

# WC46 PTO WOOD CHIPPER



## OPERATOR'S MANUAL



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## INTRODUCTION

Congratulations on your purchase and welcome to Woodland Mills! This manual gives you the necessary information about your machine so you will be able to use it properly. The entire manual must be read and understood before you start using the machine. If any questions should arise that are not covered by this manual, please contact Woodland Mills Inc.

### OWNER'S RECORD

Please take a moment to record the following information about your wood chipper. If you need to call for assistance, please be ready to provide your model and serial numbers. This information will allow us to help you more quickly when you call.

#### MODEL NUMBER

#### SERIAL NUMBER

#### DATE OF PURCHASE

This machine is designed for certain applications only. We strongly recommend that this machine is not modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the machine until you have first contacted us to determine if it can or should be performed on the product.

For technical questions and replacement parts, please contact Woodland Mills Inc.

## INTENDED USE

Woodland Mills wood chippers are designed for acreage owners to aid in chipping natural, untreated wood only. Materials that are processed may contain chemicals or by-products that could corrode the machine or damage it, resulting in safety concerns.



## SAFETY GUIDELINES

### **\*\*SAVE THESE INSTRUCTIONS\*\***

- Do not operate this machine until this manual has been read and fully understood; serious injury or severe machine damage could occur if these safety warnings are ignored.
- Never allow more than one person to operate this machine at one time. If two people are working together it will increase the chance of your workmate engaging the machine or causing you to fall into the machine.
- If your hand is ever near the chipping or feeding area, serious injury could occur.
- Never place your hands or feet on or near the machine while it is engaged.
- Never place your hands or feet on or near the material while it is feeding.
- DO NOT wear loose clothing, jewelry, or anything that can catch a branch that is feeding into the wood chipper.
- DO NOT stand directly in front of the infeed chute when loading material into the hopper; always load from the side of the hopper. This will help prevent any part of your body from being pulled into the machine.
- Always wear safety hearing protection, eye wear, gloves, and long pants when operating the wood chipper.
- Never place your hands beyond the opening of the hopper while the wood chipper is running.
- Never allow children, disabled, or untrained persons to operate the wood chipper.
- Do not operate the wood chipper near bystanders, public roads, or anywhere that debris may travel far enough to injure another person.
- Never move the wood chipper while it is running.
- Shut off the tractor and allow the wood chipper to come to a complete stop before removing any debris.
- Never perform any maintenance or repair while the wood chipper is running.



## ROTATING DRIVELINES

**\*\*STAY CLEAR OF ROTATING DRIVELINES\*\***



- Entanglement in rotating driveline can cause serious injury or death.
- Keep tractor master shield and driveline shields in place at all times. Make sure rotating shields spin freely.
- Wear close-fitting clothing.
- Shut off the engine and be sure the PTO driveline has stopped before making adjustments, connections, or cleaning out PTO-driven equipment.
- Do not install any adapter device between the tractor and the primary implement PTO drive shaft that would allow a 1000 RPM tractor shaft to power a 540 RPM implement at speeds higher than 540 RPM.
- Do not install any adapter device that results in a portion of the rotating implement shaft, tractor shaft, or the adapter to be unguarded. The tractor master shield shall overlap the end of the splined shaft.



### WARNING!

Read and understand all instructions. Failure to properly follow the instructions listed below may result in serious injury or death.



### WARNING!

The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product but must be supplied by the operator.



## PERSONAL SAFETY

- **Stay alert**, watch what you are doing and use common sense when operating a power tool. Do not use a power tool when you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.
- **Dress properly.** Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing, and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts. Air vents often cover moving parts and should be avoided.
- **Use safety apparel and equipment.** Use safety goggles or safety glasses with side shields that comply with current national standards, or when needed, a face shield. Use a dust mask in dusty work conditions. This applies to all persons in the work area. Also use non-skid safety shoes, a hardhat, gloves, dust collection systems, and hearing protection when appropriate.
- **Do not over reach.** Keep proper footing and balance at all times.
- **Remove adjusting keys or wrenches** before connecting to the power supply or turning on the tool. A wrench or key that is left attached to a rotating part of the tool may result in personal injury.
- **Never remove or install blades, conduct any maintenance, or make any other adjustments while the tractor engine is running.** Always shut the engine off, remove the ignition key, and disconnect the PTO shaft prior to carrying out any of the aforementioned procedures. Consult your tractor's manual for safe shutdown procedures to prevent accidental ignition.



## WORK AREA

- **Keep work area clean**, free of clutter and well lit. Cluttered and dark work areas can cause accidents.
- **Do not use your wood chipper where there is a risk of causing a fire or an explosion;** e.g. in the presence of flammable liquids, gasses, or dust. Power tools create sparks which may ignite the dust or fumes.
- **Keep children and bystanders** away while operating a power tool. Distractions can cause you to lose control, therefore, visitors should remain a safe distance from the work area.
- **Be aware of all power lines, electrical circuits**, water pipes and other mechanical hazards in your work area, particularly those hazards below the work surface hidden from the operator's view that may be unintentionally contacted and cause personal harm or property damage.
- **Be aware of your surroundings.** Using power tools in confined work areas may put you dangerously close to cutting tools and rotating parts.

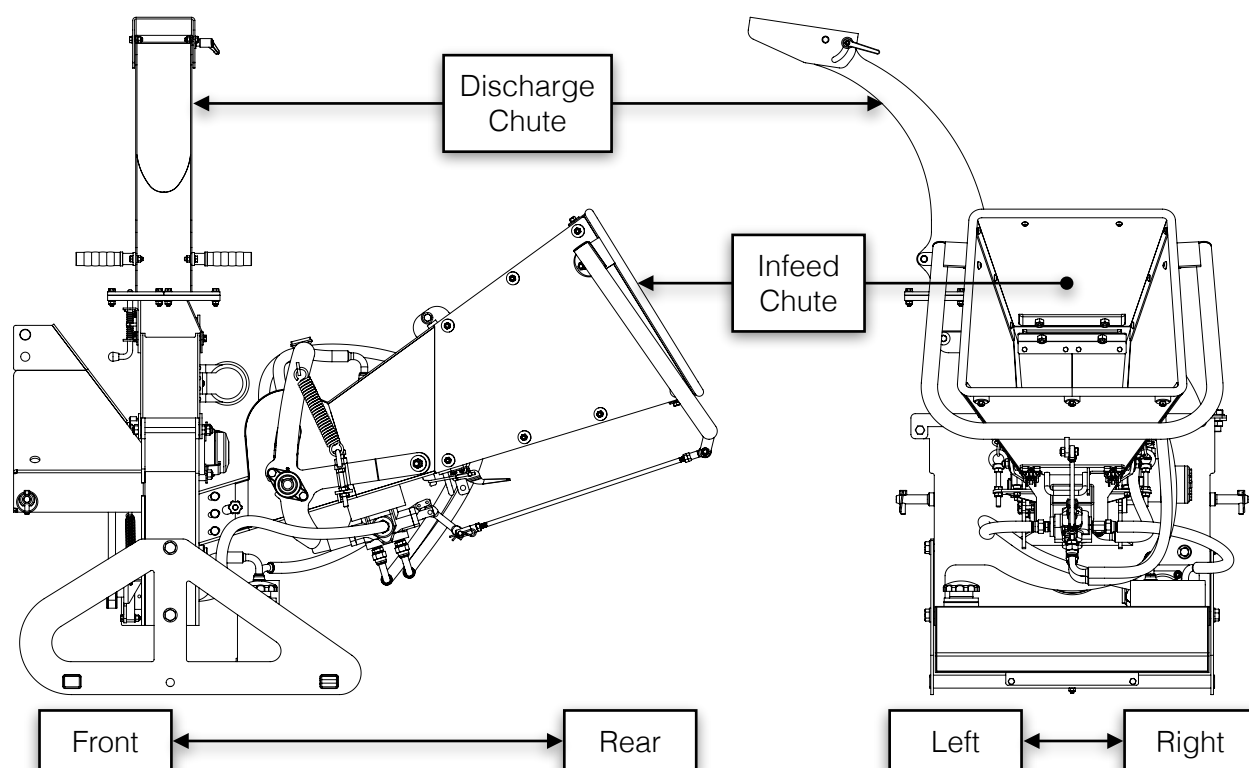


## TOOL USE AND CARE

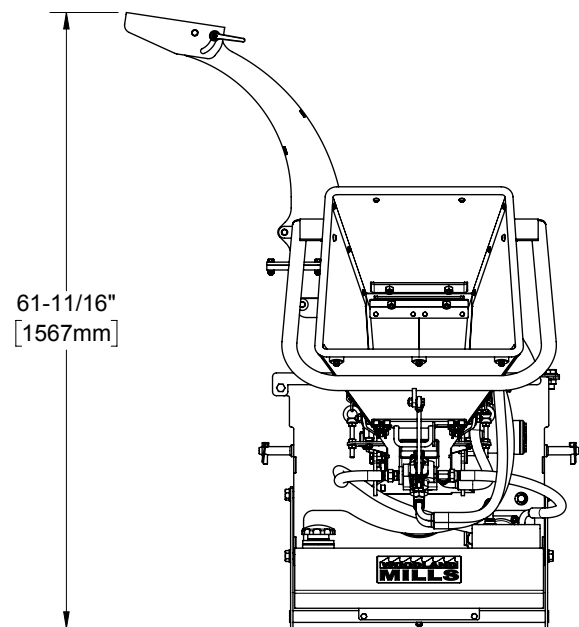
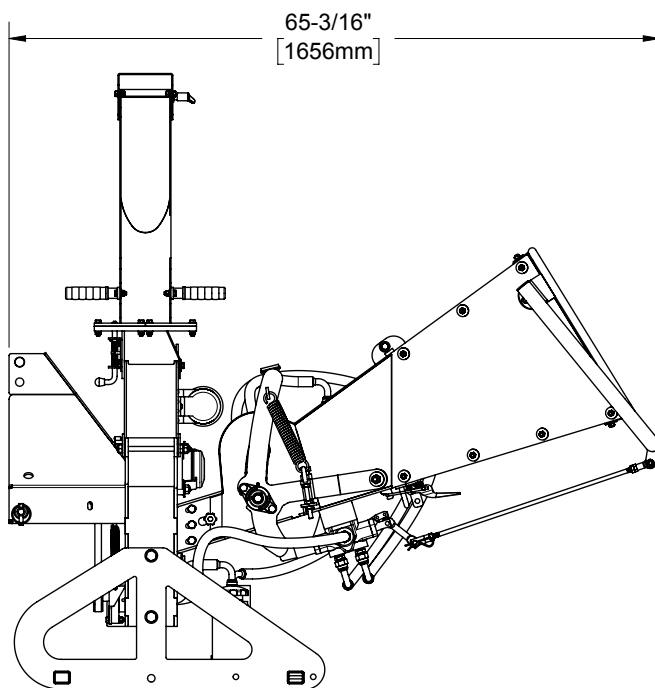
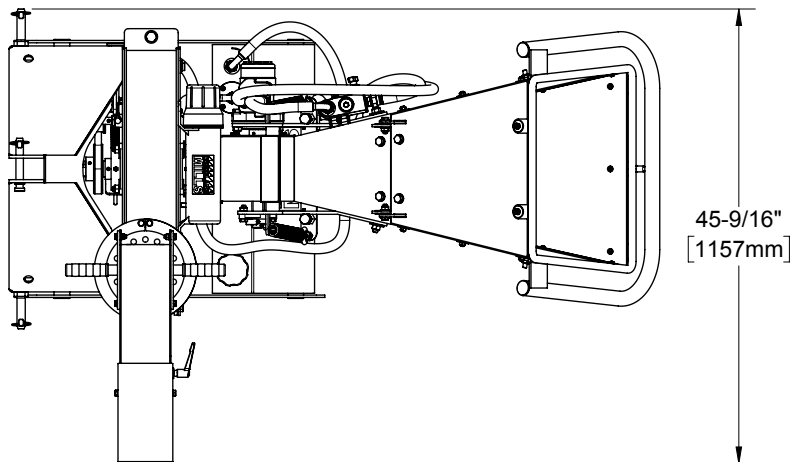
- **Always be sure the operator is familiar** with proper safety precautions and operation techniques before using machine.
- **Do not force the tool.** Tools do a better and safer job when used in the manner for which they are designed.
- **Turn off the tractor engine** and disconnect the PTO shaft before servicing, adjusting, installing accessories or attachments, or storing. Such preventive safety measures reduce the risk of starting the power tool accidentally.
- **Storing the wood chipper.** When the wood chipper is not in use, store it in a dry, secure place or keep it well covered and out of reach of children. Inspect the wood chipper for good working condition prior to storage and before re-use.
- **Maintain your wood chipper.** It is recommended that the general condition of the wood chipper be examined before it is used. Keep your wood chipper in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. If abnormal vibration or noise occurs, turn the wood chipper off immediately and have the problem corrected before further use.
- **Keep blades sharp and clean.** Properly maintained wood chipper blades are less likely to bind and make feeding-in brush easier.
- **Cleaning and Lubrication.** Use only soap and a damp cloth to clean your wood chipper. Many household cleaners are harmful to plastic and rubber components on the wood chipper.
- **Use only accessories that are recommended** by the manufacturer for your model. Suitable accessories for another wood chipper may create an injury risk when used on this wood chipper.
- **Always** operate the machine with all safety devices and guards in place and in working order. DO NOT modify or make changes to safety devices. DO NOT operate the machine if any safety devices or guards are missing or inoperative.
- **Never leave wood chipper running unattended.**
- **Never use the equipment to chip brush with trunks exceeding 4" (102 mm) in diameter** or for any purpose other than chipping brush as described in this manual.

## TECHNICAL SPECIFICATIONS

Component	WC46 Specification
Drive System	PTO
Transport	3-Point Hitch
Minimum HP Required (at PTO)	15 hp
In-Feed System	Hydraulic
Hydraulic Oil	ISO 32 / AW 32 (ISO 46 / AW 46 for warmer climates)
Hydraulic Tank Volume	4.5 gal [17 L]
Hydraulic Requirement (Tractor)	None. Self contained.
PTO Shear Bolt	M8 X 50 mm Class 8.8 [5/16-18 X 2 in Grade 5] Hex Bolt
Blade Quantity and Dimensions	Four (4); 5.71 X 2.72 X 5/16 in [145 X 69 X 8 mm]
Blade Hardware	M10 X 35 mm Flat Head, M10 Lock Nuts - Class 10.9
Infeed Roller Diameter	5-1/4 in [133 mm] at Tooth Tip
Infeed Chute Dimensions	19-5/8 X 18-7/8 in [500 X 480 mm]
Product Weight	550 lb [250 kg]
Product Shipping Weight	625 lb [284 kg]



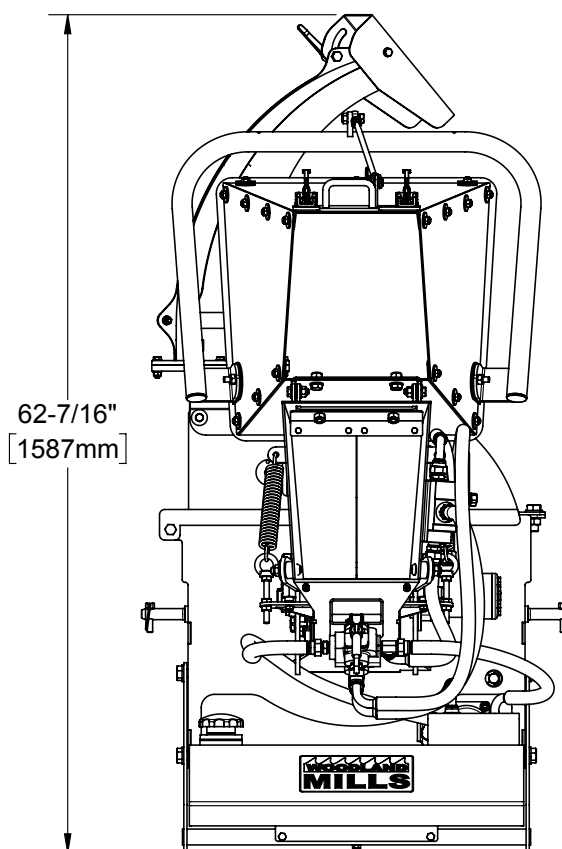
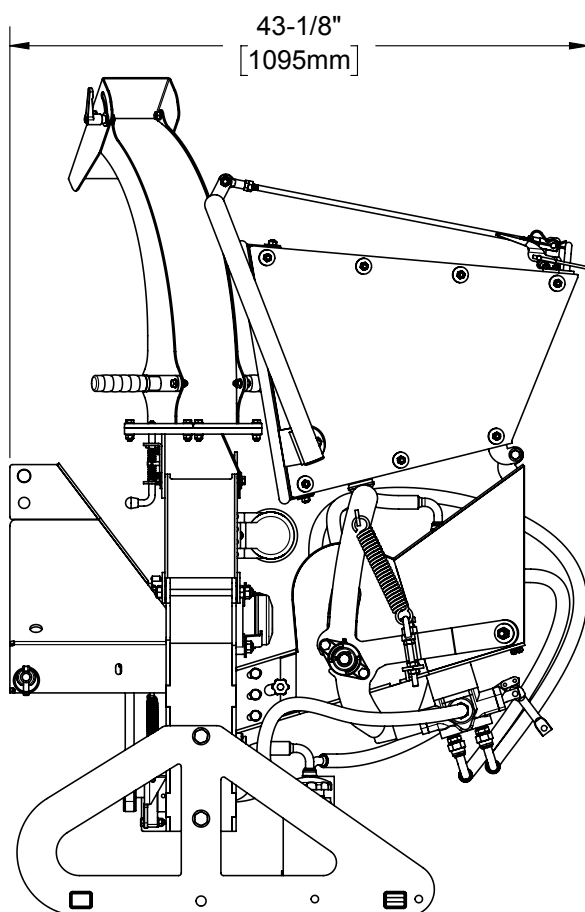
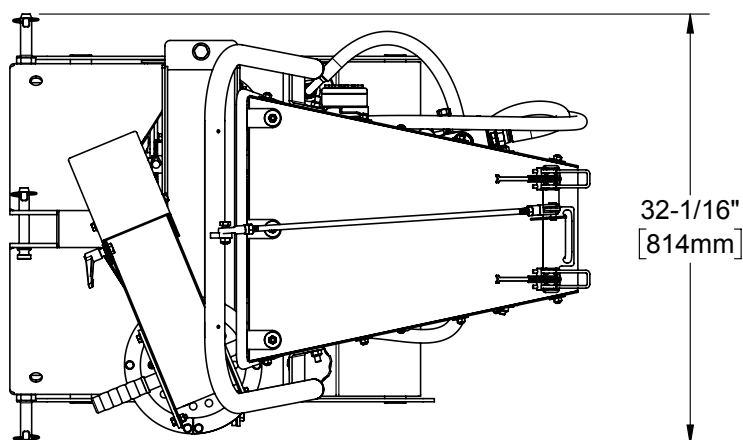
## i. OVERALL DIMENSIONS—OPERATING STATE





## ii. OVERALL DIMENSIONS—STORED STATE

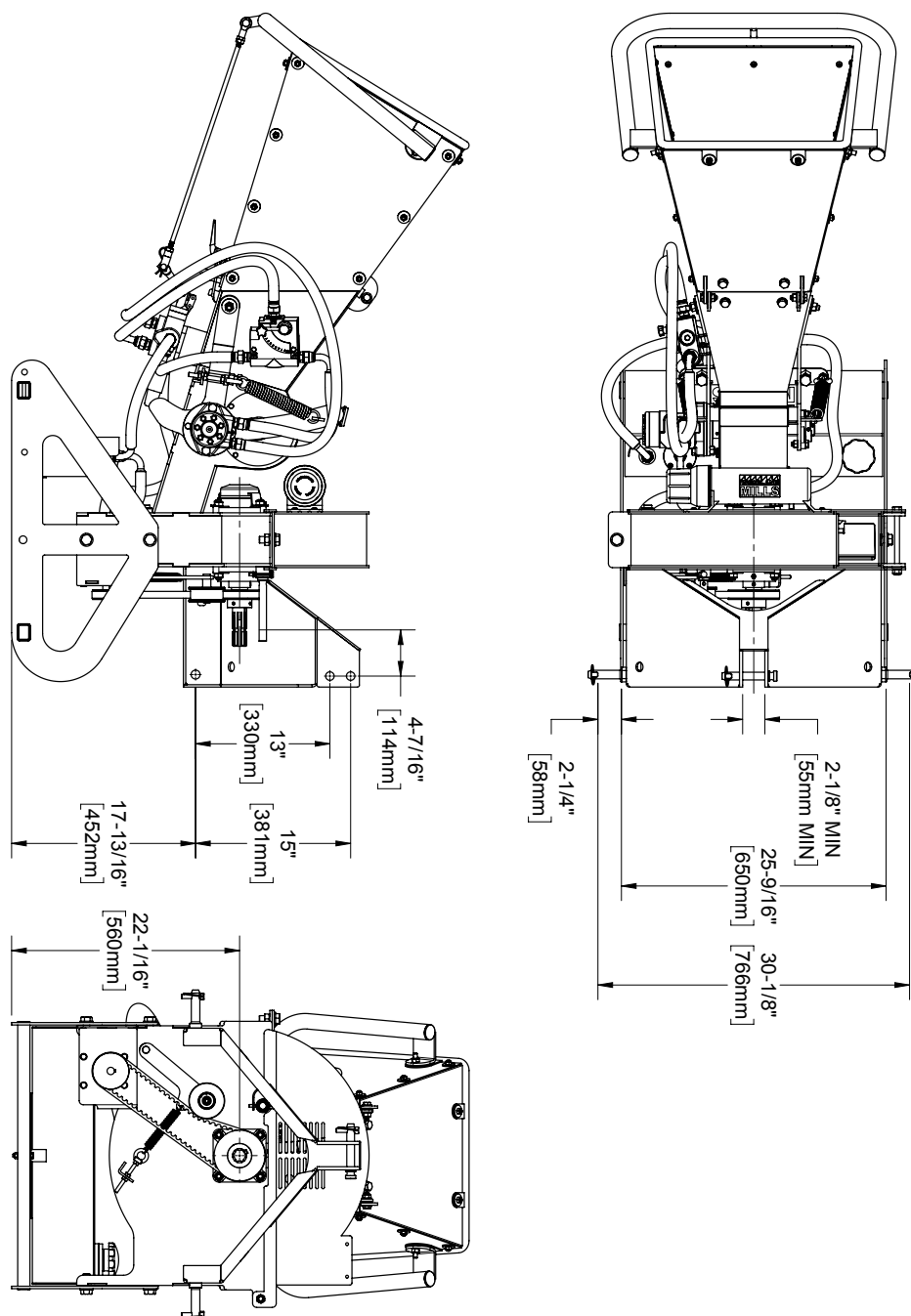
The discharge chute must be rotated so that it is angled towards the left side of the chipper in order to allow room for the infeed chute to be flipped upward when the machine is in its stored state. See section, **Storage**, for more information.



