

WOODLANDER® XL TRAILER HM136MAX™

*Track Not Included



OPERATOR'S MANUAL

0009012-M-EN: Rev A
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DISCOVER THE WOODLAND™

The Woodlander® XL is sold as an *off-road only* sawmill trailer compatible with HM126, HM130, HM130MAX®, & HM136MAX™ sawmills. Woodlander® is a registered trademark of Woodland Mills, Inc.

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TABLE OF CONTENTS

TABLE OF CONTENTS	1
INTRODUCTION	3
GENERAL SAFETY RULES	4
INSPECTION/MAINTENANCE	5
TECHNICAL SPECIFICATIONS	6
BOLT TORQUE SPECIFICATIONS	6
UNPACKING	7
COMPONENT LISTS	8
TO-SCALE HARDWARE	10
BOLTS & SCREWS	10
WASHERS	13
NUTS	13
SAWMILL COMPONENTS	14
SAWMILL HARDWARE	14
TRAILER ASSEMBLY	15
1. TOOLS REQUIRED	15
2. TRACK RAILS, JOINING GUSSETS, LOG BUNK	16
3. LONG SIDE PLATES, JOINING GUSSETS	19
4. TRACK RAILS, END BUNKS, END GUSSETS	21
5. SWIVEL JACKS [TEMPORARY]	23
6. JOINING LOG BUNKS	24
7. CENTRE ALIGNMENT	26
8. LOG BUNKS, JOINING GUSSETS	27
9. SHORT SIDE PLATES, CARRIAGE STOPS	29
10. SIDE PLATE-TO-RAIL OFFSET & BOLT TORQUING	31
11. CROSS BEAMS, JACK MOUNTS [ENDS]	36
12. CROSS BEAM, JACK MOUNTS [CENTRE]	39
13. CROSS BEAMS, AXLE CROSS BEAM, AXLE MOUNTS	41
14. AXLES	44
15. TONGUE AND COUPLER	46
16. LIGHTING	48
17. ADDITIONAL JACKS	52



18. NAMEPLATES _____	54
19. HEAD LOCK-DOWN PLATES _____	56
SAWHEAD CARRIAGE LOCK-DOWN POSITIONS _____	57
20. WHEELS _____	58
WHEEL ALIGNMENT ADJUSTMENT _____	59
21. FENDERS _____	60
22. SAFETY CHAIN _____	62
23. CANT HOOK LEVERAGE PLATES _____	63
OPERATION _____	64
LOCKING-DOWN THE SAWMILL HEAD _____	64
REPLACEMENT PARTS ORDERING _____	66
EXPLODED ASSEMBLY VIEWS _____	67
CHASSIS AND TRACK _____	67
TONGUE _____	68
NORTH AMERICA _____	68
EUROPE _____	68
AXLES, WHEELS, AND FENDERS _____	69
LIGHTING _____	70
NORTH AMERICA _____	70
EUROPE _____	71
NAMEPLATES _____	72
SWIVEL JACKS AND RATCHET STRAP _____	73
PARTS LISTS _____	74
NORTH AMERICA _____	74
EUROPE _____	76
NOTES _____	78
NOTES _____	79
NOTES _____	80



INTRODUCTION

Congratulations on your purchase and welcome to Woodland Mills! This manual gives you the necessary information about your Woodlander® XL sawmill trailer so you will be able to use it properly. The entire manual must be read and understood before using the trailer. 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 Woodlander® sawmill trailer. 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

The Woodlander® sawmill trailer is compatible with HM126, HM130, HM130MAX®, & HM136MAX™ sawmill and track systems for milling logs while the trailer is stationary and firmly supported on the ground. It is not intended to carry any additional weight or be used as a utility trailer.

The Woodlander® XL sawmill trailer is sold as *off-road only* trailers designed for certain applications. We strongly recommend the trailer not be 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 trailer until you have first contacted Woodland Mills to determine if it can or should be performed using the product.

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



GENERAL SAFETY RULES



WARNING!

Read and understand all instructions. Failure to follow all instructions listed below may result serious injury.



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.



WARNING!

The trailer is not designed to carry any additional weight other than the sawmill and trailer itself while being towed. Failure to heed this warning could result in damage to the trailer and/or the sawmill.

Damage caused by towing additional weight will void the warranty.



WARNING!

The Woodlander® XL sawmill trailers are designed and sold as off-road trailer packages and are recommended for this type of use. While they include some road safety components, every province, state, and country have unique regulations that need to be met for road-worthiness. It is important to comply with all regional regulations if attempting to convert the trailer for road use.



INSPECTION/MAINTENANCE

- Check the tires before all trips. Make sure they are inflated to the pressure shown on the tire.
- Grease the axle bearings every 3 months or 1000 miles [1600 km], whichever comes first.
- Check the tow hitch ball coupler. Make sure it is not damaged.
- Check the wheel lug nuts before all trips. Make sure they are torqued properly.
- Check the lights. Make sure all the lights work properly. Replace any lights that do not work.
- Inspect trailer before all trips for any damaged or loose parts.



TECHNICAL SPECIFICATIONS

Item	Specification
Trailer Axle	Independent Torsion Axle Design
Trailer Wheels	5 Bolts @ 4.5 in [114 mm] & 175/80R13 Approved Tires
Tire Pressure	Refer to Tire
Wheel Nut Torque	80 ft•lb [110 N•m]
Trailer Ball Coupler	2 in [50 mm]
Trailer Lights	LED Light Kit (stop, turn, tail, side markers, and license plate light)
Finish	Powder Coat Paint / Galvanized Steel
Fenders	Removable
Safety	Locking pins and safety straps to secure sawhead while travelling
Shipping Weight	1019 lb [462 kg]
Product Weight	958 lb [435 kg]

BOLT TORQUE SPECIFICATIONS

Bolt (Thread Size)	Torque
M5	78 in•lb [9 N•m]
M6	133 in•lb [15 N•m]
M8	333 in•lb [38 N•m]
M10	53 ft•lb [72 N•m]
M12	93 ft•lb [126 N•m]



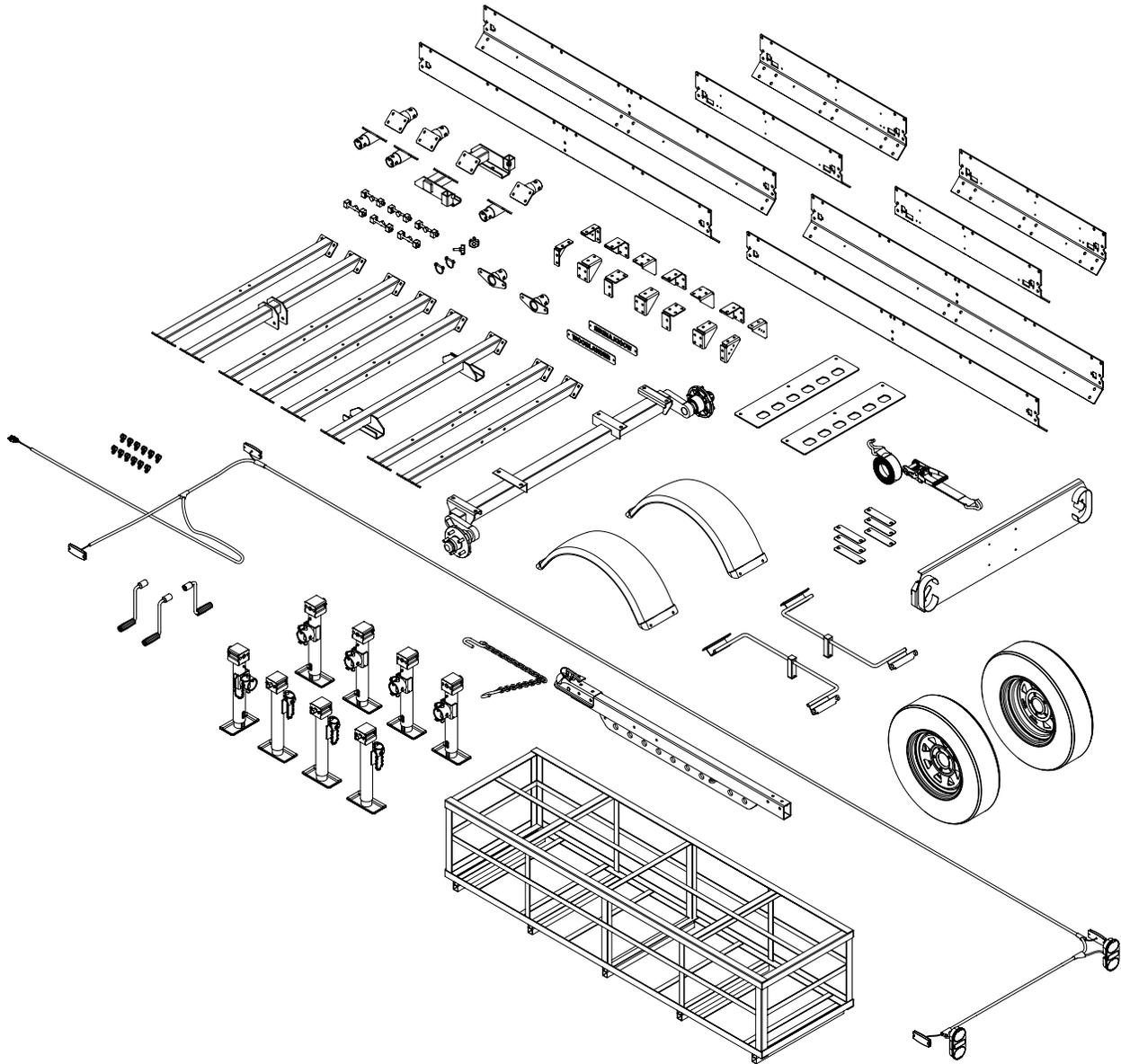
BOLT TORQUE WARNING!

The torque specifications listed above apply only to the track and trailer assembly outlined in this manual. They do *not* apply to the sawmill assembly. Follow the instructions in the sawmill operator's manual when assembling the carriage and sawhead.



UNPACKING

Remove all the parts from both the steel trailer crate and trailer extension box. Set the steel trailer crate aside as it will be used as a support for several of the assembly steps.

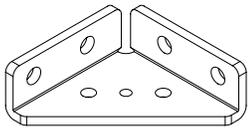
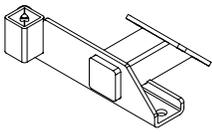
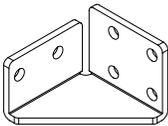
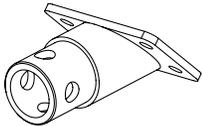
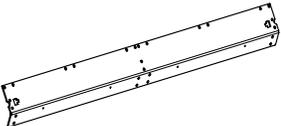
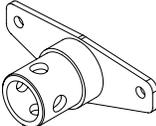
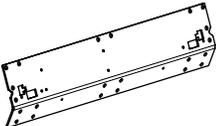
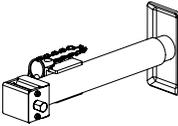
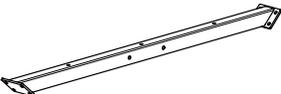
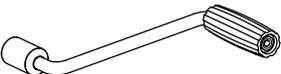
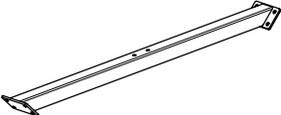
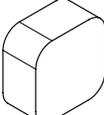
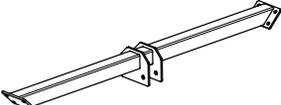
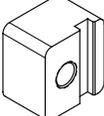
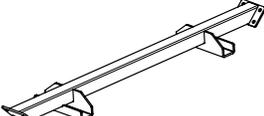
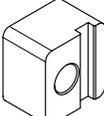
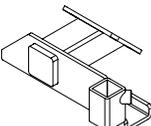
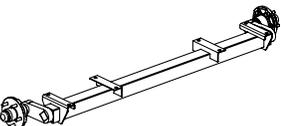




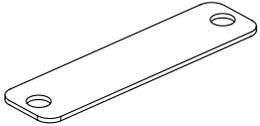
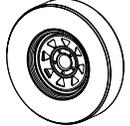
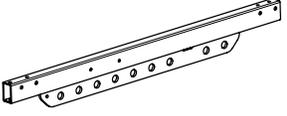
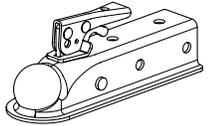
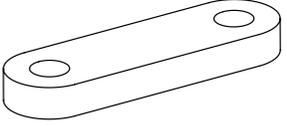
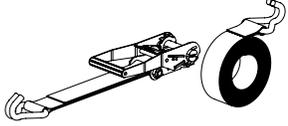
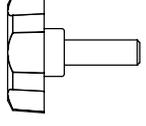
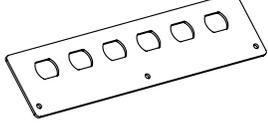
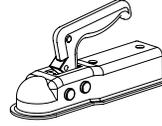
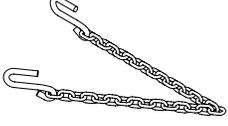
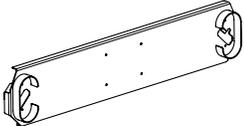
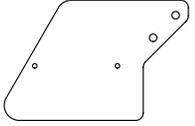
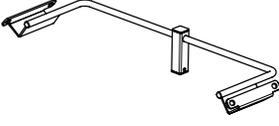
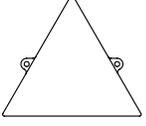
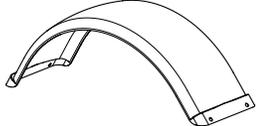
COMPONENT LISTS

Verify all component and hardware quantities are correct prior to assembling the trailer.

Note: component quantities shown below are the total quantities from both the Woodlander® Trailer and Woodlander® Trailer Extension crates.

4x	End Gusset [0001373]		1x	Right Axle Mount [0009156]	
10x	Joining Gusset [0001374]		6x	Jack Mount [0001376]	
4x	Long Side Plate [0008948]		2x	Bushlander Jack Mount [0002249]	
4x	Short Side Plate [0008947]		8x	Swivel Jack [0006798]	
5x	Cross Beam [0008942]		3x	Swivel Jack Handle [0006800]	
1x	Front Cross Beam [0003935]		6x	Side Plate Alignment Diamond [0008949]	
1x	Tongue Cross Beam [0009650]		6x	Side Plate Alignment Nut [0008950]	
1x	Axle Cross Beam [0003937]		6x	Side Plate Alignment Jaw [0008951]	
1x	Left Axle Mount [0009155]		1x	Axle Assembly	



6x	Axle Shim Plate [0001682]		1x	Wiring Harness (North America) [0001676-1]	
2x	Wheel [175-80R13]		2x	Nameplate [0004445]	
1x	Tongue [0001371]		1x	Hitch Ball Coupler (North America) [0001381]	
1x	Tongue Bracket [0001372]		1x	Ratchet Strap [0005146]	
2x	Knob M10 X 30 mm [0001698]		2x	Cant Hook Leverage Plate [0008944]	
3x	Round Locking Pin [0004728]		1x	Hitch Ball Coupler (Europe) [0001702]	
1x	Safety Chain [0001382]		1x	Wiring Harness (Europe) [0001676-2]	
1x	Taillight Bracket [0003938]		2x	Reflector Bracket (Europe) [0001379]	
2x	Fender Bracket [0009823]		2x	Rear Reflector (Europe) [0001390]	
2x	Fender [0004221]		4x	Side Reflector (Europe) [0001391]	
12x	Cable Clamp [0001396]		2x	Front Reflector (Europe) [0001392]	

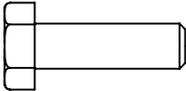
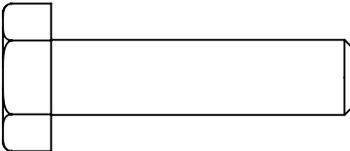
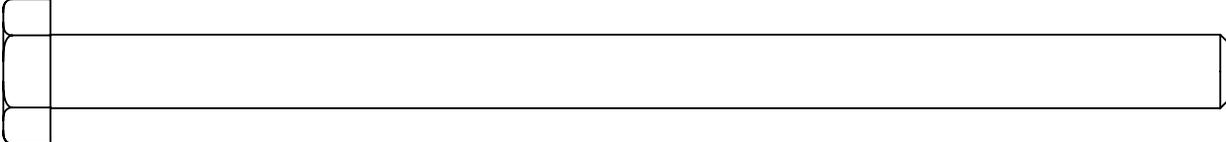
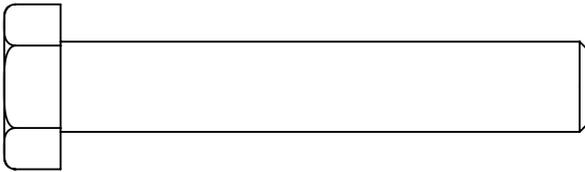
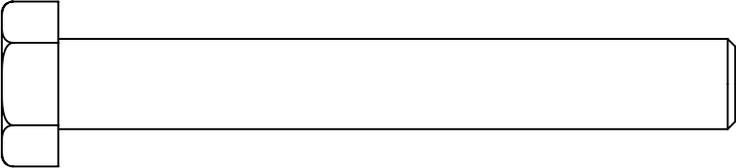


TO-SCALE HARDWARE

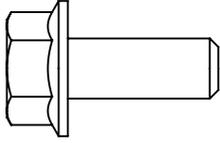
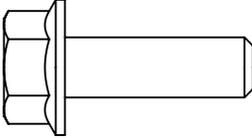
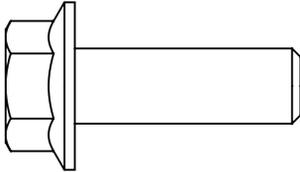
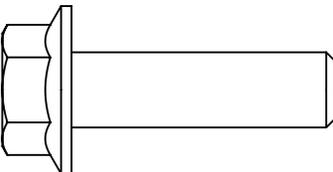
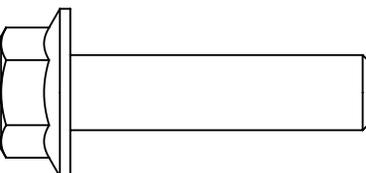
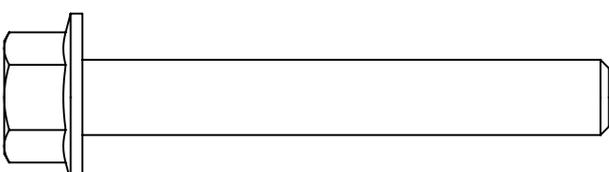
BOLTS & SCREWS

Hardware graphics are printed at 1:1 scale for ease of identification. Simply place the hardware over the image in the tables to verify it is the correct size.

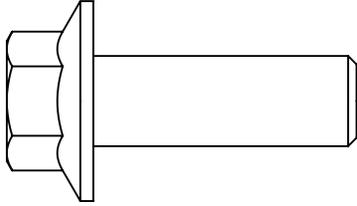
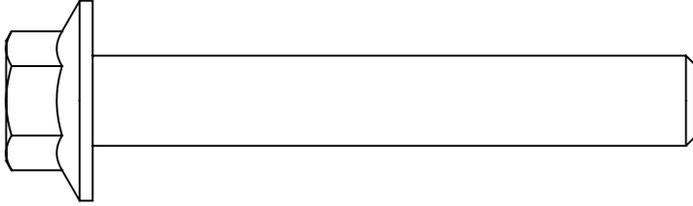
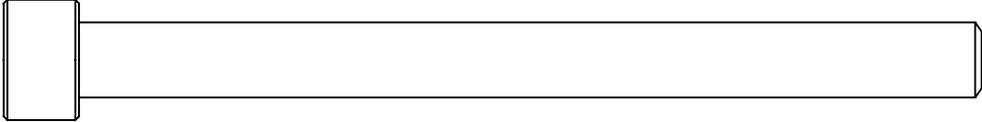
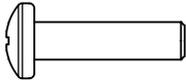
Hardware quantities shown below are the total quantities from both the Woodlander® trailer and Woodlander® trailer extension crates.

16x	HHB-MBE075FCJ	M6 X 1 X 20 mm HEX BOLT
		
1x	HHB-MBM095FCM	M10 X 1.5 X 40 mm HEX BOLT
		
2x	HHB-MBM215PCM	M10 X 1.5 X 160 mm HEX BOLT
		
2x	HHB-MBR125PCM*	M12 X 1.75 X 70 mm HEX BOLT
		
2x	HHB-MBR155PCM**	M12 X 1.75 X 100 mm HEX BOLT
		



8x	FHH-MBJ075FCJ	M8 X 1 X 20 mm FLANGED HEX BOLT
		
4x	FHH-MBJ080FCJ	M8 X 1 X 25 mm FLANGED HEX BOLT
		
172x	FHH-MBM085FCM	M10 X 1.5 X 30 mm FLANGED HEX BOLT
		
40x	FHH-MBM090PCM	M10 X 1.5 X 35 mm FLANGED HEX BOLT
		
16x	FHH-MBM095PCM	M10 X 1.5 X 40 mm FLANGED HEX BOLT
		
10x	FHH-MBM125PCM	M10 X 1.5 X 70 mm FLANGED HEX BOLT
		



8x	FHH-MBR090PCM	M12 X 1.75 X 35 mm FLANGED HEX BOLT
		
2x	FHH-MBR135PCM	M12 X 1.75 X 80 mm FLANGED HEX BOLT
		
6x	SHC-MBM175PTA	M10 X 1.5 X 120 mm SOCKET HEAD CAP SCREW
		
8x	PPH-MBA075FCE***	M5 X 0.8 X 20 mm PHILLIPS PAN HEAD SCREW
		

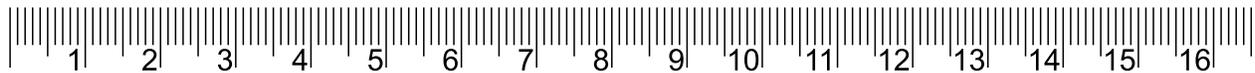
* M12 X 1.75 X 70 mm Hex Bolts not applicable on European trailers

** M12 X 1.75 X 100 mm Hex Bolts not applicable on North American trailers

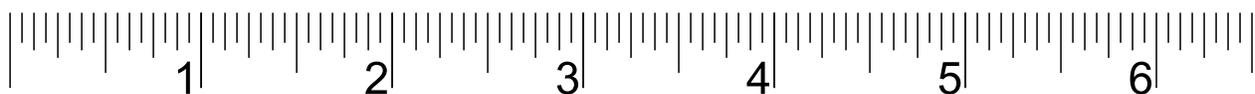
*** M5 X 0.8 X 20 mm Phillips Pan Head Screw quantity 12x on European trailers

SCALES

Ruler scales are also provided below to double-check bolt and screw lengths when necessary.



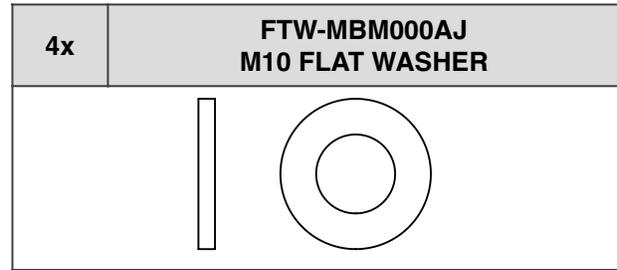
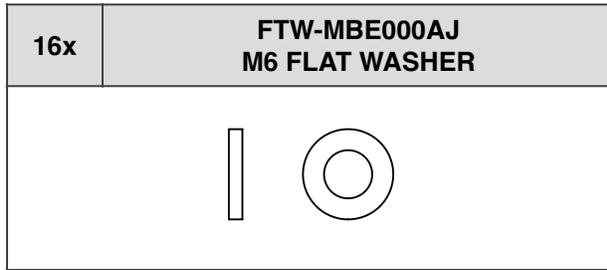
CENTIMETRES / MILLIMETRES



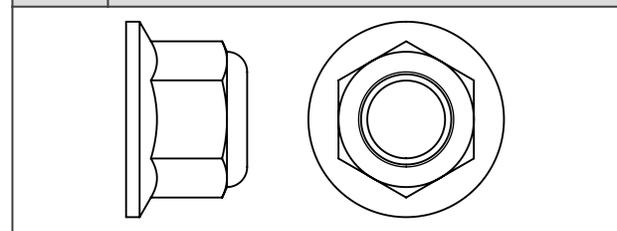
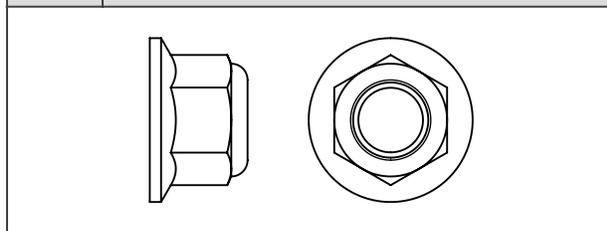
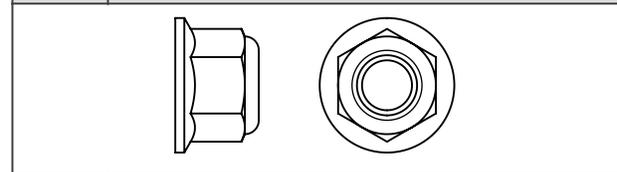
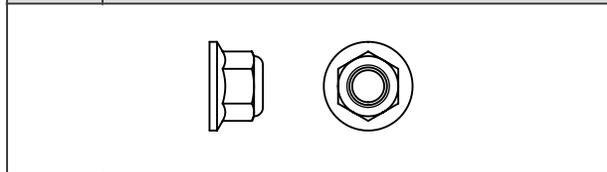
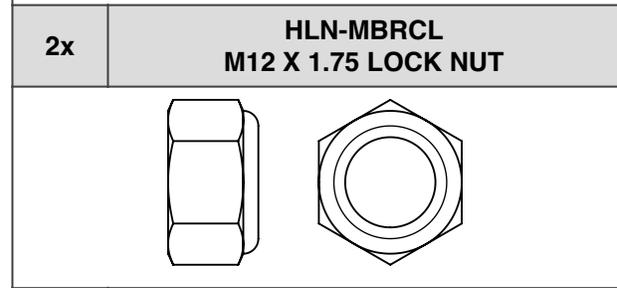
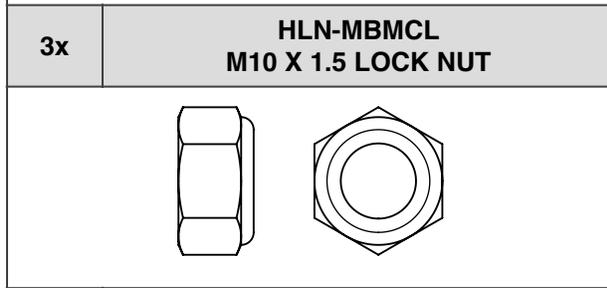
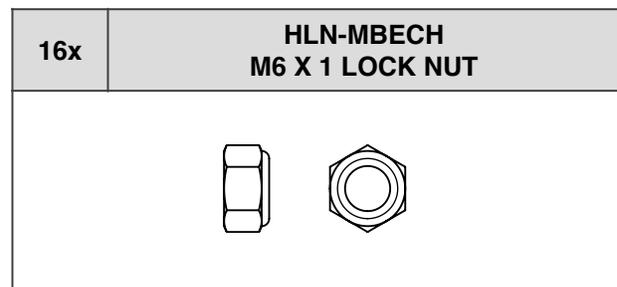
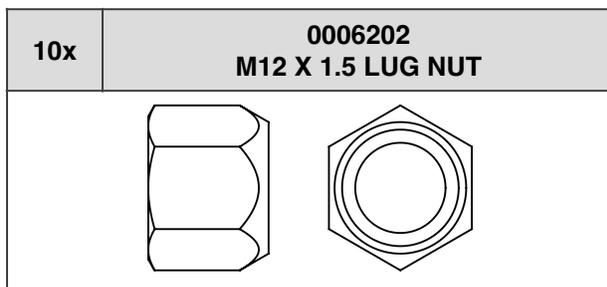
INCHES



WASHERS



NUTS

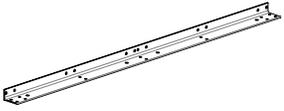
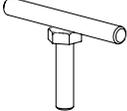
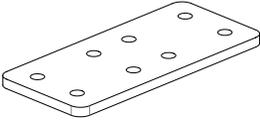
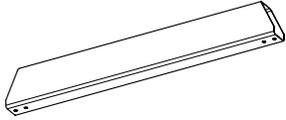
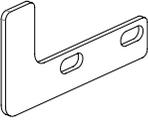
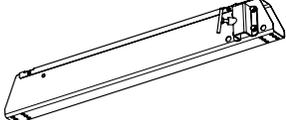


*** M5 X 0.8 Flanged Lock Nut quantity 14x on European trailers**



SAWMILL COMPONENTS

These components from the sawmill and sawmill track extension crates are required to build the trailer. They do not ship with the Woodlander® XL trailer.

6x	Track Rail [0001073]		5x	T-Bolt M10 X 40 mm [0001059]	
4x	Reinforcement Plate [0001072]		2x	End Bunk [0003606]	
4x	Carriage Stop [0001055]		5x	Log Bunk [0009120]	
6x	Anti-Tip Rail [0003620]				

SAWMILL HARDWARE

None of the hardware from the sawmill is used to build the trailer.



TRAILER ASSEMBLY

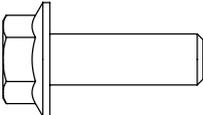
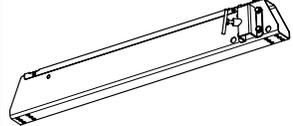
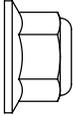
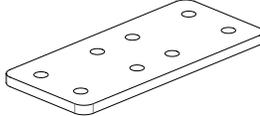
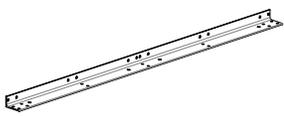
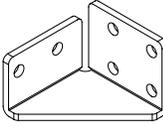
1. TOOLS REQUIRED

Tool	Specification
Phillips Head Screwdriver	No. 3
Wrench/Socket	8 mm
Wrench/Socket	9 mm
Wrench/Socket	10 mm
Wrench/Socket	13 mm
Wrench/Socket	14 mm
Wrench/Socket	15 mm
Wrench/Socket	18 mm
Adjustable Wrench	Variable
Torque Wrench	Capable of 93 ft•lb [126 N•m]
Drill	Corded or cordless



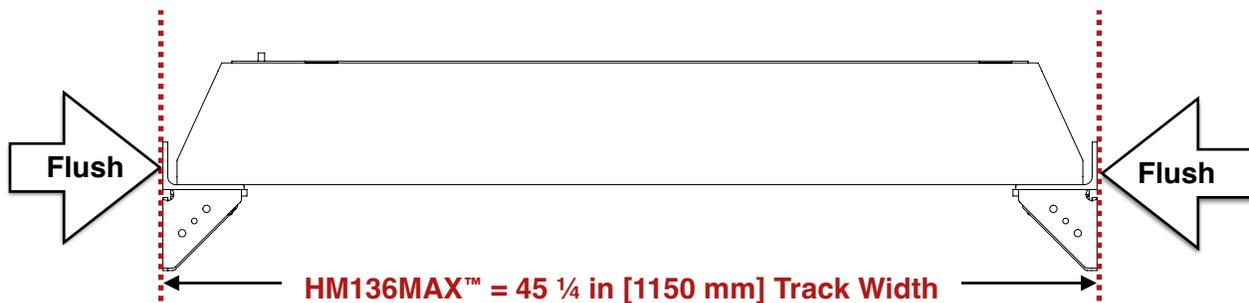
2. TRACK RAILS, JOINING GUSSETS, LOG BUNK

Using the hardware listed below, assemble the gussets to the track as shown on the next page. Torque all bolts per the table in section **BOLT TORQUE SPECIFICATIONS**.

12x	M10 X 30 mm Flanged Hex Bolt		1x	Log Bunk	
12x	M10 Flanged Lock Nut		4x	Reinforcement Plate	
2x	Track Rail		2x	Joining Gusset	

Track components listed in these tables are *not* included with the trailer package, namely track rails, reinforcement plates, bunks, and carriage stops. These components are found in the sawmill crate. If the trailer was purchased for an existing sawmill (i.e. the sawmill is currently assembled), the track will need to be disassembled prior to building the trailer.

When assembling the track, ensure the gussets are flush with the track rails as shown in the graphic below. Measure diagonally to check for squareness.

