## TABLE OF CONTENTS

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>PAGE NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>Warranty</td>
<td>1</td>
</tr>
<tr>
<td>Safety Message</td>
<td>2</td>
</tr>
<tr>
<td>Safety Signs</td>
<td>5</td>
</tr>
<tr>
<td>Operating Instructions</td>
<td>6</td>
</tr>
<tr>
<td>Service Instructions</td>
<td>8</td>
</tr>
<tr>
<td>Assembly Instructions</td>
<td>9</td>
</tr>
<tr>
<td>3-Point Hitch Mounted Drawing</td>
<td>12</td>
</tr>
<tr>
<td>Trailing Type</td>
<td>13</td>
</tr>
<tr>
<td>Rotary Cutter Parts List</td>
<td>14</td>
</tr>
<tr>
<td>Chain Shielding Kit</td>
<td>18</td>
</tr>
<tr>
<td>Chain Shielding Kit Parts List</td>
<td>19</td>
</tr>
<tr>
<td>Chain Shielding Kit Assembly</td>
<td>20</td>
</tr>
<tr>
<td>#510 PTO Shaft</td>
<td>21</td>
</tr>
<tr>
<td>#510 PTO Shaft Parts List</td>
<td>22</td>
</tr>
<tr>
<td>#620 &amp; #720 PTO Shaft</td>
<td>23</td>
</tr>
<tr>
<td>#620 3-Point Hitch Parts List</td>
<td>24</td>
</tr>
<tr>
<td>#620 Trailing parts List</td>
<td>25</td>
</tr>
<tr>
<td>#720 3-Point Hitch Parts List</td>
<td>26</td>
</tr>
<tr>
<td>#720 PTO Trailing PTO Shaft</td>
<td>27</td>
</tr>
<tr>
<td>#720 Trailing Parts List</td>
<td>28</td>
</tr>
<tr>
<td>#720 Q-Shaft</td>
<td>29</td>
</tr>
<tr>
<td>#720 Q-Shaft Trailing Parts List</td>
<td>30</td>
</tr>
<tr>
<td>#510 Gearbox</td>
<td>31</td>
</tr>
<tr>
<td>#510 Gearbox Parts List</td>
<td>32</td>
</tr>
<tr>
<td>#620 Gearbox</td>
<td>33</td>
</tr>
<tr>
<td>#620 Gearbox Parts List</td>
<td>34</td>
</tr>
<tr>
<td>#720 Gearbox</td>
<td>35</td>
</tr>
<tr>
<td>#720 Gearbox Parts List</td>
<td>36</td>
</tr>
<tr>
<td>Cylinder Assembly</td>
<td>37</td>
</tr>
<tr>
<td>Bundles</td>
<td>38</td>
</tr>
</tbody>
</table>
WARRANTY REGISTRATION AND POLICY

Buhler Manufacturing products are warranted for a period of twelve (12) months 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 a rate determined by the Company, Buhler Manufacturing.

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
ROTARY CUTTER

The following models of Rotary Cutters are available:

**MODEL #510:** 60" cutter equipped for three point hitch with a shear pin protected PTO and stump jumper.

**MODEL #620:** 72" cutter with a slip clutch protected PTO and a stump jumper. It is available equipped for a three-point hitch or as a two wheel trailing type.

**MODEL #720:** 84" cutter with a slip clutch protected PTO and a stump jumper. It is available equipped for a three-point hitch or as a two wheel trailing type.

**IMPORTANT SAFETY MESSAGE FOR ROTARY CUTTER**

⚠️ To avoid serious injury or death, follow some basic safety rules:

Before operating equipment read, understand and review annually:
* Operator’s Manual
* Safety Signs

Avoid fall off:
* Operate only with ROPS and seatbelt equipped tractors.

Before dismounting tractor:
* Lower cutter to ground.
* Disengage PTO shaft.
* Allow moving parts to stop.

* Stop engine
* Set brake
* Remove key for unattended equipment.

Rotating Blades & Driveline:

* KEEP AWAY
* Keep guards and shields in place and in good repair.
* Allow no riders on tractor.
* Allow moving parts to stop before repair.
IMPORTANT SAFETY MESSAGE FOR ROTARY CUTTER – cont’d.

