

BUSH HOG®

Squealer Series Rotary Cutters

**SQ142, SQ148, SQ160, SQ172, SQ184, SQ84T
Operator's Manual**



BUSH HOG®

ASSEMBLY ● OPERATION ● MAINTENANCE

CONGRATULATIONS!

You have invested in the best implement of its type on the market today.

The care you give your Bush Hog implement will greatly determine your satisfaction with its performance and its service life. We urge a careful study of this manual to provide you with a thorough understanding of your new implement before operating, as well as suggestions for operation and maintenance.

If your manual should become lost or destroyed, Bush Hog will be glad to provide you with a new copy. Order from Bush Hog, 2501 Griffin Ave., Selma, Alabama, 36703. Most of our manuals can also be downloaded from our website at www.bushhog.com.

As an authorized Bush Hog dealer, we stock genuine Bush Hog parts which are manufactured with the same precision and skill as our original equipment. Our trained service personnel are well informed on methods required to service Bush Hog equipment, and are ready and able to help you.

Should you require additional information or assistance, please contact us.

YOUR AUTHORIZED
BUSH HOG DEALER

BECAUSE BUSH HOG MAINTAINS AN ON GOING PROGRAM OF PRODUCT IMPROVEMENT, WE RESERVE THE RIGHT TO MAKE IMPROVEMENTS IN DESIGN OR CHANGES IN SPECIFICATIONS WITHOUT INCURRING ANY OBLIGATION TO INSTALL THEM ON UNITS PREVIOUSLY SOLD.

BECAUSE OF THE POSSIBILITY THAT SOME PHOTOGRAPHS IN THIS MANUAL WERE TAKEN OF PROTOTYPE MODELS, PRODUCTION MODELS MAY VARY IN SOME DETAIL. IN ADDITION, SOME PHOTOGRAPHS MAY SHOW SHIELDS REMOVED FOR PURPOSES OF CLARITY. **NEVER OPERATE THIS IMPLEMENT WITHOUT ALL SHIELDS IN PLACE.**

SQUEALER ROTARY CUTTERS

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RETAIL CUSTOMER'S RESPONSIBILITY UNDER THE BUSH HOG WARRANTY

It is the Retail Customer and/or Operator's responsibility to read the Operator's Manual, to operate, lubricate, maintain and store the product in accordance with all instructions and safety procedures. Failure of the operator to read the Operator's Manual is a misuse of this equipment.

It is the Retail Customer and/or Operator's responsibility to inspect the product and to have any part(s) repaired or replaced when continued operation would cause damage or excessive wear to other parts or cause a safety hazard.

It is the Retail Customer's responsibility to deliver the product to the authorized Bush Hog Dealer, from whom he purchased it, for service or replacement of defective parts which are covered by warranty. Repairs to be submitted for warranty consideration must be made within forty-five (45) days of failure.

It is the Retail Customer's responsibility for any cost incurred by the Dealer for traveling to or hauling of the product for the purpose of performing a warranty obligation or inspection.



BUSH HOG[®]
Performance You Can Count OnSM

LIMITED WARRANTY



Bush Hog warrants to the original purchaser of any new Bush Hog equipment, purchased from an authorized Bush Hog dealer, that the equipment be free from defects in material and workmanship for a period of one (1) year for non-commercial, state, and municipalities' use and ninety (90) days for commercial use from date of retail sale. Squealer Model gearboxes are covered by a five (5) year limited warranty period. The obligation of Bush Hog to the purchaser under this warranty is limited to the repair or replacement of defective parts.

Replacement or repair parts installed in the equipment covered by this limited warranty are warranted for ninety (90) days from the date of purchase of such part or to the expiration of the applicable new equipment warranty period, whichever occurs later. Warranted parts shall be provided at no cost to the user at an authorized Bush Hog dealer during regular working hours. Bush Hog reserves the right to inspect any equipment or parts which are claimed to have been defective in material or workmanship.

DISCLAIMER OF IMPLIED WARRANTIES & CONSEQUENTIAL DAMAGES

Bush Hog's obligation under this limited warranty, to the extent allowed by law, is in lieu of all warranties, implied or expressed, **INCLUDING IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE** and any liability for incidental and consequential damages with respect to the sale or use of the items warranted. Such incidental and consequential damages shall include but not be limited to: transportation charges other than normal freight charges; cost of installation other than cost approved by Bush Hog; duty; taxes; charges for normal service or adjustment; loss of crops or any other loss of income; rental of substitute equipment, expenses due to loss, damage, detention or delay in the delivery of equipment or parts resulting from acts beyond the control of Bush Hog.

THIS LIMITED WARRANTY SHALL NOT APPLY:

1. To vendor items which carry their own warranties, such as engines, tires, and tubes.
2. If the unit has been subjected to misapplication, abuse, misuse, negligence, fire or other accident.
3. If parts not made or supplied by Bush Hog have been used in connection with the unit, if, in the sole judgement of Bush Hog such use affects its performance, stability or reliability.
4. If the unit has been altered or repaired outside of an authorized Bush Hog dealership in a manner which, in the sole judgement of Bush Hog, affects its performance, stability or reliability.
5. To normal maintenance service and normal replacement items such as gearbox lubricant, hydraulic fluid, worn blades, or to normal deterioration of such things as belts and exterior finish due to use or exposure.
6. To expendable or wear items such as teeth, chains, sprockets, belts, springs and any other items that in the company's sole judgement is a wear item.

NO EMPLOYEE OR REPRESENTATIVE OF BUSH HOG IS AUTHORIZED TO CHANGE THIS LIMITED WARRANTY IN ANY WAY OR GRANT ANY OTHER WARRANTY UNLESS SUCH CHANGE IS MADE IN WRITING AND SIGNED BY BUSH HOG'S SERVICE MANAGER, 2501 GRIFFIN AVE., SELMA, ALABAMA 36703.



Record the model number, serial number and date purchased. This information will be helpful to your dealer if parts or service are required.

MODEL NUMBER _____

SERIAL NUMBER _____

MAKE CERTAIN THE WARRANTY INFORMATION HAS BEEN FILED ONLINE WITH BUSH HOG SELMA, ALABAMA.

DATE OF RETAIL SALE _____

DEALER PREPARATION CHECK LIST

SQUEALER ROTARY CUTTERS

BEFORE DELIVERING MACHINE — The following check list should be completed.
Use the Operator's Manual as a guide.

- 1. Assembly completed.
- 2. Gearbox filled with oil.
- 3. All fittings lubricated.
- 4. All shields in place and in good condition.
- 5. All fasteners torqued to specifications given in Torque Chart.
- 6. Slip clutches have been checked for proper operation.
- 7. All decals in place and readable. (See decal page.)
- 8. Overall condition good (i.e. paint, welds)
- 9. Operators manual has been delivered to owner and he has been instructed on the safe and proper use of the cutter.
- 10. Warranty Information has been filed on line to Bush Hog.
- 11. Purchaser or dealer elects to delete deflectors. (front belting, rear bands, front and rear chains)

Explanation: _____

WARNING

Deflector kit or chain shielding is standard equipment. Must be used for all non-agricultural uses or in areas where the possibility of thrown objects could be hazardous to persons or property. Use 5/16" double row highway chains for all roadside mowing operations.

Dealer's
Signature _____

Purchaser's
Signature _____

THIS CHECKLIST TO REMAIN IN OWNER'S MANUAL
It is the responsibility of the dealer to complete the procedures listed above before delivery of this implement to the customer.

IMPORTANT SAFETY PRECAUTIONS

This symbol is used to call attention to safety precautions that should be followed by the operator to avoid accidents. When you see this symbol, carefully read the message that follows and heed its advice. Failure to comply with safety precautions could result in serious bodily injury.



In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel in the operation, transport, maintenance and storage of equipment. Lack of attention to safety can result in accident, personal injury, reduction of efficiency and worst of all—loss of life. Watch for safety hazards and correct deficiencies promptly. Use the following safety precautions as a general guide to safe operations when using this machine. Additional safety precautions are used throughout this manual for specific operating and maintenance procedures. Read this manual and review the safety precautions often until you know the limitations.

1. Read the Operator's Manual. Failure to read the Operator's Manual is considered a misuse of this equipment.
2. Become familiar with all the machine's controls and all the caution, warning and danger decals affixed to the machine before attempting to start or operate.
3. Before starting or operating the machine, make a walk around inspection and check for obvious defects such as loose mounting bolts and damaged components. Correct any deficiency before starting.
4. Do not allow children to operate the cutter. Do not allow adults to operate it without proper instruction.
5. Do not carry passengers.
6. Keep the area of operation clear of all persons, particularly small children and pets. The operator should cease mowing whenever anyone comes within the operating area.
7. Clear the work area of objects which might be picked up and thrown.
8. Use a piece of cardboard or wood rather than hands to search for hydraulic leaks. Escaping hydraulic oil under pressure can penetrate skin. If fluid is injected into the skin, it must be surgically removed within a few hours by a doctor familiar with this form of injury or gangrene may result.
9. Do not operate without all guards and shields in place and in good condition.
10. Lower implement to ground, stop tractor engine, apply parking brake, and allow blades to completely stop before leaving the tractor.
11. Keep hands and feet away from blades.
12. This cutter is not to be operated along highways or in any area where people may be present unless all sides of the unit are enclosed by permanent bands, safety chains or other factory approved safety shields that are in good repair.
13. Wear personal protective equipment such as, but not limited to, protection for eyes, ears, feet, hands and head when operating or repairing the equipment. Do not wear loose clothing or jewelry that may catch on equipment moving parts.
14. When performing adjustments or maintenance on the cutter, first lower it to the ground or block it securely at a workable height.
15. Never stand between tractor and cutter while tractor is being backed to the cutter hitch.
16. Reduce speed when transporting cutter to avoid bouncing and momentary loss of steering.
17. Use tractor flashing warning lights, day or night, when transporting cutter on road or highways unless prohibited by law.
18. In the event that someone other than yourself will operate this equipment we firmly suggest that all SAFETY references be discussed prior to operation.
19. It is recommended that tractor be equipped with Rollover Protective System (ROPS) and seat belt be used in all mowing operations.