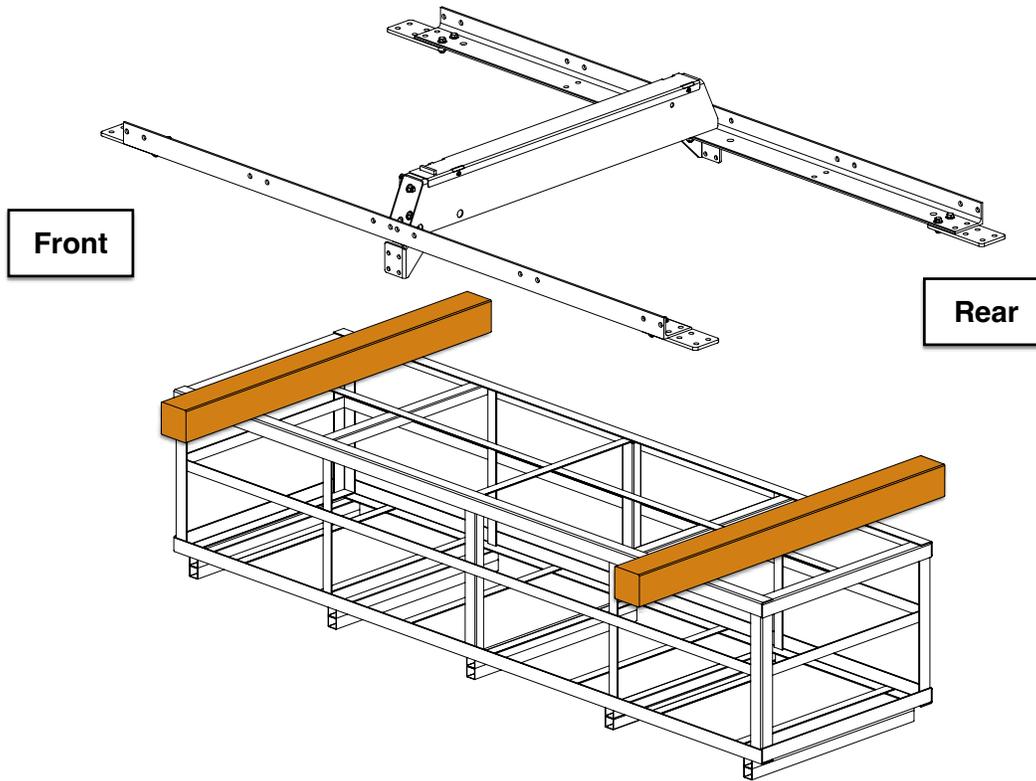


Use the fasteners included with the sawmill trailer to assemble the track. The fasteners included with

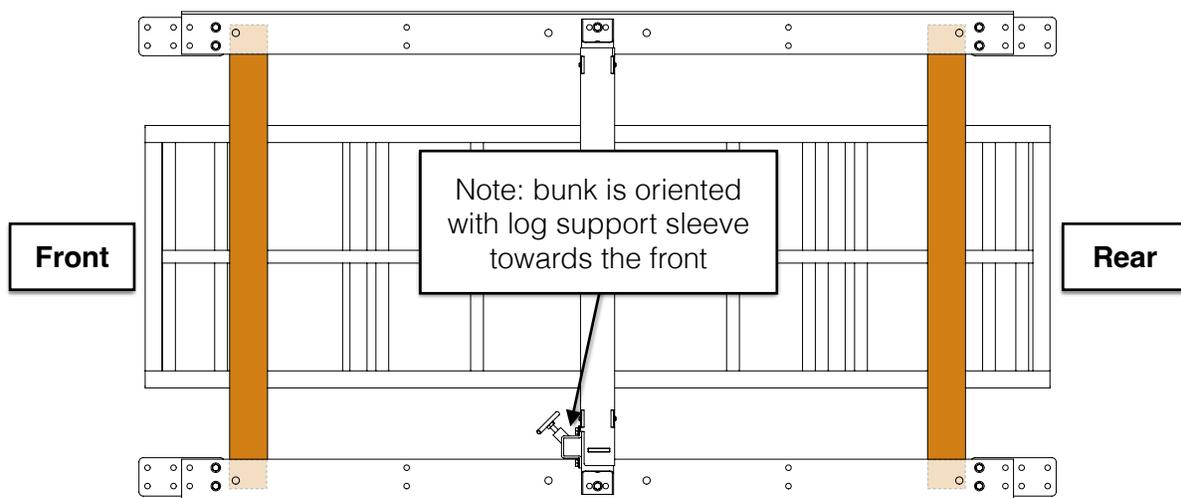


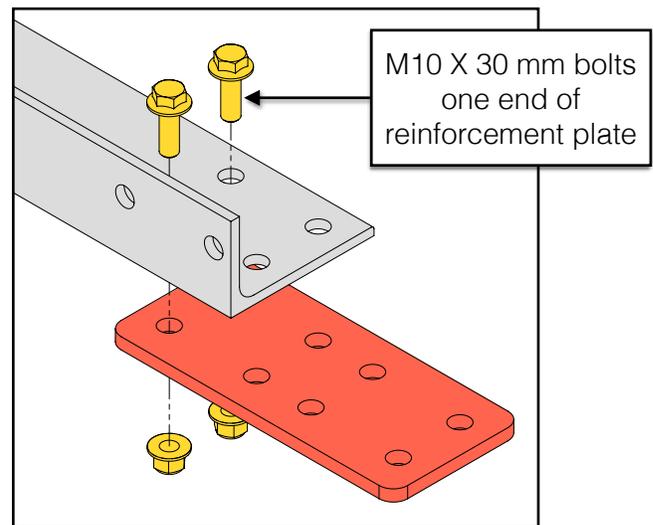
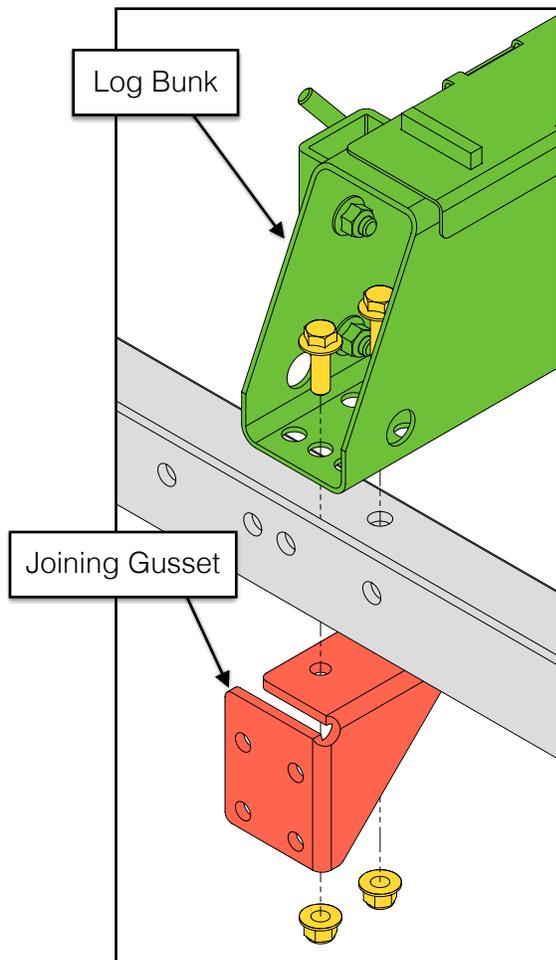
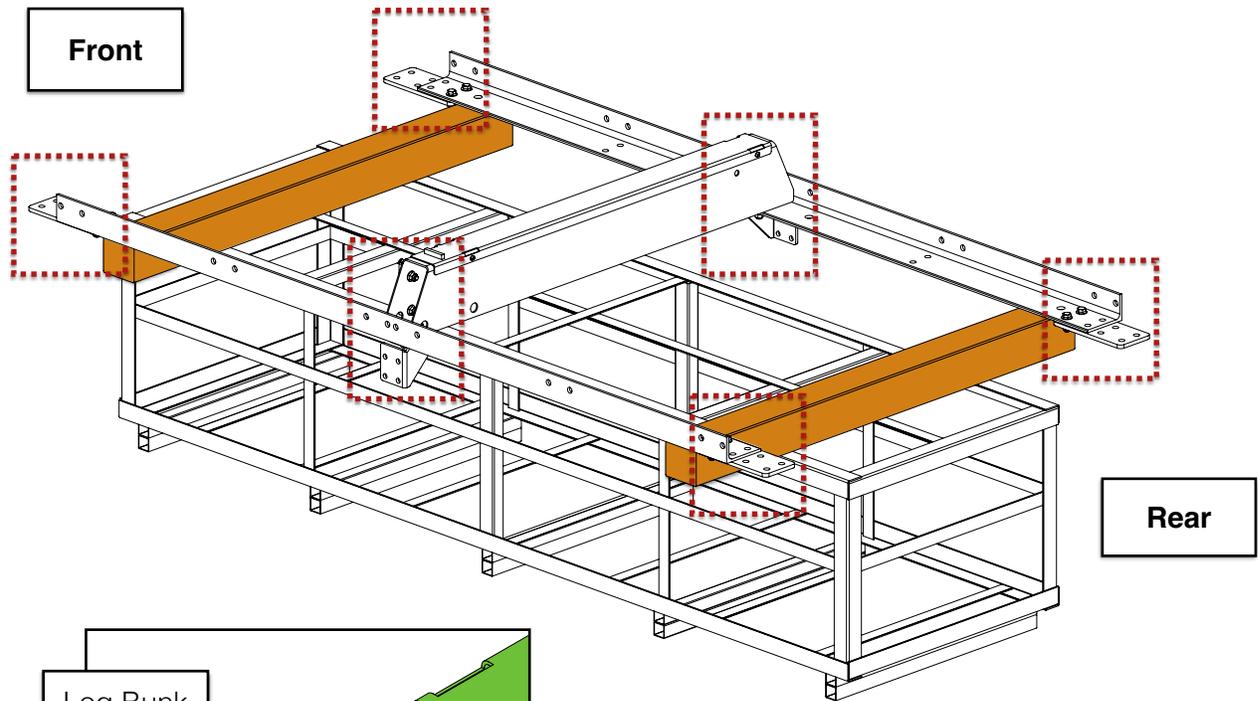


Using the shipping crate as an assembly aid, lay two (2) 4X4s across the top the crate near each end. Position the track/gusset assembly on the 4X4s, ensuring it is centred end-to-end. The 4X4s need to be long enough to support the track rails but shorter than the track is wide.



Use 43 in [1092 mm] long 4X4s.

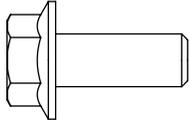
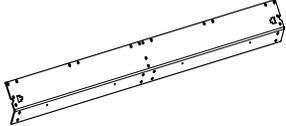
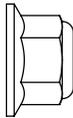
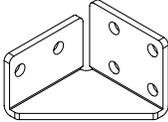


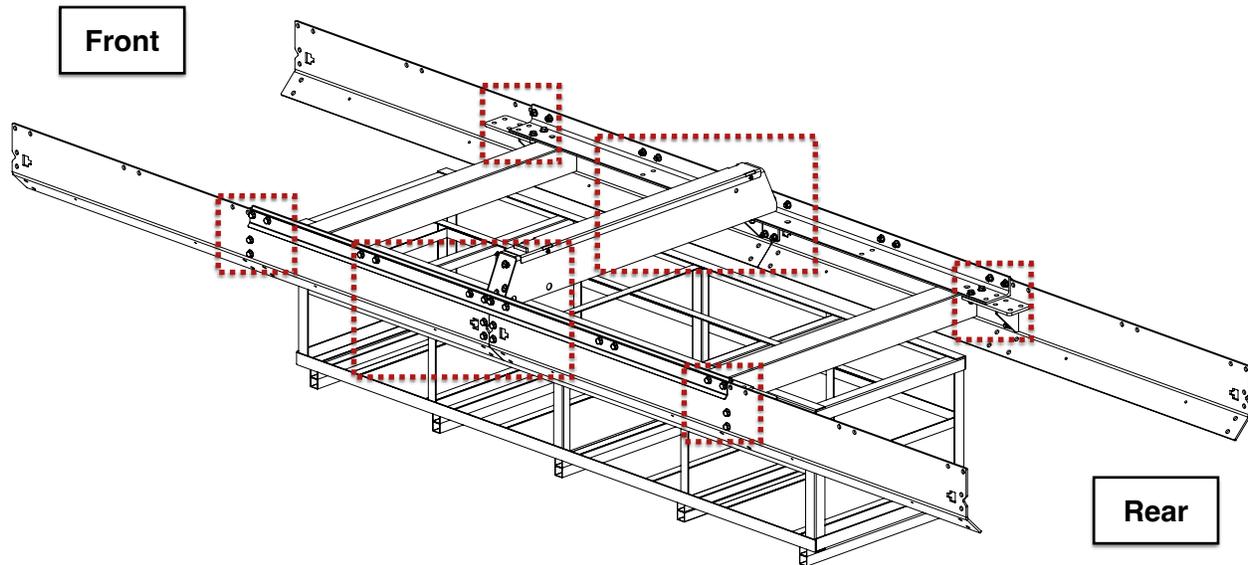


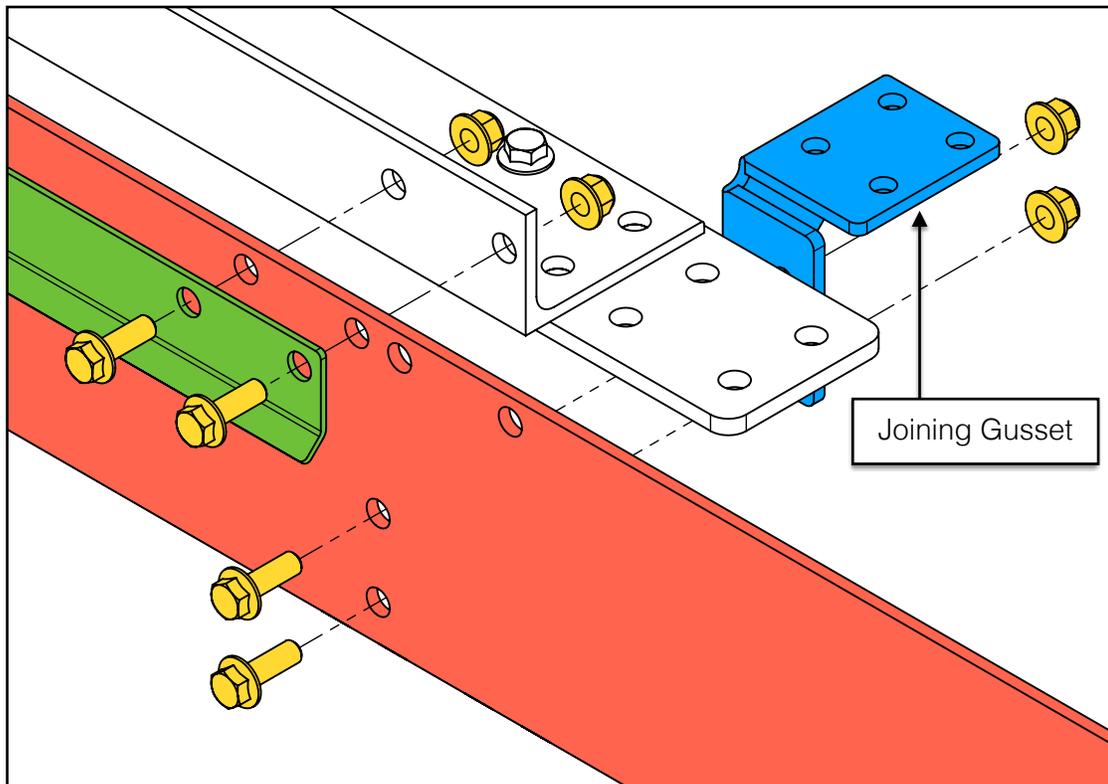
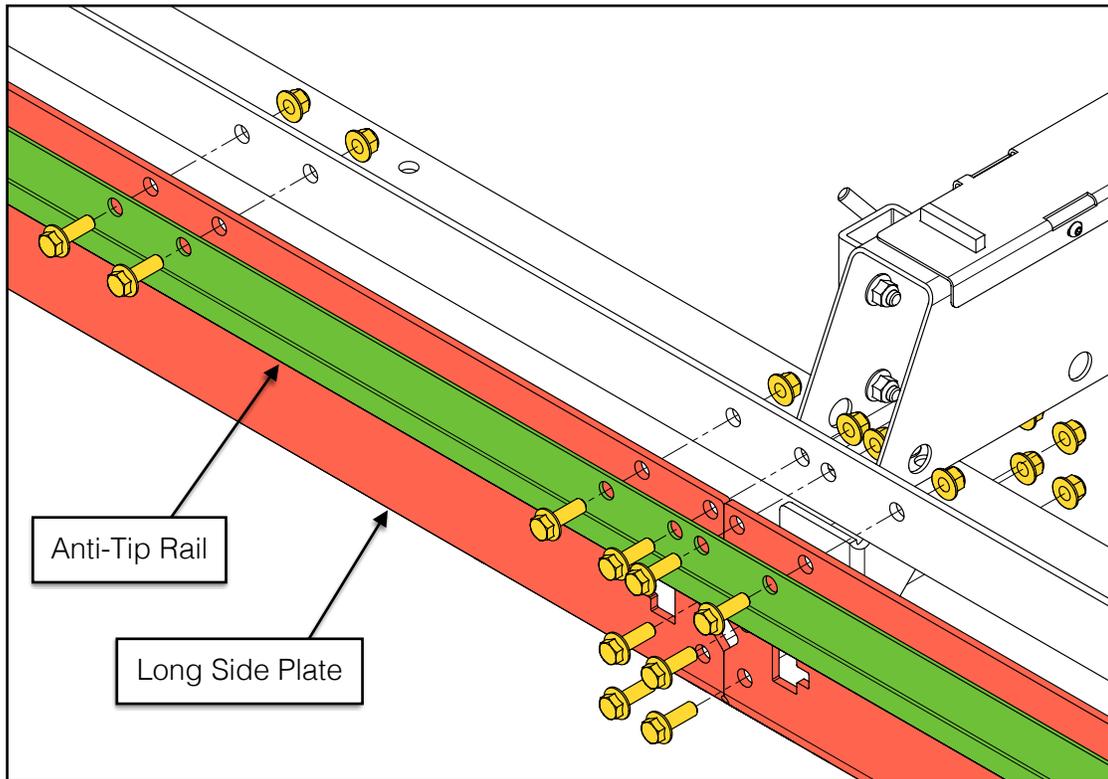


3. LONG SIDE PLATES, JOINING GUSSETS

Using the hardware listed below, hang the long side plates and centre anti-tip rails on the centre track section. Snug the bolts up, but leave them loose enough to move the plates.

40x	M10 X 30 mm Flanged Hex Bolt		4x	Long Side Plate	
40x	M10 Flanged Lock Nut		4x	Joining Gusset	
			2x	Anti-Tip Rail	

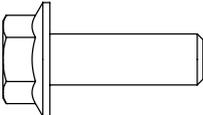
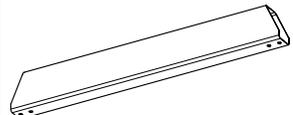
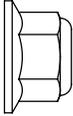
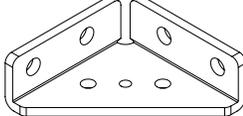
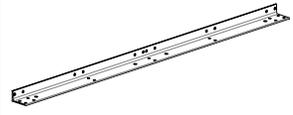


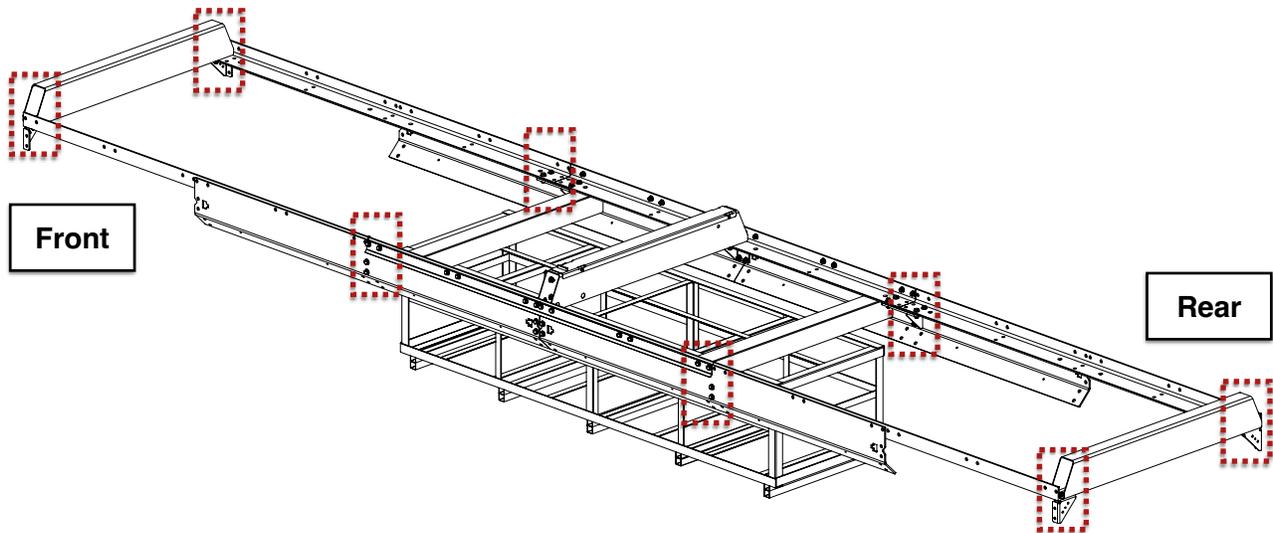


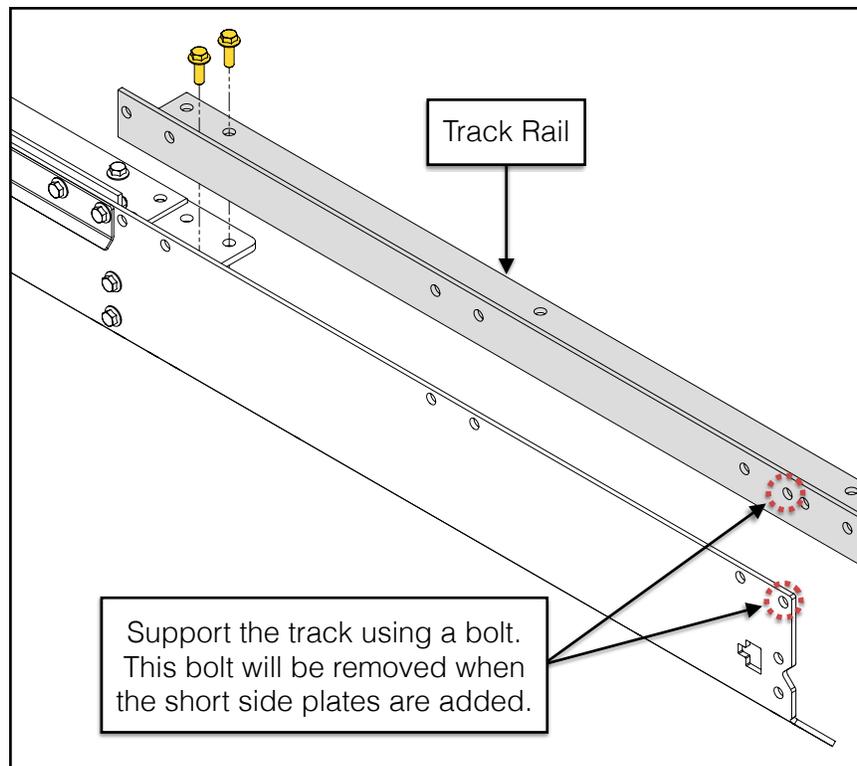
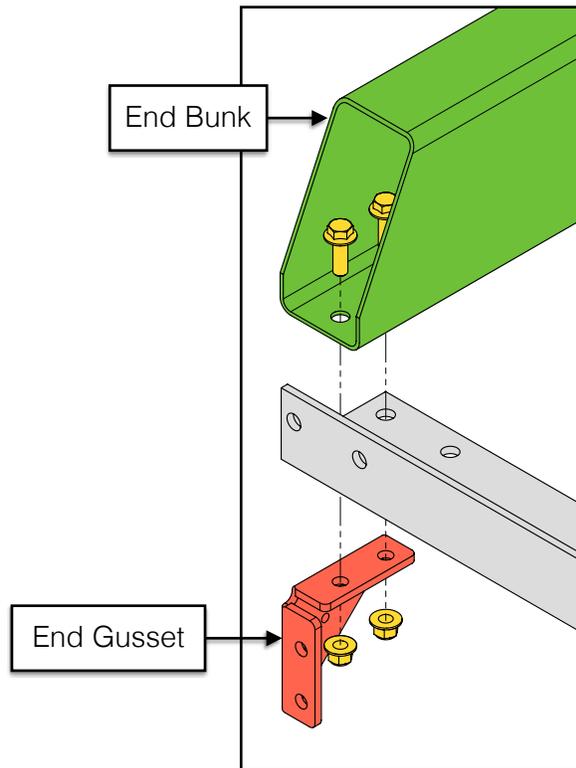


4. TRACK RAILS, END BUNKS, END GUSSETS

Using the hardware listed below, add the remaining track sections and end bunks. Leave the bolts loose.

16x	M10 X 30 mm Flanged Hex Bolt		2x	End Bunk	
16x	M10 Flanged Lock Nut		4x	End Gusset	
			4x	Track Rail	

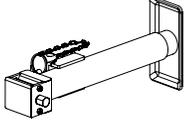
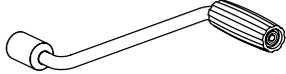


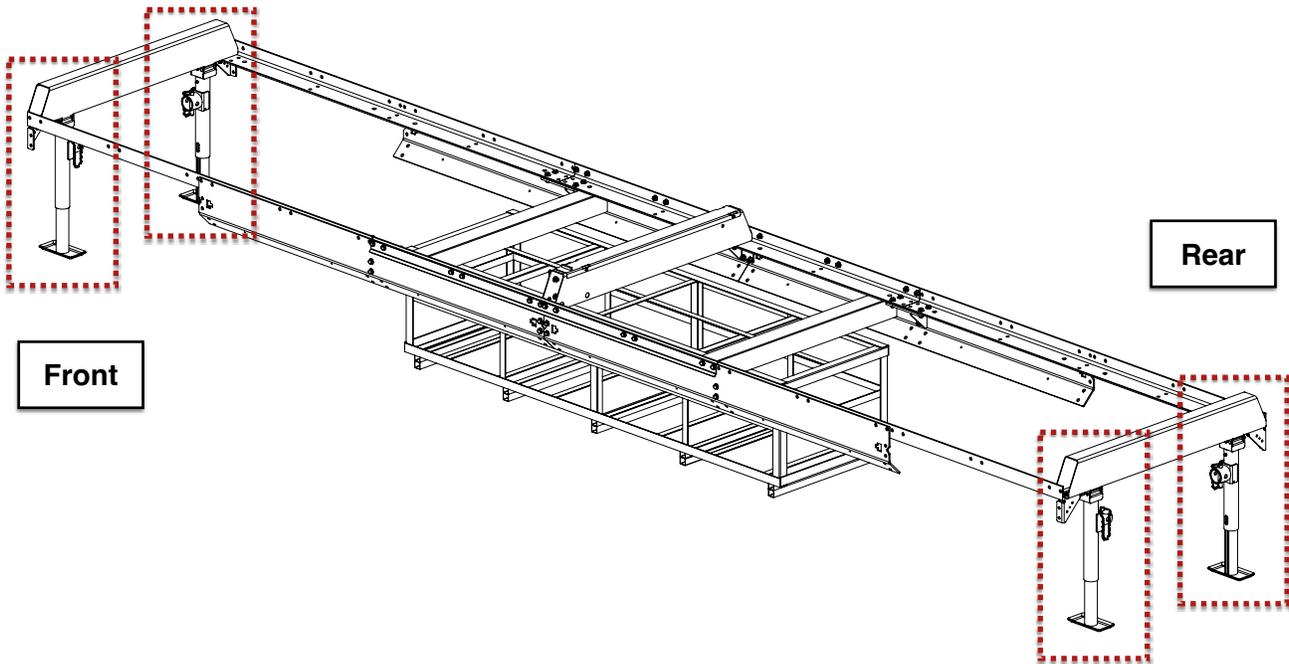




5. SWIVEL JACKS [TEMPORARY]

Using 4 swivel jacks, place 2 under each end bunk and level the assembly while still using the crate as support in the middle. Measure diagonally to check for squareness. Snug all of the bolts, but do not fully tighten.

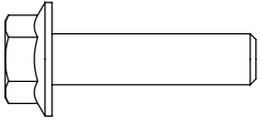
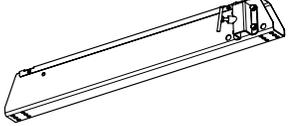
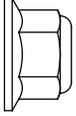
4x	Swivel Jack		1x [3x]	Swivel Jack Handle	
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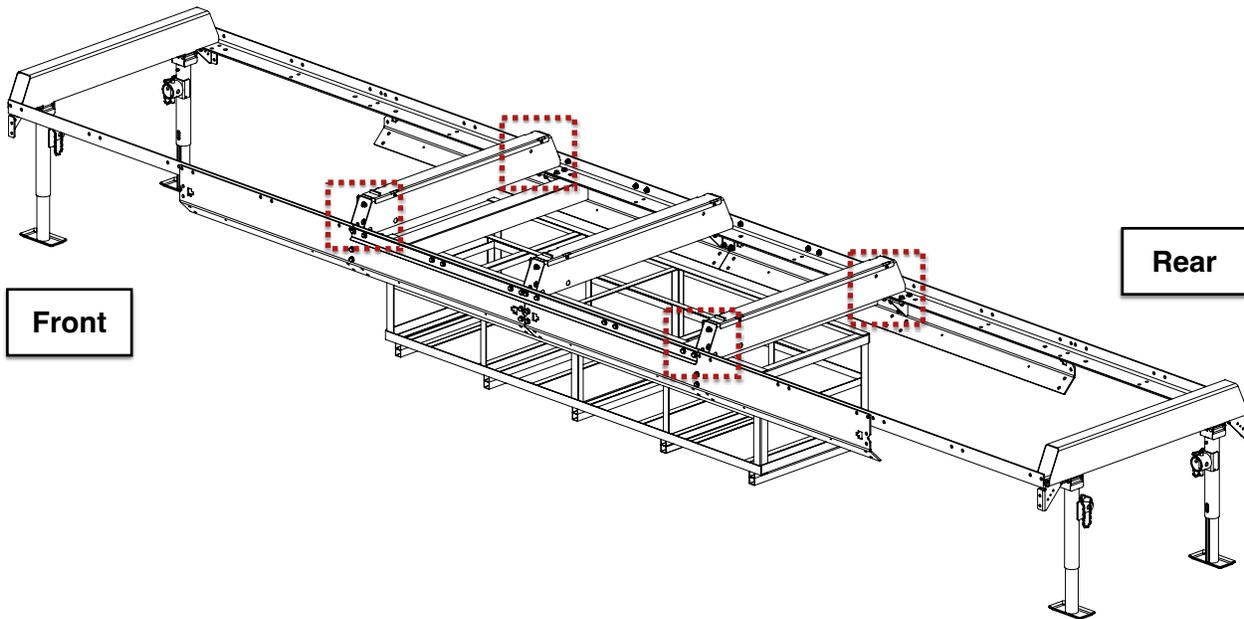


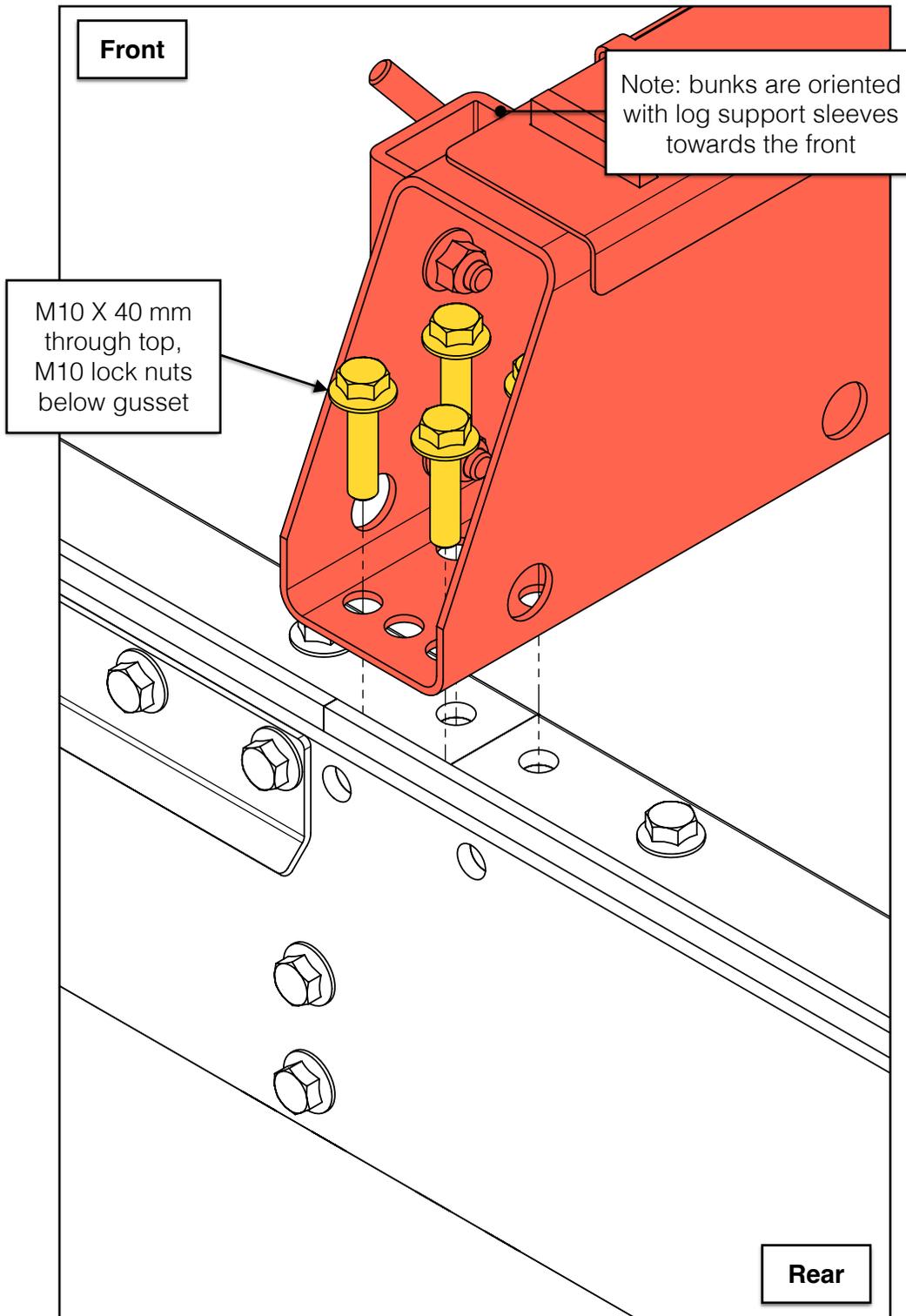


6. JOINING LOG BUNKS

Using the hardware listed below, install the log bunks to the track rails and joining gussets. Use eight (8) M10 X 40 mm bolts through each bunk. Tighten the bolts in the order instructed throughout this section.

