



OPERATOR AND PARTS MANUAL

Snowblower

Model 1080 & 1200

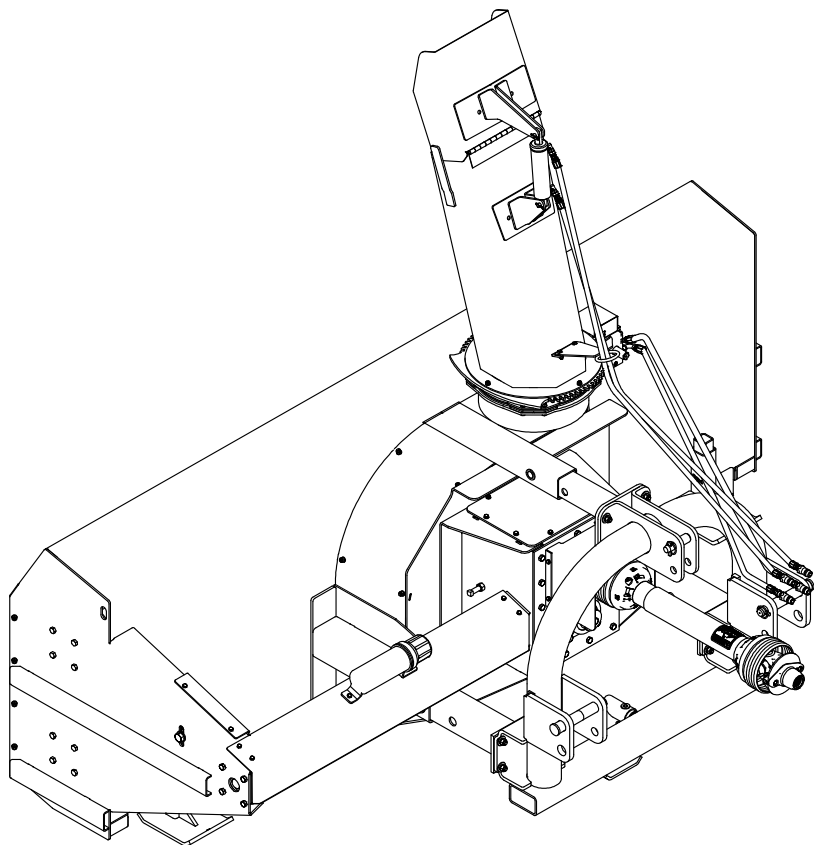


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Manufacturer's statement: for technical reasons Buhler Industries Inc. reserves the right to modify machinery design and specifications provided herein without any preliminary notice. Information provided herein is of descriptive nature. Performance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

Introduction

Allied has years of snowblower manufacturing expertise and thousands of acreages, farms and cities depend on Allied snowblowers. PTO-driven Allied Snowblowers attach to a 3-point hitch. A hitch system, which is quick-hitch compatible, is standard on all models. This model is supplied with category 2 pins, as well as conversion bushings to category 3.

A 7' or 10' commercial truck loader chute is available as an option. Adjustable cup type skid shoes are standard on all models. This model has a 4-blade fan and hydraulic spout control as standard equipment.

There is a shear bolt on the drive shaft and on the PTO shaft to protect the machine from damage if a large object is picked up. Any smaller objects in the snow will be thrown with it and could cause serious injury. Do not allow anyone to stand behind the tractor or in the area of the discharged snow.

Keep this manual handy for frequent reference. All new operators or owners must review the manual before using the equipment and at least annually thereafter. Contact your Allied Dealer if you need assistance, information, or additional copies of the manual. Visit our website at www.farm-king.com for a complete list of dealers in your area.

The directions left, right, front and rear, as mentioned throughout this manual, are as seen facing in the direction of travel of the implement.

Safety

Safety Instructions

Remember, YOU are the key to safety. Good safety practices not only protect you, but also the people around you. Make these practices a working part of your safety program. Be certain that everyone operating this equipment is familiar with the recommended operating and maintenance procedures and follows all the safety precautions. Most accidents can be prevented. Do not risk injury or death by ignoring good safety practices.

The alert symbol is used throughout this manual. It indicates attention is required and identifies hazards. Follow the recommended precautions.



The safety alert symbol means...
ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



CAUTION

The caution symbol indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.



WARNING

The Warning Symbol indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.



