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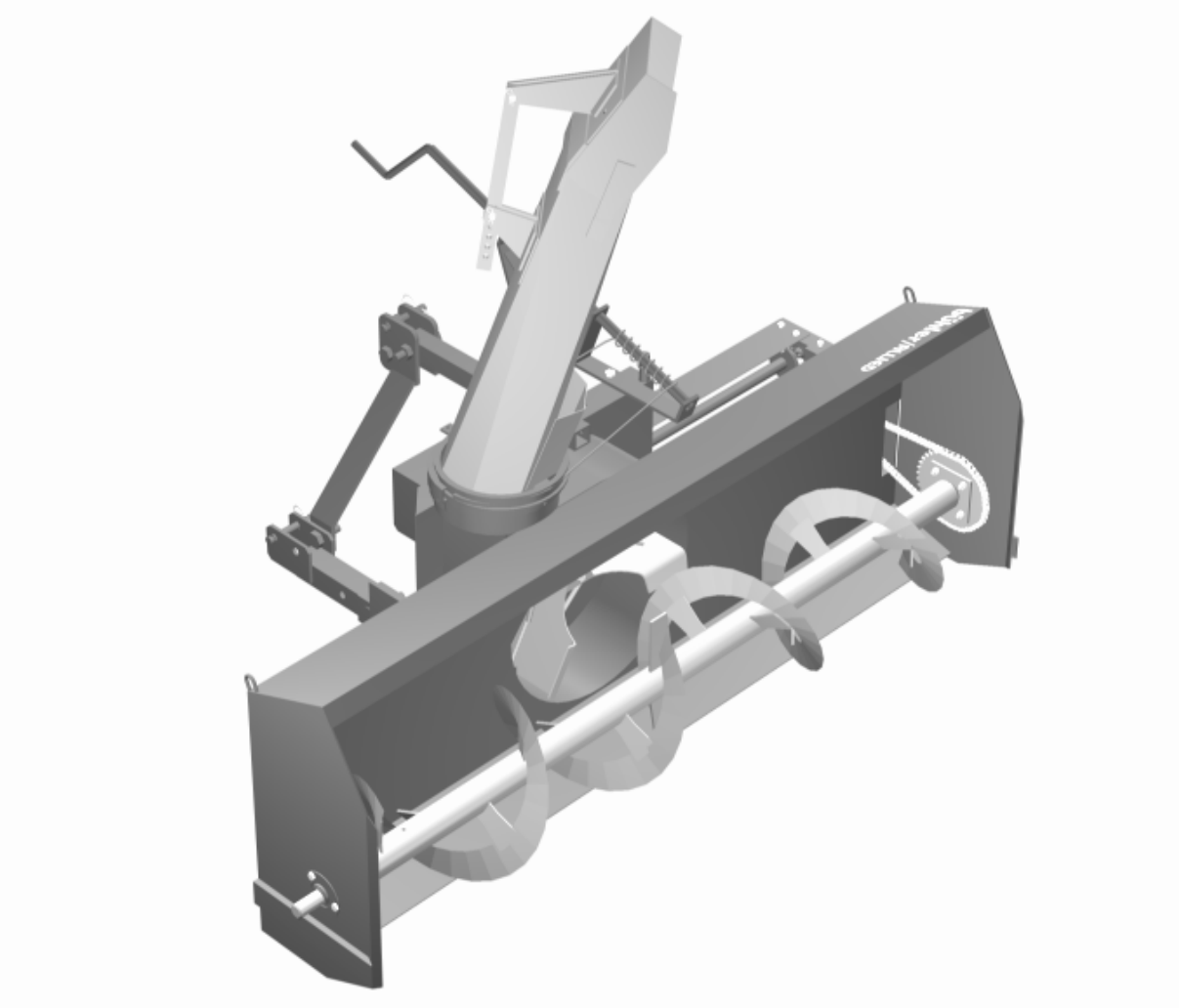


74" Snowblower

Operator's and Parts Manual
FK331

2009

TABLE OF CONTENTS

DESCRIPTION **PAGE**

WARRANTY 1

INTRODUCTION 2

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

ASSEMBLY 7
- Assembly Instructions 7

OPERATION 9
- Operating Instructions 9
- Theory Of Operation 10

MAINTENANCE 11
- Bolt Torque 11

PARTS DRAWINGS 12
- 74” Allied Snowblower Drawings 12
- 74” Allied Snowblower Parts Llist 14
- 74” Allied Snowblower PTO Drawing 17
- 74” Allied Snowblower PTO (Standard) List 18
- 74” Allied Snowblower (Opt. Long) Parts List 19
- Cylinder Drawings & Parts Lists 20

SHIPPING KIT AND BUNDLE NUMBERS 21

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 attach to a 3-point hitch. This model is supplied with a category 1 pins and also bushings which convert the pins to a category 2. Adjustable cup type skid shoes are standard on all models.

Three blade fans are on all models. A 4 blade fan is also 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 longer 36” PTO shaft is optional on the 74” model.

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 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 ignoring good safety practices.

