

Farm King

OPERATOR AND PARTS MANUAL

Rotary Cutter

Series II - 7'

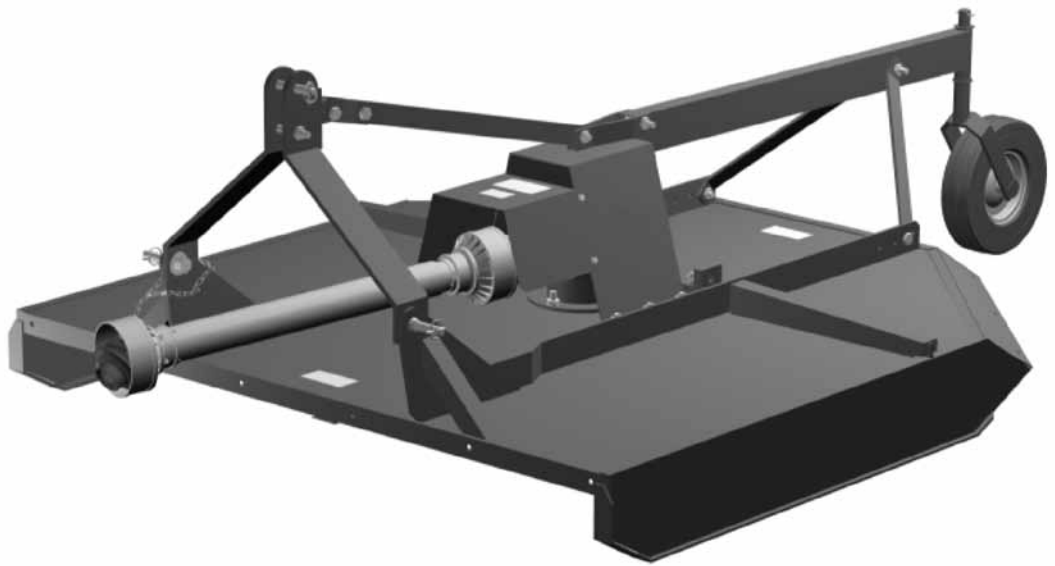


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Manufacturer’s statement: for technical reasons Buhler Industries Inc. reserves the right to modify machinery design and specifications provided herein without any preliminary notice. Information provided herein is of descriptive nature. Performance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

Introduction

The Farm King Series II Rotary cutter available in 60", 72" and 84" and are equipped with either trailing style or 3-point hitch. The 3-point hitch is Quick Hitch compatible so it is easy to attach and unhook. 3-point hitch models include a single solid rubber training wheel, while rotary cutters with a trailing hitch have two wheels, either air-filled or made of solid rubber.

Farm King Rotary Cutters are built tough and made to last. The blades are heat-treated to enhance rigidity and the heavy-duty gearbox is designed to be rugged and durable. The access panel on the deck makes it easy to inspect or replace the blades. An optional chain kit minimizes the possibility of flying debris. The stump-jumper is a 24" plate mounted to the blades below the gearbox and minimizes stress on the deck and gearbox. The power take-off (PTO) shaft on the Series II 60" Rotary Cutter includes a sheer pin to protect the gearbox in the event of an unforeseen obstacle, while the 72" and 84" rotary cutters are equipped with a slip clutch to prevent gearbox damage. The Y720T with the trailing style hitch includes a two-piece PTO shaft for tighter turning radius. An 8" cylinder and hoses are optional for all trailing models.

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 Farm King 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 mower 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.
- Never operate over 540 PTO rpm 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.
- Do not tow equipment that does not have brakes at speeds over 20 mph (32 km/h).
- Do not tow equipment that does not have brakes that, when fully loaded, has a mass (weight) over 3300 lb. (1.5 t) and more than 1.5 times the mass (weight) of the towing unit.
- 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.
- 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

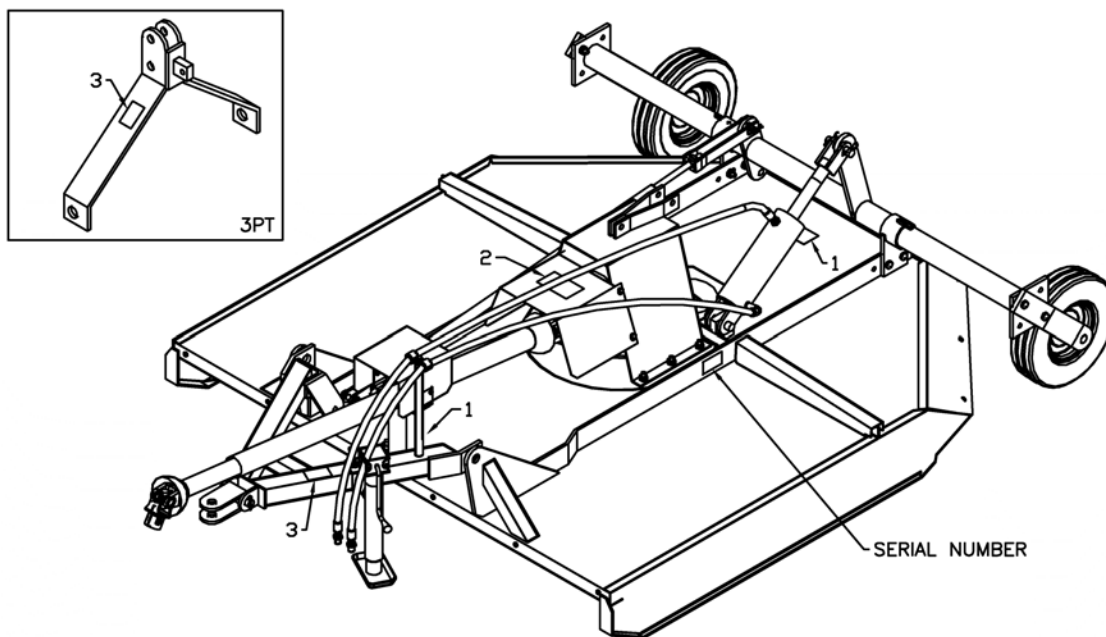
- Store the unit in an area away from human activity.
- Do not permit children to play on or around the stored machine.
- Support the frame on stands and blocks to provide a secure base.

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 sign immediately should it become damaged, torn or illegible. Obtain replacements from your authorized dealer using the part numbers shown.



⚠ DANGER

1. Avoid bodily injury:
Object may be thrown great distances by cutting blade rotating under deck.
2. Stay clear and watch out for bystanders.
Keep all shields in place.
Use extra protective shields (optional) on all discharge openings at front and rear of deck whenever possible.
3. Before working on mower:
Disengage power, shut off engine, and make sure blade has stopped turning.

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⚠ WARNING

- ENSURE DRIVELINE SHIELDS ARE IN PLACE AND IN GOOD CONDITION BEFORE OPERATING.
- PTO OPERATING SPEED IS 540 RPM.
- ALWAYS REMOVE TRACTOR KEY, SET PARK BRAKE AND PLACE MOWER IN LOWEST POSITION WHEN UNATTENDED.
- ENSURE ROTATION OF ALL COMPONENTS HAS STOPPED BEFORE SERVICING.