16x	M10 X 40 mm Flanged Hex Bolt		2x	Log Bunk	
16x	M10 Flanged Lock Nut				

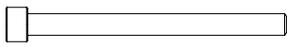
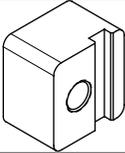
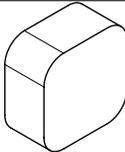
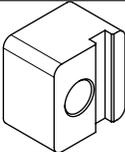


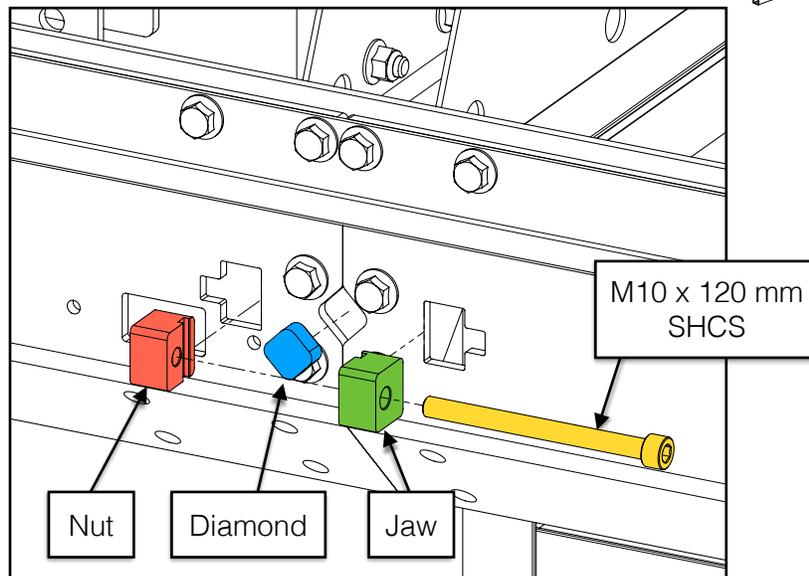
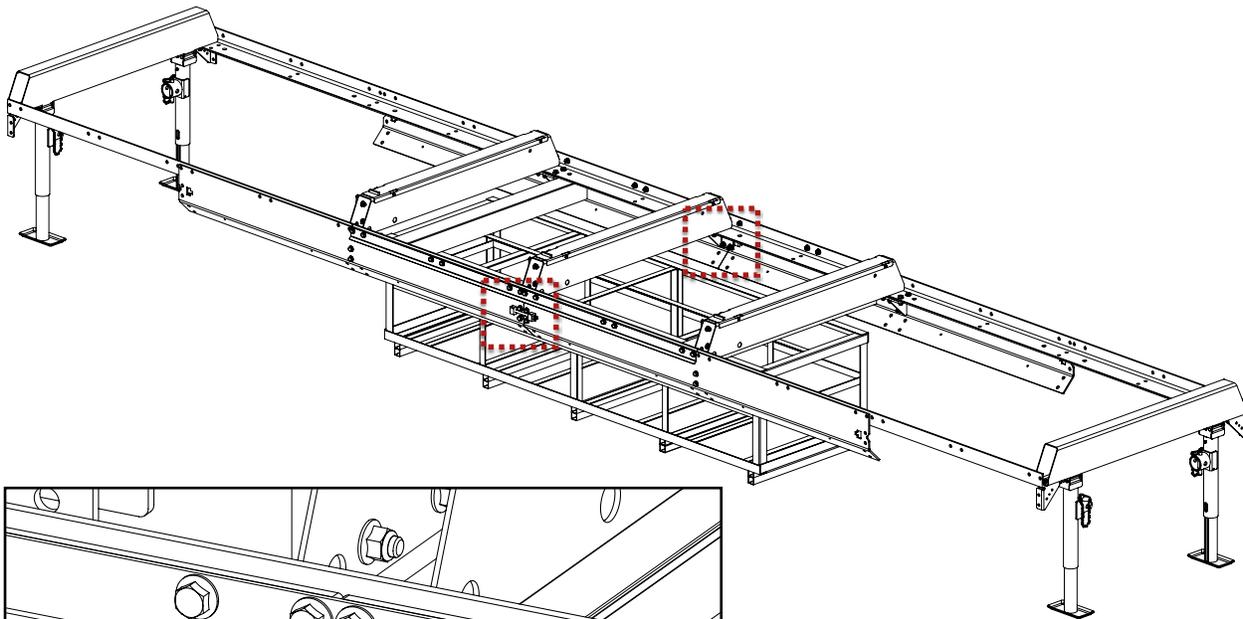




7. CENTRE ALIGNMENT

Using the hardware listed below, install the centre side alignment hardware. Snug the M10 X 120 mm Socket Head Cap Screw to close the gap between the long side plates, but do not fully tighten yet.

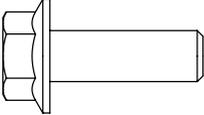
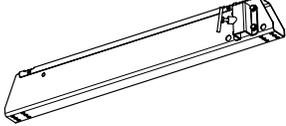
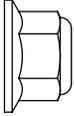
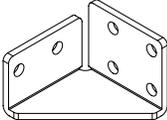
2x	M10 X 120 mm Socket Head Cap Screw		2x	Side Plate Alignment Nut	
2x	Side Plate Alignment Diamond		2x	Side Plate Alignment Jaw	

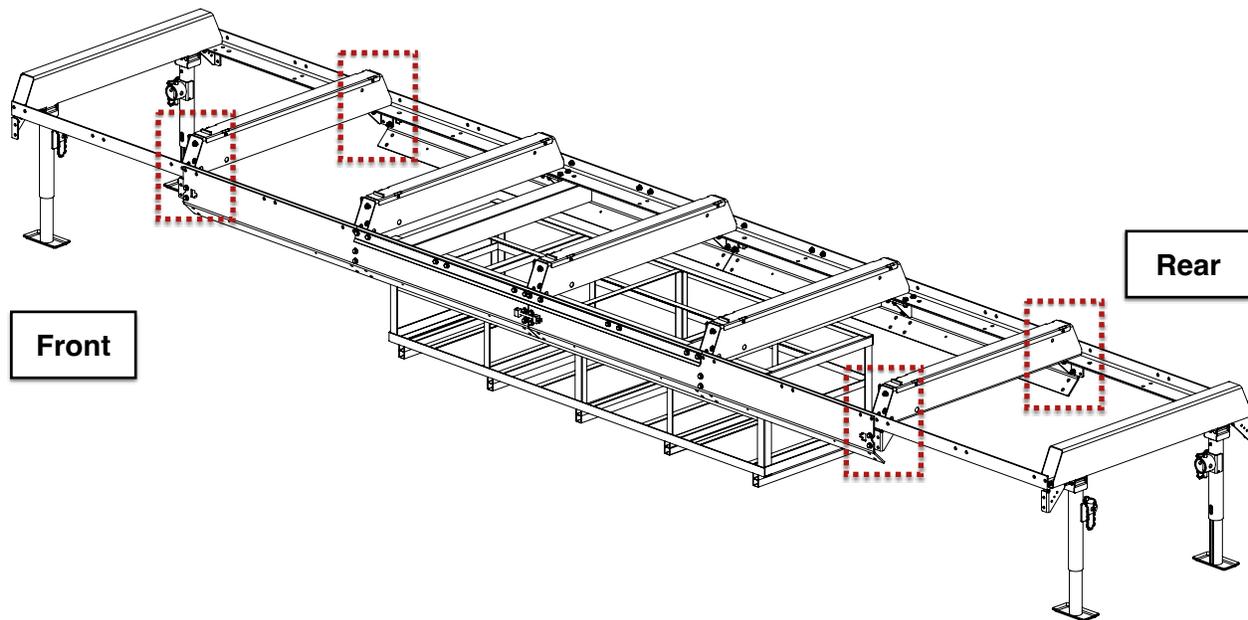


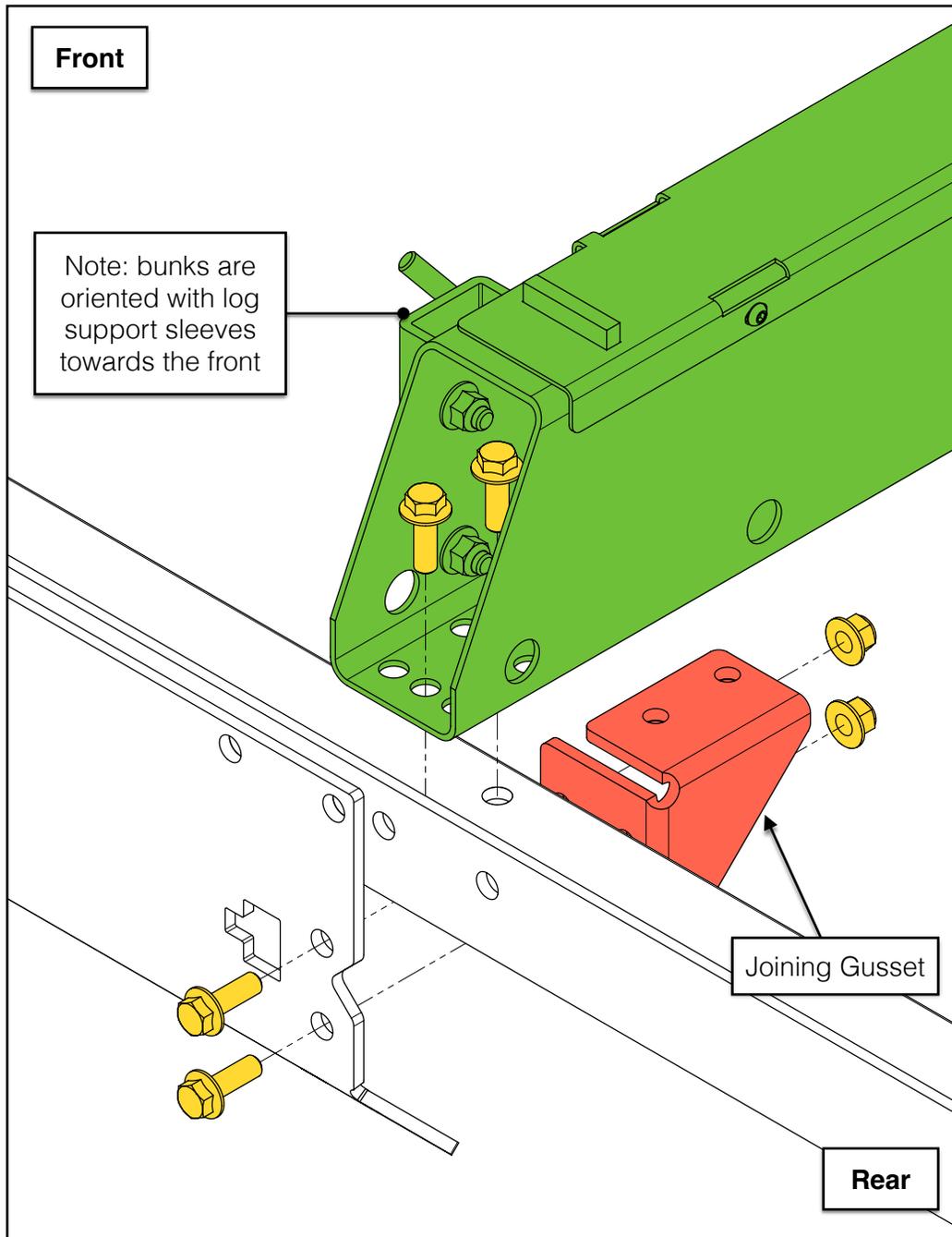


8. LOG BUNKS, JOINING GUSSETS

Using the hardware below, install the remaining bunks and gussets. Tighten the bolts in this step.

16x	M10 X 30 mm Flanged Hex Bolt		2x	Log Bunk	
16x	M10 Flanged Lock Nut		4x	Joining Gusset	

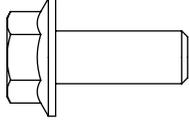
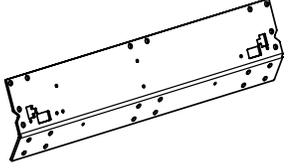
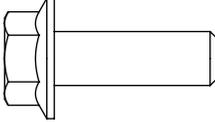
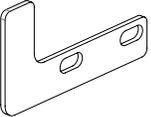
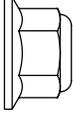


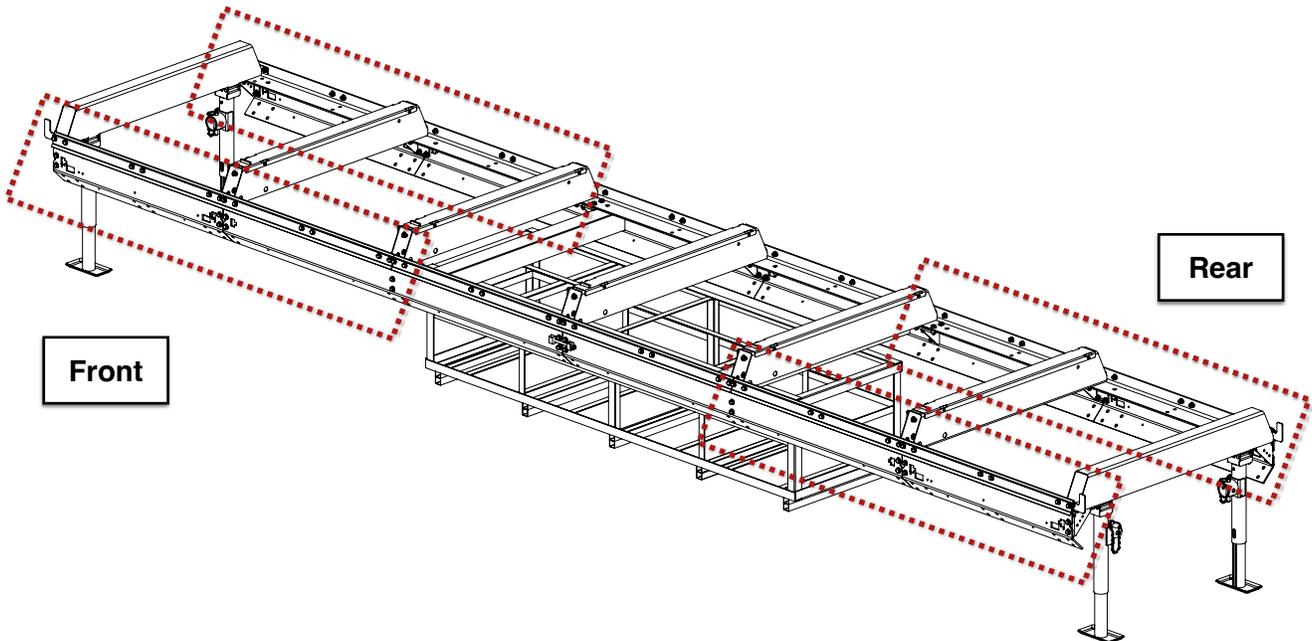


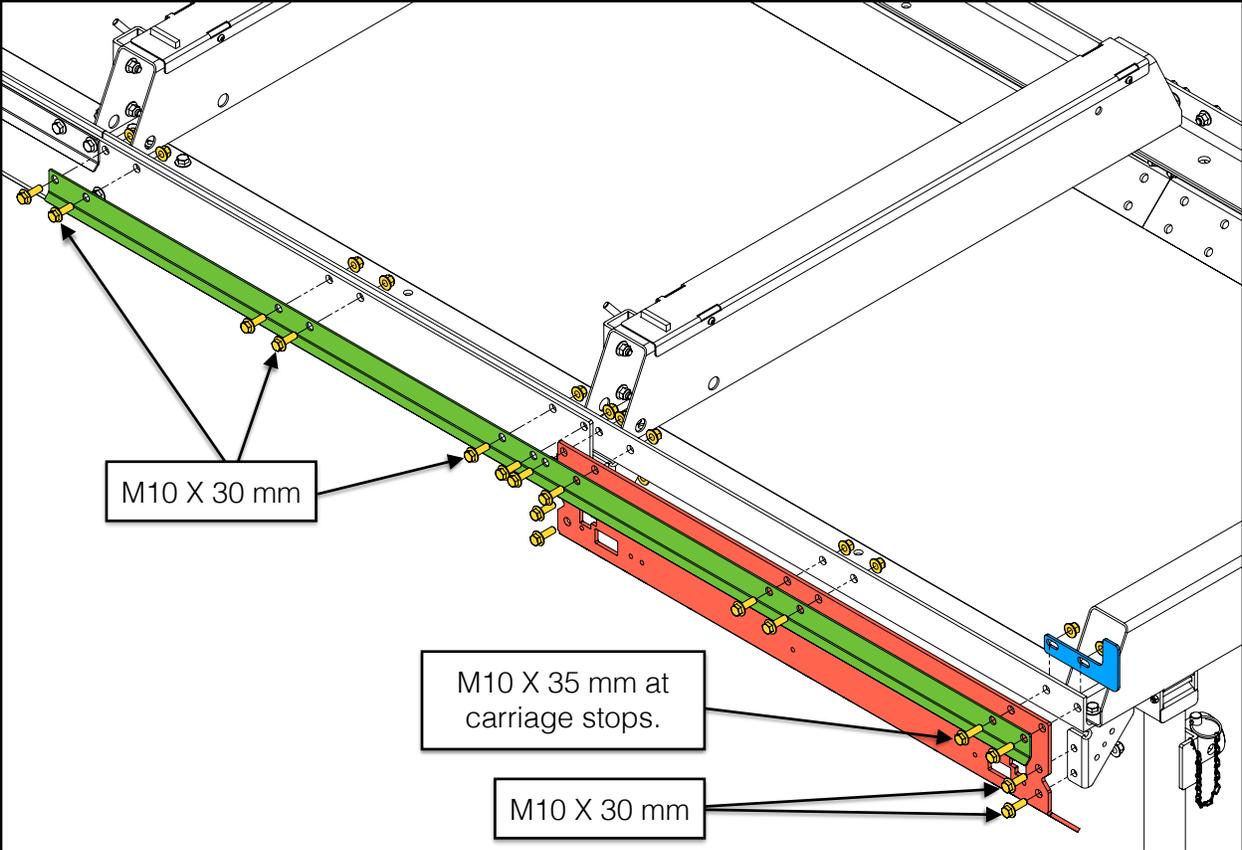


9. SHORT SIDE PLATES, CARRIAGE STOPS

Using the hardware listed below, install the short side plate and carriage stops. The M10 X 35 mm bolts are used at the 4 carriage stop locations. Tighten all of the side plate bolts only when instructed. The carriage stops can be fully adjusted once the sawhead is back on the track.

56x	M10 X 30 mm Flanged Hex Bolt		4x	Short Side Plate	
8x	M10 X 35 mm Flanged Hex Bolt		4x	Carriage Stop	
64x	M10 Flanged Lock Nut		4x	Anti-Tip Rail	

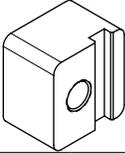
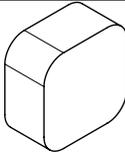
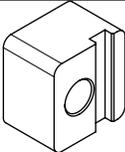


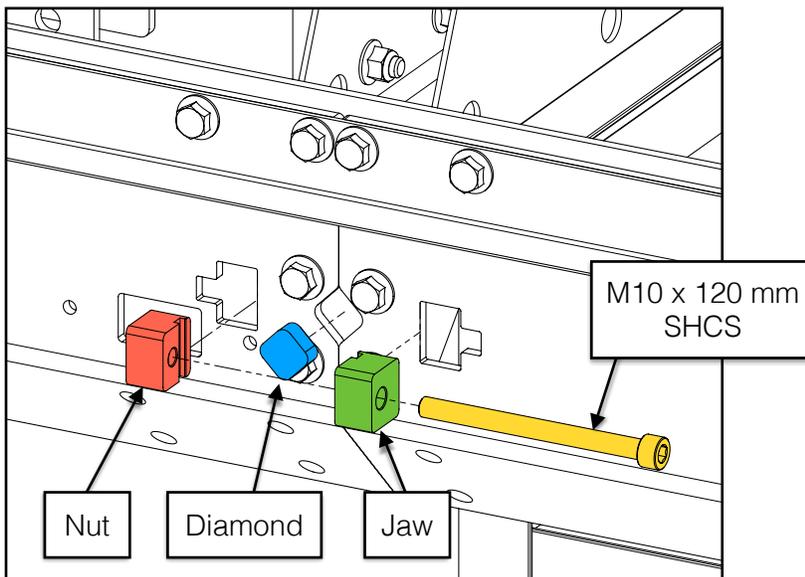
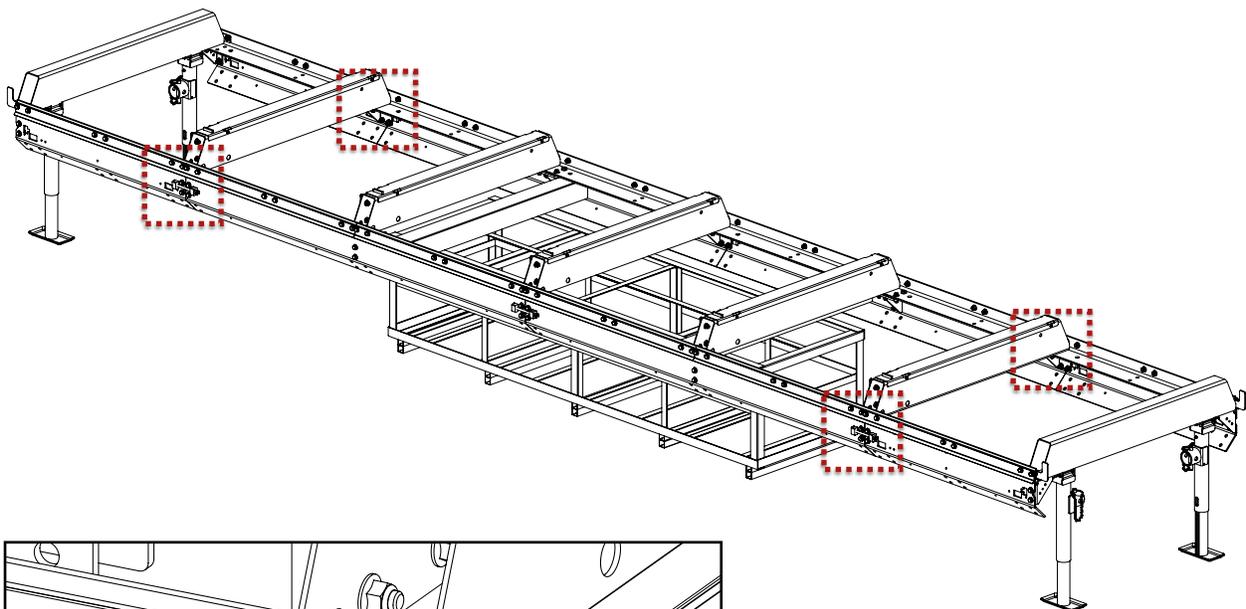




10. SIDE PLATE-TO-RAIL OFFSET & BOLT TORQUING

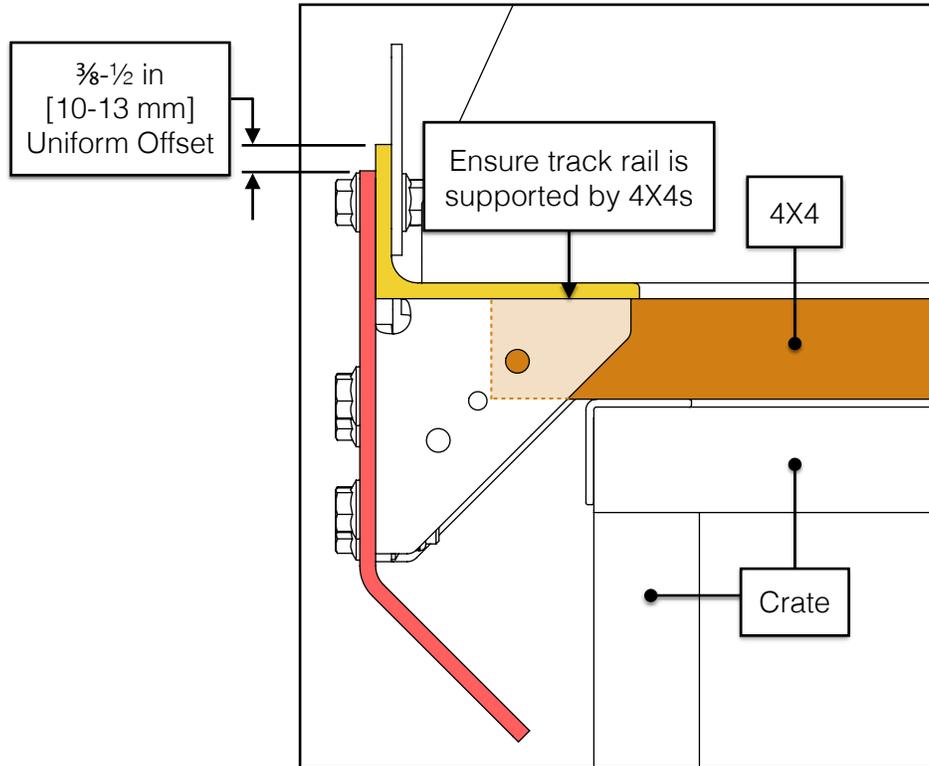
Using the hardware listed below, install the centre side alignment hardware. Tighten the M10 X 120 mm Socket Head Cap Screws to close the gap between the long side plates.

4x	M10 X 120 mm Socket Head Cap Screw		4x	Side Plate Alignment Nut	
4x	Side Plate Alignment Diamond		4x	Side Plate Alignment Jaw	





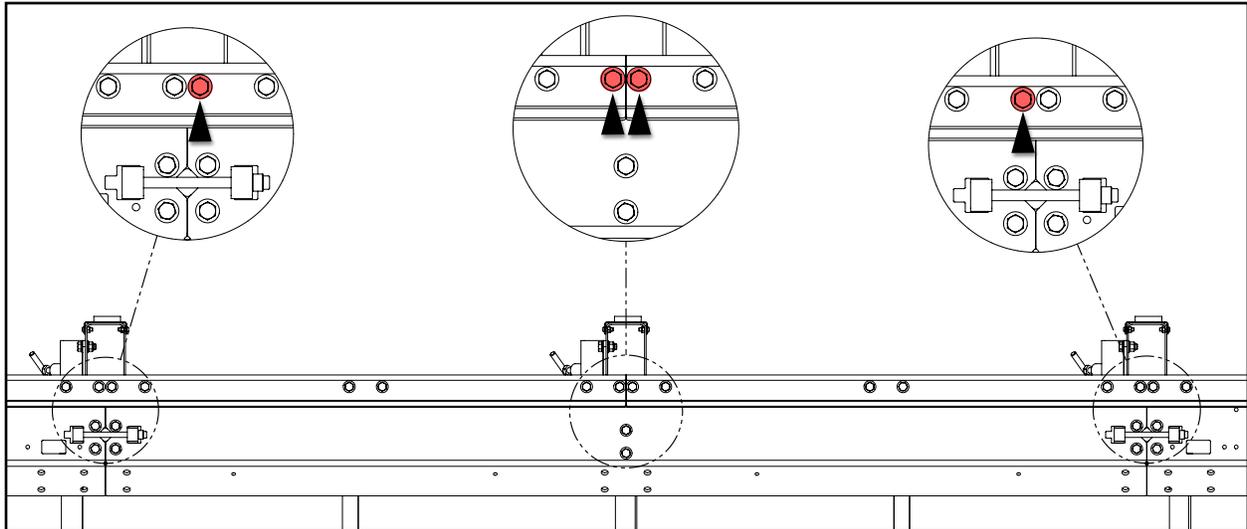
Before torquing the chassis bolts as shown on the following 3 pages, verify there is a $\frac{3}{8}$ - $\frac{1}{2}$ in [10-13 mm] offset between the top of the track rails and the top of the side plates. The offset must be uniform along the entire length of the trailer on both sides.



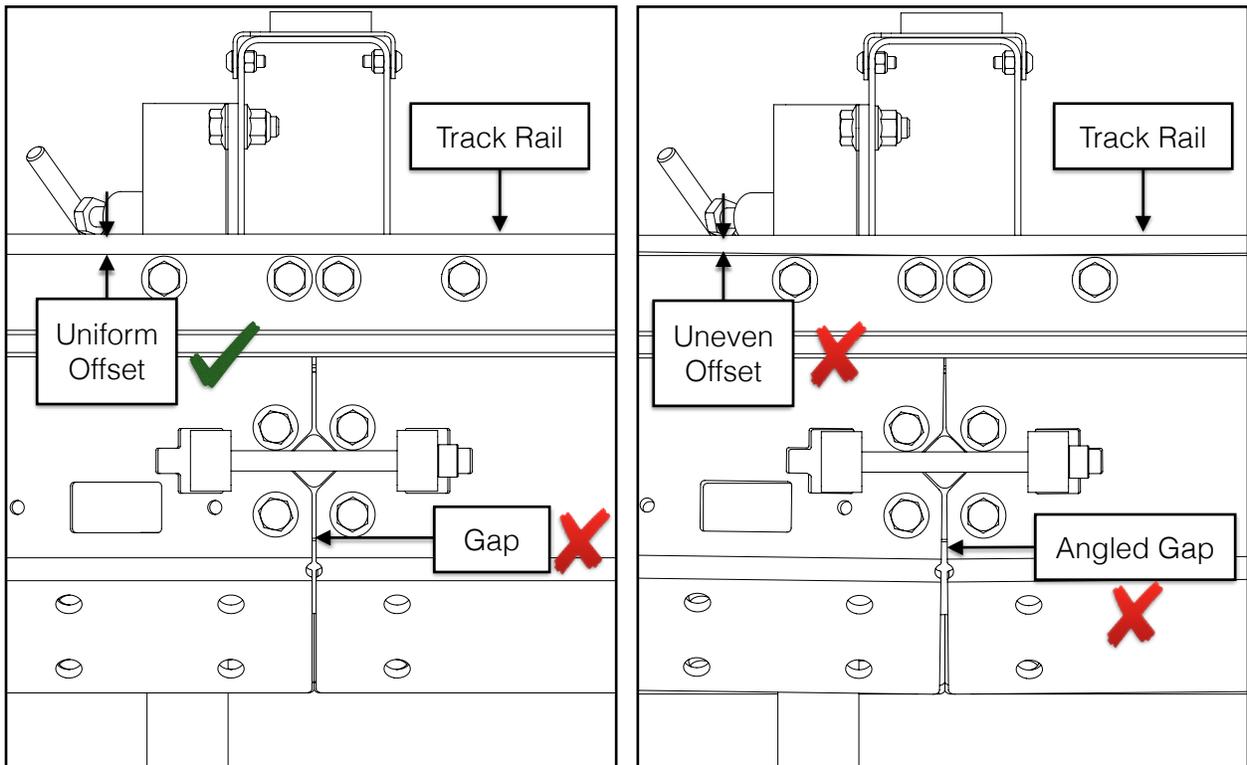
If the offset is not uniform, ensure the track is sitting on the 4X4s and not the crate. The side plates need to hang from the rails unobstructed, with only the force of gravity pulling them down.