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

This safety alert symbol means…

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

CAUTION

This 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 lights and reflections 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

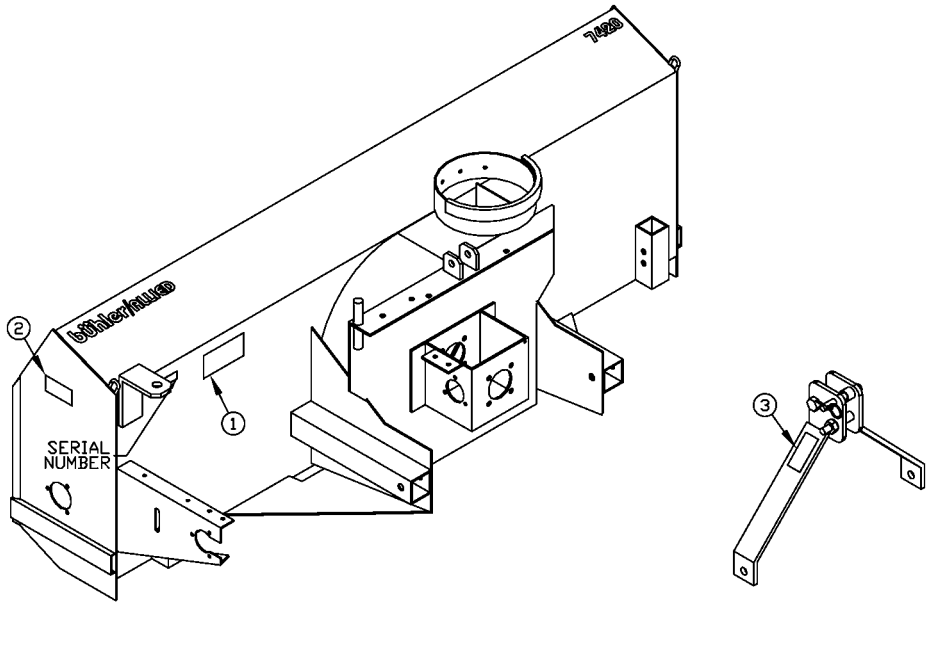
Store the unit in an area away from human activity.
Do not permit children to play on or around the stored machine.
Support the frame on stands and blocks to provide a secure base.

SAFETY SIGNS

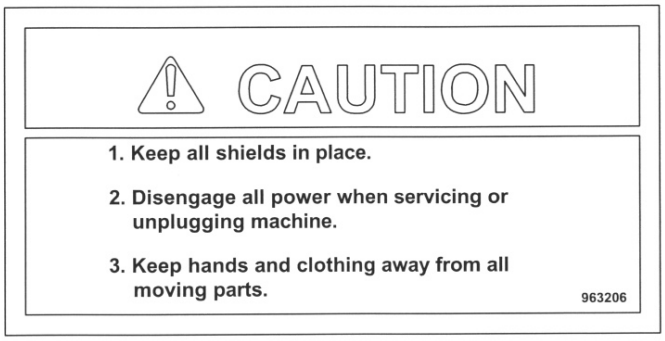
The following illustration shows the approximate location and detail of safety signs. Keep all safety signs clean and legible and replace any that are damaged or missing. When original parts are replaced, any safety signs are available from your local dealer.

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.

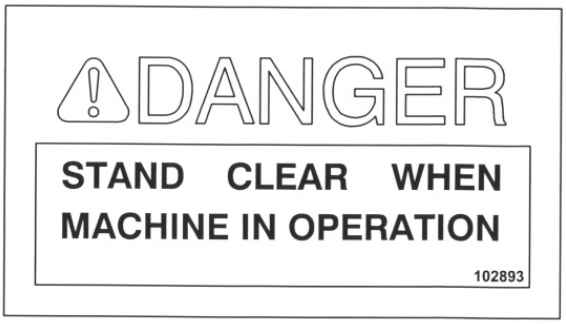


SB–09



#1

WHEN ORDERING PARTS
Always give your dealer the Model 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.



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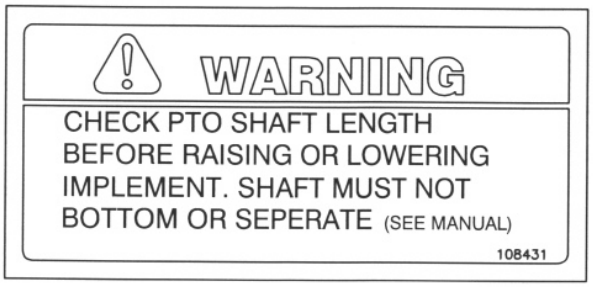


#3

ASSEMBLY INSTRUCTIONS

1. Turn the bottom tube weldments (#9) as shown in drawing and slide them into the sleeve welded to the main body. These tubes have holes for two positions. The correct position for each individual tractor will be determined when mounting the snowblower on the tractor. These tubes are connected to the tractor with a ¾” x 4 ¼” pin (#96) and a hairpin clip (#103).

2. Bolt the left (#20) and the right (#21) a-frames to the inside of the plates welded to the hitch tubes using 7/8” x 2 ½” hex bolts (#101) and lock nuts. Join the top of the hitch arms by bolting a 1” O.D. x 2” spacer (#19) between the top plates using a ¾” x 4” bolt, lock washer and hex nut through the lower outside holes. Bolt the upper hitch tube weldment (#47) between the same plates using the same size of bolt. Use the inside holes on the top plates for the upper tube. The other end of the top hitch tube bolts between the welded brackets on the top edge of the fan housing with the same hardware. Tube must be turned as shown in drawing. Tighten all hardware.