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⚠ WARNING

CHECK PTO SHAFT LENGTH BEFORE RAISING OR LOWERING IMPLEMENT. SHAFT MUST NOT BOTTOM OR SEPERATE (SEE MANUAL)

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Assembly Instructions

3-Point Hitch Mounted Assembly Instructions

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. 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. Assemble chain PTO holder (#104) to 3-point hitch (#7) using one 3/8" x 1 1/2" hex bolt (#103), lock washer and hex nut.
3. Bolt the tail wheel arm (#8) to the center mount (#2) using a 5/8" x 4" bolt and lock nut. The tube welded to the outside end of the tail wheel arm is offset 2-1/4" past the edge of the tube. The 2-1/4" offset is turned down for 5' and 6' cutters and up for 7' cutters. Assemble the tail wheel (#11) in the wheel yoke (#10) using axle pin (#12) and a 1/4" x 1-1/2" 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 1/4" x 1-3/4" 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 3/4" 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.

Trailing Model Assembly Instructions

1. Mount the swivel tube assembly (#47) to the cutter deck by bolting to the outside edge of the deck reinforcement using 1/2" x 1-3/4" hex bolts, lock washers and hex nuts.
2. The wheel yoke arms (#48) may be assembled to cutter in two ways:
 - Wheels trailing behind mower. Assemble as shown in drawing. Bolt the yoke arms (#48) to the tube assembly using 1/2" 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 1/4" x 1-1/2" cotter pin to mount the wheels.
 - 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 2-1/2" bolts, lock washers and hex nuts. The 1-1/4" 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. Bolt the welded end of the level control rod (#56) to the front tongue as shown on drawing using a 5/8" x 2 1/2" 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.
5. 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 3/4" hex bolts, lock washers and hex nuts.
6. An optional jack (#67) is available to lift the tongue when mounting the cutter a tractor.
7. Re check and tighten all bolts. Only pieces held by a bolt and lock nut should have free movement.
8. Bolt the PTO bearing stand (#76) to the edge of the deck using 5/8" x 1-3/4" 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 2-1/4" 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 1/4" x 1/2" hex bolts, lock washers and hex nuts.

Chain 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 1/2" x 1" hex bolts, lock washers and hex nuts.
2. Use 1/4" 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 1/4" 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.

Operation 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 1/2" x 3-1/2" 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.



WARNING

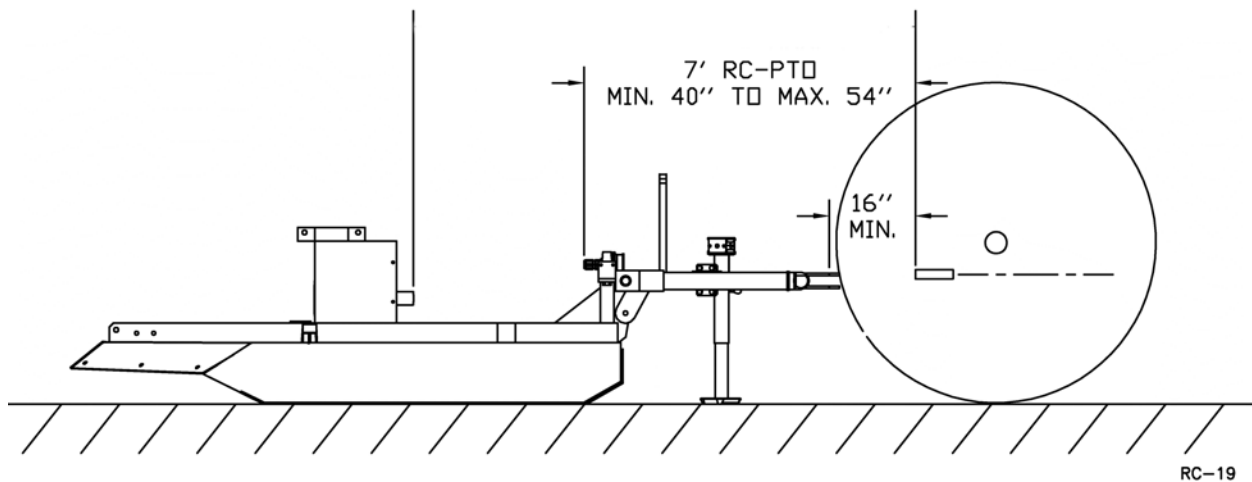
Always be certain that the PTO shaft is disengaged and the tractor brakes are locked before making this or any other adjustment.

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.

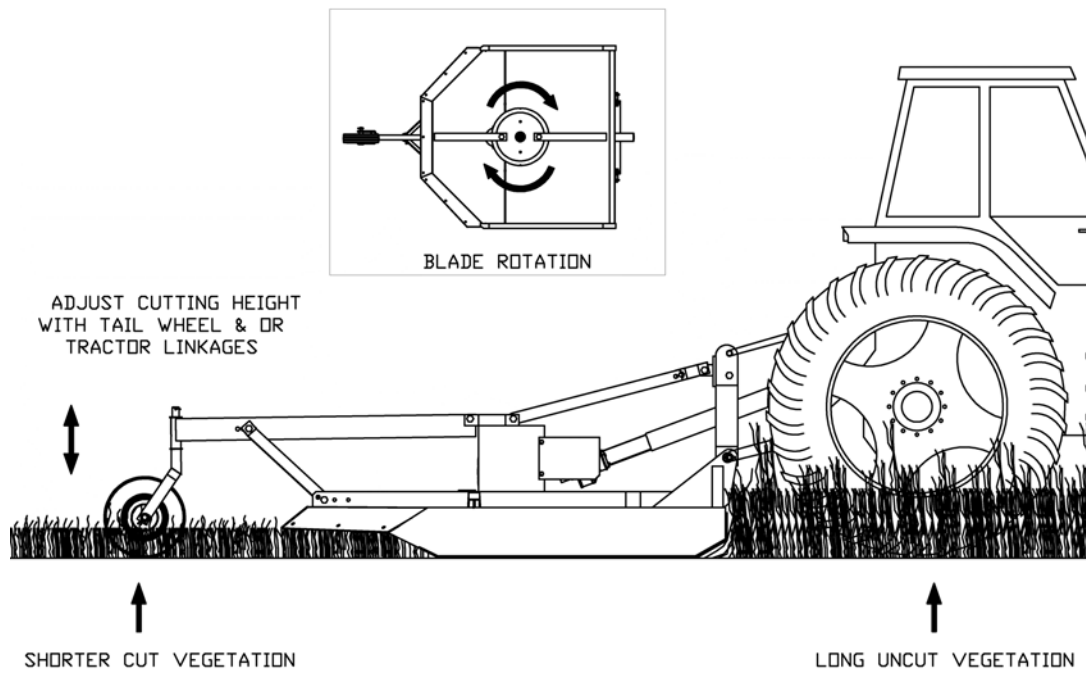
3. Operating Tractor Engine: Operate the tractor PTO at 540 rpm when doing normal cutting. If the forward speed is too high, a lower gear can be used.