Ensuring the side plate-to-rail offset is uniform, tighten and torque *only* the four (4) highlighted bolts securing the long side plates. Do this for both sides of the trailer.



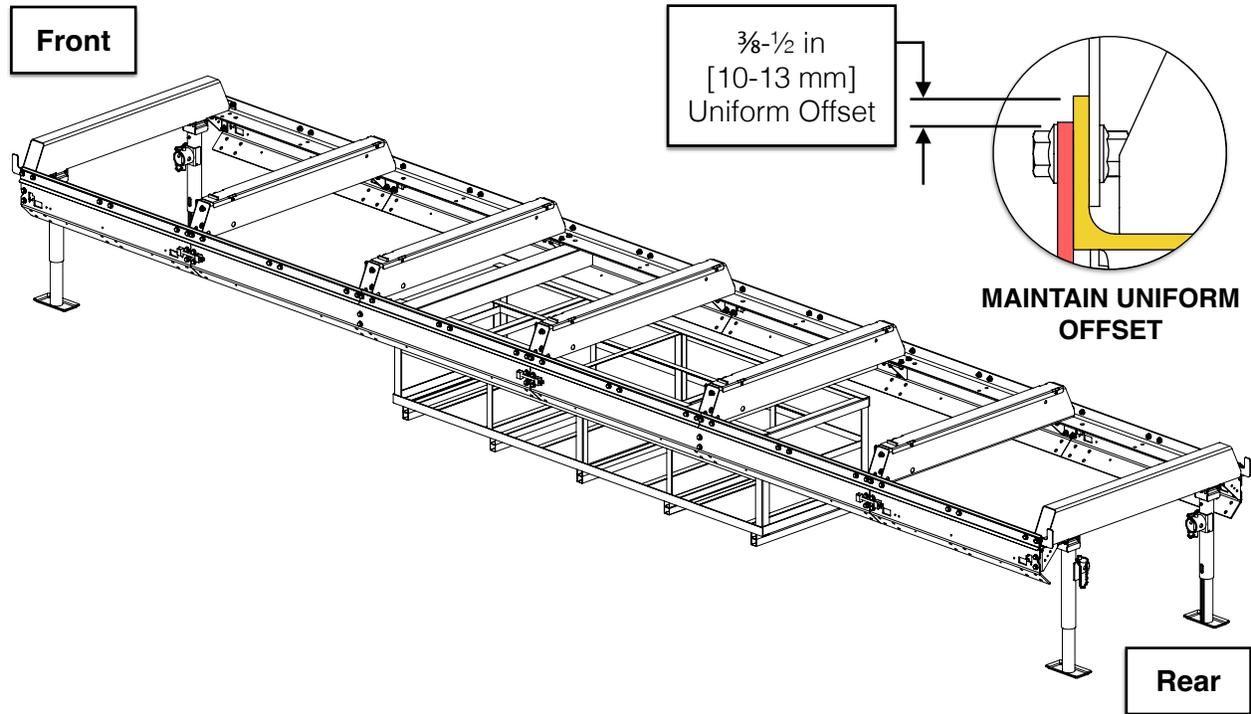
With the long side plate secured in place, note the gaps (if any) between the short side plates and the long side plates.



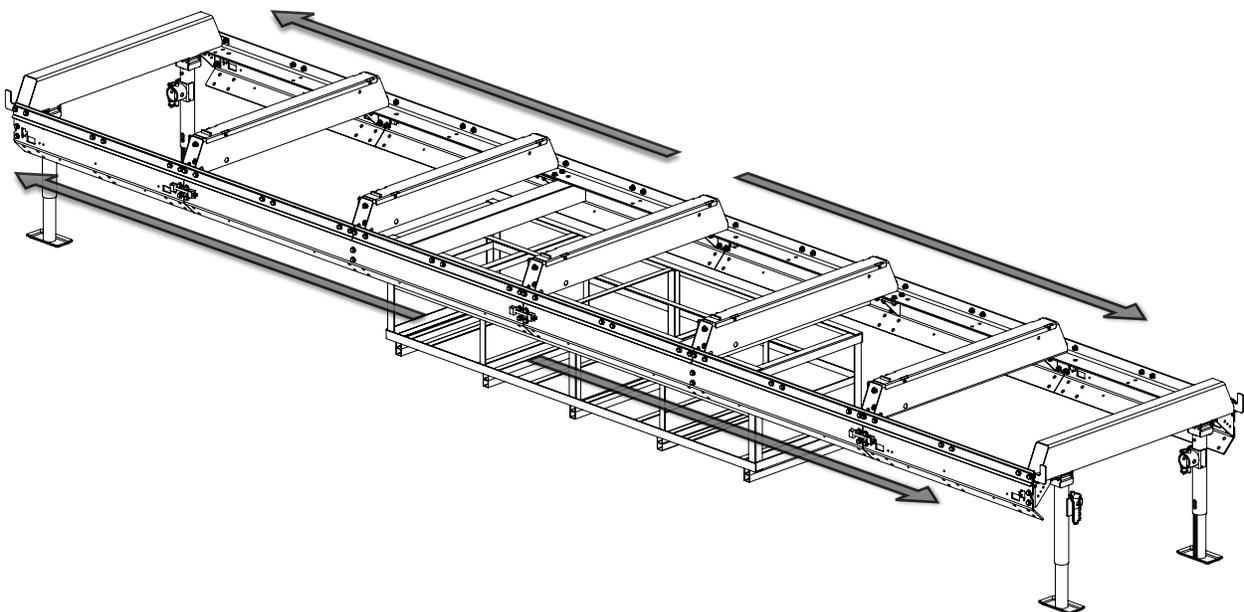
If there are gaps, they can be closed by tightening the M10 X 120 mm Socket Head Cap Screw. Tighten all four (4) M10 X 120 mm Socket Head Cap Screws to close the gaps.



Remember to maintain a uniform offset between the top of the track rails and the top of the side plates when tightening the alignment hardware.

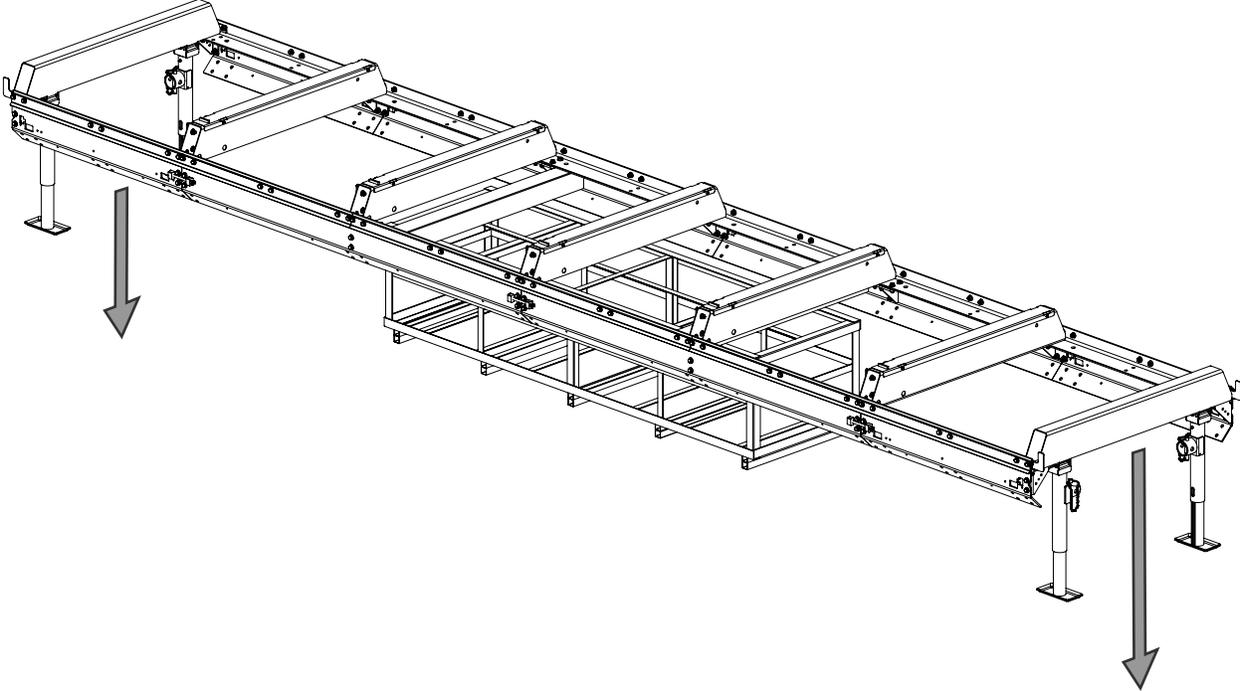


While maintaining a uniform side plate-to-rail offset, torque the remaining bolts per the table in section, ***BOLT TORQUE SPECIFICATIONS***, starting from the centre and working towards the outer ends. Ensure the track is straight, level, and square during this procedure.





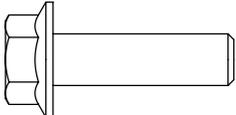
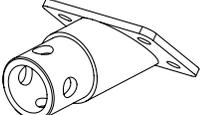
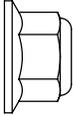
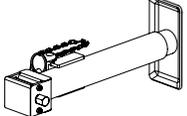
With all of the bolts now tightened, lower the jacks so that the assembly is resting entirely on the crate.

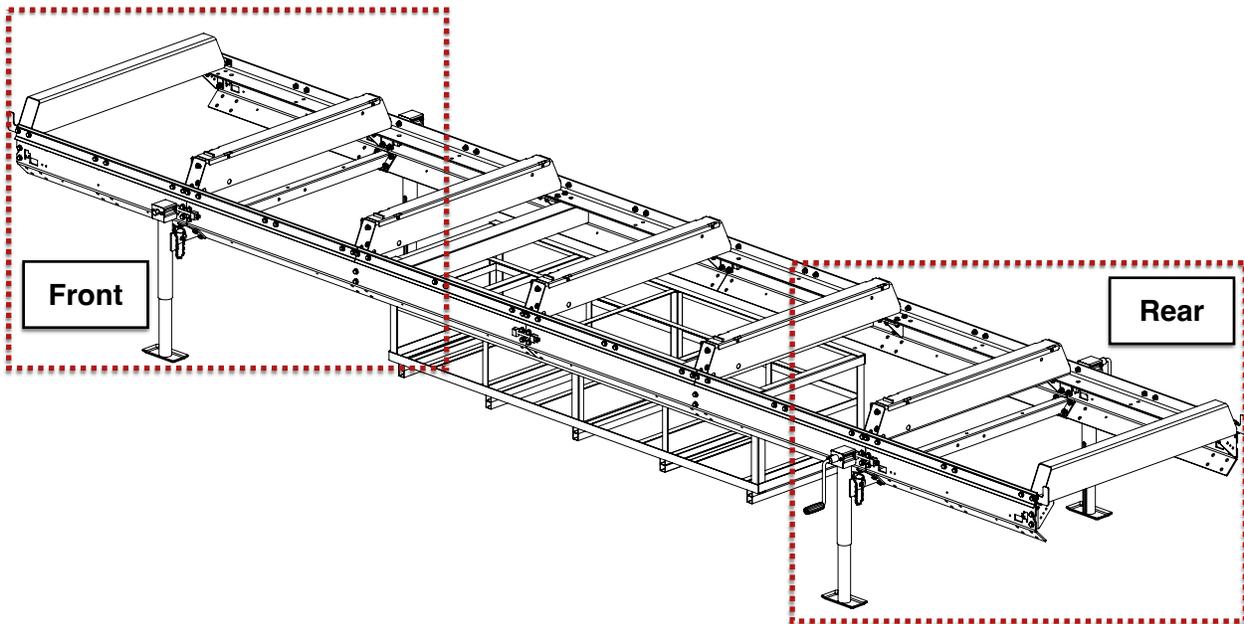


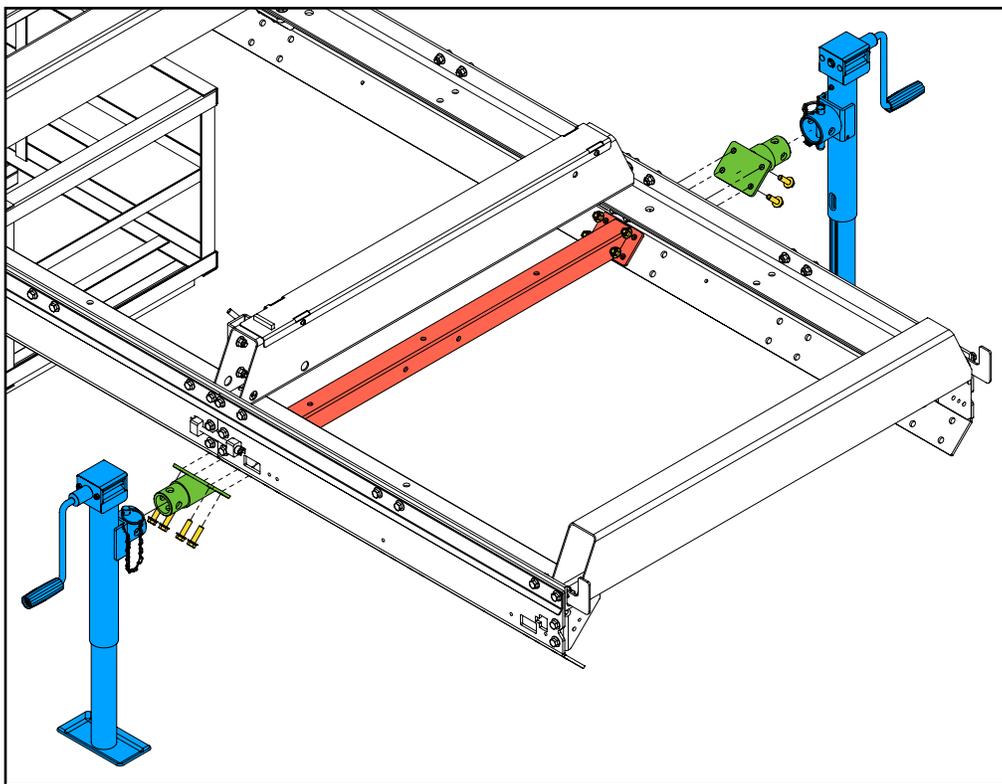
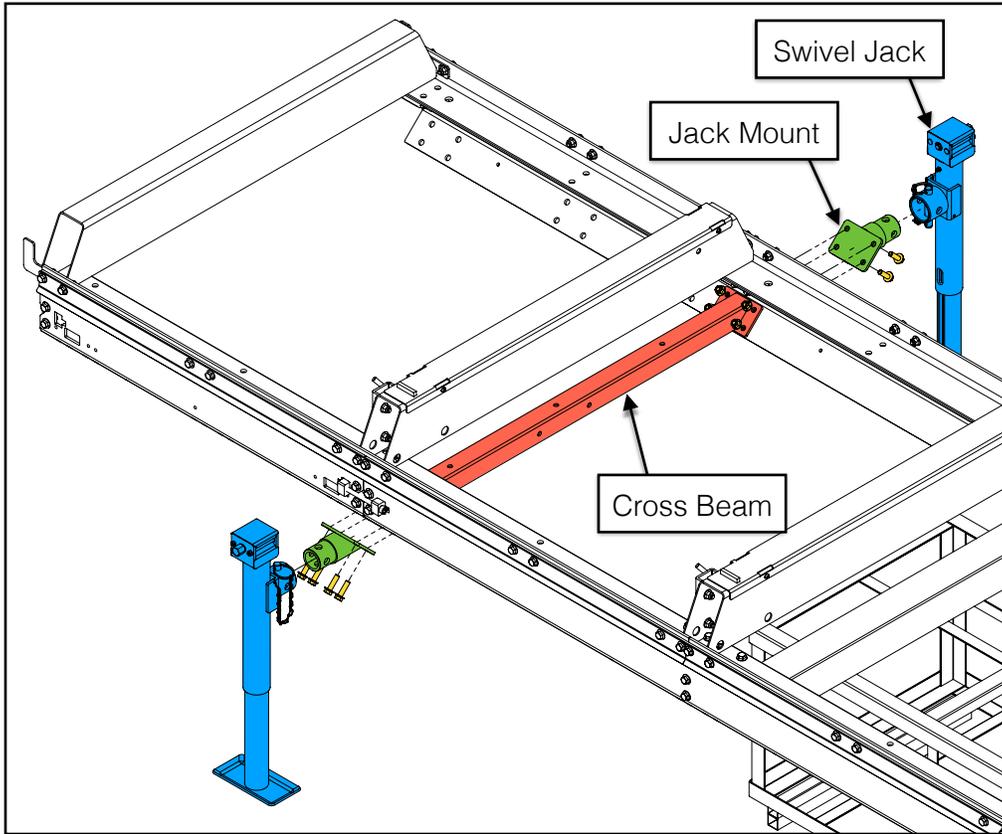


11. CROSS BEAMS, JACK MOUNTS [ENDS]

Using the hardware listed below, install the front and rear jack mounts including 1 cross beam with each pair of mounts. Tighten all bolts. Install swivel jacks on the jack mounts.

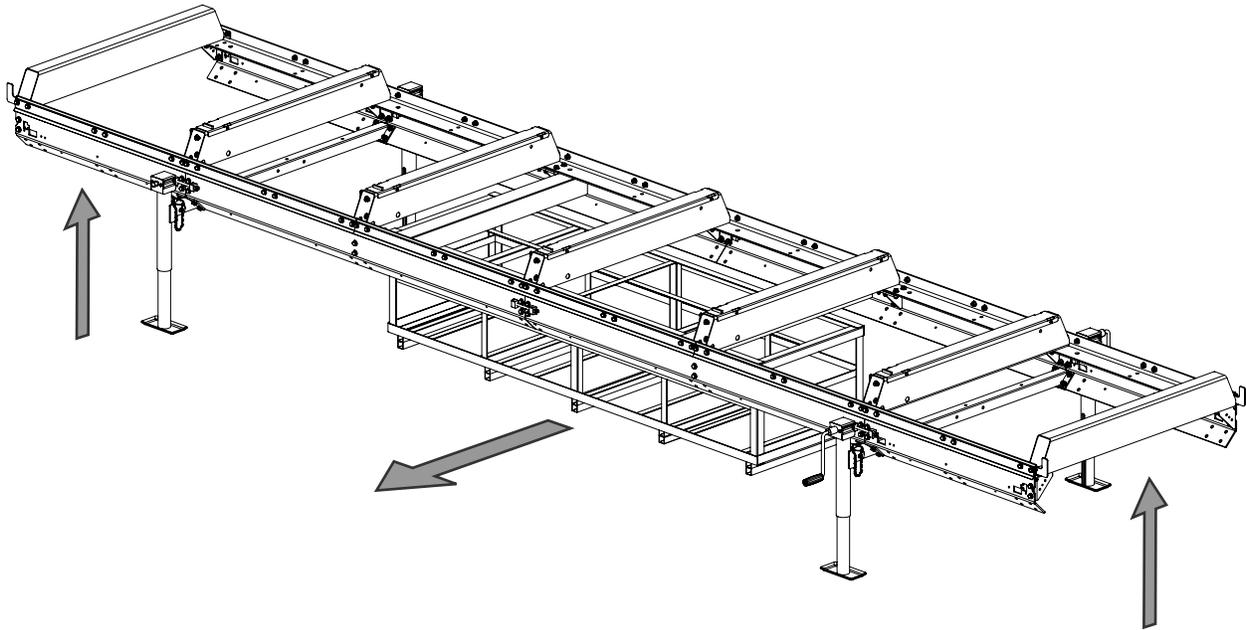
16x	M10 X 35 mm Flanged Hex Bolt		4x	Jack Mount	
16x	M10 Flanged Lock Nut		4x	Swivel Jack	
2x	Cross Beam		1x [3x]	Swivel Jack Handle	







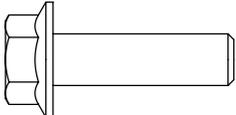
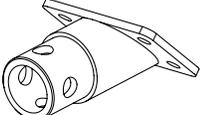
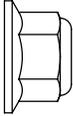
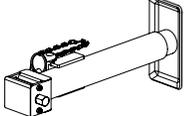
Next, raise the assembly as high as the jacks stands will permit. Pull the crate out from under the assembly once it is sufficiently high enough. It may be necessary to place a block of wood under each jack foot to achieve a sufficient height.

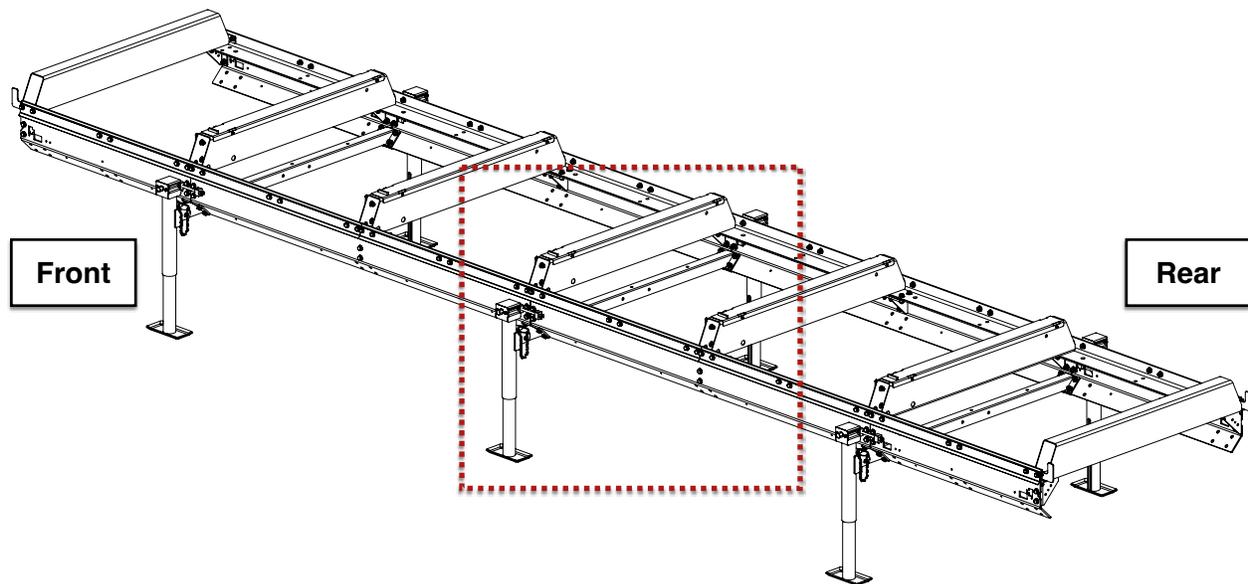


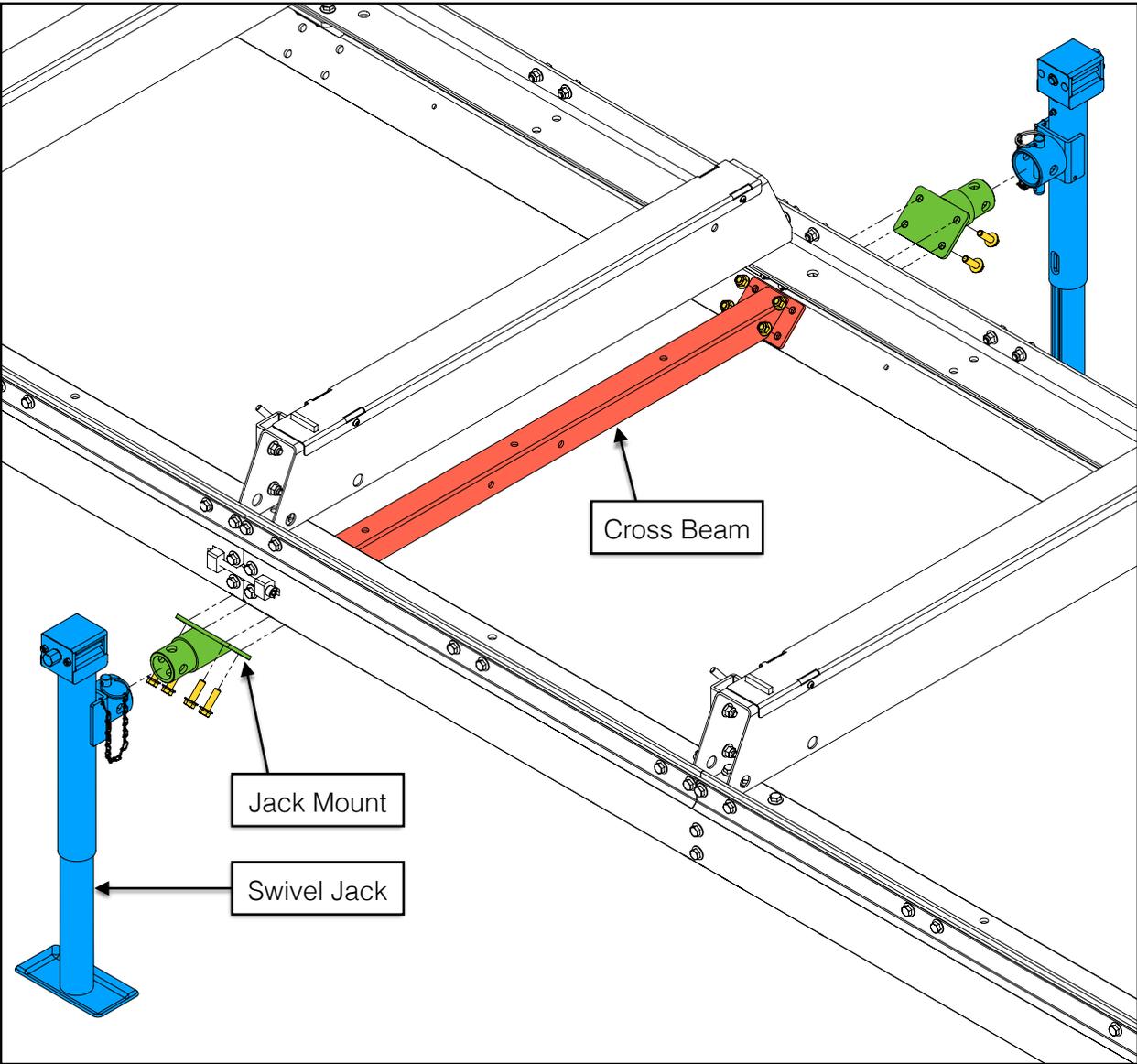


12. CROSS BEAM, JACK MOUNTS [CENTRE]

Using the hardware below, install the centre cross beam and jack mounts. Level the trailer on all six swivel jacks. Tighten all the bolts.