DANGER

The Danger Symbol indicates an imminently hazardous situation that, if not avoided will result in death or serious injury. This signal word is to be limited to the most extreme situations, typically for machine components that, for functional purposes, cannot be guarded.

General Safety Instructions

- Have a first-aid kit available for use and know how to use it.
- Have a fire extinguisher available, stored in a highly visible location, and know how to use it.
- Wear appropriate protective gear. This list may include but is not limited to:
 - hard hat
 - protective shoes with slip resistant soles
 - protective glasses or goggles
 - heavy gloves
 - wet weather gear
 - hearing protection
 - respirator or filter mask
- Read and understand the Operator's Manual and all safety signs before operating, servicing, adjusting, repairing, or unplugging the equipment.
- Do not attempt any unauthorized modifications to your Farm King product as this could affect function or safety, and could affect the life of the equipment.
- Never start or operate the snowblower except from the operator's station on the power unit.
- Inspect and clean the working area before operating.
- Keep hands, feet, clothing, and hair away from moving parts.
- Ensure bystanders are clear of the area before operating.

Start-Up Safety

- Do not let inexperienced operators or children run this equipment.
- Place all tractor and machine controls in neutral before starting.
- Operate only with ROPS and seatbelt equipped tractors.
- Do not operate inside a building unless there is adequate ventilation.
- Ensure all shields are in place and in good condition before operating.
- Stay clear of PTO shaft and machine when engaging PTO.

Operation Safety

- Do not permit riders.
- Do not wear loose fitting clothing during operation.
- Never operate equipment in the raised position.

Transport Safety

- Review Transport Safety instructions in tractor manual before moving.
- Check with local authorities regarding transport on public roads. Obey all applicable laws and regulations.
- Make sure the SMV (Slow Moving Vehicle) emblem and all the lights and reflectors that are required by the local highway and transport authorities are in place, are clean, and can be seen clearly by all overtaking and oncoming traffic.
- Never have the equipment in operation during transport.
- Always travel at a safe speed.

Service and Maintenance Safety

- Stop engine, set brake, remove ignition key, and wait for all moving parts to stop before servicing, adjusting, repairing, or unplugging.
- Support the equipment with blocks or safety stands before working beneath it.
- Follow good shop practices including:
 - keep service area clean and dry
 - be sure electrical outlets and tools are properly grounded
 - use adequate light for the job.
- Use only tools, jacks, and hoists of sufficient capacity for the job.
- Replace and secure all shields removed during servicing before operating.
- Use heavy leather gloves to handle sharp objects.
- Check hydraulics regularly for leaks. Use cardboard to look for leaks, and use hand and eye protection.
- Relieve pressure on hydraulic system before repairing or adjusting.