3. A category 1 top link pin (#18) 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.

4. Mount the discharge spout (#6) using the spout clamps (#59) bolted to the spout ring on the snowblower. Lubricate the spout ring and clamps.

5. Hydraulic spout swivel:
   a) Mount the swivel arm (#60) onto the swivel pin welded to the back corner of the fan housing using a 1" I.D. washer (#29) and a 3/16" x 1 ½” cotter pin (#62).
   b) Wrap cable (#61) around spout and clamp to the ends of the swivel using 3/16" cable clamps (#17).
   c) With the swivel in extended position (i.e. cylinder fully extended) and the spout turned to the right, clamp the cable to the spout cable anchor using a ¼” cable clamp (#84).
   Ensure that the spout is not jammed and that there is no slack in the cable.
   d) Use a standard 8" stroke cylinder (20 ¼” min., 28 ¼” max. pin centers).
   e) **Note:** A hydraulic cylinder and hose kit to control the spout deflector is available as an option.

6. Hand Crank (Option):
   a) Fasten crank assembly (#5) using two ½” x 1 ¾” hex bolts, lock washers and hex nuts.
   b) Thread cable (#7) through hole in hand crank to even lengths and wrap around the tube to each side of the hole four turns in opposite directions.
   c) Turn spout to center forward position and clamp cable to cable anchor on far side of spout using clamp (#84).

ASSEMBLY INSTRUCTIONS – cont’d.

7. Mounting blower on tractor:
   a) Mount the blower on a tractor with a category 1 or category 2 hitch.
   b) Using tape or bright colored marking pen, mark on the outer shields 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 3/8" keyway. Slide the yoke onto the gearbox shaft with the 3/8" 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. A longer optional PTO shaft is available if the standard shaft is too short. Check for free movement of all parts in various raised positions; particularly the PTO shaft.

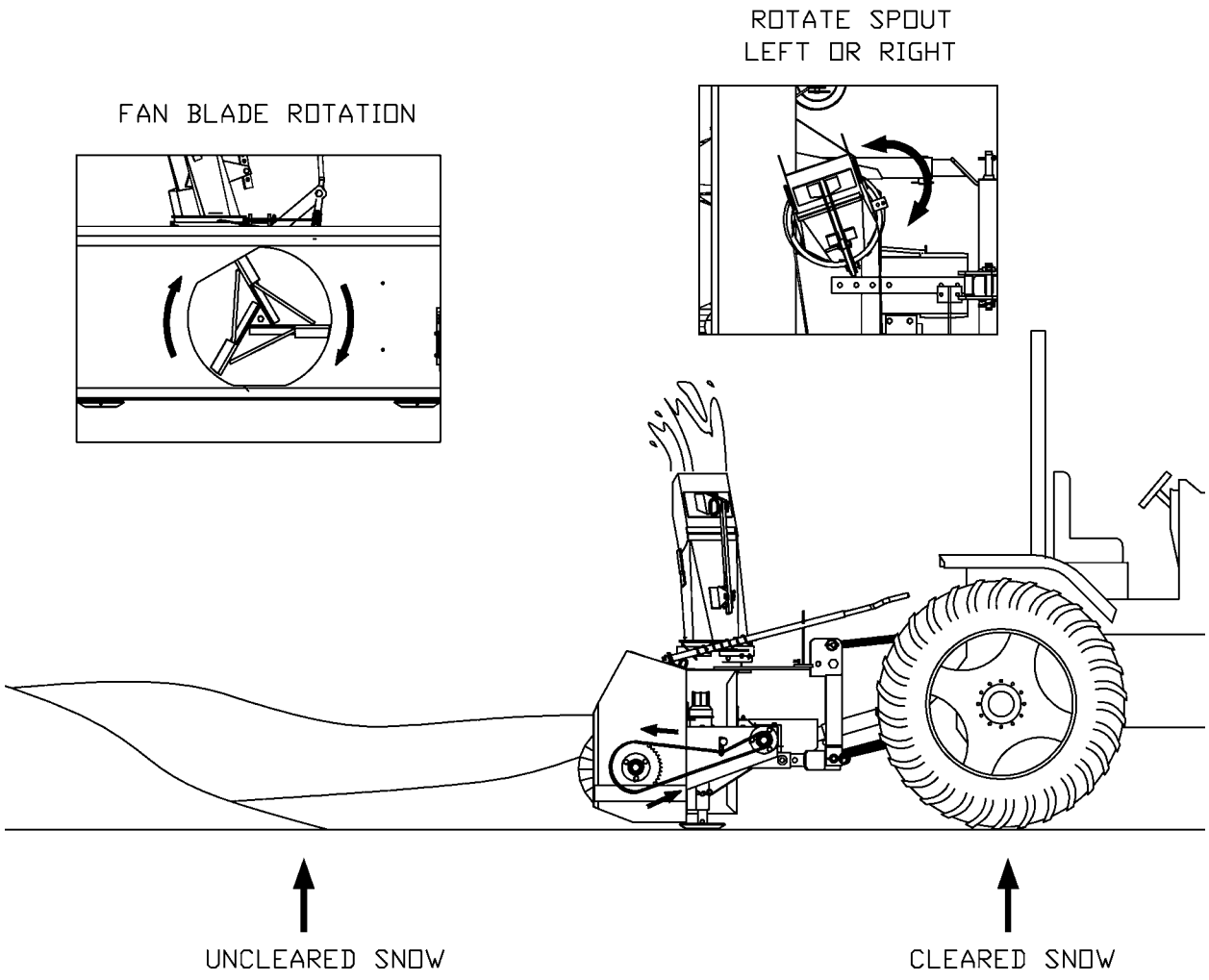
8. PTO Shield: All snowblowers are supplied with a PTO shield. Bolt the shield (#74) to the hinges on the top of the gearbox on the snowblower using ¼” x ½” hex bolts, lock washers and hex nuts. Insert a 3/16" cotter pin in the hole in the shield and in the hole at the bottom corner of the gearbox. Fold back the cotter pins to hold them in place. Hook the ends of the spring (#71) into these cotter pins to hold the shield down. Bolt the PTO shield to the gearbox plate using these same bolts. Insert a 3/16" cotter pin in the hole in the shield and fold to lock in place. Hook one end of the spring (#71) into this cotter pin and the other end into a hole in the lower gearbox plate to hold the shield in place.

