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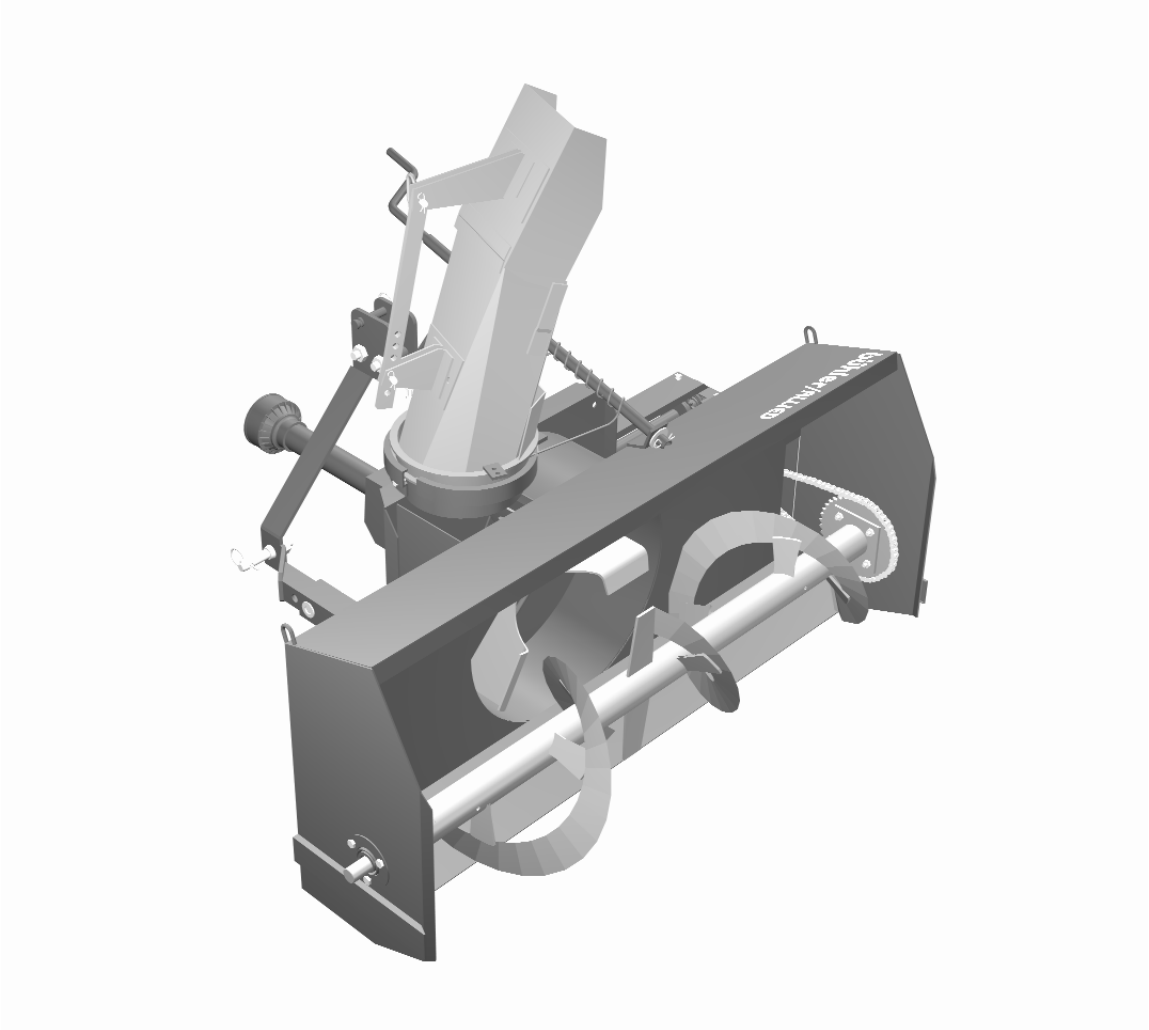


50" & 60" Snowblowers

Operator's and Parts Manual
FK312

2009

TABLE OF CONTENTS

DESCRIPTION **PAGE**

WARRANTY 1

INTRODUCTION 2

SAFETY 3
- Safety 3
- General Safety 4
- Start Up Safety 4
- Operation Safety 4
- Transport Safety 5
- Service and Maintenance Safety 5
- Storage Safety 5
- Safety Signs 5
- Safety Sign Installation 6

ASSEMBLY 7
- Assembly Instructions 7

OPERATION 10
- Operating Instructions 10
- Theory of Operation 12

MAINTENANCE 13
- Bolt Torque 13

PARTS DRAWINGS 14
- 50” & 60” Snowblower Drawings 14
- 50” & 60” Snowblower Parts Lists 16
- 50” & 60” Snowblower PTO Shaft Drawing 19
- 50” & 60” Snowblower PTO Shaft Parts Lists 20
- Cylinder Drawing & Parts List 21

SHIPPING KIT AND BUNDLE NUMBERS 22

WARRANTY POLICY

Buhler Manufacturing products are warranted for a period of twelve (12) months (90 days for commercial application) from original date of purchase, by original purchaser, to be free from defects in material and workmanship under correct, normal agricultural use and proper applications.

Buhler Manufacturing’s obligations under this warranty shall be limited to the repair or exchange, at Buhler Manufacturing’s option, of any Buhler Manufacturing product or part which proves to be defective as provided. Buhler Manufacturing reserves the right to either inspect the product at the buyer’s location or have it returned to the factory for inspection.

The above warranty does not extend to goods damaged or subject to accident, abuse or misuse after shipment from Buhler Manufacturing’s factory, nor to goods altered or repaired by anyone other than an authorized Buhler Manufacturing representative.