IMPORTANT FEDERAL LAWS AND REGULATIONS* CONCERNING EMPLOYERS, EMPLOYEES AND OPERATIONS.

*(This section is intended to explain in broad terms the concept and effect of the following federal laws and regulations. It is not intended as a legal interpretation of the laws and should not be considered as such).

U.S. Public Law 91-596 (The Williams-Steiger Occupational and Health Act of 1970) OSHA

This Act Seeks:

“...to assure so far as possible every working man and woman in the nation safe and healthful working conditions and to preserve our human resources...”

DUTIES

Sec. 5 (a) Each employer—

- (1) shall furnish to each of his employees employment and a place of employment which are free from recognized hazards that are causing or are likely to cause death or serious physical harm to his employees;
- (2) shall comply with occupational safety and health standards promulgated under this Act.
 - (b) Each employee shall comply with occupational safety and health standards and all rules, regulations and orders issued pursuant to this Act which are applicable to his own actions and conduct.

OSHA Regulations

Current OSHA regulations state in part: “At the time of initial assignment and at least annually thereafter, the employer shall instruct every employee in the safe operation and servicing of all equipment with which the employee is, or will be involved.” These will include (but are not limited to) instructions to:

Keep all guards in place when the machine is in operation;

Permit no riders on equipment;

Stop engine, disconnect the power source, and wait for all machine movement to stop before servicing, adjusting, cleaning or unclogging the equipment, except where the machine must be running to be properly serviced or maintained, in which case the employer shall instruct employees as to all steps and procedures which are necessary to safely service or maintain the equipment.

Make sure everyone is clear of machinery before starting the engine, engaging power, or operating the machine.

EMPLOYEE TRACTOR OPERATING INSTRUCTIONS:

1. Securely fasten your seat belt if the tractor has a ROPS.
2. Where possible, avoid operating the tractor near ditches, embankments, and holes.
3. Reduce speed when turning, crossing slopes, and on rough, slick, or muddy surfaces.
4. Stay off slopes too steep for safe operation.
5. Watch where you are going, especially at row ends, on roads, and around trees.
6. Do not permit others to ride.
7. Operate the tractor smoothly - no jerky turns, starts, or stops.
8. Hitch only to the drawbar and hitch points recommended by tractor manufacturers.
9. When tractor is stopped, set brakes securely and use park lock if available.

Child Labor Under 16 Years Old

Some regulations specify that no one under the age of 16 may operate power machinery. It is your responsibility to know what these regulations are in your own area or situation. (Refer to U.S. Dept. of Labor, Employment Standard Administration, Wage & Home Division, Child Labor Bulletin #102.)

SECTION I

INTRODUCTION AND DESCRIPTION

1-1 INTRODUCTION

We are pleased to have you as a Bush Hog customer. Your Squealer Series Rotary Cutter has been carefully designed to give maximum service with minimum down time. This manual is provided to give you the necessary operating and maintenance instructions for keeping your rotary cutter in top operating condition. Please read this manual thoroughly. Understand what each control is for and how to use it. Observe all safety precautions decaled on the machine and noted throughout the manual for safe operation of implement. If any assistance or additional information is needed, contact your authorized Bush Hog dealer.

The squealer Cutters (Figure 1-1) are light duty cutters designed for cutting grass and small brush. Each cutter has free-swinging blades which reduce the shock of impact when a stationary object is hit. A shear bolt through the input shaft (SQ142, SQ148) or offset shear bolt (SQ160, SQ172) protects the gearbox and driveline from damage on all models except the SQ184 and SQ84T, which have slip clutches standard. Slip clutches are optional for Models SQ160 and SQ172. Standard equipment includes driveline shields, clutch shields and front and rear discharge shields(deflectors). NOTE: Dealer or purchaser may elect to delete front and rear discharge shields (deflectors) at their option. Refer to "WARNINGS" in Section 3-3.

Figure 1-1 Major Components



TABLE 1-1 TECHNICAL SPECIFICATIONS

Model No.	SQ142	SQ148	SQ160	SQ172	SQ84T	SQ184
Length	79"	85"	97"	109.5"	75"	125.5"
Width	46-1/2"	52-1/2"	64-1/2"	76-1/2"	87"	88-1/2"
Cutting Width	42"	48"	60"	72"	84"	84"
Weight (Est.)	402 lbs.	472 lbs.	651 lbs.	774 lbs.	720 lbs.	1024 lbs.
Cutting Capacity	1-1/2" dia	1-1/2" dia.	1-1/2" dia.	1-1/2" dia.	1" dia.	1-1/2" dia.
Cutting Height	2" - 12"	2" - 12"	2" - 12"	2" - 12"	2" - 12"	1" - 10"
Type Hitch	Cat.0&1&QH	Cat. 1&QH	Cat. 1&QH	Cat. 1&QH	Cat. 1	Cat. 2&QH
Gearbox HP	45	45	65	65	Main 60 Outboard 45	90
Blade Tip Speed	12,861 ft./min.	13,029 ft./min.	14,335 ft./min.	14,963 ft./min.	11,500 ft./min.	14,963 ft./min.
Blades	3/8 x 3"	3/8 x 3"	1/2 x 4"	1/2 x 4"	1/2 x 4"	1/2 x 4"
Shear Bolt Size	1/2 x 3" Gr. 2	1/2 x 3" Gr. 2	8 x 50mm, Gr.8.8 Slip Clutch Optional	8 x 50mm, Gr.8.8 Slip Clutch Optional	Slip Clutch	Slip Clutch
Recommended Tractor HP	10 - 25	15 - 25	25 - 40	30 - 45	25 - 50	50 Min.

SECTION II PREPARATION FOR USE

2-1 ATTACHING TO TRACTOR

⚠ WARNING

NEVER STAND BETWEEN TRACTOR AND CUTTER WHILE TRACTOR IS BEING BACKED TO HITCH.

⚠ WARNING

ADDITIONAL TRACTOR FRONT BALLAST MAY BE NEEDED FOR STABLE OPERATION AND TRANSPORT OF THE 3-POINT HITCH MOUNTED CUTTER. SEE TRACTOR OPERATOR'S MANUAL FOR RECOMMENDED WEIGHTS.



A. Insure that all bolts and hitch pins on 3-point hitch are tightened. Hitches need no further adjustment.

B. Attach cutter to tractor 3-point hitch per tractor operator's manual. Do not attach driveline at this time.

C. Raise 3-point hitch until front of cutter is approximately 1-2 inches (25-51mm) lower than rear for standard cut or until front of cutter is 1 inch (35mm) higher than rear for extra shredding. Shut down tractor. Securely block cutter in position. For further explanation of cutter adjustment, see paragraph 3-2.

NOTE

Due to the many variations in tractor / implement hitch points and corresponding differences in distances between tractor PTO shafts and implement input shafts, drivelines may need to be shortened as described in the following steps:

D. Raise and lower cutter to determine position with shortest distance between the tractor PTO shaft and gearbox input shaft. Shut down tractor leaving cutter in position of shortest distance. **Securely block cutter in position.**

E. Pull driveline apart. Attach outer (female) section to tractor PTO shaft. Pull on driveline section to be sure that yoke locks into place.

F. Hold driveline sections parallel to each other to determine if too long. Each section should end approximately 3 inches (76mm) short of reaching universal joint shield on opposite section. If too long, measure 3 inches (76mm) back from universal joint shield and mark on opposite section. (Figure 2-2). Do this for both sections.

G. Raise and lower cutter to determine position with greatest distance between PTO shaft and gearbox input shaft. Shut down tractor leaving cutter in position of greatest distance. **Securely block cutter in position.**

Figure 2-1 3-Point Hitch Points

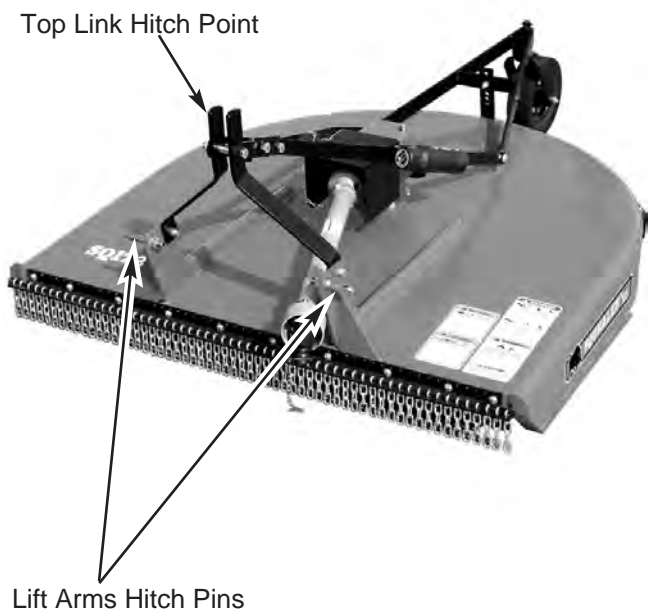
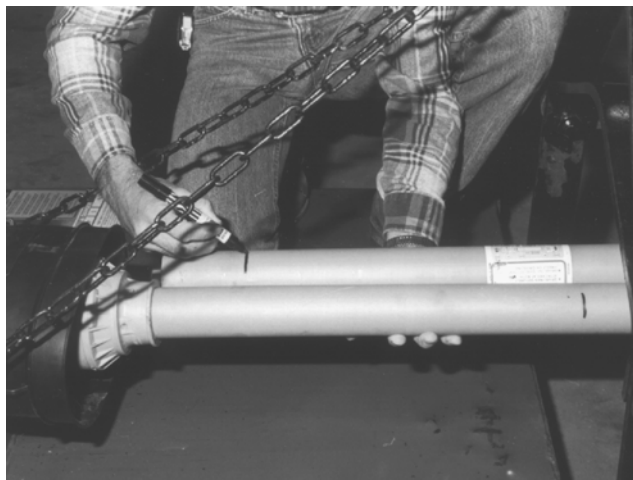
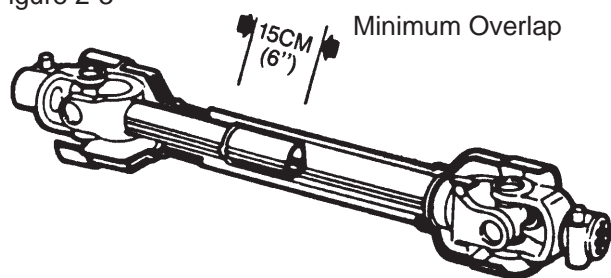