Thrown Object Hazard:
* Before mowing, clear area to be cue of debris.
* Do not cut with bystanders in the area.

Raised Cutter Hazard:
* Securely support mower before working underneath.
* Lock up raised wings before transport.
* Do not cut in raised or transport position.

Highway Transport:
* Transport with clean reflectors, SMV and lights as required by local laws.
IMPORTANT SAFETY MESSAGE FOR ROTARY CUTTER – cont’d.

Safety is Important to You!! Why?
• Accidents Disable & Kill.
• Accidents Cost
• Accidents can be avoided.

Safety is the manufacturers primary concern in design, manufacture, sale & use of rotary cutters.

In addition to the equipment design and configuration, hazard control and accident prevention are dependant upon the owners and operators awareness, concern, prudence and proper training in the operation, transport, maintenance and storage of equipment.

Accidents have occurred by:
* Unqualified operators attempting to use rented or loaned rotary cutters.
* Being entangled in moving parts of drivelines by failure to maintain or keep guards and shields in place over exposed rotating parts.
* Hitting bystanders with thrown objects by cutter with bystanders in area or failure to maintain or keep discharge deflectors or guards in place.
* Riders or operators not using seatbelts, falling off machine and being run over by equipment.
* Not stopping engines and allowing moving parts to stop before adjustments, repairs, or maintenance operations.
* Raised cutter or wing falling on person working underneath by failure to securely support or block up the cutter.

Contact your dealer today to replace any missing or damaged driveline and discharge shielding or guard, safety signs and operator’s manual. Also, consider ROPS and seatbelt installation for non-equipped tractors.

Safety is important to responsible owners and operators of Rotary Cutters.
Replace safety sign immediately should it become damaged, torn or illegible. Obtain replacements from your authorized dealer using the part numbers shown.
OPERATING INSTRUCTIONS

1. Connecting to tractor: All cutters are supplied with a standard 1 3/8" 6-spline yoke on the PTO shaft.
   
   Warning: This cutter is designed to operate only with a 540 rpm PTO. After connecting cutter to tractor and before doing any cutting, check to see that the PTO shaft is not touching anywhere on the cutter when raising and lowering or when cornering.

2. PTO Shafts: Make sure the length of the PTO shaft is compatible with different working positions of the cutter. Carefully follow the lubrication chart supplied with the PTO shaft. When cutting, avoid joint angles over 35°. PTO shafts should be disengaged when turning sharp corners. Using tape or a 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 cutter through all possible operating angles to see that the PTO shaft stays within this range.

   PTO shafts with shear pin - Loosen the outer shield on the implement end of the PTO and push the gearbox shaft through the end yoke. Using snap ring pliers, put the snap ring on the end of the gearbox shaft. This is what keeps the PTO shaft on if the shear pin breaks and the cutter should not be used without it. Insert a ½” x 3 ½” Grade 2 bolt with a lock nut to act as shear pin and replace all shields.

   PTO shafts with slip clutch - Note: All PTO shafts with a slip clutch are shipped with the slip clutch disengaged. There are four socket set screws on the inside of the clutch assembly which are all turned out as far as they go to engage the clutch. Disengage by turning set screws in fully. The clutch should slip if a hard object such as a stump or rock is hit by the blades.

   Caution: Always be certain that the PTO shaft is disengaged and the tractor brakes are locked before making this or any other adjustment.

   The clutch plates should be "burned" just before using the cutter in spring for the first time. This is done by disengaging the clutch and then engaging the PTO shaft for a few seconds till the clutch plates smoke. After this you engage the clutch again as described above. This is done because the plates may lock up during prolonged storage.

3. Operating tractor engine: Operate the tractor PTO at 540 rpm when doing normal cutting. If the forward speed is too high, a lower gear can be used.
OPERATING INSTRUCTIONS – cont’d.

4. **Cutting**: The cutter should be run with the front end a little low or just level for normal light cutting. For brush or dense tall weeds, running front end high may give a better shredding job. On rough ground, the front end will also tend to dig in less. The cutter can also be used to shred stubble or top vegetables prior to harvest.