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

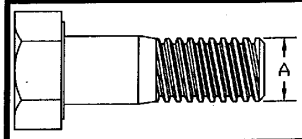
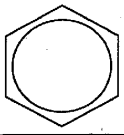
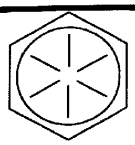
OPERATING INSTRUCTIONS

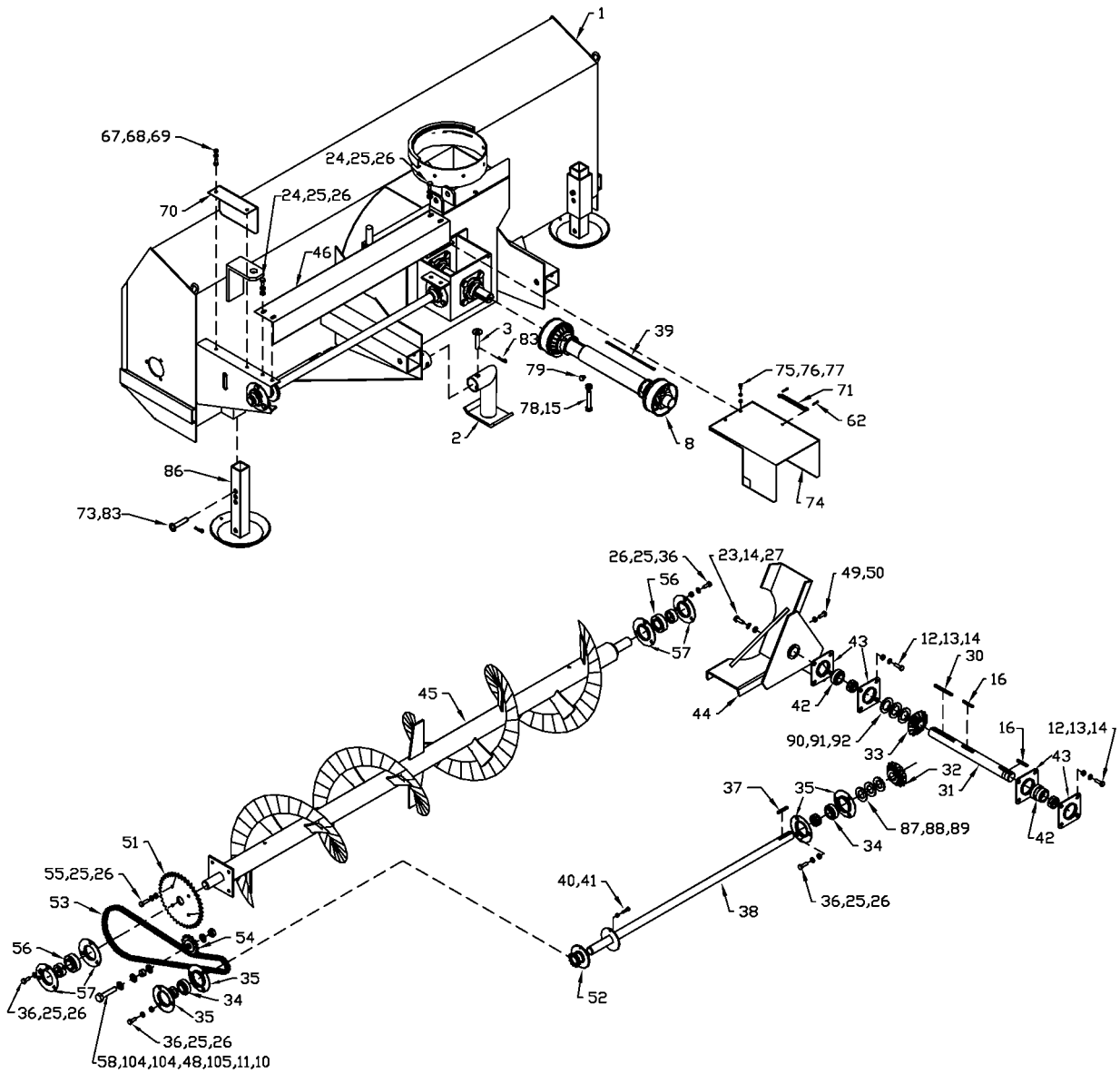
1. Do not operate the blower in the fully raised position. The three-point hitch on some tractors raises high enough to cause the PTO shaft to bind. This can cause damage to the PTO shaft and/or to the hitch and pins.
   ⚠ **ALERT:** PTO shaft angle should not exceed 20 degrees for optimum performance 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. ⚠ **CAUTION**: 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 bolt (Two 5/16" x 1"-Grade 5) Auger shear bolt (1/4" x 1"-Grade 5). 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) Regularly oiling the chain will significantly increase the life of the chain.
   d) The grease fitting on the hydraulic spout swivel arm should be kept lubricated.
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.
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. Shear Sprocket: The Shear Sprocket (#52) should be checked at the beginning of every season to make sure it will spin freely. With time this sprocket 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.
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.