### iii. 3-POINT HITCH DIMENSIONS

The wood chipper 3-point hitch is a *Category 1* system design to work with tractors in the horsepower range of 15-30 hp. Top link pin is  $\frac{3}{4}$ " (19 mm) diameter and the lift arm pins are  $\frac{7}{8}$ " (22 mm) diameter.

Discharge chute removed from views for clarity.

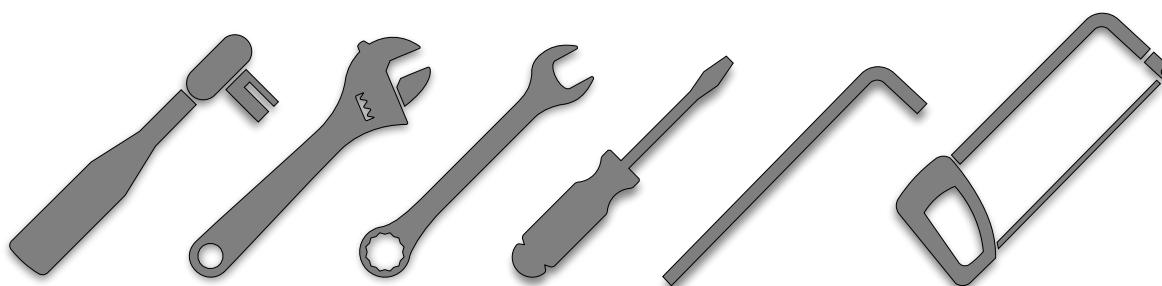


## ASSEMBLY

### 1. TOOLS REQUIRED

Tool	Specification
Wrench/Socket	13 mm (2X)
Wrench/Socket	16 mm (2X)
Wrench/Socket	17 mm
Wrench/Socket	24 mm or Adjustable Wrench
Wrench	27 mm or Adjustable Wrench
Hex Key	Set of Metric Hex Keys (e.g. 2-10 mm)
Hacksaw*	Any metal-cutting saw (Sawzall, etc.)

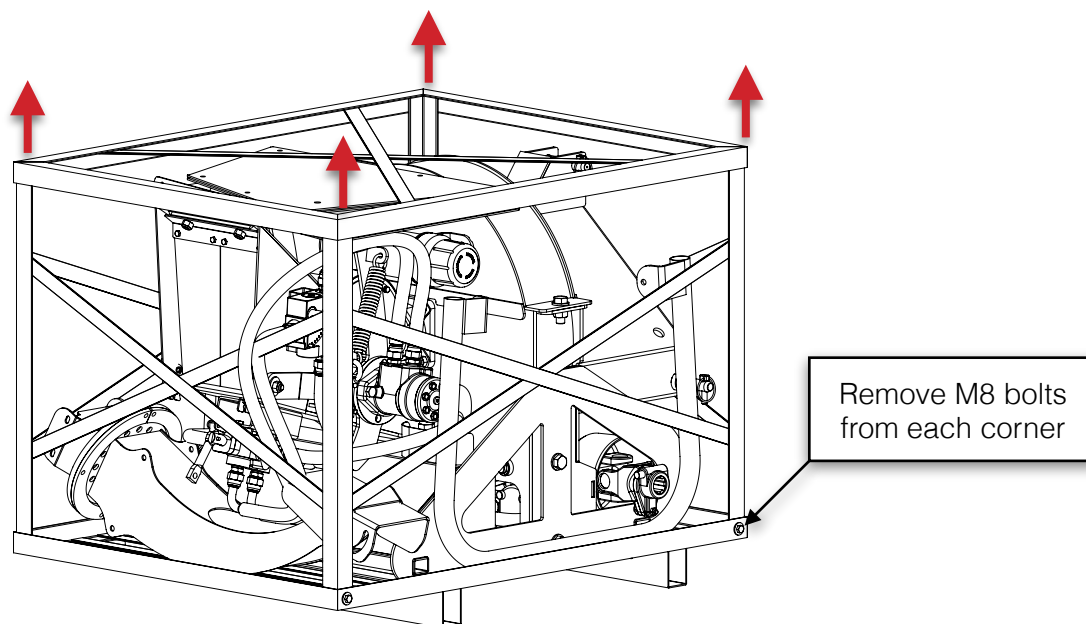
\* Only if PTO shaft requires trimming. See [\*Trimming the PTO Shaft\*](#) section for more detail.



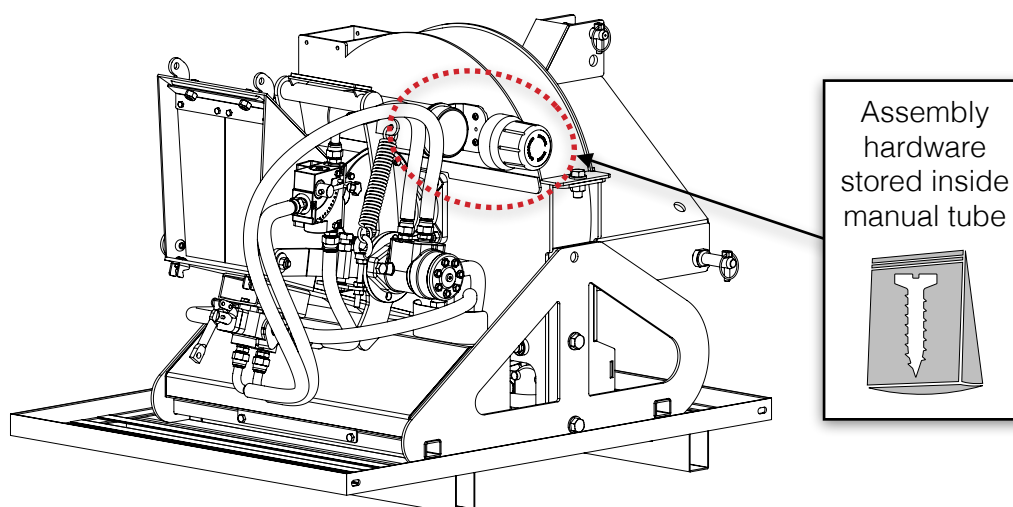
## 2. UNPACKING

### A. UNBOXING THE CRATE

Unpack the contents of the crate by first cutting the nylon strapping and then remove the cardboard top and sides. Remove the four (4) M8 hex bolts and nuts located at each bottom corner of the crate and then lift it off the skid. Discard the crate.



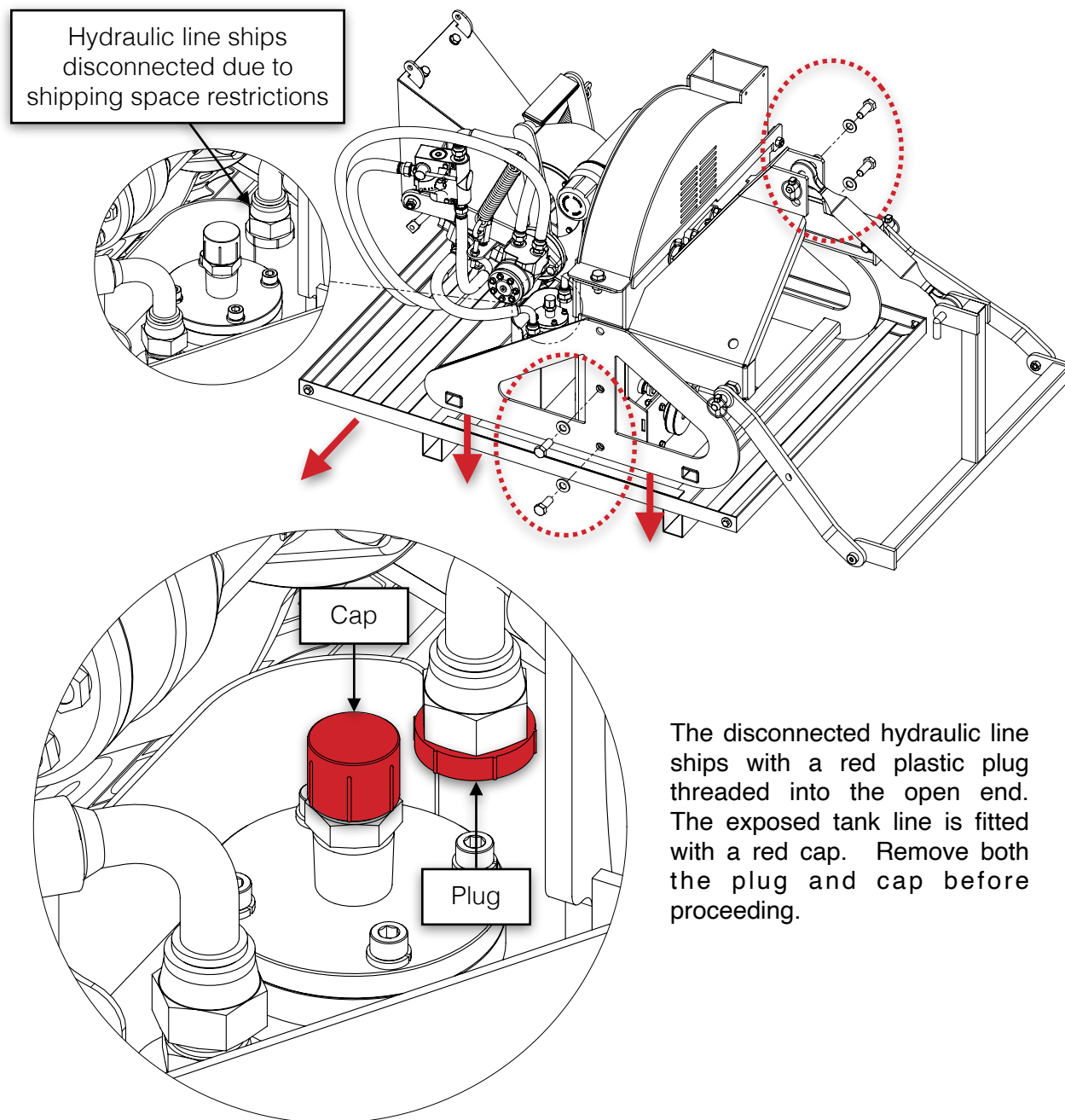
Remove all the loose components from the skid (infeed chute panels, control arm, edge bar, control arm linkage, discharge chute, discharge chute handles, PTO shaft) and set them to the side. Leave the wood chipper on the skid.



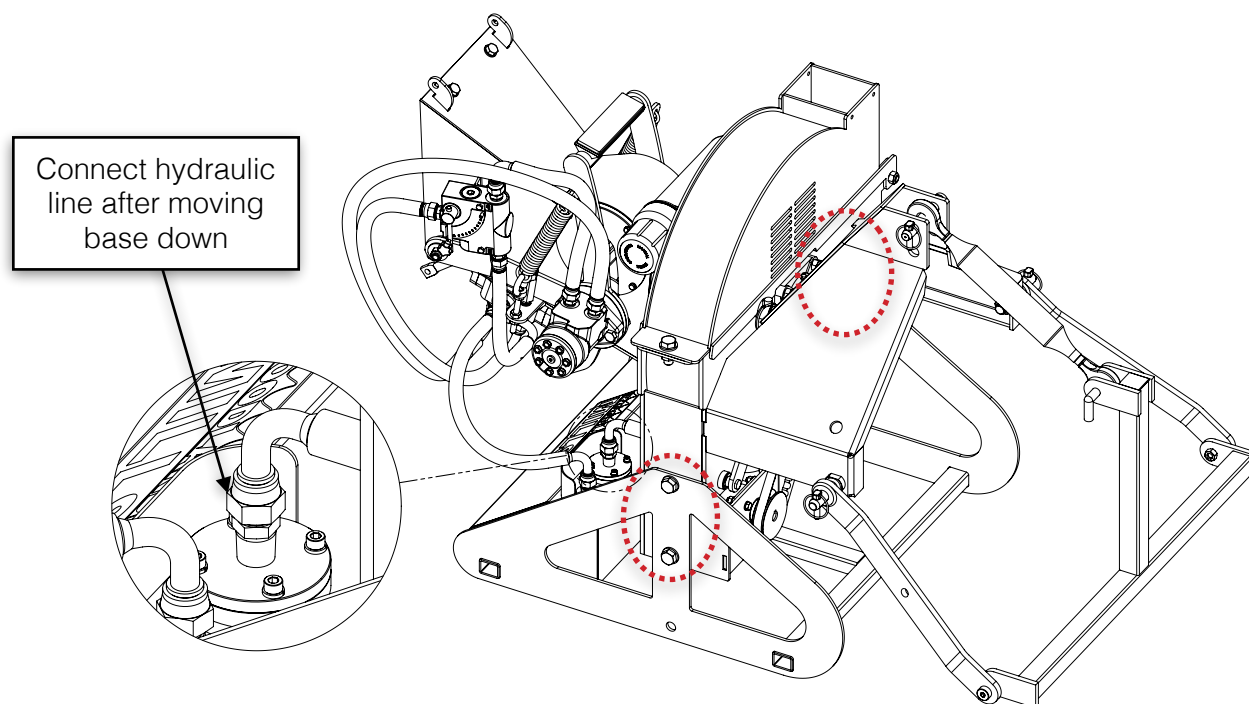
Note that the wood chipper is shipped dry (i.e. no hydraulic fluid) from the factory. See the **Technical Specifications** section for the volume and type of oil required.

## B. SETTING THE MOUNTING BASE

With the wood chipper still resting on the skid, attach the tractor's 3-point hitch and raise it a minimum of 2-1/4" (57 mm) above the skid. Slide the skid out from under the wood chipper and discard it. Remove the four (4) M16 X 40 mm hex bolts and M16 flat washers that connect the base assembly to the lower flywheel housing.



Carefully lower the detached base assembly to the ground. Use the 3-point hitch system to lower the wood chipper until the top two (2) holes on each side of the mounting base align with the corresponding holes in the lower flywheel housing. Reattach the four (4) M16 X 40 mm hex bolts and M16 flat washers. Connect the hydraulic line to the tank that originates from the pump beneath the lower flywheel housing.



## WARNING!

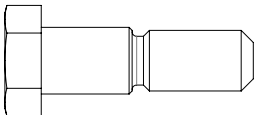
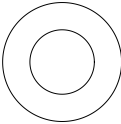
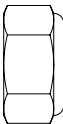
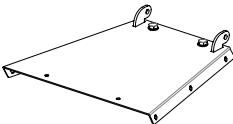
The hydraulic tank ships empty from the factory. The user must add the recommended hydraulic fluid per the table in the section, **Technical Specifications**, prior to using the chipper.

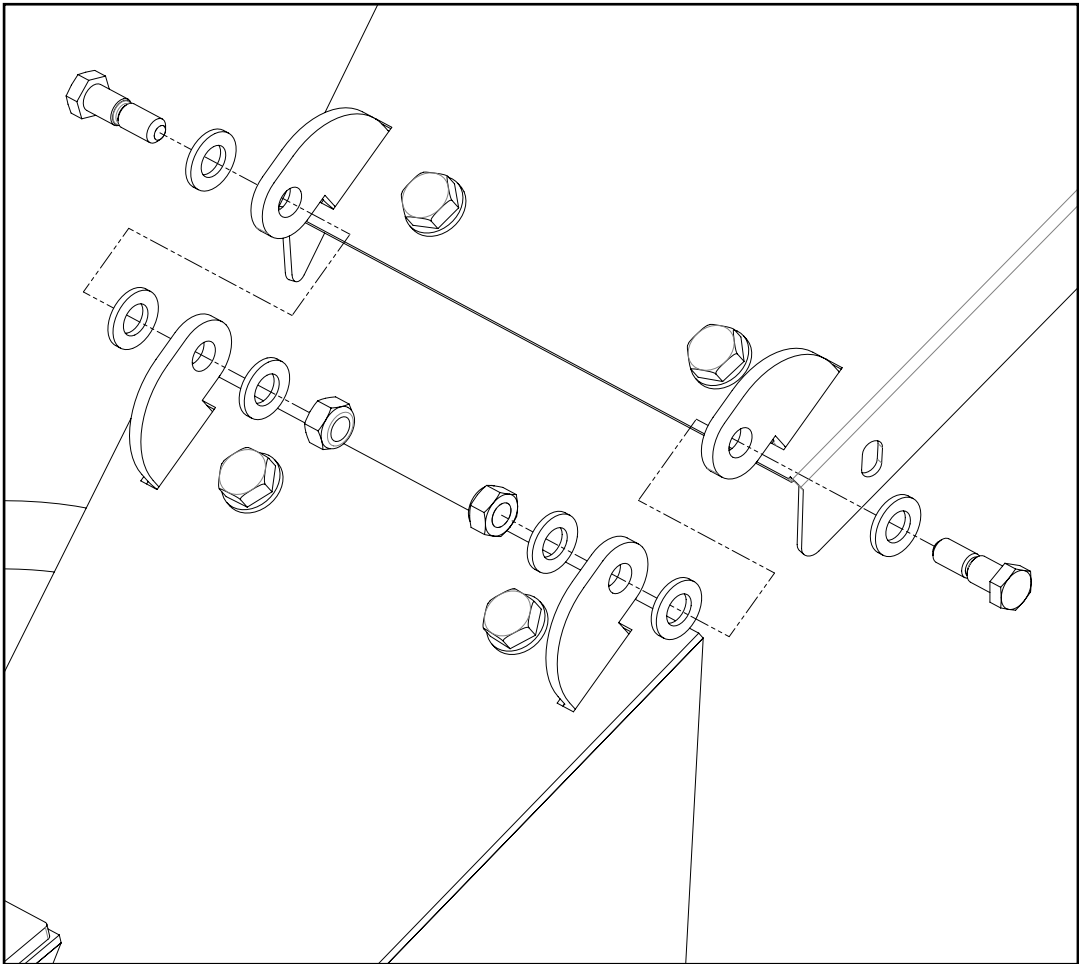


3. INFEED CHUTE

A. TOP PANEL

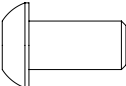
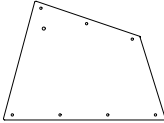

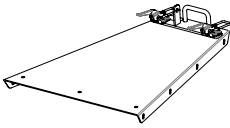
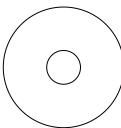
The wood chipper infeed chute consists of four (4) metal panels that are bolted together. The first step is bolting the top panel to the lower flywheel housing that forms the hinge. Using the hardware listed in the table below, assemble the hinge connection. Note that the infeed chute top panel and hinge bracket come pre-assembled from the factory.