5. **5' & 6' Trailing Models**: The wheels supplied with the cutter are for towing at speeds of no more than 20 miles per hour. These wheels should be greased every time you use the cutter.
SERVICING INSTRUCTIONS

LUBRICATION

1. **Gearbox:** The gearbox should be filled with SAE90 oil to the bottom edge of the lower oil plug when shipped. Check this before using the cutter and at regular intervals to see that this oil level is maintained.

2. Grease wheels, tail wheel spindle sleeve, universal joints and shield bushings on the PTO shaft after every eight hours of use. Lubricate the telescoping PTO tube and the PTO quick release about every twenty hours of use.

3. **Shielding:** Always keep all shielding in place and repair or replace if damaged.

4. **Blades:** When replacing or grinding the cutting blades, both blades must be replaced or reground at the same time to maintain the proper balance in the cutting unit.

   IMPORTANT: Use Buhler replacement blades only. Using substitute blades may be dangerous. When changing blades, open the access door on the deck and take the screws out of the blade pin clips. The clips are then pulled out and the blade should fall down. Replacing the new or sharpened blades is done with the back of the mower raised and securely blocked so it will not fall. Bolt on the blade pin clips and close the access door.

5. **PTO Shaft:** To replace clutch lining on slip clutch PTO shafts, first disengage the clutch by turning the four set screws all the way in. Remove outside bolts from clutch assembly and replace clutch linings. When re-tightening bolts, stop when the clutch spacer starts to touch the clutch plates. You should be able to just move the spacer by hand when you have the correct bolt torque. Re-engage clutch after assembly is complete.
ASSEMBLY INSTRUCTIONS

Three point hitch mounted models:

1. Mount the hitch assembly (#7) to the deck using the category 1 lift arm pins (#32) supplied. The bushings (#34), and the 1” I.D. washer (#73) should allow the hitch to swivel freely.

2. The ends of the two pivot arms (#5 & #6) with the offset holes bolt to the hitch using a 5/8” x 4” bolt and lock nut. The offset should be turned down to improve clearance for the top link pin. The lift arm (#4) bolts between the ends of the pivot arms and the brackets at the top of the center mount (#2) using 5/8” x 2” hex bolts and lock nuts. Do not over tighten the lock nuts. The entire hitch assembly should swivel freely if properly assembled.

3. Bolt the tail wheel arm (#8) to the center mount (#2) using a 5/8” x 4” bolt and lock nut. Assemble the tail wheel (#11) in the wheel yoke (#10) using axle pin (#12) and a ¼” x 1 ½” cotter pin. Mount the yoke in the sleeve at the end of the tail wheel arm. Use an 18 gauge washer on each side of the sleeve and lock in place with a ¼” x 1 ¾” cotter pin. The adjustment arms (#9) hold the tail wheel arm in place and also set the cutting height of the cutter. Bolt arms to the deck using hex bolts (#15) and lock nuts and to the tail-wheel arm using 5/8” x 4” hex bolt and lock nut.

4. Connect the PTO shaft to the gearbox. A snap ring holds on the PTO shafts with a shear pin. The clutch must be engaged on PTO shafts with a slip clutch as per operating instructions so the clutch will slip if you hit a hard object. After engaging clutch, bolt the PTO guard (#3) to the center mount using 5/16” x ¾” hex bolts, lock washers and hex nuts.

5. Re-check all the fasteners. There should be free movement of all pieces held together by a bolt and lock nut.
ASSEMBLY INSTRUCTIONS - CONT’D.

Trailing Models:

1. Mount the swivel tube assembly (#47) to the cutter deck by bolting to the outside edge of the deck reinforcement using ½” x 1 ¾” hex bolts, lock washers and hex nuts.

2. The wheel yoke arms (#48) may be assembled to cutter in two ways:
   a) Wheels trailing behind mower. Assemble as shown in drawing. Bolt the yoke arms (#48) to the tube assembly using ½” x 2” hex bolts, lock washers and hex nuts with the wheels turned to the inside of the mower. With the wheels in this position, the control rod clevis (#53) attaches to the top bracket on the tube assembly as shown in drawing. Use a 1” I.D. flat washer and a ¼” x 1 ½” cotter pin to mount the wheels.
   b) Wheels forward at side of cutter. Bolt the yoke arms to the tube assembly so the wheels are on the outside of the cutter. With the wheels in this position, the control rod clevis (#53) attaches to the bottom bracket on the tube assembly.

