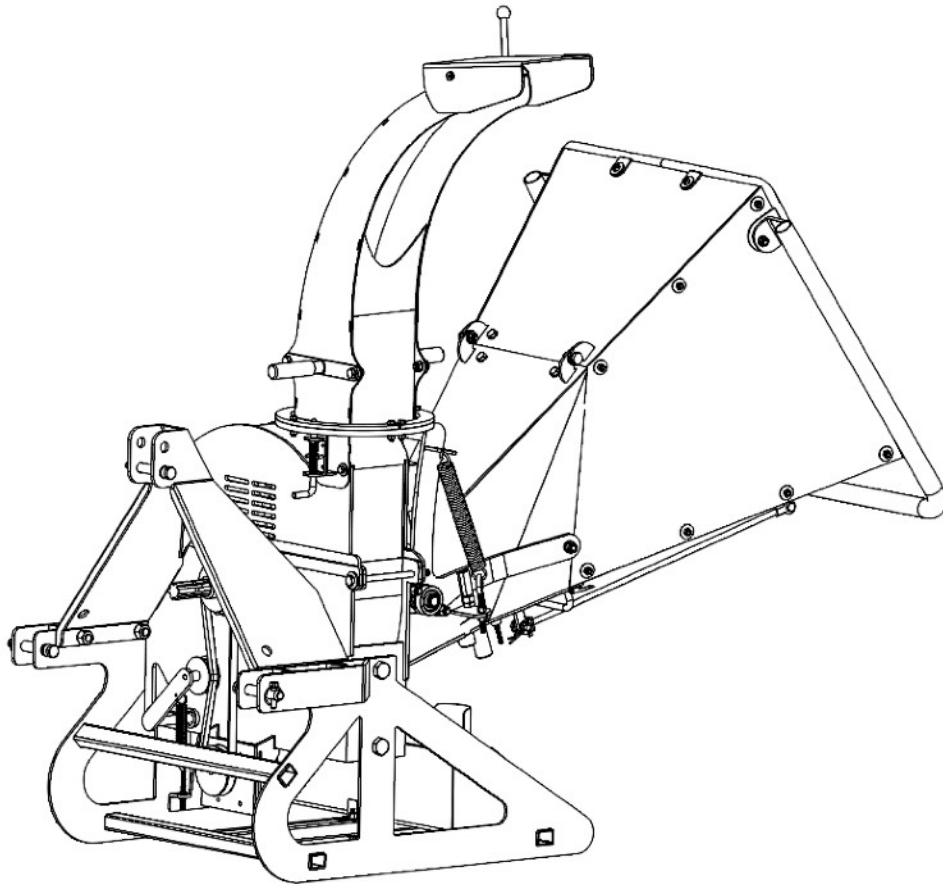


WC68 PTO WOOD CHIPPER

2018

WC68

04/10/2017



OWNER'S MANUAL





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Dear Woodland Mills Customer,

Congratulations and thank you for choosing the Woodland Mills™ WC68 wood chipper! It was designed to be the best valued PTO wood chipper on the market. Please take the time to read through the manual for detailed instructions on assembly, operation and maintenance. Following the procedures and recommendations in this manual will ensure you yield maximum performance and safety from the WC68 wood chipper.

For any technical questions or replacement parts, please contact Woodland Mills™.

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



INTRODUCTION

INTENDED USE

Woodland Mills 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.

SPECIFICATIONS

SPECIFICATIONS	WC68
PTO Shear Pin	M8 X 45mm Bolt - Class 8.8 (Grade 5)
Drive System	PTO
Transport	3 Point Hitch
Minimum HP Required (at the PTO)	20
Flywheel Size	24" (610mm) Diameter / 100 lbs (46kgs)
Blades	(4) 2.75" x 8.625" x 0.3125" (70mm x 219mm x 8mm)
Blade Bolts	M10
In-Feed System	Hydraulic
Hydraulic Oil	ISO 32 (ISO 46 for warmer climates)
Hydraulic Requirement	None. Self contained.
In-Feed Roller	8.25" (210mm) Diameter
Hopper Opening	24" x 26" (610mm x 660mm)
Weight	710 lbs (320kgs)



SAFETY

- Do not operate this machine until this manual has been read and fully understood; serious injury or severe machine damage can 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 can 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 chipper.
- DO NOT stand directly in front of the infeed hopper when loading material into the hopper; always load from the side of the hopper. This will not allow any part of your body to be pulled into the machine.
- Always wear safety hearing protection, eye wear, gloves, and long pants when operating the chipper.
- Never place your hands beyond the opening of the hopper while the chipper is running.
- Never allow children, disabled, or untrained persons to operate the chipper.
- Do not operate the chipper near bystanders, public roads, or anywhere that the debris may travel far enough to injure another person.
- Never move the chipper while it is running.
- Shut off the tractor and allow the chipper to come to a complete stop before removing any debris.
- Never perform any maintenance or repair while the chipper is running.

SAFETY



STAY CLEAR OF ROTATING DRIVELINES

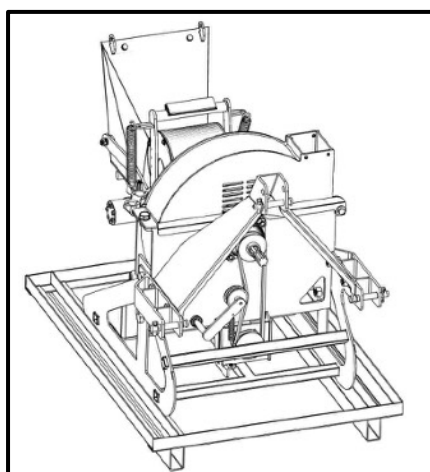
- Entanglement in rotating driveline can cause serious injury or death.
- Keep tractor master shield and driveline shields in place at all times. Make sure rotating shields turn freely.
- Wear close fitting clothing.
- Stop the engine and be sure that PTO driveline is stopped before making adjustments, connections, or cleaning out PTO driven equipment.
- Do not install any adapter device between the tractor and the primary implement PTO drive shaft that will 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.

ASSEMBLY

The WC68 wood chipper will arrive in a steel crate and will require minimal assembly and set up. Follow the below steps to properly assemble and set up your chipper.

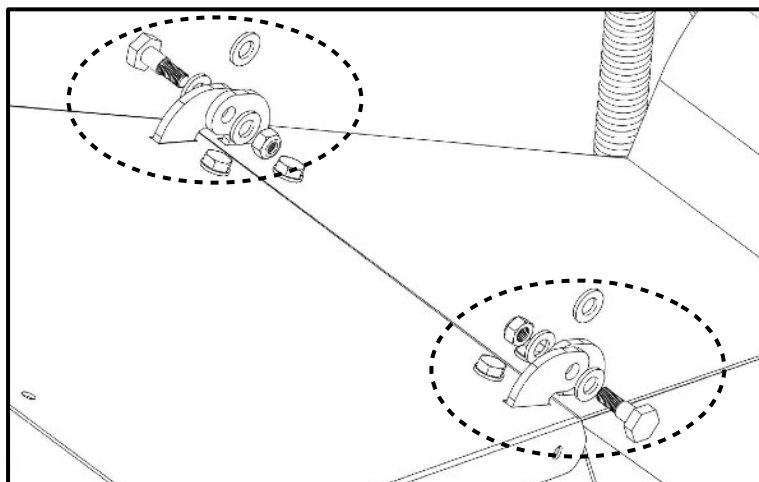
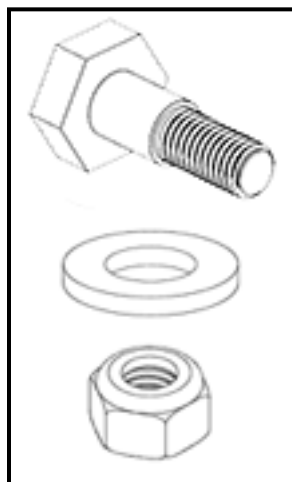
UNPACKING

The upper steel crate frame may be removed from the crate base by removing the bolts at the bottom. The wrapped chipper parts may also be removed from the crate at this point and packaging material removed. When finished, the chipper will be sitting on the base of the steel crate as shown below.