Storage Safety

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

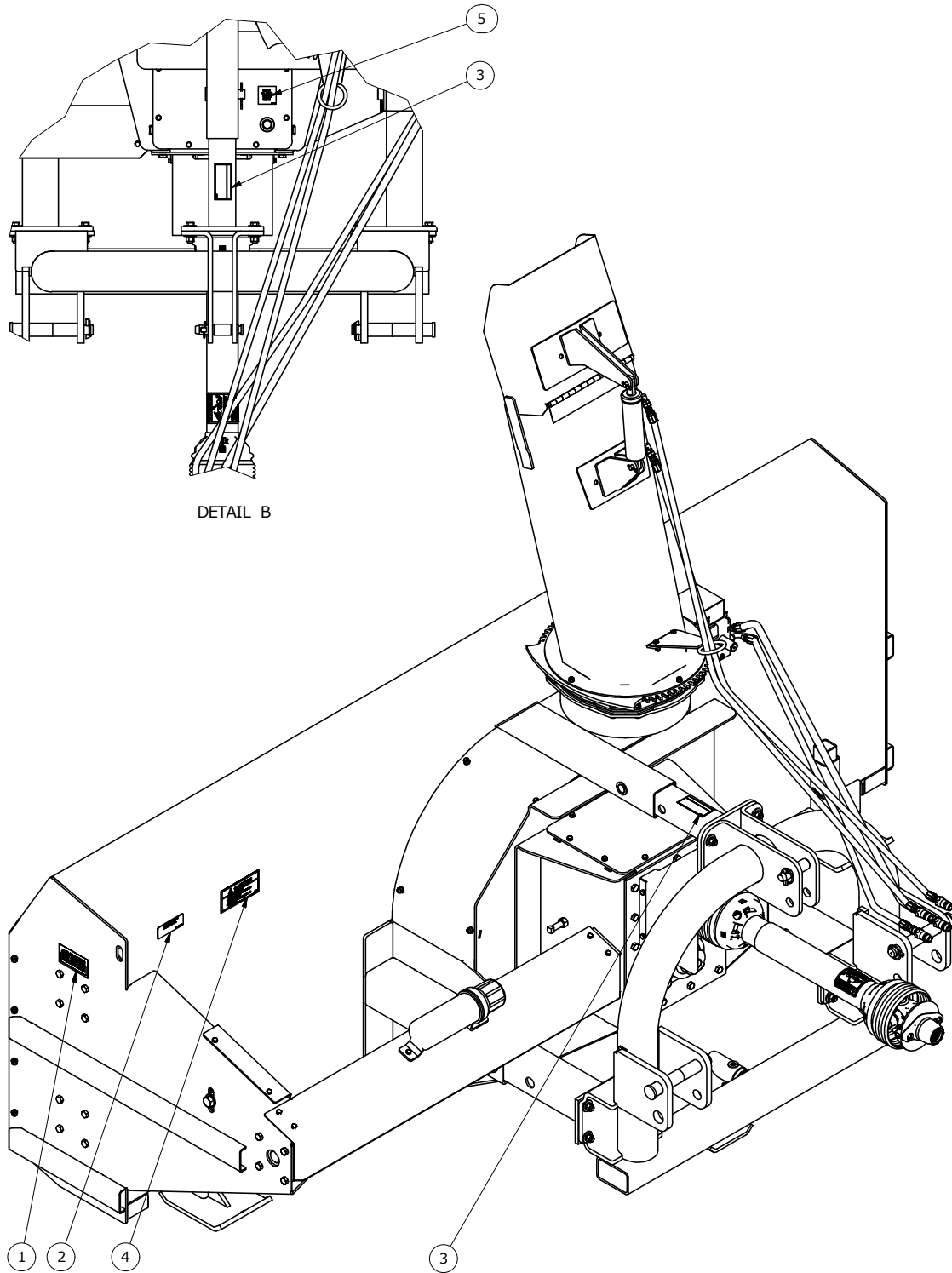
Safety Signs

- The illustration on the next page shows the approximate location and detail of safety signs.
- Keep all safety signs clean and legible and replace any that are damaged or missing.
- When original parts are replaced, any safety signs affixed to those parts should be replaced as well. Replacement safety signs are available from your local dealer.

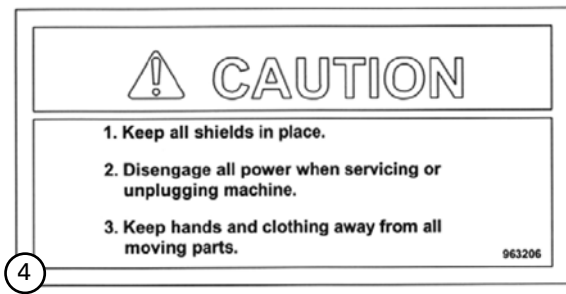
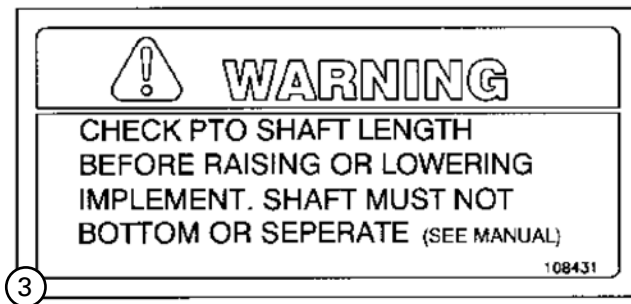
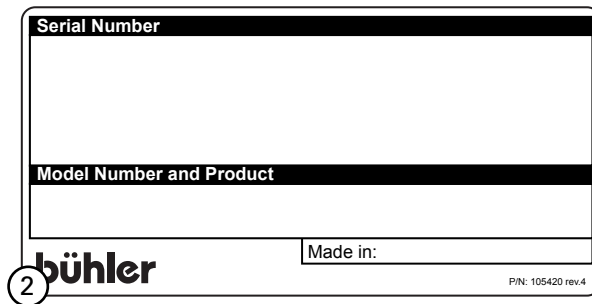
Installation

- To install safety signs, ensure the installation area is clean and dry. Decide on the exact position before you remove the backing paper. Remove the smallest portion of the split backing paper and align over the specified area. Carefully press in place.
- Slowly peel back the remaining paper and smooth the remaining portion in place. Small air pockets can be pierced with a pin and smoothed out.