Figure 2-2



H. Hold driveline sections parallel to each other and check for minimum 6 inches (15cm) overlap. Figure 2-3). If driveline has been marked for cutting, overlap will be the distance between two marks. If driveline has less than minimum overlap, do not use. Contact authorized Bush Hog dealer.

Figure 2-3



NOTE

If driveline is the correct length, omit the following steps "I" through "L" and proceed to step "M".

I. Clamp driveline in a well padded vice to prevent damage to the shield. Cut off shield where marked. (Figure 2-4)

Figure 2-4



J. Using cut off section of shield as a guide, cut shaft the same amount. (Figure 2-5)

Figure 2-5



K. Repeat steps "I" and "J" to other driveline section.

L. Deburr ends of driveline sections and clean away all chips and filings. (Figure 2-6)

Figure 2-6



M. Apply multi-purpose grease to inside of outer (female) driveline section. Assemble driveline and install on tractor and cutter. Pull on each driveline section to be sure yokes lock into place. Make certain driveline shielding is in place and in good condition.

N. Adjust lower lift arm(s) to level cutter right to left. Refer to tractor operator's manual for instructions.

NOTE

After attaching driveline to tractor, attach driveline shield chains from both ends of driveline shielding to stationary locations.

SECTION III OPERATING INSTRUCTIONS

3-1 GENERAL SAFETY

Only qualified people should operate this machine. Operator should wear hard hat, safety glasses and safety shoes. Use ROPS (Rollover Protective Structures) and seat belt equipped tractors for mowing operations. Before beginning operation, clear work area of objects that may be picked up and thrown. Check for ditches, stumps, holes or other obstacles that could upset tractor or damage cutter. Always turn off tractor engine, set parking brake, and allow cutter blades to come to a complete stop before dismounting tractor.

3-2 ADJUSTING FOR WORK

The cutter should be operated at the highest position which will give desired cutting results. This will help prevent the blades from striking the ground, reducing blade wear and undue strain on the machine. For best results under heavier cutting conditions, always tilt the cutter approximately 2 inches (51mm) lower in the front. This tilt decreases horsepower requirements and increases potential ground speed. When fine shredding is desired, adjust cutter deck level or slightly lower in the rear. This will keep the foliage under cutter until thoroughly shredded. More power is required for shredding.

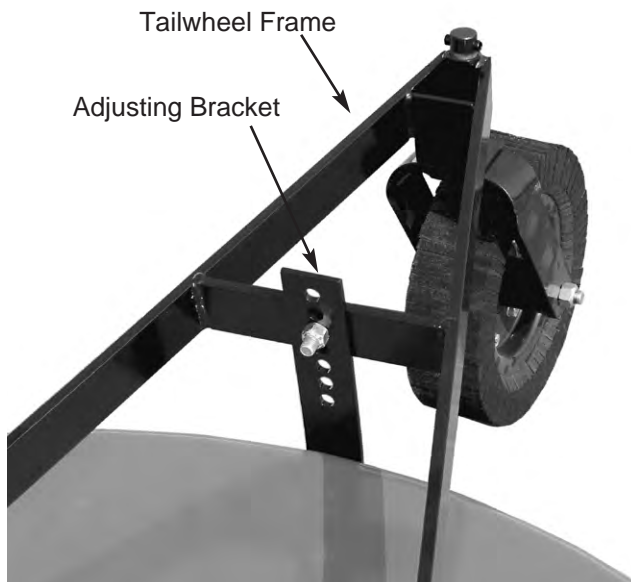
3-2.1 CUTTING HEIGHT ADJUSTMENT



WARNING

THE CUTTER CAN FALL FROM HYDRAULIC SYSTEM FAILURE. TO AVOID SERIOUS INJURY OR DEATH, SECURELY SUPPORT CUTTER BEFORE WORKING UNDERNEATH.

Figure 3-1 Tailwheel Height Adjustment

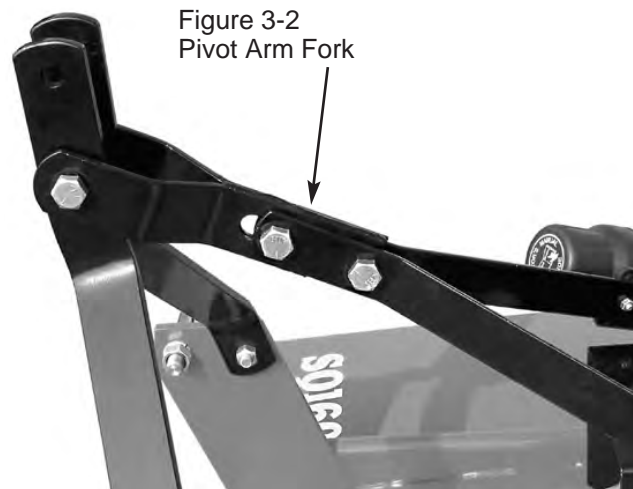


WARNING

AVOID PLACING HANDS, FEET OR ANY OTHER BODY PARTS BENEATH THE CUTTER WHILE MAKING HEIGHT ADJUSTMENTS.

Each cutter can be adjusted to several cutting heights. The SQ142, SQ148, SQ160 and SQ172 can be adjusted from 2" to 12" of cutting height. The SQ184 can be adjusted from 1" to 10" of cutting height. The SQ84T can be adjusted from 2" to 12" of cutting height. To adjust, raise cutter and block securely in position. Remove bolt from adjusting bracket shown in Figure 3-1. Adjust tailwheel frame up or down and secure in desired position.

The pivot-arm fork allows the cutter to follow ground contours for a closer cut. (Figure 3-2)



3-3 OPERATION

- Perform **BEFORE EACH USE** maintenance listed in paragraph 4-1.
- Start tractor per tractor operator's manual.
- Raise/lower 3-point hitch to place cutter in working position.
- Look to be sure no one is near cutter. **WITH TRACTOR AT IDLE SPEED, SLOWLY ENGAGE PTO DRIVE.**



DANGER

STAY CLEAR OF ROTATING DRIVELINE. DO NOT OPERATE WITHOUT DRIVELINE SHIELDS IN PLACE AND IN GOOD CONDITION. FAILURE TO HEED THESE WARNINGS MAY RESULT IN PERSONAL INJURY OR DEATH.

- Set tractor throttle for appropriate PTO speed (540 RPM).

 **DANGER**

ROTATING CUTTER BLADES, STAND CLEAR UNTIL ALL MOION HAS STOPPED. TO AVOID AN ACCIDENTAL FALL FROM TRACTOR AND POSSIBLE INJURY FROM CUTTER, USE ROPS (ROLLOVER PROTECTION STRUCTURES) AND SEAT BELT EQUIPPED TRACTORS FOR ALL MOWING OPERATIONS.

F. Place tractor in gear and proceed forward. Advance tractor throttle to 540 PTO rpm. Tractor forward speed should be controlled by gear selection, not engine speed. For maximum cutting efficiency, forward speed should allow cutter to maintain a constant, maximum blade speed. If cutter stalls or tractor engine bogs, disengage PTO. Before re-engaging

PTO, position cutter in a cut area and reduce tractor throttle to idle. If cutter continuously stalls, select lower gear and/or increase cutting height.

 **WARNING**

ALL ROTARY CUTTERS CAN DISCHARGE OBJECTS AT HIGH SPEEDS WHICH COULD RESULT IN SERIOUS INJURY TO BYSTANDERS OR PASSERS-BY.

THEREFORE, THIS CUTTER IS NOT TO BE OPERATED ALONG HIGHWAYS OR IN ANY AREA WHERE PEOPLE MAY BE PRESENT UNLESS ALL SIDES OF THE UNIT ARE ENCLOSED BY PERMANENT BANDS THAT ARE IN GOOD REPAIR.

SECTION IV MAINTENANCE

4-1 MAINTENANCE CHECK LIST

Perform scheduled maintenance as outlined below. Lower machine to ground, turn off tractor and set parking brake before doing maintenance inspections or work. All bolts should be torqued as recommended in the Torque Specifications unless otherwise indicated.