INFEED CHUTE PANELS

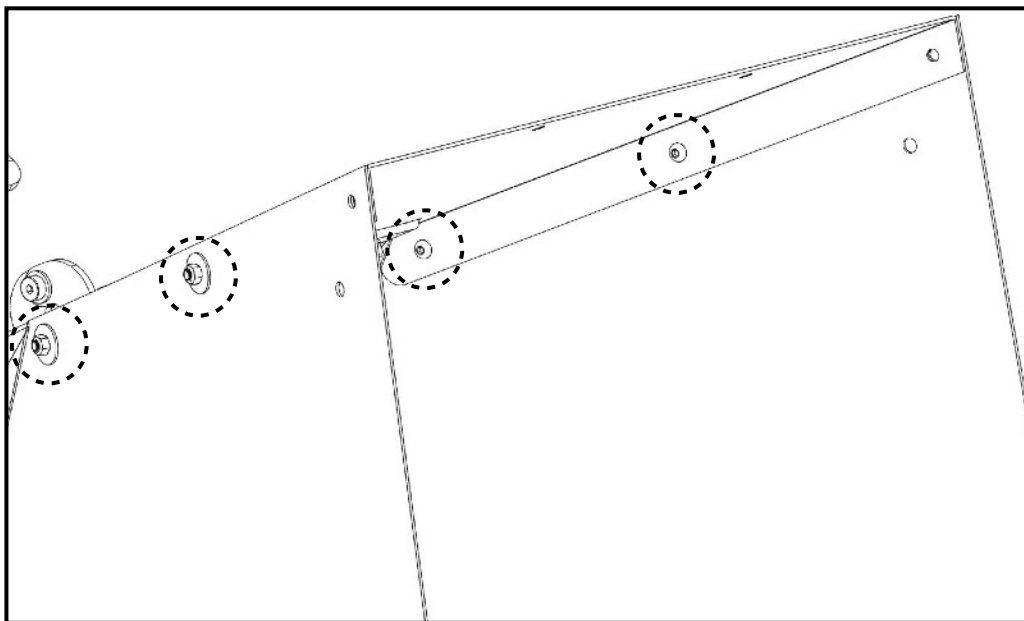
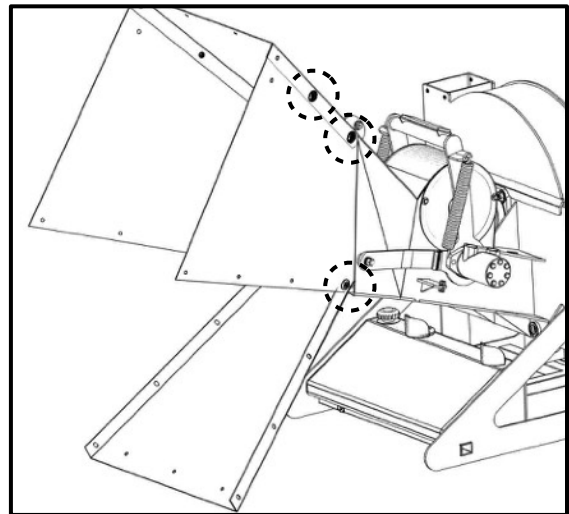
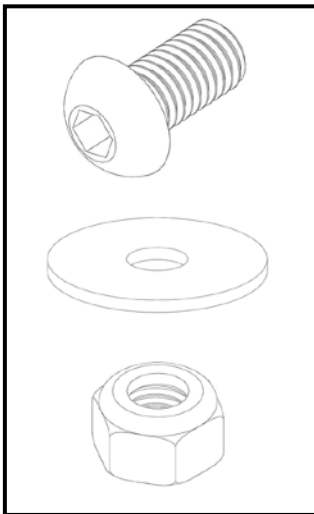
The chipper infeed chute consists of four (4) metal panels that require bolting together. Begin by locating the top panel. It contains two (2) hinge locations that get bolted to the hinge on the chipper. Using the two (2) bolts, lock nuts and washers, assemble as shown below and tighten the bolts.



ASSEMBLY

INFEED CHUTE PANELS CONTINUED...

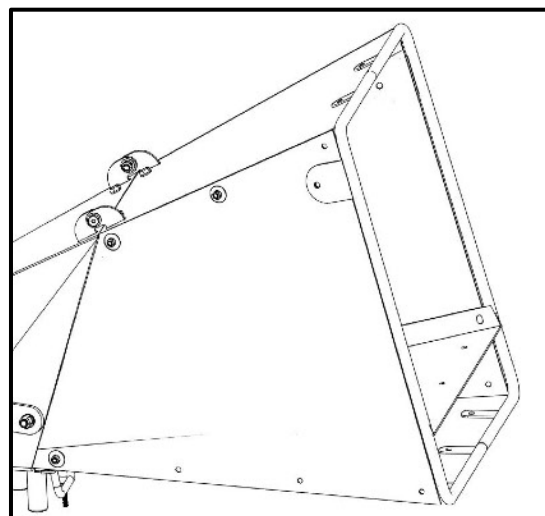
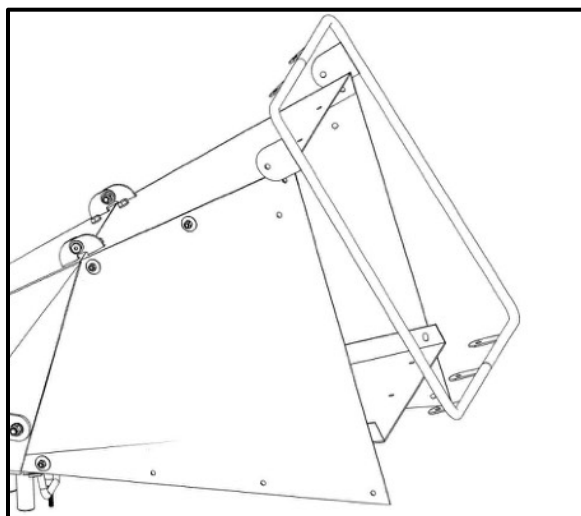
With the top panel bolted to the hinge, the two (2) side panels can now be bolted to the outside of it using the M6 allen key socket button head bolts, 13mm lock nuts and flat washers. Install 2 bolts per side and leave the last bolt out at this point. Do not fully tighten the bolts yet. The head of the bolt should be on the inside of the chute with the washer and lock nut on the outside. The bottom panel may now be installed with the first two (2) bolts as shown below so that it can be swung up to meet the side panels.



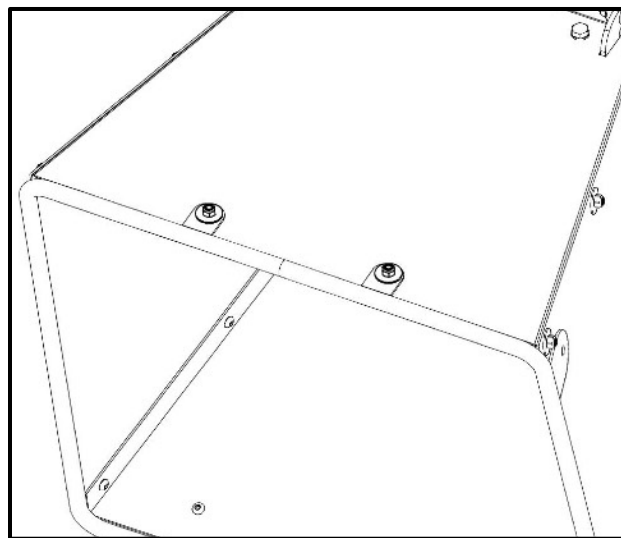
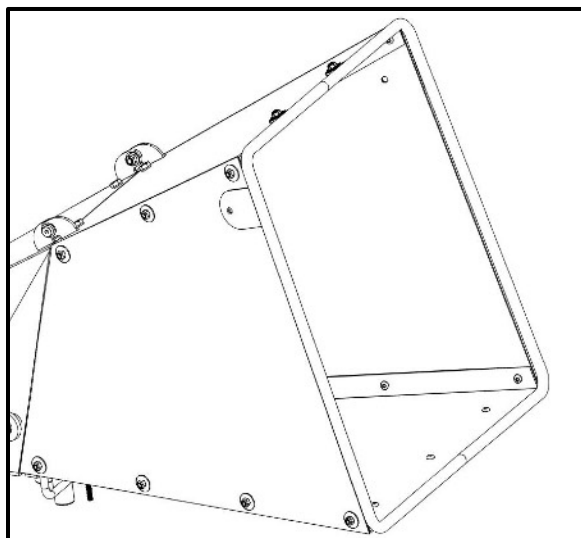
ASSEMBLY

INFEED CHUTE PANELS CONTINUED...

The round edge bar is designed to add additional strength to the infeed panels and also act as a rounded edge, eliminating branches from getting caught on the edge of the infeed panels. To install it, swing the bottom panel up as shown below and fit the tabs of the round bar on the outside of the panels. and are held in place using five (5) M6 allen key headed bolts, 13mm lock nuts and flat washers. There are two tabs on the side of the round edge bar which will be bolted to the side panels in the following step.



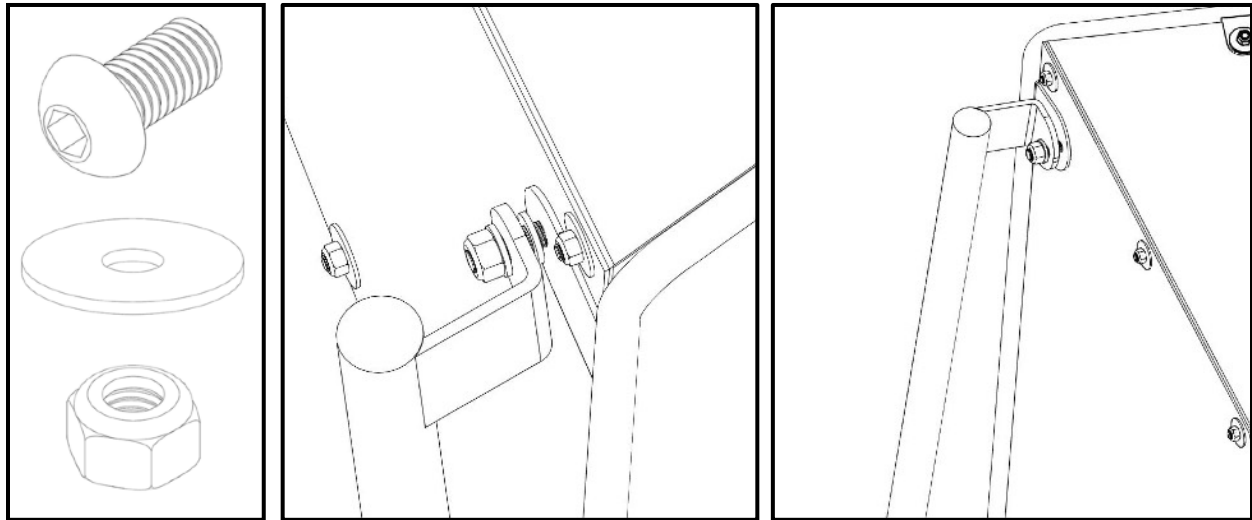
The remaining bolts can be installed as shown below to fully secure the panels and round edge bar in place. Only hand tighten the bolts at this point.