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.

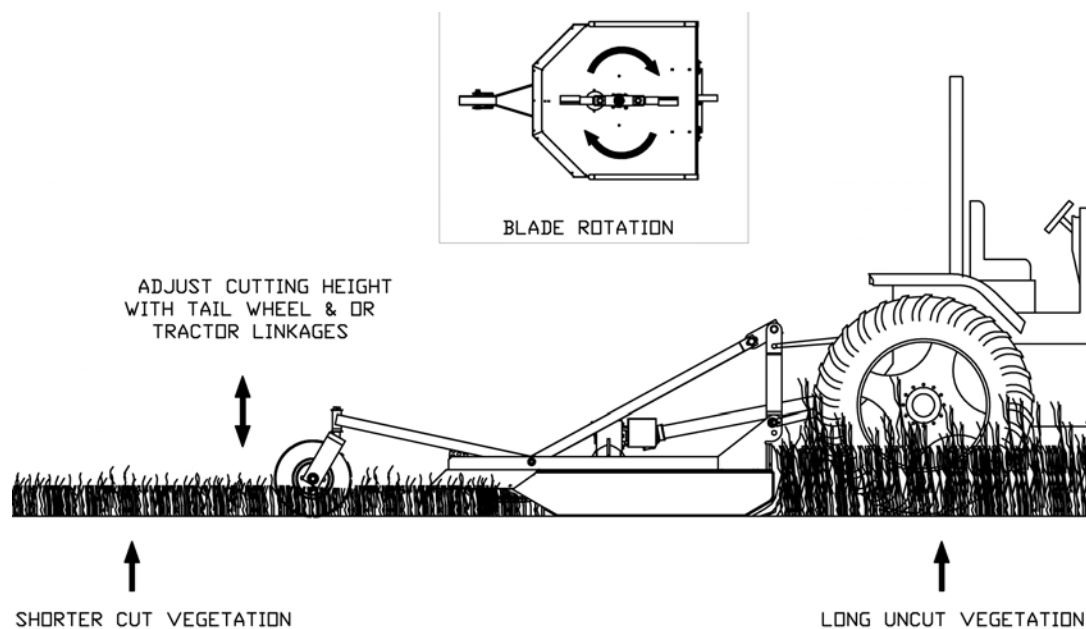
NOTE: TRACTOR HITCH OF LESS THAN 16" MIN CAN RESULT IN PTO BOTTOMING OUT.
(ASAE STD: TYPE 2 PTO (1 3/8"/1000 RPM) = TRACTOR HITCH DIM OF 16")



Theory of Operations



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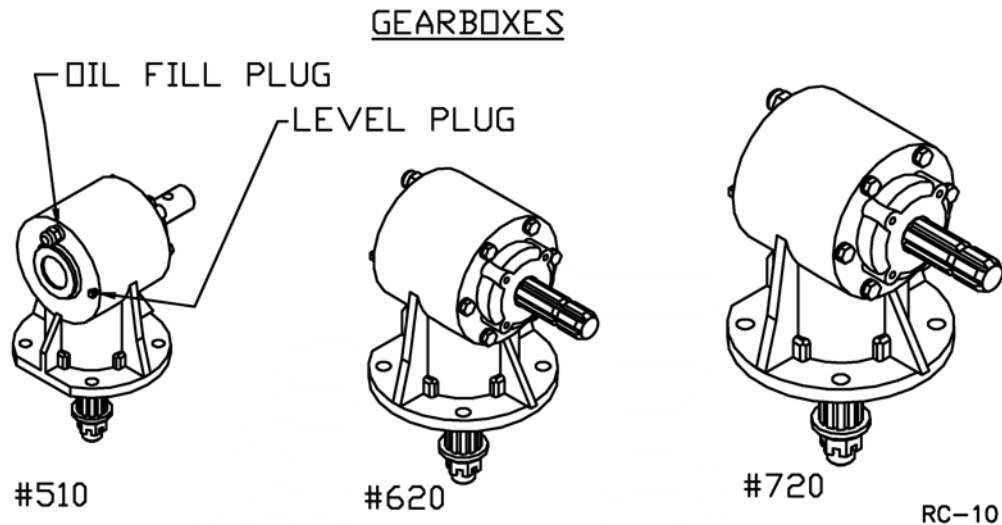


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Maintenance

Service

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.

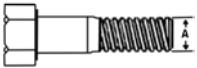


2. Grease wheels, tail wheel spindle sleeve, universal joints and shield bushings on the PTO shaft after every eight hours of use. Lubricate the telescoping PTO tube and the PTO quick release about every twenty hours of use.
3. Shielding: Always keep all shielding in place and repair or replace if damaged.
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. **NOTE:** Use Farm King 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.

