Stand
15	965211A	Chain Guard
16	965302	Hydraulic Swivel Arm
17	965213A	Cylinder Arm Base
18	965654	3/8" x 80" Cable
19	964264	3/8" Cable Clamp
20	968632	1-1/2" Housing w/ Bearing - 4 Bolt
21	9812443	1-1/2" x 18GA Narrow Rim Washer
22	965215A	Spout Clamp
23	967475	1/2" x 1-3/4" Flush Head Bolt (skt) (pl)
24	81637	1/2" Lock Washer (pl)
25	81636	1/2" Hex Nut (pl)
26	87553	1/2" x 1-3/4" Hex Bolt (pl)
27	81628	1/2" x 3-1/4" Hex Bolt (pl)
28	86170	3/8" x 1" Hex Bolt (pl)
29	81593	3/8" Lock Washer (pl)
30	81592	3/8" Hex Nut (pl)
31	9812487	1-1/4" x 10GA Narrow Rim Washer (pl)
32	81210	1/4" x 2" Cotter Pin (pl)
33	9812444	1-1/2" x 14GA Narrow Rim Washer
34	81678	5/8" BS Flat Washer (pl)
35	81677	5/8" Lock Washer (pl)

Item	Part Number	Description
36	81676	5/8" Hex Nut (pl)
37	81549	5/16" x 3/4" Hex Bolt (pl)
38	81569	5/16" Lock Washer (pl)
39	81568	5/16" Hex Nut (pl)
40	965216	Auger (15" O.D. x 107-3/8" long)
41	902902	4-Blade Fan Weldment
42	965294A	Jack Stand Pin
43	F9231	Standard PTO (1-3/8" x 21 spline)
	F9232	Optional PTO (1-3/4" x 20 spline)
	F9233	540 RPM PTO (1-3/8" x 6 spline)
44	965280	Drive Shaft
45	965281A	Drive Shaft Guard
46	965221A	Shear Sprocket (13T, #80)
47	965222	Flighting Sprocket (40T, #80)
48	965282	Roller Chain (#80 X 109 link w/ Connector & Offset)
	965273	#80 Offset Link only
49	965224A	Idler Sprocket (11T. #80, 3/4" bore)
50	965225A	Idler Spacer (1-1/4" O.D. 3/4" ID x 2-5/16" lg)
51	811751	3/4" x 5" Hex Bolt (pl)
52	81702	3/4" B.S. Flat Washer (pl)
53	81701	3/4" Lock Washer (pl)
54	81700	3/4" Hex Nut (pl)
55	81552	5/16" x 1-1/4" GR. 5 Hex Bolt (pl)
56	812362	5/16" Lock Nut (pl)
57	811792	3/8" x 1-1/2" Hex Bolt (pl)
58	965226	Fan Key (3/8" x 3/8" x 5")
59	968807	PTO Key (3/8" x 3/8" x 2")
60	965296	Bearing Spacer
61	963030	1/2" x 3" Sq. Hd. Set Screw (pl)
62	984077	1/2" Jam Nut (pl)
63	84270	5/8" x 1-3/4" Hex Bolt (pl)
64	F9241	Standard Spout Weldment
65	965647	1-1/2" Oil Seal Plate
66	967451	1/2" Solid Pipe Plug
67	967452	1" Solid Pipe Plug
68	24930	Cylinder 1.75 Dia x 5.0 - 9/16" ORB
69	967453	Oil Seal (CR #15142)
70	960913	1/2" x 1-13/16" Clevis Pin (pl)
71	961876	1/2" x 1-1/2" Clevis Pin (pl)
72	9812430	1/8" x 1" Cotter Pin (pl)
73	F9243	Truckloader Spout Assembly 10' (965306 - Weldment)