ASSEMBLY

INFEED ROLLER CONTROL HANDLE

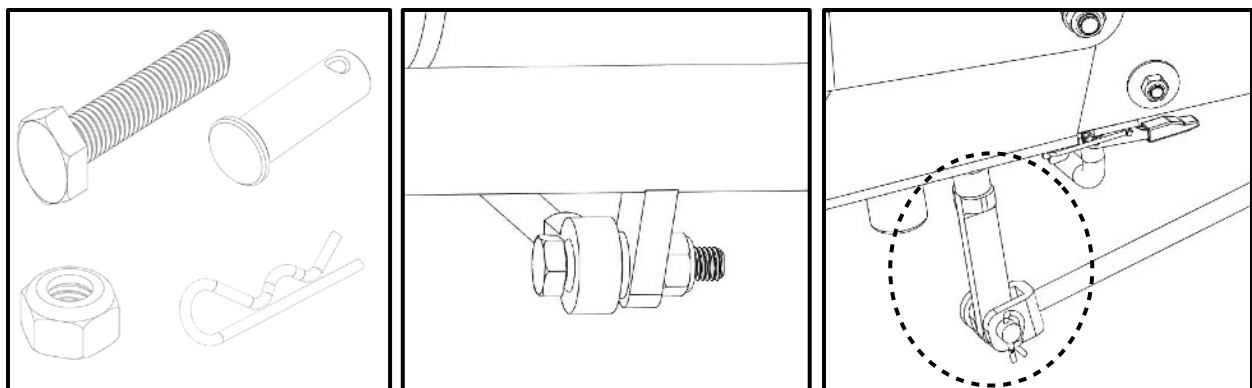
The large red coloured infeed control handle is attached using the two (2) M10 allen key headed bolts, lock nuts and flat washers. These bolts will go through the panel, round edge bar side tabs and through the control handle as shown below.



With all of the bolts loosely installed for the infeed panels, they can all be tightened securely.

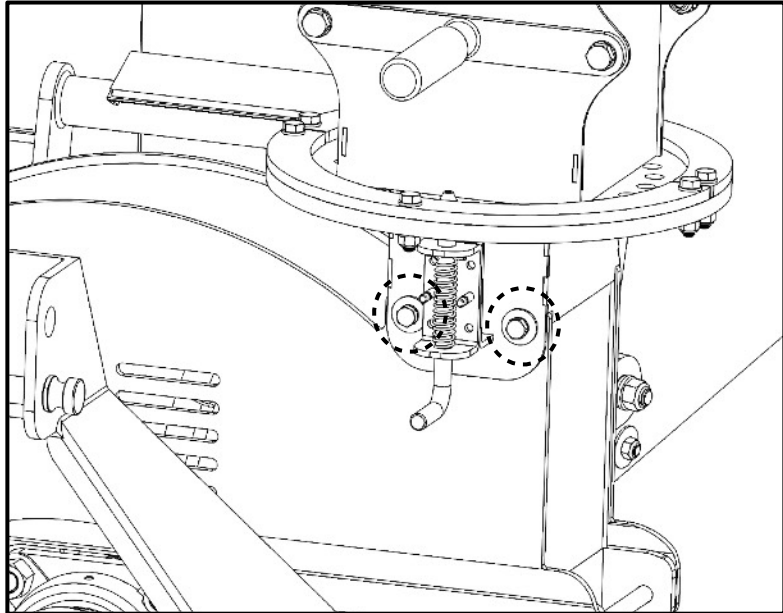
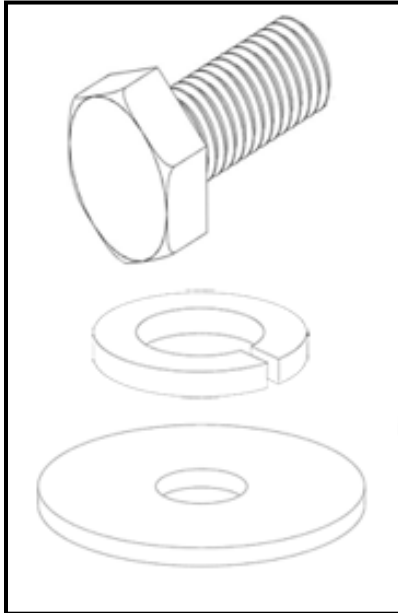
INFEED ROLLER LINKAGE ARM

With the control handle now fastened to the infeed chute, the linkage arm can be connected to it and the hydraulic control valve as shown below. The M10 bolt and nut is used to fasten the heim joint to the red coloured control handle. The round pin and clip is used to secure the linkage to the hydraulic valve.



DISCHARGE CHUTE

The discharge chute can be attached to the flywheel housing using the four (4) short M8 bolts, lock washers and flat washers as shown the below.



ASSEMBLY

HARDWARE

Check all bolts and nuts to make sure everything is tight. All hardware is checked at the factory, but sometimes it will vibrate loose during shipment. Also check all fasteners periodically between use. A wood chipper produces high vibration levels which can cause hardware to loosen.

HYDRAULIC OIL

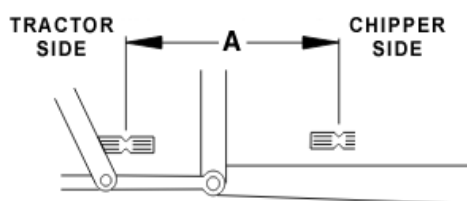
The wood chipper requires 20 litres (5.3 U.S gallons) of ISO 32 hydraulic oil (ISO 46 for warmer climates) before operating. Remove the cap on the hydraulic tank and pour the oil in using a funnel.

ASSEMBLY

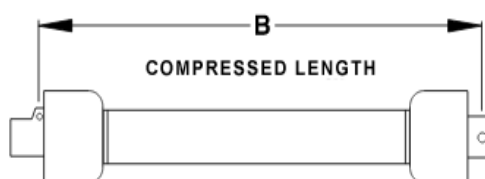
PTO SHAFT LENGTH

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

- 1) Attach the wood chipper to the tractor, but do not install the PTO shaft.
- 2) Raise the chipper using the tractors 3 point hitch system so that the shaft on the tractor is level with the shaft on the chipper.
- 3) Measure the distance between the locking grooves on the shaft of the tractor and chipper (**A**) as shown below.



- 4) Measure the distance between the locking pins on the PTO shaft itself when it is in the compressed/shortest length (**B**) as shown below.



- 5) If (**A**) is at least 1" (25mm) longer than (**B**), the PTO shaft will not need to be cut. It is recommended that (**B**) not be used at a dimension any longer than 38" (96cm).
- 6) If dimension (**B**) is longer than (**A**), the PTO shaft will need to be cut. The below equation may be used to calculate the correct amount to trim.

$$(\mathbf{B-A}) + 1'' = \mathbf{C} \text{ (AMOUNT TO CUT)}$$

- 7) Once (**C**) has been calculated; this amount will need to be cut off of **BOTH** halves of the PTO shaft.
- 8) After both halves of the PTO shaft have been cut, use a file to remove any burrs or sharp edges and slide the shaft together ensuring it telescopes in and out freely. The PTO shaft can now be attached to the chipper and tractor, ready for use.

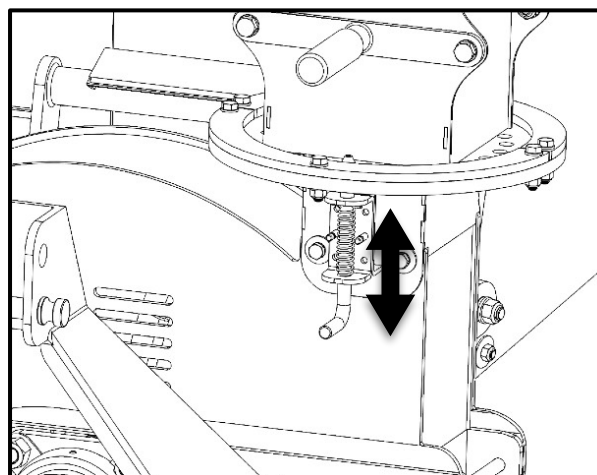
OPERATION

START UP

- Place tractor transmission in neutral and set the parking brake, then turn the tractor engine off.
- Connect the 3 pt. hitch linkages to the chipper and secure them with safety lynch pins.
- Adjust the top link so that the chipper sits level.
- Connect the PTO shaft to the tractor. Make sure that the PTO safety chains are attached to both the tractor and the chipper to keep the protective PTO shield from rotating.
- Turn the discharge chute in a safe direction and adjust the chip deflector to the desired position.
- Start 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 you engage the PTO you could damage the drive belts or break the shear bolt on the PTO shaft. After the rotor is spinning freely raise the tractor RPM's until the PTO speed is at 540 RPM. Most tractor RPM gauges indicate this with a line and or text.
- With the chipper now running at full speed you may begin chipping. Start by feeding small diameter branches until you get better acquainted with the machine and its operation, then you may begin feeding larger pieces.

DISCHARGE CHUTE ADJUSTMENT

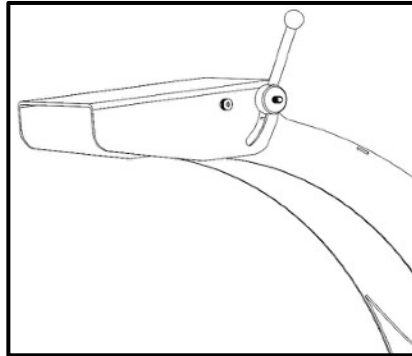
- To position/rotate the discharge chute, push the spring loaded rod down as shown below. The chute is now free to rotate and conveniently does so at a full 360 degrees. Rotate it to the desired position and allow the rod to retract back into the closest locking hole to secure it in position.