Bolt Torque

Checking Bolt Torque

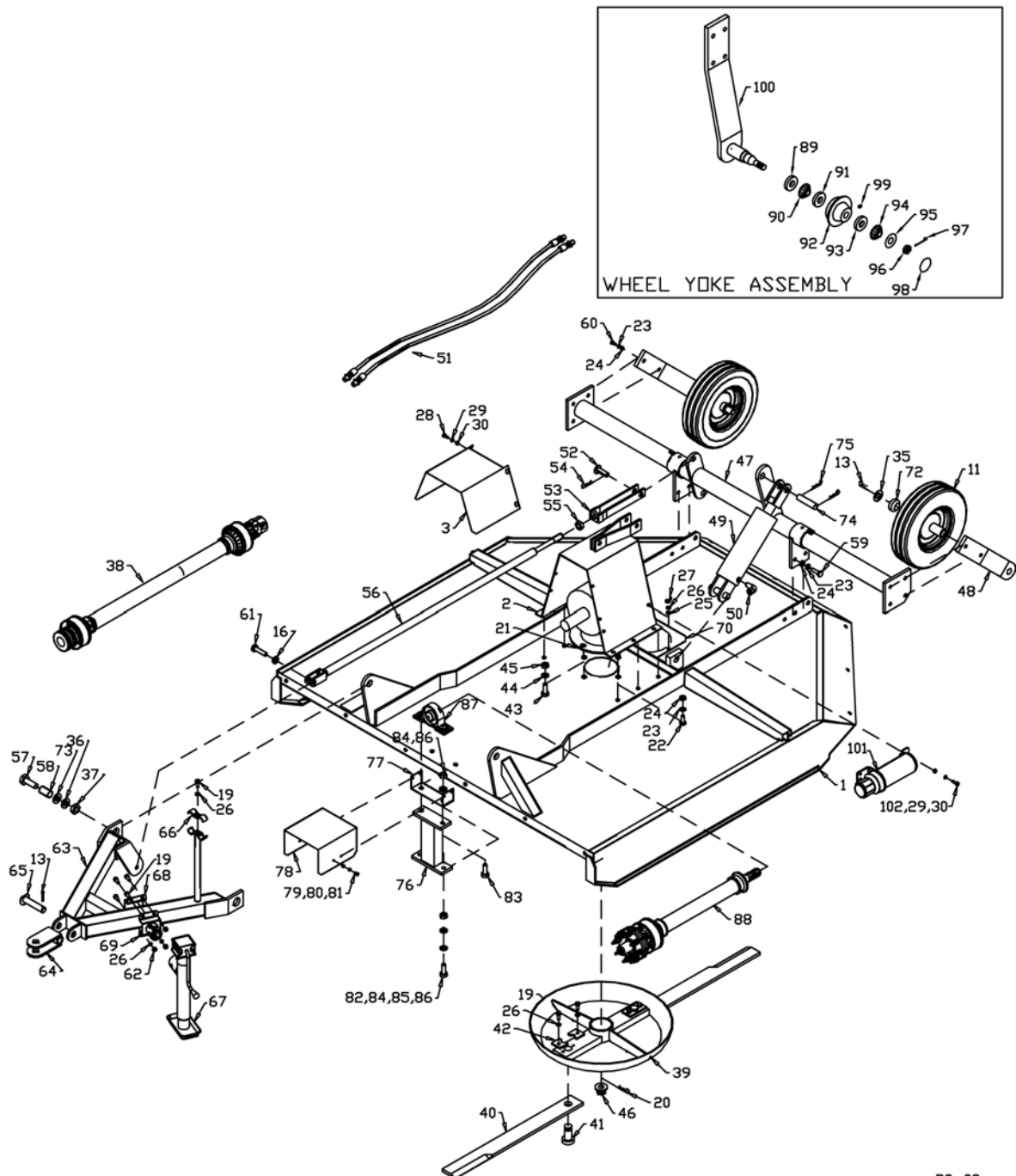
The tables shown below give correct torque values for various bolts and hex bolts. Tighten all bolts to the torques specified in chart unless otherwise noted. Check tightness of bolts periodically, using bolt torque chart as a guide. Replace hardware with the same strength bolt.

Bolt Torque*						
						
Bolt Diameter	Grade 2 Bolts		Grade 5 Bolts		Grade 8 Bolts	
(inches)	SAE 2		SAE 5		SAE 8	
"A"	(lb-ft)	(N.m)	(lb-ft)	(N.m)	(lb-ft)	(N.m)
0.25 (1/4)	6	8	9	12	12	17
0.313 (5/16)	10	13	19	25	27	36
0.375 (3/8)	20	27	33	45	45	63
0.438 (7/16)	30	42	53	72	75	100
0.5 (1/2)	45	61	80	110	115	155
0.563 (9/16)	70	95	115	155	165	220
0.625 (5/8)	95	128	160	215	220	305
.75 (3/4)	165	225	290	390	400	540
0.875 (7/8)	170	230	420	570	650	880
1	225	345	630	850	970	1320

Torque figures indicated above are valid for non-greased or non-oiled threads and heads unless otherwise specified. Therefore, do not grease or oil bolts or hex bolts unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

* Torque value for bolts and hex bolts are identified by their head markings.

Trailing Drawing



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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.

Item	Part Number	Description
1	906420	Deck Weldment - 7'
2	906372	Center Mount - 7'
3	966102	PTO Guard - 7'
4	906382	Lift Arm (38-1/4") - 7'
5	906380	Pivot Arm (Left)
6	906381	Pivot Arm (Right)
7	906390	A-Frame Hitch Weldment - 7'
8	905143	Tail Wheel Arm (63") - 7'
9	902318	Adjustment Arm (22-1/8") - 7'
10	905147	Rear Wheel Yoke - 7'
11	905145	20 1/2" Solid Rubber Wheel w/ Brg. - 7'
12	966511	Axle Pin (1" x 7")
13	9812434	1/4" x 1-1/2" Cotter Pin
14	967110	1-1/4" ID x 14 Ga Narrow Rim Washer
15	84299	5/8" x 2" Hex Bolt - 7'
16	812482	5/8" Lock Nut
17	81671	5/8" x 4" Hex Bolt
18	84299	5/8" x 2" Hex Bolt
19	86170	3/8" x 1" Hex Bolt
20	966562	85mm x 50mm Cotter Pin
21	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	965910	Top Link Pin 1" x 5-1/4" (Cat.2) - 7'
32	965926	Lift Arm Pin w/ Nut & Washer (Cat.2) - 7'
33	965911	Linch Pin 7/16"
34	906418	Swivel Bushing (1-1/2" OD x 9/16") - 7'
35	84522	1" S.A.E. Flat Washer
36	981765	1-1/8" Lock Washer (pl) - 7'

Item	Part Number	Description
37	907310	1-1/8" Hex Nut - 7'
38	F0442	PTO Shaft (Slip Clutch) - 7' w/ 3-Point Hitch
	F0443	PTO Shaft (Slip Clutch) - 7' Trailing Type
39	966110	Stump Jumper - 7'
40	966192	Blade (36") - 7" (Standard)
41	966520	Blade Pin Clip
42	966521	Blade Pin Clip
43	81684	3/4" x 2 1/4" Hex Bolt - 7'
44	81701	3/4" Lock Washer - 7'
45	81700	3/4" Hex Nut - 7'
46	907157	30M x 2 Slotted Hex Nut - 7'
47	966146	Swivel Tube Assembly (73-3/4") - 6' & 7'
48	966523	Wheel Yoke Arm
49	24791M	3" x 8" Stroke Hydraulic Cylinder - (Optional)
50	964650	1/2" x 90 Degree Street Elbow - 5' & 6'
51	114905	1/2" x 144" Hydraulic Hose - (Optional)
52	966524	Control Rod Pin (3/4" x 2-5/16")
53	902341	Control Rod Clevis - 7'
54	9812433	3/16" x 1-1/2" Cotter Pin
55	967142	1" Hex Nut (pl) - 7'
56	901756	Level Control Rod (1.66" x 71-1/2") - 7'
57	907308	1-1/8" x 2-1/2" Hex Bolt (pl) - 7'
58	906418	Swivel Bushing (1-1/4" OD x 9/16") - 7'
59	87553	1/2" x 1-3/4" Hex Bolt
60	81684	1/2" x 2-1/4" Hex Bolt
61	84335	5/8" x 2-1/2" Hex Bolt
62	81592	3/8" Hex Nut
63	906415	Hitch Weldment - 7'
64	966530	Swivel Clevis
65	966531	Clevis Pin (1" x 4-9/16")
66	964638	Hose Clamp
67	960327	Jack
68	966532	Jack Clamp
69	966533	Jack Clamp w/ Pivot
70	966534	Access Door
71	81210	1/4" x 2" Cotter Pin
72	89598	Bearing Ball - 7'
73	907309	1 1/8" x 10 Ga Narrow Rim Washer
74	103753	1" X 4" Clevis Pin
75	12779	Hair Pin Clip #9