BEFORE EACH USE

1. Check tractor tire air pressure. Refer to tractor operator's manual.
2. Check blades and spindles to be sure that no foreign objects such as wire or steel strapping bands are wrapped around them.
3. Check blade bolts for tightness. Tighten to 600 ft./lbs. (814 Nm) on Models SQ160, SQ172, SQ184 and SQ84T, or 460 ft./lbs. (624 Nm) on Models SQ142 and SQ148.
4. Inspect blades for wear. Replace if necessary per paragraph 4-3. Always replace both blades on blade holder with two blades equal in weight. Use only genuine Bush Hog replacement blades.
5. Make sure belting and bands are in good repair.
6. Make certain driveline shields are in place and in good repair.
7. Inspect wheel for wear, damage, or foreign objects. Repair or replace if necessary.
8. Perform BEFORE EACH USE lubrication per paragraph 4-2.
9. During operation, listen for abnormal sounds which might indicate loose parts, damaged bearings, or other damage.

AFTER EACH USE

1. Clean all debris from machine especially under side of deck. When cleaning underside of deck, securely block machine into position.

4-2 LUBRICATION (Figure 4-1 & 4-2)

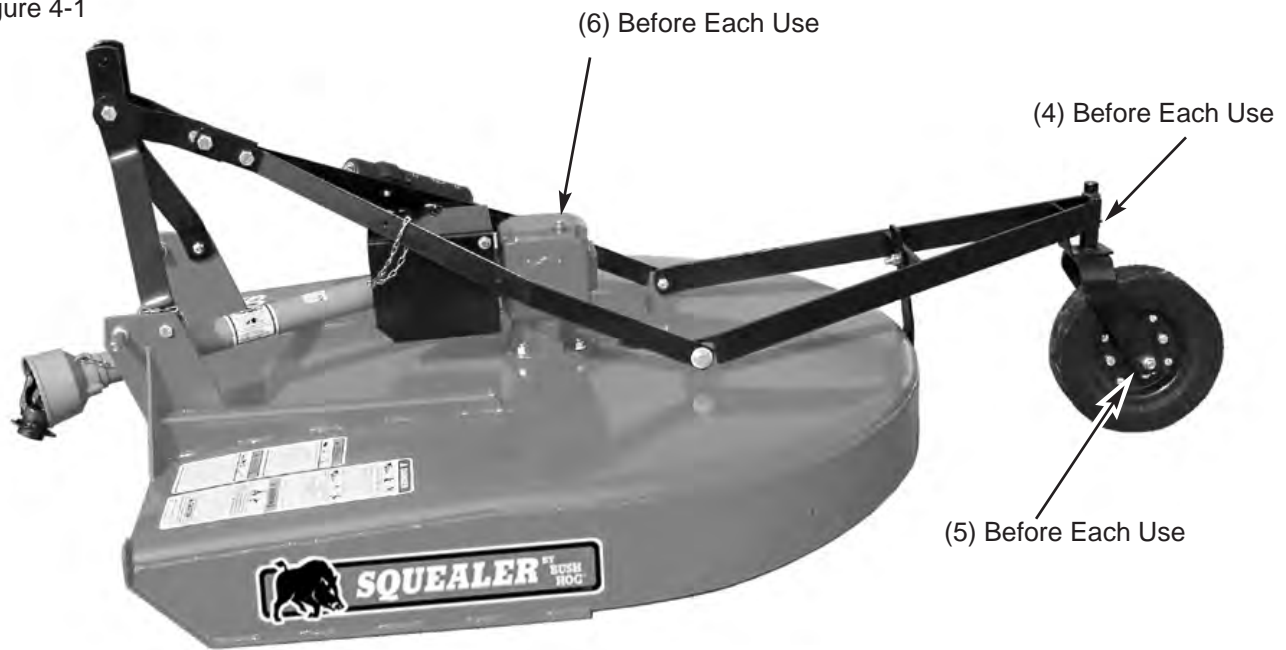
NOTE

The multi-purpose grease referenced in this section is an NLGI Grade 2 type grease.

BEFORE EACH USE

1. Driveline Universal Joints - Apply multi-purpose grease with grease gun.
2. Driveline Guard - Apply 2-3 shots of multi-purpose grease with grease gun to plastic fitting.
3. Driveline - Disconnect PTO driveline, pull two sections apart and apply thin coat of multi-purpose grease to inside of outer female section. Re-assemble sections and install. Pull each section to be sure driveline and shields are securely connected. Make certain PTO shielding is in good condition.
4. Wheel Pivot Tubes - Apply multi-purpose grease with grease gun.
5. Tailwheel - Apply multi-purpose grease with grease gun.
6. **Gearbox - Check oil level by removing oil level check plug on right side of gearbox. Add EP80W-90 gear oil if necessary to bring oil level to check plug hole. Capacity of SQ142 and SQ148 is 1.6 quarts (1.5L), SQ160 and SQ172 is 2 quarts (1.9L). Capacity of SQ184 is 1 quart (.95L). Capacity of SQ84T**

Figure 4-1



is 2.5 quarts (2.3L) for transfer and 1.5 quarts (1.4L) for outboard gearbox.

7. Yoke(Figures 4-4 & 4-5) - Apply multi-purpose grease to fitting on shear pin yokes on the SQ142 and SQ148. The SQ160 and SQ184 models use offset shear bolt yokes. **It is important that these fittings be greased regularly to prevent yokes from seizing, rendering the shear pin or bolt useless.**

4-3 BLADE REPLACEMENT

It is not necessary to remove the complete blade holder assembly to replace the blades. Blade bolts are accessible through a hole in the top of the cutter deck. Always replace both blades on a blade holder using two blades having the same weight. Use only genuine Bush Hog replacement blades. (Figure 4-3)

- A. Raise cutter and securely block in position.
- B. Remove nuts from blade bolts through the access hole in the cutter deck. (Figure 4-3) **The SQ142 and SQ148 require a 1-5/16" socket and the SQ160, SQ172, SQ184 and SQ84T require a 1-11/16" socket.**
- C. Inspect blade bolt shoulder for wear. Replace if necessary.
- D. Assemble new blades to blade holder using blade bolts, nuts and lockwashers. Tighten nuts to 460 ft./lbs. (624 Nm) on Models SQ142 and SQ148. 600 ft./lbs. (814 Nm) on Models SQ160, SQ172, SQ184 and SQ84T.

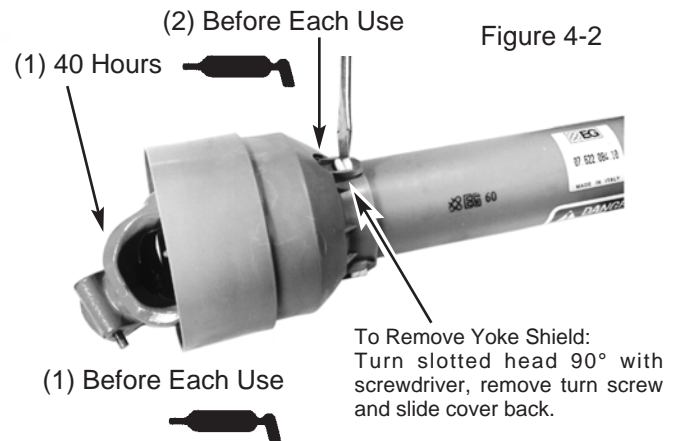
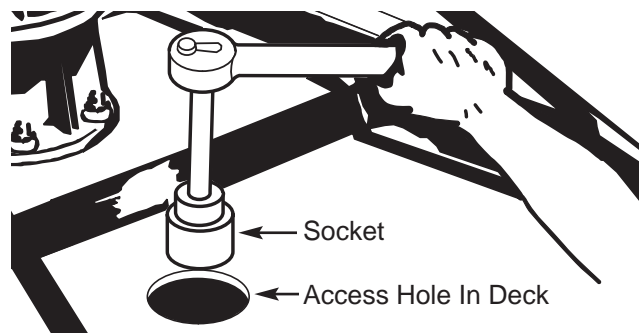


Figure 4-2

Figure 4-3 Blade Removal



- E. Check to be sure blades swing 360° freely. **If blades will not swing freely, remove, locate problem and repair. Operating cutter when blades will not swing freely will cause excessive vibration, damaging implement.**

⚠ DANGER

DO NOT GET UNDER CUTTER UNLESS IT IS SECURELY BLOCKED IN POSITION. ACCIDENTAL FALL COULD CAUSE SERIOUS INJURY OR DEATH.

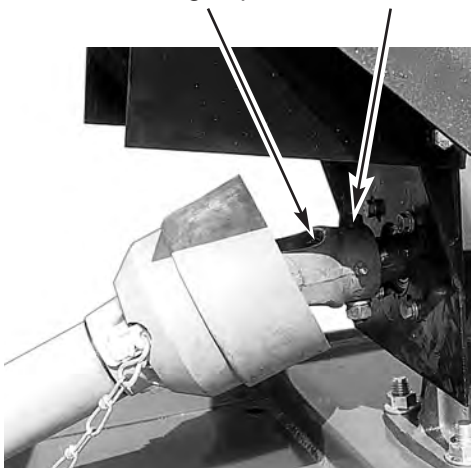
4-4 SHEAR BOLT REPLACEMENT (SQ142 & SQ148 - 1/2 x 3", Gr. 2)

- Slide yoke shield back. (Figure 4-2)
- Realign holes in yoke and shaft and remove sheared bolt with hammer and punch.
- Install new shear bolt. Lock yoke shield into place. Use only genuine Bush Hog replacement shear bolts. (Figure 4-4)

⚠ WARNING

FAILURE TO INSTALL RETAINING CLIP ON INPUT SHAFT WILL ALLOW DRIVE-LINE TO SWING FREELY IF BOLT IS SHEARED CAUSING POSSIBLE INJURY OR DEATH.