OPERATION

DISCHARGE CHUTE DEFLECTOR

- The chip deflector easily adjusts to regulate the distance that the chips are thrown. Loosen the threaded lever, adjust the deflector to the appropriate angle and then tighten threaded lever to secure the deflector's position.



CHIPPING

Keep face and body away from the feed opening. Do not over reach. Keep proper balance and footing at all times. The Woodland Mills 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 chipper in accordance with the safety instructions **MAY RESULT IN PERSONAL INJURY!**

- Be sure the wood chipper is at full operating speed before starting to chip material.
- Select limbs up to 6 inches in diameter. Trim side branches that cannot be bent enough to feed into the chipper 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 chipper.
- Never lean into the infeed chute or extend any parts of your body inside the infeed chute to push objects further into the chipper. Use another stick or branch.
- Do not use hand tools to push brush into the chipper. They can go through the chipper and can cause injury or damage to the wood chipper.
- Place branches, butt end first, into the chipper chute until it contacts the infeed roller. Once the infeed roller contacts the branches, it will pull the material inwards.
- **NOTE:** The wood chipper blades dull with use and require periodic sharpening or replacement. Refer to service and maintenance, "sharpening chipper blades" for further instructions.



OPERATION

STOPPING

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

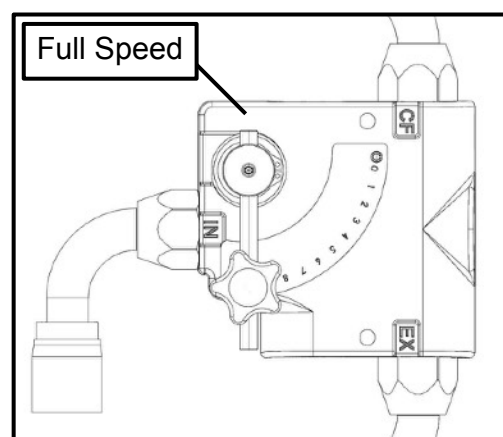
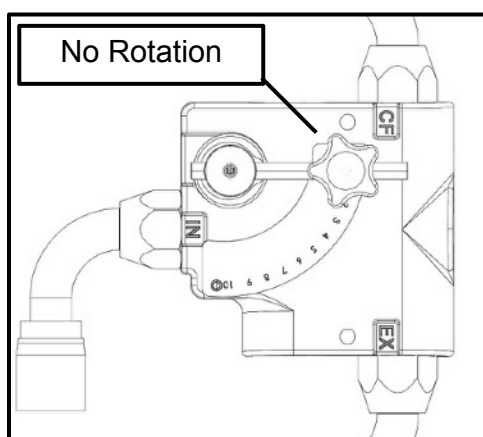
- Move tractor throttle to SLOW / IDLE position.
- Disengage PTO lever and shut off tractor engine.
- Allow the wood chipper to come to a complete stop.
- **NOTE:** The flywheel continues to rotate for some time after the engine or tractor has been shut off. The rotor is stopped when no noise or machine vibration is present. The PTO shaft will also no longer be rotating.

OPERATION

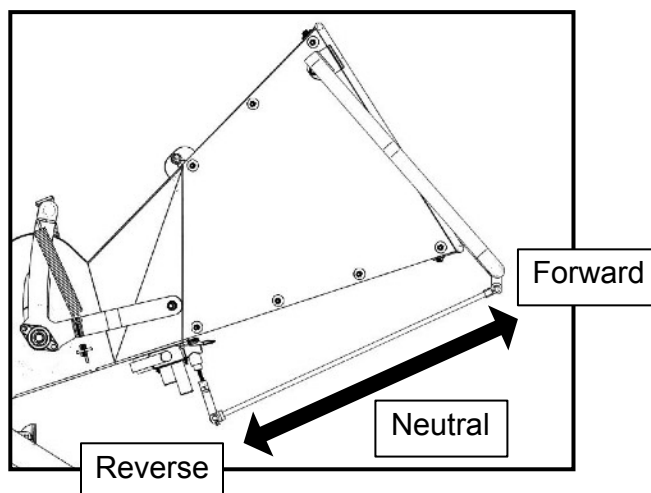
INFEEED ROLLER CONTROL

The chipper comes standard with an infeed roller speed control valve. Moving the arm shown in the below pictures will increase or decrease the speed of the roller. The number "0" represents (left image) no rotation of the infeed roller while number "10" (right image) represents full speed.

To change the speed of the infeed roller, place the red coloured feed control handle bar in the neutral position. When this is done, the feed roller should not be rotating. The speed control valve can now be moved to the desired position.



The infeed roller can be set to three (3) different rotation settings – Forward, Neutral & Reverse. The forward position will pull branches into the chipper, neutral will stop the roller from turning and reverse will push branches back out of the chipper towards the operator. See the below picture for these positions:

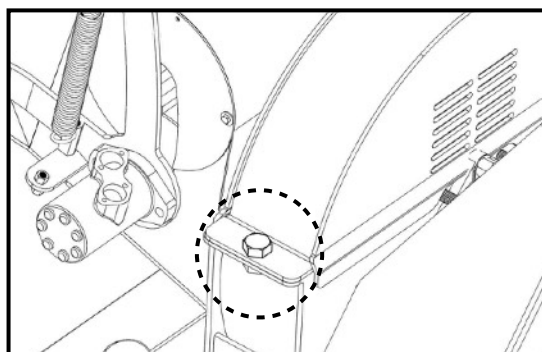


MAINTENANCE & SERVICE

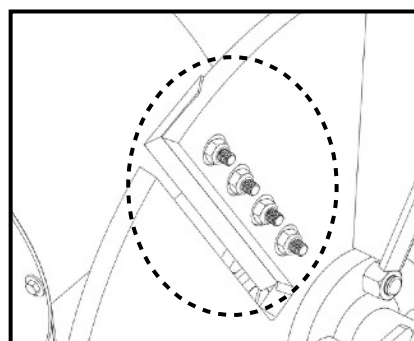
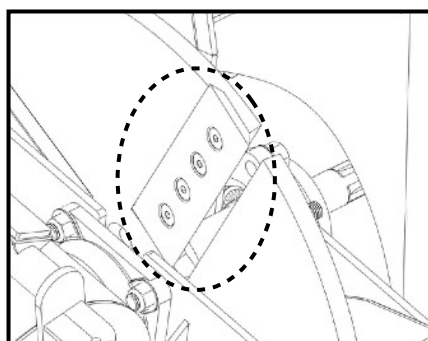
REPLACING BLADES

Follow these steps to replace the blades. The WC68 wood chipper uses four (4) hardened steel blades. The blades are reversible and are 2.75" x 8.625" x 0.3125" (70mm x 219mm x 8mm) in size.

- 1) If installed, the PTO shaft should be disconnected from the tractor for safety.
- 2) The upper flywheel housing can be opened to access the blades by using a 24mm wrench to remove the bolt holding the two halves together.



- 3) With the flywheel now exposed, rotate it so that there is access to the first blade. Using a 17mm wrench or socket on the nut and a 6mm allen key on the bolt, remove the four bolts holding the blade onto the flywheel. Ensure that you do not drop the nuts or bolts into the bottom of the flywheel housing. If this occurs, a long pen magnet can be used to retrieve them.



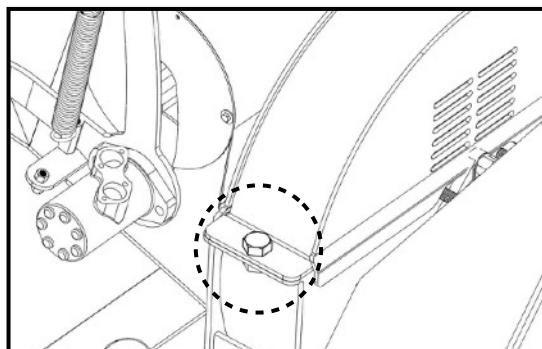
- 4) Repeat step 3 to remove the other three blades. At this point, the blades can be reversed to utilize the other cutting edge or the entire blade can be removed and either sharpened or replaced with new blades. Always replace the nuts and bolts with new hardware when changing blades or reversing the blades.
- 5) Close the upper flywheel housing and tighten the bolt to secure it to the lower flywheel housing.

MAINTENANCE & SERVICE

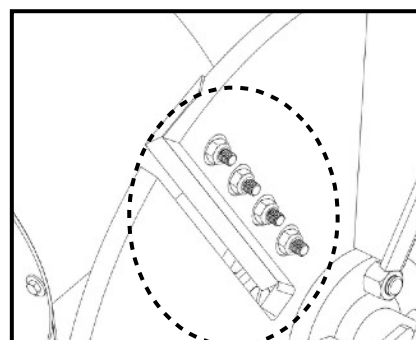
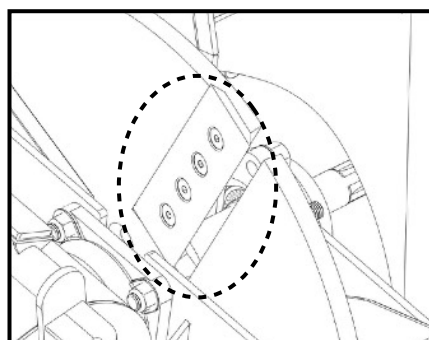
SHARPENING BLADES

The chipper blades will dull, making chipping difficult and your tractor to labour. It is recommended to sharpen the chipper blades every 25-50 hours of chipper operation. The WC68 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) If installed, the PTO shaft should be disconnected from the tractor for safety.
- 2) The upper flywheel housing can be opened to access the blades by using a 24mm wrench to remove the bolt holding the two halves together.