THEORY OF OPERATIONS



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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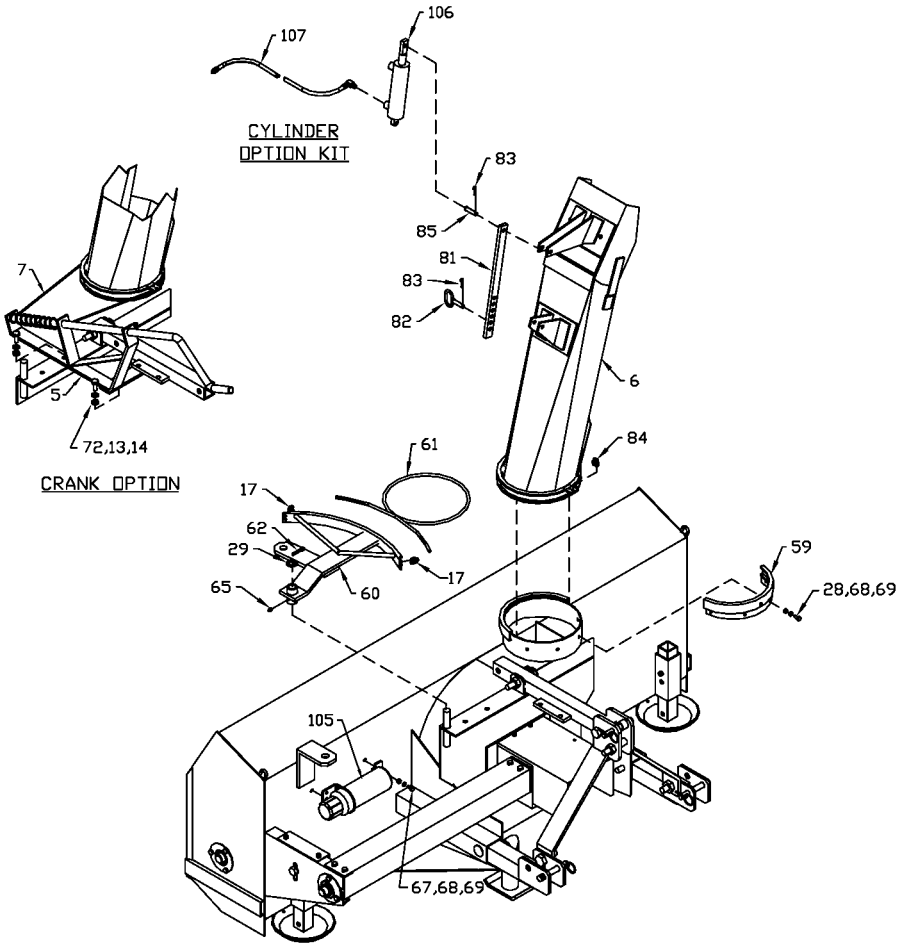
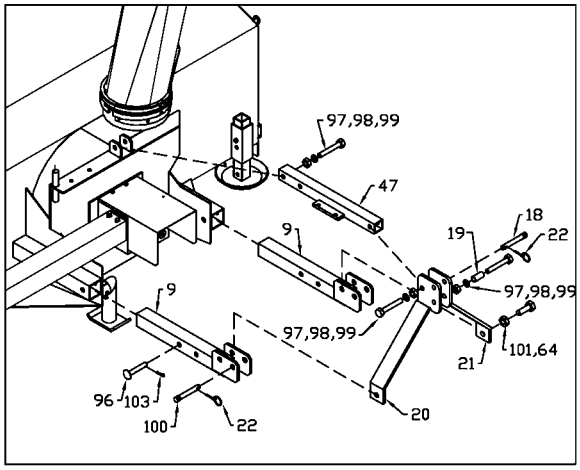
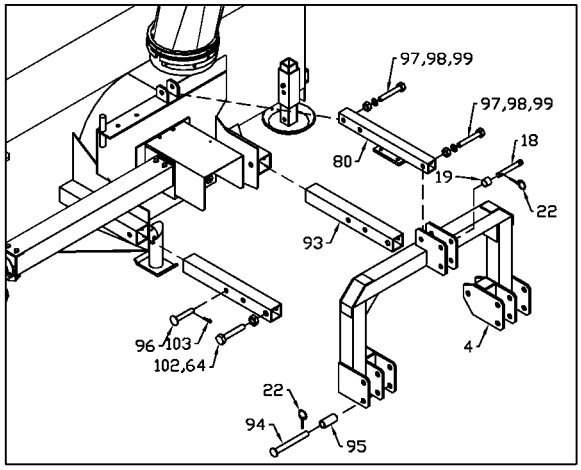




STD. – CAT. 1 (A–FRAME)



OPT. – CAT. 1 & 2 (HEAVY FRAME)

SB–07

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.