8x	M10 X 35 mm Flanged Hex Bolt		2x	Jack Mount	
8x	M10 Flanged Lock Nut		2x	Swivel Jack	
1x	Cross Beam		1x [3x]	Swivel Jack Handle	

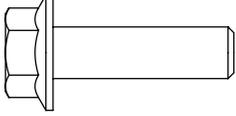
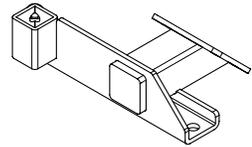
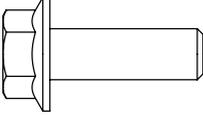
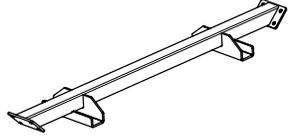
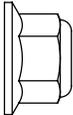
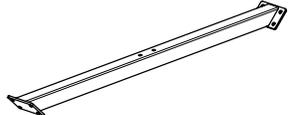
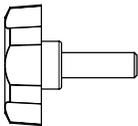
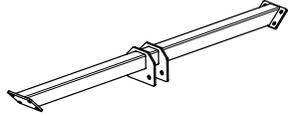
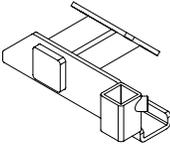
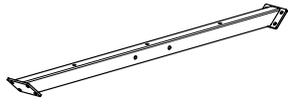


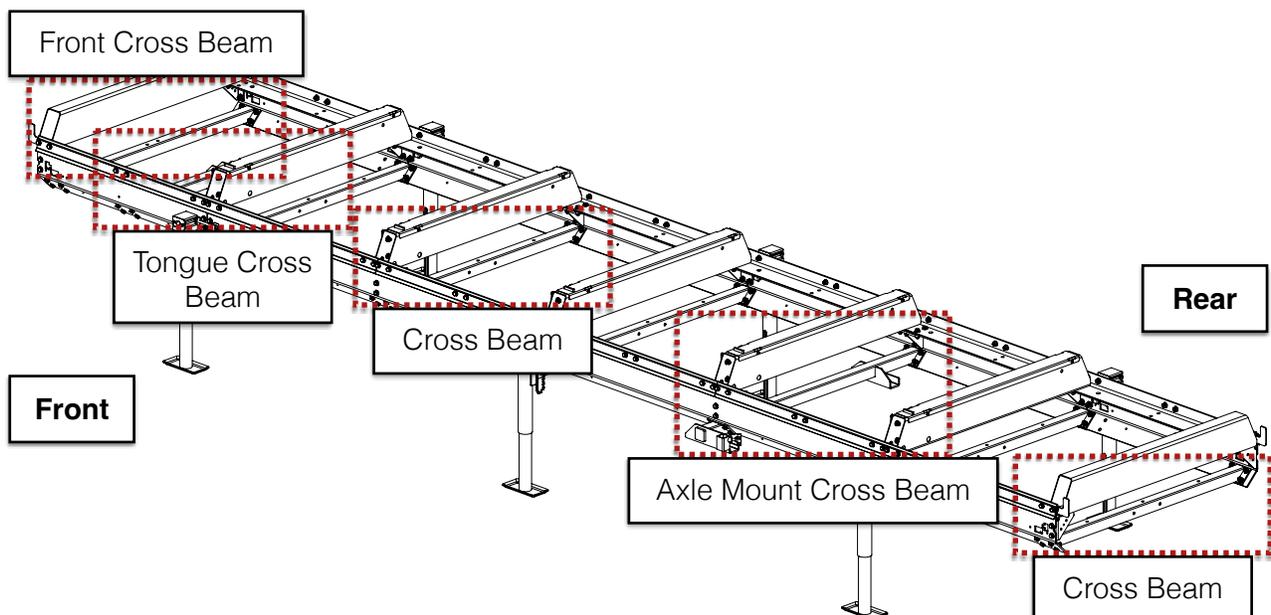


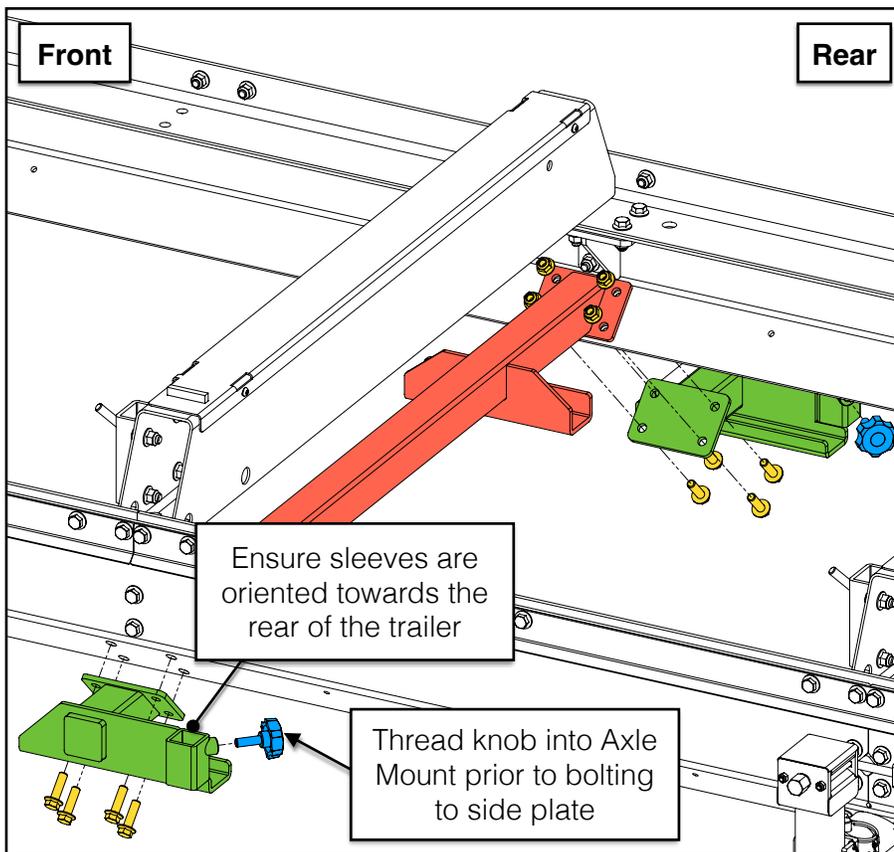
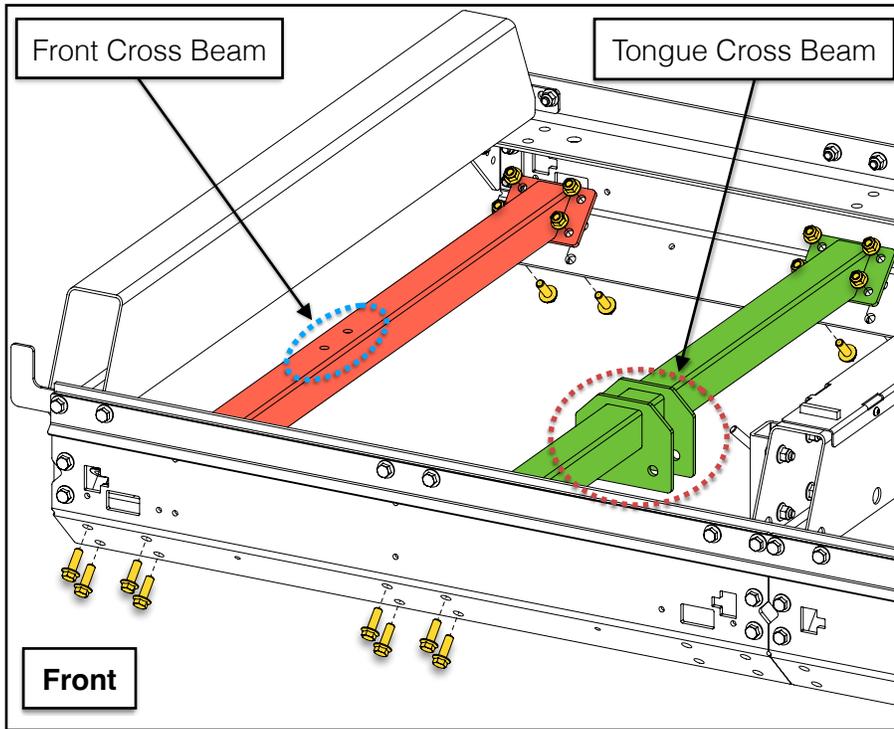


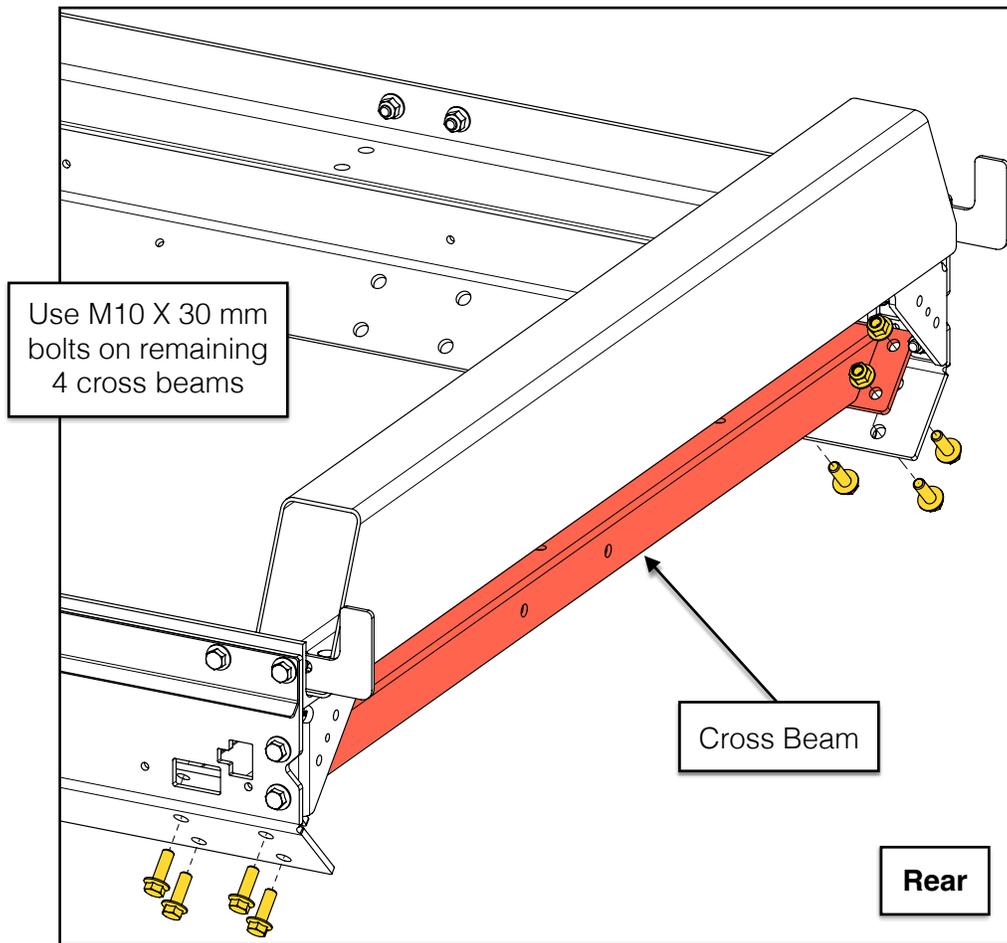
13. CROSS BEAMS, AXLE CROSS BEAM, AXLE MOUNTS

Using the hardware listed below, install the remaining cross beams, the front cross beam (with 2 holes), the tongue cross beam, and axle mount cross beam in the locations shown below. Tighten all bolts.

8x	M10 X 35 mm Flanged Hex Bolt		1x	Axle Mount w/ Fender Adapter [Right]	
32x	M10 X 30 mm Flanged Hex Bolt		1x	Axle Mount Cross Beam	
40x	M10 Flanged Lock Nut		1x	Front Cross Beam	
2x	M10 X 30 mm Knob		1x	Tongue Cross Beam	
1x	Axle Mount w/ Fender Adapter [Left]		2x	Cross Beam	



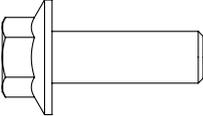
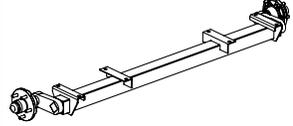
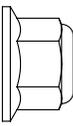
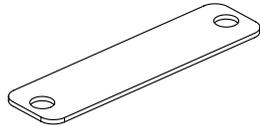


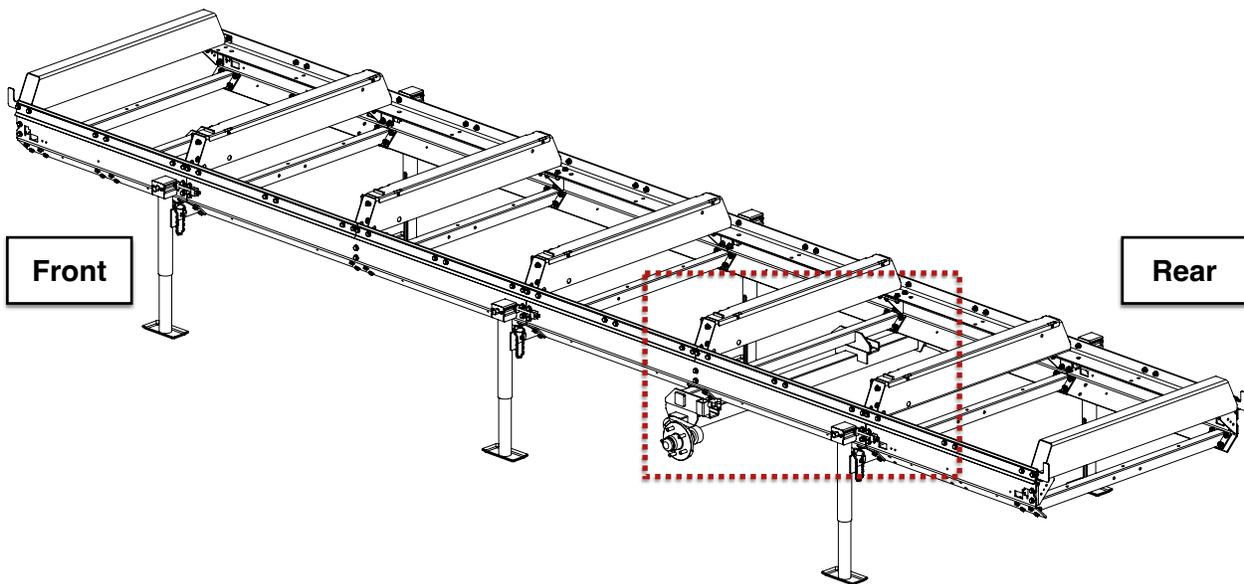




14. AXLES

Using the hardware listed below, install the axles as shown on the next page.

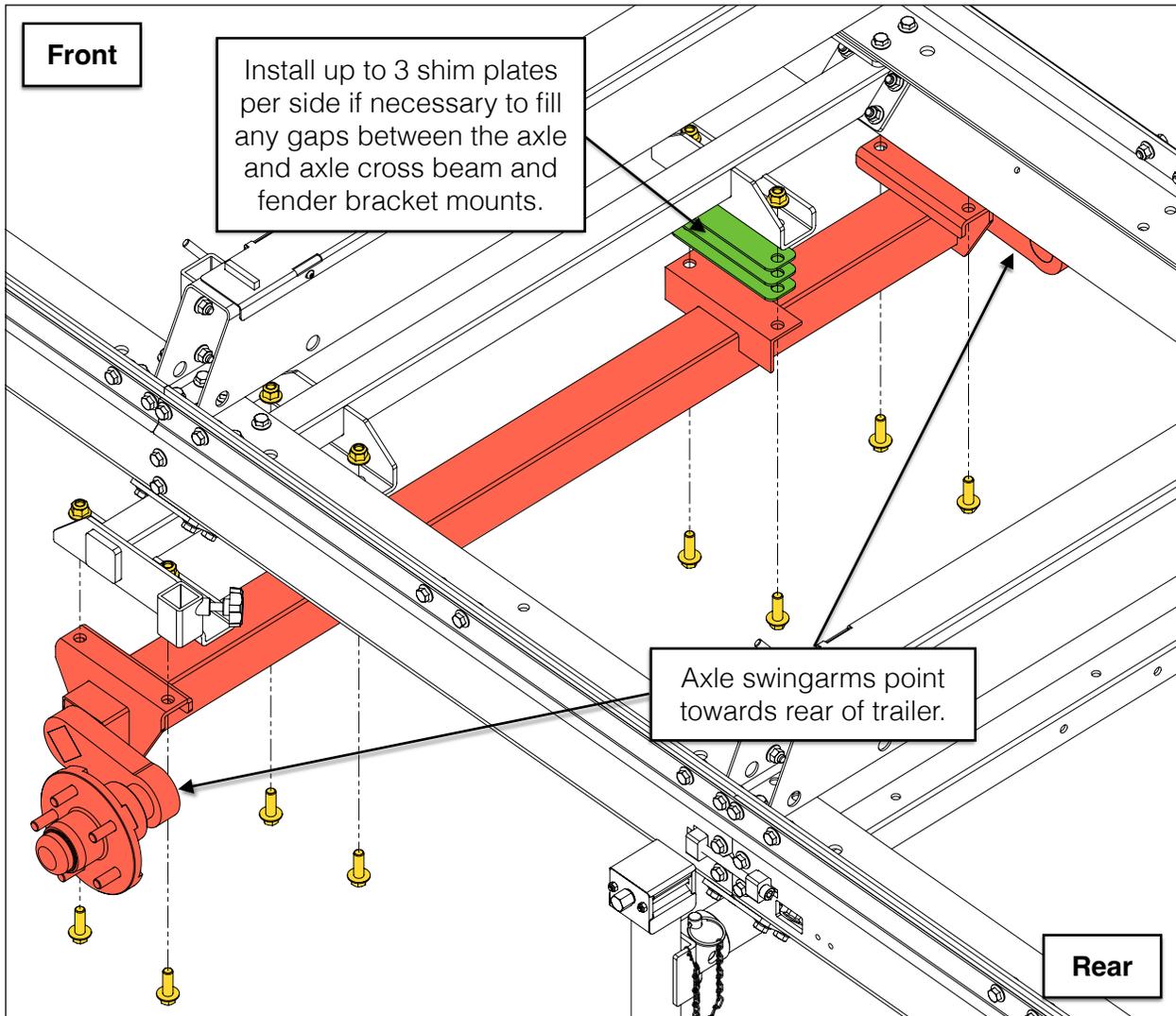
8x	M12 X 35 mm Flanged Hex Bolt		1x	Axle	
8x	M12 Flanged Lock Nut		6x	Axle Shim Plate	





Check for gaps between the axle and fender bracket mounts and axle cross beam. If there are any gaps, use axle shim plates fill the gaps to prevent any flexing of the axle. The shims are not necessary if there are no gaps.

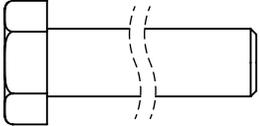
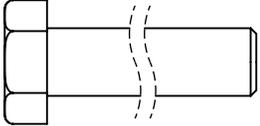
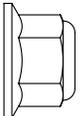
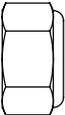
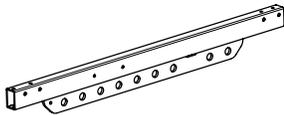
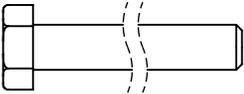
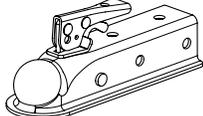
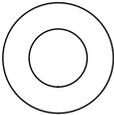
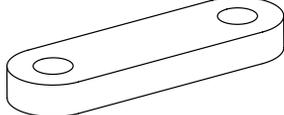
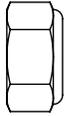
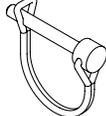
Tighten these bolts to the ***specified torque***.

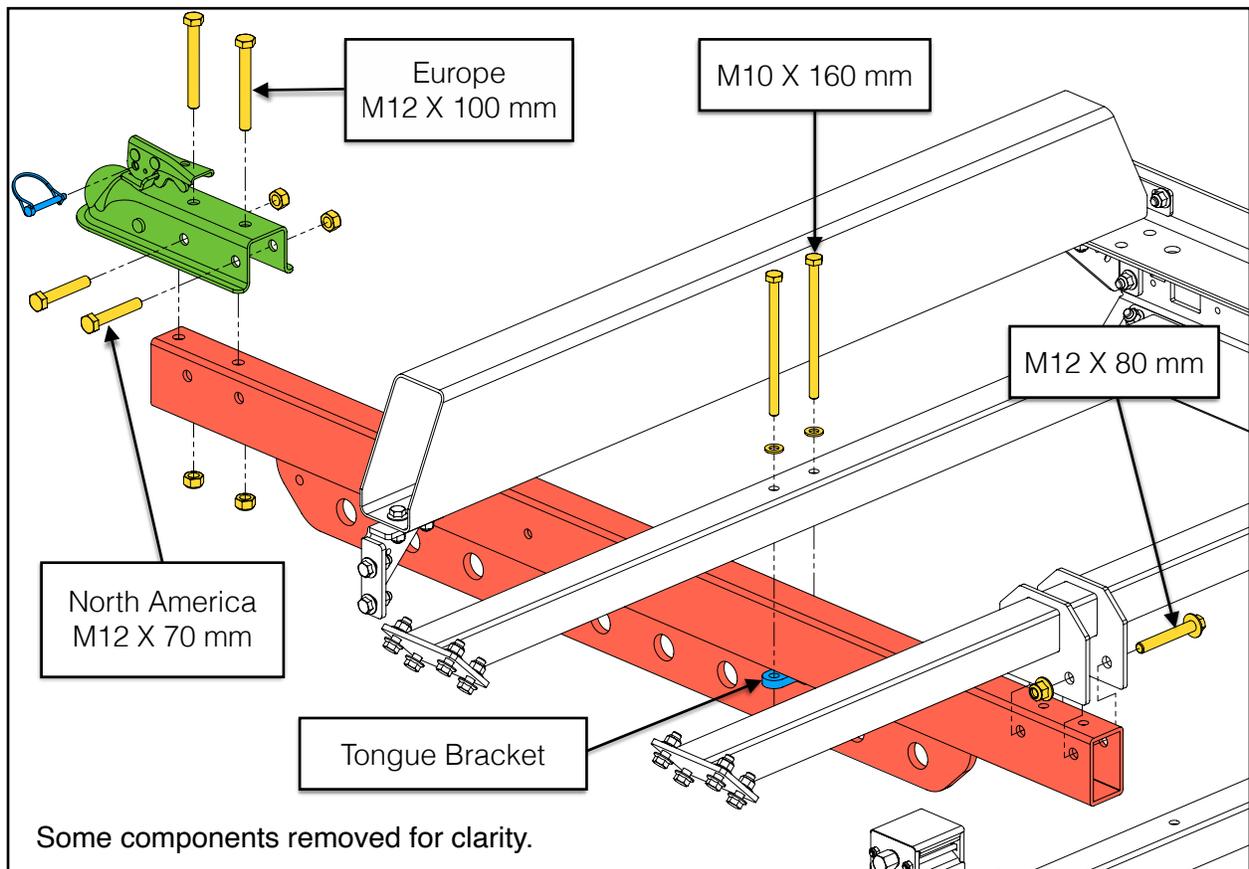
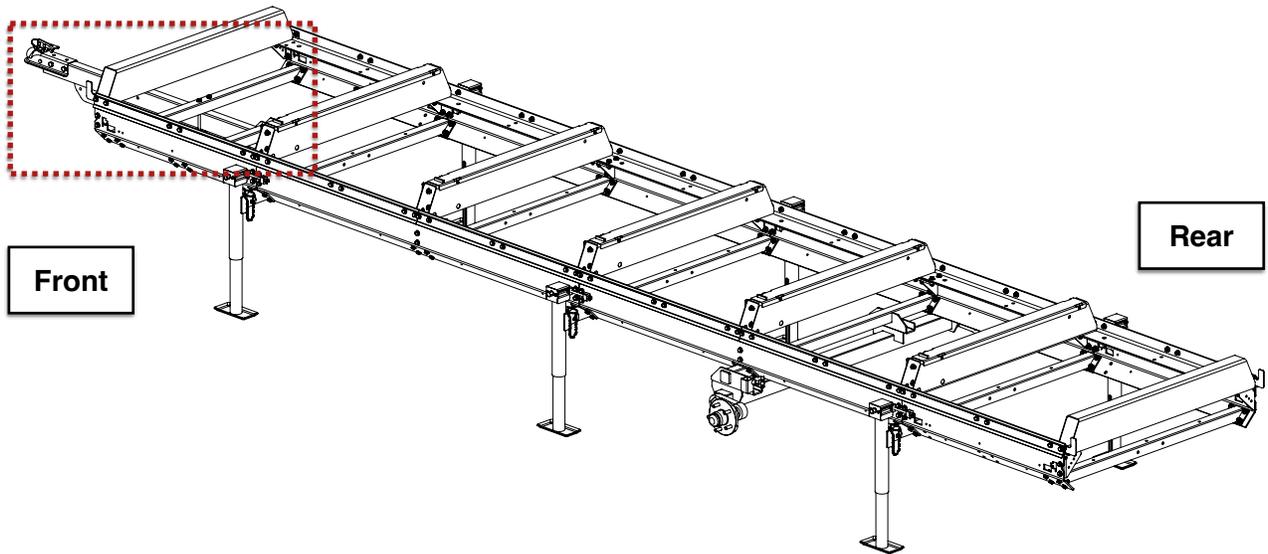




15. TONGUE AND COUPLER

Using the hardware listed below, install the trailer tongue and hitch coupler. Tighten these bolts.

2x	M12 X 100 mm Hex Bolt (Europe Only)		2x	M12 X 80 mm Flanged Hex Bolt	
2x	M12 X 70 mm Hex Bolt (North America)		2x	M12 Flanged Lock Nut	
2x	M12 Lock Nut		1x	Tongue	
2x	M10 X 160 mm Hex Bolt		1x	Hitch Coupler	
2x	M10 Flat Washer		1x	Tongue Bracket	
2x	M10 Lock Nut		1x	Locking Pin	

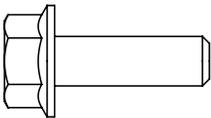
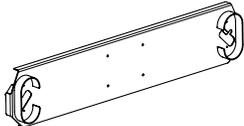
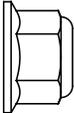
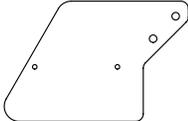
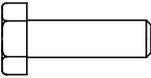
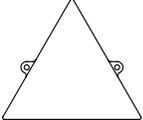
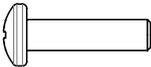


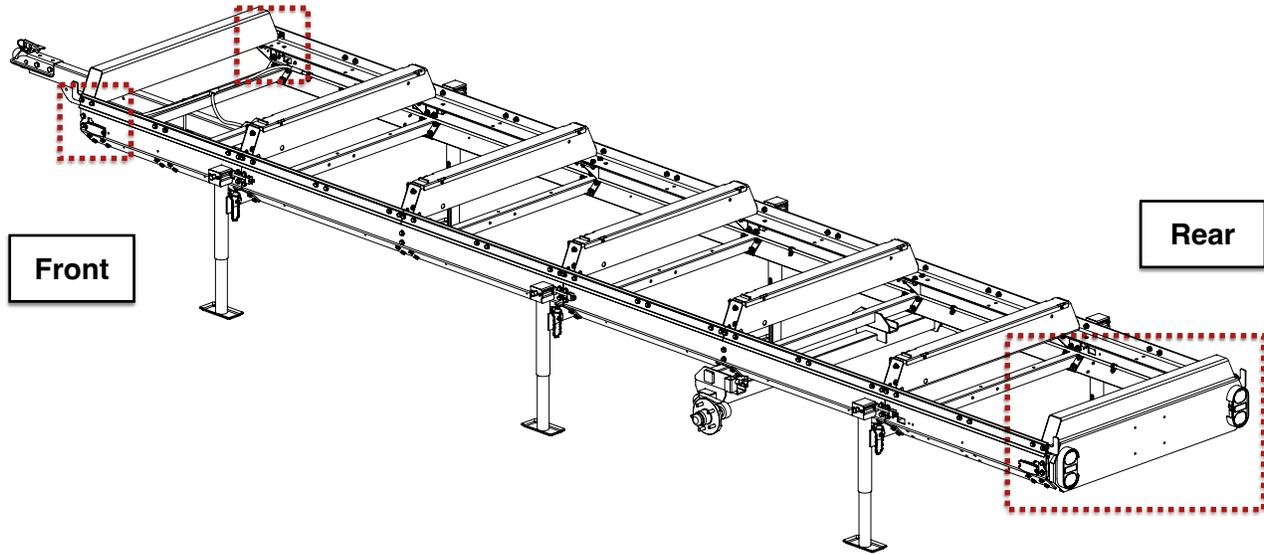


16. LIGHTING

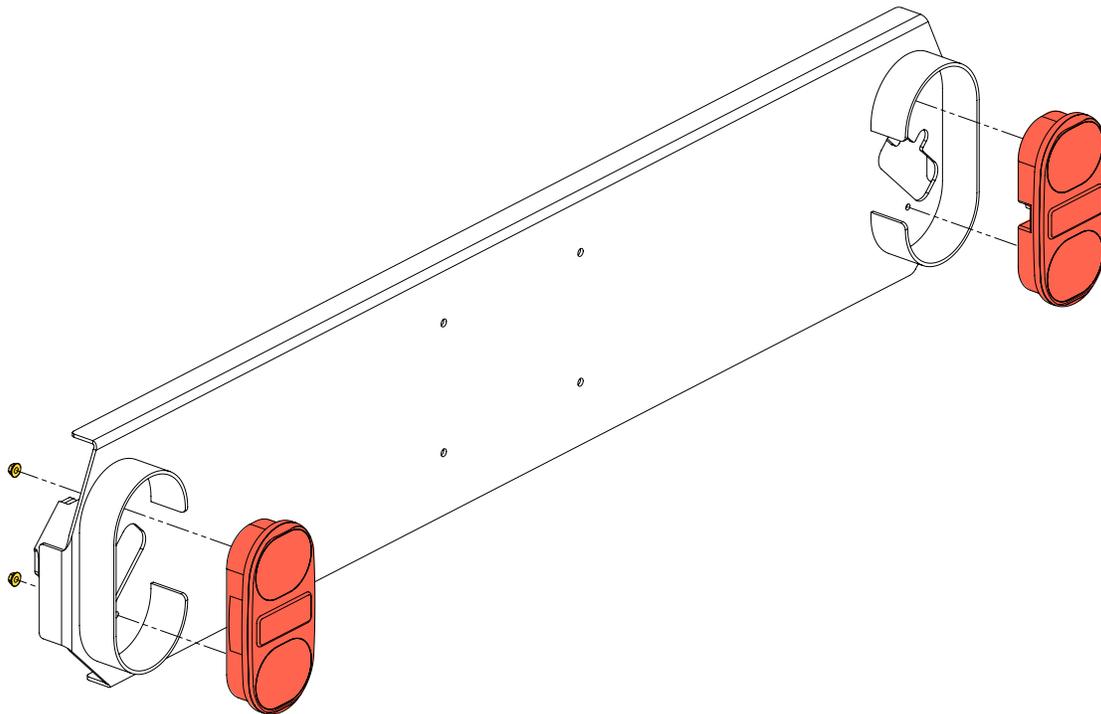
Using the hardware listed below, install the taillight bracket and country appropriate wire harness. Secure tail lights to the taillight bracket using M5 flanged lock nuts before mounting taillight bracket to trailer. Use cable clamps to secure wire harness to side plates down right-side of trailer. Tighten all bolts.

On the European (**EU**) version, install the 4 side reflectors, 2 front reflectors, and 2 rear reflector brackets and reflectors as shown on the following pages. There are no red/amber side lights on the European wire harness like the ones included with the North American (**NA**) version.

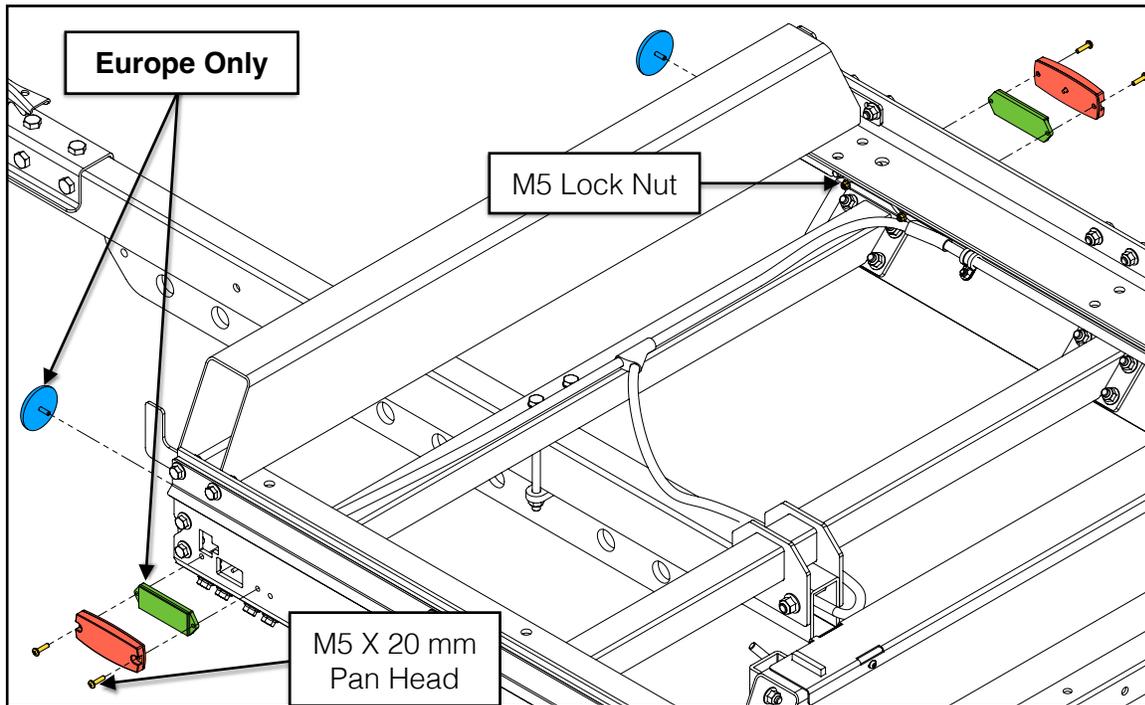
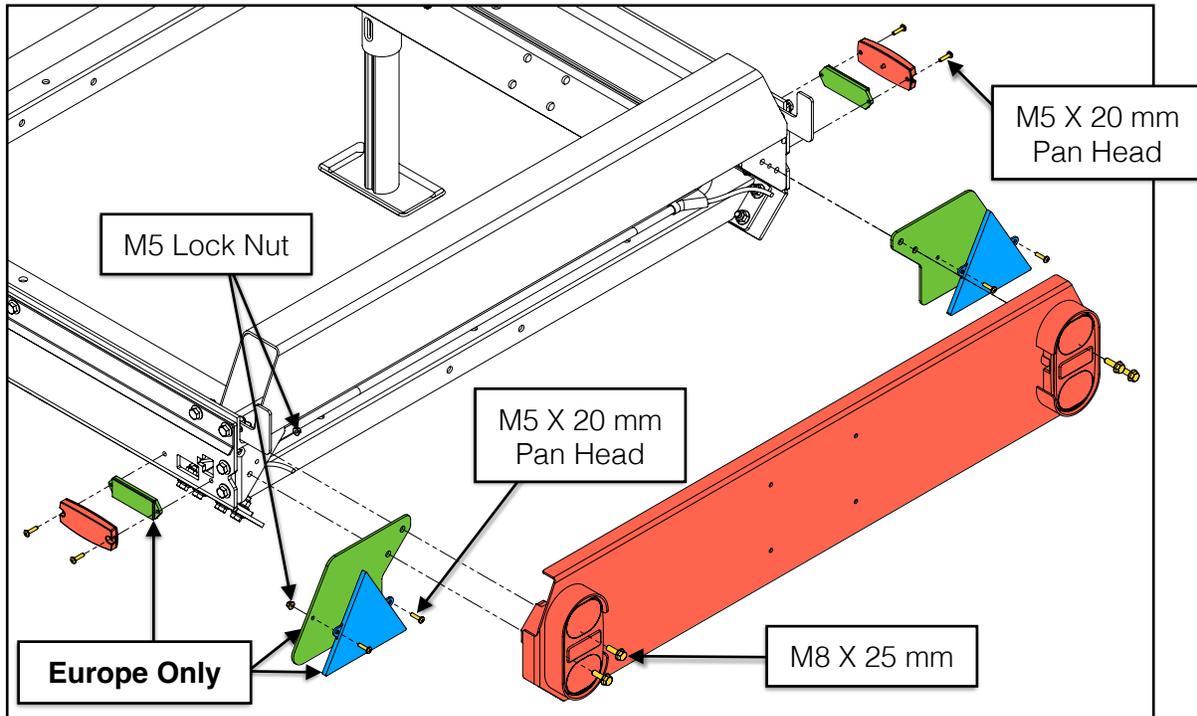
4x	M8 X 25 mm Flanged Hex Bolt		1x	Taillight Bracket	
4x	M8 Flanged Lock Nut		2x	Rear Reflector Bracket (EU Only)	
12x	M6 X 20 mm Hex Bolt		2x	Rear Reflector (EU Only)	
12x	M6 Flat Washer		4x	Side Reflector (EU Only)	
12x	M6 Lock Nut		2x	Front Reflector (EU Only)	
12x	M5 X 20 mm Pan Head Screw (8x NA Only)		12x	Cable Clamp	
14x	M5 Flanged Lock Nut (8x NA Only)		1x	Wire Harness (NA Only)	
			1x	Wire Harness (EU Only)	



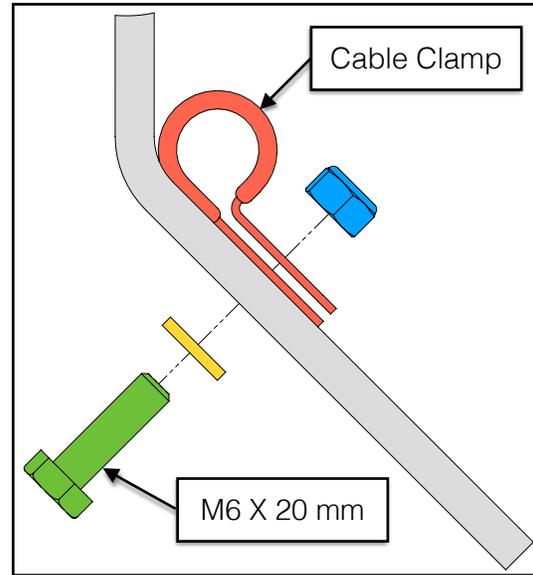
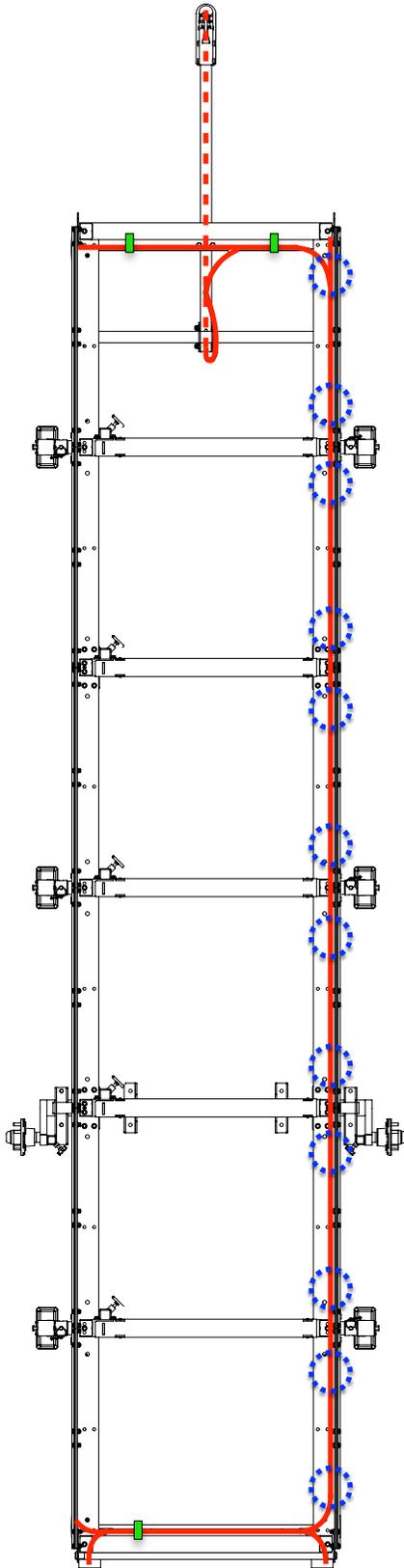
Secure tail lights to the taillight bracket using M5 flanged lock nuts before mounting taillight bracket to trailer.