Buhler Manufacturing makes no Express Warranties other than those, which are specifically described. Any description of goods, including any references and specifications in catalogues, circulars and other written material published, is for the sole purpose of identifying goods and shall conform to such descriptions. Any sample or model is for illustrative purposes only and does not create an Express Warranty that the goods conform to sample or model shown.

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 Manufacturing 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.

WARRANTY CLAIMS:

Warranty requests must be prepared on Buhler Manufacturing 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 Manufacturing. 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.

GOVERNMENT LEGISLATION:

Warranty terms and conditions are subject to Provincial or State legislation.

IMPORTANT FACTS:

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

IMPORTANT NOTE: This warranty does not apply to rentals

INTRODUCTION

Buhler Allied has years of snowblower manufacturing expertise and thousands of acreages, farms and cities depend on Buhler snowblowers. PTO-driven Buhler Allied Snowblowers will mount to a tractor with a category 1 3-point hitch or category 1 Quick Hitch. You can attach your snowblower to the Quick Hitch from your tractor seat with ease, speed and safety. These models have open gearboxes. Adjustable cup type skid shoes are standard on all models. The three blade fan is standard, and a four blade fan is available as an option.

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. A hitch system, which is quick-hitch compatible, is standard on all models. A length-adjustable hitch is standard on all models. Also available is an optional Hydraulic Spout Control. 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 Buhler Dealer if you need assistance, information, or additional copies of the manual. Visit our website at www.buhler.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

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 Buhler 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.
Stay clear of Snowblower augers.
Stay clear of Snowblower discharge chute. Rocks or debris can be picked up and thrown.
Never operate over 540 rpm PTO speed.
Never operate the 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

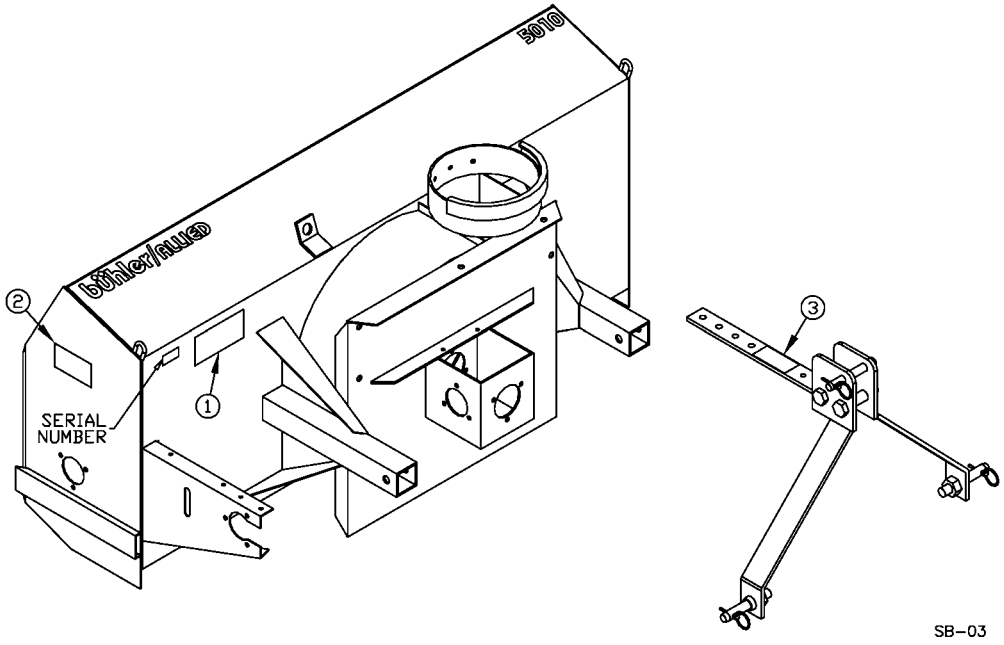
Store the unit in an area away from human activity.
Do not permit children to play on or around the stored machine.
Support the frame on stands and blocks to provide a secure base.

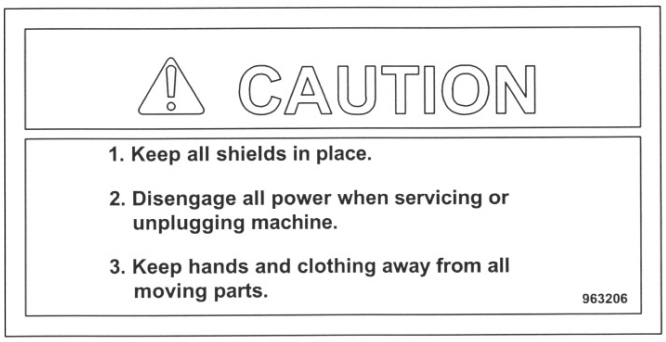
SAFETY SIGNS

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 OF SAFETY SIGNS

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.





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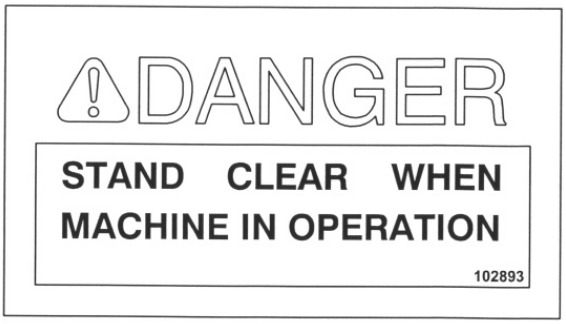

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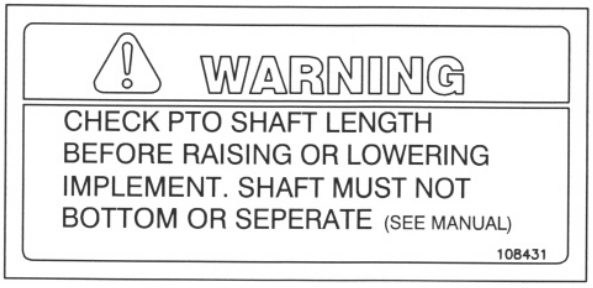

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Replace safety signs immediately should they become damaged, torn or illegible. Obtain replacements from your authorized dealer using the part numbers shown.