Safety Decal Location



- Replace safety signs immediately should they become damaged, torn or illegible. Obtain replacements from your authorized dealer using the part numbers shown.



Part #	Description
102893	Danger Decal
105420	Reference Plate JBI/FK Serial #
108431	Warning Check PTO Shaft
963206	Caution Decal
967388	Check Oil

Assembly Instructions

**CAUTION**

The ports in the cylinder are both 9/16" ORB. Be sure that the bottom edge of the deflectors are properly fitted in the guides before using the hydraulic control.

Operation Instructions

1. Do not operate the blower in the fully raised position. The three-point hitch on some tractors raises high enough to cause the PTO shaft to bind. This can cause damage to the PTO shaft and/or to the hitch and pins.
2. Depth of the cut can be partially controlled by tilting the blower forward or backward. Adjust the top link of the tractor hitch so the snowblower is just slightly tilted back when resting on the ground.



CAUTION

Excessive backward tilt may cause the "U" joints to flutter resulting in PTO shear bolt failure.

3. The snowblower hitch should mount on three types of tractor hitches. A standard category 2 uses the pins supplied without bushings. A standard category 3 uses the pins supplied with the bushings. A category 3 quick hitch uses the pins with bushings on the inside holes (holes are exactly 19" apart measured up and down.)
4. Adjust the lower link sway chains or blocks on the tractor to restrict movement of the blower when operating.
5. The snowblowers may be purchased with either of two available spouts. Both spouts have hydraulically controlled spout deflectors. The standard spout should be suitable for all general snow blowing applications. The truck loader spout was designed to blow snow directly onto the back of a truck. The maximum height of the truck side you blow over should be approximately 10 feet.
6. Run the blower at low RPM to check operation before blowing snow.
7. The snowblower has shear bolts to protect the tractor and snowblower in case a large object enters the snowblower. The PTO shaft uses two - 3/8" x 1" (10 x 25 mm) (Grade 2) hex bolts as shear bolts for 1080 snowblower and uses two - 3/8" x 1" (10 x 25 mm) (Grade 5) hex bolts as shear bolts for 1200 snowblower. The drive shaft uses one - 5/16" x 1-1/4" (8 mm x 32 mm) (Grade 5) hex bolt as a shear bolt. Shear bolts should be fastened with a lock nut. These bolts must be kept tight to prevent wear of the bolt and bolt holes.
8. Never run PTO shaft at over 1000 RPM.
9. Chain Tension: Slack on the lower side of the chain should be 3/8" to 1/2" (10 x 25 mm)
10. Lubrication:
 - The spout clamps and rings should be periodically lubricated with gun grease. This is particularly important on the truck loader spout which turns harder than the standard spout due to the length and weight.
 - PTO shaft universal joints and splined slide should be greased daily.
 - Regularly oiling the chain will significantly increase the life of the chain.
 - The grease fitting on the hydraulic spout swivel arm and discharge spout should be kept lubricated.
 - Use any 80-90 gear oil or multigrade with 80 minimum in the gearbox up to the level plug height.

11. Periodically check all bolts for tightness. The bolt holding on the fan and the bearing bolts are of particular importance.

**DANGER**

Always stop blowing for servicing or unplugging. The PTO should be disengaged before dismounting from the tractor.

12. Shear Sprocket: The shear sprocket should be checked at the beginning of every season to make sure it will spin freely. Clean to loosen if necessary.
13. When replacing bearings or tightening a loose bearing collar, always tighten collar in the direction of shaft rotation using a center punch or a similar tool.

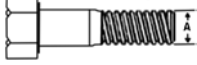



**CAUTION**

Avoid raising or lowering snowblower under load. Doing so can create excessive end pressure on the PTO shaft which could lead to bearing failure on the snowblower.