Item	Part Number	Description
	F9234	Truckloader Spout Assembly 7' (965309 - Weldment)
74	82111	#111 O-Ring
75	811791	1/2" x 2" Hex Bolt (pl)
76	965304	Spout Link - 28-1/8"
77	965305	Spout Link - 8-3/4"
78	965238	Cylinder Arm
79	965239	Hose Clamp
80	81620	1/2" x 1-1/4" Hex Bolt (pl)
81	812364	1/2" Lock Nut (pl)
82	965266	Cat. 2-3 Top Link Pin Bushing
83	965267	Cat. 2-3 Lift Arm Bushing
84	965268	Fan Housing Liner
85	967431	3/8" x 1" Flat Head Bolt (pl)
86	905609	5/8" x 2-1/4" Flat Head Bolt (pl)
87	810149	3/4" x 3-1/2" Hex Bolt (pl)
88	905630	3/4" x 5" Idler Bolt
89	906497	1-3/4" Housing w/bearing (Ductile)
	965283	1-3/4" Bearing w/collar
	906498	1-3/4" Ductile Housing Only
90	906499	2" Housing w/bearing (Ductile)
	967375	2" Bearing w/collar
	906500	2" Ductile Housing Only
91	84050	3/4" SAE Flat Washer (pl)
92	985639	3/8" Dia x 1/2" Socket Set Screw
93	812365	3/4" Lock Nut (pl)
94	965821	3/8" x 1-3/4" Key
95	965284	3/8" x 3-3/4" Key
96	965285	1/2" x 4-1/2" Key
97	965286	Fan Shaft (2" x 23")
98	965667	Jack Shaft (2" 1-3/4" x 18-3/4")
99	965288	Idler Sprocket Spacer
100	965660	Gearbox Cover
101	965290	Chain Tightener Weldment
102	965269	Sprocket 15T, #80 DBL, 1-3/4" B
103	965270	Sprocket 28T, #80 DBL, 2" B
104	965271	Chain (#80 Dbl x 40 link w/ Connector)
105	965275	Gear 22T, 1-1/2" Bore
106	965274	Gear 22T, 2" Bore
107	906496	Gearbox Front Cover Plate
108	965655	PTO Guard
109	965295A	Idler Shield

Item	Part Number	Description
110	84299	5/8" x 2" Hex Bolt (pl)
111	965298A	1-3/4" Bearing Cover (540 RPM only)
112	965299	540 RPM Fan Shaft
113	81638	1/2" BS Flat Washer (pl)
114	812026	5/16" x 1" Hex Bolt (pl)
115	115370	3/8" x 114" Hose w/ 90 Degree Elbow
116	905080	Idler Assembly - Parts Only
117	115371	3/8" x 156" Hose w/ fittings
	115369	3/8 x 156 Hose 1/2 MNPT x 9/16 SWFJIC
	811918	Elbow 90 deg 9/16 SWMORB X 9/16 MJIC
	886786	Elbow 90 deg 1/4" MNPT X 9/16" MJIC
118	902127	1/2" x 1-3/4" Gear Key (540 RPM)
119	936402	PTO Safety Chain
120	967433	5/8" x 3-1/4" Hex Bolt (pl)
121	812482	5/8" Lock Nut (pl)
122	84277	1/2" x 1-1/2" Hex Bolt (pl)
123	967164	Pound-In Grease Fitting
124	967135	1-1/2" x 10GA Narrow Rim Washer (pl)
125	967474	3/8" x 1-1/4" Sq Hd Set Screw
126	84270	5/8" x 1-3/4" Hex Bolt (pl) (540 RPM)
	968898	5/8" x 4" Sq Hd Set Screw (1000 RPM)
127	81624	1/2" x 2-1/4" Hex Bolt (pl)
128	907590	Spout Hose Holder
129	812482	5/8" Lock Nut (pl)
130	909277	Manual holder

PTO Drawing



Item	Part Number	Description
	F9231	Standard Shaft (21 Spline, 1 3/8'') - 1000 RPM
	F9232	Optional Shaft (20 Spline, 1 3/4'') - 1000 RPM
	F9233	540 RPM Shaft (6 Spline, 1 3/8'')
1	936413	Standard Shear Assembly (21 Spl, 1 3/8'')
	936422	Shear Hub Only (21 Spl, 1 3/8'')
	936414	Optional Shear Assembly (20 Spl, 1 3/4'')
	936423	Shear Hub Only (20 Spl, 1 3/4'')
	936429	540 RPM Shear Assy (6 Spl, 1 3/8'')
	936424	Shear Hub Only (6 Spl, 1 3/8'')
	936428	Shear Yoke Only (All Sizes)
2	936415	Safety Slide Lock Repair Kit (20 Spl, 1 3/4'')
	936199	Safety Slide Lock Repair Kit (7 & 21 Spl, 1 3/8'')
3	936249	Shear Assy Repair Kit
4	908890	Shear Bolt - 3/8'' x 1'' (Gr.2) - 1000 RPM (Pack of 10)
	908846	Shear Bolt - 3/8'' x 1'' (Gr.8) - 540 RPM (Pack of 10)
5	936197	Repair Kit (Option)
	906548	Extended Life Repair Kit (Std)
6	936426	Yoke & Tube (Splined)
7	936417	Bearing & Snap Ring Kit
8	936418	Inner Guard
9	936419	Outer Guard
10	936425	Yoke & Shaft (Splined)
11	936421	Clamp Yoke
12	967433	5/8'' x 3 1/4'' Bolt
13	812482	5/8'' Lock Nut

Shipping Kit and Bundle Numbers

The following is a list of Kit Numbers for this product and the Bundle Numbers, Descriptions, and Quantities for each Kit.