50" & 60" SNOWBLOWER ASSEMBLY INSTRUCTIONS

1. Mount the discharge spout (#2) using the spout clamp (#3) bolted to the spout ring on the snowblower. Lubricate the spout ring and clamp. **NOTE:** A hydraulic cylinder and hose kit to control the spout deflector is available as an option.

2. **Hitch Assembly**: With right and left hitch tubes (#5 & #6) turned as shown in drawing, slide them into the sleeves welded to the main body. These tubes are adjustable to four different positions. The correct position for each individual tractor will be determined when mounting the snowblower on the tractor. These tubes are connected to the snowblower with a 3/4" x 3 ¼” pin (#11) and a hairpin clip (#12). Bolt the left (#83) and the right (#84) hitch arms to the outside of the clevises on the hitch tubes using the lift pins (#9). **NOTE:** Pins should be turned to the outside. Do not tighten any hardware until assembly is complete. Join the top of the hitch arms by bolting a 1” O.D. x 2 ¼” spacer (#4) between the top plates using a ¾” x 4” bolt and lock nut through the lower outside holes. Bolt the hitch top bar (#85) between the same plates using the same bolt through the welded tube on the bar. Use the inside holes on the top plates for the top bar. The other end of the hitch top bar bolts to the top of the blower fan housing with a ½” x 1 ¾” hex bolt, lock washer and hex nut. Use the same hole position as the hitch tubes. Tighten all hardware.

   A category 1 top link pin (#8) is fitted in the top holes of the hitch arm plates. This pin is used for standard three-point hitch only. The bushing in the lower holes is used for the quick hitch.

3. **Hand Crank Assembly:** (Standard)
   a) Bolt the crank mounting bracket (#16) to the top of the hitch using 3/8" x 1 ¼” hex bolts, lock washers and hex nuts.
   b) Insert the crank handle (#15) through the mount and through the bracket welded to the main housing. Lock the crank in place using a washer and roll pin on each side of the bracket.
   c) Thread the cable (#17) through the hole in the crank tube to even lengths and wrap around the tube to each side of the hole four turns in opposite directions.
   d) With the spout turned forward, fasten the cable to the bracket welded to the bottom of the spout using a ¼” cable clamp (#70).

ASSEMBLY INSTRUCTIONS – cont’d.

4. **Hydraulic Control Assembly**: (option)
   a) Bolt the hydraulic swivel assembly (#21) to the back of the fan housing on the left side using ½” x 1 ¼” hex bolts, lock washers and hex nuts.
   b) Bolt the cylinder mounting bracket (#23) to the back of the fan housing on the right side using the same size hex bolts.
   c) Turn the spout forward and the center of the swivel arm in line with the spout center. With the spout and swivel arm in this position, wrap the cable (#22) around the spout and clamp to both ends of the swivel arm and to the bracket welded to the bottom of the spout using 3/16" cable clamps (#20).
   d) Use a standard 8" stroke cylinder (20 1/4" min., 28 1/4" max. pin centers).

5. **Mounting Blower on Tractor**:
   a) Mount the blower on a tractor with a category 1 hitch.
   b) Using tape or a bright colored marking pen, mark on the outer shield 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.
   c) With the engine on the tractor shut off, attach the PTO shaft. The tractor end has a standard 6-spline end with a spring loaded locking collar. The snowblower end has a clamp-style yoke with a ¼” keyway. Slide the yoke onto the gearbox shaft with a ¼” key supplied. Lock the yoke in place with the ½” x 3” hex 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.
      ⚠ **CAUTION:** 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.
   d) Check that the PTO shaft does not bottom or separate with the blower in the extreme high and low positions. Check to see which of the four different hitch positions will allow you to keep about a 4" minimum overlap on the PTO shields without bottoming out. This position varies between different tractor models because of the different lengths of the three-point arms. If the PTO shaft is still too long with the hitch fully extended, the PTO shaft will have to be cut shorter. Check for free movement of all parts in various raised positions; particularly the PTO shaft.

ASSEMBLY INSTRUCTIONS – cont’d.

6. **PTO Shield**:

All snowblowers manufactured for the 1990 production and up are supplied with a PTO shield. The PTO shield (#65) bolts to the gearbox assembly using ¼” x ¾” hex bolts. Hook one end of the spring (#66) in the hole in the back edge of the PTO shield and the other end of the spring in the hole punched in the edge of the gearbox assembly.

⚠ **CAUTION:** Do not run the snowblower without the PTO shield in place.

OPERATING 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. **NOTE:** PTO shaft angle should not exceed 20° for optimum performance and life. Damage may occur to PTO and/or snowblower if angle becomes more extreme.

2. Depth of 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. ⚠ **ALERT:** Excessive backward tilt may cause the “U” joints to flutter resulting in PTO shear bolt failure.