3. Bolt the tongue assembly (#63) to the cutter deck using 7/8” x 2 ½” bolts, lock washers and hex nuts. The 1 ¼” diameter x 5/8” long bushings (#58) held in place by a 1” I.D. flat washer (#73) should allow the tongue to swivel.

4. An 8” stroke hydraulic cylinder (#49) is required to operate the hydraulic lift on the cutter. Using ½” x 90º elbows (#50) on the hydraulic cylinder will keep the hoses in better alignment (for 5’ & 6’). Approximately 12 foot long hydraulic hoses are required.

5. Bolt the welded end of the level control rod (#56) to the front tongue as shown on drawing using a 5/8” x 2 ½” hex bolt and lock nut. The control rod clevis (#53) must be adjusted so the cutter will sit level with the ground when it is pinned to the swivel assembly.

   **Note:** Be sure to use the top bracket on the swivel assembly (#47) when the wheels are trailing behind the cutter as shown in drawing.

6. Mount the slip clutch PTO shaft on the cutter. The clutch must be engaged so it will slip when you hit a hard object as per operating instructions. After engaging the clutch, bolt on the PTO guard (#3) using 5/16” x ¾” hex bolts, lock washers and hex nuts.

7. An optional jack (#67) is available to lift the tongue when mounting the cutter on a tractor.
Trailing Models:

8. Re-check and tighten all bolts. Only pieces held by a bolt and lock nut should have free movement.

9. 7' Cutters Only: Bolt the PTO bearing stand (#76) to the edge of the deck using 5/8" x 1 ¾" hex bolts, lock washers and hex nut. Mount the PTO Q-shaft on the cutter gearbox. Slide a 1 3/8" pillow bearing onto the shaft at the end of the Q-shaft. With the guard mount (#77) under the pillow bearing, bolt the pillow block to the stand using 5/8" x 2 ¼" hex bolts, lock washers and hex nuts. Connect the second PTO shaft to the splined end of the Q-shaft. Bolt the PTO guard (#78) to the stand using ¼" x ½" hex bolts, lock washers and hex nuts.
ROTARY CUTTER – THREE POINT HITCH MOUNTED
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.