Figure 4-4 Retaining Clip Shear Bolt



4 - 5

SHEAR BOLT REPLACEMENT (SQ160, SQ172 - 8 x 50mm, Gr. 8.8)

- Slide yoke shield back. (Figure 4-2)
- Drive out sheared bolt with hammer and punch.
- Align holes and install new shear bolt. (Figure 4-5) Use only genuine Bush Hog replacement shear bolts.
- Slide yoke shield securely in place.

Figure 4-5 Shear Bolt Yoke Shield



4-6 SLIP CLUTCH OPERATIONAL CHECK

After the implement has been stored for 30 days or more, perform the following operational check:

- Loosen eight nuts retaining clutch springs 1/3 turn or until spring can be turned with fingers.
- With tractor at idle speed, engage tractor PTO drive for 2-3 seconds. Clutch should slip without turning blades. If clutch does not slip, contact your authorized Bush Hog dealer.
- Retighten nuts to original position. Initial spring lengths are shown in Figure 4-6.

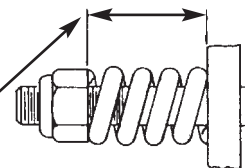
IMPORTANT

FAILURE TO RETIGHTEN NUTS TO ORIGINAL POSITION MAY CAUSE DAMAGE TO IMPLEMENT AND/OR TRACTOR DUE TO IMPROPER SLIP CLUTCH TORQUE SETTING

4-7 SLIP CLUTCH ADJUSTMENT

The slip clutch is factory preset to the correct torque for protecting implement and tractor. **Periodic adjustment is recommended; refer to section 4-6.** Should adjustments be needed, first check to be sure all spring lengths are the same. Initial spring lengths are shown in Figure 4-6. If necessary, adjust nut on any spring that is unequal. Adjust all eight spring retaining nuts 1/3 of a turn (2 flats on a nut) and check clutch slippage. If further adjustment is necessary, do so in 1/3 turn increments. **Adjust only to provide sufficient torque to prevent slippage under normal conditions. Occasional slippage is normal for driveline protection.** If satisfactory results cannot be obtained, consult your Bush Hog dealer.

Figure 4-6
Spring Lengths
Models SQ160, SQ172,
SQ184 & SQ84T.
See Chart Page 20



NOTE: REFER TO PAGE 20 FOR IDENTIFYING DIFFERENCES IN THE CLUTCHES.

IMPORTANT

DO NOT OVER-TIGHTEN NUT AND CAUSE SPRING TO BECOME SOLID AS THIS WILL CAUSE COMPONENT FAILURE.

4-8 BLADE HOLDER AND GEARBOX REMOVAL (All Except SQ84T)

- Raise cutter and securely block into position.
- Remove cotter pin and blade holder retaining nut. Wear heavy work gloves to protect hands from sharp edges.
- Grasp blade holder assembly and pull off shaft. If necessary, align blade bar with access hole in top of cutter deck and drive off with hammer and pipe. Care should be taken not to damage threads on blade bolt.
- Remove driveline from gearbox input shaft.
- Remove nuts securing gearbox to deck. Remove gearbox.

4-9 BLADE HOLDER AND GEARBOX INSTALLATION (All Except SQ84T)

A. Raise cutter and securely block into position.
 B. Attach gearbox to cutter deck using flange nuts.
 C. Install blade holder onto gearbox securing with castle nut and flat washer. **Torque nut to 450 ft./lbs. (610 Nm).** Wear heavy work gloves to protect hands from sharp edges.

D. Install cotter pin to retain nut. It may be necessary to slightly tighten nut to install cotter pin.

E. (Models SQ142, SQ148) Slide driveline yoke onto gearbox input shaft. (Figure 4-4) Install shear pin through yoke and input shaft. Install retaining clip on input shaft. Apply multi-purpose grease to fitting on yoke

WARNING

FAILURE TO INSTALL RETAINING CLIP ON INPUT SHAFT WILL ALLOW DRIVELINE TO SWING FREELY IF BOLT IS SHEARED CAUSING POSSIBLE INJURY OR DEATH.

F. (Models SQ160, SQ172) Depress quick disconnect pin and install driveline onto gearbox input shaft. Pull to be sure driveline is locked securely in place.

G. (Models with Slip Clutches) Install slip clutch shield onto gearbox using four bolts and lockwashers. Slide clutch onto gearbox input shaft and secure using previously removed tapered pin. **Torque to 30 ft./lbs.**

H. Fill gearbox with oil per paragraph 4-2.

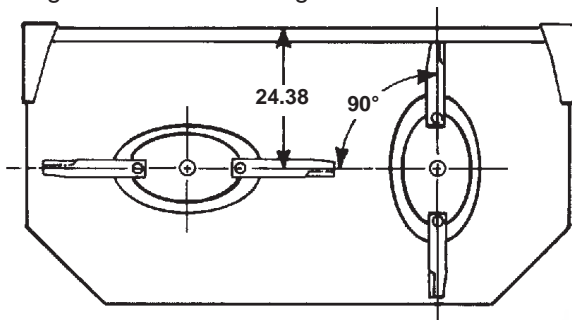
4-10 BLADE HOLDER AND GEARBOX REMOVAL (SQ84T Only)

A. Raise cutter and block securely in position.

B. Remove cotter pin and blade holder retaining nut. Wear heavy gloves to protect hands from sharp edges.

C. Grasp blade holder assembly and pull off shaft.

Figure 4-7 Blade Timing SQ84T



If necessary, align blade bar with access hole in top of cutter deck and drive off with hammer and pipe. Care should be taken not to damage threads on blade bolt.

D. Remove bolt securing cross shaft to gearbox. Slide cross shaft off gearbox shaft.

E. Remove gearbox.

4-11 BLADE HOLDER AND GEARBOX ASSEMBLY (SQ84T Only)

A. Raise cutter and block securely in position.

B. Attach gearbox to cutter deck using flange nuts.

C. Attach cross shaft to gearbox shaft. Do not secure with bolt.

D. Wearing heavy gloves, install blade holder onto lower shaft. Blades must be at 90° angle as shown in Figure 4-7. It may be necessary to disconnect cross shaft, advance gearbox one spline, then reconnect shaft to achieve 90° angle. **Tighten blade holder nut to 450 ft./lbs. (610 Nm).**

E. Install cotter pin to retain blade holder nut. It may be necessary to slightly loosen nut to install pin.

F. **Secure cross shaft to gearbox using 1/2" x 2-3/4" bolt, nut and lockwasher. Tighten bolt to 85 ft./lbs. (115 Nm).**

4-12 TROUBLESHOOTING

Troubleshooting procedures are listed in Table 4-2. If the problem cannot be solved or replacement parts are necessary, contact your authorized Bush Hog dealer.

Please have ready your machine name, model number, serial number, purchase date, and exact cause or description of problem.

Figure 4-8 SQ84T

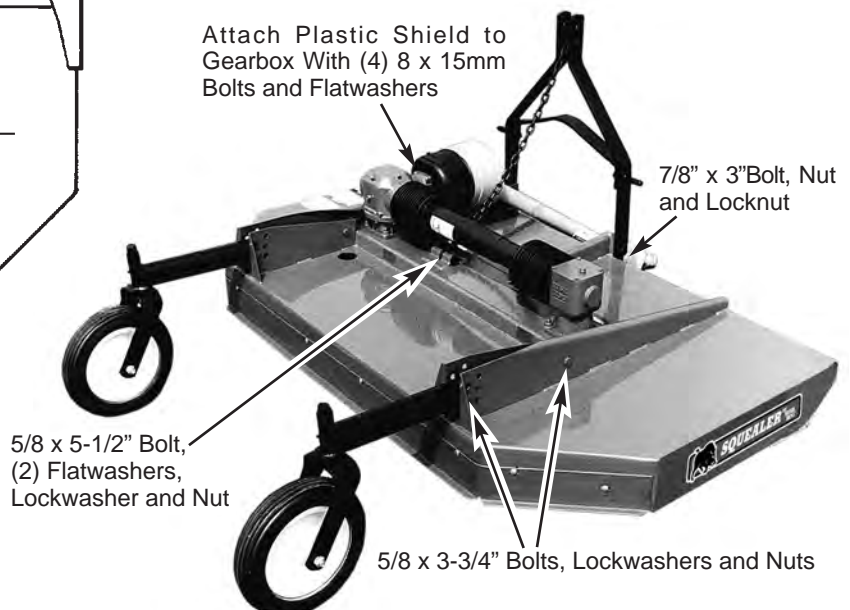


TABLE 4-2 GENERAL TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	REMEDY
Uneven Cut	Cutter not level side to side or front to rear	Refer to SECTION II.
	Worn or bent blades	Replace blades per paragraph 4-3.
Stripping or Windrowing	Possible build up of material under cutter	Clean cutter.
	Cutter not level	Refer to SECTION II.
	Worn blades	Replace per paragraph 4-3.
	Cutter not being operated at rated RPM speed	Set tractor throttle for proper PTO speed during operation.
Noisy Cutter	Loose components	Check all bolts for tightness per Torque Specifications.
	Low oil in gearbox	Check for proper oil level Refer to paragraph 4-2.
Rapid blade wear (cutting edge)	Blade contacting the ground	Adjust cutter to operate at a height that will eliminate ground contact.
Rapid blade wear (bolt hole)	Cutter not being operated at rated RPM speed	Set tractor for proper PTO speed during operation.
Cutter vibration	Cutter not being operated at rated RPM speed	Set tractor throttle for proper PTO speed during operation.
	Blades have unequal weight	Replace blades with matched set.