****Note: Tail lights (North America and Europe) and side lights (North America only) are integral to the wire harness. They are shown exploded for assembly clarity.****



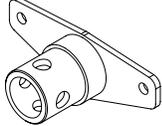
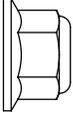
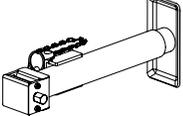
There are 2 cable clamps per short side plate (2) and 4 per long side plate (1) for a total of 12. Cable clamps are installed down the right-hand side of the trailer only (locations circled blue). Use the M6 X 20 mm hex bolts, M6 washers, and M6 lock nuts as shown. This applies to both North American and European models. The wire harness routing is shown below, highlighted red. The excess wire harness should be cable tied to the cross beams, highlighted green.

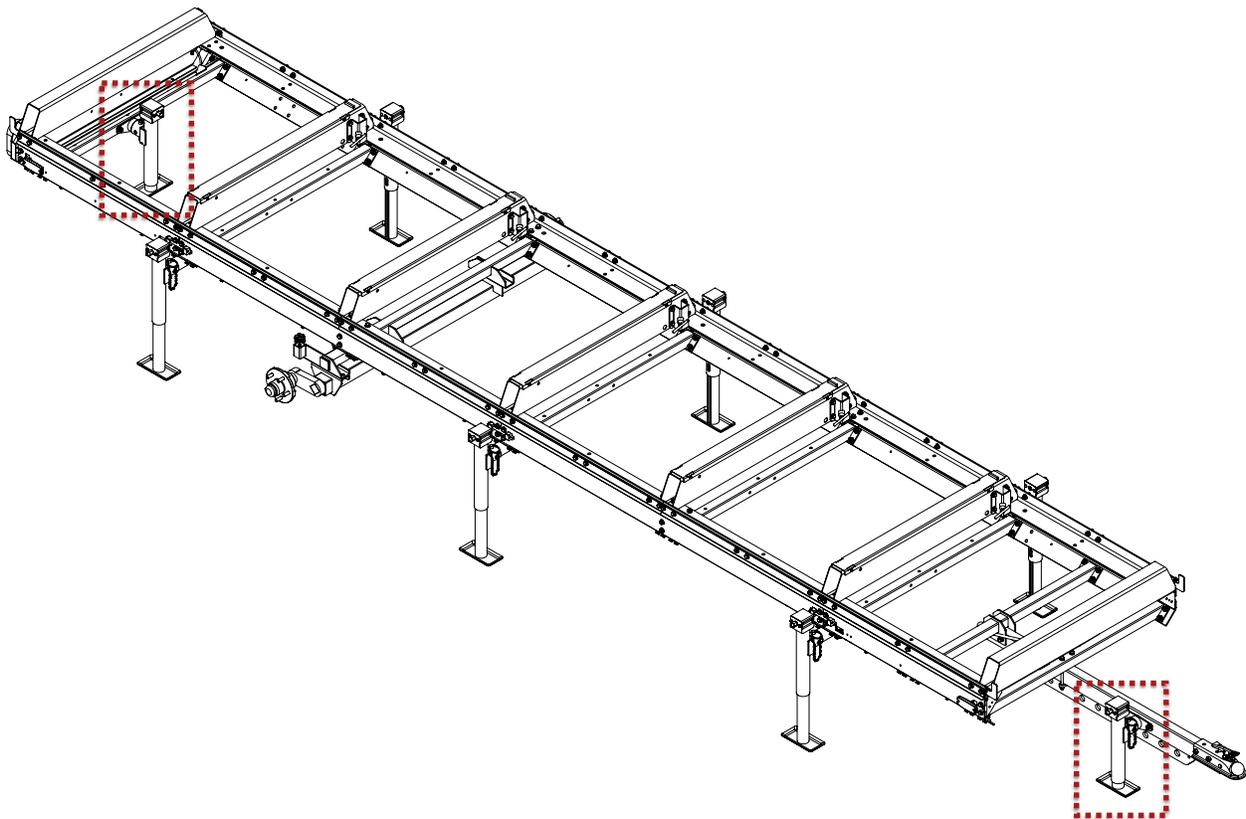


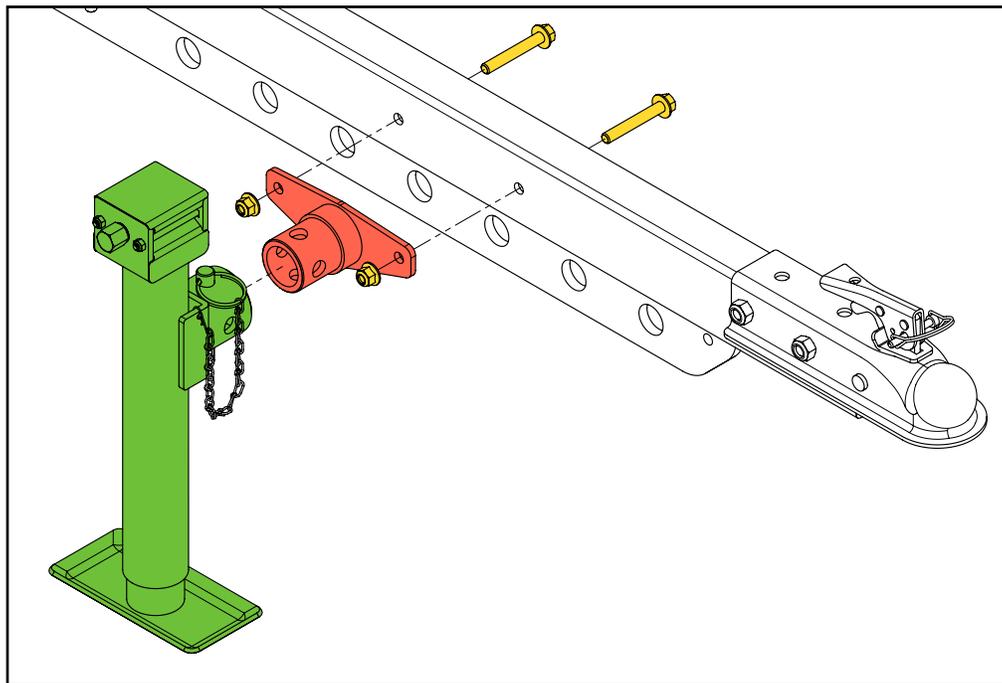
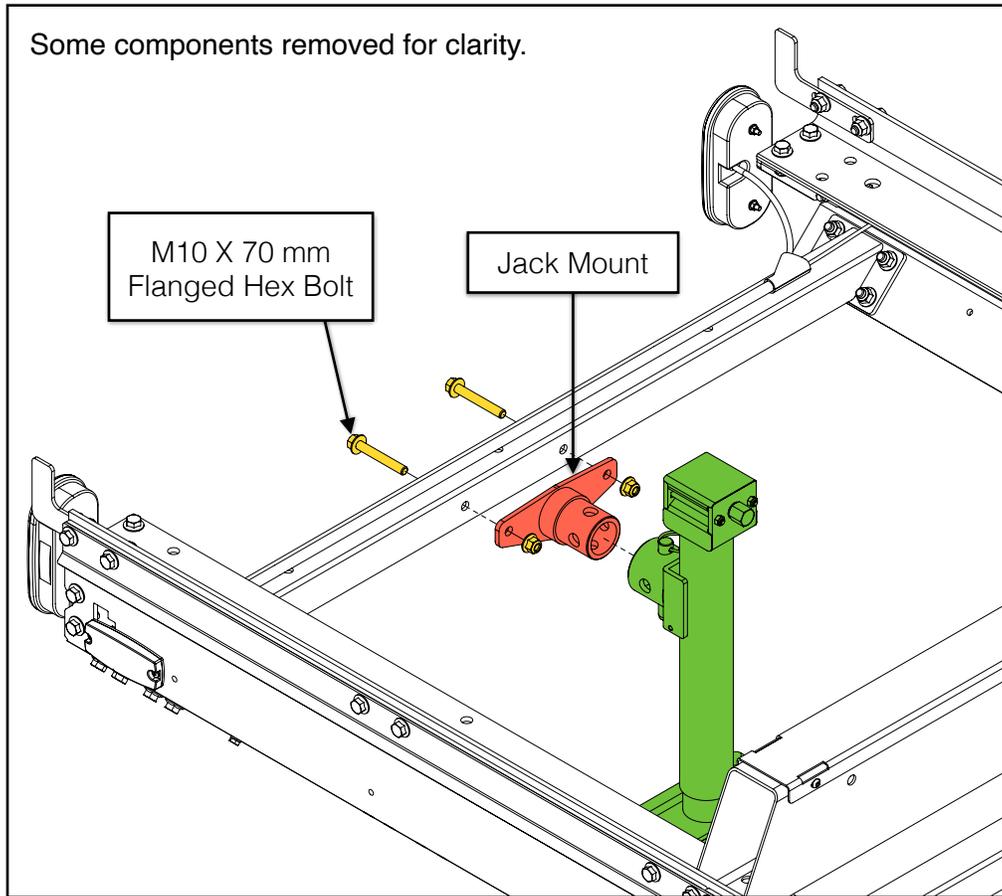


17. ADDITIONAL JACKS

Using the hardware listed below, install the two (2) jack mounts and swivel jacks. Tighten these bolts.

4x	M10 X 70 mm Flanged Hex Bolt		2x	Jack Mount	
4x	M10 Flanged Lock Nut		2x	Swivel Jack	



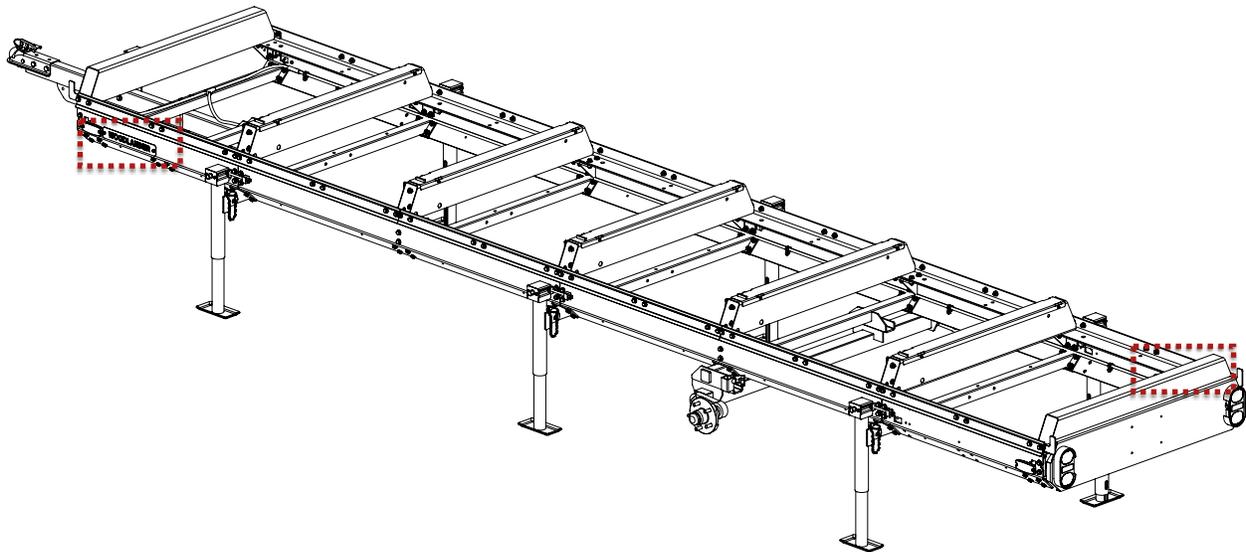


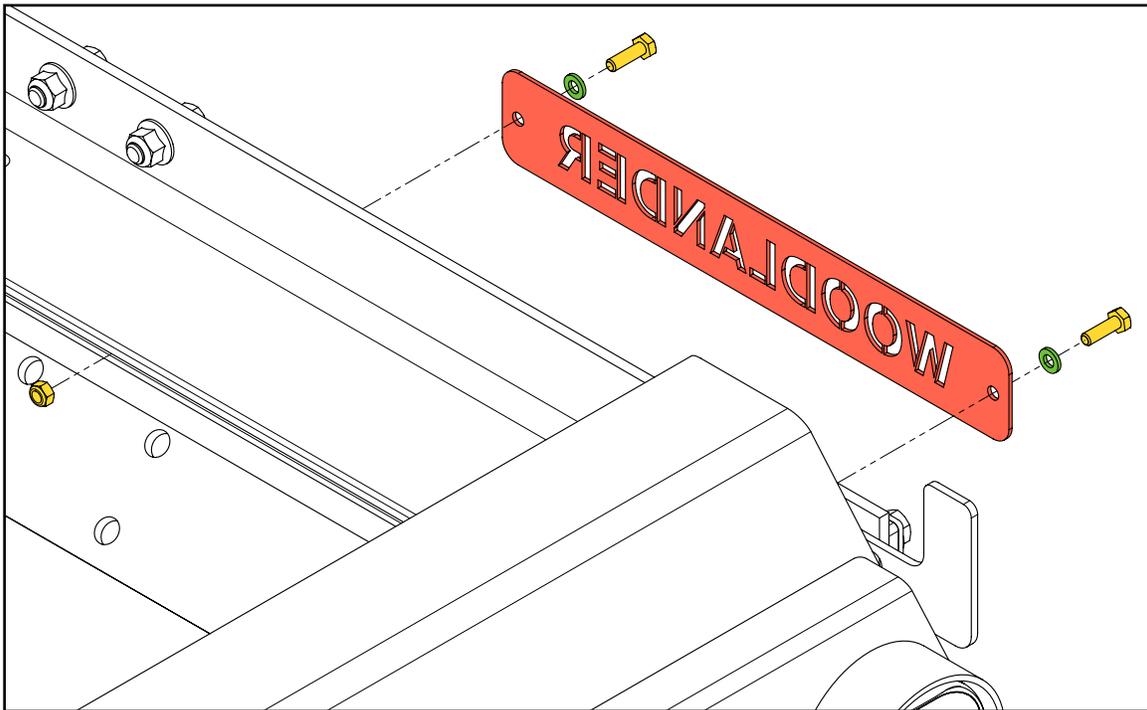
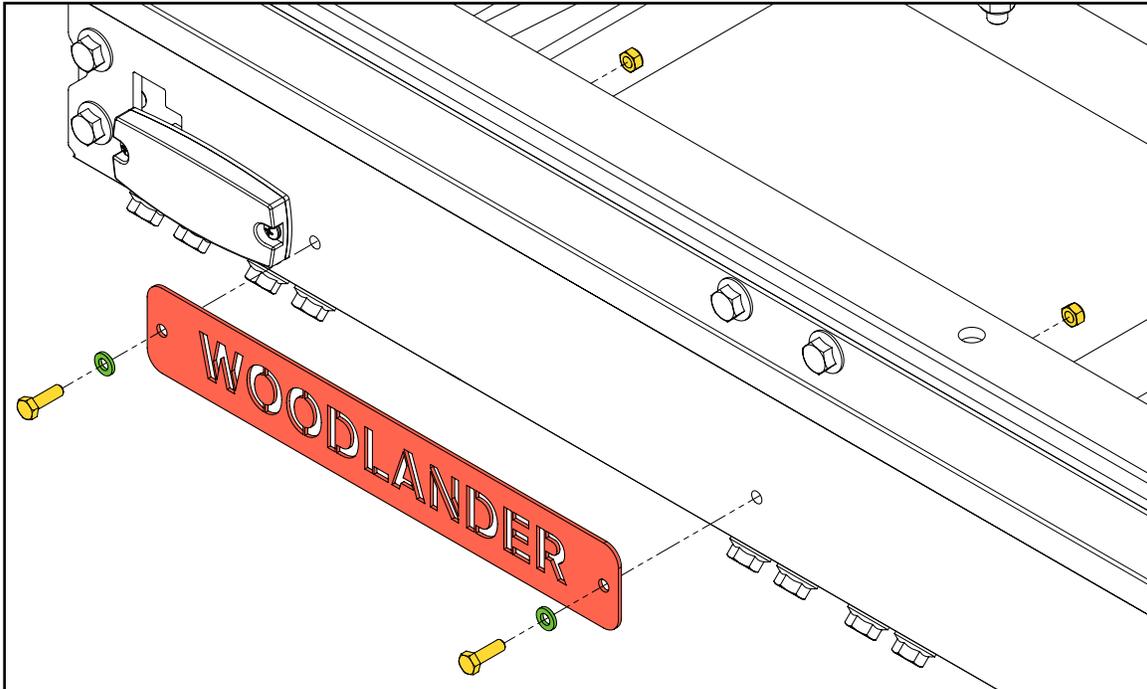


18. NAMEPLATES

Using the hardware listed below, install the two (2) *Woodlander* nameplates as shown.

4x	M6 X 20 mm Hex Bolt		2x	Woodlander Nameplate	
4x	M6 Flat Washer		4x	M6 Lock Nut	



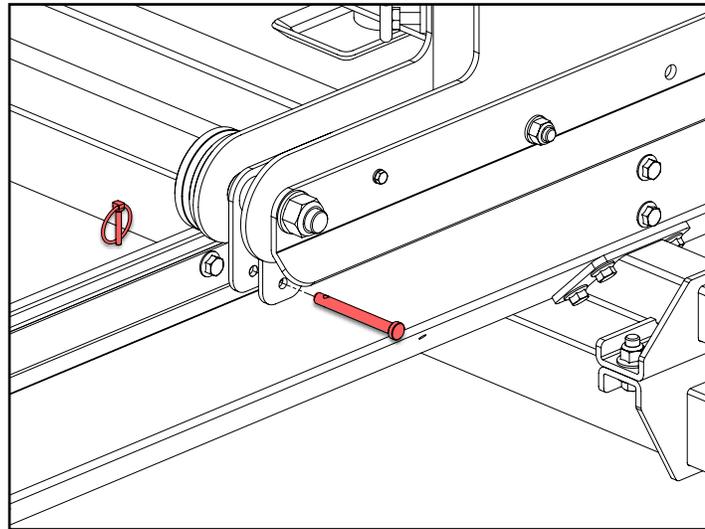
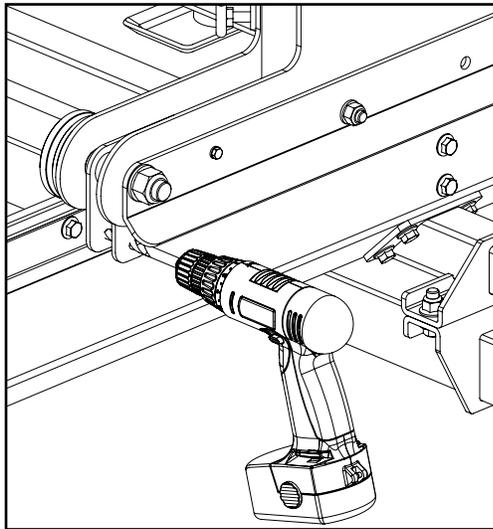
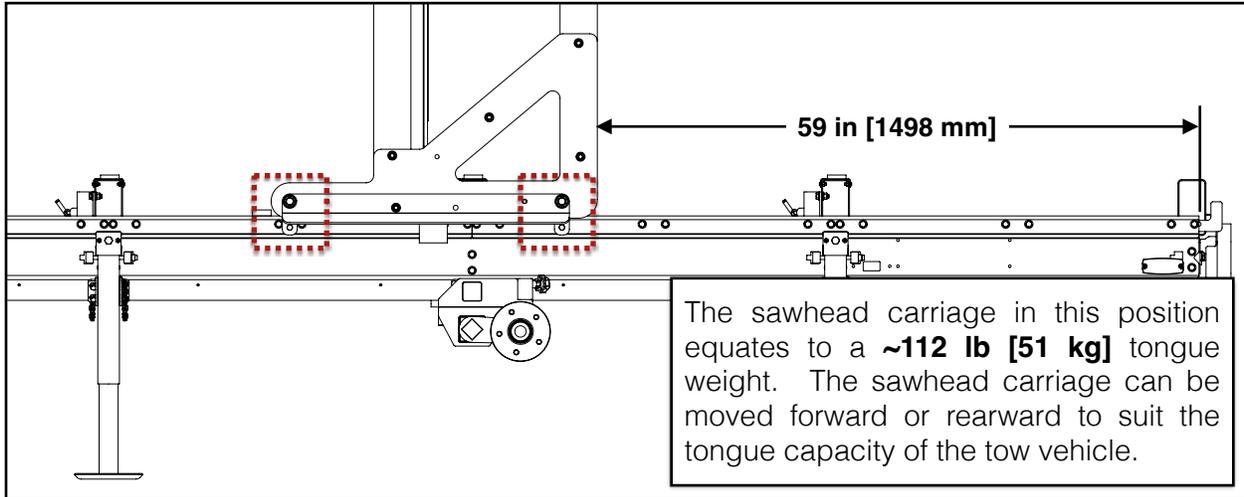




19. HEAD LOCK-DOWN PLATES

Place the assembled sawhead on the trailer.

Drill four (4) holes for the lock-down plates using the 10 mm [$\frac{3}{8}$ in] drill bit provided with the Sawmill. Measure 59 and 63 in [1498 and 1600 mm] from the rear edge of the track rail (*not* the carriage stop) to the rear post of the sawhead. Insert a locking pin into each hole as they are drilled. Secure each locking pin with a linch pin.



WARNING!

Use cutting oil when drilling holes for lock-down brackets or else the heat generated could ruin the drill bit and produce a rough surface finish.





SAWHEAD CARRIAGE LOCK-DOWN POSITIONS

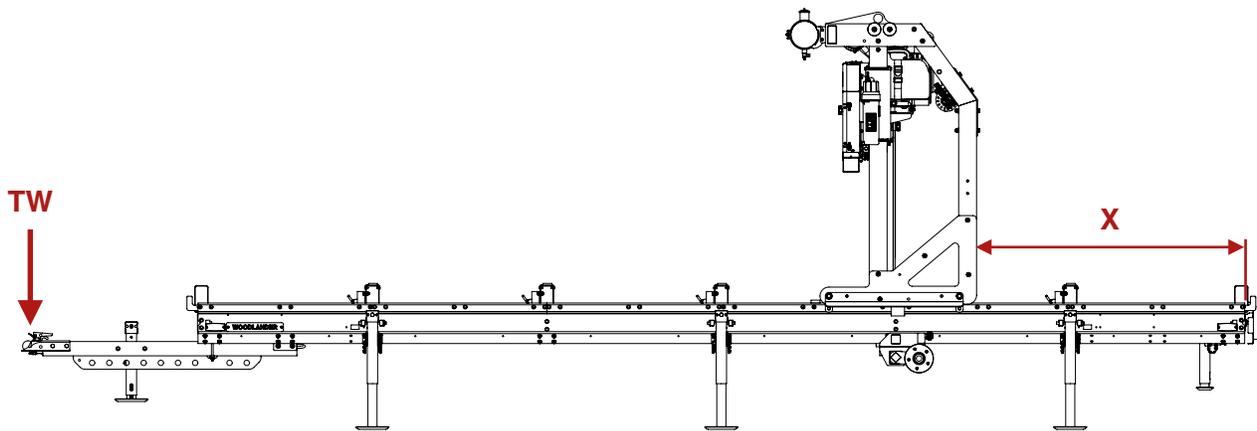
When deciding where to position the sawhead carriage, it is important to consider the tongue weight capacity of the tow vehicle. Lighter tongue weights are better suited for ATVs and smaller vehicles while heavier tongue weights work well with larger vehicles like pickup trucks.

****Note: Tolerance on tongue weights is approx. ±15 lb [±7 kg] depending on how many accessories are installed (Lap Siding, Power Head, Log Loading Ramp Kit, Toolbox, Cant Hook, etc.)****

Tongue Weight "TW" (lb) vs. Carriage Position Dim "X" (in)								
TW	209 lb	233 lb	259 lb	285 lb*	312 lb	339 lb	364 lb	392 lb
Dim X	38 in	44 in	50 in	56 in*	62 in	68 in	74 in	80 in

Tongue Weight "TW" (kg) vs. Carriage Position Dim "X" (cm)								
TW	95 kg	106 kg	118 kg	129 kg*	142 kg	154 kg	165 kg	178 kg
Dim X	97 cm	112 cm	127 cm	142 cm*	158 cm	173 cm	188 cm	203 cm

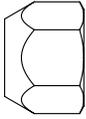
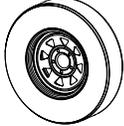
*Sawhead carriage centre of mass positioned over axles (highlighted yellow)

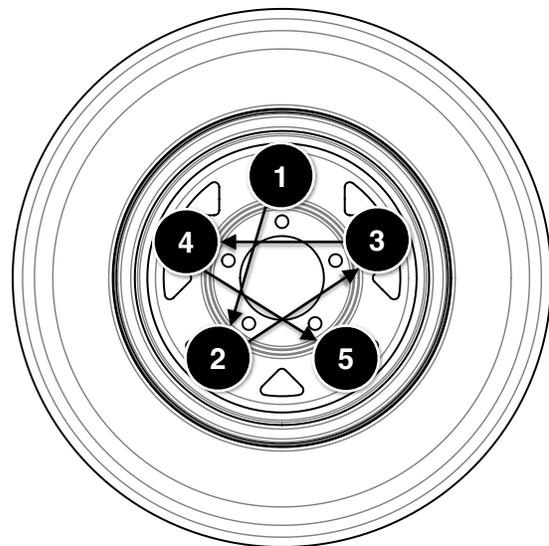
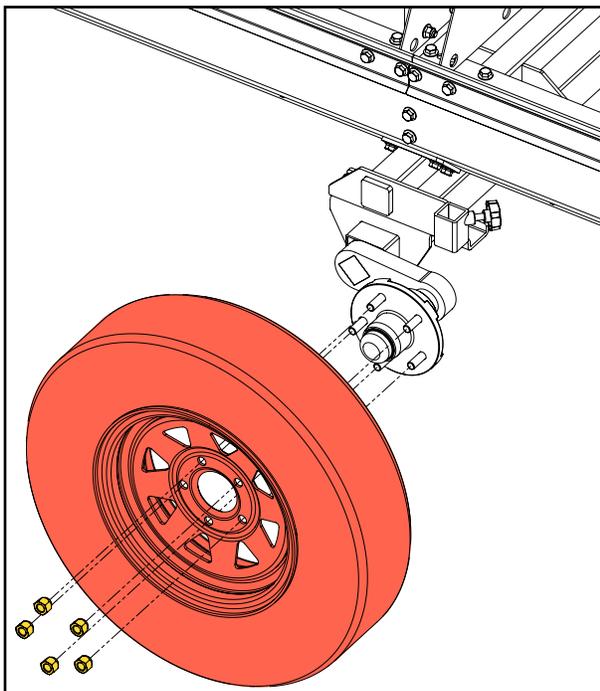
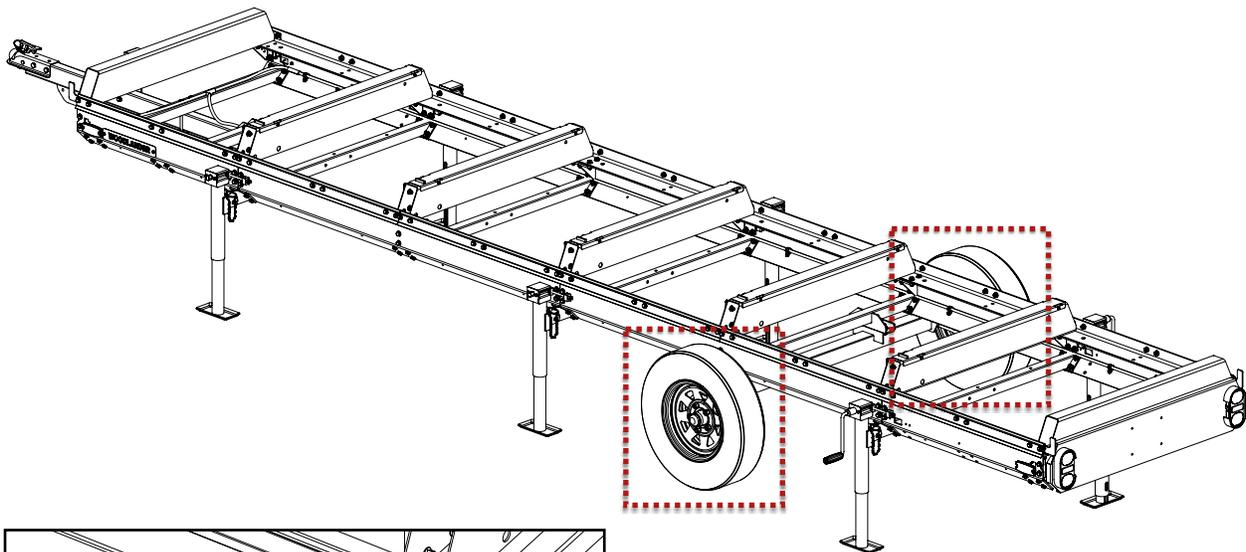




20. WHEELS

Using the hardware listed below, install the tires on the axles. Using a torque wrench, torque the lug nuts to 80 ft•lb / 110 N•m following the pattern shown below.