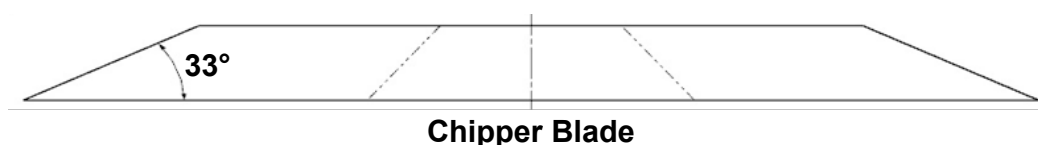
- 3) With the flywheel now exposed, rotate it so that there is access to the first blade. Using a 17mm wrench or socket on the nut and a 6mm allen key on the bolt, remove the two bolts holding the blade onto the flywheel. Ensure that you do not drop the nuts or bolts into the bottom of the flywheel housing. If this occurs, a long pen magnet can be used to retrieve them.



MAINTENANCE & SERVICE

SHARPENING BLADES CONTINUED...

- 4) Grind the angled edge of the chipping blade at **33 degrees** (see below picture) using a slow wet grinder or have them sharpened by a professional. A bench style grinder can yield poor results if not used properly. If sharpened too quickly or aggressively on a bench grinder, the blade edge can get hot and begin to change colour. This indicates overheating and will remove the heat treat properties of the blade. Use short grinding times and cool with water. Remove an equal and consistent amount of material from each blade to maintain proper balance.

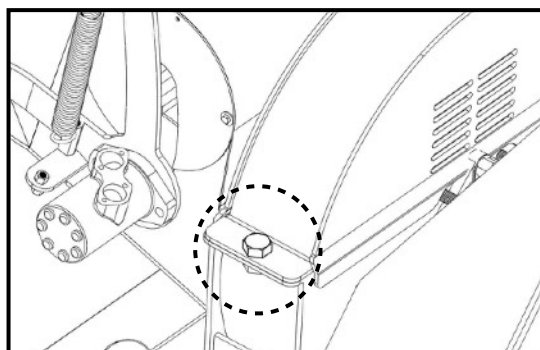


- 5) Re-install the sharpened blades on the flywheel and torque the bolts to **40-45 ft-lbs (54-60N-m)**. Always replace the nuts and bolts with new hardware when changing blades or reversing the blades.

SETTING BED PLATE GAP

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

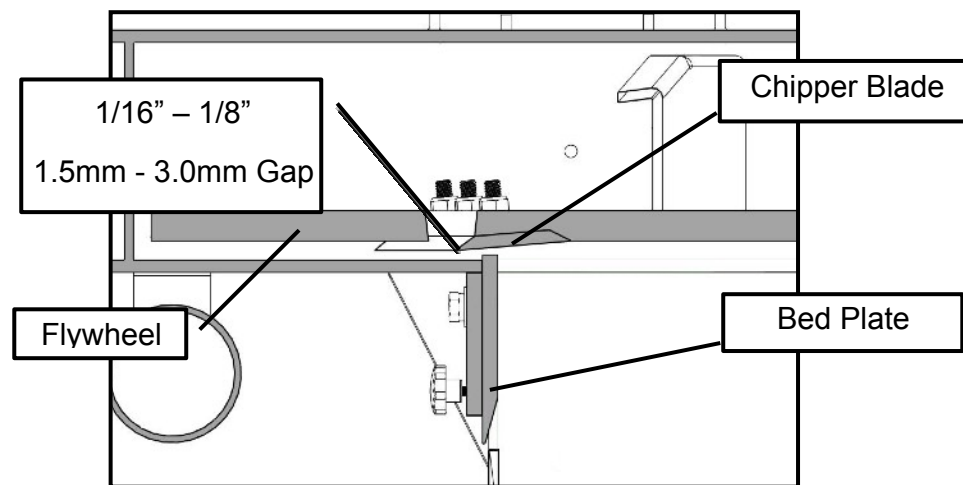
- 1) If installed, the PTO shaft should be disconnected from the tractor for safety.
- 2) The upper flywheel housing can be opened to access the blades by using a 24mm wrench to remove the bolt holding the two halves together.



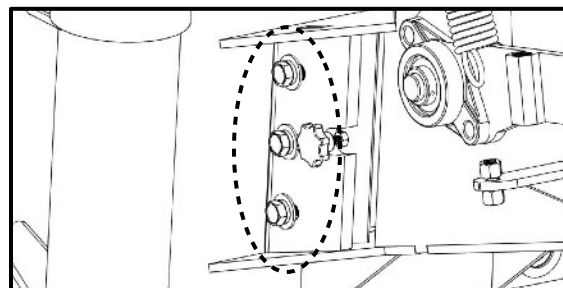
MAINTENANCE & SERVICE

SETTING BED PLATE GAP CONTINUED...

- 3) With the flywheel now exposed, rotate it so that the first blade lines up with the bed plate. The use of a flash light will aid in better viewing. Note the gap. Rotate the flywheel so the second, third and finally the forth blades line up, noting the blade that is the closest. This is the blade that will be used to set the bed plate gap.



- 4) Loosen the three M10 bolts that secure the bed plate to the slotted base plate so that the bed plate is free to slide in and out of slot in the flywheel housing. This movement will increase or decrease the gap between it and the cutting edge of the chipper blade. Position the bed plate so that it is within **1/16" - 1/8" (1.5mm-3.0mm)** of the cutting edge of the blade. Ensure the gap is consistent along the entire edge of the blade.
- 5) Tighten the three (3) M10 bed plate bolts back up to **40 ft-lbs (54 N-m)** when the position is set correctly.



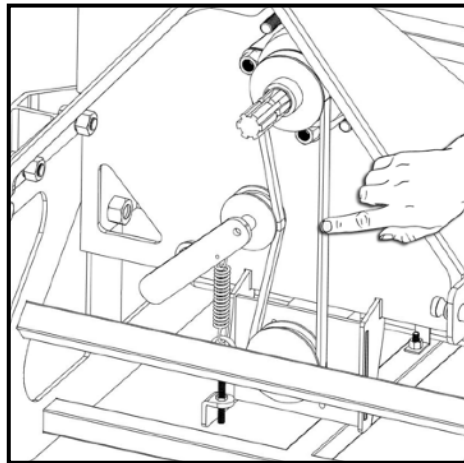
- 6) Rotate the flywheel by hand and note the gap at each chipper blade. Again, the gap should be no more or less than **1/16" - 1/8" (1.5mm-3.0mm)** at each blade.
- 7) Close the upper flywheel housing and tighten the bolt to secure it to the lower flywheel housing.

MAINTENANCE & SERVICE

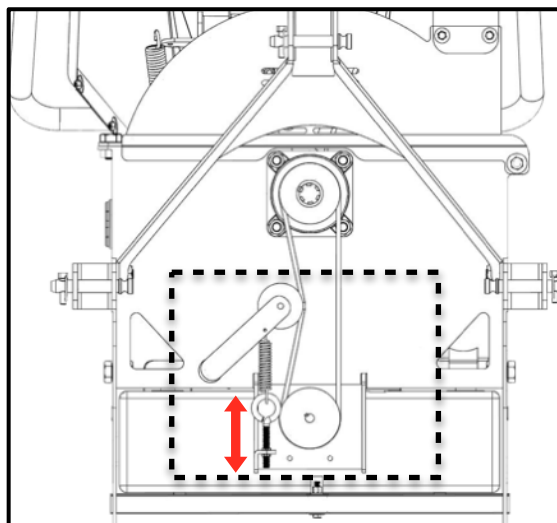
ADJUSTING HYDRAULIC PUMP BELT TENSION

Check the condition and tension of the hydraulic pump belt every 30 hours of chipper operation. The belt is self tensioning via a spring. However, the amount of tension can be adjusted by doing the following:

- 1) If installed, the PTO shaft should be disconnected from the chipper for safety and to allow rotation of the belt guard.
- 2) Check the tension of the belts by pressing on it with your finger. There should not be any free slack in the belt. It should be under firm tension.



- 3) If the belt requires more tension, the eye bolt that the spring attaches to can be tightened. This will stretch the springs further and increase the belt tension until the desired tension is achieved.

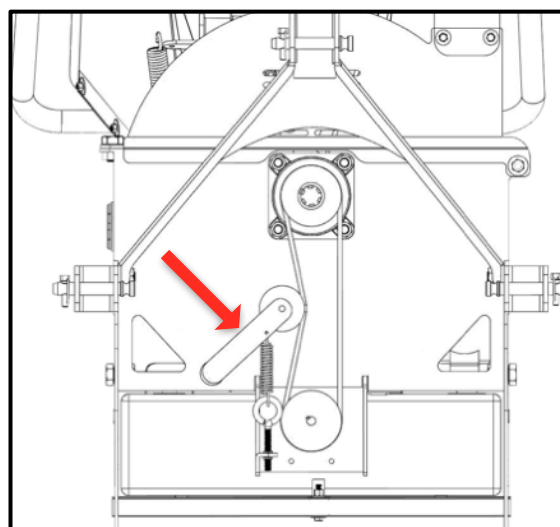
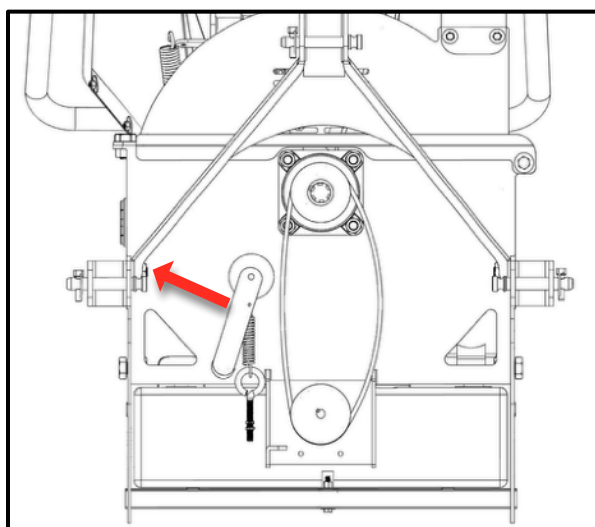


MAINTENANCE & SERVICE

REPLACING THE HYDRAULIC PUMP DRIVE BELT

Check the condition and tension of the hydraulic pump belt every 30 hours of chipper operation. If the infeed roller is not turning or turning slowly, the belt may be slipping. A squealing noise may also be heard. In either case, these conditions can occur due to improper belt tension as described on the previous page or a worn belt. To replace a worn belt, follow the below steps:

- 1) If installed, the PTO shaft needs to be disconnected from the chipper for safety.
- 2) Loosen the nuts that secure the eye bolt to the steel bracket so that the spring can be disconnected from the belt tensioning arm. The arm can now be swung back out of the way allowing the belt to be removed from the two pulleys.
- 3) Install the new belt and reinstall the spring. Re-tension the spring. There should not be any free slack in the belt. It should be under firm tension when pushed with your finger.