### ROTARY CUTTER

<table>
<thead>
<tr>
<th>ITEM</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>906417</td>
<td>Deck Assembly - 5'</td>
</tr>
<tr>
<td></td>
<td>906419</td>
<td>Deck Assembly - 6'</td>
</tr>
<tr>
<td></td>
<td>906420</td>
<td>Deck Assembly - 7'</td>
</tr>
<tr>
<td>2</td>
<td>906426</td>
<td>Center Mount - 5'</td>
</tr>
<tr>
<td></td>
<td>906421</td>
<td>Center Mount - 6'</td>
</tr>
<tr>
<td></td>
<td>906372</td>
<td>Center Mount - 7'</td>
</tr>
<tr>
<td>3</td>
<td>966502</td>
<td>PTO Guard - 5'</td>
</tr>
<tr>
<td></td>
<td>966102</td>
<td>PTO Guard - 6' &amp; 7'</td>
</tr>
<tr>
<td>4</td>
<td>906424</td>
<td>Lift Arm (25 1/4&quot;&quot;) - 5'</td>
</tr>
<tr>
<td></td>
<td>906425</td>
<td>Lift Arm (32 1/2&quot;&quot;) - 6'</td>
</tr>
<tr>
<td></td>
<td>906382</td>
<td>Lift Arm (38 1/4&quot;&quot;) - 7'</td>
</tr>
<tr>
<td>5</td>
<td>906380</td>
<td>Pivot Arm (Right) - 5', 6', &amp; 7'</td>
</tr>
<tr>
<td>6</td>
<td>906381</td>
<td>Pivot Arm (Left) - 5', 6', &amp; 7'</td>
</tr>
<tr>
<td>7</td>
<td>906389</td>
<td>Hitch Assembly - 5'</td>
</tr>
<tr>
<td></td>
<td>906390</td>
<td>Hitch Assembly - 6' &amp; 7'</td>
</tr>
<tr>
<td>8</td>
<td>966582</td>
<td>Tail Wheel Arm (48&quot;) - 5'</td>
</tr>
<tr>
<td></td>
<td>966144</td>
<td>Tail Wheel Arm (54 1/2&quot;) - 6'</td>
</tr>
<tr>
<td></td>
<td>905143</td>
<td>Tail Wheel Arm (63&quot;) - 7'</td>
</tr>
<tr>
<td>9</td>
<td>966508</td>
<td>Adjustment Arm (22 1/8&quot;) - 5'</td>
</tr>
<tr>
<td></td>
<td>966105</td>
<td>Adjustment Arm (24 1/2&quot;) - 6'</td>
</tr>
<tr>
<td></td>
<td>902318</td>
<td>Adjustment Arm (22 1/8&quot;) - 7'</td>
</tr>
<tr>
<td>10</td>
<td>966583</td>
<td>Rear Wheel Yoke - 5'</td>
</tr>
<tr>
<td></td>
<td>966145</td>
<td>Rear Wheel Yoke - 6'</td>
</tr>
<tr>
<td></td>
<td>905147</td>
<td>Rear Wheel Yoke - 7'</td>
</tr>
<tr>
<td>11</td>
<td>966510</td>
<td>16&quot; Solid Rubber Wheel - 5' &amp; 6'</td>
</tr>
<tr>
<td></td>
<td>905145</td>
<td>20 1/2&quot; Solid Rubber Wheel W/ Brg. - 7'</td>
</tr>
<tr>
<td>12</td>
<td>966511</td>
<td>Axle Pin (1&quot; x 7&quot;)</td>
</tr>
<tr>
<td>13</td>
<td>9812434</td>
<td>1/4&quot; x 1 1/2&quot; Cotter Pin</td>
</tr>
<tr>
<td>14</td>
<td>9812439</td>
<td>1 1/4&quot; ID x 18 Ga Narrow Rim Washer</td>
</tr>
<tr>
<td>15</td>
<td>84270</td>
<td>5/8&quot; x 1 3/4&quot; Hex Bolt - 5' &amp; 6'</td>
</tr>
<tr>
<td></td>
<td>84299</td>
<td>5/8&quot; x 2&quot; Hex Bolt - 7'</td>
</tr>
<tr>
<td>16</td>
<td>812482</td>
<td>5/8&quot; Lock Nut</td>
</tr>
<tr>
<td>17</td>
<td>81671</td>
<td>5/8&quot; x 4&quot; Hex Bolt</td>
</tr>
<tr>
<td>18</td>
<td>84299</td>
<td>5/8&quot; x 2&quot; Hex Bolt</td>
</tr>
<tr>
<td>19</td>
<td>86170</td>
<td>3/8&quot; x 1&quot; Hex Bolt</td>
</tr>
</tbody>
</table>
20 966562 5mm x 50mm Cotter Pin
21 966108 Gearbox Assembly (Slip Clutch) - 5'