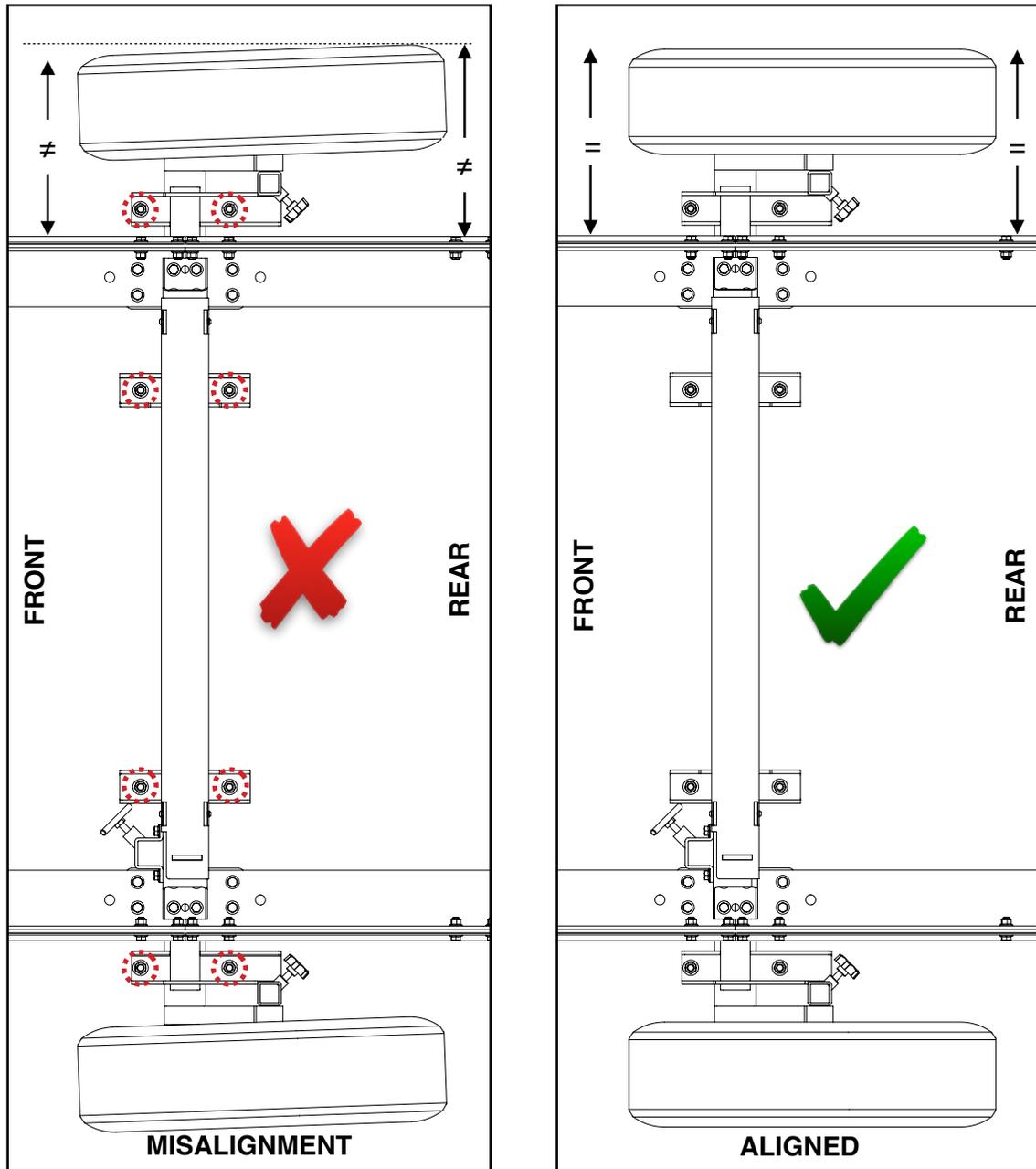
10x	1/2-20 Lug Nut		2x	175/80R13 Wheel	
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WHEEL ALIGNMENT ADJUSTMENT

With the wheels installed, observe their alignment to the side plates. If the wheels are not parallel to the side plates, the axle position needs to be adjusted before the trailer can be towed behind a vehicle.

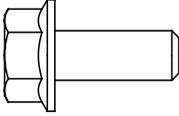
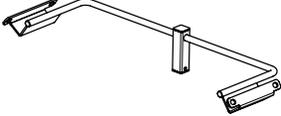
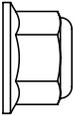
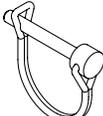


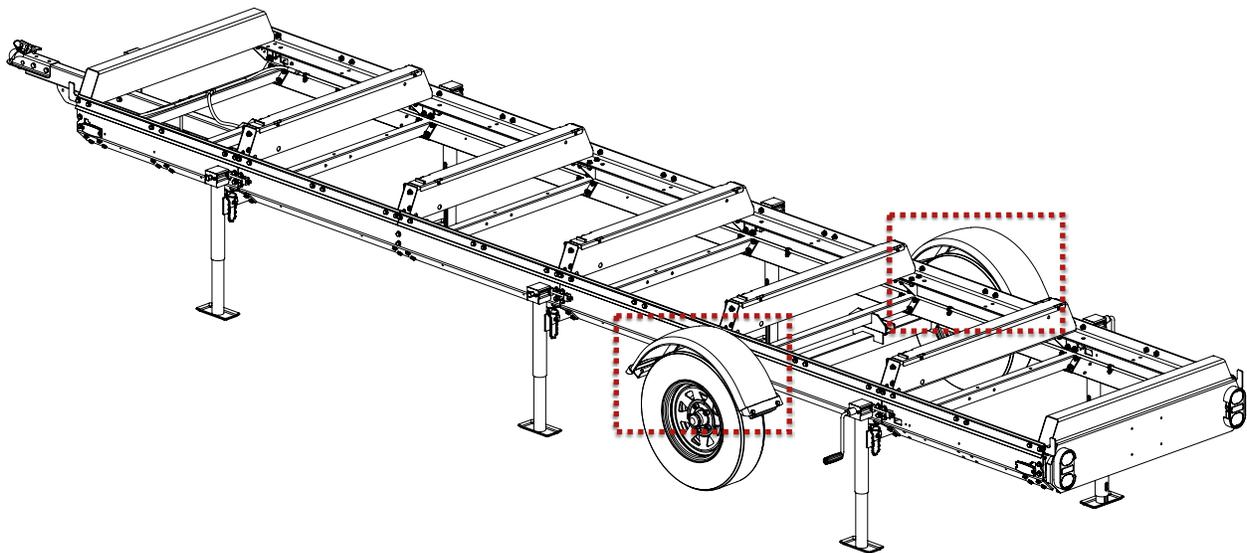
If the wheels are parallel, tighten the axle bolts to the ***specified torque*** and proceed to the next section. However, if the wheels are *not* parallel, loosen the four (4) M12 bolts on the affected axle(s). Rotate the axle assembly and wheel until the wheels are parallel. Then tighten the axle bolts to the ***specified torque***.



21. FENDERS

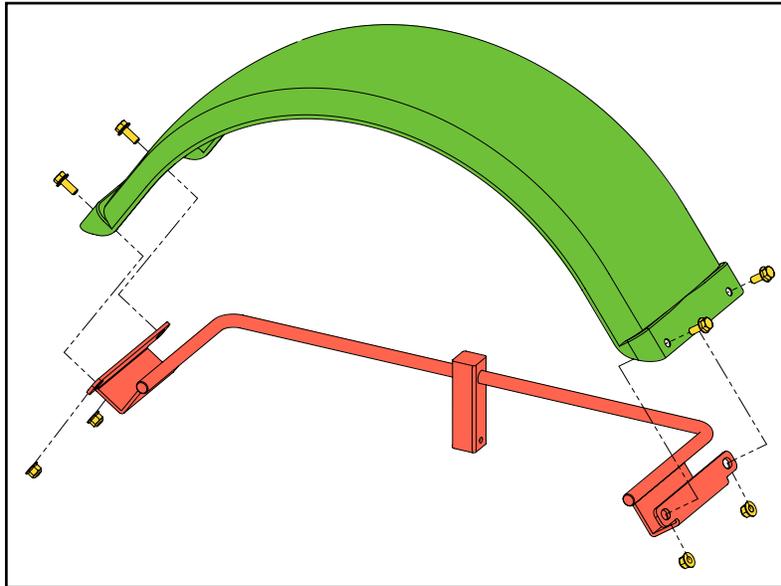
Using the hardware listed below, assemble the fenders to the fender brackets.

8x	M8 X 20 mm Flanged Hex Bolt		2x	Fender Bracket	
8x	M8 Flanged Lock Nut		2x	Fender	
			2x	Locking Pin	

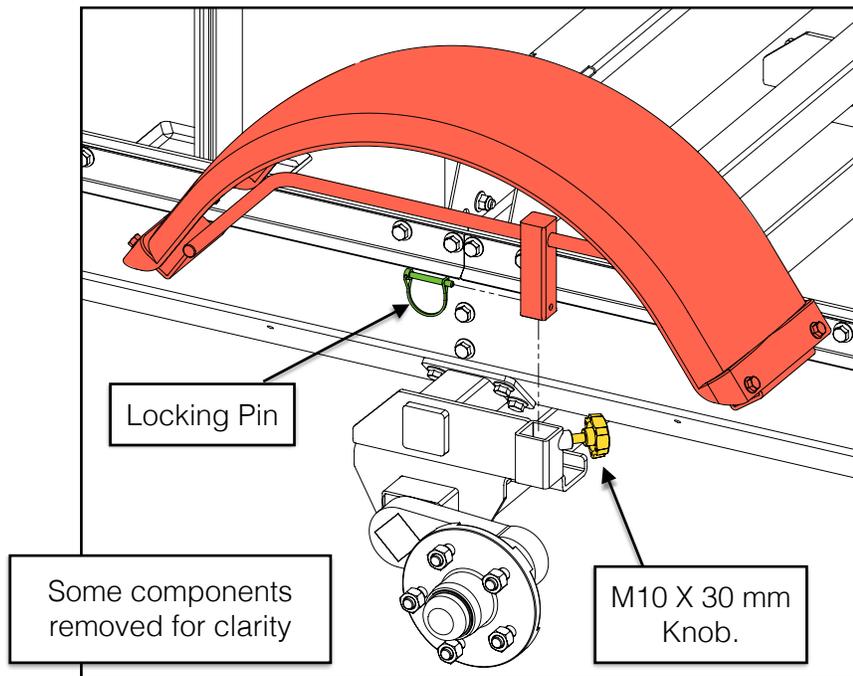




Fasten a metal fender to each fender bracket using four (4) M8 X 20 mm bolts and four (4) M8 flanged lock nuts. Fully tighten these bolts.



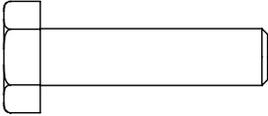
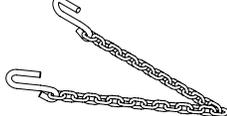
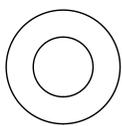
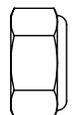
Slide the post on the fender bracket into the sleeve on the axle mount and insert the locking pin through the hole located at the bottom of the fender bracket post. Secure the fender/fender bracket sub-assembly using the M10 X 30 mm knob by threading it into the axle mount until tight.

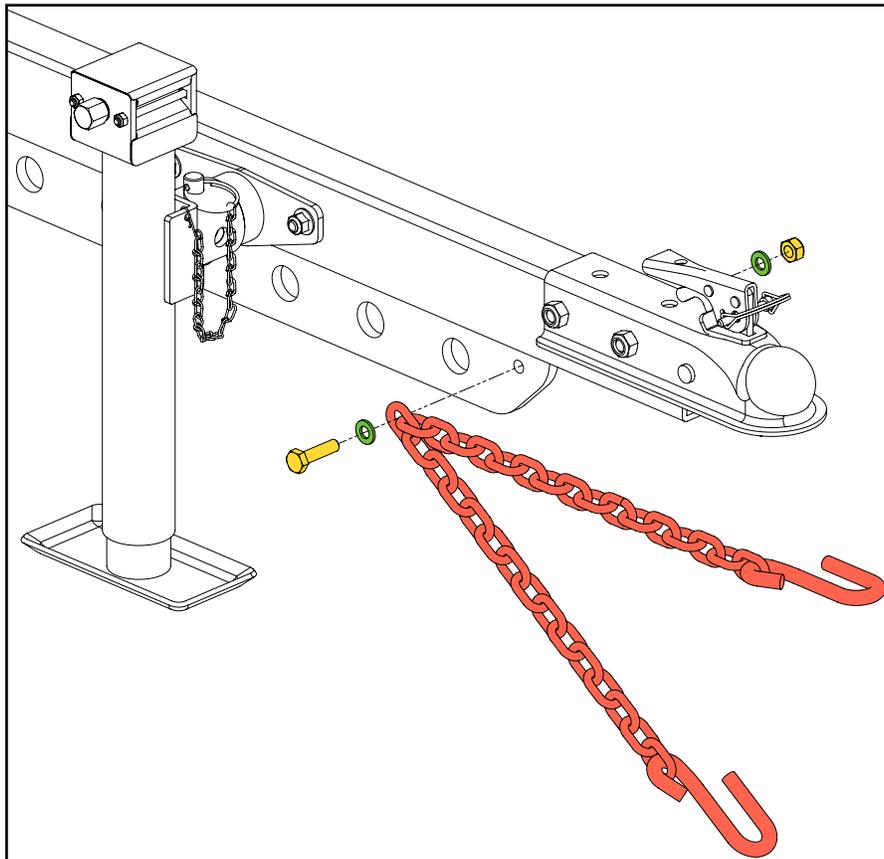




22. SAFETY CHAIN

Using the hardware below, install the safety chain on the trailer tongue.

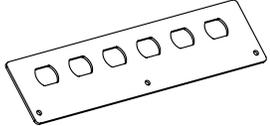
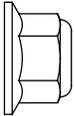
1x	M10 X 40 mm Hex Bolt		1x	Safety Chain	
2x	M10 Flat Washer				
1x	M10 Lock Nut				

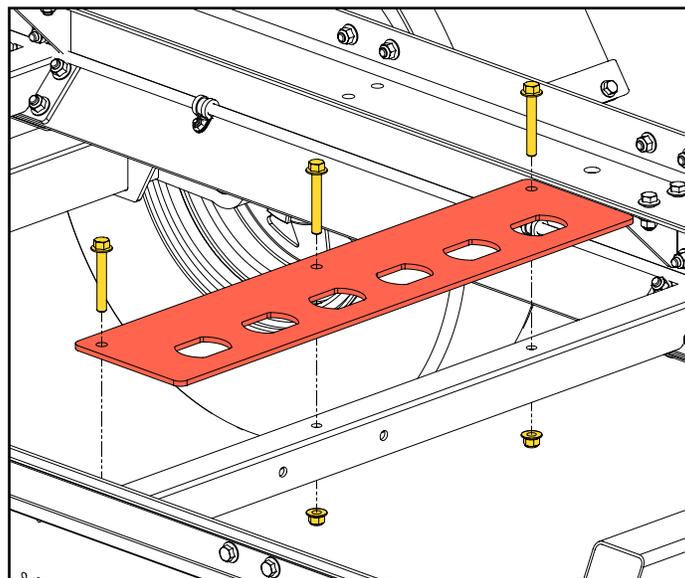
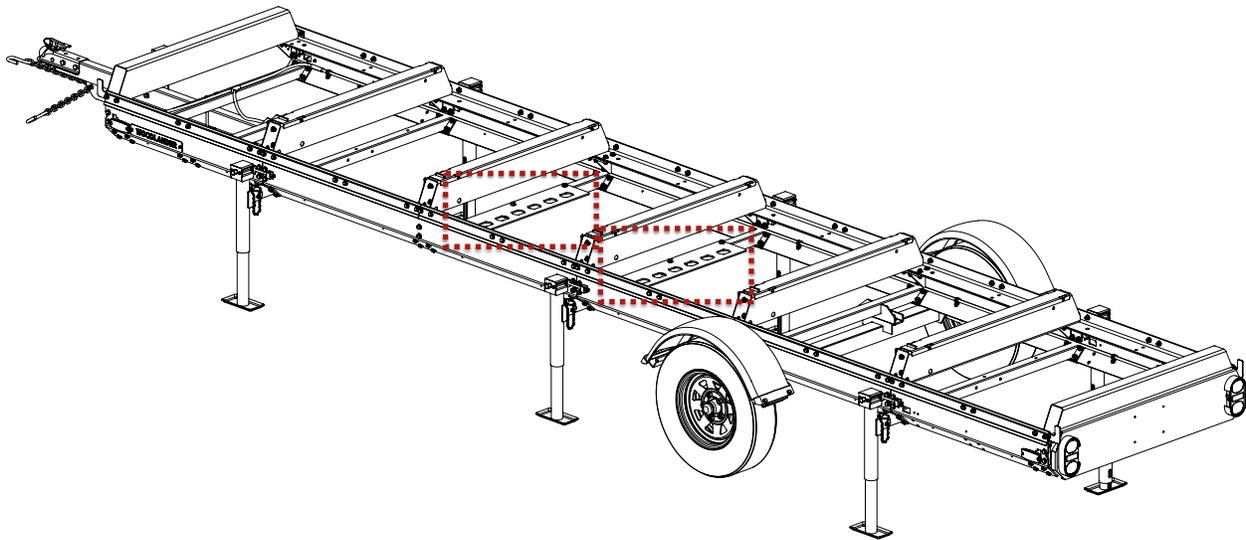




23. CANT HOOK LEVERAGE PLATES

Using the hardware below, install the cant hook leverage plates on the cross beams.

6x	M10 X 70 mm Flanged Hex Bolt		2x	Cant Hook Leverage Plate	
6x	M10 Flanged Lock Nut				

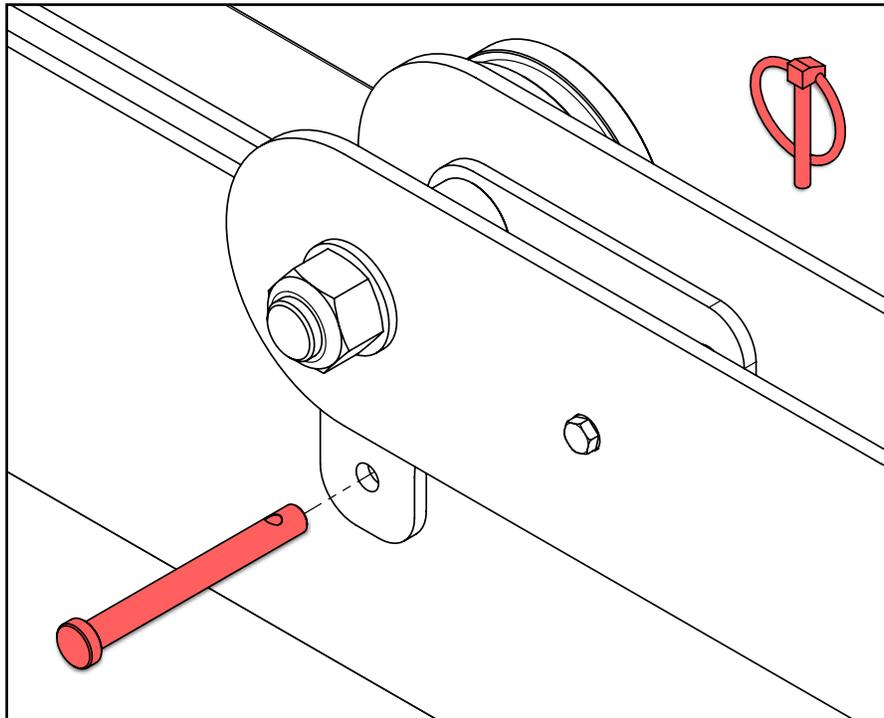




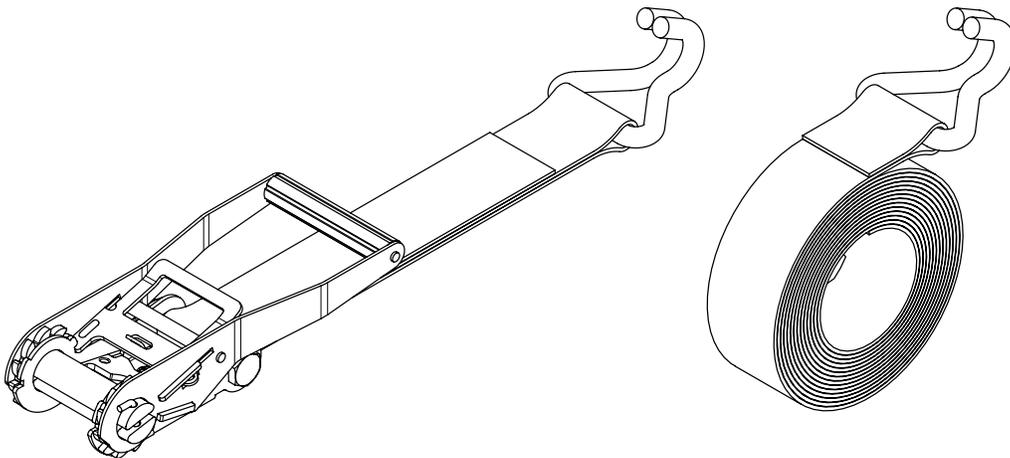
OPERATION

LOCKING-DOWN THE SAWMILL HEAD

When transporting the trailer, it is imperative that the sawmill head is locked-down securely to the trailer. Start by inserting the four (4) locking pins through the lock-down brackets and secure them with linch pins.

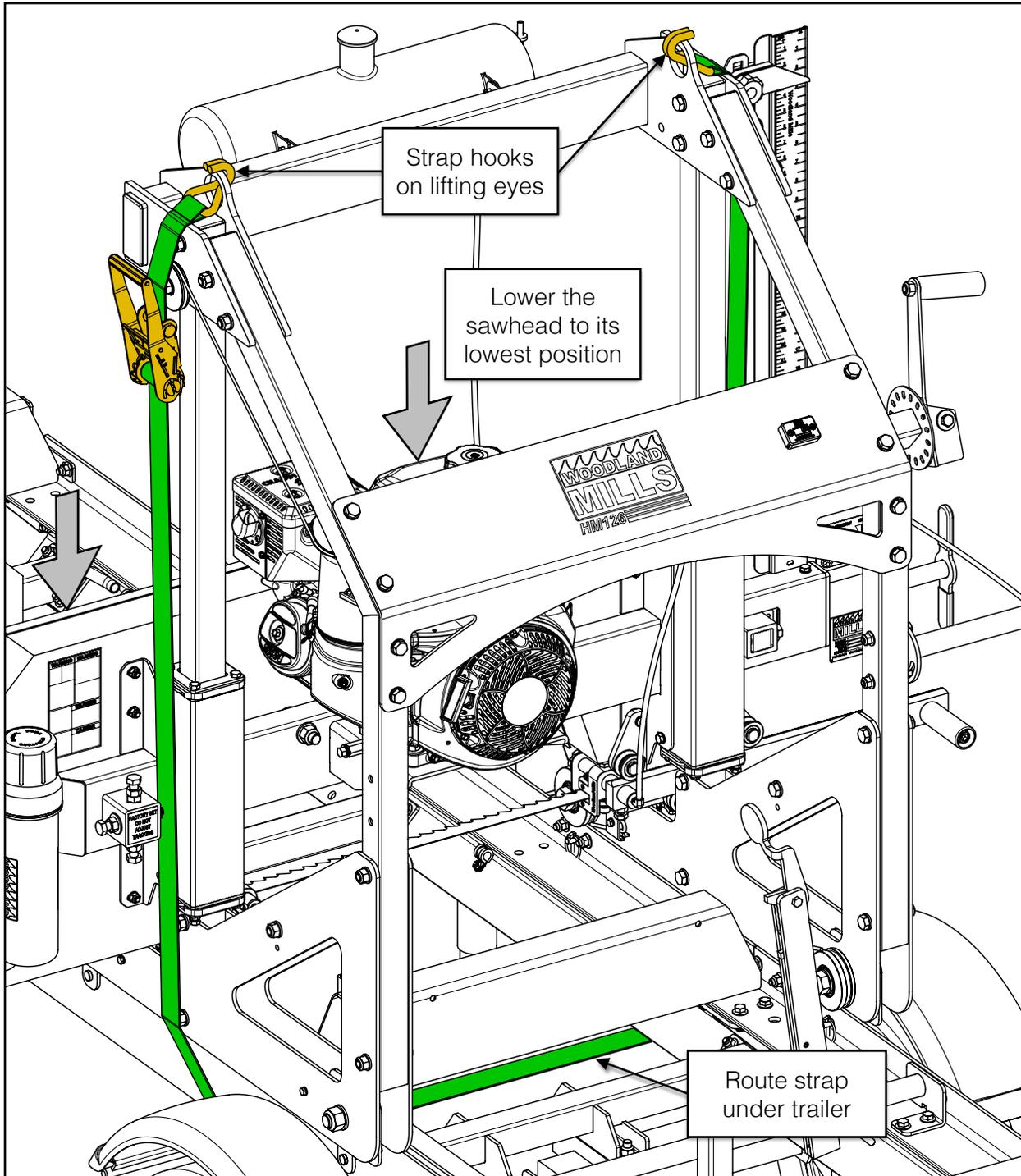


Next, route the included ratchet strap (shown below) around the sawmill and trailer to fully lock-down the sawmill head as shown on the next page.





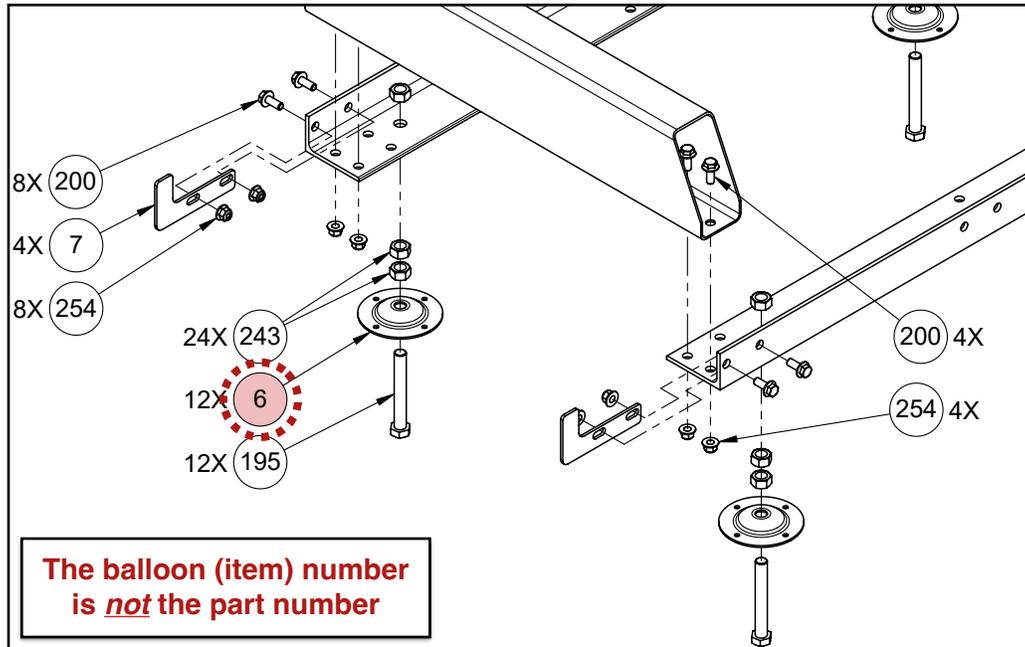
Lower the sawhead to its lowest position. Then insert the short strap hook into the cross beam lifting eye on one side of the sawmill, route the long strap down and under the bottom of the trailer, then up to the opposite lifting eye. Ratchet the strap tight until there is no slack.





REPLACEMENT PARTS ORDERING

When ordering replacement parts, first locate the balloon number(s) from the appropriate ***exploded assembly view*** as shown in the example below:



Next, turn to the ***Parts Lists*** section and locate the balloon number in the “**Item**” column:

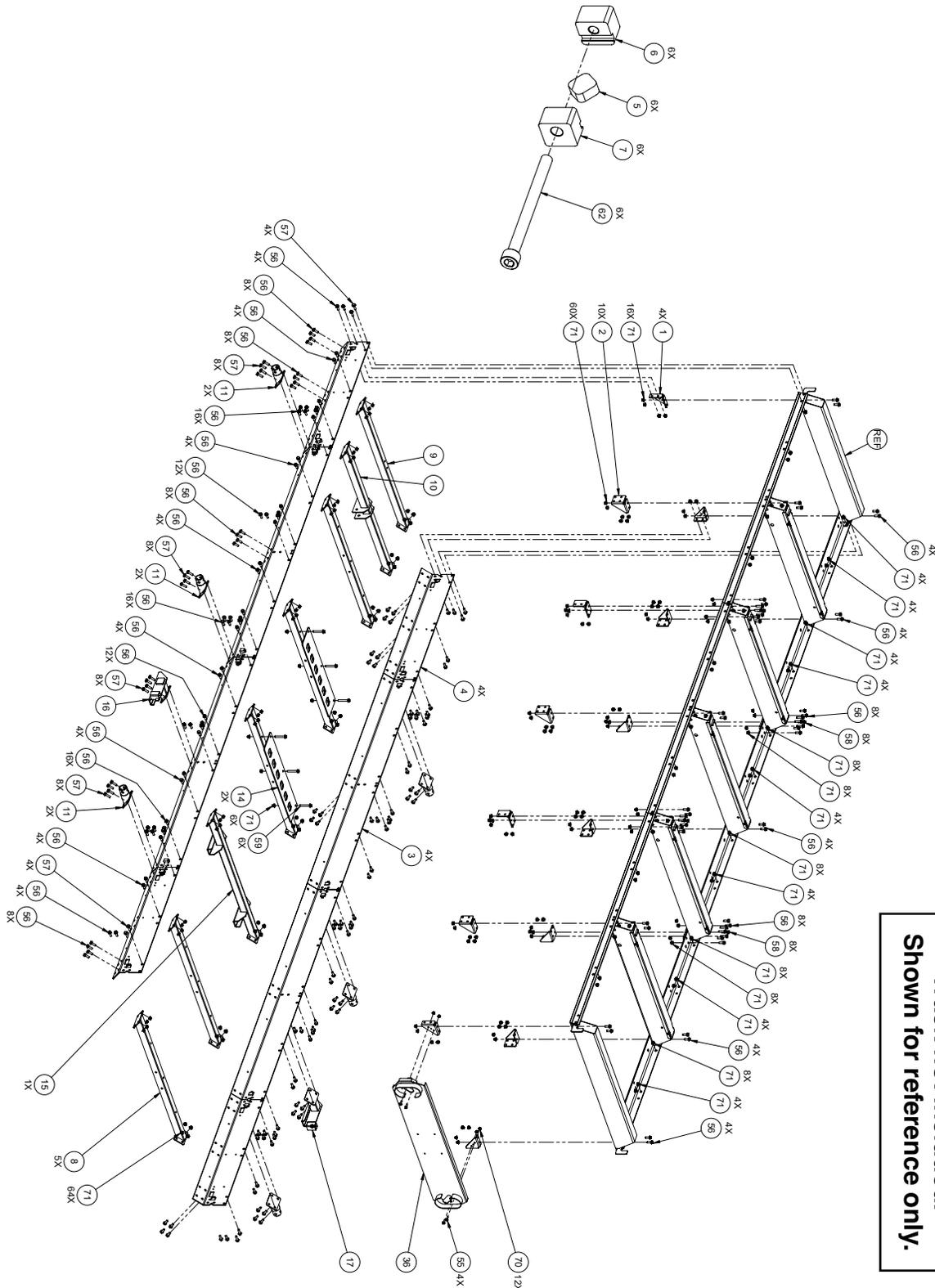
PARTS LIST				
Item	Quantity		Part No.	Description
	14 hp	9.5 hp		
1	4	4	0001073	TRACK RAIL, 58.5 mm TALL
2	2	2	0001075	LOG BUNK, END
3	2	2	0001080	LOG BUNK, MID
4	1	1	0001084	LOG BUNK, CENTER
5	2	2	0001072	REINFORCEMENT PLATE, 90 X 200 mm
6	12	12	0001071	LEVELLING FOOT BASE
7	4	4	0001055	CARRIAGE STOP
8	1	1	0001062	LOG CLAMP SHAFT AND BRACKET WELDMENT

Record the part number (e.g. *0001071, HHB-MBM080FCJ, etc.*) in the “**Part No.**” column.