Quantity	Bundle Number	Description
YC1080C - 1000 RPM with Standard Spout		
1	FX9244	Hitch
1	F9241	Standard Spout
1	FX0199	Body Assembly
1	F0560	Deflector Cylinder & Hose Kit
1	F9231	PTO 1000 RPM (1-3/8" x 21 Spline)
YC1080CT - 1000 RPM with Truckloader Spout		
1	FX9244	Hitch
1	F9243	Truckloader Spout
1	FX0199	Body Assembly
1	F9118	Deflector Cylinder & Hose Kit
1	F9231	PTO 1000 RPM (1-3/8" x 21 Spline)
YC1080D - 540 RPM with Standard Spout		
1	FX9244	Hitch
1	F9241	Standard Spout
1	FX0201	Body Assembly
1	F0560	Deflector Cylinder & Hose Kit
1	F9233	PTO 540 RPM (1-3/8" x 6 Spline)
YC1080DT - 540 RPM with Truckloader Spout		
1	FX9244	Hitch
1	F9243	Truckloader Spout
1	FX0201	Body Assembly
1	F9118	Deflector Cylinder & Hose Kit
1	F9233	PTO 540 RPM (1-3/8" x 6 Spline)

Optional Bundle Numbers

The following is a list of options available for the Kits listed above.

1	F9116	Swivel Arm Cylinder & Hose Kit
1	F9232	1000 RPM PTO (1-3/4" x 20 spline)
1	F9233	540 RPM PTO (1-3/8" x 6 Spline)
1	Y907	7' Truckloader Spout c/w Cylinder & Hoses
1	Y910	10' Truckloader Spout c/w Cylinder & Hoses

Allied by Farm King Limited Warranty

This document limits your warranty rights.

Base Limited Warranty

Buhler Industries Inc. provides this warranty only to original retail purchasers of its product. Buhler Industries Inc. warrants to such purchasers that all Buhler Industries Inc. manufactured parts and components used and serviced as provided for in the Operator's Manual shall be free from defects in materials and workmanship for a period following delivery to the original retail purchaser of 12 months (80 days for commercial applications). This limited warranty applies only to those parts and components manufactured by Buhler Industries Inc. Parts and components manufactured by others are subject to their manufacturer's warranties, if any.

Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Buhler Industries Inc. reserves the right to either inspect the product at the buyer's location or have it returned to the factory for inspection. Parts must be returned through the selling representative and the buyer must prepay transportation charges.

Buhler Industries Inc. will not be responsible for repairs or replacements that are necessitated, in whole or part, by the use of parts not manufactured by or obtained from Buhler Industries Inc. Under no circumstances are component parts warranted against normal wear and tear. There is no warranty on product pump seals, product pump bearings, rubber product hoses, pressure gauges, or other components that require replacement as part of normal maintenance. Also: Buckets and Bucket Tines carry no warranty, Bent Spears carry no warranty, Snowblower Fan Shafts carry no warranty, Mower Blades carry no warranty, Portable Auger Parts Have Two (2) Year Warranty, Loader Parts Have Two (2) Year Warranty. The purchaser is solely responsible for determining suitability of goods sold. This warranty is expressly in lieu of all other warranties expressed or implied. Buhler Industries Inc. will in no event be liable for any incidental or consequential damages whatsoever. Nor for any sum in excess of the price received for the goods for which liability is claimed.

Repair Parts Limited Warranty

Buhler Industries Inc. warrants Farm King replacement parts purchased after the expiration of the Buhler Industries Inc. Limited Warranty, and used and serviced as provided for in the Operator's Manual, to be free from defects in materials or workmanship for a period of thirty (30) days from the invoice date for the parts. Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Such parts must be shipped to Buhler Industries Inc. at the purchaser's expense.

What is Not Covered

Under no circumstances does this limited warranty cover any components or parts that have been subject to the following: negligence; alteration or modification not approved by Buhler Industries Inc.; misuse; improper storage; lack of reasonable and proper maintenance, service, or repair; normal wear; damage from failure to follow operating instructions; accident; and/or repairs that have been made with parts other than those manufactured, supplied, and or authorized by Buhler Industries Inc.