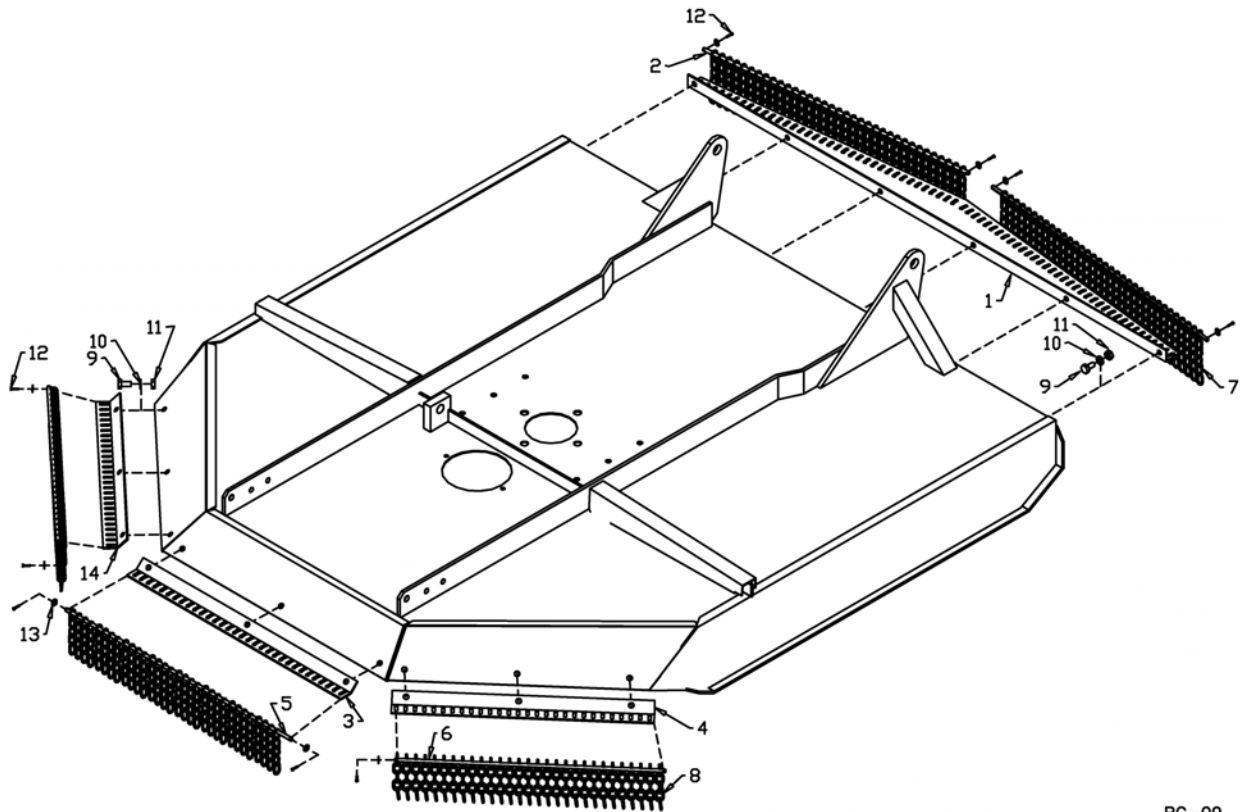
Item	Part Number	Description
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7' Trailing PTO Kit		
76	902348	PTO Stand Weld't
77	902549	PTO Guard Mount
78	902550	PTO Guard
79	81523	1/4" x 1/2" Hex Bolt
80	81545	1/4" Lock Washer
81	81544	1/4" Hex Nut
82	84270	5/8" x 1-3/4" Hex Bolt
83	981664	5/8" x 2-1/4" Hex Bolt
84	81677	5/8" Lock Washer
85	812639	5/8" Flat Washer
86	81676	Hex Nut
87	967490	1-3/8" Pillow Baring
88	F9458	PTO w/Qshaft

Wheel Yoke Assembly		
89	961891	Oil Seal CTD (SE11)
90	967712	Outer Bearing Cone (LM67048)
91	968405	Bearing Cup (LM11910)
92	105173	4-Bolt Hub (H411) w/ Cups CTD
93	967711	Outer Bearing Cup (LM67010)
94	968406	Outer Bearing Cone (LM11949)
95	9812416	Washer 3/4" SAE (br)
96		3/4" Slotted Hex Nut (br)
97	981309	1/8" x 1-1/4" Cotter Pin (br)
98	968409	Dust Cap (C12)
99	967900	Grease Fitting 1/4"
100	901051	Wheel Yoke 3/4" x 4" x 26"
	F9434	Wheel Yoke Assembly c/w Hub

101	907475	Manual (FK324) w/ Holder
	909277	Manual Hldr.
102	812026	5/16" x 1" Hex Bolt
103	811792	3/8" x 1-1/2" Hex Bolt
104	909703	23 Link Chain w/ Hook