SECTION V DEALER ASSEMBLY

5-1 ASSEMBLY

A. Attach single-holed end of A-frame struts to holes in mounting brackets using 5/8" x 1-3/4" capscrews, 5/8" SAE flat washers, spacer bushings and locknuts. Locknuts should be tightened to firmly hold the flat washers against the bushings. This arrangement allows the struts to rotate freely on the bushings between the washers and the hitch lugs. The A-frame struts have a slight bend (about 15°) in the upper area which allows the upper portion of the struts to stand up straight when the lower section is angled slightly toward the front of the cutter. (Figure 5-1) **A-frame struts must be oriented properly so that the holes in the upper portion are vertically in line with the lower hitch pins.**

B. Hold pivot arm fork with fork around A-frame struts near the lower hole at the top of the A-frame struts (**pointed end of pivot arm fork should face toward rear of cutter with sharp point on top side**). Place upper quick hitch bushing between A-frame struts and install 3/4" x 5-1/2" capscrew through bushings, A-frame struts and quick hitch bushing, securing with 3/4" locknut. Tighten locknut until it bottoms on adjacent spacer bushing.

C. Install double-holed end of yokes to pivot arm fork by placing a wear bushing (slit along length of bushing) inside the oblong hole in the pivot arm fork and then sandwich fork with yokes placed on either side. Connect assembly with 3/4" x 2-1/2" capscrew placed through first hole in yoke and secure with 3/4" locknut. Tighten locknut until it bottoms on yoke face.

D. Place another wear bushing between the yokes in line with the second hole on the yokes and install a 3/4" x 2-1/2" capscrew through the hole. **Make sure that the bushing is located under the angled edge of the pivot arm weldment; other-**

wise, damage to cutter could occur during operation. Secure using a 3/4" locknut. Tighten locknut until it bottoms on yoke face.

E. Position tailwheel frame arms inside of attaching lugs on cutter deck (behind gearbox) as shown in Figure 5-1. Position free ends of yokes outside of attaching lugs and place a yoke bushing inside of holes on yokes and a 5/8" SAE washer on the outside of the yokes. Align holes in tailwheel frame, lugs, yokes/bushings, and washer and connect them using a 5/8" x 2-1/2" capscrew. Secure using a 5/8" locknut and tighten until nut is very snug while allowing tailwheel frame to be rotated with moderate force.

F. Fasten clutch shield and mount bracket as shown in drawing. Pivot bolts should be tight enough to prevent rattling, but still permit folding.

G. **Remove temporary fill plug from gearbox and discard. Fill gearbox with EP80-90 gear oil. Capacity for the SQ142, SQ148, SQ160 and SQ172 is .9 Quart (.86L). Capacity of the SQ184 is 1 quart (.9L). Capacity of the SQ84T is 2.5 quarts (2.3L) for the transfer and 1.5 quarts (1.4L) for the onboard gearbox. Install breather plug supplied in operator's manual package.**

H. (Models SQ142, SQ148) Slide driveline yoke onto gearbox input shaft. Install retaining clip onto input shaft. (Figure 4-4) **Install 1/2 x 3", Gr. 2 shear pin through yoke and input shaft. apply multi-purpose grease to fitting on yoke.**

I. (Models SQ160, SQ172) Depress quick disconnect pin and install driveline (**with 8 x 50mm, Gr. 8.8 shear bolt**) onto gearbox input shaft. Pull to be sure driveline is locked securely in place.

J. (Models with Slip Clutches) Remove tapered pin from splined end of slip clutch. Slide clutch onto gearbox input shaft and secure using previously removed tapered pin. **Torque to 30 ft./lbs. Perform slip clutch operational check as outlined in paragraph 4-6.**

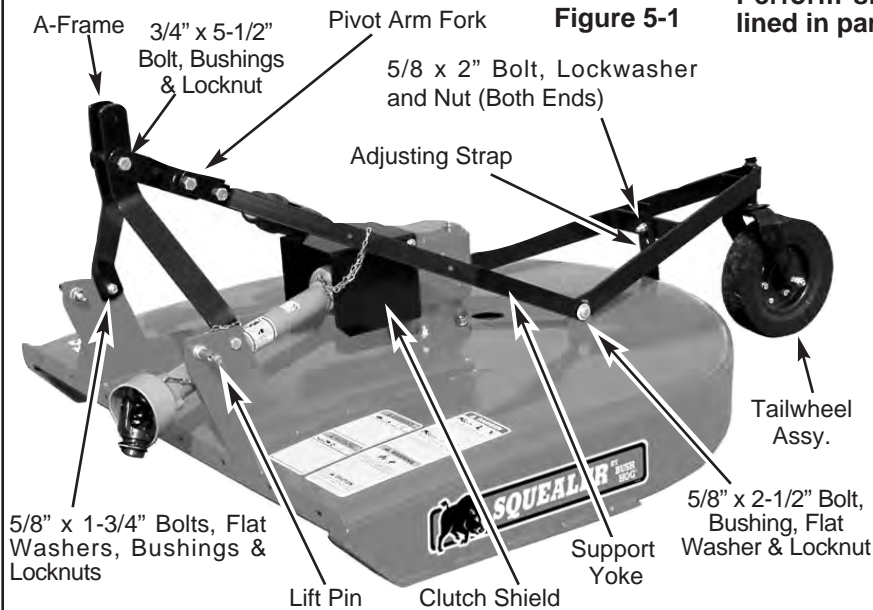


Figure 5-1

Pivot Arm Fork Assembly

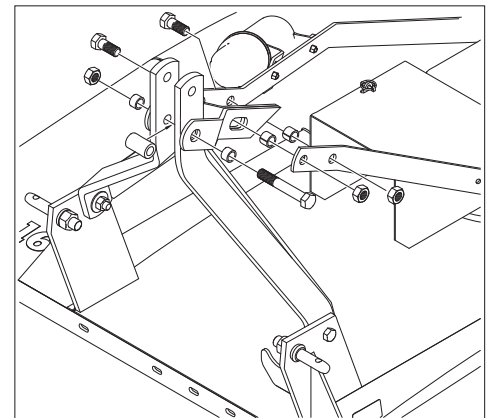
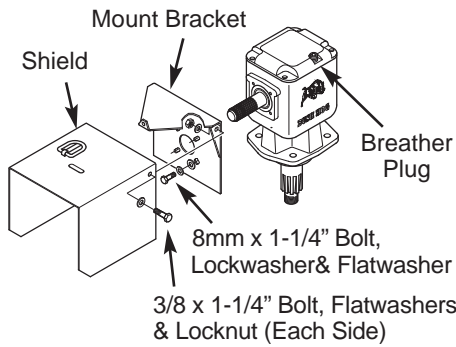


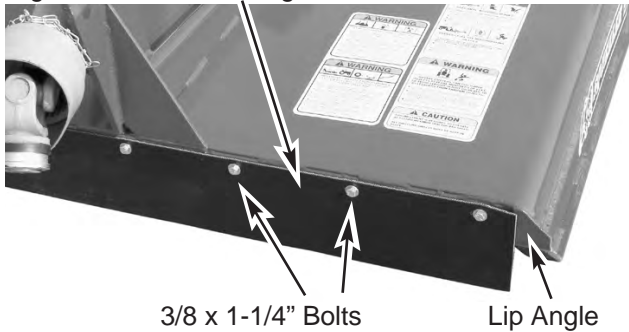
Figure 5-2



5-2 OPTIONAL FRONT SHIELDING INSTALLATION (SQ142, SQ148, SQ160, SQ172, SQ184)

A. Install front belting to deck lip angle securing with 3/8 x 1-1/4" bolts, flatwashers and locknuts. (SQ184 uses 3/8 x 3-1/2" bolts) Bolt heads should be to the outside of the deck. (Figure 5-3)

Figure 5-3 Front Belting

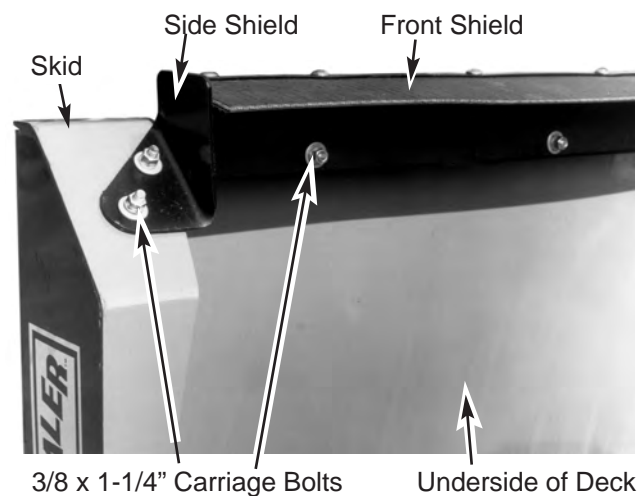


5-3 OPTIONAL FRONT SHIELDING INSTALLATION (SQ84T)

A. Install front shield to deck lip angle securing with six 3/8 x 1-1/4" carriage bolts, flatwashers, lockwashers and nuts. (Figure 5-4) Carriage bolts should be installed from top of lip angle.

B. Install right and left side shield to skid using two 3/8 x 1-1/4" carriage bolts, flatwashers, lockwashers, and nuts.

Figure 5-4 SQ84T Front Shielding



5-4 OPTIONAL REAR BAND INSTALLATION (SQ142, SQ148, SQ160, SQ172, SQ184)



WARNING

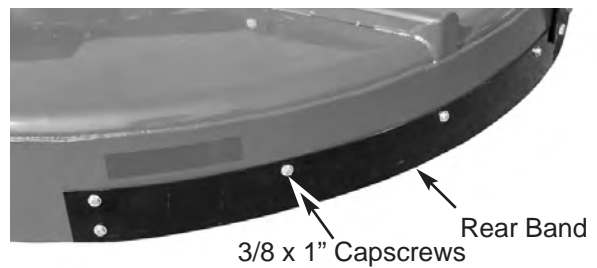
CUTTER MUST BE EQUIPPED WITH FRONT AND REAR BANDS WHEN OPERATING IN THE VICINITY OF HIGHWAYS OR IN ANY AREA WHERE PEOPLE MAY BE PRESENT.