2x	M10 X 15 X 20 mm Shoulder Bolt		6x	M12 Nylon Flat Washer	
2x	M10 Lock Nut		1x	Infeed Chute Top Panel	

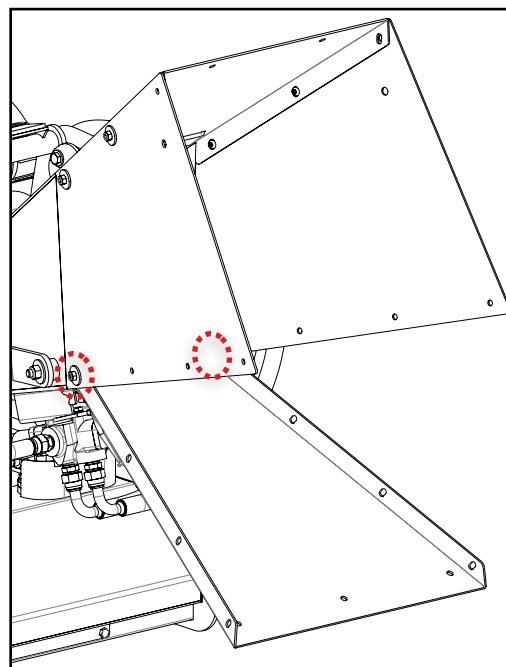
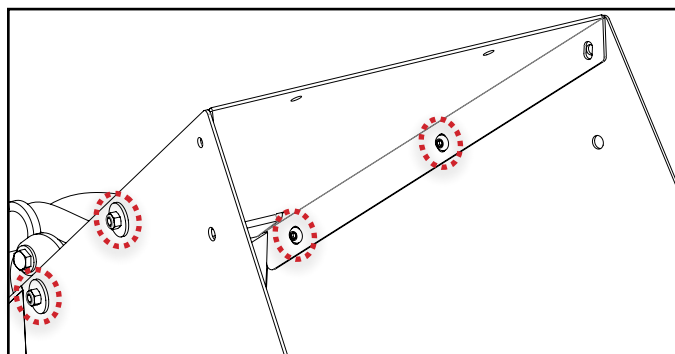


## B. SIDE PANELS AND BOTTOM PANEL

With the top panel bolted to the hinge, assemble each side panel to the sides of the top panel using the M8 X 18 mm button head screws, M8 lock nuts, and M8 fender washers. Use a hex key for the screws and a socket/wrench for the lock nuts.

6x	M8 X 18 mm Button Head Screw		2x	Infeed Chute Side Panel	
6x	M8 Lock Nut		1x	Infeed Chute Bottom Panel	
6x	M8 X 30 mm Fender Washer				

Install two (2) screws per side along the top edge leaving the last holes empty. Do not fully tighten the screws. Be sure to assemble the screws with the heads on the inside of the chute pointing outwards. Next, install the bottom panel using only the first two (2) bolts as shown below (right). This will allow it to swing up to join the side panels in the coming steps. Note that the infeed chute bottom panel and latches come pre-assembled from the factory.

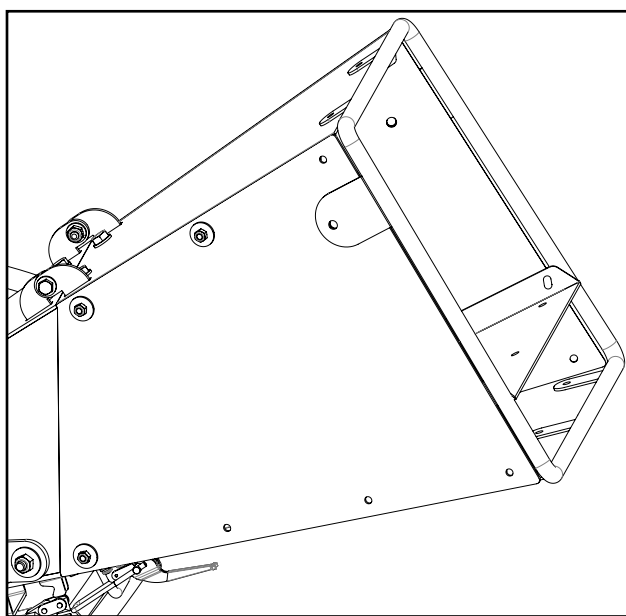
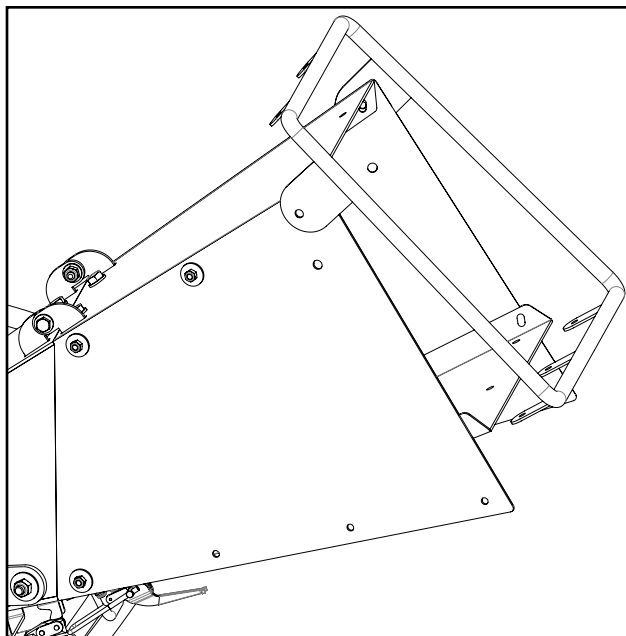




## C. EDGE BAR

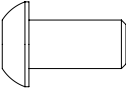
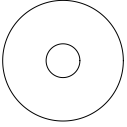

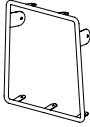
The round edge bar is designed to add additional strength to the infeed panels as well as act as a rounded edge, eliminating branches from getting caught on the edge of the infeed panels.

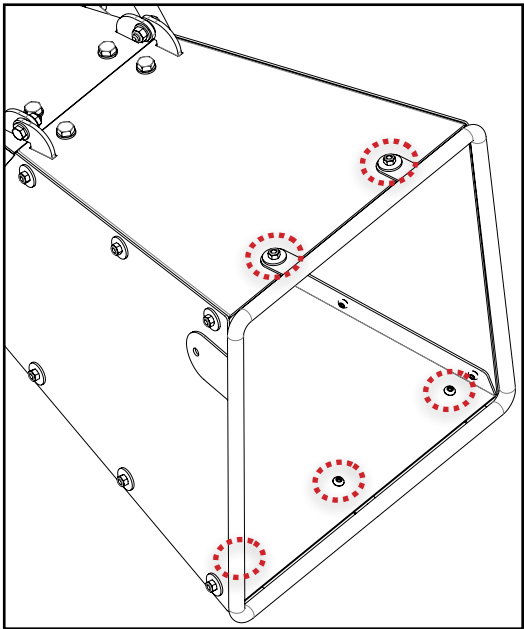
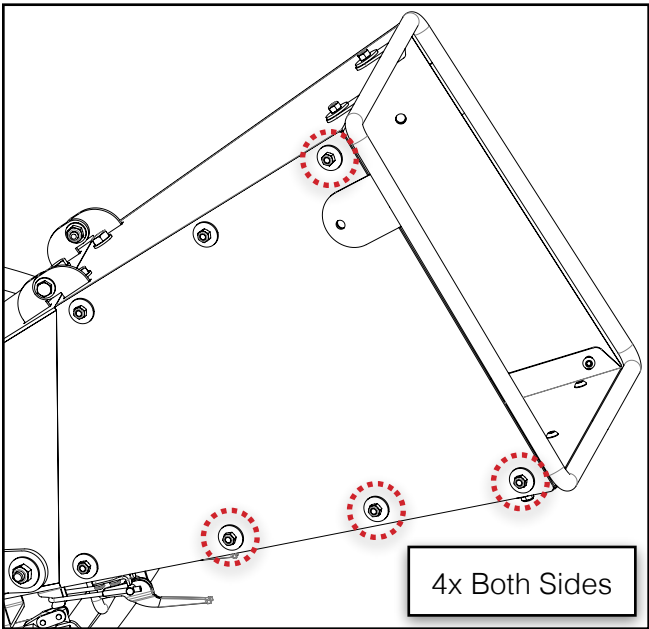
To install the edge bar, swing the bottom panel up as shown below and fit the tabs over the outside of the panels. There are two tabs on the side of the round edge bar which will be bolted to the side panels in a later step.





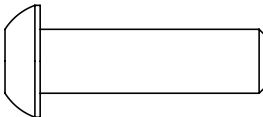
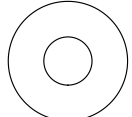
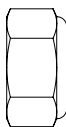
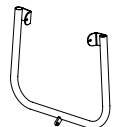
With the edge bar in place, use the hardware listed below to assemble the panels and the edge bar. Use a hex key for the button head screws and a socket/wrench for the lock nuts. Install the remaining thirteen (13) M8 X 18 mm button head screws, M8 lock nuts, and M8 X 30 mm fender washers as shown below to secure the panels and edge bar in place. Do not fully tighten the screws.

13x	M8 X 18 mm Button Head Screw		13x	M8 X 30 mm Fender Washer	
13x	M8 Lock Nut		1x	Infeed Chute Round Edge Bar	

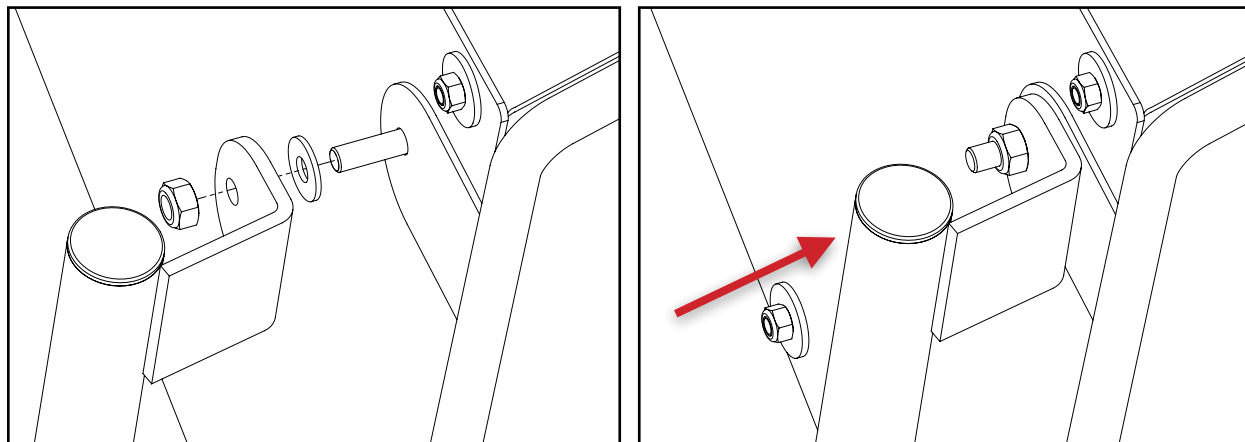


## D. CONTROL ARM

The large red infeed control arm is attached using two (2) M10 X 35 mm button head screws, M10 lock nuts, and M10 X 26 mm fender washers. Use a hex key for the screws and a socket/wrench for the lock nuts. The screws pass through the inside of the chute side panel, through the round edge bar side tabs, and finally through the control handle tabs as shown below.

2x	M10 X 35 mm Button Head Screw		2x	M10 X 26 mm Fender Washer	
2x	M10 Lock Nut		1x	Control Arm	

The screw passes through the green chute panel, the grey edge bar side tab, and finally through the red control arm tab as shown below.


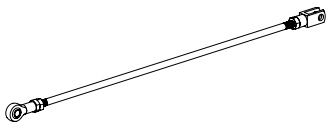
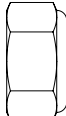
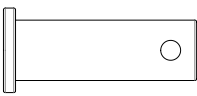
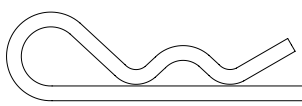


Note that the distance between the unassembled red infeed control arm mounting tabs can be significantly wider than the infeed chute. This is normal and the arm will flex when compressed. Assemble one side of the control arm first (but do not fully tighten it), then pull the other end in and secure that side.

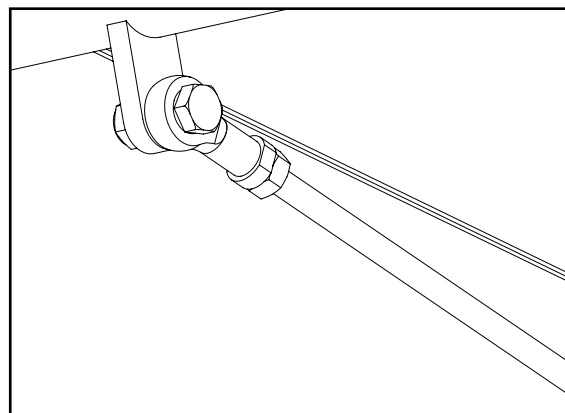
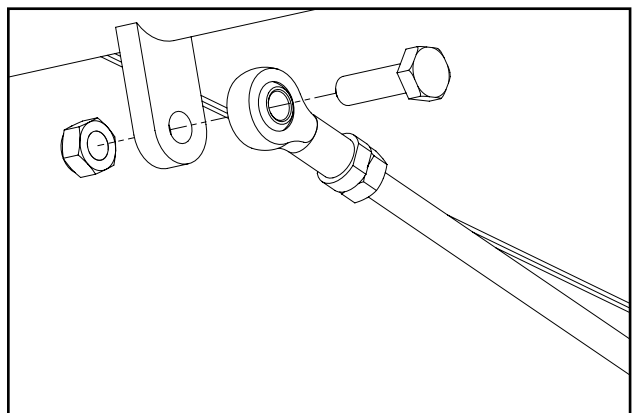
With all of the infeed panel, edge bar, and control arm screws now loosely assembled, tighten all screws securely.

## E. CONTROL ARM LINKAGE

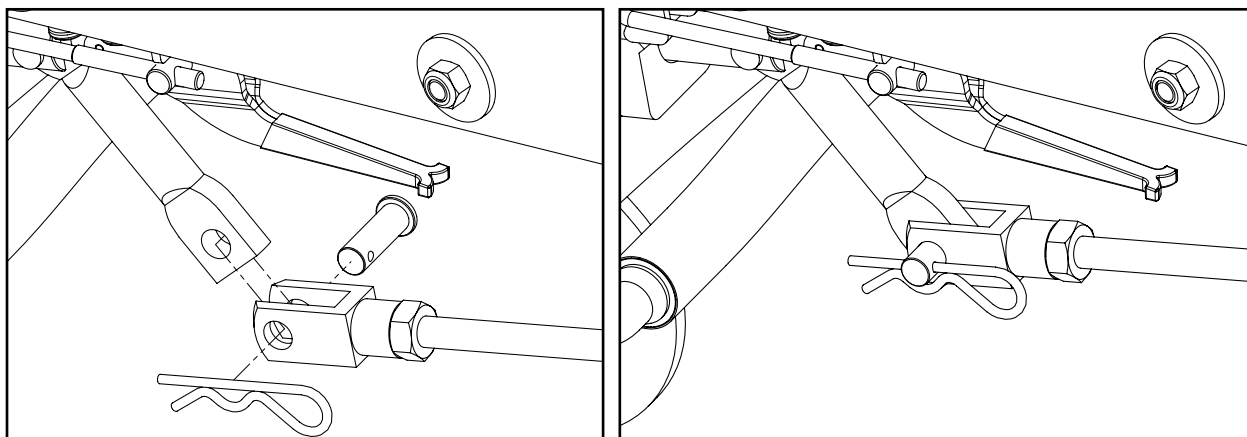
With the control arm fastened to the infeed chute, the linkage assembly can now be connected between it and the hydraulic directional control valve.

1x	M10 X 35 mm Hex Bolt		1x	Control Arm Linkage Assembly	
1x	M10 Lock Nut		1x	10 mm Clevis Pin	
			1x	Hairpin Cotter Pin	

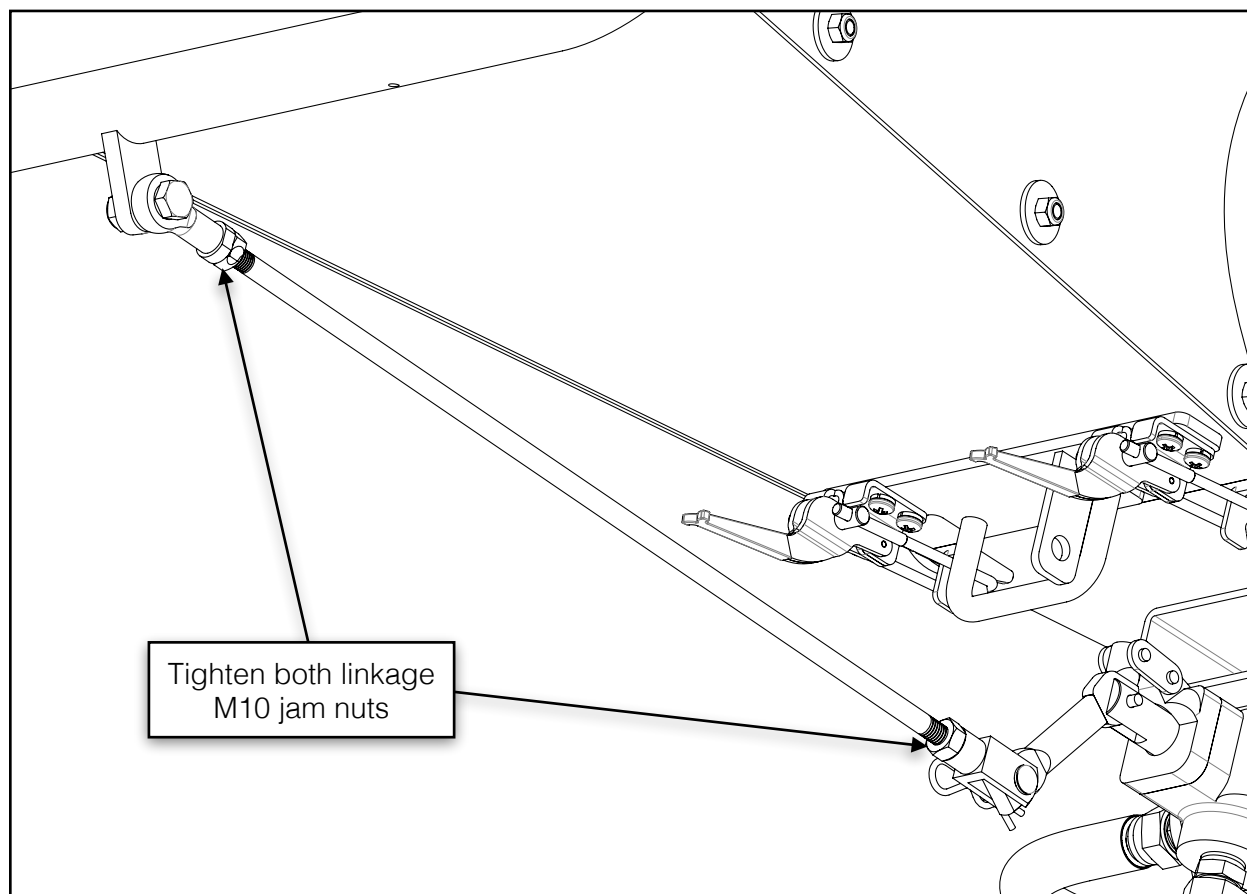
Fasten the rod end bearing to the red control arm with the M10 X 35 mm hex bolt and M10 lock nut as shown below.



On the opposite end of the linkage, secure the linkage to the the hydraulic directional control valve actuator using the clevis pin and hairpin cotter pin.



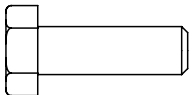
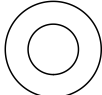
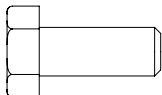
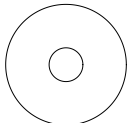
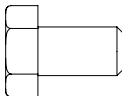
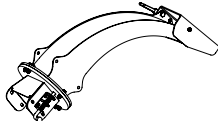

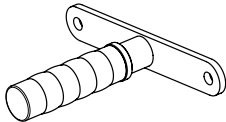
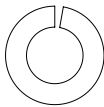
Once the linkage has been assembled, ensure both M10 jam nuts are tight.