    966109 Gearbox Assembly (Slip Clutch) - 6'
    966194 Gearbox Assembly (Slip Clutch) - 7'
22 81620 1/2” x 1 1/4” Hex Bolt
23 81637 1/2” Lock Washer
24 81636 1/2” Hex Nut
25 84000 3/8” ID Flat Washer
26 81593 3/8” Lock Washer
27 84217 3/8” Wing Nut
28 81549 5/16” x 3/4” Hex Bolt
29 81569 5/16” Lock Washer
30 81568 5/16” Hex Nut
31 965807 Top Link Pin (Cat.1) - 5'
    906989 Top Link Pin 1” x 6” (Cat.2) - 6’ & 7’
32 965809 Lift Arm Pin w/ Nut & Washer (Cat.1) - 5'
    965926 Lift Arm Pin w/ Nut & Washer (Cat.2) - 6’ & 7’
33 965911 Linch Pin 7/16”
34 966528 Swivel Bushing (1 1/4" O.D. x 5/8") - 5’
    906418 Swivel Bushing (1 1/2" OD x 9/16") - 6’ & 7’
35 84522 1” S.A.E. Flat Washer
36 81723 7/8” Lock Washer - 5’
    981765 1 1/8” Lock Washer (pl) - 6’ & 7’
37 81722 7/8” Hex Nut - 5’
    1 1/8” Hex Nut - 6’ & 7’
38 F0438 PTO Shaft (Shear Pin) - 5’ w/ 3 PT. Hitch
    F0440 PTO Shaft (Slip Clutch) - 6’ w/ 3 PT. Hitch
    F0441 PTO Shaft (Slip Clutch) - 6’ Trailing Type
    F0439 PTO Shaft (Shear Pin) - 5’ Trailing Type
    F0442 PTO Shaft (Shear Pin) - 7’ w/ 3pt. Hitch
    F0442 PTO Shaft (Shear Pin) - 7’ Trailing Type
39 966518 Stump Jumper - 5’
    966110 Stump Jumper - 6’ & 7’
40 966519 Blade (24”) - 5’ (Standard)
    966111 Blade (30”) - 6’ (Standard)
    966192 Blade (36”) - 7” (Standard)
    Blade (24 1/4") - 5’ (Optional Low Cut)
    Blade (30 1/4") - 6’ (Optional Low Cut)
41 966520 Blade Pin Clip
42 966521 Blade Pin Clip
43 84270 5/8” x 1 3/4” Hex Bolt - 5’
    84467 3/4” x 2” Hex Bolt - 6’ & 7’
44 81677 5/8” Lock Washer - 5’
    81701 3/4” Lock Washer - 6’ & 7’
<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>45</td>
<td>81676</td>
<td>5/8&quot; Hex Nut - 5'</td>
</tr>
<tr>
<td></td>
<td>81700</td>
<td>3/4&quot; Hex Nut - 6' &amp; 7'</td>
</tr>
<tr>
<td>46</td>
<td>967217</td>
<td>1&quot; Slotted Hex Nut - 5' &amp; 6'</td>
</tr>
<tr>
<td></td>
<td>907157</td>
<td>30M x 2 Slotted Hex Nut - 7'</td>
</tr>
<tr>
<td>47</td>
<td>966584</td>
<td>Swivel Tube Assembly (61 3/4'') - 5'</td>
</tr>
<tr>
<td></td>
<td>966146</td>
<td>Swivel Tube Assembly (73 3/4'') - 6' &amp; 7'</td>
</tr>
<tr>
<td>48</td>
<td>966523</td>
<td>Wheel Yoke Arm</td>
</tr>
<tr>
<td>49</td>
<td>24791</td>
<td>3&quot; x 8&quot; Stroke Hydraulic Cylinder - (Optional)</td>
</tr>
<tr>
<td>50</td>
<td>964650</td>
<td>1/2&quot; x 90 Degree Street Elbow - 5' &amp; 6'</td>
</tr>
<tr>
<td>51</td>
<td>114905</td>
<td>1/2&quot; x 144&quot; Hydraulic Hose - (Optional)</td>
</tr>
<tr>
<td>52</td>
<td>966524</td>
<td>Control Rod Pin (3/4&quot; x 2 5/16'')</td>
</tr>
<tr>
<td>53</td>
<td>966525</td>
<td>Control Rod Clevis - 5'</td>
</tr>
<tr>
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<td>902341</td>
<td>Control Rod Clevis - 6' &amp; 7'</td>
</tr>
<tr>
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7" Rotary Cutter (Trailing) - PTO Kit