Bolt Torque

Checking Bolt Torque

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

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

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

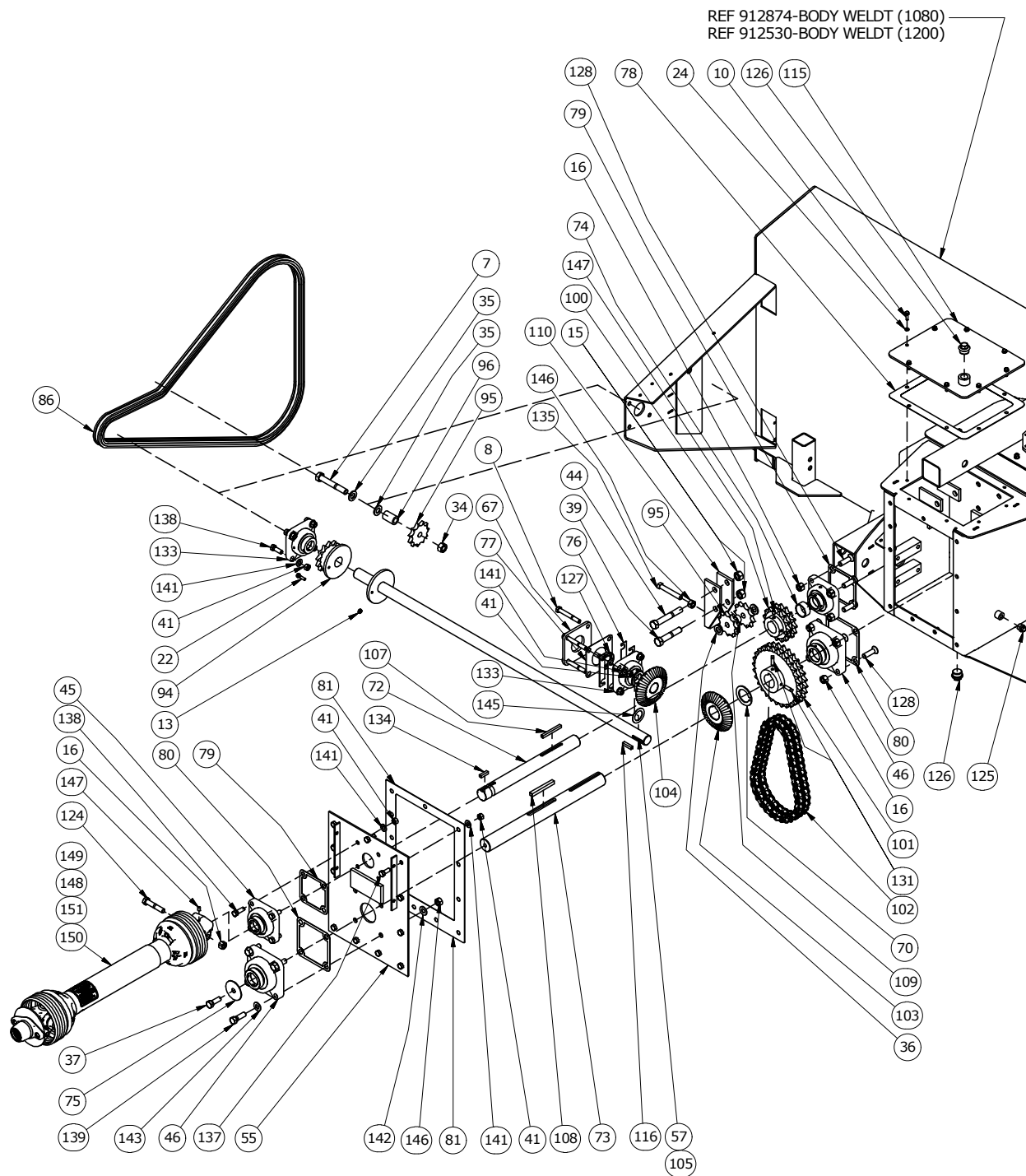
* Torque value for bolts and hex bolts are identified by their head markings.

Hydraulic Fittings					
Dash Size	Thread Size	Jam Nut or Straight ORB Fitting Torque		SAE 37° (JIC) Swivel Nut Torque	
		(lb-ft)	(NM)	(lb-ft)	(NM)
-4 (1/4)	7/16-20	16 - 14	20 - 22	11 - 10	13 - 15
-5 (5/16)	1/2-20	20 - 18	24 - 27	15 - 13	18 - 20
-6 (3/8)	9/16-18	26 - 24	33 - 35	19 - 17	23 - 26
-8 (1/2)	3/4-16	60 - 50	68 - 78	38 - 34	47 - 52
-10 (5/8)	7/8-14	80 - 72	98 - 110	56 - 50	69 - 76
-12 (3/4)	1-1/16-12	135 - 125	170 - 183	78 - 70	96 - 106
-14 (7/8)	1-3/16-12	180 - 160	215 - 245	90 - 80	110 - 122
-16 (1)	1-5/16-12	220 - 200	270 - 300	104 - 94	127 - 141
-20 (1 1/4)	1-5/8-12	280 - 210	285 - 380	138 - 124	169 - 188
-24 (1 1/2)	1-7/8-12	360 - 270	370 - 490	173 - 156	212 - 235