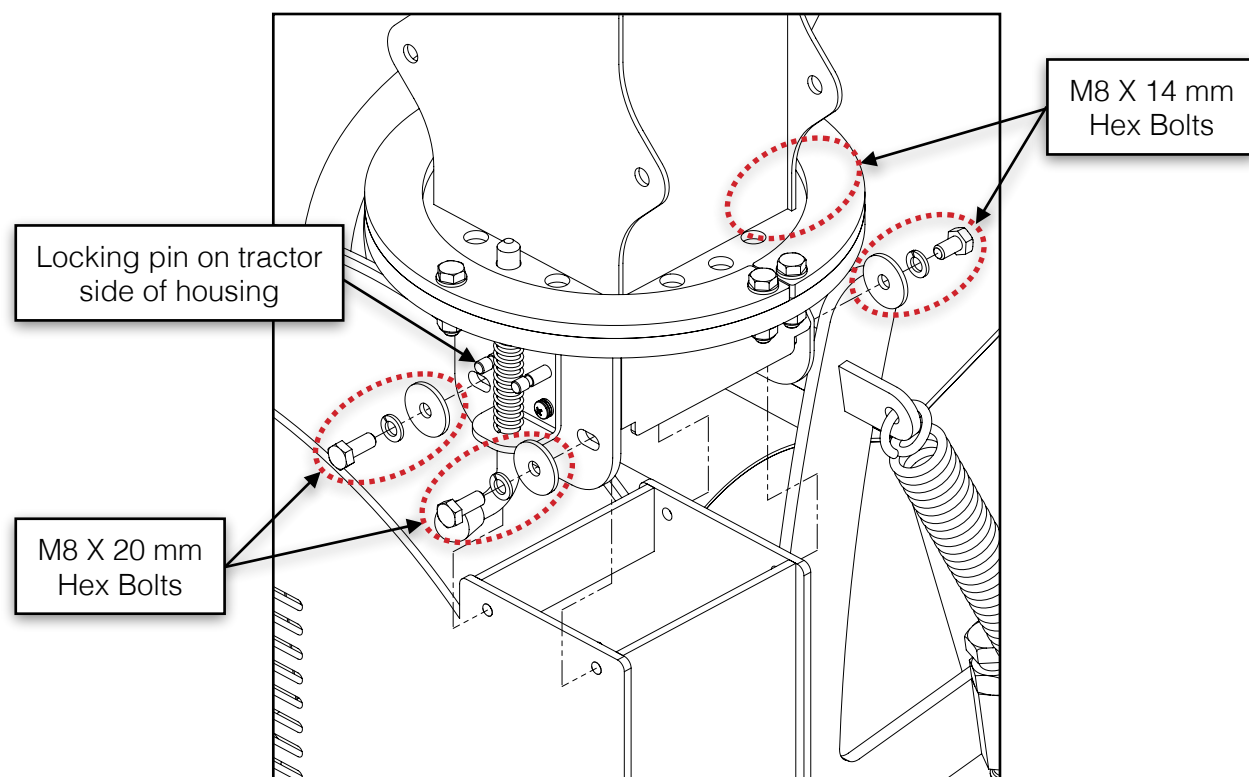
## 4. DISCHARGE CHUTE

The discharge chute assembly comes pre-assembled from the factory. With the hardware listed below, fasten the discharge chute assembly to the upper flywheel housing first and then assemble the handles to the discharge chute.

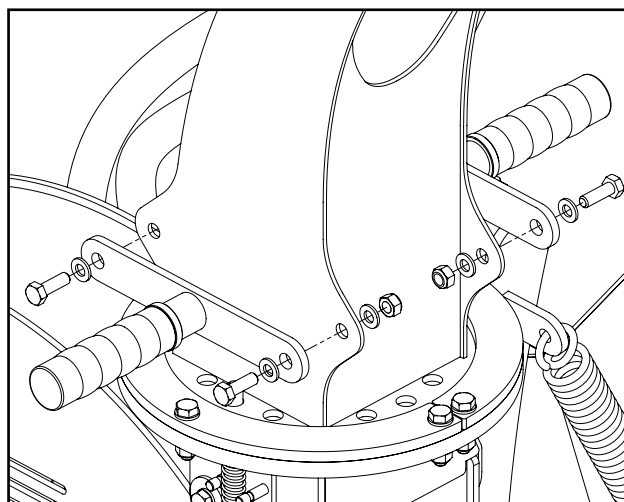
4x	M8 X 25 mm Hex Head Bolt		8x	M8 Flat Washer	
2x	M8 X 20 mm Hex Head Bolt		4x	M8 X 30 mm Fender Washer	
2x	M8 X 14 mm Hex Head Bolt		1x	Discharge Chute Assembly	
4x	M8 Lock Nut		2x	Discharge Chute Handle with Grip	
4x	M8 Lock Washer				

Connect the chute using two (2) M8 X 20 mm hex bolts, two (2) M8 X 14 mm hex bolts, four (4) M8 lock washers, and four (4) M8 X 30 mm fender washers as shown on the next page.

Note, when orienting the discharge chute on the upper flywheel housing, the locking pin side of the chute is assembled to the tractor side of the housing.



Assemble both handles to the chute using four (4) M8 X 25 mm hex bolts, eight (8) M8 flat washers, and four (4) M8 lock nuts.



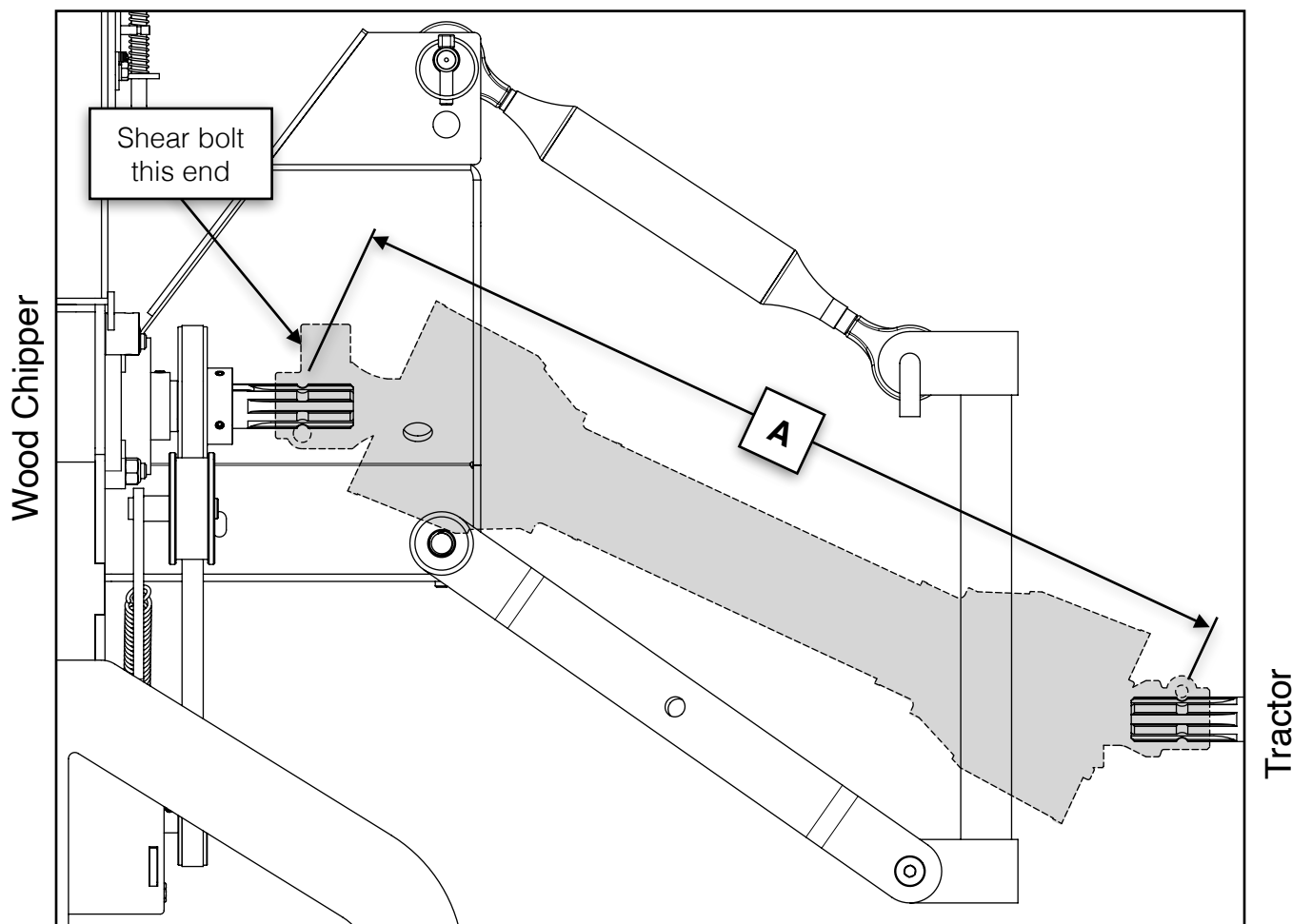
## TRIMMING THE PTO SHAFT

The wood chipper is shipped with a PTO shaft that can be fitted to most Category 1 tractors. The PTO shaft may need to be trimmed depending on your tractor and configuration. Follow the steps below to ensure the PTO shaft is correctly fitted to your tractor.

**\*\*Note: the shear bolt end of the PTO shaft mounts to the wood chipper.\*\***

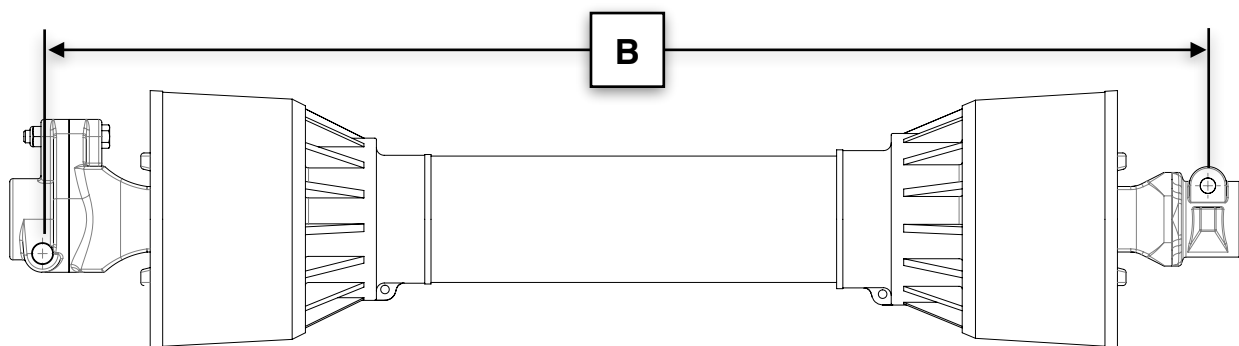
1. Attach the wood chipper to the tractor's 3-point hitch system. Do not install the PTO shaft.
2. Raise the wood chipper as high as the tractor's 3-point hitch will allow and measure the straight-line distance between the locking grooves on the splined shafts as shown below.

Now lower the wood chipper to the ground and measure the distance between the locking grooves again (the two shafts may or may not align—either is normal as tractor output shaft height varies). Whichever dimension is *shortest*, record it as **Dim A**.





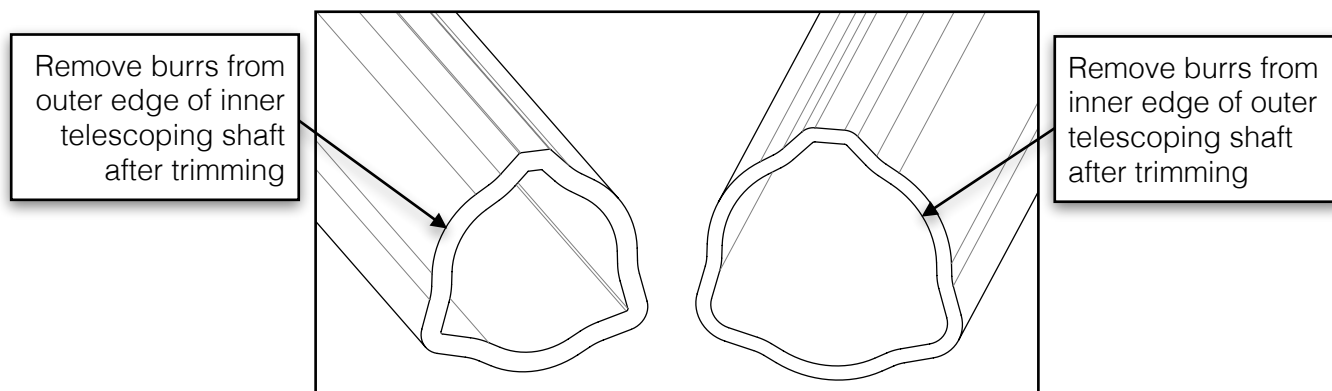
3. Verify the distance between the locking pins on the PTO shaft while in the compressed state (**Dim B**) as shown in the image below. It should measure 29-7/16 in [747 mm].



4. If **Dim A** is at least 1 in [25 mm] longer than **Dim B**, the PTO shaft does not require trimming. It is recommended the shaft not be used if there is less than 6 in [150 mm] of overlap between the two halves of the PTO shaft when the equipment is in the operating position.
5. If **Dim B** is longer than **Dim A**, the PTO shaft will require trimming. Use this equation to calculate the correct amount to trim:

$$(B - A) + 1 \text{ inch} = C \text{ (Amount to Trim)}$$

6. Once **C** has been calculated, trim that amount from **BOTH** halves of the PTO shaft safety cover *first*, then trim the same amount from both shafts. This will ensure the safety cover on each end remains a few inches back from the ends of the shafts, otherwise PTO shaft reassembly could be difficult.
7. After trimming both halves of the PTO shaft, use a file to remove any burrs or sharp edges and slide the halves back together, ensuring they telescope in-and-out freely. The PTO shaft is now ready to connect the wood chipper to the tractor for operation.






## OPERATION

### 1. PRE-START UP CHECKLIST

- i. Fill the hydraulic tank with hydraulic oil per the table below:

Model	Capacity		Hydraulic Oil
	Gallons (gal)	Litres (L)	
 WC46	4.5	17	ISO 32, ISO 46, AW 32, AW 46
WC68	5	18.9	
WC88	5	18.9	

- ii. Attach the wood chipper to your tractor and take the appropriate measurements to trim the PTO shaft. Refer to the "**TRIMMING THE PTO SHAFT**" section of the operator's manual for detailed instructions.

**\*\*Note: Failure to do so may result in severe damage to the implement and is not covered under warranty.\*\***

- iii. Ensure the bed plate gap is set to within 1/16—1/8 in [1.5—3 mm] between it and the blades. Refer to "**SETTING THE BED PLATE GAP**" in the operator's manual for detailed instructions.
- iv. The wood chipper has several bearings fitted with Zerk fittings for greasing. The PTO shaft is fitted with two (2) Zerk fittings, one on each yoke. The PTO shaft and all bearings come pre-greased and do not require greasing on initial start-up. Refer to the "**GREASING BEARINGS AND PTO SHAFT**" section of the operator's manual for detailed maintenance instructions.



## 2. START UP

The following steps in the sub-section below (a. through i.) are a summarization of the steps necessary to safely and properly operate the wood chipper. Please follow the references to other sections that provide further detail into the step being performed.

- a. Place the tractor transmission in neutral, set the parking brake, then turn the tractor engine off.
- b. Connect the 3-point hitch linkages to the wood chipper and secure them with linch pins.
- c. Adjust the top link of the 3-point hitch so that the wood chipper sits level.
- d. Connect the PTO shaft to the tractor with the shear bolt end of the PTO on the wood chipper. Make sure the PTO safety chains are attached to both the tractor and the wood chipper to keep the protective PTO safety cover from rotating.
- e. Rotate the discharge chute towards a safe direction and lock it in place with the spring-loaded latch and indexing holes. Adjust the chip deflector to the desired position based on how far they should be thrown.
- f. Push the red control arm all the way in until it stops, then pull it out one click to ensure the infeed roller is in the neutral position.
- g. Start the tractor engine and hold the engine RPM's at a strong idle. Engage the PTO slowly. If the tractor is running at a high speed when the PTO is engaged, you could damage the hydraulic pump belt or break the shear bolt on the PTO shaft. After the rotor is spinning freely increase the tractor RPM's until the PTO speed is 540 RPM. Most tractor tachometers commonly indicate this with a line and/or text.
- h. Pull the red control arm all the way out until it stops (forward position). This will start the infeed roller rotating. Set the infeed roller control to the desired speed.
- i. With the wood chipper now running and the infeed roller rotating, it is safe to begin chipping. Start by feeding smaller diameter branches until better acquainted with the machine and its operation. Once comfortable, begin feeding in larger pieces. Adjust the infeed roller control as necessary to regulate the infeed rate of the branches.

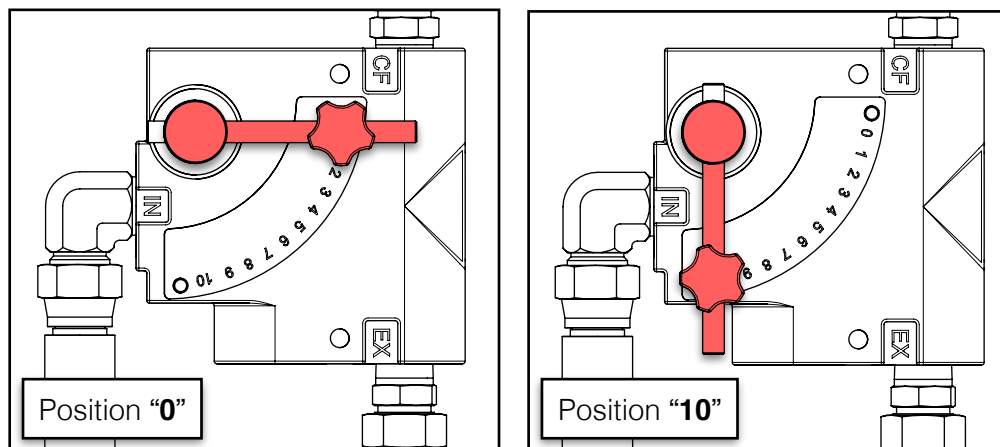


### WARNING!

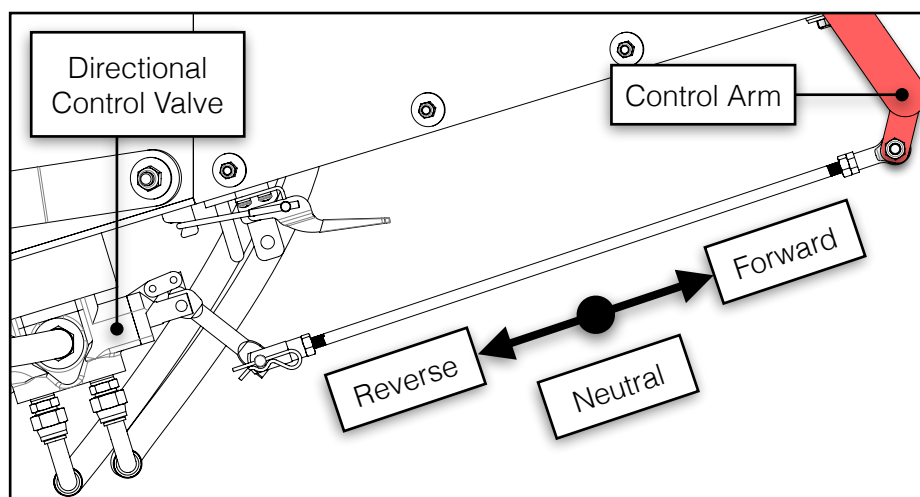
To avoid serious injury or death, do not chip brush containing embedded foreign objects such as nails, wire, metal fragments, etc. The operator and any assistants must always stay clear of the infeed chute of the wood chipper whenever it is running.

### 3. INFEEED ROLLER CONTROL

The wood chipper infeed roller speed control valve is located to the right of the infeed chute. Rotating the arm as shown in the pictures below will increase or decrease the speed of the infeed roller. The number “0” (left image) represents no infeed roller rotation while “10” (right image) represents full speed.



The infeed roller can be set to three (3) different rotation settings—*forward*, *neutral* and *reverse*—by pushing or pulling the red control arm. The *forward* position pulls branches into the wood chipper; *neutral* stops the roller from rotating; and *reverse* pushes the branches back out the wood chipper towards the operator. The diagram below illustrates the 3 positions:

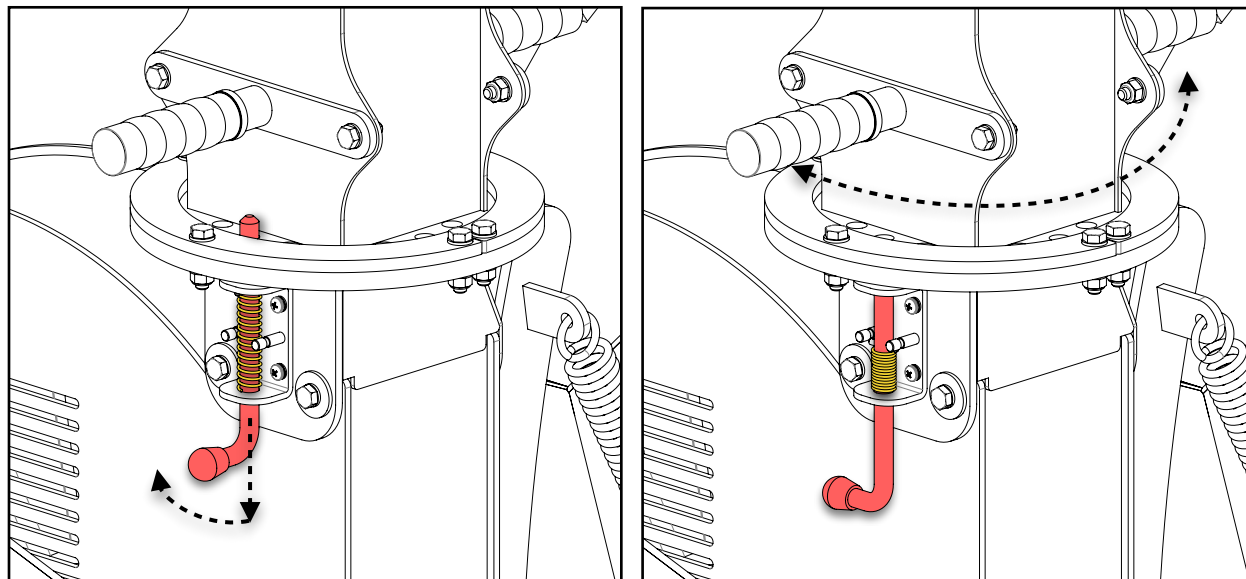


To change the speed of the infeed roller, place the red control arm in the *neutral* position. This stops the infeed roller from rotating. The speed control valve can now be moved to the desired position/speed. Reengage the infeed roller via the control arm.