Contact Woodland Mills through the website or via phone/email. If possible, include the invoice or sales number from the purchased product so an associated account can be located. If the account has multiple addresses on file, please indicate to which address the replacement part(s) will be shipped.



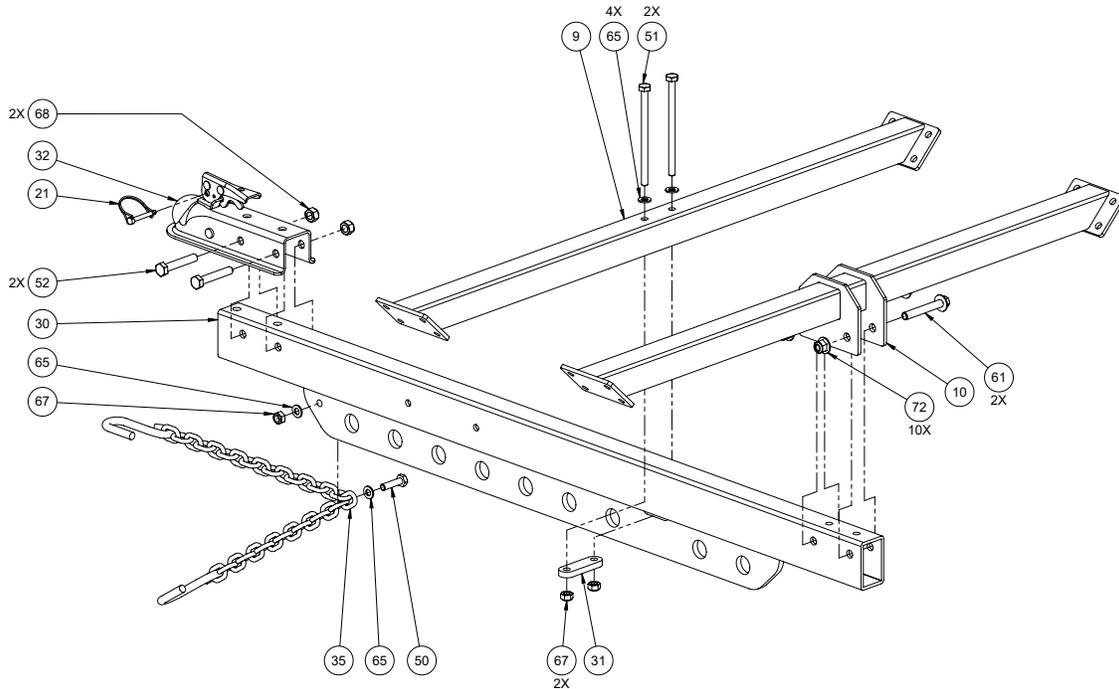
EXPLODED ASSEMBLY VIEWS CHASSIS AND TRACK



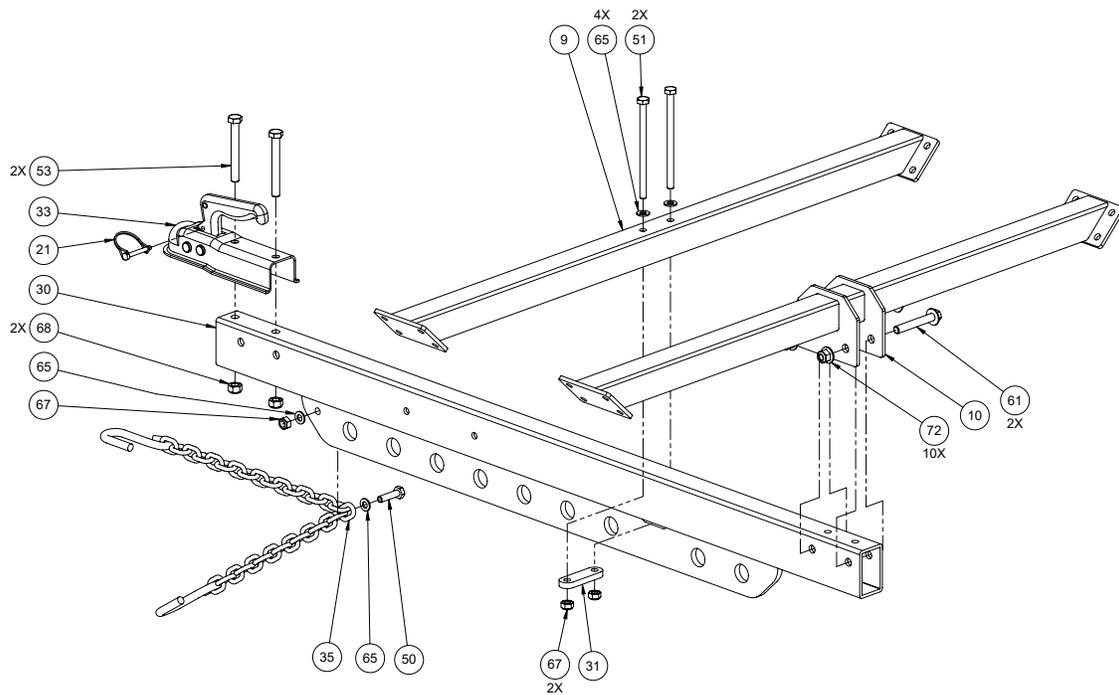


TONGUE

NORTH AMERICA

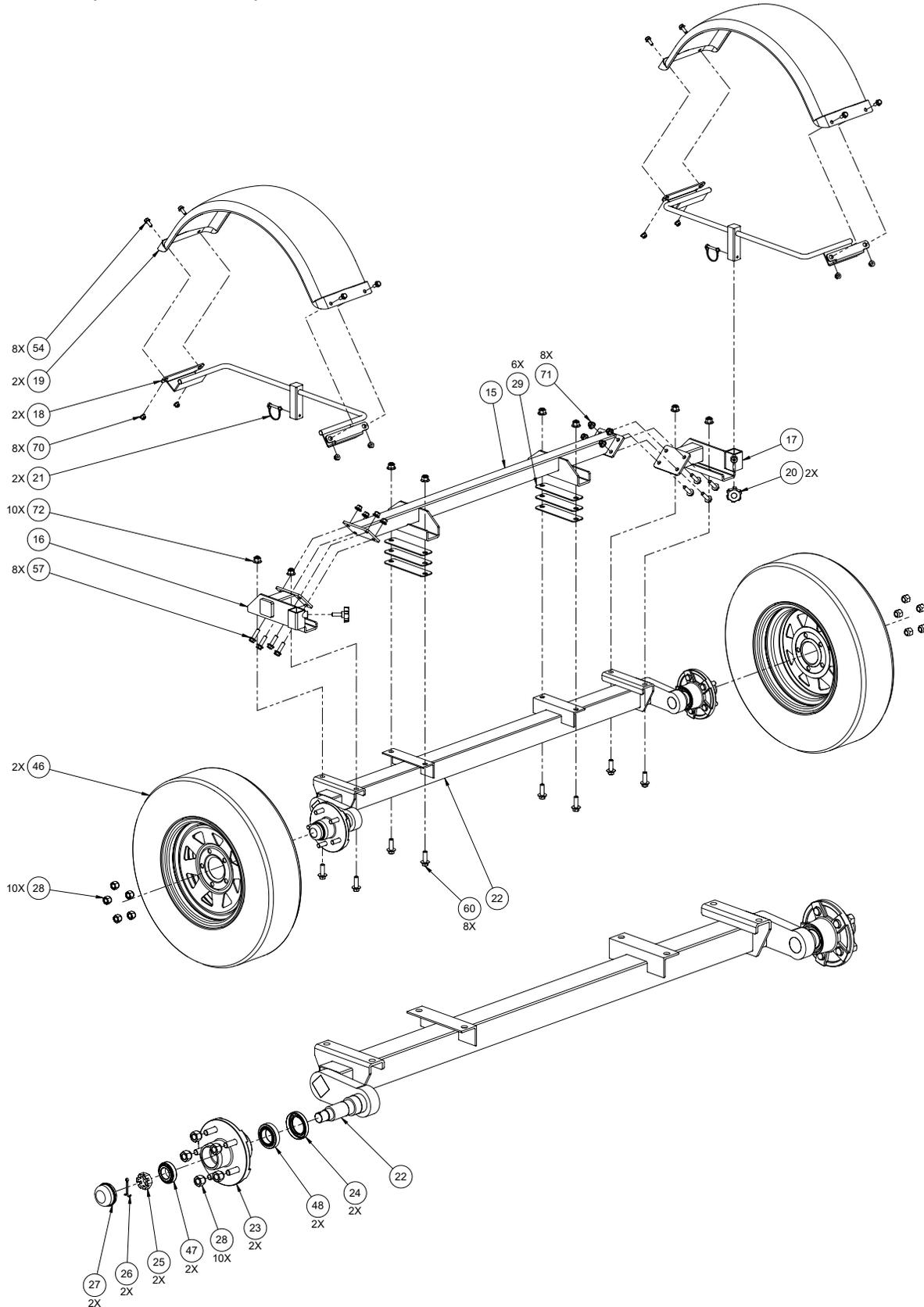


EUROPE





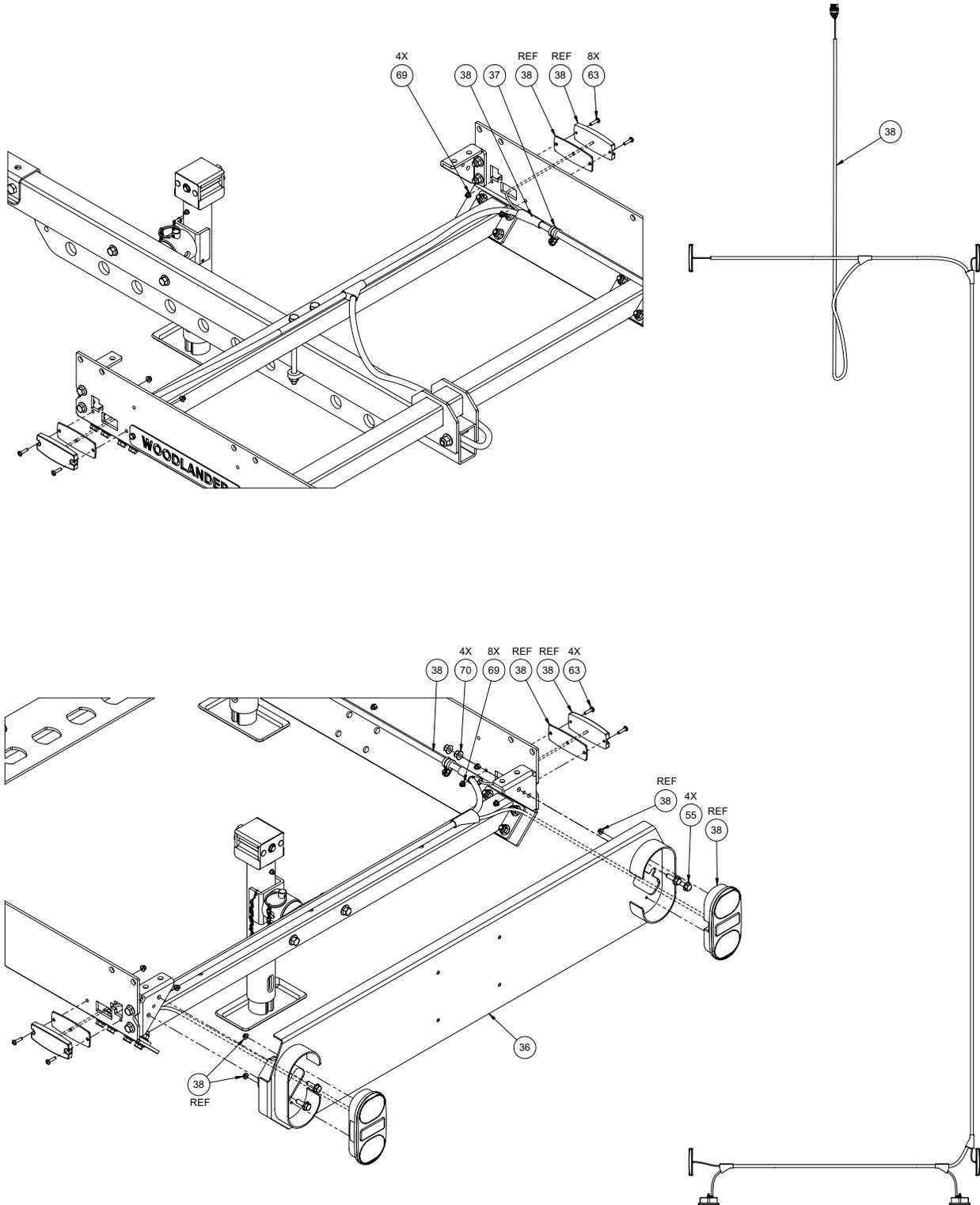
AXLES, WHEELS, AND FENDERS





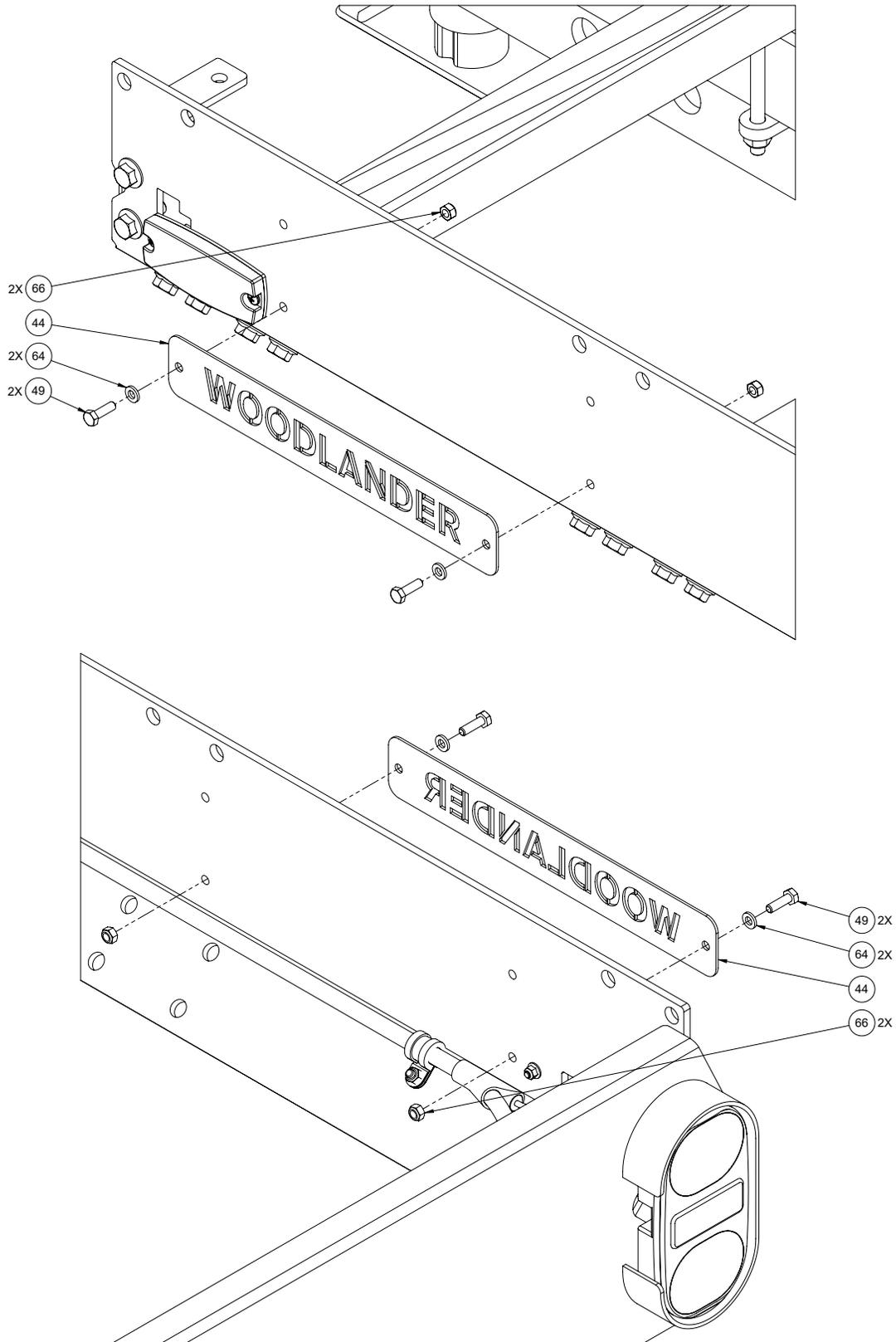
LIGHTING

NORTH AMERICA



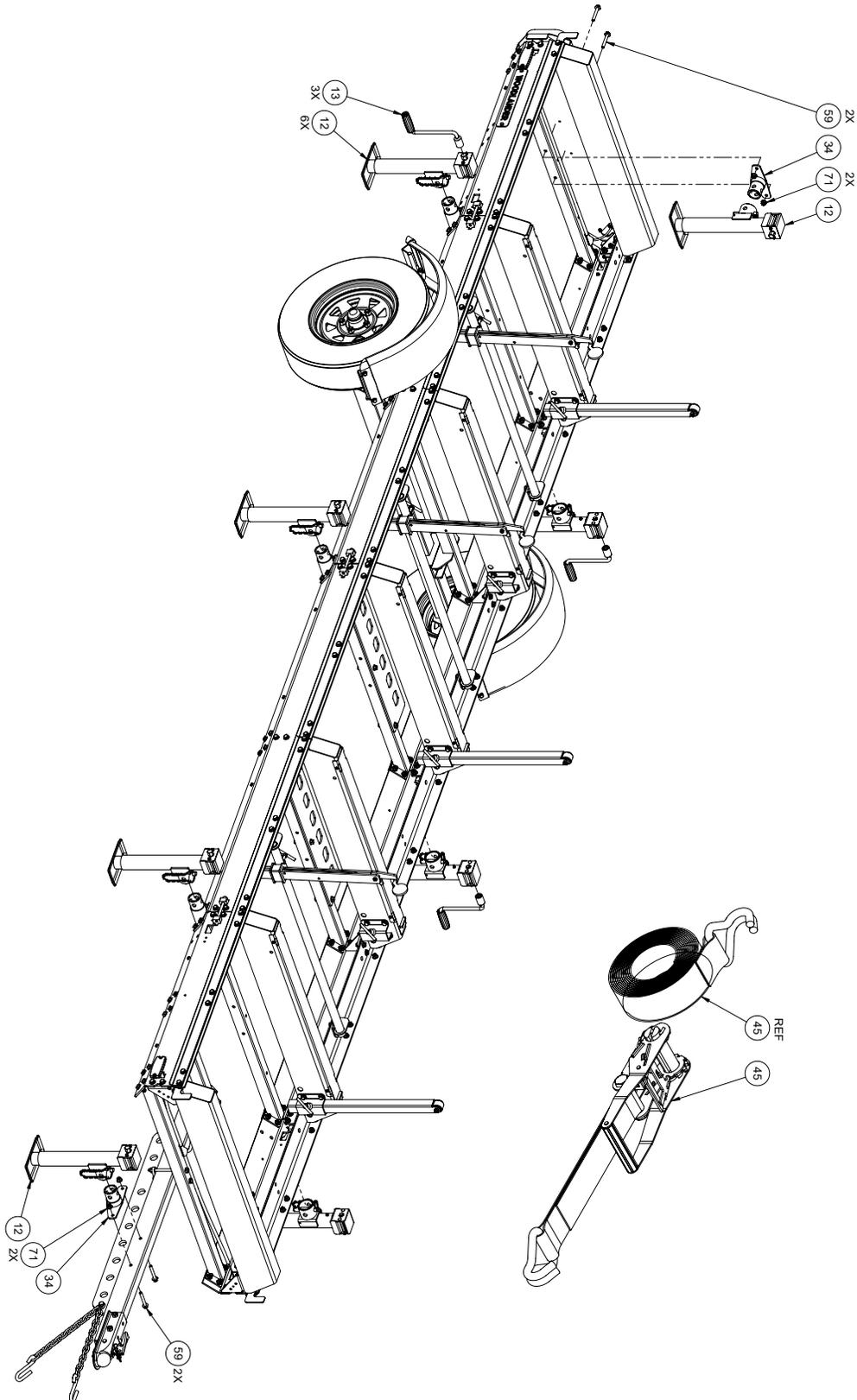


NAMEPLATES





SWIVEL JACKS AND RATCHET STRAP





PARTS LISTS

NORTH AMERICA

ITEM	NA16	PART NO	DESCRIPTION
1	4	0001373	GUSSET, END
2	10	0001374	GUSSET, JOINING
3	4	0008948	SIDE PLATE, LONG
4	4	0008947	SIDE PLATE, SHORT
5	6	0008949	SIDE PLATE ALIGNMENT DIAMOND
6	6	0008950	SIDE PLATE ALIGNMENT NUT
7	6	0008951	SIDE PLATE ALIGNMENT JAW
8	5	0008942	CROSS BEAM
9	1	0003935	CROSS BEAM, FRONT
10	1	0009650	CROSS BEAM, TONGUE
11	6	0001376	JACK MOUNT
12	8	0006798	SWIVEL JACK, PIPE MOUNT, SIDEWIND SOCKET RECEIVER
13	3	0006800	CRANK HANDLE, SOCKET DRIVE, 3/4 in [19 mm], SWIVEL JACK
14	2	0008944	CANT HOOK LEVERAGE PLATE
15	1	0003937	CROSS BEAM, AXLE
16	1	0009155	AXLE MOUNT W/ FENDER ADAPTER, LEFT
17	1	0009156	AXLE MOUNT W/ FENDER ADAPTER, RIGHT
18	2	0009823	BRACKET, METAL FENDER, 175-80R13 WHEEL
19	2	0004221	METAL FENDER, 175-80R13 WHEEL
20	2	0001698	KNOB, MULTI-LOBE, 48 mm OD, M10 X 1.5, 30 mm LG
21	3	0004728	LOCKING PIN, ROUND, 1/4 in DIA, 1-3/8 in USABLE LG, 2 in LG
22	1	0009652	AXLE, COMBINED, 3500 lb
23	2	0004165	WHEEL HUB, 1/2-20 LUGS
24	2	0009010	ROTARY SHAFT SEAL, SPRING-LOADED, WIPER LIP, 43.5 mm SHAFT, 65 mm OD
25	2	0006092	LOCK NUT, SLOTTED, M24 X 1.5, 16 mm THK
26	2	0004753	COTTER PIN, 5/32 in DIA, 1-1/2 in LG
27	2	0001552	WHEEL HUB DUST COVER, 5-BOLT, 1/2-20 LUGS
28	10	0006201	LUG NUT, 1/2-20
29	6	0001682	AXLE SHIM PLATE, 3 mm THK
30	1	0001371	TONGUE
31	1	0001372	TONGUE BRACKET
32	1	0001381	HITCH BALL COUPLER, 2 in [50.8 mm] BALL, NORTH AMERICA
34	2	0002249	JACK MOUNT, BUSHLANDER
35	1	0001382	SAFETY CHAIN
36	1	0003938	TAILLIGHT BRACKET
37	12	0001396	CABLE CLAMP, 1/2 in ID, 1-3/4 in LG
38	1	0001676-1	LIGHTING WIRING HARNESS, WOODLANDER, NA
44	2	0004445	WOODLANDER NAMEPLATE
45	1	0005146	RATCHET STRAP, 50 mm WD, 4500 mm LG



ITEM	NA16	PART NO	DESCRIPTION
46	2	175-80R13 Wheel	WHEEL, 175/80R13
47	2	L44649	ROLLER BEARING, TAPERED, 1-1/16 in SFT, 1-3/64 in HSG, .56 in WD
48	2	L68149	ROLLER BEARING, TAPERED, 1-3/8 in SFT, 2-21/64 in HSG, 5/8 in WD
49	16	HHB-MBE075FCJ	HEX HEAD BOLT, CLS 8.8, M6 X 1, 20 mm LG, FULL
50	1	HHB-MBM095FCM	HEX HEAD BOLT, CLS 10.9, M10 X 1.5, 40 mm LG, FULL
51	2	HHB-MBM215PCJ	HEX HEAD BOLT, CLS 8.8, M10 X 1.5, 160 mm LG, 26 mm LG THD
52	2	HHB-MBR125PCM	HEX HEAD BOLT, CLS 10.9, M12 X 1.75, 70 mm LG, 30 mm LG THD
54	8	FHH-MBJ075PCJ	HEX BOLT, FLANGED, CLS 8.8, M8 X 1.25, 20 mm LG, 16 mm LG THD
55	4	FHH-MBJ080FCJ	HEX BOLT, FLANGED, CLS 8.8, M8 X 1.25, 25 mm LG, FULL
56	172	FHH-MBM085FCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 30 mm LG, FULL
57	40	FHH-MBM090PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 35 mm LG, 26 mm LG THD
58	16	FHH-MBM095PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 40 mm LG, 26 mm LG THD
59	10	FHH-MBM125PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 70 mm LG, 26 mm LG THD
60	8	FHH-MBR090PCM	HEX BOLT, FLANGED, CLS 10.9, M12 X 1.75, 35 mm LG, 30 mm LG THD
61	2	FHH-MBR135PCM	HEX BOLT, FLANGED, CLS 10.9, M12 X 1.75, 80 mm LG, 30 mm LG THD
62	6	SHC-MBM175PTA	SHCS, SST, M10 X 1.5, 120 mm LG, 32 mm LG THD
63	8	PPH-MBA075FCE	SCREW, PPH, CLS 4.8, M5 X 0.8, 20 mm LG, FULL
64	16	FTW-MBE000AJ	FLAT WASHER, M6
65	4	FTW-MBM000AJ	FLAT WASHER, M10
66	16	HLN-MBECH	LOCK NUT, CLS 8, M6 X 1
67	3	HLN-MBMCL	LOCK NUT, CLS 10, M10 X 1.5
68	2	HLN-MBRCL	LOCK NUT, CLS 10, M12 X 1.75
69	8	FLN-MBACH	LOCK NUT, FLANGED, CLS 8, M5 X 0.8
70	12	FLN-MBJCH	LOCK NUT, FLANGED, CLS 8, M8 X 1.25
71	238	FLN-MBMCL	LOCK NUT, FLANGED, CLS 10, M10 X 1.5
72	10	FLN-MBRCL	LOCK NUT, FLANGED, CLS 10, M12 X 1.75



EUROPE

ITEM	EU16	PART NO	DESCRIPTION
1	4	0001373	GUSSET, END
2	10	0001374	GUSSET, JOINING
3	4	0008948	SIDE PLATE, LONG
4	4	0008947	SIDE PLATE, SHORT
5	6	0008949	SIDE PLATE ALIGNMENT DIAMOND
6	6	0008950	SIDE PLATE ALIGNMENT NUT
7	6	0008951	SIDE PLATE ALIGNMENT JAW
8	5	0008942	CROSS BEAM
9	1	0003935	CROSS BEAM, FRONT
10	1	0009650	CROSS BEAM, TONGUE
11	6	0001376	JACK MOUNT
12	8	0006798	SWIVEL JACK, PIPE MOUNT, SIDEWIND SOCKET RECEIVER
13	3	0006800	CRANK HANDLE, SOCKET DRIVE, 3/4 in [19 mm], SWIVEL JACK
14	2	0008944	CANT HOOK LEVERAGE PLATE
15	1	0003937	CROSS BEAM, AXLE
16	1	0009155	AXLE MOUNT W/ FENDER ADAPTER, LEFT
17	1	0009156	AXLE MOUNT W/ FENDER ADAPTER, RIGHT
18	2	0009823	BRACKET, METAL FENDER, 175-80R13 WHEEL
19	2	0004221	METAL FENDER, 175-80R13 WHEEL
20	2	0001698	KNOB, MULTI-LOBE, 48 mm OD, M10 X 1.5, 30 mm LG
21	3	0004728	LOCKING PIN, ROUND, 1/4 in DIA, 1-3/8 in USABLE LG, 2 in LG
22	1	0009652	AXLE, COMBINED, 3500 lb
23	2	0004165	WHEEL HUB, 1/2-20 LUGS
24	2	0009010	ROTARY SHAFT SEAL, SPRING-LOADED, WIPER LIP, 43.5 mm SHAFT, 65 mm OD
25	2	0006092	LOCK NUT, SLOTTED, M24 X 1.5, 16 mm THK
26	2	0004753	COTTER PIN, 5/32 in DIA, 1-1/2 in LG
27	2	0001552	WHEEL HUB DUST COVER, 5-BOLT, 1/2-20 LUGS
28	10	0006201	LUG NUT, 1/2-20
29	6	0001682	AXLE SHIM PLATE, 3 mm THK
30	1	0001371	TONGUE
31	1	0001372	TONGUE BRACKET
33	1	0001702	HITCH BALL COUPLER, 50 mm [2 in] BALL, EUROPE
34	2	0002249	JACK MOUNT, BUSHLANDER
35	1	0001382	SAFETY CHAIN
36	1	0003938	TAILLIGHT BRACKET
37	12	0001396	CABLE CLAMP, 1/2 in ID, 1-3/4 in LG
39	1	0001676-2	LIGHTING WIRING HARNESS, WOODLANDER, EU
40	2	0001379	TRIANGLE REFLECTOR BRACKET, EU
41	2	0001390	REAR REFLECTOR, RED, EU
42	4	0001391	SIDE REFLECTOR, AMBER, EU
43	2	0001392	FRONT REFLECTOR, WHITE, EU



ITEM	EU16	PART NO	DESCRIPTION
44	2	0004445	WOODLANDER NAMEPLATE
45	1	0005146	RATCHET STRAP, 50 mm WD, 4500 mm LG
46	2	175-80R13 Wheel	WHEEL, 175/80R13
47	2	L44649	ROLLER BEARING, TAPERED, 1-1/16 in SFT, 1-3/64 in HSG, .56 in WD
48	2	L68149	ROLLER BEARING, TAPERED, 1-3/8 in SFT, 2-21/64 in HSG, 5/8 in WD
49	16	HHB-MBE075FCJ	HEX HEAD BOLT, CLS 8.8, M6 X 1, 20 mm LG, FULL
50	1	HHB-MBM095FCM	HEX HEAD BOLT, CLS 10.9, M10 X 1.5, 40 mm LG, FULL
51	2	HHB-MBM215PCJ	HEX HEAD BOLT, CLS 8.8, M10 X 1.5, 160 mm LG, 26 mm LG THD
53	2	HHB-MBR155PCM	HEX HEAD BOLT, CLS 10.9, M12 X 1.75, 100 mm LG, 30 mm LG THD
54	8	FHH-MBJ075PCJ	HEX BOLT, FLANGED, CLS 8.8, M8 X 1.25, 20 mm LG, 16 mm LG THD
55	4	FHH-MBJ080FCJ	HEX BOLT, FLANGED, CLS 8.8, M8 X 1.25, 25 mm LG, FULL
56	172	FHH-MBM085FCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 30 mm LG, FULL
57	40	FHH-MBM090PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 35 mm LG, 26 mm LG THD
58	16	FHH-MBM095PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 40 mm LG, 26 mm LG THD
59	10	FHH-MBM125PCM	HEX BOLT, FLANGED, CLS 10.9, M10 X 1.5, 70 mm LG, 26 mm LG THD
60	8	FHH-MBR090PCM	HEX BOLT, FLANGED, CLS 10.9, M12 X 1.75, 35 mm LG, 30 mm LG THD
61	2	FHH-MBR135PCM	HEX BOLT, FLANGED, CLS 10.9, M12 X 1.75, 80 mm LG, 30 mm LG THD
62	6	SHC-MBM175PTA	SHCS, SST, M10 X 1.5, 120 mm LG, 32 mm LG THD
63	12	PPH-MBA075FCE	SCREW, PPH, CLS 4.8, M5 X 0.8, 20 mm LG, FULL
64	16	FTW-MBE000AJ	FLAT WASHER, M6
65	4	FTW-MBM000AJ	FLAT WASHER, M10
66	16	HLN-MBECH	LOCK NUT, CLS 8, M6 X 1
67	3	HLN-MBMCL	LOCK NUT, CLS 10, M10 X 1.5
68	2	HLN-MBRCL	LOCK NUT, CLS 10, M12 X 1.75
69	14	FLN-MBACH	LOCK NUT, FLANGED, CLS 8, M5 X 0.8
70	12	FLN-MBJCH	LOCK NUT, FLANGED, CLS 8, M8 X 1.25
71	238	FLN-MBMCL	LOCK NUT, FLANGED, CLS 10, M10 X 1.5
72	10	FLN-MBRCL	LOCK NUT, FLANGED, CLS 10, M12 X 1.75

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