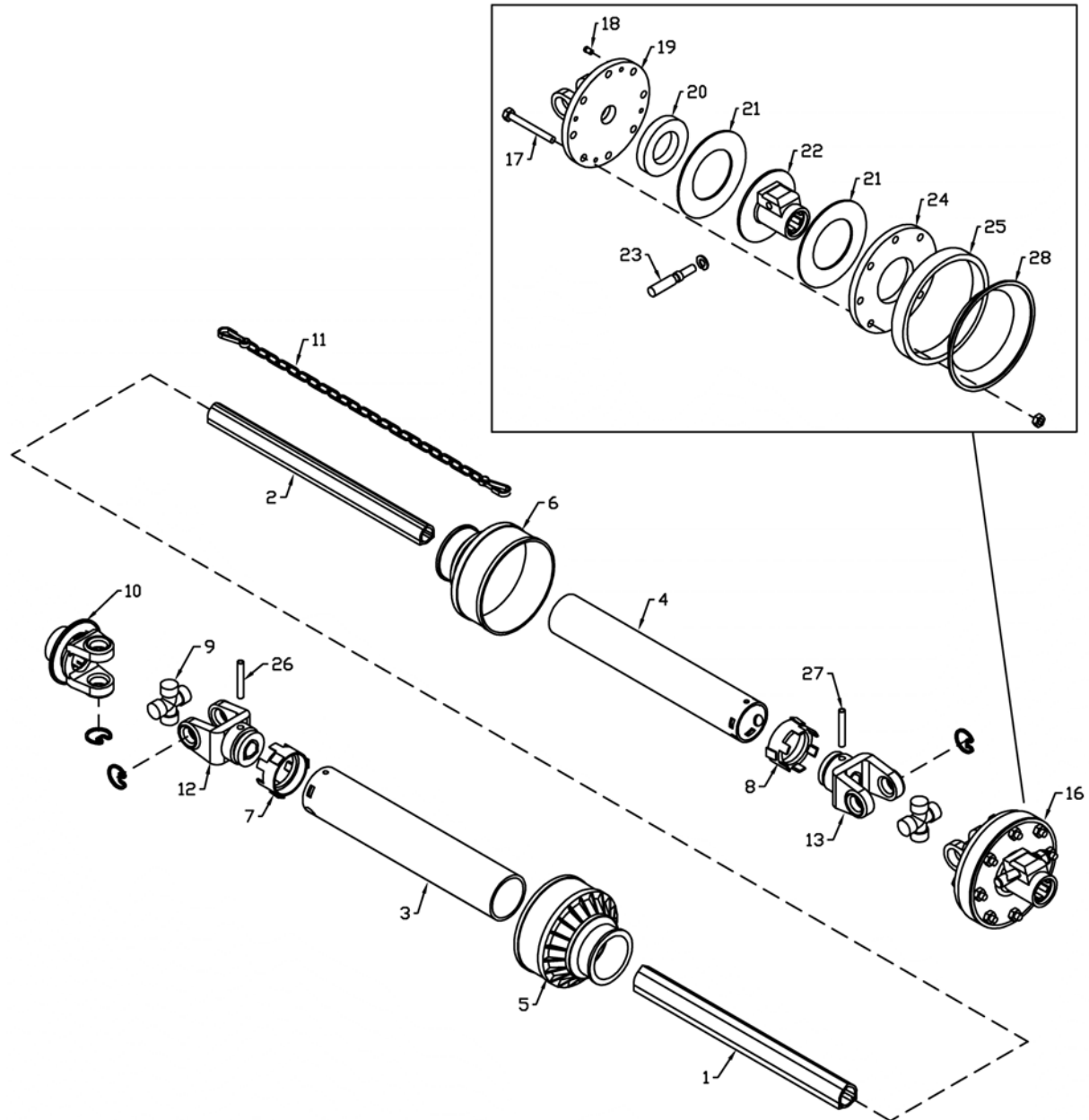
Chain Kit Drawing (Optional)



RC-09

Item	Part Number	Description
1	966610	Front Chain Holder, 7' (84" Long)
2	966611	Front Chain Rod, 7' (3/8" x 42")
3	966612	Rear Center Chain Holder, 7' (33-1/2" Long)
4	966613	R.H. Rear Side Chain Holder, 7' (37-1/4" Long)
5	966614	Rear Center Chain Rod, 7' (3/8" x 33")
6	966615	Rear Side Chain Rods, 7' (3/8" x 37")
7	966591	1/4" x 6 Link Plated Chain (Front)
8	966596	1/4" x 5 Link Plated Chain (Rear)
9	81619	1/2" x 1" Hex Bolt
10	81637	1/2" Lock Washer
11	81636	1/2" Hex Nut
12	9812430	1/8" x 1" Cotter Pin
13	964001	7/16" I.D. x 10 Ga x 1" O.D. Flat Washer (pl)
14	966616	L.H. Rear Side Chain Holder, 7' (37-1/4" Long)