Prevailing Torque Lock Nuts				
Nut Size and Threads per Inch	Grade B Nuts		Grade C Nuts	
	Nut Tightening Torque		Nut Tightening Torque	
	(lb-ft)	(NM)	(lb-ft)	(NM)
Coarse Thread				
1/4 - 20	7 - 5	7 - 9	10 - 7	9 - 14
3/16 - 18	12.5 - 9	12 - 17	16 - 11	15 - 22
3/8 - 16	20 - 14.5	20 - 27	28 - 20	27 - 38
7/16 - 14	32 - 23	31 - 43	43 - 31	42 - 58
1/2 - 13	50 - 37	50 - 68	62.5 - 45	61 - 85
9/16 - 12	70 - 50	68 - 95	95 - 70	95 - 129
5/8 - 11	95 - 70	95 - 129	122.5 - 90	122 - 166
3/4 - 10	165 - 125	169 - 224	210 - 155	210 - 285
7/8 - 9	250 - 185	251 - 339	312.5 - 225	305 - 423
1 - 8	375 - 275	373 - 508	462.5 - 360	488 - 627
Fine Thread				
1/4 - 28	7.5 / 5.5	7 - 10	10 - 7	9 - 14
3/16 - 24	13 - 10	14 - 18	17 - 12	16 - 23
3/8 - 24	22 - 16	22 - 30	29 - 21	28 - 39
7/16 - 20	34 - 24	33 - 46	43 - 31	42 - 58
1/2 - 20	52.5 - 37.5	51 - 71	70 - 50	68 - 95
9/16 - 18	77.5 - 57.5	78 - 105	95 - 70	95 - 129
5/8 - 18	97.5 - 72.5	98 - 132	125 - 90	122 - 169
3/4 - 16	165 - 120	163 - 224	210 - 155	210 - 285
7/8 - 14	270 - 200	271 - 266	312.5 - 225	305 - 423
1 - 14	400 - 300	407 - 542	500 - 362.5	491 - 678

1) For Grade A locknut torque specifications refer to Grade B specifications.