3. Adjust the lower link sway chains or blocks on the tractor to restrict side movement of the blower when operating

4. Run the blower at low rpm to check operation before blowing snow.

5. The snowblower has two shear bolts to protect the tractor and blower in case a large object enters the blower. PTO shear bolts – 50” - one 3/8" x 1" (gr.8), 60” - two - 5/16" x 1" (gr. 8), auger shear bolt - 1/4" x 1" (gr. 2). Shear bolts should be fastened with a lock nut or two jam nuts. These bolts must be kept tight to prevent wear of the bolt and bolt holes.

6. Never run PTO shaft at over 600 rpm.

7. Chain Tension: Slack on the lower side of the chain should be 3/8 to ½”.

8. Lubrication:
   a) The spout clamps and rings should be periodically lubricated with gun grease.
   b) PTO shaft universal joints and square shaft slide should be greased daily.
   c) PTO shear yoke should be greased before using the blower for the first time.
   d) Regularly oiling the chain will significantly increase the life of the chain.
   e) Gearbox is open type and need not be greased or lubricated.
   f) Hydraulic spout option – grease the swivel arm.

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

10. ⚠ **DANGER:** Always stop blower for servicing or unplugging. The PTO should be disengaged before dismounting from the tractor.

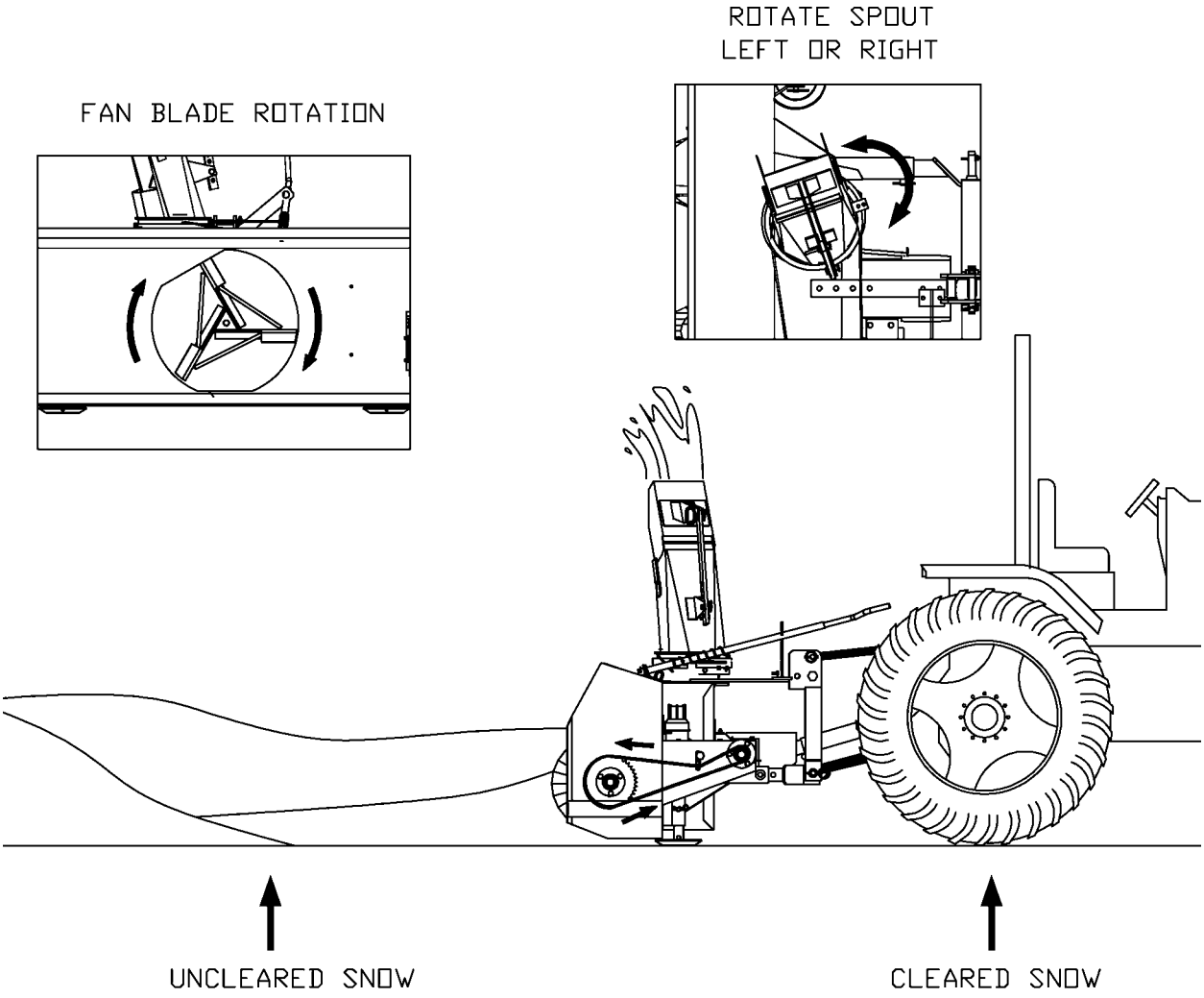
OPERATING INSTRUCTIONS – cont’d.

11. ⚠ **CAUTION:** Always check to see that both ends of the PTO shaft are securely attached as per instructions every time you are preparing to use the snowblower.

12 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.

13. Shear Sprocket: The shear sprocket (#43) should be checked at the beginning of every season to make sure it will spin freely. With time the sprocket plate could corrode and seize which will not allow the shear bolt to break if something jams in the snowblower auger. Clean to loosen if necessary.