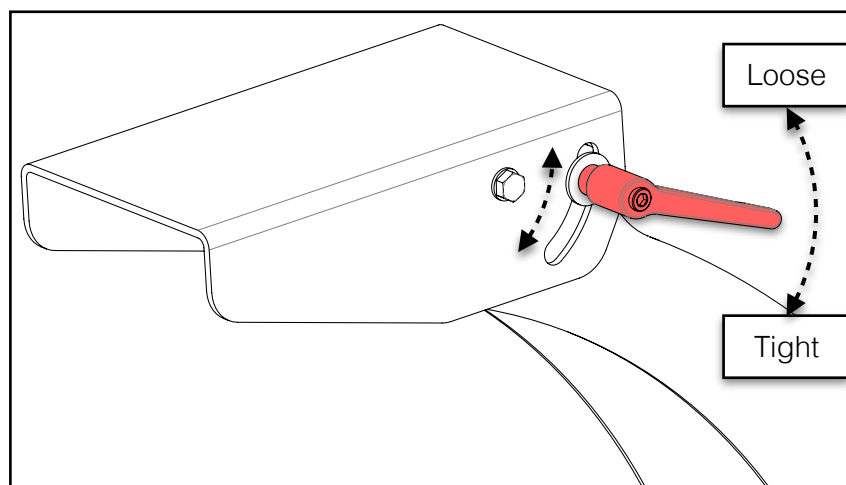
See maintenance section, **ADJUSTING THE RED CONTROL ARM**, if the control arm feels too loose or stiff, or if it falls into neutral or reverse unexpectedly.

## 4. DISCHARGE CHUTE

To rotate the discharge chute, push down all the way on the spring-loaded locking pin and twist it 90° to temporarily lock it in the open position. The discharge chute is now free to rotate a full 360°. Using the handles, rotate it to the desired position and then twist the locking pin back 90° so that it extends into the closest locking hole to secure the chute in position.



The chip deflector easily adjusts to regulate the distance the chips are thrown. Rotate the handle counterclockwise to loosen the deflector, adjust the deflector to the desired angle, then re-tighten the handle by rotating it clockwise to secure the deflector.





## 5. CHIPPING

Keep your face and body away from the feed opening. Do not over reach. Keep proper balance and footing at all times. The wood chipper is designed to chip a variety of materials into a more readily decomposing or handled condition. The following guidelines can be used to help you get started. Please read and follow all safety instructions in this manual. Failure to operate the wood chipper in accordance with the safety instructions **MAY RESULT IN PERSONAL INJURY!**

- Ensure the wood chipper is at full operating speed before starting to chip material.
- Select limbs up to 4" (102 mm) in diameter. Trim side branches that cannot be bent enough to feed into the wood chipper infeed chute. Hold small diameter branches in a bundle and feed simultaneously.
- Feed brush from the side of the infeed chute rather than from the front. Step aside to avoid being hit by brush moving into the wood chipper.
- Never lean into the infeed chute or extend any parts of your body inside the infeed chute to push objects further into the wood chipper. Use another stick or branch.
- Do not use hand tools to push brush into the wood chipper. They can go through the wood chipper and cause injury or damage to the wood chipper.
- Place branches, butt end first, into the wood chipper infeed chute until it contacts the infeed roller. Once the infeed roller makes contact with the branches, it will pull the material inwards.
- **NOTE:** The wood chipper blades dull with use and require periodic sharpening and sometimes replacing. Refer to the section under service and maintenance, "Sharpening Wood Chipper Blades," for further instructions.

## 6. STOPPING

Do not leave the wood chipper unattended or attempt any inspection/service unless the PTO is disengaged and the tractor engine is turned off. Allow time for the wood chipper to come to a complete stop. To stop the wood chipper, follow the steps below:

1. Move the tractor throttle to the SLOW/IDLE position.
2. Disengage the PTO lever and turn off the tractor engine.
3. Allow time for the wood chipper to come to a complete stop.

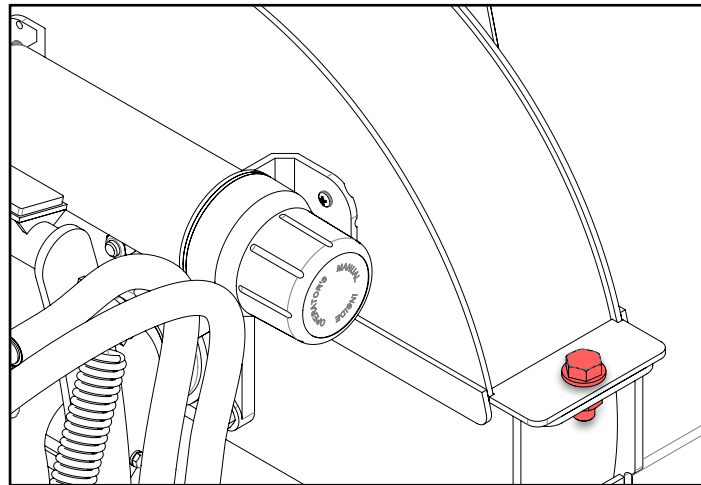
**NOTE:** The flywheel continues to spin for some time after the engine or tractor has been turned off. The flywheel has stopped spinning when noise and/or machine vibration are no longer detectable. The PTO shaft will also no longer be spinning.

## MAINTENANCE

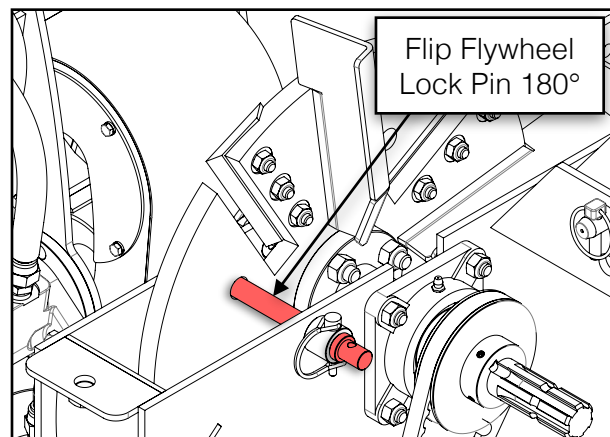
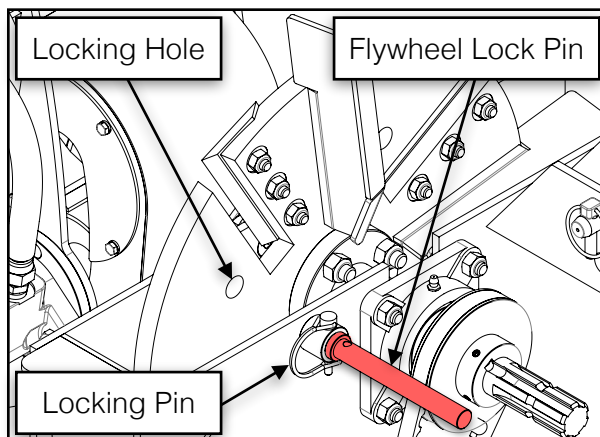
### REPLACING BLADES

Follow these steps when replacing blades. The WC46 wood chipper uses four (4) reversible hardened steel blades. Each blade is 5.71 X 2.72 X 5/16" (145 X 69 X 8 mm) in size.

1. If installed, disconnect the PTO shaft from the tractor for safety.
2. Open the upper flywheel housing using a 24 mm socket/wrench by removing the M16 X 40 mm bolt and flat washer securing the upper and lower housings together.

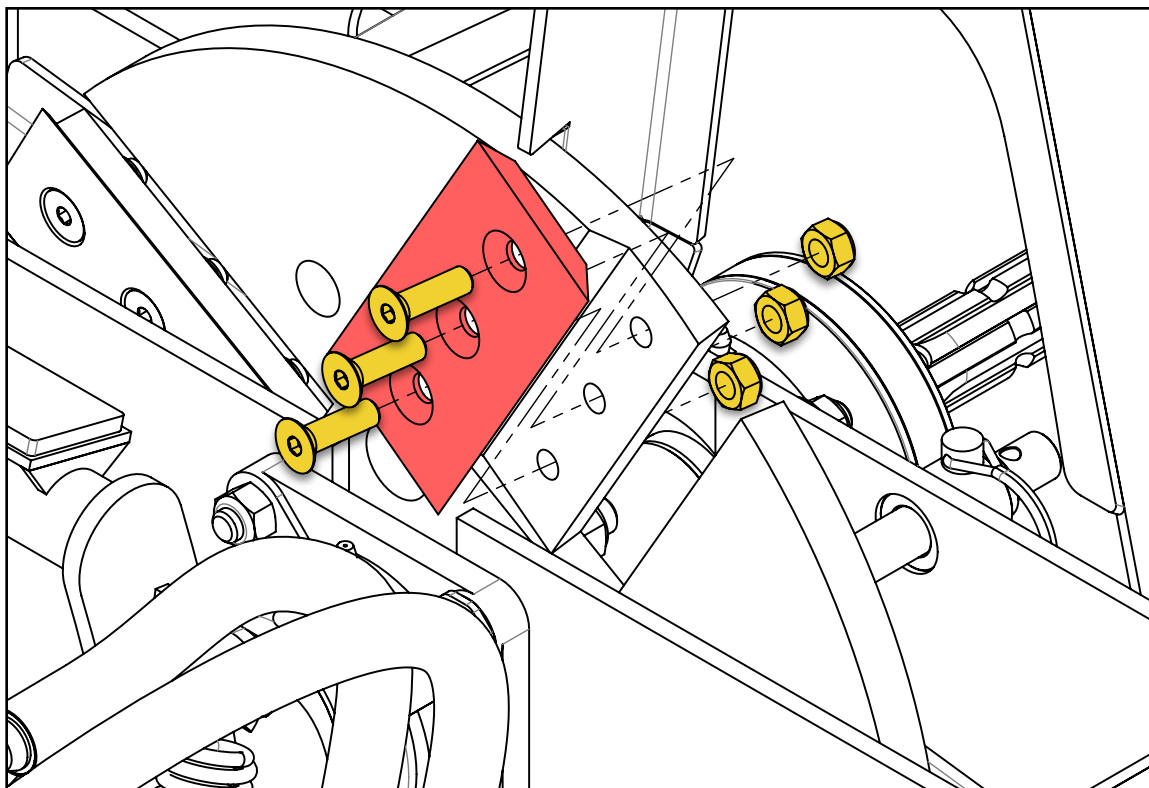


3. With the flywheel exposed, manually rotate it so that one of the four (4) locking holes in the flywheel (near the front of the blade) approximately lines up with the flywheel lock pin at the rear of the housing. Remove the small locking pin from the flywheel lock pin and flip the flywheel lock pin around 180°, passing it through the housing and into the locking hole in the flywheel. Reinstall the smaller locking pin to the flywheel lock pin.



**Belt/pulley shroud removed from images for clarity.**

4. Remove the three (3) M10 X 35 mm flat head bolts and M10 lock nuts that fasten the blade to the flywheel using a 6 mm hex key on the bolts and a 17 mm socket/wrench on the lock nuts. Take care not to drop the hardware into the lower flywheel housing. However, should this occur, a telescoping pen magnet can be used to retrieve them.



5. Repeat Steps 3 & 4 above to remove the remaining three blades. If this is the first time the blades have been removed following either the original wood chipper purchase or a recent blade sharpening, the blades can be reversed to utilize the other cutting edge. Or, the entire blade can be removed and sharpened or it can be replaced with a new blade. Torque the M10 X 35 mm flat head bolts to 40-45 ft•lb (54-60 N•m) when installing blades. Always replace the M10 lock nuts with a new set when changing or reversing blades. Refer to section, **Blade Sharpening** for blade sharpening instructions.
6. Once the blades have been reversed or new blades installed, proceed to section, **Setting the Bed Plate Gap**, to properly set the spacing between the blades and bed plate.

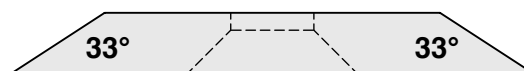




## BLADE SHARPENING

The wood chipper blades will dull, making chipping difficult and cause your tractor to labour. It is recommended to sharpen the blades every 25-50 hours of operation. The WC46 wood chipper uses four (4) hardened steel blades. The blades are reversible and can be sharpened on both sides. Follow the below steps to sharpen the blades.

1. Follow the steps from the previous section, **Replacing Blades**, to safely remove the blades from the flywheel.
2. Hand-grind the angled edges of the blade at 33° (see diagram below) using a whetstone or have them sharpened by a professional. A pedestal style bench grinder will likely yield poor results if not used properly. If sharpened quickly or aggressively on a bench grinder, the blade edge can get too hot and change colour, thus removing the heat treating-properties from the steel. Use short grinding times and cool frequently with water. Remove an equal and consistent amount of material from each blade to maintain proper balance when reassembled to the flywheel.

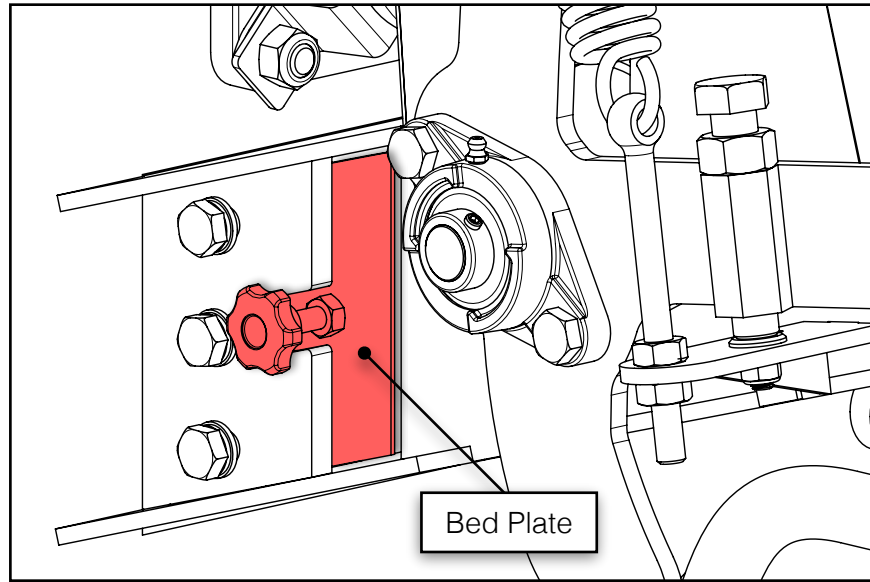


**Blade Profile**

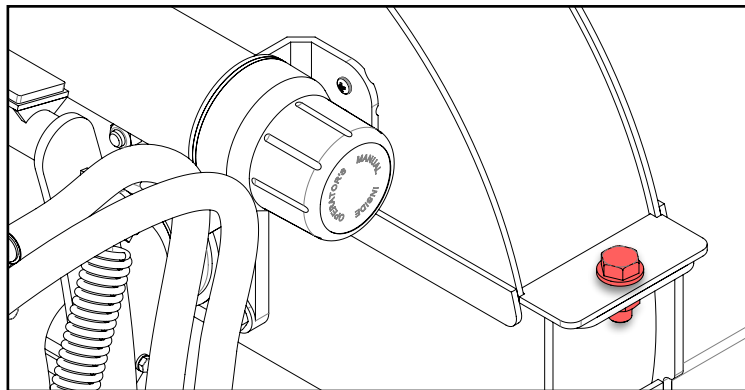
3. Reinstall the sharpened blades on the flywheel and torque the M10 X 35 mm flat head bolts to 40-45 ft•lb (54-60 N•m). Always replace the lock nuts with new hardware when changing or reversing the blades.
4. Once the blades have been sharpened, proceed to the next section, **Setting the Bed Plate Gap**, to properly set the spacing between the newly sharpened blades and the bed plate.

## SETTING THE BED PLATE GAP

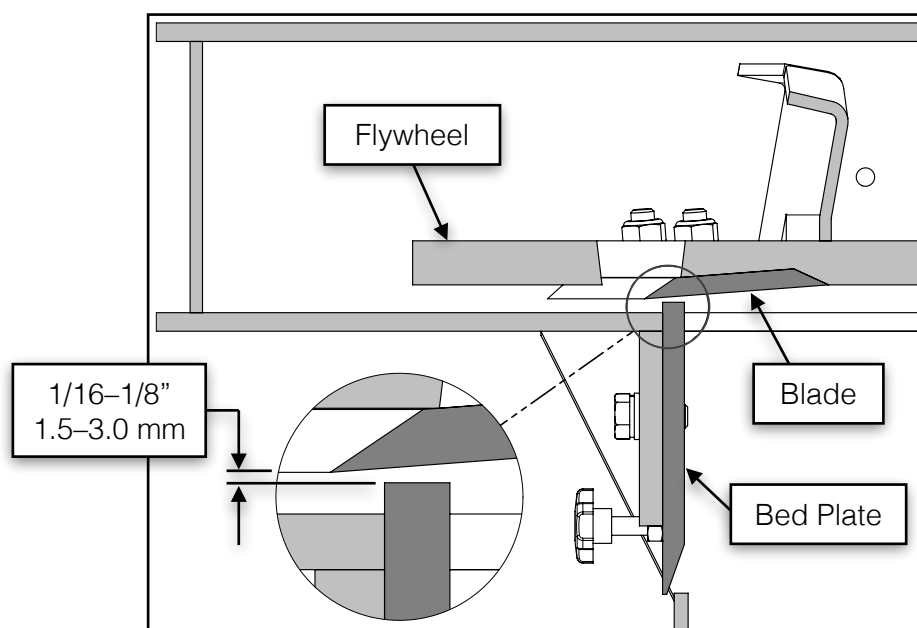
The bed plate (also known as the *anvil plate*) is located on the left side of the flywheel housing (when facing the infeed chute). For ideal chipping performance, the gap between the bed plate and the blades should be set to 1/16-1/8" (1.5-3 mm). Follow the steps below to set the gap properly. Failure to set the proper gap can lead to poor chipping performance and/or clogging.



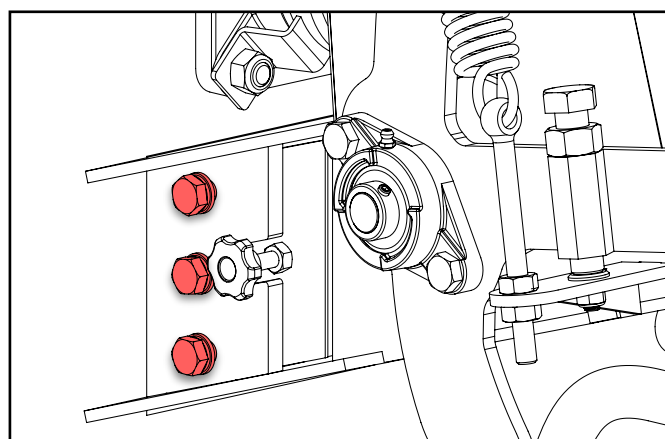
1. If installed, disconnect the PTO shaft from the tractor for safety.
2. Open the upper flywheel housing using a 24 mm socket/wrench by removing the M16 X 40 mm bolt and flat washer securing the upper and lower housings together.



3. With the flywheel exposed, manually rotate it so that the first blade lines up with the bed plate and note the gap between them. Use a flash light for better viewing if necessary. Repeat this process for the remaining three blades, noting which blade is closest. Use this blade to set the bed plate gap.



4. Loosen the three (3) M10 X 25 mm hex bolts securing the bed plate to the lower flywheel housing so the bed plate is free to slide in and out. This movement will increase or decrease the gap between the bed plate and the cutting edge of the blade. Slide the bed plate by gripping the knob and adjust its position so that it is within 1/16-1/8" (1.5-3.0 mm) of the cutting edge of the blade. Ensure the gap is uniform along the entire edge of the blade.