GREASABLE BEARINGS

The chipper has five (5) grease zerk fittings on the bearings & PTO shaft. Check bearings before each use and add grease as needed:

- Two grease zerks on the PTO shaft itself.
- Two greaseable bearings on the flywheel shaft.
- One greaseable bearing on the infeed roller



PARTS LIST

P/N	Description	Quantity
9	Pin	2
20	Shaft Pin B	1
41	Spring	2
47	Hydraulic Tank	1
48	Tank Pick-up Pipe	1
53	Bushing	2
54	Bearing Housing	1
55	Block Bearing UCFLU204	1
58	Block Bearing UCF210	2
60	Bearing 6205	1
61	Tank Filter	1
62	Filler Cap Filter	1
63	Hydraulic Line D	1
63a	Nylon Hose Sleeve L=1470	1
66	Hydraulic Line A	2
66a	Nylon Hose Sleeve L=400	2
73	Hydraulic Motor	1
74	Speed Valve	1
75	Directive Valve	1
76	Round Pin 10*30	1
77	Cotter Pin	1
78	Joint Bearing M10	1
79	Y Connector 32	1
81	Nut M10*1.25	1
82	Hex Bolt M12*25	2
83	Instruction Manual Tube	1
84	O Ring	1
89	Circlip 17	1
90	Eye Bolt Nut	2
92	Thread Rod M10*100	2
94	Linch Pin M10*45	3
95	A90 Linch Pin	1
97	Hex Bolt M6*10	3
98	Hex Bolt M6*20	8
99	Hex Bolt M6*60	2
100	Hex Bolt M8*16	4
104	Hex Bolt M8*30	4
111a	Hex Bolt M10*25	3
112	Hex Bolt M10*35	2
116	Hex Bolt M12*55	2

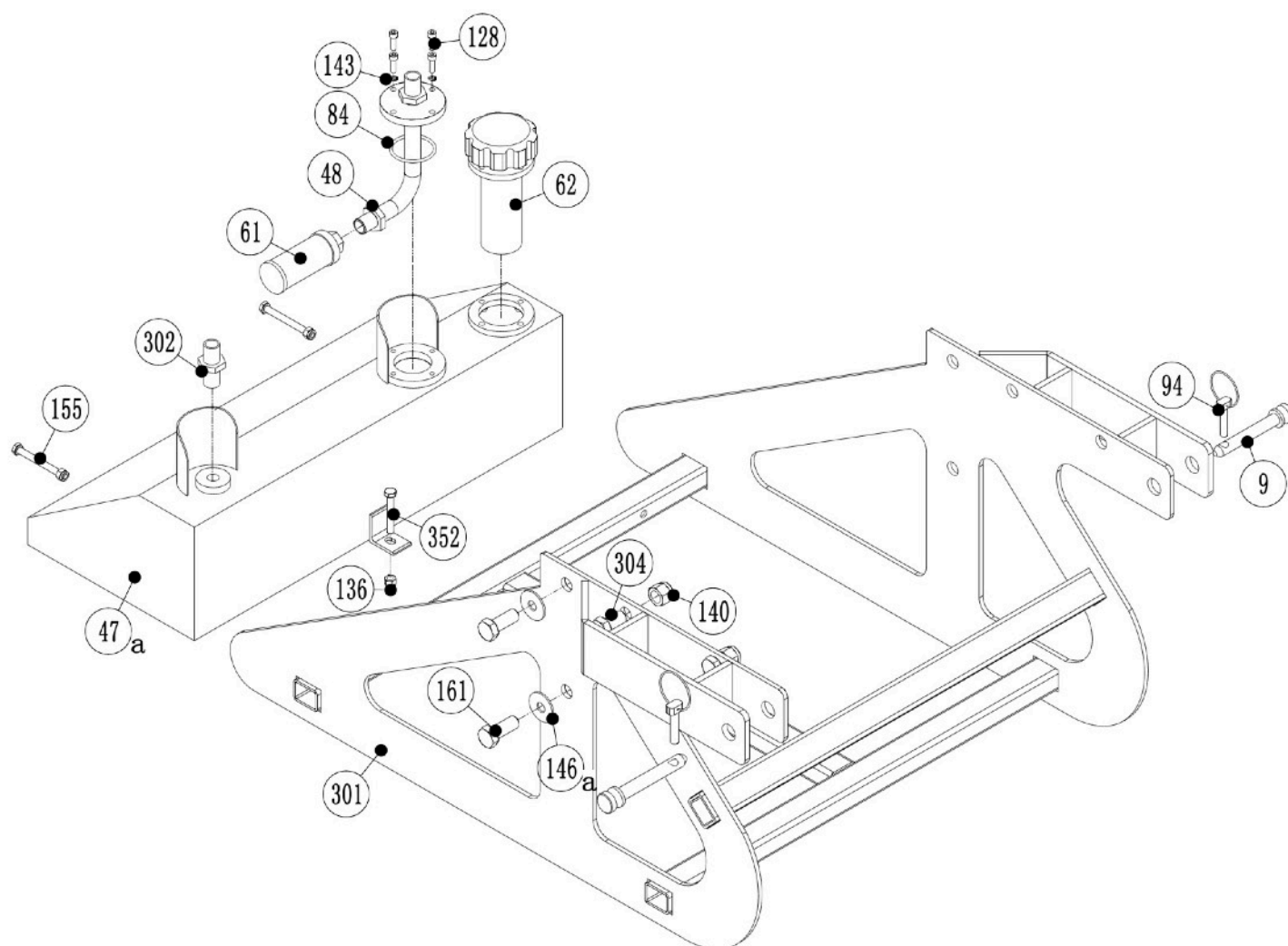
P/N	Description	Quantity
119	Hex Bolt M12*20	2
121	Hex Bolt M16*80	2
122	Bolt M6*10	8
123	Bolt M6*12	3
125	Inner Hex Round Bolt M8*16	21
126	Inner Hex Bolt 12X50	2
128	Inner Hex Bolt M6*20	4
130	Inner Hex Bolt M14*45	8
132	Nut M10	7
133	Nut M16	2
135	Locking Nut M6	14
136	Locking Nut M8	31
137	Locking Nut M10	23
138	Locking Nut M12	9
139	Locking Nut M8	8
140	Locking Nut M16	13
142	Spring Washer M8	4
143	Spring Washer M6	15
144	Flat Wahser M8	25
146a	Flat Washer M16	4
150	Hose Clamp	14
153	A90 Linch Pin	1
154	Hex Bolt M10*35	2
155	Hex Bolt M8*55	2
156	Inner Hex Bolt M10*25	2
157	Plastic Cap	2
158	Flate Washer M12	2
159	Shaft Key	1
160	Inner Hex Bolt 6x8	1
161	Hex Bolt M16*40	4
165	Spring Washer 10	3
301	Base	1
302	7/8-1/2 Coupler	11
304	Hex Bolt M16*30	4
307	Upper Housing	1
308	Hex Bolt M12*180	1
309	Inner Hex Bolt M10*30	16
310	Cutting Blade	4
311	Flywheel	1
312	Inner Hex Bolt M8*16	4