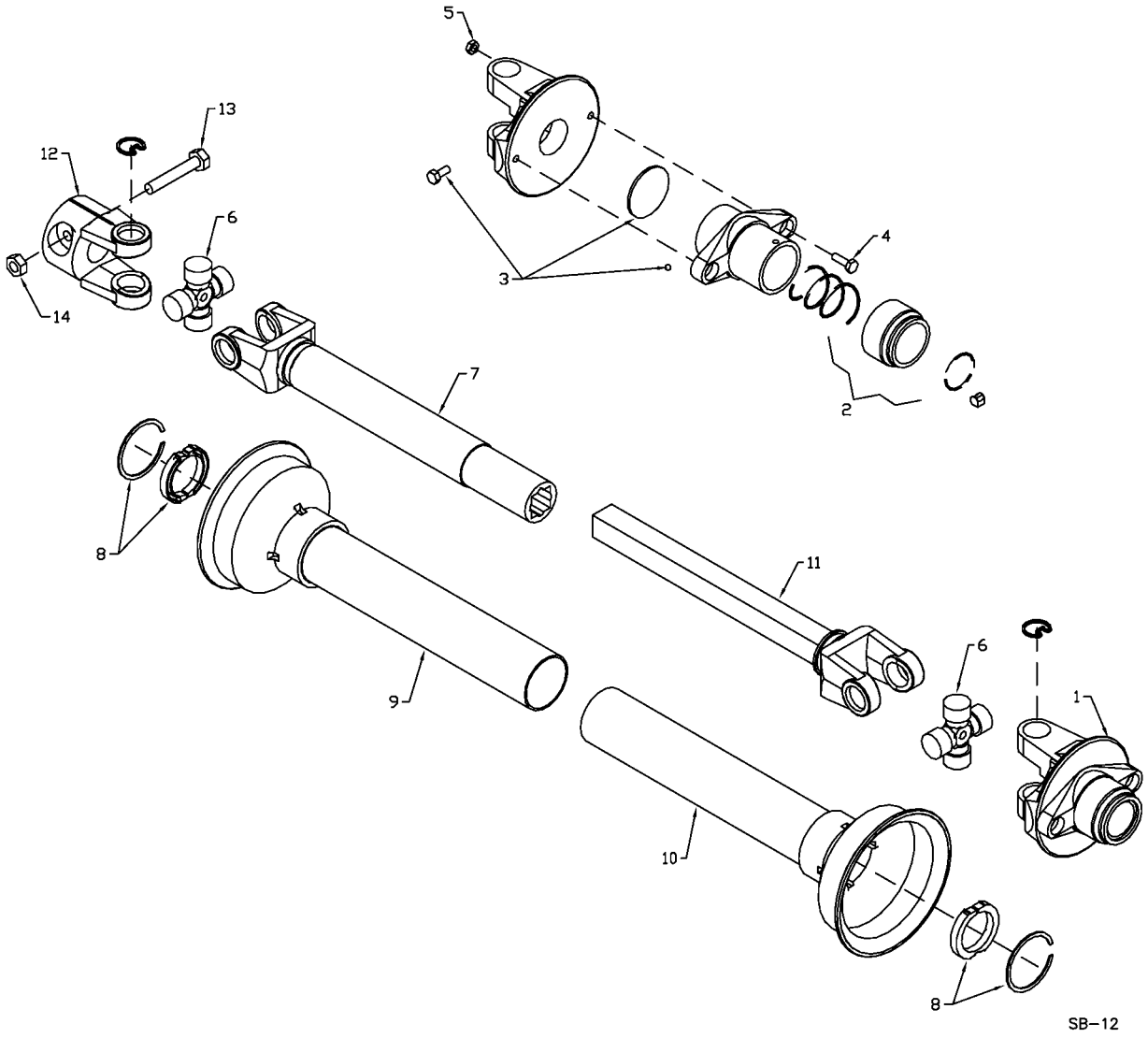
74" SNOWBLOWERS

ITEM	PART #	DESCRIPTION
1	907241	Main Body
2	907244	Stand Weld't - 8" Tall
3	965294	Stand Pin 9/16" x 2 7/8"
4	F0570	Hitch Weldment (Category 1 & 2) (optional)
5	965803	Hand Crank
6	965653	Discharge Spout
7	965927	3/16" Cable x 100" Long
8	F842	PTO Shaft (Standard)
	F844	PTO Shaft (Optional Long)
9	907213	Btm Tube Weld't 20 5/8" Lg
10	81676	5/8" Hex Nut
11	81677	5/8" Lock Washer
12	81619	1/2" x 1" Hex Bolt
13	81636	1/2" Hex Nut
14	81637	1/2" Lock Washer
15	81627	1/2" x 3" Hex Bolt
16	965821	3/8" x 1 3/4" Key
17	965806	3/16" Cable Clamp
18	965807	Top Link Pin (Category 1)
19	965808	Top Link Pin Bushing (Category 1-2)
20	907214	A-Frame LH (Category 1)
21	907215	A-Frame RH (Category 1)
22	965911	7/16" Linch Pin
23	84277	1/2" x 1 1/2" Hex Bolt
24	84072	3/8" x 3/4" Hex Bolt
25	81593	3/8" Lock Washer
26	81592	3/8" Hex Nut
27	81638	1/2" B.S. Flat Washer
28	812026	5/16" x 1" Hex Bolt
29	967140	1" x 10Ga Narrow Rim Washer
30	902377	3/8" x 4 3/4" Key
31	965835	Fan Shaft, 1 1/2" x 16 3/4"
32	965816	Bevel Gear - 1 1/4" Bore
33	965817	Bevel Gear - 1 1/2" Bore
34	965818	1 1/4" Bearing w/ Collar