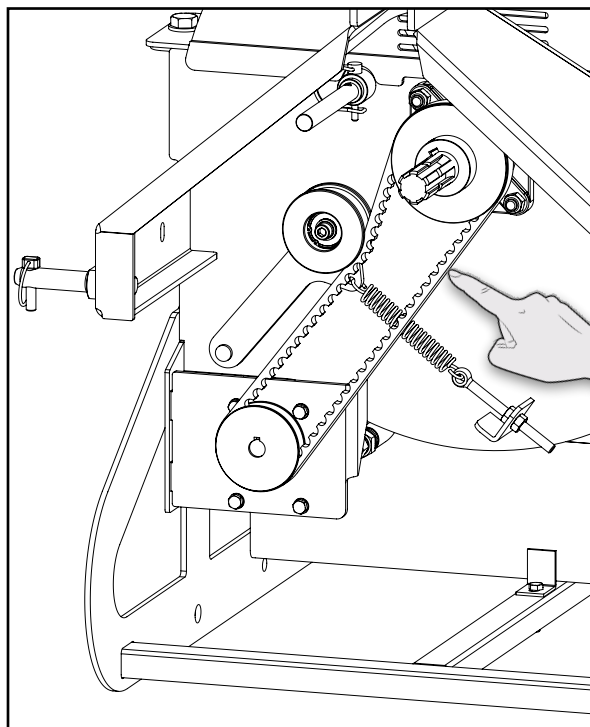


5. Torque the three (3) M10 X 25 mm bed plate hex bolts to 40 ft•lb (54 N•m) once the gap has been set correctly.
6. Rotate the flywheel by hand and note the gap at each blade. Again, the gap should be no more or less than 1/16-1/8" (1.5-3.0 mm) at each blade edge.
7. Close the upper flywheel housing and secure it to the lower housing by reinstalling the M16 X 40 mm bolt and flat washer.

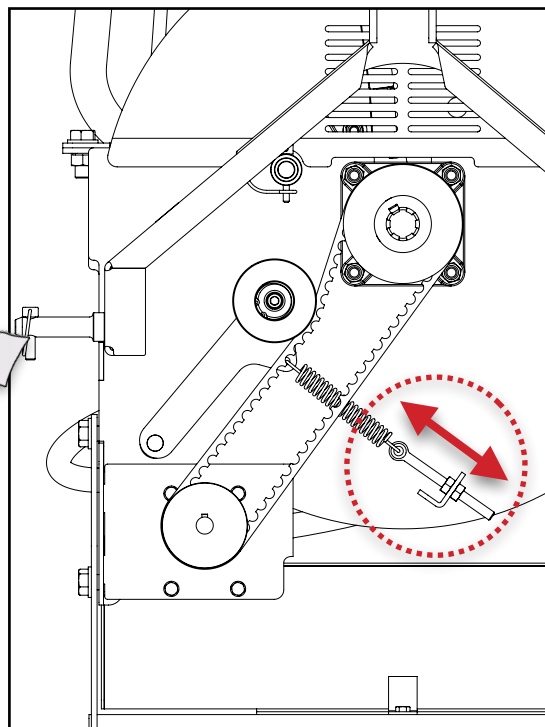
## ADJUSTING THE HYDRAULIC PUMP BELT TENSION

Check the condition and tension of the hydraulic pump belt after every 30 hours of operation. The belt is self-tensioning via an extension spring. The amount of tension can be adjusted by following these steps:

1. If installed, disconnect the PTO shaft from the wood chipper for safety and to allow rotation of the belt and pulleys.
2. Check the belt tension by pressing on it with your finger (see “*Checking Belt Tension*” below). There should not be any free slack in the belt. It should be under firm tension.
3. If the belt requires more tension, the eyebolt connected to the spring can be adjusted by moving the M8 hex nuts (see “*Adjusting Belt Tension*” below). This will stretch the spring and increase the belt tension until the proper tension is achieved.



**Checking Belt Tension**

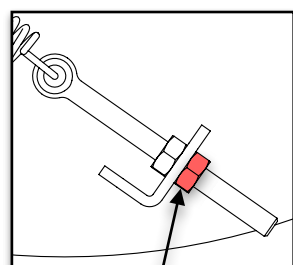


**Adjusting Belt Tension**

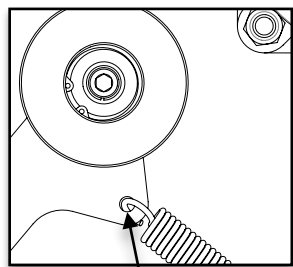
## REPLACING THE HYDRAULIC PUMP BELT

Check the condition and tension of the hydraulic pump belt after every 30 hours of operation. If the infeed roller is not rotating, or it is rotating slowly, the belt could be slipping. A squealing noise may also be heard. In either case, these conditions can occur due to a worn belt or improper belt tension (see the previous section, **Adjusting the Hydraulic Pump Belt Tension**). To replace a worn belt, follow the steps below:

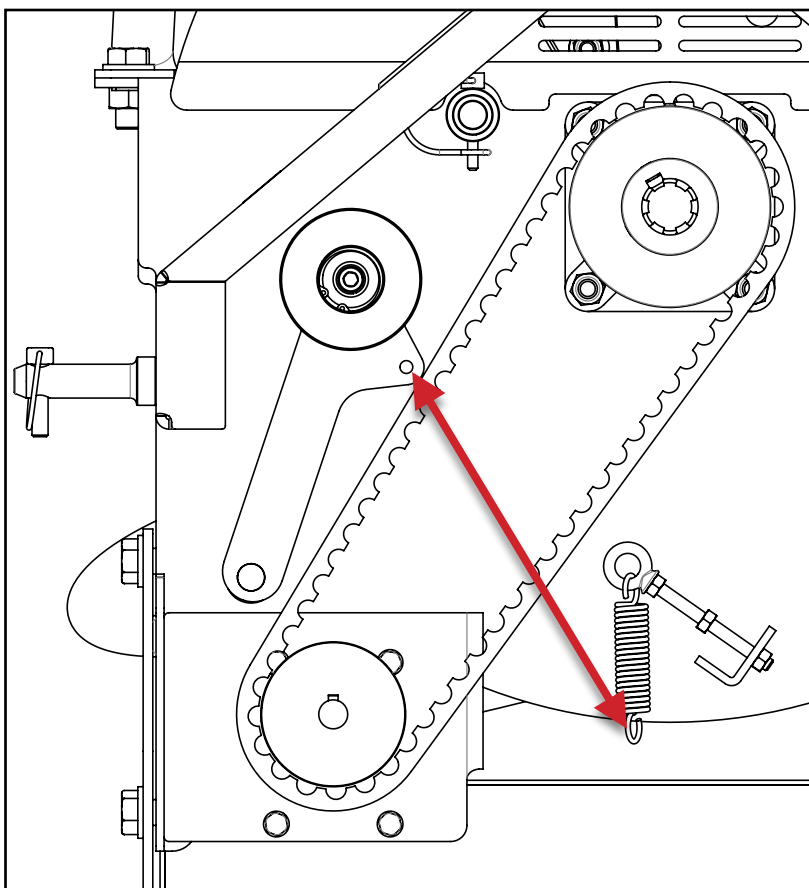
1. If installed, disconnect the PTO shaft from the wood chipper for safety.
2. Loosen the lower M8 hex nut that secures the eyebolt to the steel bracket until sufficient tension has been removed from the spring allowing it to be unhooked from the belt tensioner. The belt tensioner can now be swung up out of the way allowing for removal of the belt from the pulleys.



Loosen lower  
M8 hex nut



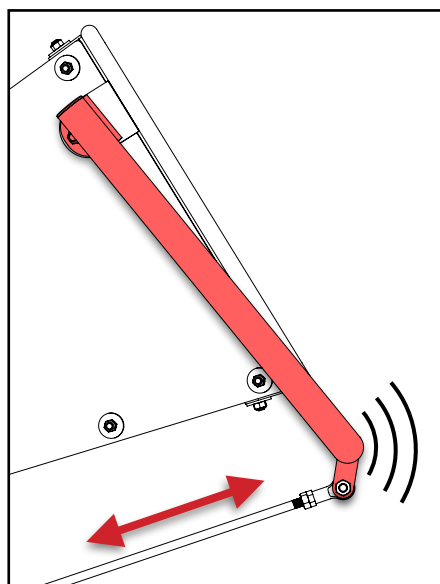
Unhook spring from  
belt tensioner once  
sufficiently loose



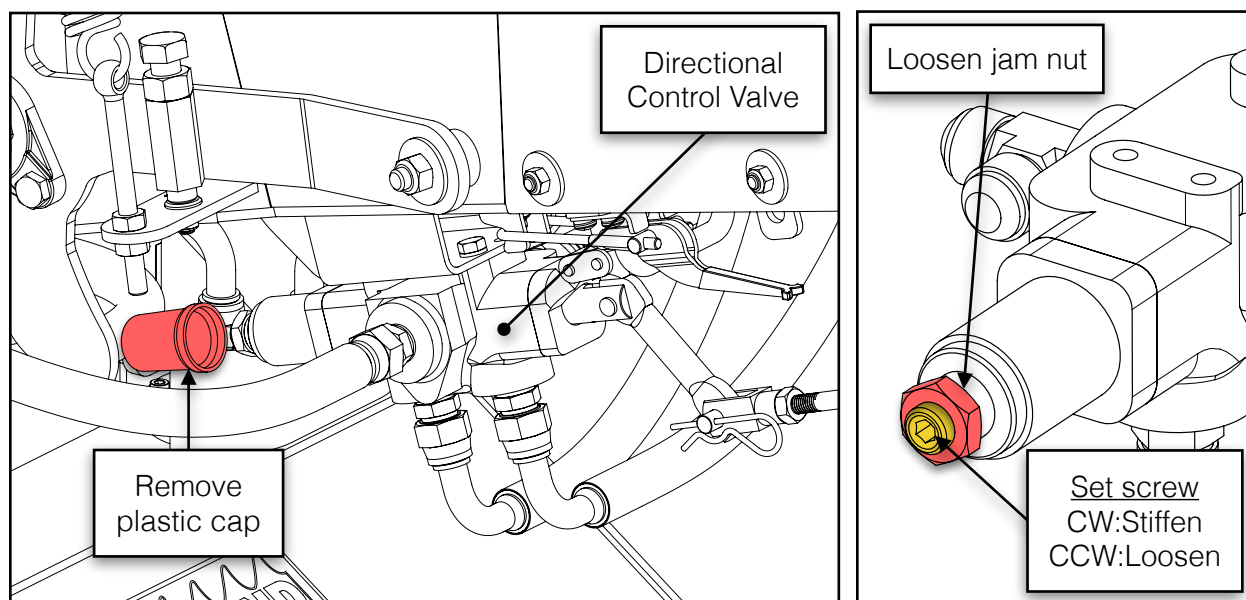
3. Install the new belt around the pulleys first and then reinstall the spring. Re-tension the spring by tightening the lower M8 hex nut on the eyebolt. Refer to the previous section, **Adjusting the Hydraulic Pump Belt Tension**, for instructions on how to properly re-tension the belt.

## ADJUSTING THE RED CONTROL ARM

If the movement of the red control arm feels too stiff or too loose, or if it falls into neutral or reverse unexpectedly, it can be adjusted via the directional control valve.



Unscrew the plastic cap from the back of the directional control valve (located under the infeed chute), exposing the jam nut and set screw.

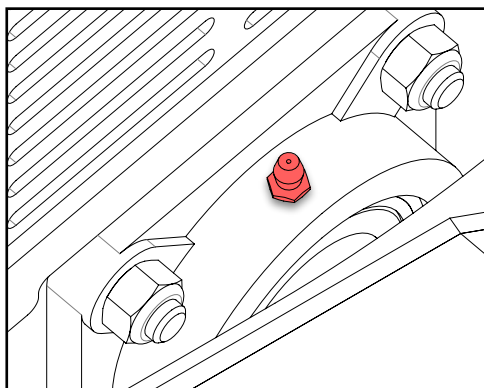


Loosen the jam nut with a 22 mm [ $\frac{7}{8}$  in] wrench. Use a 6 mm hex key and turn the set screw **clockwise to stiffen** the movement of the arm, **counter-clockwise to loosen** it. Tighten the jam nut and replace the cap after the control arm movement feels satisfactory.

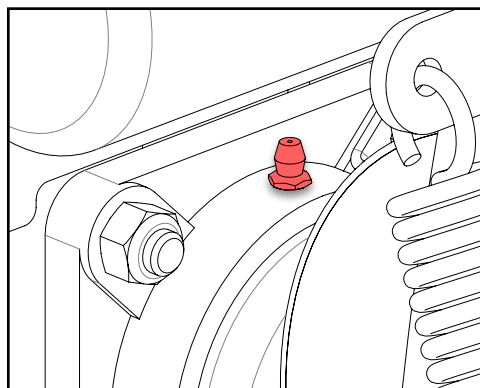
## GREASING BEARINGS AND PTO SHAFT

The wood chipper has six (6) grease points: two (2) flywheel bearings, one (1) infeed roller bearing, and three (3) on the PTO shaft. Check each grease point prior to use and add grease as needed.

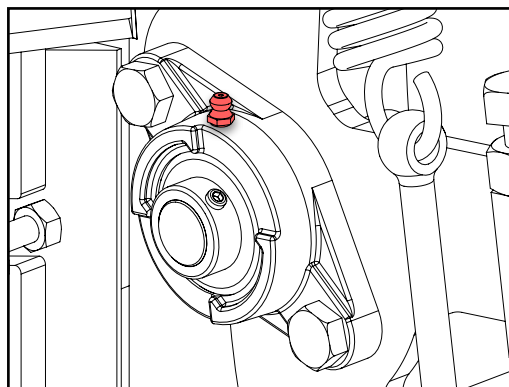
***\*\*Warning: These grease points come pre-greased from the factory. Do not add grease to these points on a new wood chipper. Over-greasing can damage the bearing seals.\*\****



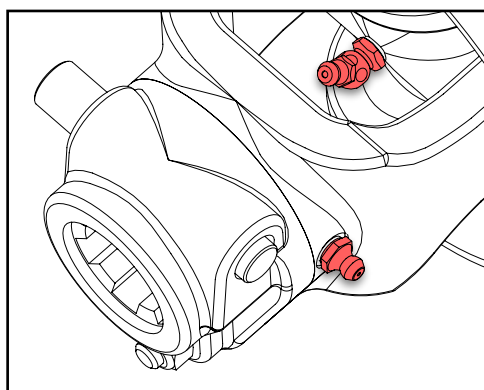
**Front Flywheel Shaft Bearing**



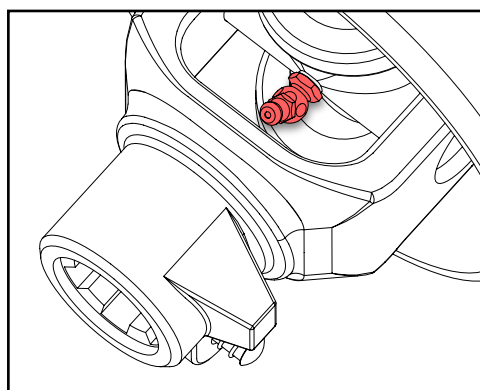
**Rear Flywheel Shaft Bearing**



**Infeed Roller Bearing**



**PTO Shaft U-Joint 1**

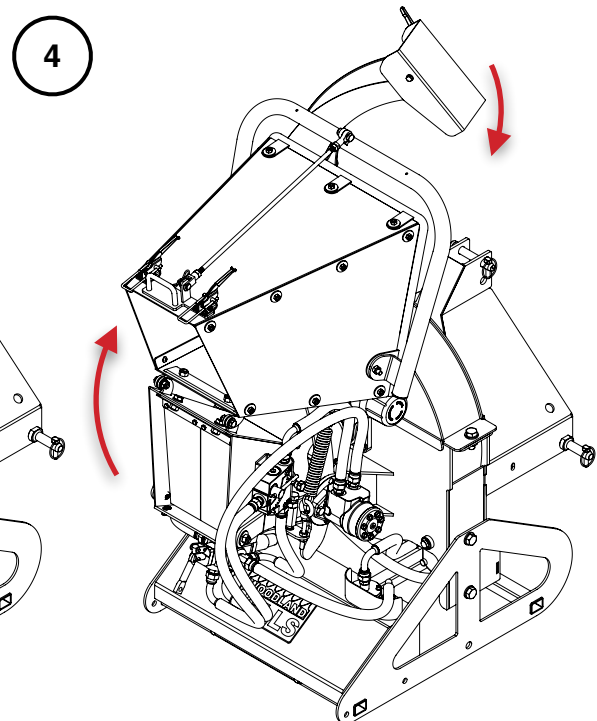
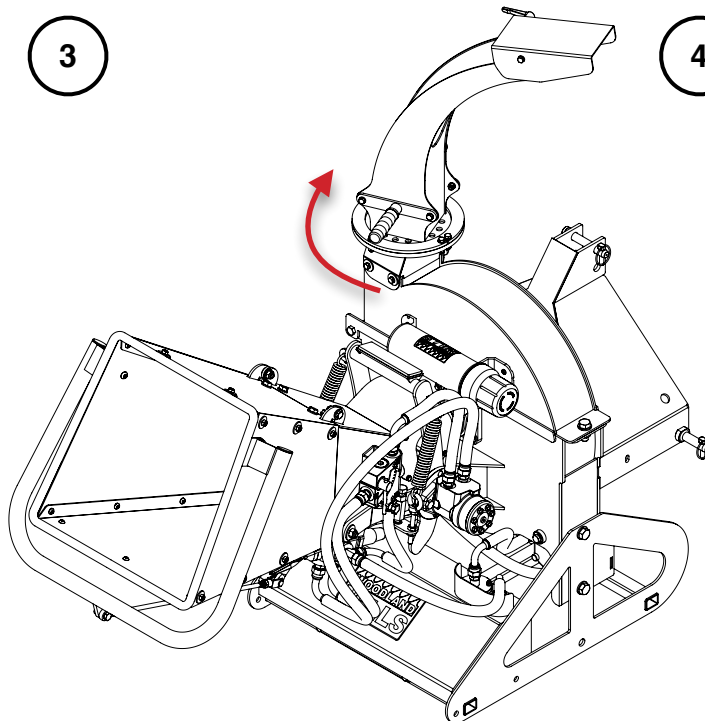
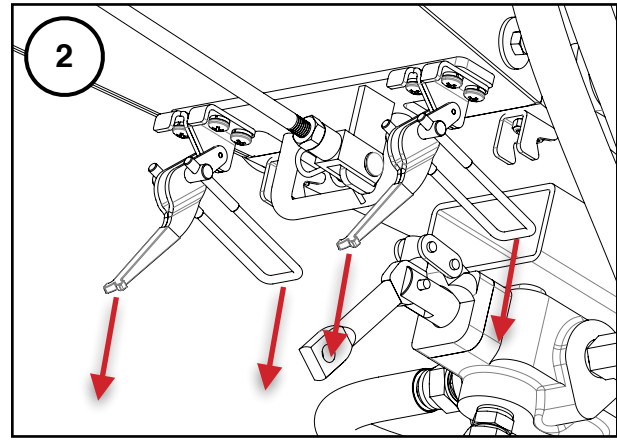
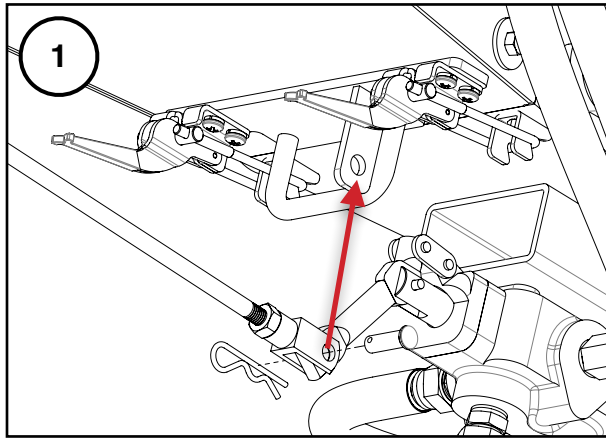


**PTO Shaft U-Joint 2**

## STORAGE

When the wood chipper is not in use, it can be stored to utilize a smaller footprint to save space. Follow these steps to put the wood chipper in its storage state:

1. Disconnect the control bar linkage from the directional control valve and reconnect it to the tab on the underside of the infeed chute bottom panel.
2. Disengage the two (2) latches on the underside of the infeed chute bottom panel.
3. Rotate the discharge chute so that it is angled towards the left side of the machine.
4. Swing the infeed chute up until it is resting on the swingarm. Tilt the deflector down.