THEORY OF OPERATIONS



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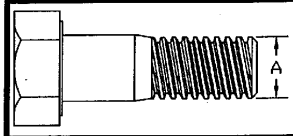
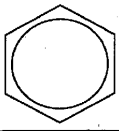
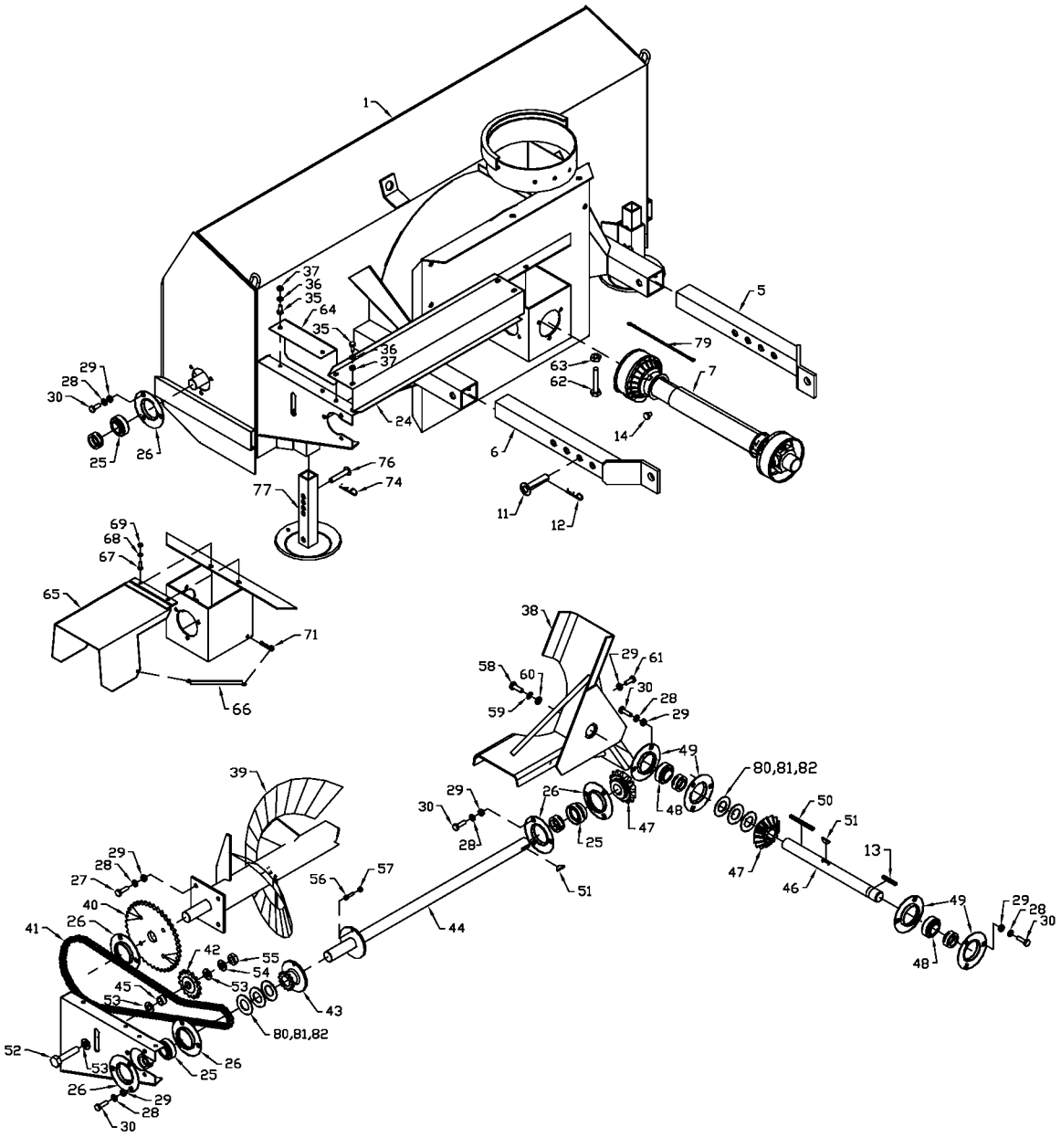
MAINTENANCE