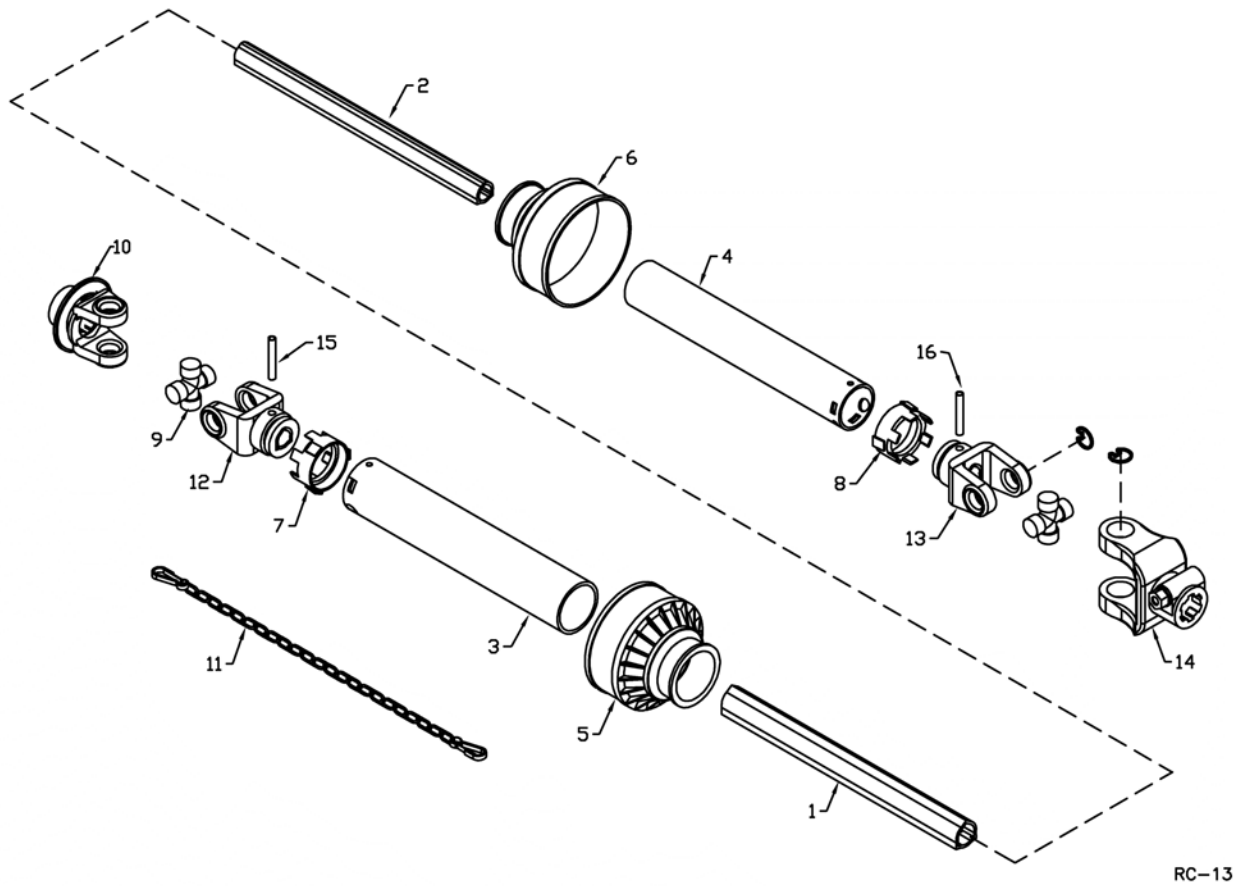
720 PTO Shaft Drawing



RC-12

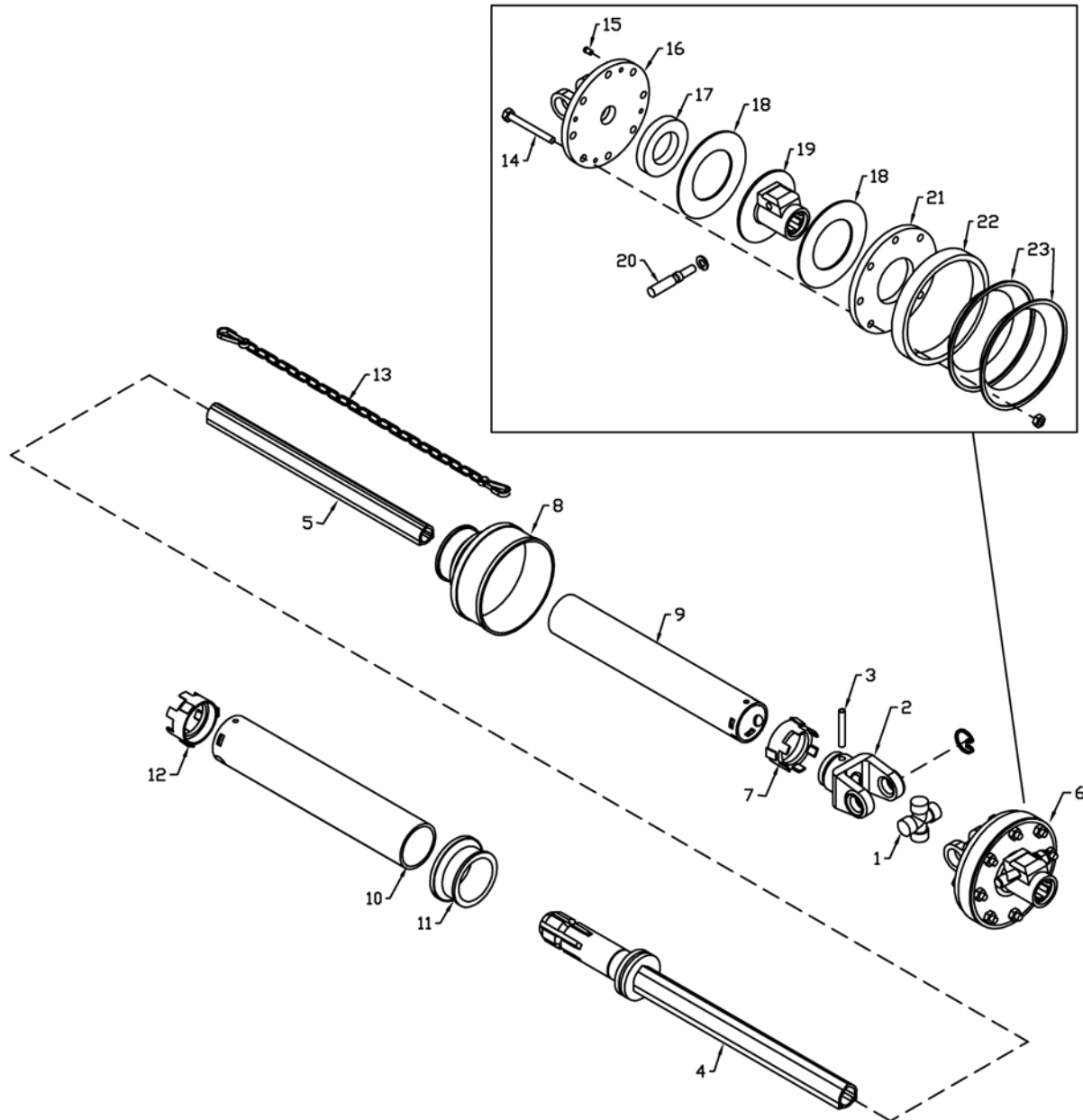
Item	Part Number	Description
720 - (Slip Clutch) 3-Point Hitch Parts List		
	F0442	Shaft Complete
	907300	Tractor Half
	907301	Implement Half
1	936442	Outer Cardan Tube
2	936443	Inner Cardan Tube
3	936445	Outer Shield Tube
4	936446	Inner Shield Tube
5	966232	Outer Shield Cone
6	936518	Inner Shield Cone
7	910-046	Outer Shield Collar
8	910-055	Inner Shield Collar
9	910-036	Repair Kit
10	907299	Quick Disconnect Yoke (6-Spline)
11	936402	Safety Chain
12	910-039	Outer Tube Yoke
13	910-048	Inner Tube Yoke
16	936528	Torque Limiter FT42/6
17	936519	Screw
18	936512	Screw
19	936529	Clutch Plate
20	966223	Bushing
21	936521	Lining
22	936523	Hub
23	910-075	Pivot
24	936522	Thrust Plate
25	936526	Spacer
26	910-040	Flexible Pin, Outer Yoke
27	910-042	Flexible Pin, Inner Yoke
28	936524	Spring Set

720 PTO Shaft Drawing



Item	Part Number	Description
720 - (Slip Clutch) Trailing Parts List		
	F0443	Shaft Complete
	907302	Tractor Half
	907303	Implement Half
1	936486	Outer Cardan Tube
2	936487	Inner Cardan Tube
3	936490	Outer Shield Tube
4	936491	Inner Shield Tube
5	966232	Outer Shield Cone
6	936492	Inner Shield Cone
7	910-046	Outer Shield Bearing
8	910-055	Inner Shield Bearing
9	910-036	Repair Kit
10	907299	Quick Disconnect Yoke (6-Spline) 540rpm
11	936402	Safety Chain
12	910-039	Outer Tube Yoke
13	910-048	Inner Tube Yoke
14	936489	Clamp Yoke (6 Spline)
15	910-040	Flexible Pin, Outer Yoke
16	910-042	Flexible Pin, Inner Yoke