A. Align deflector band with holes in rear band of deck.

B. SQ142 & SQ148 use the same fasteners in all locations around the rear band. Fasten with 3/8 x 1" capscrews, flatwashers, lockwashers and nuts. (Figure 5-5)

SQ160, SQ172, & SQ184 require longer bolts at the outer ends of the rear bands. Fasten the ends with 3/8 x 1-1/2" capscrews, flatwashers, lockwashers and nuts. The remaining locations around the band use 3/8 x 1" capscrews, flatwashers, lockwashers and nuts.

Figure 5-5 Rear Band



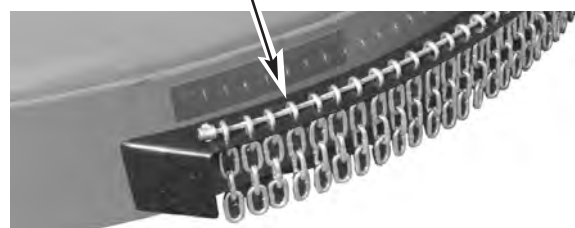
5-5 FRONT AND REAR CHAIN INSTALLATION

Install chain sections in the same manner as the front belting and rear bands. The rear safety chains use only one bolt at each end.

Figure 5-6 Front Chain Assembly



Figure 5-7 Rear Chain Assembly



5-6 SQ84T REAR BAND INSTALLATION

WARNING

CUTTER MUST BE EQUIPPED WITH FRONT AND REAR BANDS WHEN OPERATING IN THE VICINITY OF HIGHWAYS OR IN ANY AREA WHERE PEOPLE MAY BE PRESENT.

A. Fasten band to rear middle of deck using 3/8 x 1" bolts, flatwashers, lockwashers and nuts in existing holes. Lip angle must be to the bottom and extending away from the deck.

B. Bend the sides of band around the rear of the cutter. (Figure 5-5)

C. Fasten the remaining holes. (Figure 5-6)

Figure 5-7



Bend Bands Into Place

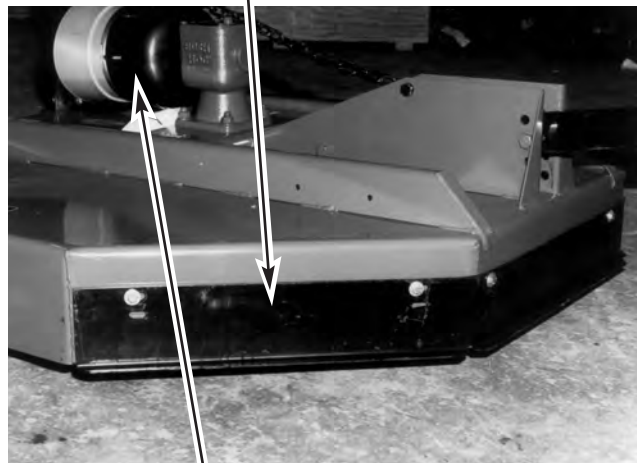
5-7 SQ84T GEARBOX INPUT SHIELD

Install slip clutch shield onto gearbox using four 8 x 15mm bolts and flatwashers which are included in the Operator's Manual package. (Figure 5-10)

Figure 5-8 Tighten All Fasteners

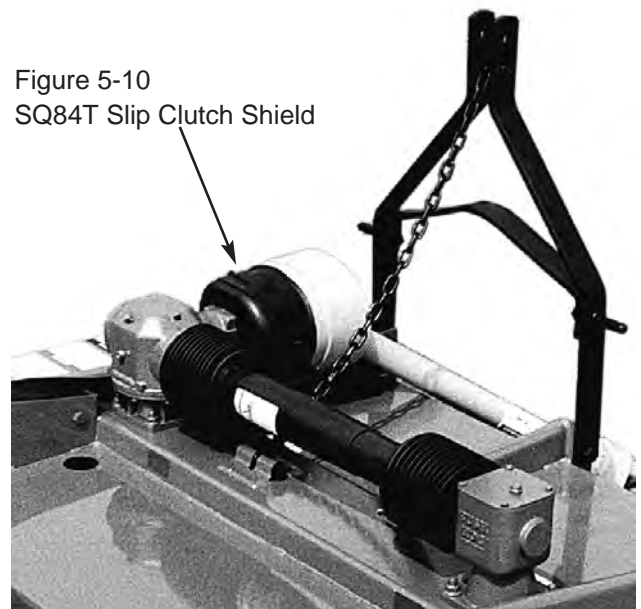


Figure 5-9 Rear Band Installed



Plastic Slip Clutch Shield

Figure 5-10
SQ84T Slip Clutch Shield



SAFETY DECALS

To promote safe operation, Bush Hog supplies safety decals on all products manufactured. Because damage can occur to safety decals either through shipment, use or reconditioning, Bush Hog will, upon request, provide safety decals for any of our products in the field at no charge. Contact your authorized Bush Hog dealer for more information.

⚠ DANGER

KEEP AWAY - ROTATING BLADES

TO AVOID SERIOUS INJURY OR DEATH FROM BLADE CONTACT:

- LOWER IMPLEMENT, STOP ENGINE AND PTO, ALLOW ALL MOVING PARTS TO STOP, AND REMOVE KEY BEFORE DISMOUNTING FROM TRACTOR.
- ALLOW NO RIDERS ON TRACTOR OR MOWER.
- KEEP ALL PERSONS CLEAR OF OPERATING MOWER AND MOWING AREA.
- KEEP CLEAR OF ROTATING BLADES, PARTS, AND DRIVELINES.

PREVENT FALL OFF INTO ROTATING BLADES

TO PREVENT ACCIDENTAL FALL OFF FROM TRACTOR AND SERIOUS INJURY OR DEATH FROM RUN OVER OR ROLLOVER BY TRACTOR OR MOWER:

- USE ROPS (ROLLOVER PROTECTIVE STRUCTURES) AND SEAT BELT EQUIPPED TRACTORS FOR MOWING OPERATIONS.
- BUCKLE UP SEAT BELT.
- KEEP ALERT FOR STUMPS, HOLES, RUTS AND UNEVEN TERRAIN.

⚠ WARNING

ROTAARY CUTTERS CAN DISCHARGE OBJECTS SEVERAL HUNDREDS OF FEET. TO AVOID SERIOUS INJURY OR DEATH TO BYSTANDERS FROM THROWN OBJECTS:

- CLEAR MOWING AREA OF VISIBLE DEBRIS AND USE EXTRA CAUTION WHERE ROCKS OR DEBRIS MAY BE PRESENT.
- DO NOT OPERATE CUTTER ALONG ROADWAYS OR IN THE VICINITY OF OTHER PERSONS WITHOUT ENCLOSED SIDES, PERMANENT BANDS, BELTING, HIGHWAY CHAINS OR OTHER FACTORY APPROVED DISCHARGE SHIELDS IN PLACE AND IN GOOD WORKING ORDER.
- KEEP ALL PERSONS WELL CLEAR OF MOWER WHEN IN OPERATION.

⚠ CAUTION

THIS IMPLEMENT IS DESIGNED TO OPERATE AT 540 RPM MAXIMUM TRACTOR PTO SPEED.

ALL DRIVE LINE SHIELDS MUST BE KEPT IN PLACE.

50029417

⚠ DANGER

ROTATING DRIVELINE CONTACT CAN CAUSE DEATH KEEP AWAY!

DO NOT OPERATE WITHOUT -

- ALL DRIVELINE GUARDS, TRACTOR AND EQUIPMENT SHIELDS IN PLACE
- DRIVELINES SECURELY ATTACHED AT BOTH ENDS
- DRIVELINE GUARDS THAT TURN FREELY ON DRIVELINE

BONDIOLI & PAVESI

78608

⚠ DANGER

GUARD MISSING DO NOT OPERATE

⚠ DANGER

GUARD MISSING DO NOT OPERATE

⚠ DANGER

78786

⚠ WARNING

TO AVOID SERIOUS INJURY OR DEATH:

- READ OPERATOR'S MANUAL BEFORE OPERATING AND FOLLOW ALL PRECAUTIONS. (CONTACT DEALER FOR MANUAL)
- KEEP SHIELDS AND GUARDS IN PLACE. KEEP CLEAR OF DRIVES AND BELTS.
- LOWER IMPLEMENT, STOP ENGINE AND PTO, ALLOW ALL MOVING PARTS TO STOP, AND REMOVE KEY BEFORE DISMOUNTING FROM TRACTOR.
- KNOW HOW TO STOP TRACTOR AND EQUIPMENT QUICKLY IN AN EMERGENCY.
- ALLOW NO CHILDREN OR UNQUALIFIED PERSONS TO OPERATE EQUIPMENT.
- BE CAREFUL ON UNEVEN TERRAIN. DECREASE SPEED WHEN TURNING.
- DO NOT OPERATE MOWER IN TRANSPORT POSITION.