35	961637	Bearing Retainer (Set)
36	86170	3/8" x 1" Hex Bolt
37	901940	5/16" x 1 1/4" Key
38	965413	Drive Shaft 1 1/4" x 37 1/4"
39	936402	PTO Safety Chain
40	81527	1/4" x 1" Hex Bolt
41	84498	1/4" Lock Nut
42	968627	1 1/2" Bearing With Collar
43	967260	1 1/2" Bearing Retainer (Set)
44	965822	Fan (Standard 3-Blade)
	965447	Fan (Optional 4-Blade)
45	965414	Auger
46	965415	Drive Shaft Guard
47	907218	Hitch Tube Weld't 22" Lg
48	965834	Idler Spacer, 5/8" Long
49	84111	1/2" x 1 1/4" Sq. Hd. Set Screw
50	984077	1/2" Jam Nut (pl)
51	965825	40 Tooth Sprocket, #50
52	965826	13 Tooth Sprocket, #50 (Shear)
53	965827	Roller Chain (#50 x 98 Link w/ Connector)
54	965844	15 Tooth Idler Sprocket, #50
55	86171	3/8" x 1 1/4" Hex Bolt
56	965917	1 3/8" Bearing With Collar
57	961675	Bearing Retainer (Set)
58	84289	5/8" x 3" Hex Bolt
59	965416	Spout Clamp
60	907820	Swivel Arm
61	965832	3/16" x 62" Cable
62	9812433	3/16" x 1 1/2" Cotter Pin
64	907674	7/8" Lock Nut
65	967164	Pound-In Grease Nipple
67	81549	5/16" x 3/4" Hex Bolt
68	81569	5/16" Lock Washer
69	81568	5/16" Hex Nut
70	965968	Idler Shield
71	960135	PTO Shield Spring
72	87553	1/2" x 1 3/4" Hex Bolt
73	900712	Skid Pin Weldment
74	965410	PTO Shield
75	81523	1/4" x 1/2" Hex Bolt
76	81545	1/4" Lock Washer
77	81544	1/4" Hex Nut
78	812364	1/2" Lock Nut
79	988999	3/8" x 3/8" Socket Set Screw
80	907221	Upper Hitch Tube Weld't 21" Lg (Category 1 & 2)

81	965646	Spout Adjustment Bar
82	903523	1/2" x 1 1/2" Adjustment Pin Weldment
83	961012	#16 Hair Pin Clip
84	961658	1/4" Cable Clamp
85	961876	1/2" x 1 1/2" Clevis Pin
86	902407	Skid Plate Weldment
	F6707	Skid Plate Bundle
87	9812487	1 1/4" x 10ga Narrow Rim Washer
88	967110	1 1/4" x 14ga Narrow Rim Washer
89	9812439	1 1/4" x 18ga Narrow Rim Washer
90	967135	1 1/2" x 10ga Narrow Rim Washer
91	9812444	1 1/2" x 14ga Narrow Rim Washer
92	9812443	1 1/2" x 18ga Narrow Rim Washer
93	907250	Hitch Inner Tube 20 5/8" Long (Category 1 & 2)
94	907315	Pin 7/8" x 7 3/4" (Category 1 & 2)
95	907316	Pin Sleeve 1 1/8" x 2 7/8"Lg (Category 1 & 2)
96	905821	Pin Rod 3/4" x 4 1/4"
97	84336	3/4" x 4" Hex Bolt
98	81701	3/4" Lock Washer
99	81700	3/4" Hex Nut
100	967361	7/8" x 4" Clevis Pin
101	966527	7/8" x 2 1/2" Hex Bolt
102	811826	7/8" x 5" Hex Bolt
103	12779	#9 Hair Pin Clip
104	81678	5/8" Flat Washer
105	909277	Manual Holder
106	24930	Cylinder 1.75"Dia x 5.0 - 9/16" ORB
107	115370	3/8" x 114" Hyd Hoses C/W Fittings

ALLIED SNOWBLOWER PTO



SNOWBLOWER PTO (STANDARD)