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Wheel Yoke Assembly

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OPTIONAL CHAIN SHIELDING KIT FOR ROTARY CUTTERS
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<td>Front Chain Rod, 6' (3/8&quot; x 36 3/8'')</td>
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CHAIN SHIELDING KIT - ASSEMBLY INSTRUCTIONS

All cutters have the required holes for mounting the chain kit. The use of this chain kit will help reduce the possibility of injury to persons or property by stopping many thrown objects.

1. Bolt the front chain holder (#1) to the front of the cutter using ½” x 1” hex bolts, lock washers and hex nuts.

2. Use ¼” x 6 link chains (#7) at the front. A chain is pushed through each slot from underneath and a 3/8” rod is threaded through the top link of each chain. Hold rods in place using the cotter pins supplied. See parts list for correct length of rods.

3. Bolt the rear center (#3) and rear side (#14) chain holder to the rear of the cutter. Use ¼” x 5 link chains (#8) along all rear edges. Thread rods as in front using lengths as shown in parts list.

⚠️ NOTE: Washers are used to hold an extra chain at both ends of the rear center rod and at the inside end only of the rear side rods. These extra chains close the gap left at the corners where the chain holders meet.
### Model #510 (Shear Pin) - Trailing

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## Model #510 (Shear Pin) - 3-Point Hitch

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# Model #620 (Slip Clutch) 3-Point Hitch

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## Rotary Cutter

### Model #620 (Slip Clutch) Trailing

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#720 TRAILING ROTARY CUTTER PTO SHAFT
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MODEL #720 TRAILING ROTARY CUTTER Q-SHAFT
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# Model #510 Gearbox

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MODEL #620 ROTARY CUTTER GEARBOX

10/21/2003 03:41:35 AM, Andrew
## Model #620 Gearbox

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<td>Output Cap</td>
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<td>23</td>
<td>966885</td>
<td>O-Ring 5 x 90</td>
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<td>24</td>
<td>966886</td>
<td>Split Pin 5 x 55</td>
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<tr>
<td>25</td>
<td>966887</td>
<td>M10 Lockwasher</td>
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<tr>
<td>26</td>
<td>81569</td>
<td>M8 Lockwasher (sub 5/16&quot;)</td>
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<tr>
<td>27</td>
<td>966888</td>
<td>Level Plug</td>
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3 x 8 CYLINDER ASSEMBLY

<table>
<thead>
<tr>
<th>Item #</th>
<th>Part #</th>
<th>Description</th>
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<tbody>
<tr>
<td>24791</td>
<td>1</td>
<td>Cylinder Complete</td>
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<tr>
<td>1</td>
<td>24827</td>
<td>Tube Weldment</td>
</tr>
<tr>
<td>2</td>
<td>113934</td>
<td>Piston Rod 1.5 Dia</td>
</tr>
<tr>
<td>3</td>
<td>X2415</td>
<td>Seal Kit</td>
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</table>
### ROTARY CUTTER BUNDLES

<table>
<thead>
<tr>
<th>QUANTITY</th>
<th>BUNDLE NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>F0185</td>
<td>Deck Assembly w/Shear Pin</td>
</tr>
<tr>
<td>1</td>
<td>F9427</td>
<td>Wheel &amp; Yoke</td>
</tr>
<tr>
<td>1</td>
<td>F0334</td>
<td>Hitch &amp; Adj. Arms</td>
</tr>
<tr>
<td>1</td>
<td>F0188</td>
<td>Tail wheel Arm &amp; Lift Arms</td>
</tr>
<tr>
<td>1</td>
<td>F0438</td>
<td>Shear Pin PTO</td>
</tr>
<tr>
<td>1</td>
<td>F0179</td>
<td>Carton</td>
</tr>
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</table>

**MODEL #510 ROTARY CUTTER (TRAILING)- Y510T**

<table>
<thead>
<tr>
<th>QUANTITY</th>
<th>BUNDLE NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>F0185</td>
<td>Deck Assembly w/Shear Pin</td>
</tr>
<tr>
<td>2</td>
<td>F9416</td>
<td>Wheel &amp; Yoke</td>
</tr>
<tr>
<td>1</td>
<td>F0177</td>
<td>Tongue Assembly</td>
</tr>
<tr>
<td>1</td>
<td>F9431</td>
<td>Swivel Tube &amp; Rod</td>
</tr>
<tr>
<td>1</td>
<td>F0439</td>
<td>Shear Pin PTO</td>
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<tr>
<td>1</td>
<td>F0180</td>
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**MODEL #620 ROTARY CUTTER (THREE POINT)- Y620S**

<table>
<thead>
<tr>
<th>QUANTITY</th>
<th>BUNDLE NO.</th>
<th>DESCRIPTION</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>F0186</td>
<td>Deck Assembly w/Slip Clutch</td>
</tr>
<tr>
<td>1</td>
<td>F9428</td>
<td>Wheel &amp; Yoke</td>
</tr>
<tr>
<td>1</td>
<td>F0335</td>
<td>Hitch &amp; Adj. Arms</td>
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<tr>
<td>1</td>
<td>F0189</td>
<td>Tail wheel Arm &amp; Lift Arms</td>
</tr>
<tr>
<td>1</td>
<td>F0440</td>
<td>Slip Clutch PTO</td>
</tr>
<tr>
<td>1</td>
<td>F0181</td>
<td>Carton</td>
</tr>
</tbody>
</table>