Bolt Torque						
						
Bolt Diameter	SAE2		SAE5		SAE8	
"A"	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft
1/4"	8	6	12	9	17	12
5/16"	13	10	25	19	36	27
3/8"	27	20	45	33	63	45
7/16"	41	30	72	53	100	75
1/2"	61	45	110	80	155	115
9/16"	95	70	155	115	220	165
5/8"	128	95	215	160	305	220
3/4"	225	165	390	290	540	400
7/8"	230	170	570	420	880	650
1"	345	225	850	630	1320	970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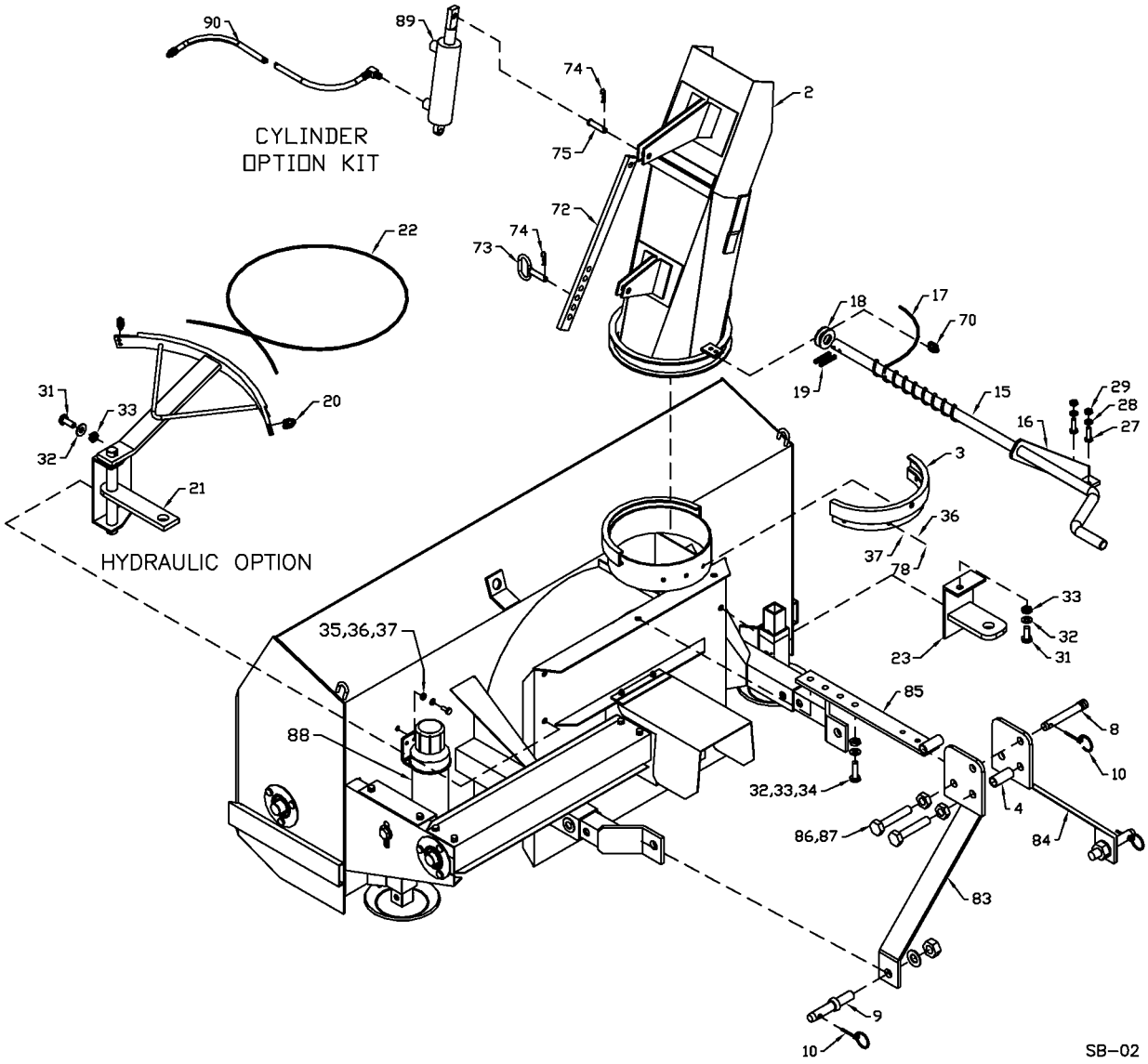

CYLINDER
OPTION KIT
HYDRAULIC OPTION
SB-02

WHEN ORDERING PARTS

Always give your dealer the Model, Color and Serial Number of your machine to assist him 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.