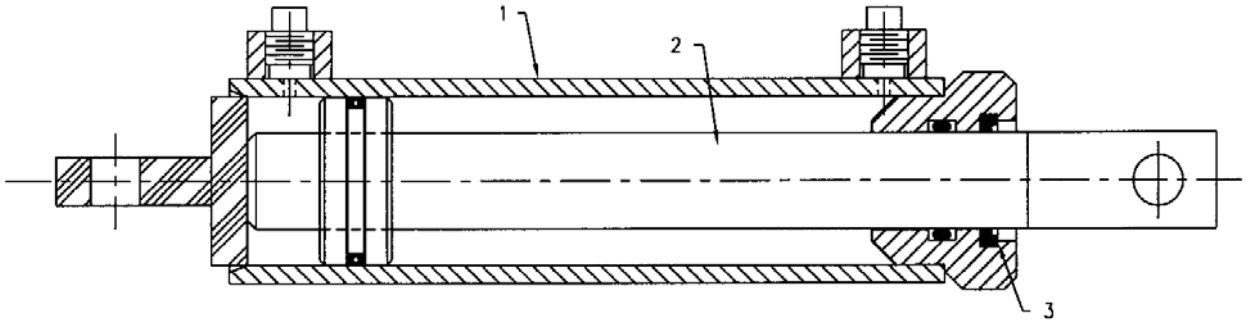
Item #	Part #	Description
	F842	Shaft Complete
	936263	Tractor Half of PTO (Shear)
	936264	Implement Half of PTO (Clamp Yoke)
1	936277	Shear Assembly
2	936199	Safety Slide Lock Repair Kit (Collar, Spring, Ret. Ring, 2-Pawls)
3	936249	Shear Assembly Repair Kit (3/8" x 1/2" Bolt, Lube, Blank, 31 - 1/4" Balls)
4	903296	Shear Bolt - 5/16" x 1" (Grade 5) (Pack of 10)
5	812362	5/16" Lock Nut
6	936025	Repair Kit (Option)
	906504	Extended Life Repair Kit (Std)
7	936270	Yoke & Tube
8	936319	Bearing & Snap Ring Kit
9	936272	Inner Shield
10	936273	Outer Shield
11	936274	Yoke & Shaft
12	936269	Clamp Yoke
13	81627	1/2" x 3" Hex Bolt (pl)
14	812364	1/2" Lock Nut (pl)

SNOWBLOWER PTO (OPTIONAL LONG)

Item #	Part #	Description
	F844	Shaft Complete
	936285	Tractor Half of PTO (Shear)
	936280	Implement Half of PTO (Clamp Yoke)
1	936277	Shear Assembly
2	936199	Safety Slide Lock Repair Kit (Collar, Spring, Ret. Ring, 2-Pawls)
3	936249	Shear Assembly Repair Kit (3/8" x 1/2" Bolt, Lube, Blank, 31-1/4" Balls)
4	903296	Shear Bolt - 5/16" x 1" (Grade 5) (Pack of 10)
5	812362	5/16" Lock Nut
6	936025	Repair Kit (Option)
	906504	Extended Life Repair Kit (Std)
7	936281	Yoke & Tube
8	936319	Bearing & Snap Ring Kit
9	936282	Inner Shield
10	936283	Outer Shield
11	936284	Yoke & Shaft
12	936269	Clamp Yoke
13	81627	1/2" x 3" Hex Bolt (pl)
14	812364	1/2" Lock Nut (pl)

1.75 X 5 CYLINDER ASSEMBLY

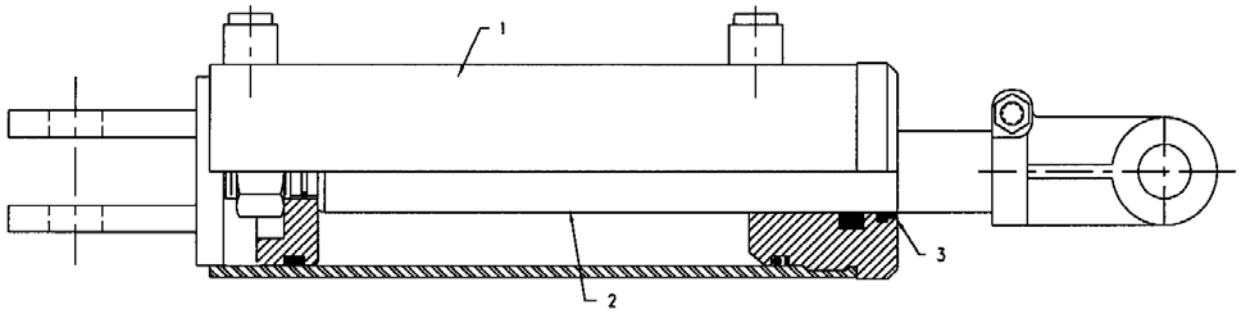
Item #	Part #	Description
	24930	Cyl Complete
1	115367	Tube Weldt
2	112104	Shaft Weldt 1.0 Dia
3	X2669	Seal Kit



24930

3.5 x 8 CYLINDER ASSEMBLY

Item #	Part #	Description
	24803	Cyl Complete
1	24804	Tube Weldt
2	113934	Piston Rod 1.5 Dia
3	X2098	Seal Kit



24803

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
YC7420 74” Snowblower w/hydraulic chute control, 3-blade fan		
1	F0460	Body Assembly
YC7420-4 74” Snowblower w/hydraulic chute control, 4-blade fan		
1	F0461	Body Assembly

OPTIONAL BUNDLE NUMBERS

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

F844	36” Optional Long PTO
F842	Standard PTO
FX9102	Hand Crank Kit
F0573	Hydraulic Chute Control Kit
F9116	Hydraulic Cylinder & Hose Kit for Spout Swivel
F9117	Spout Deflector Cylinder and Hose Kit

NOTES

NOTES

DIVISION LOCATIONS

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301 Mountain Street S.
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