## TROUBLESHOOTING

Problem/Issue	Possible Causes	Resolution Options
Brush is feeding too slowly	<ol style="list-style-type: none"> <li>1. Infeed roller control set too low.</li> <li>2. PTO RPM below 540.</li> <li>3. Blades are dull.</li> <li>4. Improper bed plate gap.</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase infeed roller control to a higher value. Refer to <a href="#">page 30</a>.</li> <li>2. Adjust tractor RPMs to 540 at output.</li> <li>3. Reverse, sharpen, or replace blades. Refer to <a href="#">page 33</a> &amp; <a href="#">page 35</a>.</li> <li>4. Re-set bed plate gap. Refer to <a href="#">page 36</a>.</li> </ol>
Brush exiting discharge chute is stringy	<ol style="list-style-type: none"> <li>1. Blades are dull.</li> <li>2. Brush is excessively sappy.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reverse, sharpen, or replace blades. Refer to <a href="#">page 33</a> &amp; <a href="#">page 35</a>.</li> <li>2. Clean blades and bed plate.</li> </ol>
Excessive clogging	<ol style="list-style-type: none"> <li>1. Blades are dull.</li> <li>2. Improper bed plate gap.</li> <li>3. PTO RPM below 540.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reverse, sharpen, or replace blades. Refer to <a href="#">page 33</a> &amp; <a href="#">page 35</a>.</li> <li>2. Re-set bed plate gap. Refer to <a href="#">page 36</a>.</li> <li>3. Clean blades and bed plate.</li> <li>4. Adjust tractor RPMs to 540 at output.</li> </ol>
Hydraulic pump belt slipping or squeaking	<ol style="list-style-type: none"> <li>1. Belt tension not set properly.</li> <li>2. Belt is old/worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust belt tension. Refer to <a href="#">page 38</a>.</li> <li>2. Replace belt. Refer to <a href="#">page 39</a>.</li> </ol>
Excessive noise coming from flywheel bearings	<ol style="list-style-type: none"> <li>1. Bearings not sufficiently lubricated.</li> <li>2. Bearings are worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Grease bearings. Refer to <a href="#">page 41</a>.</li> <li>2. Replace bearings. Please contact Woodland Mills for bearing replacement instructions.</li> </ol>
Red control arm falls into neutral or reverse	<ol style="list-style-type: none"> <li>1. Directional control valve not adjusted properly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust directional control valve set screw. Refer to <a href="#">page 40</a>.</li> </ol>



## PARTS LIST

Item	Qty	Part No.	Description
1	1	0001740	BASE
2	1	0001739	HYDRAULIC TANK, 17 L [4.5 gal]
3	1	0001164	HYDRAULIC TANK INTAKE LINE
4	1	0001752	HYDRAULIC INTAKE FILTER, 1/2 NPT
5	1	0004841	O-RING, 50 mm ID / 57 mm OD, 3.5 mm THK
6	1	0005188	OIL SCREEN, 50 mm DIA X 120 mm LG SCREEN
7	1	0005183	OIL SCREEN CAP, 85 mm DIA, M48 X 2 THD
8	1	0005187	GASKET, OIL SCREEN, 55 mm ID
9	1	0005186	GASKET, OIL SCREEN CAP, 48 mm ID
10	1	0005185	RETAINING RING, INTERNAL, 46 mm BORE (48.5 mm GROOVE)
11	1	0001747	LOWER FLYWHEEL HOUSING
12	1	0001711	INNER HINGE, INFEED CHUTE
13	1	0001726	CURTAIN BRACKET
14	2	0001727	CURTAIN
15	1	0001728	CURTAIN PLATE
16	1	0001715	SWINGARM
17	2	0001182	SWINGARM PIVOT BUSHING, 15 mm SHOULDER
18	2	0001732	EXTENSION SPRING, HOOK ENDS, 33 mm OD, 5 mm DIA WIRE, 180 mm LG
19	1	0001179	HYDRAULIC MOTOR ADAPTER PLATE, 6205-2RS BEARING
20	1	0004861	HYDRAULIC MOTOR
21	1	0004846	PARALLEL KEY, 8 X 7 mm, 25 mm LG
22	1	0001717	INFEED ROLLER
23	1	0001729	INFEED ROLLER COVER PLATE
24	1	0001730	BED PLATE, 126 X 103.6 X 9.4 mm
25	1	0001191	KNOB, MULTI-LOBE, 32 mm OD, M8 X 1.25, 30 mm LG, M8 WLD HEX NUT
26	2	0001733	STRIKE PLATE BOLT, 20 mm HEAD DIA, M8 X 1.25 THD
27	2	0001738	3-POINT HITCH PIN, LOWER, M20 X 2.5, 21 mm DIA, 60 mm USEABLE LG
28	1	0001156	3-POINT HITCH PIN, UPPER, 19 mm DIA, 90 mm USEABLE LG
29	3	0004705	LINCH PIN, 10 mm DIA, 38 mm USEABLE LG
30	1	0001744	FLYWHEEL
31	4	0001735	FLYWHEEL BLADE, 145 X 69 X 8 mm
32	1	0001745	FLYWHEEL SHAFT
33	4	0001734	SPACER, 40.6 ID X 46 OD X 1.5 mm THK
34	1	0004849	PARALLEL KEY, 10 X 8 mm, 40 mm LG
35	1	0001736	V-BELT PULLEY, 35 mm SHAFT, 125 mm DIA
36	1	0001731	FLYWHEEL SHAFT COVER, UCFU208 BEARING
37	1	0001795	FLYWHEEL SHAFT COVER PLUG
38	1	0001746	FLYWHEEL LOCK PIN
39	1	0004728	LOCKING PIN, ROUND, 1/4 in DIA, 1-3/8 in USEABLE LG
40	1	0001743	BELT TENSIONER ARM
41	2	0004789	CIRCLIP, 16-24 mm SHAFT (15 mm GROOVE)
42	1	0001692	IDLER PULLEY, SINGLE BEARING, 25 mm WD, 80 mm DIA
43	1	0004816	RETAINING RING, INTERNAL, 40 mm BORE (42.5 mm GROOVE)
44	1	0001192	EXTENSION SPRING, HOOK ENDS, 21 mm OD, 3 mm DIA WIRE, 100 mm LG
45	1	0004869	HYDRAULIC GEAR PUMP, 10 mL/r, KEYED SHAFT
46	1	0004845	PARALLEL KEY, 6 X 6 mm, 32 mm LG
47	1	0001737	V-BELT PULLEY, 18 mm SHAFT, 90 mm DIA
48	1	0004872	DIRECTIONAL CONTROL VALVE

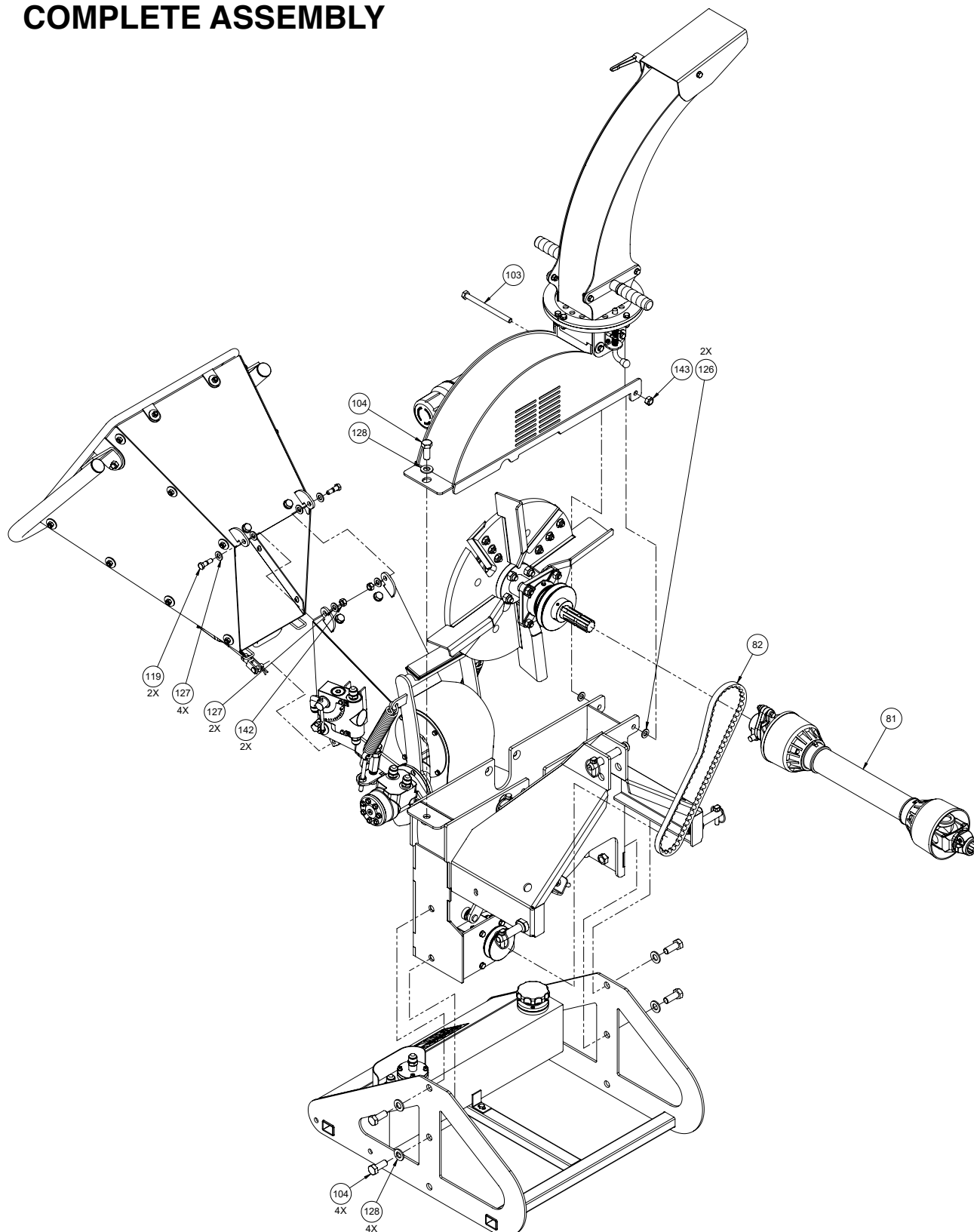


Item	Qty	Part No.	Description
49	1	0004875	VARIABLE FLOW CONTROL VALVE, 1/2 in NPT, 0-16 gal/min
50	2	0001304	LATCH-STYLE TOGGLE CLAMP
51	1	0001714	INFEED CHUTE TOP PANEL
52	1	0001716	OUTER HINGE, INFEED CHUTE
53	2	0001712	INFEED CHUTE SIDE PANEL
54	1	0001713	INFEED CHUTE BOTTOM PANEL
55	1	0001723	ROUND EDGE BAR, INFEED CHUTE
56	1	0001724	CONTROL ARM, INFEED ROLLER
57	2	0001781	PLASTIC END CAP, 38 mm DIA
58	1	0001725	LINKAGE ROD, INFEED ROLLER
59	1	0004834	CLEVIS ROD END, M10 X 1.5 THD, 10 mm ID, 10 mm JAW OPENING
60	1	0004749	CLEVIS PIN, 10 mm DIA, 24 mm USABLE LG, 30 mm LG
61	1	0004760	HAIRPIN COTTER PIN, 10-16 mm CLEVIS, 3 mm WIRE DIA
62	1	0004888	ROD END BEARING, 10 mm, M10 X 1.5 FEM THD
63	1	0001742	UPPER FLYWHEEL HOUSING
64	1	0001741	DISCHARGE CHUTE NOZZLE
65	1	0001172	DISCHARGE CHUTE LOCK PIN ASSEMBLY, 12 mm DIA
66	1	0001722	DISCHARGE CHUTE
67	2	0001720	DISCHARGE CHUTE RETAINER PLATE
68	2	0001718	DISCHARGE CHUTE ROTATION HANDLE
69	2	0001030	HANDLE GRIP, GROOVED, 26 mm ID, 108 mm LG
70	1	0001721	DISCHARGE CHUTE DEFLECTOR
71	1	0001786	ADJUSTABLE HANDLE, 78 X 54 mm, M10 X 1.5
72	1	0001655	MANUAL TUBE
73	8	0005124	FITTING, ADAPTER, 1/2 in NPT MALE TO 7/8-14 UNF MALE
74	3	0005115	FITTING, ELBOW, 90°, 1/2 NPT TO 7/8-14 THD
75	1	0004911	FITTING, TEE, 1/2 NPT TO 7/8-14 (2X)
76	3	0003297	HYDRAULIC LINE ASSEMBLY, STR AND ELB FITTINGS, 350 mm LG
77	1	0003298	HYDRAULIC LINE ASSEMBLY, STR AND ELB FITTINGS, 500 mm LG
78	1	0003300	HYDRAULIC LINE ASSEMBLY, STR AND ELB FITTINGS, 600 mm LG
79	1	0003302	HYDRAULIC LINE ASSEMBLY, STR FITTINGS, 1000 mm LG
80	1	0003303	HYDRAULIC LINE ASSEMBLY, STR AND ELB FITTINGS, 1450 mm LG
81	1	0001761	PTO SHAFT W/ SHEAR BOLT, TRIMMABLE, 31-38 in (790-973 mm)
81.1	1	0003069	COVER/RETAINING CLIP KIT, PTO SHAFT W/ SHEAR BOLT
81.2	1	0003073	RETAINING CLIP KIT, PTO SHAFT W/ SHEAR BOLT
81.3	1	HDW	HEX BOLT, M8 X 1.25, 50 mm LG, 22 mm LG THD
81.4	1	HDW	LOCK NUT, M8 X 1.25
82	1	BX41	V-BELT, COGGED, BX41
83	1	6203-2RS	BALL BEARING, SEALED, 6203-2RS, 17 mm BORE, 40 mm OD, 12 mm WIDE
84	1	6205-2RS	BALL BEARING, SEALED, 6205-2RS, 25 mm BORE, 52 mm OD, 15 mm WIDE
85	2	UCF208	FLANGE BEARING, SQ, 4-BOLT, UCF208, 40 mm BORE, 102 mm C-C
86	1	UCFL204	FLANGE BEARING, OVAL, 2-BOLT, UCFL204, 20 mm BORE, 90 mm C-C
87	4	HDW	HEX BOLT, M6 X 1, 10 mm LG
88	4	HDW	HEX BOLT, M6 X 1, 20 mm LG
89	2	HDW	HEX BOLT, M6 X 1, 60 mm LG, 18 mm LG THD
90	2	HDW	HEX BOLT, M8 X 1.25, 14 mm LG
91	2	HDW	HEX BOLT, M8 X 1.25, 16 mm LG
92	4	HDW	HEX BOLT, M8 X 1.25, 20 mm LG
93	4	HDW	HEX BOLT, M8 X 1.25, 25 mm LG
94	6	HDW	HEX BOLT, M8 X 1.25, 35 mm LG
95	4	HDW	HEX BOLT, M8 X 1.25, 40 mm LG

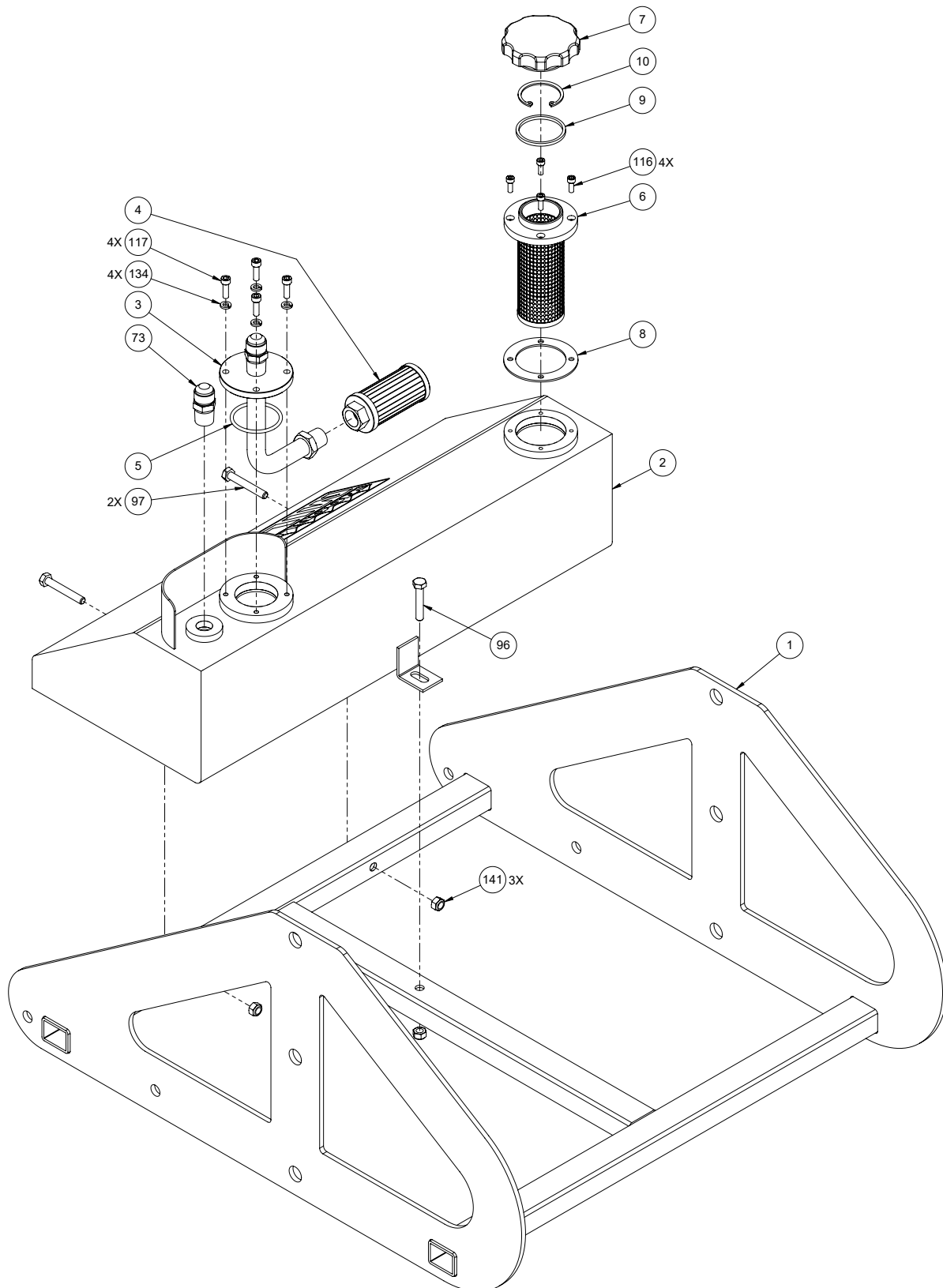


Item	Qty	Part No.	Description
96	1	HDW	HEX BOLT, M8 X 1.25, 45 mm LG
97	2	HDW	HEX BOLT, M8 X 1.25, 55 mm LG, 22 mm LG THD
98	3	HDW	HEX BOLT, M10 X 1.5, 25 mm LG
99	3	HDW	HEX BOLT, M10 X 1.5, 35 mm LG
100	2	HDW	HEX BOLT, M12 X 1.75, 25 mm LG
101	2	HDW	HEX BOLT, M12 X 1.75, 30 mm LG
102	2	HDW	HEX BOLT, M12 X 1.75, 50 mm LG
103	1	HDW	HEX BOLT, M12 X 1.75, 160 mm LG, 30 mm LG THD
104	5	HDW	HEX BOLT, M16 X 2, 40 mm LG
105	2	HDW	HEX BOLT, M16 X 2, 80 mm LG, 38 mm LG THD
106	3	HDW	EYEBOLT, DIN444, M10 X 1.5, 120 mm LG
107	19	HDW	BUTTON HEAD SCREW, M8 X 1.25, 18 mm LG
108	2	HDW	BUTTON HEAD SCREW, M10 X 1.5, 35 mm LG
109	2	HDW	BUTTON HEAD SCREW, M12 X 1.75, 50 mm LG
110	4	HDW	SCREW, PPH, M5 X 0.8, 14 mm LG
111	11	HDW	SCREW, PPH, M6 X 1, 10 mm LG
112	4	HDW	SCREW, PPH, M6 X 1, 16 mm LG
113	12	HDW	SCREW, HFH, M10 X 1.5, 35 mm LG, CL 10.9
114	8	HDW	SCREW, HFH, M12 X 1.75, 40 mm LG
115	4	HDW	SCREW, HFH, M14 X 2, 60 mm LG
116	4	HDW	SHCS, M5 X 0.8, 14 mm LG
117	4	HDW	SHCS, M6 X 1, 20 mm LG
118	1	HDW	SHCS, M10 X 1.5, 25 mm LG
119	2	HDW	SHLDR SCREW, HEX HEAD, 11 X 15 mm LG SHLDR, M10 X 1.5 X 20 mm LG THD
120	2	HDW	SET SCREW, FLAT TIP, M6 X 1, 6 mm LG
121	1	HDW	SET SCREW, FLAT TIP, M6 X 1, 8 mm LG
122	4	HDW	SET SCREW, FLAT TIP, M8 X 1.25, 10 mm LG
123	4	HDW	FLAT WASHER, M5
124	28	HDW	FLAT WASHER, M8
125	3	HDW	FLAT WASHER, DIN7349, M10, 4 mm THK
126	6	HDW	FLAT WASHER, M12
127	6	HDW	FLAT WASHER, M12, 25.1 mm OD, NYLON
128	5	HDW	FLAT WASHER, M16
129	23	HDW	FENDER WASHER, M8, 30 mm OD
130	1	HDW	FENDER WASHER, M10, 22 mm OD
131	3	HDW	FENDER WASHER, M10, 26 mm OD
132	2	HDW	FENDER WASHER, M12, 37 mm OD
133	4	HDW	SPLIT LOCK WASHER, M5
134	16	HDW	SPLIT LOCK WASHER, M6
135	6	HDW	SPLIT LOCK WASHER, M8
136	4	HDW	SPLIT LOCK WASHER, M10
137	1	HDW	HEX NUT, M10 X 1.25
138	7	HDW	HEX NUT, M10 X 1.5
139	2	HDW	HEX NUT, M16 X 2
140	10	HDW	LOCK NUT, M6 X 1
141	36	HDW	LOCK NUT, M8 X 1.25
142	19	HDW	LOCK NUT, M10 X 1.5
143	17	HDW	LOCK NUT, M12 X 1.75
144	4	HDW	LOCK NUT, M14 X 2
145	2	HDW	LOCK NUT, M20 X 2.5
146	4	HDW	LOCK NUT, FLANGED, M8 X 1.25