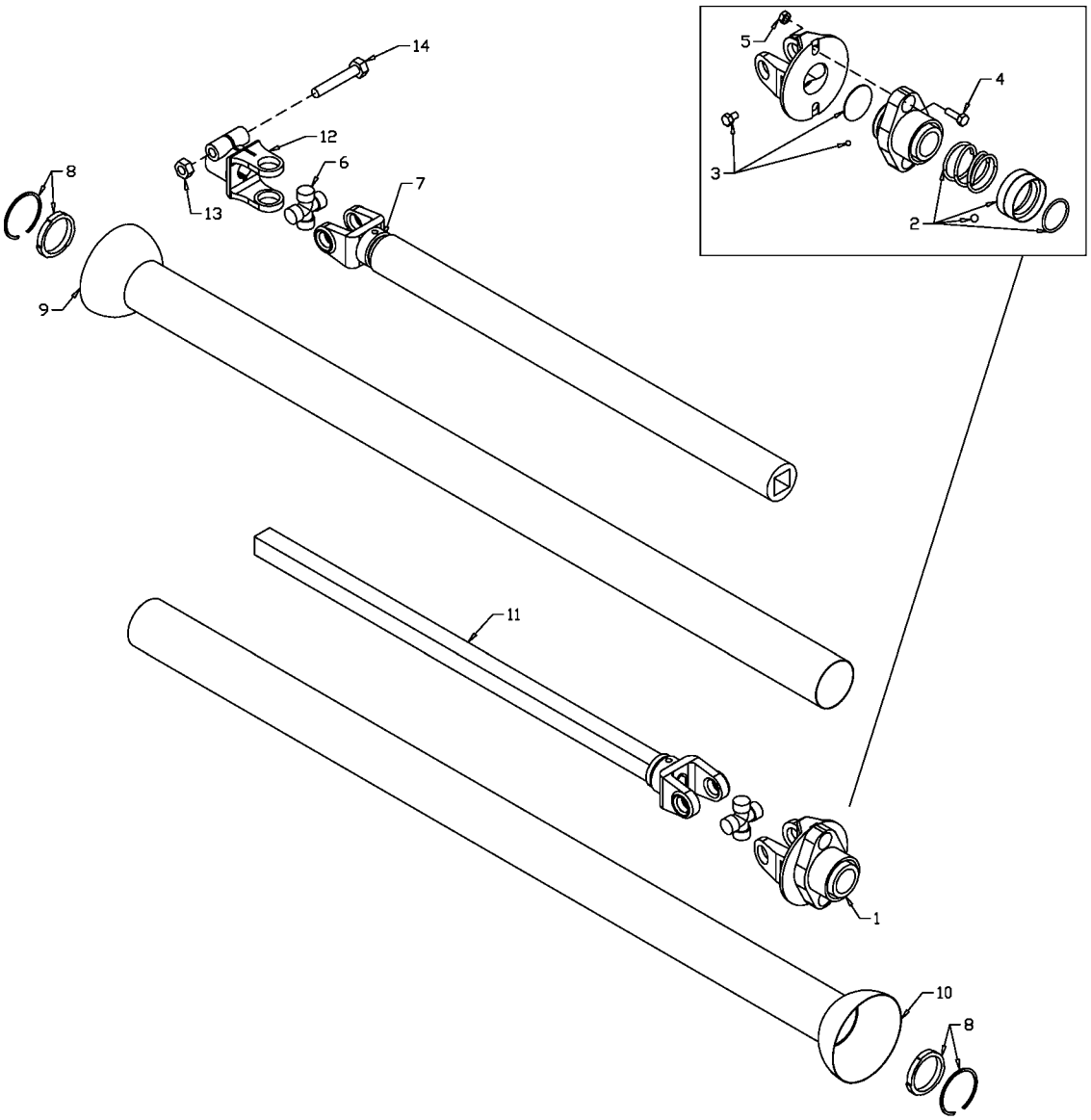
50" & 60" SNOWBLOWERS

ITEM	PART #	DESCRIPTION
1	905595	Main Body (50")
	905596	Main Body (60")
2	965645	Discharge Spout
3	965638	Spout Clamp
4	906770	Hitch Spacer 1"OD x 2 1/4"
5	907127	Hitch Tube Weldment - Right
6	907128	Hitch Tube Weldment - Left
7	F512	PTO Shaft (50")
	F612	PTO Shaft (60")
8	965807	Top Link Pin (Category 1)
9	965809	Lift Pin W/ Nut And Washer (Category 1)
10	965911	7/16" Linch Pin
11	965624	Hitch Pin 3/4" x 3 1/4"
12	12779	#9 Hair Pin Clip
13	968811	Pto Key - 1/4" x 2"
14	988999	3/8"Dia. x 3/8" Socket Set Screw
15	906667	Crank Handle
16	965634	Crank Mounting Bracket
17	965616	Crank Cable - 3/16" x 84" Long
18	9812438	1" ID x 14 Ga Narrow Rim Washer
19	9812425	1/4" x 1 1/4" Spring Pin
20	965806	3/16" Cable Clamp
21	965626	Hydraulic Swivel Weldment
22	965627	Hydraulic Cable - 3/16" x 58"
23	965628	Cylinder Mounting Bracket
24	965512	Drive Shaft Guard (50")
	965644	Drive Shaft Guard (60")
25	965818	1 1/4" Bearing W/ Collar
26	961637	1 1/4" Bearing Retainer
27	86171	3/8" x 1 1/4" Hex Bolt
28	81593	3/8" Lock Washer
29	81592	3/8" Hex Nut
30	86170	3/8" x 1" Hex Bolt

31	81620	1/2" x 1 1/4" Hex Bolt
32	81637	1/2" Lock Washer
33	81636	1/2" Hex Nut
34	87553	1/2" x 1 3/4" Hex Bolt
35	81549	5/16" x 3/4" Hex Bolt
36	81569	5/16" Lock Washer
37	81568	5/16" Hex Nut
38	965630	Fan (50") (Standard 3-Blade)
	965445	Fan (50") (4-Blade)
	965642	Fan (60") (Standard 3-Blade)
	907118	Fan (60") (4-Blade)
39	965505	Auger (50")
	965610	Auger (60")
40	965637	40 Tooth Sprocket - 50" & 60"
41	965631	Roller Chain (#50 x 94 Link with Connector)
42	965844	Idler Sprocket, 15T, #50
43	965826	Shear Sprocket, 13T, #50
44	965507	Drive Shaft (50"), 1 1/4" x 25 1/2"
	965613	Drive Shaft (60"), 1 1/4" x 30 1/2"
45	965632	Idler Spacer - 1/2" Long
46	965069	Fan Shaft 1 1/4" x 14 1/2"
47	961882	Bevel Gear, 1 1/4" Bore
48	961676	1 1/4" Bearing W/ Collar
49	961675	1 1/4" Bearing Retainer
50	901331	Fan Key - 1/4" x 3 1/2"
51	109343	3/16" x 1 1/8" Woodruff Key
52	84335	5/8" x 2 1/2" Hex Bolt
53	81678	5/8" Flat Washer BS
54	81677	5/8" Lock Washer
55	81676	5/8" Hex Nut
56	812216	1/4" x 1" Hex Bolt (Grade 2)
57	84498	1/4" Lock Nut
58	81598	7/16" x 1 1/4" Hex Bolt
59	81615	7/16" Lock Washer
60	981616	7/16" Flat Washer
61	81213	3/8" x 1" Sq. Hd. Set Screw
62	81627	1/2" x 3" Hex Bolt
63	812364	1/2" Lock Nut
64	965968	Idler Shield
65	965643	Gearbox Lid
66	960135	Pto Guard Spring
67	81525	1/4" x 3/4" Hex Bolt
68	81545	1/4" Lock Washer
69	81544	1/4" Hex Nut