Authorized Dealer and Labor Costs
Repairs eligible for labor under this limited warranty must be made by Buhler Industries Inc. or an authorized Farm King dealer. Buhler Industries Inc. retains the exclusive discretion to determine whether it will pay labor costs for warranty repairs or replacements, and the amount of such costs that it will pay and the time in which the repairs will be made. If Buhler Industries Inc. determines that it will pay labor costs for warranty work, it will do so by issuing a credit to the dealer's or distributor's account. Buhler Industries Inc. will not approve or pay invoices sent for repairs that Buhler Industries Inc. has not previously approved. Warranty service does not extend the original term of this limited warranty.

Warranty Requirements
To be covered by warranty, each Farm King new product must be registered with Buhler Industries Inc. within thirty (30) days of delivery to original retail purchaser. If the customer decides to purchase replacement components before the warranty disposition of such components is determined, Buhler Industries Inc. will bill the customer for such components and then credit the replacement invoice for those components later determined to be covered by this limited warranty. Any such replacement components that are determined not be covered by this limited warranty will be subject to the terms of the invoice and shall be paid for by the purchaser.

Warranty Claims:
Warranty requests must be prepared on Buhler Industries Inc. Warranty Claim Forms with all requested information properly completed. Warranty Claims must be submitted within a thirty (30) day period from date of failure repair.

Warranty Labor:
Any labor subject to warranty must be authorized by Buhler Industries Inc. The labor rate for replacing defective parts, where applicable, will be credited at 100% of the dealer's posted shop rate. Defective parts will receive an extra 10% discount to assist with freight or other incidental costs.

Exclusive Effect of Warranty and Limitation of Liability

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY WARRANTIES, REPRESENTATIONS, OR PROMISES, EXPRESS OR IMPLIED, AS TO THE QUALITY, PERFORMANCE, OR FREEDOM FROM DEFECT OF THE COMPONENTS AND PARTS COVERED BY THIS WARRANTY AND NOT SPECIFICALLY PROVIDED FOR HEREIN.

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ON ITS PRODUCTS COVERED HEREIN, AND DISCLAIMS ANY RELIANCE BY THE PURCHASER ON BUHLER INDUSTRIES INC.'S SKILL OR JUDGMENT TO SELECT OR FURNISH GOODS FOR ANY PARTICULAR PURPOSE. THE PURCHASER'S ONLY AND EXCLUSIVE REMEDIES IN CONNECTION WITH THE BREACH OR PERFORMANCE OF ANY WARRANTY ON PRODUCTS MANUFACTURED BY BUHLER INDUSTRIES INC. ARE THOSE SET FORTH HEREIN. IN NO EVENT SHALL BUHLER INDUSTRIES INC. BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING, BY WAY OF EXAMPLE ONLY AND NOT LIMITATION, LOSS OF CROPS, LOSS OF PROFITS OR REVENUE, OTHER COMMERCIAL LOSSES, INCONVENIENCE, OR COST OF REPLACEMENT OF RENTAL EQUIPMENT). IN NO EVENT SHALL FARM KING'S CONTRACT OR WARRANTY LIABILITY EXCEED THE PURCHASE PRICE OF THE PRODUCT.

(Note that some provinces or states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitations and exclusion may not apply to you.) This warranty gives you specific legal rights and you may also have other rights, which vary from province to province or state to state.

Buhler Industries Inc. neither assumes nor authorizes any person or entity, including its selling representatives, to assume any other obligations or liability in connections with the sale of covered equipment, or to make any other warranties, representations, or promises, express or implied, as to the quality, performance, or freedom from defect of the components and parts covered herein. No one is authorized to alter, modify, or enlarge this limited warranty, or its exclusions, limitations and reservations.

Corrections of defects and improper workmanship in the manner, and for the applicable time periods, provided for herein shall constitute fulfillment of all responsibilities of Buhler Industries Inc. to the purchaser, and Buhler Industries Inc. shall not be liable in negligence, contract, or on any other basis with respect to the subject equipment.

This limited warranty is subject to any existing conditions of supply which may directly affect Buhler Industries Inc.'s ability to obtain materials or manufacture replacement parts.

Buhler Industries Inc. reserves the right to make improvements in design or changes in specifications to its products at anytime, without incurring any obligation to owners of units previously sold.

Government Legislation:
Warranty terms and conditions are subject to provincial or state legislation.

Important Note: This warranty does not apply to rentals.

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