PARTS LIST

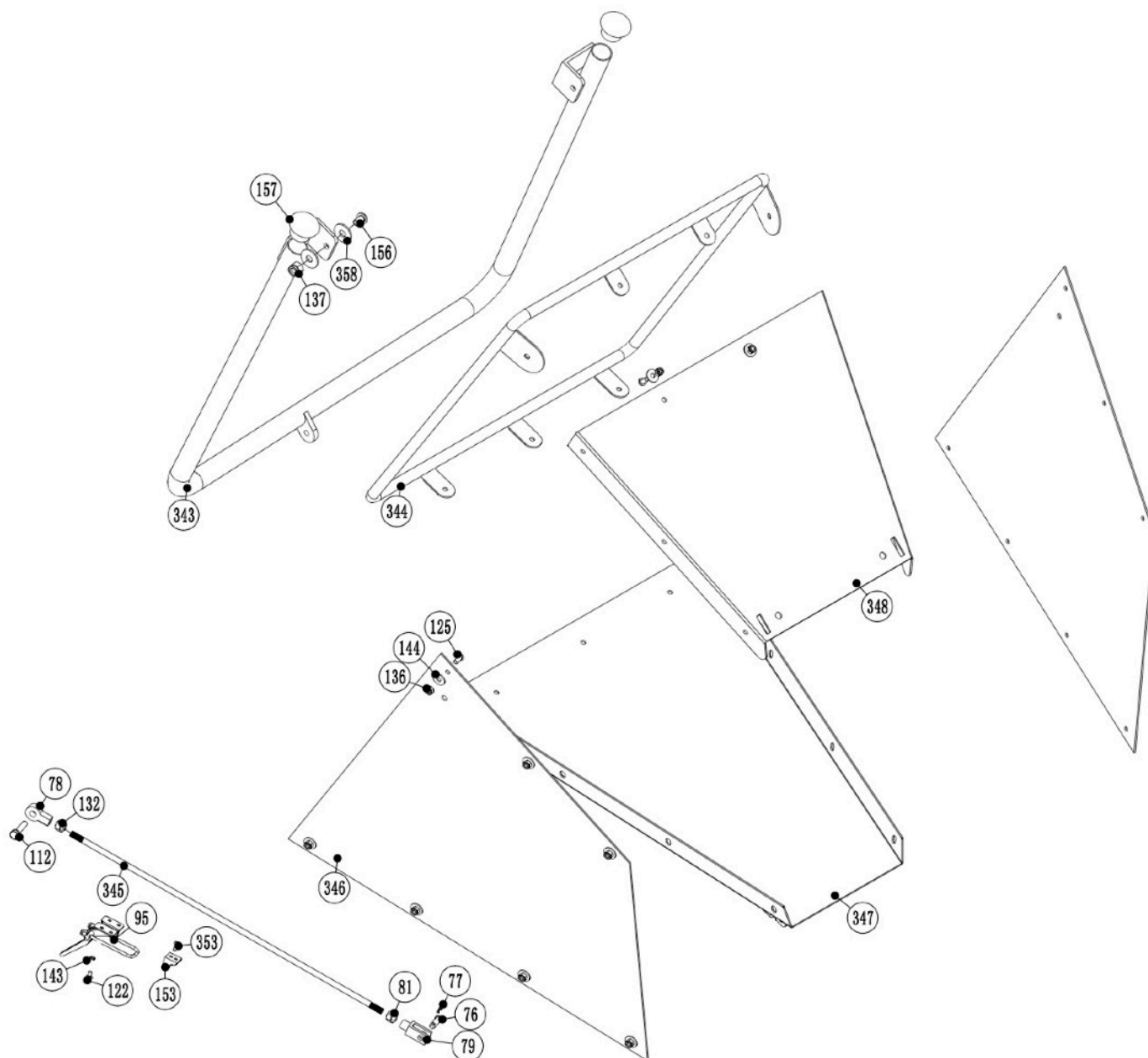
P/N	Description	Quantity
313	Drive Shaft	1
314	Flat Key 10*8	1
315	Inner Hex Bolt 8X10	4
316	Upper Pulley	1
317	AX40 Cogged Belt	1
318	Lower Pulley	1
319	Hydraulic Pump	1
320	Tension Arm	1
321	Spring	1
322	Nut M8	1
323	Threaded Rod M8*60	1
324	Nut M8	4
325	Circlip 15	2
326	Belt Tension Pulley	1
327	Bearing 6203	1
328	Circlip 40	1
329	Belt Tension Pulley Shaft	1
330	Infeed Roller Swing Arm	1
331	Rubber Pad 1	1
332	Hinge Bracket	1
333	Hinge Bracket	1
334	Flat Washer M12	4
335	Flat Washer M10	7
336	Safety Curtain	2
337	Safety Curtain Plate	1
338	Angle Bracket	1
339	Bed Plate	1
340	Round Infeed Side Plate	1
341	1/2 -7/8 Tee Pipe	1
342	Lower Housing	1
343	Infeed Roller Operation Bar	1
344	Infeed Chute Edge Bar	1
345	Infeed Roller Threaded Rod	1
346	Infeed Chute Panel B	2
347	Infeed Chute Panel C	1
348	Infeed Chute Panel A	1
349	Hydraulic Line C	1
349a	Nylon Hose Sleeve L=1120	1
350	Hydraulic Line B	3
350a	Nylon Hose Sleeve L=680	3

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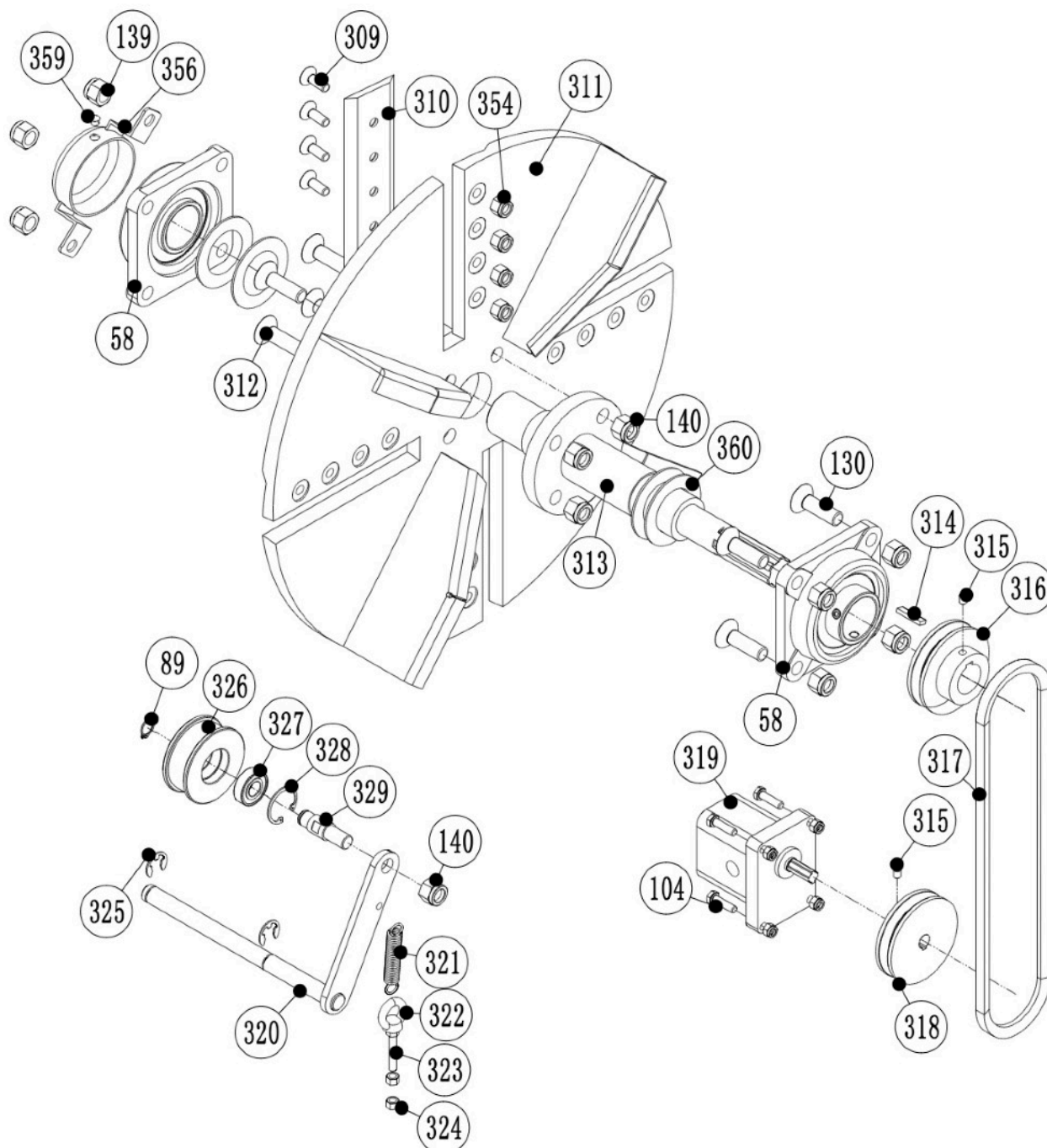
PARTS DIAGRAM