⚠ WARNING

IMPLEMENT CAN FALL FROM HYDRAULIC SYSTEM FAILURE. TO AVOID SERIOUS INJURY OR DEATH:

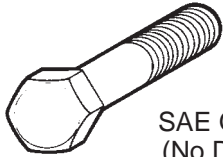
- SHUT OFF TRACTOR ENGINE, REMOVE KEY, SECURE TRACTOR PARKING BRAKE AND BLOCK UP OR SECURELY SUPPORT IMPLEMENT BEFORE WORKING UNDERNEATH.
- PURGE ALL AIR FROM HYDRAULIC SYSTEM BEFORE ATTEMPTING TO RAISE OR LOWER THIS IMPLEMENT.
- STAND CLEAR IF LOWERING OR RAISING IMPLEMENT.
- DO NOT USE HAND OR SKIN TO CHECK FOR HYDRAULIC LEAKS. USE CARDBOARD OR WOOD.
- HIGH PRESSURE OIL LEAKS CAN PENETRATE SKIN CAUSING SERIOUS INJURY AND GANGRENE. CONSULT A PHYSICIAN IMMEDIATELY.
- LOWER THE IMPLEMENT AND RELEASE HYDRAULIC PRESSURE BEFORE LOOSENING FITTINGS.
- REFER TO OWNER'S MANUAL FOR DETAILS.

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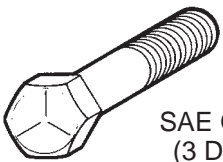
TORQUE SPECIFICATIONS

Proper torque for American fasteners used on Bush Hog equipment.
Recommended Torque in Foot Pounds (Newton Meters).*

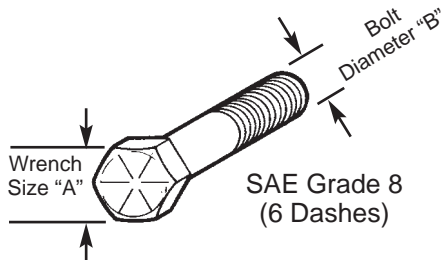
AMERICAN Bolt Head Markings



SAE Grade 2
(No Dashes)



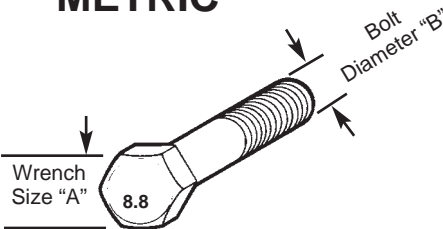
SAE Grade 5
(3 Dashes)



SAE Grade 8
(6 Dashes)

WRENCH SIZE (IN.) "A"	BOLT DIAMETER (IN.) "B" AND THREAD SIZE	SAE GRADE 2	SAE GRADE 5	SAE GRADE 8
7/16	1/4 - 20 UNC	6 (7)	8 (11)	12 (16)
7/16	1/4 - 28 UNF	6 (8)	10 (13)	14 (18)
1/2	5/16 - 18 UNC	11 (15)	17 (23)	25 (33)
1/2	5/16 - 24 UNF	13 (17)	19 (26)	27 (37)
9/16	3/8 - 16 UNC	20 (27)	31 (42)	44 (60)
9/16	3/8 - 24 UNF	23 (31)	35 (47)	49 (66)
5/8	7/16 - 14 UNC	32 (43)	49 (66)	70 (95)
5/8	7/16 - 20 UNF	36 (49)	55 (75)	78 (106)
3/4	1/2 - 13 UNC	49 (66)	76 (103)	106 (144)
3/4	1/2 - 20 UNF	55 (75)	85 (115)	120 (163)
7/8	9/16 - 12 UNC	70 (95)	109 (148)	153 (207)
7/8	9/16 - 18 UNF	79 (107)	122 (165)	172 (233)
15/16	5/8 - 11 UNC	97 (131)	150 (203)	212 (287)
15/16	5/8 - 18 UNF	110 (149)	170 (230)	240 (325)
1-1/8	3/4 - 10 UNC	144 (195)	266 (360)	376 (509)
1-1/8	3/4 - 16 UNF	192 (260)	297 (402)	420 (569)
1-5/16	7/8 - 9 UNC	166 (225)	430 (583)	606 (821)
1-5/16	7/8 - 14 UNF	184 (249)	474 (642)	668 (905)
1-1/2	1 - 8 UNC	250 (339)	644 (873)	909 (1232)
1-1/2	1 - 12 UNF	274 (371)	705 (955)	995 (1348)
1-1/2	1 - 14 UNF	280 (379)	721 (977)	1019 (1381)
1-11/16	1-1/8 - 7 UNC	354 (480)	795 (1077)	1288(1745)
1-11/16	1-1/8 - 12 UNF	397 (538)	890 (1206)	1444 (1957)
1-7/8	1-1/4 - 7 UNC	500 (678)	1120 (1518)	1817 (2462)
1-7/8	1-1/4 - 12 UNF	553 (749)	1241 (1682)	2013 (2728)
2-1/16	1-3/8 - 6 UNC	655 (887)	1470 (1992)	2382 (3228)
2-1/16	1-3/8 - 12 UNF	746 (1011)	1672 (2266)	2712 (3675)
2-1/4	1-1/2 - 6 UNC	870 (1179)	1950 (2642)	3161 (4283)
2-1/4	1-1/2 - 12 UNF	979 (1327)	2194 (2973)	3557 (4820)

METRIC



Numbers appearing on bolt heads indicate ASTM class.

Proper torque for metric fasteners used on Bush Hog equipment.
Recommended torque in foot pounds (newton Meters).*

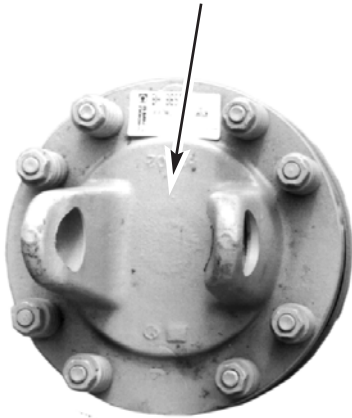
WRENCH SIZE (mm) "A"	BOLT DIA. (mm) "B"	ASTM 4.6	ASTM 8.8	ASTM 9.8	ASTM 10.9
8	5	1.8 (2.4)		5.1 (6.9)	6.5 (8.8)
10	6	3 (4)		8.7 (12)	11.1 (15)
13	8	7.3 (10)		21.1 (29)	27 (37)
16	10	14.5 (20)		42 (57)	53 (72)
18	12	25 (34)	74 (100)	73 (99)	93 (126)
21	14	40 (54)	118 (160)	116 (157)	148 (201)
24	16	62 (84)	167 (226)	181 (245)	230 (312)
30	20	122 (165)	325 (440)		449 (608)
33	22		443 (600)		611 (828)
36	24	211 (286)	563 (763)		778 (1054)
41	27		821 (1112)		1138 (1542)
46	30	418 (566)	1119 (1516)		1547 (2096)

*Use 75% of the specified torque value for plated fasteners. Use 85% of the specified torque values for lubricated fasteners.

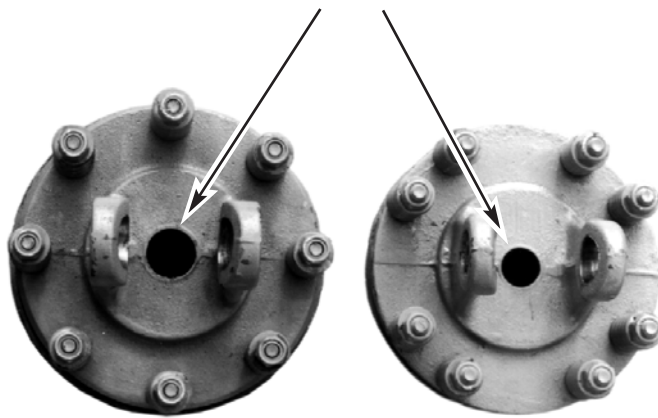
BUSH HOG SQUEALER SLIP CLUTCHES

Bush Hog Squealer Rotary Cutters are subject to having either “Bondioli & Pavesi / Binacchi” or “EG / Comer” slip clutches installed. While these clutches are similar, the spring length settings are different. Refer to the photographs below to help identify which brand of clutch you are adjusting. Notice the “Bondioli & Pavesi / Binacchi” clutches have solid castings, whereas the “EG / Comer” castings have centrally located holes through them.

BONDIOLI & PAVESI / BINACCHI
(Solid Casting)

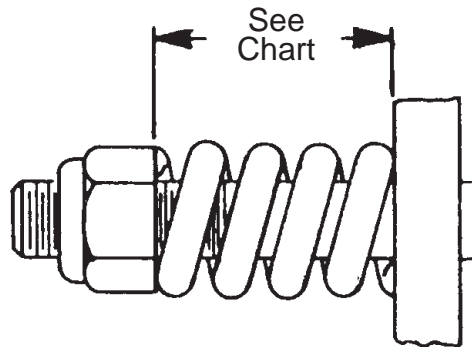


EG / COMER
(Holes Through Centers)

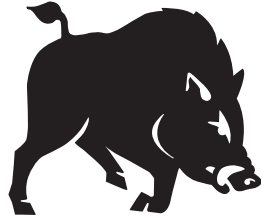


Spring Lengths

Models SQ160, SQ172, SQ184 & SQ84T



MODEL	CLUTCH SPRING LENGTH SETTING		
	BONDIOLI & PAVESI	BINACCHI	EG / COMER
SQ160	1.08" (27.4mm)	1.10" (27.9mm)	1.25" (31.8mm)
SQ172	1.08" (27.4mm)	1.10" (27.9mm)	1.25" (31.8mm)
SQ184	1.13" (28.7mm)	1.09" (27.6mm)	1.27" (32.2mm)
SQ84T	1.08" (27.4mm)	1.10" (27.9mm)	1.25" (31.8mm)



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