70	961658	1/4" Cable Clamp
71	9812434	1/4" x 1 1/2" Cotter Pin
72	965646	Spout Adjustment Bar
73	903523	1/2" x 1 1/2" Adjustment Pin Weldment
74	961012	#16 Hair Pin Clip
75	961876	1/2" x 1 1/2" Clevis Pin
76	901435	1/2" X 2 1/2" Clevis Pin
77	902477	Skid Plate Weldment
	F6598	Skid Plate Bundle
78	812026	5/16" X 1" Hex Bolt
79	936402	PTO Safety Chain
80	9812487	Narrow Rim Washer 1 1/4" x 10ga
81	967110	Narrow Rim Washer 1 1/4" x 14ga
82	9812439	Narrow Rim Washer 1 1/4" x 18ga
83	907133	Hitch Arm Weldment - Left
84	907134	Hitch Arm Weldment - Right
85	907138	Hitch Top Bar Weldment (50")
	907139	Hitch Top Bar Weldment (60")
86	84336	3/4" x 4" Hex Bolt
87	812365	3/4" Lock Nut
88	909277	Manual Holder
89	24930	Cylinder 1.75"Dia x 5.0 - 9/16" ORB
90	115370	3/8" x 114" Hyd Hoses C/W Fittings

50” & 60” ALLIED SNOWBLOWER PTO SHAFT



SB–05

50" Allied Snowblower PTO Parts List

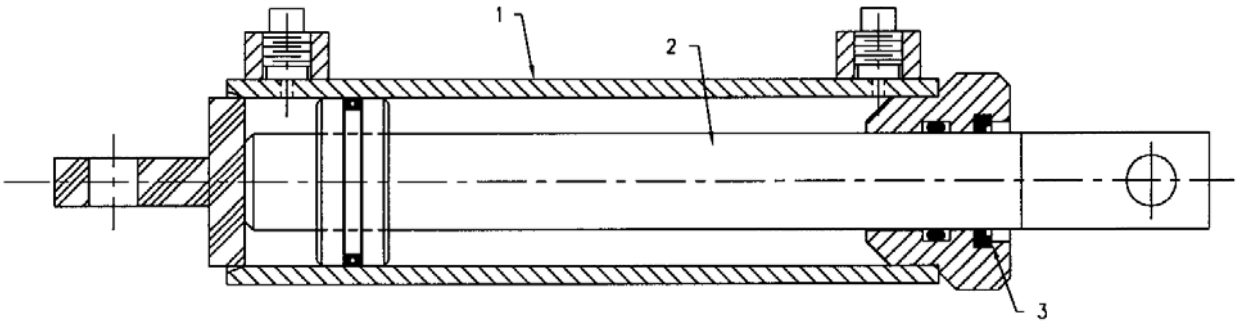
Item #	Part #	Description
	F512	Shaft Complete
	936379	Tractor Half of PTO (shear)
	936380	Implement Half of PTO (clamp yoke)
1	936247	Shear Assembly
2	936168	Spring - Lock Kit (Collar, Spring, Ret. Ring, 2-3/8" Balls)
3	936248	Shear Kit (3/8" x 1/2" Bolt, Blank, 24-1/4" Balls
4	967270	Shear Bolt 3/8" x 1" (grade 8) - 1 required
5	812363	3/8" Lock Nut
6	936079	Repair Kit (Option)
	906547	Extended Life Repair Kit (Std.)
7	936381	Yoke & Tube
8	936389	Bearing & Snap Ring Kit
9	936382	Inner Guard
10	936383	Outer Guard
11	936384	Yoke & Shaft
12	936254	Clamp Yoke
13	81627	1/2" x 3" Hex Bolt (pl)
14	812364	1/2" Lock Nut (pl)

60" Allied Snowblower PTO Parts List

Item #	Part #	Description
	F612	Shaft Complete
	936385	Tractor Half of PTO (shear)
	936386	Implement Half of PTO (clamp yoke)
1	936167	Shear Assembly
2	936168	Spring - Lock Kit (Collar, Spring, Ret. Ring, 2-3/8" Balls)
3	936248	Shear Kit
4	903297	Shear Bolt 5/16" x 1" (grade 8) (pack of 10)
5	812362	5/16" Lock Nut
6	936093	Repair Kit (Option)
	906503	Extended Life Repair Kit (Std.)
7	936375	Yoke & Tube
8	936319	Bearing & Snap Ring Kit
9	936391	Inner Guard
10	936377	Outer Guard
11	936378	Yoke & Shaft
12	936262	Clamp Yoke
13	81627	1/2" x 3" Hex Bolt (pl)
14	812364	1/2" Lock Nut (pl)

1.75 X 5 CYLINDER ASSEMBLY

Item #	Part #	Description
	24930	Cyl Complete
1	115367	Tube Weldt
2	112104	Shaft Weldt 1.0 Dia
3	X2669	Seal Kit



24930

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 NO.	DESCRIPTION
YC5010 50” Snowblower w/hand crank, 3-blade fan		
1	F0432	Body Assembly
YC5010-4 50” Snowblower w/hand crank, 4-blade fan		
1	F0433	Body Assembly
YC6010 60” Snowblower w/hand crank, 3-blade fan		
1	F0436	Body Assembly
YC6010-4 60” Snowblower w/hand crank, 4-blade fan		
1	F0437	Body Assembly

OPTIONAL BUNDLE NUMBERS

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

FX9304	Hydraulic Chute control for 50” & 60” Snowblower (less cylinder)
FX9305	Hand crank for 50” & 60” Snowblowers
F512	50” Snowblower PTO
F612	60” Snowblower PTO
F9117	Deflector Cylinder & Hose Kit for 50” & 60”
F621	Optional Long PTO for 50” & 60”
F0695	2” x 8” Hydraulic Cylinder & Hose Kit

NOTES

DIVISION LOCATIONS

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Printed in Canada