**MODEL #620 ROTARY CUTTER (TRAILING)- Y620T**

<table>
<thead>
<tr>
<th>QUANTITY</th>
<th>BUNDLE NO.</th>
<th>DESCRIPTION</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>F0186</td>
<td>Deck Assembly w/Slip Clutch</td>
</tr>
<tr>
<td>2</td>
<td>F9416</td>
<td>Wheel &amp; Yoke</td>
</tr>
<tr>
<td>1</td>
<td>F0177</td>
<td>Tongue Assembly</td>
</tr>
<tr>
<td>1</td>
<td>F0138</td>
<td>Swivel Tube &amp; Rod</td>
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<tr>
<td>1</td>
<td>F0441</td>
<td>Slip Clutch PTO</td>
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<tr>
<td>1</td>
<td>F0182</td>
<td>Carton</td>
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</table>
### ROTARY CUTTER BUNDLES – cont’d.

<table>
<thead>
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<th>BUNDLE</th>
<th>DESCRIPTION</th>
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</thead>
<tbody>
<tr>
<td></td>
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<td><strong>MODEL #720 ROTARY CUTTER (THREE POINT)- Y720S</strong></td>
</tr>
<tr>
<td>1</td>
<td>F0037</td>
<td>Wheel &amp; Yoke</td>
</tr>
<tr>
<td>1</td>
<td>F0187</td>
<td>Deck Assembly w/Slip Clutch</td>
</tr>
<tr>
<td>1</td>
<td>F0336</td>
<td>Hitch &amp; Adjustment Arms</td>
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<tr>
<td>1</td>
<td>F0190</td>
<td>Tail wheel Arm &amp; Lift Arms</td>
</tr>
<tr>
<td>1</td>
<td>F0183</td>
<td>Carton</td>
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<tr>
<td>1</td>
<td>F0442</td>
<td>Slip Clutch PTO</td>
</tr>
<tr>
<td></td>
<td></td>
<td><strong>MODEL #720 ROTARY CUTTER (TRAILING) – Y720T</strong></td>
</tr>
<tr>
<td>2</td>
<td>F7110</td>
<td>15” x 4 ½” x 4 Bolt Wheel</td>
</tr>
<tr>
<td>1</td>
<td>F0177</td>
<td>Tongue Assembly</td>
</tr>
<tr>
<td>2</td>
<td>F9434</td>
<td>Yoke &amp; 4 Bolt Hub</td>
</tr>
<tr>
<td>1</td>
<td>F0187</td>
<td>Deck Assembly w/Slip Clutch</td>
</tr>
<tr>
<td>1</td>
<td>F9453</td>
<td>Swivel Tube &amp; Rod</td>
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<tr>
<td>1</td>
<td>F0184</td>
<td>Carton of Parts</td>
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<tr>
<td>1</td>
<td>F0443</td>
<td>PTO Shaft w/o Slip Clutch</td>
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<tr>
<td>1</td>
<td>F9458</td>
<td>PTO Q-Shaft w/ Slip Clutch</td>
</tr>
</tbody>
</table>
ROTARY CUTTER BUNDLES – cont’d.

TRAILING TYPE CUTTER OPTIONS

Jack c/w mounting plate – F9415
Hydraulic Cylinder and Hose Kit - F630
#510 Trailing Kit c/w 15” rims (less tires) - Y517
#620 Trailing Kit c/w 15” rims (less tires) - Y627
#720 Trailing Kit c/w 15” rims (less tires) - Y727

OPTIONAL CHAIN SHIELDING KIT FOR #510 CUTTERS - Y524

1  F9435 Plates and Rods
1  F9436 Carton

OPTIONAL CHAIN SHIELDING KIT FOR #620 CUTTERS - Y624

1  F9437 Plates and Rods
1  F9438 Carton

OPTIONAL CHAIN SHIELDING KIT FOR #720 CUTTERS – Y724

1  F9498 Carton
1  F9499 Plates and Rods

OPTIONAL LOWER CUTTING BLADES:

F9439    Set of 2-24” Blades for 5’ Rotary Cutter
F9440    Set of 2-30” Blades for 6’ Rotary Cutter