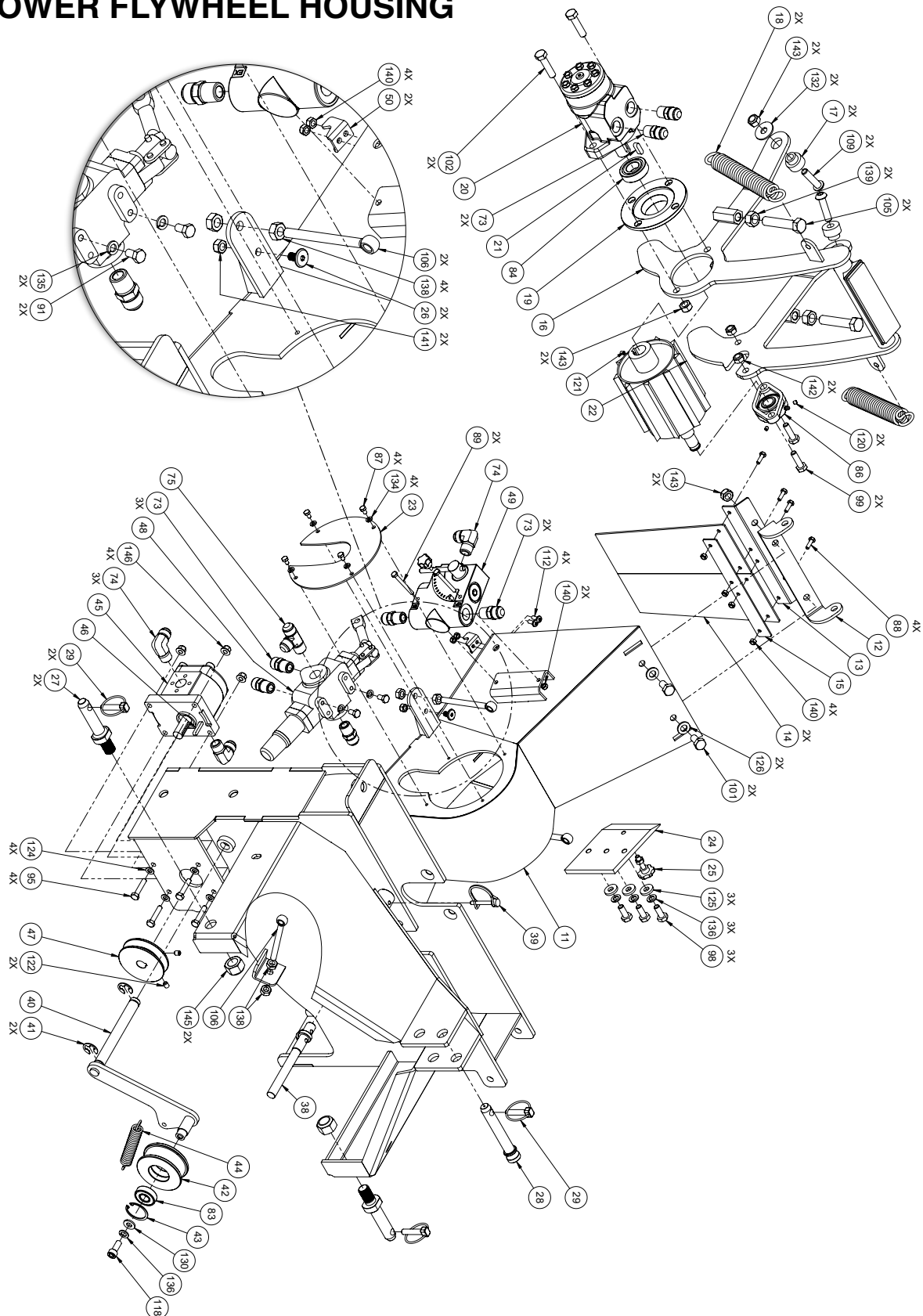
## EXPLODED ASSEMBLY VIEWS COMPLETE ASSEMBLY



## BASE

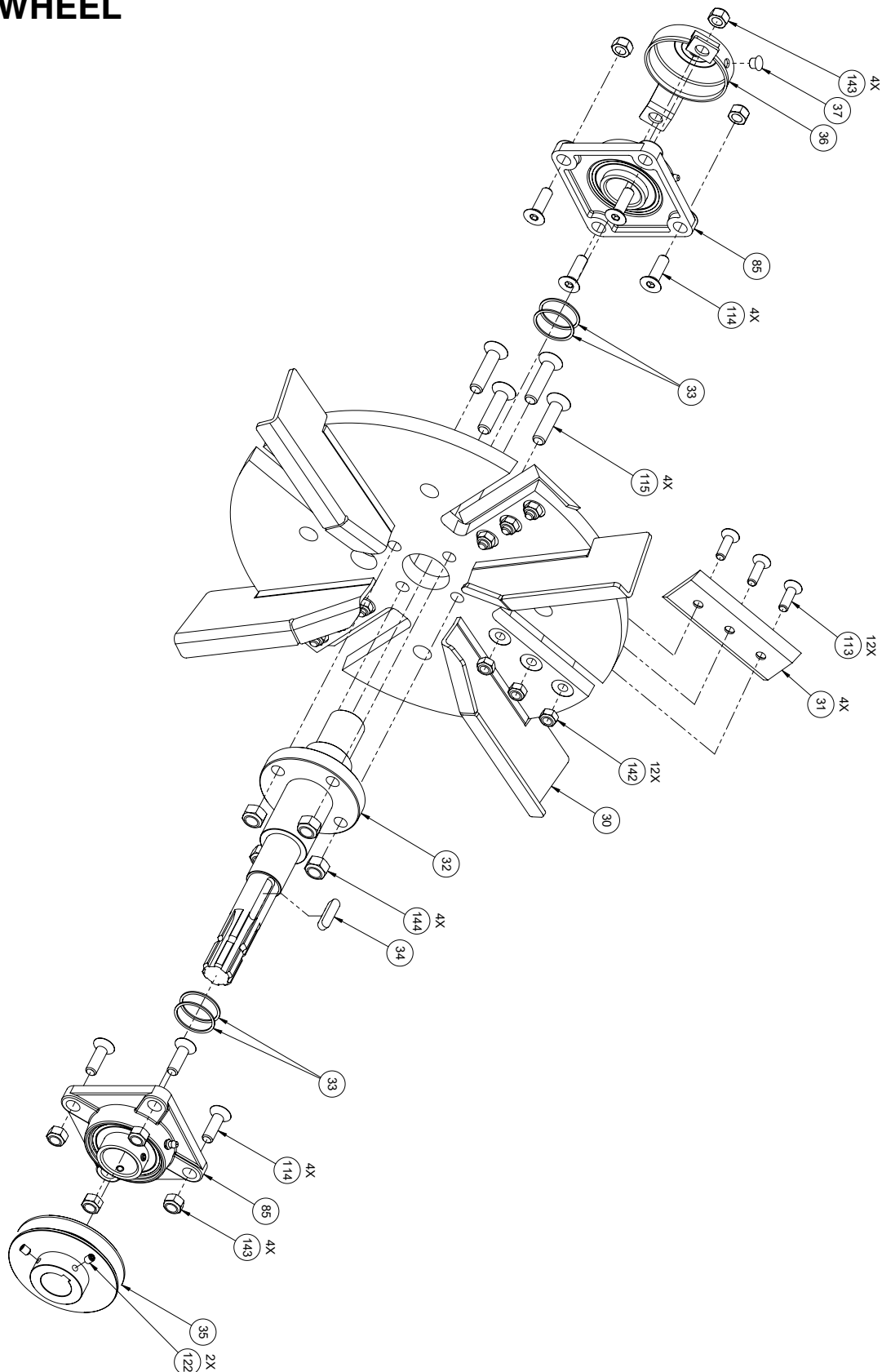


# LOWER FLYWHEEL HOUSING



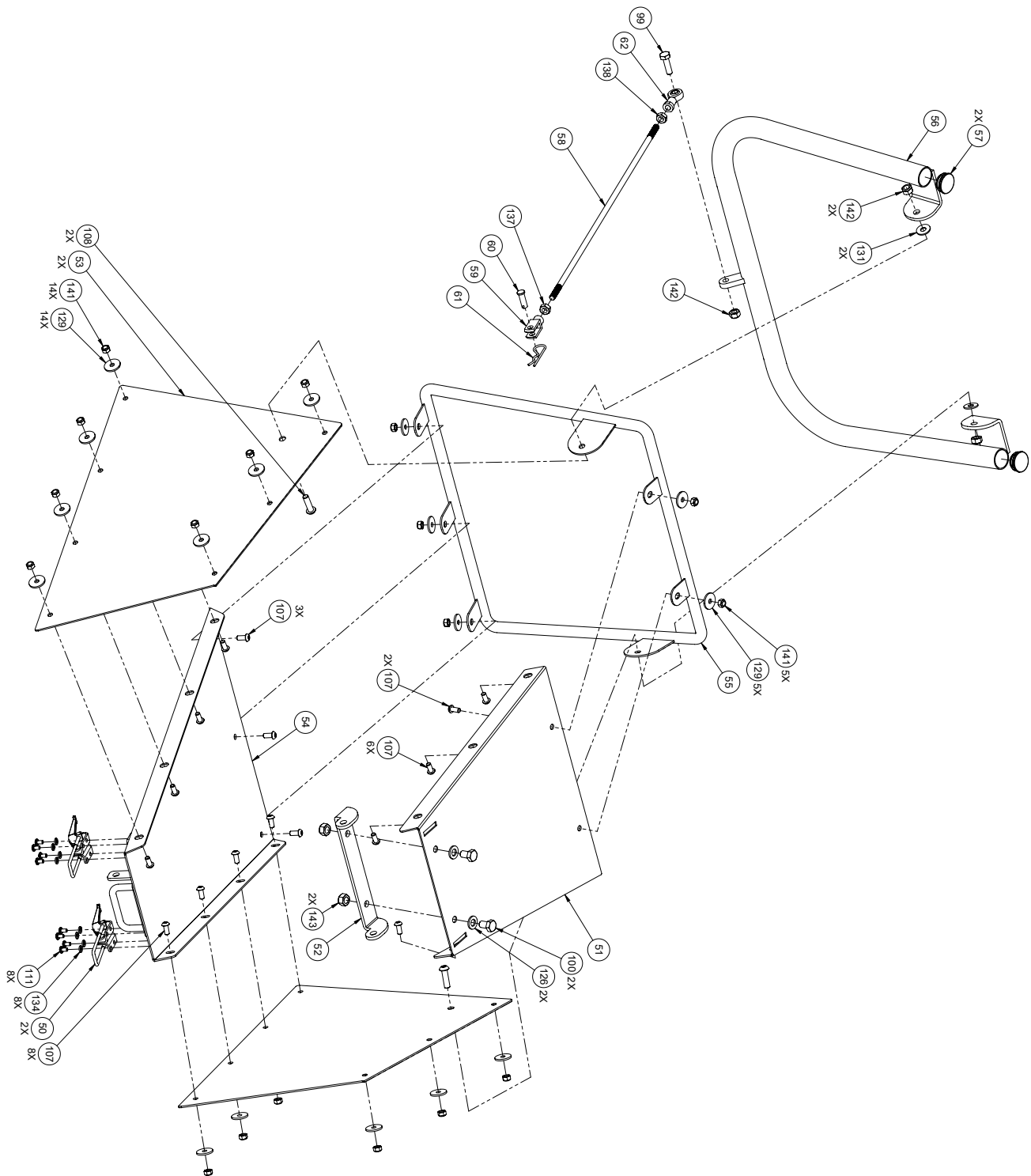


# FLYWHEEL

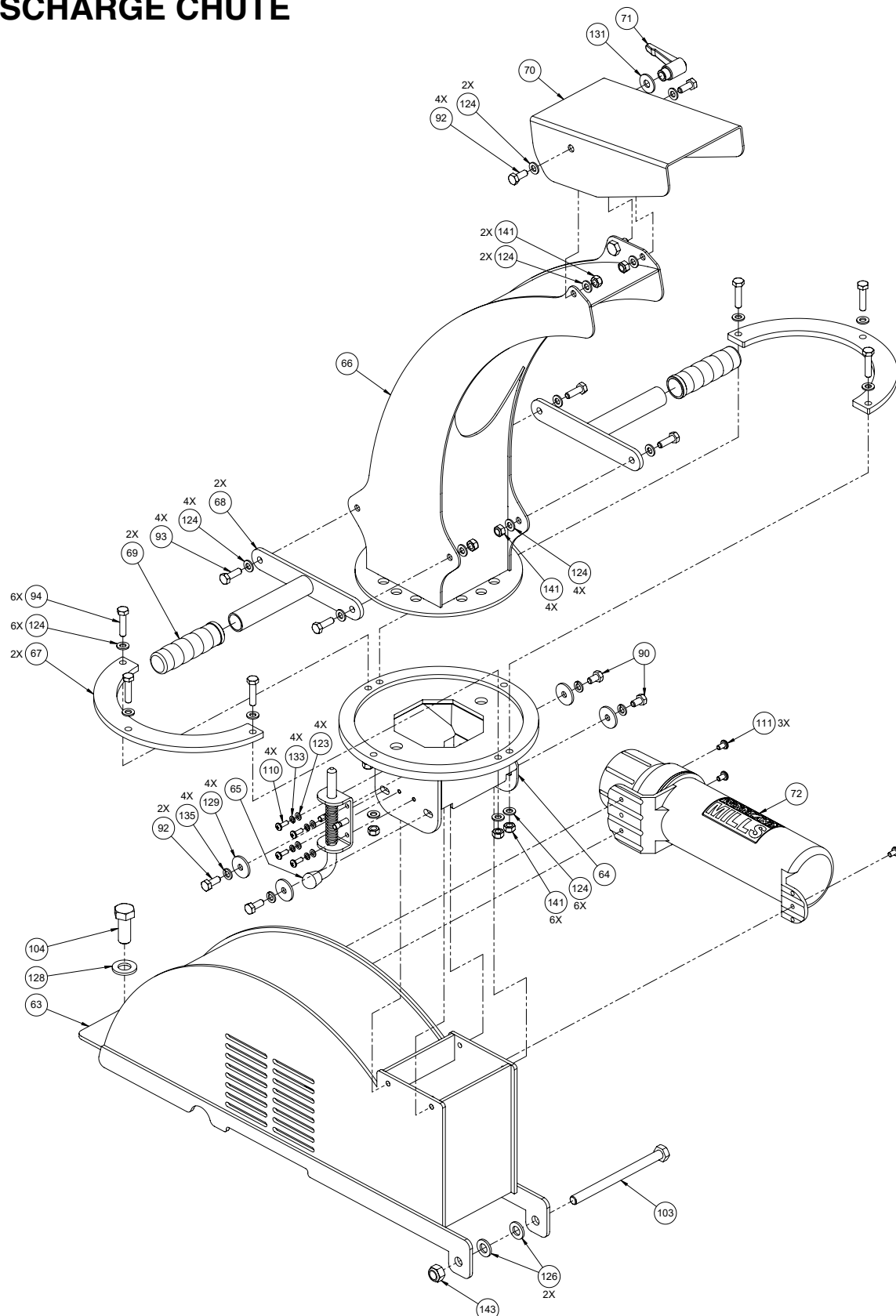




# INFEED CHUTE



# DISCHARGE CHUTE

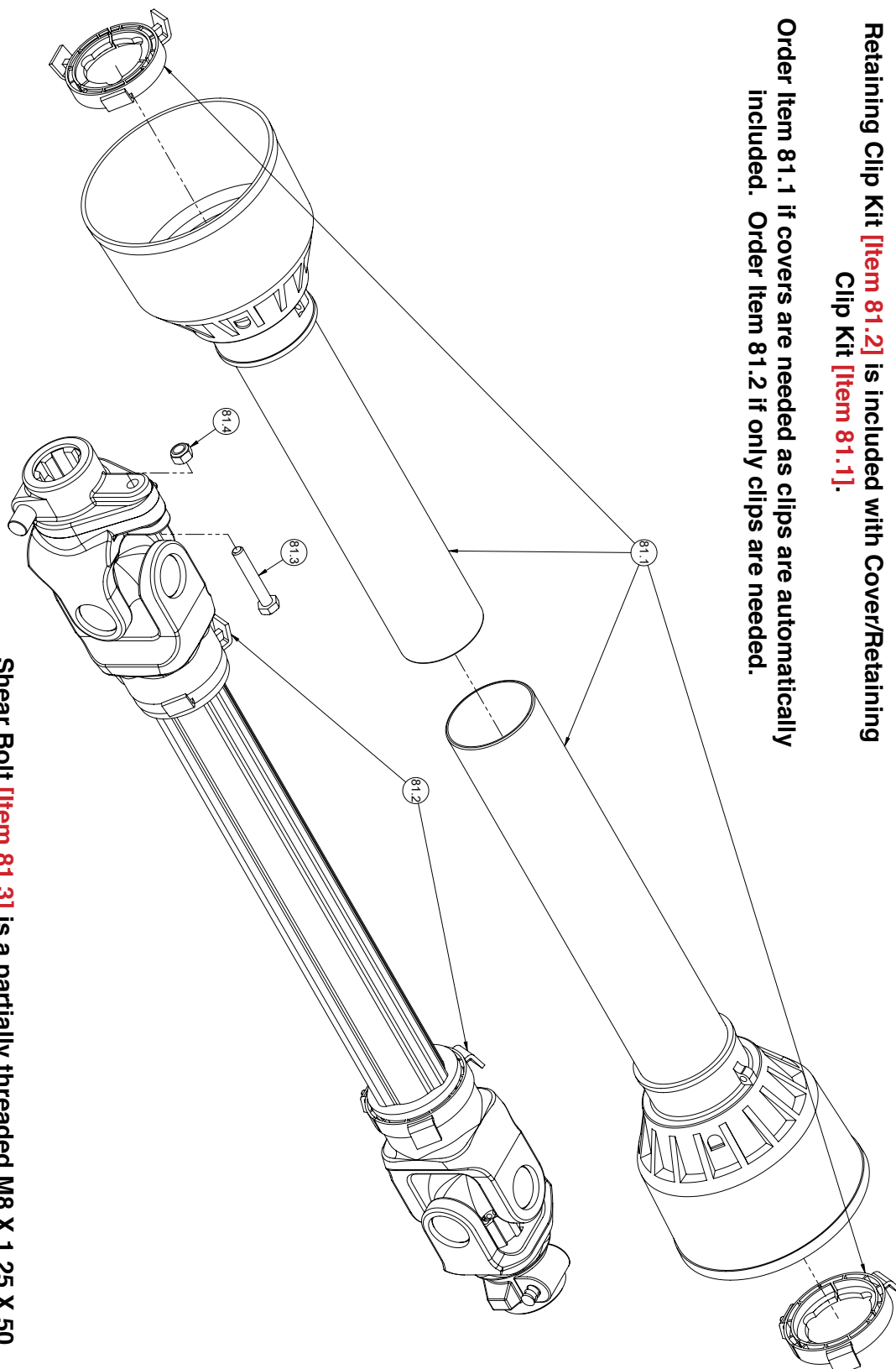


This diagram illustrates the hydraulic system components for a Mills machine. The main pump (20) is connected to the control valves (45, 49) via hoses (76, 79). The control valves are mounted on a base plate (48) which also features a large 'MILLS' logo. The system includes various fittings (77, 78) and a pressure relief valve (80). A large, textured cap is shown on the left side of the base plate.

## PTO SHAFT

Retaining Clip Kit **[Item 81.2]** is included with Cover/Retaining Clip Kit **[Item 81.1]**.

Order Item 81.1 if covers are needed as clips are automatically included. Order Item 81.2 if only clips are needed.



Shear Bolt **[Item 81.3]** is a partially threaded M8 X 1.25 X 50 mm Class 8.8 hex bolt with an M8 X 1.25 lock nut **[Item 81.4]**.  
 Shear Bolt inch equivalent: partially threaded 5/16-18 X 2 in Grade 5 hex bolt with a 5/16-18 lock nut.

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**DISCOVER THE WOODLAND™**