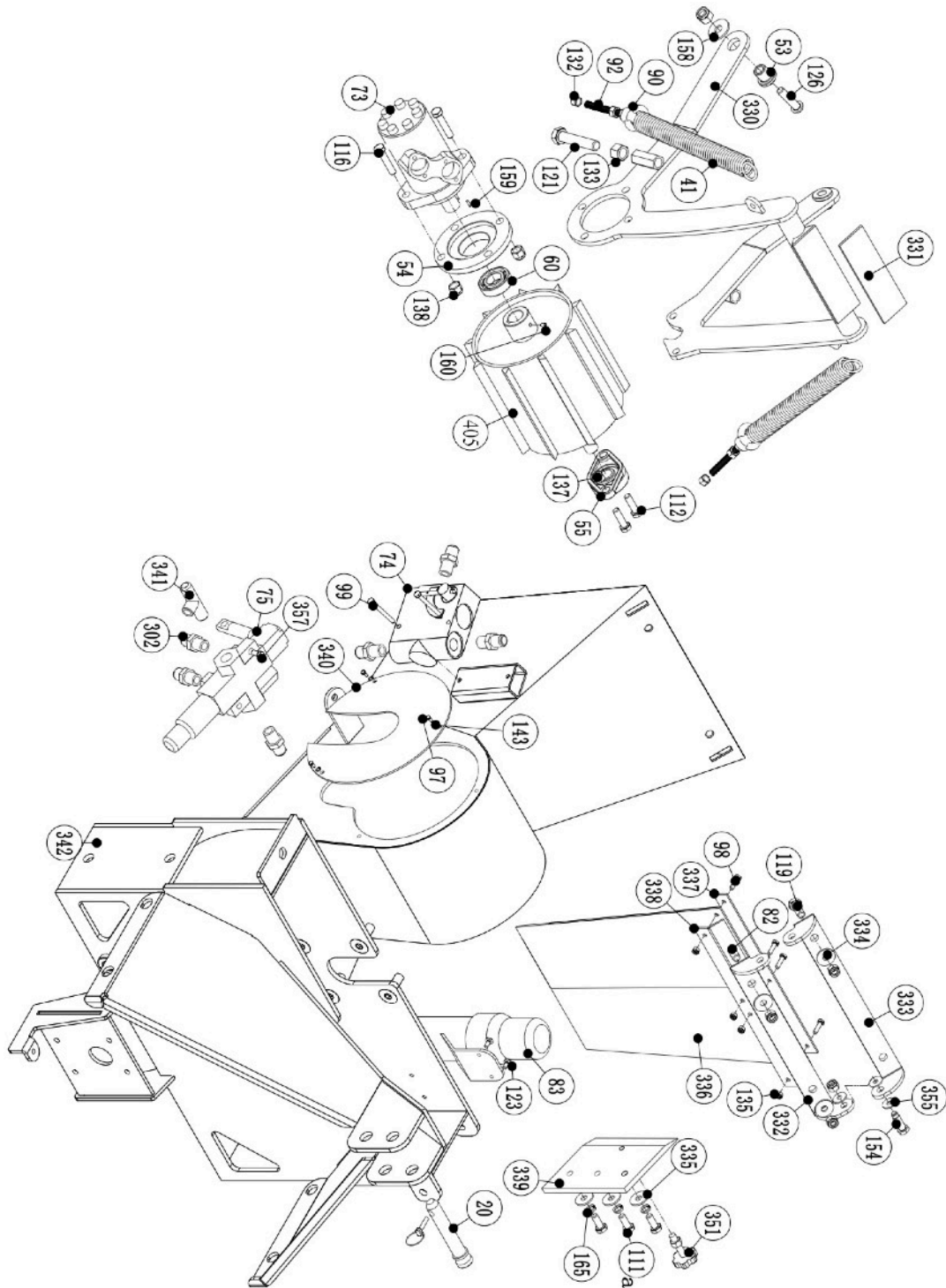
PARTS DIAGRAM



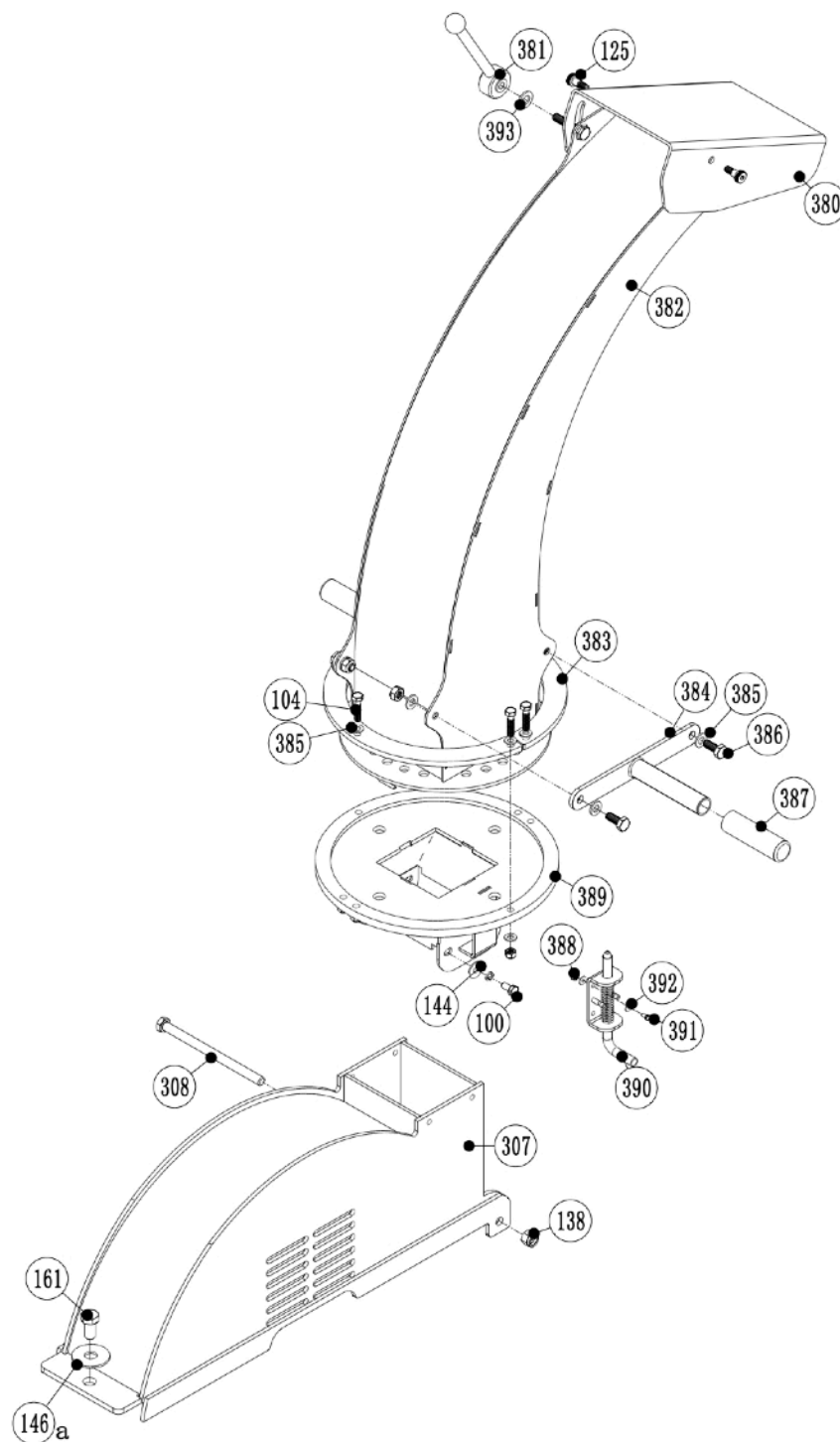
PARTS DIAGRAM



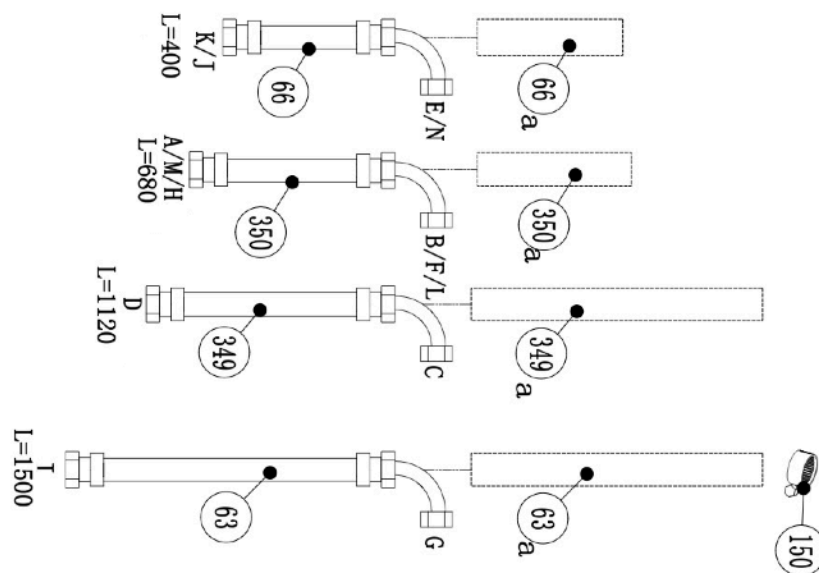
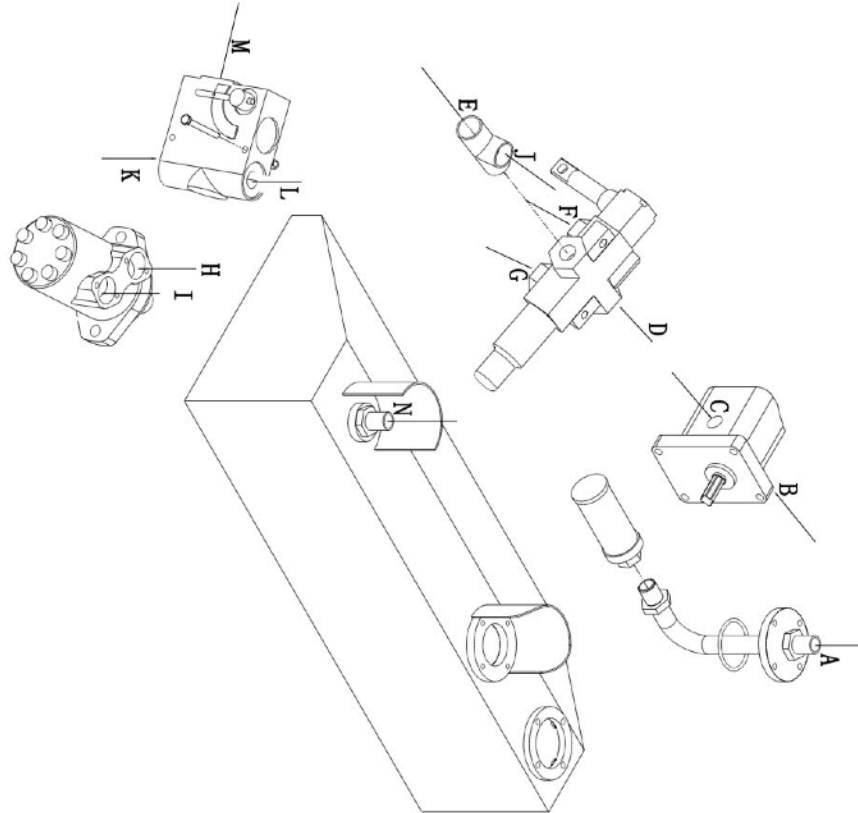
PARTS DIAGRAM



PARTS DIAGRAM



PARTS DIAGRAM





NOTES

This image shows a full page of blank white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page, providing a template for writing or drawing. There are no margins, text, or other markings present.