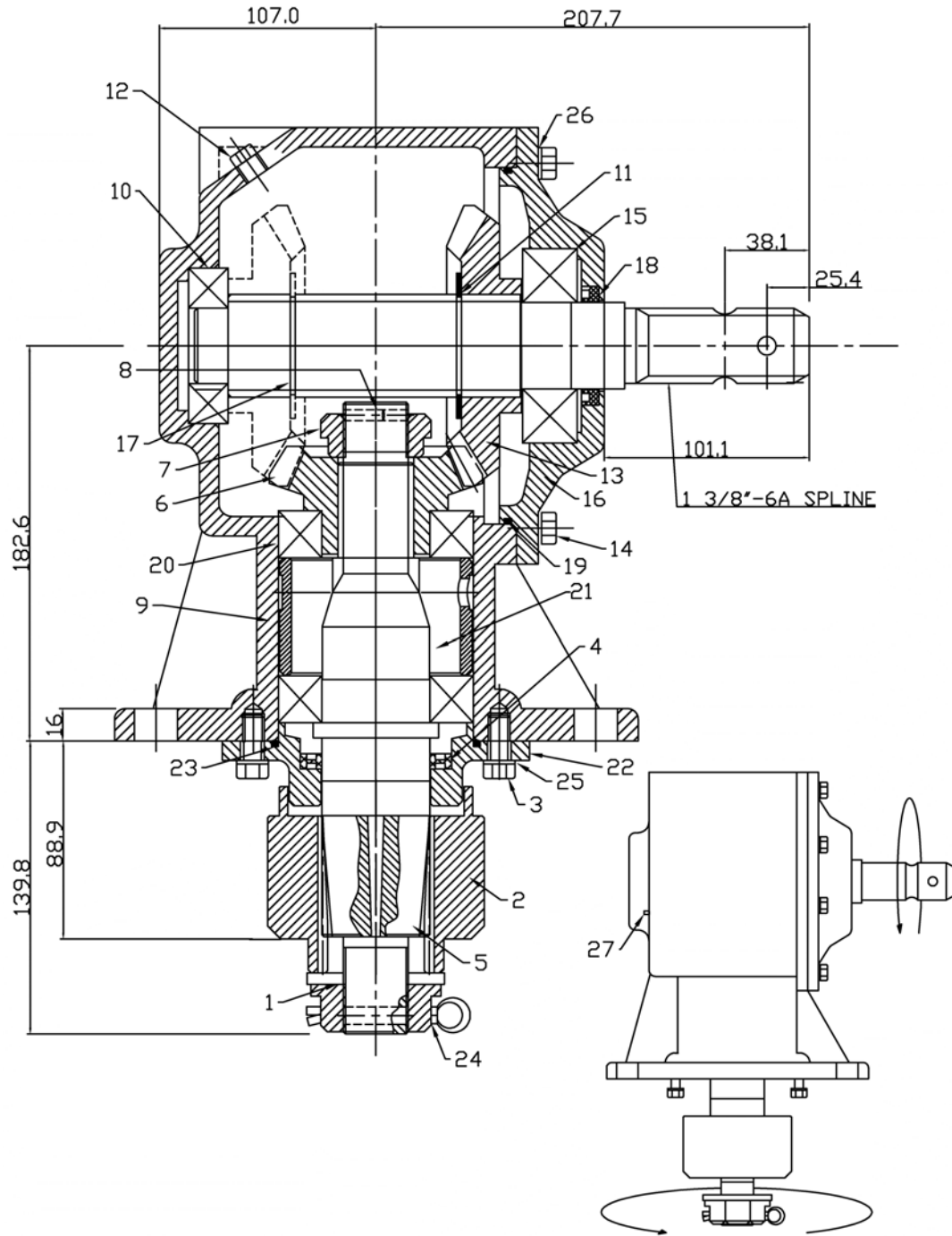
720 Q-Shaft Drawing



RC-14

Item	Part Number	Description
	F9458	Shaft Complete
	936501	Tractor Half
	936561	Implement Half
1	910-036	Repair Kit
2	910-039	Outer Tube Yoke
3	910-040	Flexible Pin, Outer Yoke
4	936496	Splined Shaft
5	936497	Outer Tube
6	936528	Torque Limiter FT42/6
7	910-046	Outer Shield Bearing
8	966232	Outer Shield Cone
9	936498	Outer Shield Tube
10	936499	Inner Shield Tube
11	936500	Inner Shield Collar
12	910-055	Inner Shield Bearing
13	936402	Safety Chain
14	936519	Clutch Screw
15	936512	Set Screw
16	936529	Clutch Plate
17	966223	Antifriction Sleeve
18	936521	Lining
19	936523	Hub
20	910-075	Retaining Bolt
21	936522	Thrust Plate
22	936526	Spacer
23	936524	Spring Set

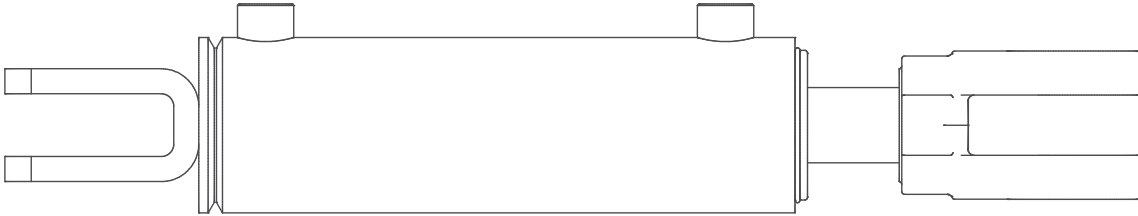
720 Gearbox Drawing



RC-17

Item	Part Number	Description
	966194	Gearbox Assembly
1	907157	Slotted Hex Nut M30 x 2
2	966866	Blade Hub
3	966867	Bolt M10 x 22
4	966868	Seal 50 x 70 x 8
5	966869	Output Shaft
6	966870	Bevel Gear - 14 Tooth
7	966874	Circlip
8	966872	Split Pin 4 x 55
9	966873	Housing
10	967308	Taper Bearing Cone & Cup 30207
11	966871	Circlip
12	966875	Vent Plug 3/8"
13	966876	Bevel Gear - 17 Tooth
14	966877	Bolt M8 x 25
15	966878	Taper Bearing Cone & Cup 30308
16	966879	End Cap
17	966880	Input Shaft
18	966881	Double Lip Seal 40 x 70 x 8
19	966882	O-Ring 3.1 x 155
20	966122	Taper Bearing Cone & Cup 30210A
21	966883	Sleeve
22	966884	Output Cap
23	966885	O-Ring 5 x 90
24	966886	Split Pin 5 x 55
25	966887	M10 Lockwasher
26	81569	M8 Lockwasher (sub 5/16")
27	966888	Level Plug

3 x 8 Cylinder Drawing



Item	Part Number	Description
	24791M	Cylinder Complete
-	X3914	Seal Kit

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
Y720S - 720 Rotary Cutter - 3-Point Hitch		
1	F0187	Deck Assembly w/ Slip Clutch
1	F0037	Wheel & Yoke
1	F0336	Hitch & Adjustment Arms
1	F0190	Tail wheel Arm & Lift Arms
1	F0442	Slip Clutch PTO
1	F0183	Carton
Y720 - 720 Rotary Cutter - Trailing		
2	F7110	15" x 4-1/2" x 4 Bolt Wheel
1	F0178	Tongue Assembly
2	F9434	Yoke & 4 Bolt Hub
1	F0187	Deck Assembly w/ Slip Clutch
1	F9453	Swivel Tube & Rod
1	F0184	Carton of Parts
1	F0443	PTO Shaft w/o Slip Clutch
1	F9458	PTO Q-Shaft w/ Slip Clutch

Optional Bundle Numbers

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

Quantity	Bundle Number	Description
1	F9415	Jack c/w Mounting Plate
1	F630	Hydraulic Cylinder & Hose Kit
1	Y725	720 3-Point Hitch Kit
1	Y727	720 Trailing Kit
1	Y207	Implement Tires 6.70 x 15" (set of 2)
Y724 - Optional Chain Kit for 720 Cutters		
1	F9499	Plates & Rods
1	F9498	Carton

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.

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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