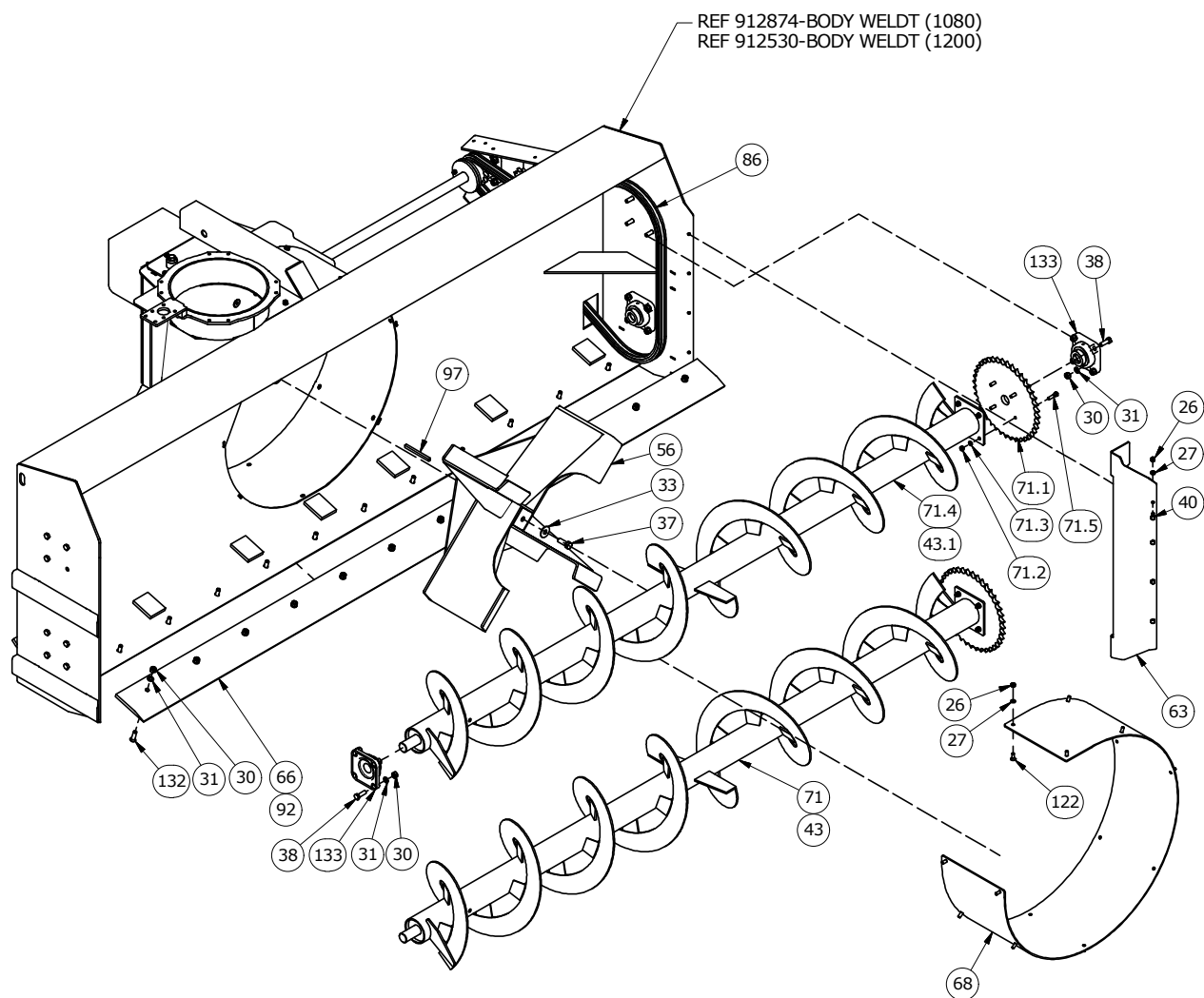
Gearbox Drawing



Item	Part #	Description
7	811751	3/4" x 5" Hex Bolt (PI)
8	811752	1/2" x 4" Hex Bolt (PI)
10	812026	5/16" x 1" Hex Bolt (PI)
13	812362	Nut Lock (Steel) 0.313 Nc Grb (PI)
15	812365	3/4" Lock Nut (PI)
16	812482	5/8" Lock Nut (PI)
22	81552	5/16" x 1-1/4" Hex Bolt (PI)
24	81569	5/16" Lock Washer (PI)
34	81700	3/4" Hex Nut (PI)
35	81702	3/4" Bs Flat Washer (PI)
36	84050	3/4" SAE Flat Washer (PI)
37	84270	5/8" x 1-3/4" Hex Bolt (PI)
39	84336	3/4" x 4" Hex Bolt (PI)
41	87554	1/2" Hex Nut (Br)
44	905630	5" Idler Bolt (Chain Drive)
45	906497	1-3/4" x 4-Bolt Hsg Ductile w/ Brg
46	906499	2" x 4-Bolt Hsg Ductile w/ Brg
55	912560	Gbox Frt Cover Weldt
57	912566	Dr Shft Weldt 1200
67	912597	Oil Seal Plate
70	912605	Slotted Washer 2" Id
72	912617	Jack Shaft - 1000 RPM Dia 1-3/4"
73	912618	Fan Shaft - 1000 RPM Dia 2"
74	912619	Gear Spacer
75	912625L	Shaft Cover
76	912626L	Bearing Spacer
77	912633	Flange Gasket
78	912634	Gearbox Cover Gasket
79	912636	Bearing Gasket
80	912637	Bearing Gasket
81	912638	Gearbox Front Cover Gasket
86	913045	Roller Chain 80-1R x 114P
94	965221	1-1/2" #80 13Tooth Sprocket
95	965224	11T x 3/4" Bore Idler Sprkt
96	965225	49/64" Id x 1-1/4" Od x 1-15/16" Idler Spacer
100	965269	1-3/4" 15Tooth Double Sprocket
101	965270	2" Ø 28Tooth Double Sprocket
102	965271	Dbl Chain #80 x 40 Link w/ Conn
103	965274	Gear 2" Bore (1289-1)
104	965275	Gear 1-1/2" Bore (1290-1)
105	965280	Dr Shft Weldt 1080

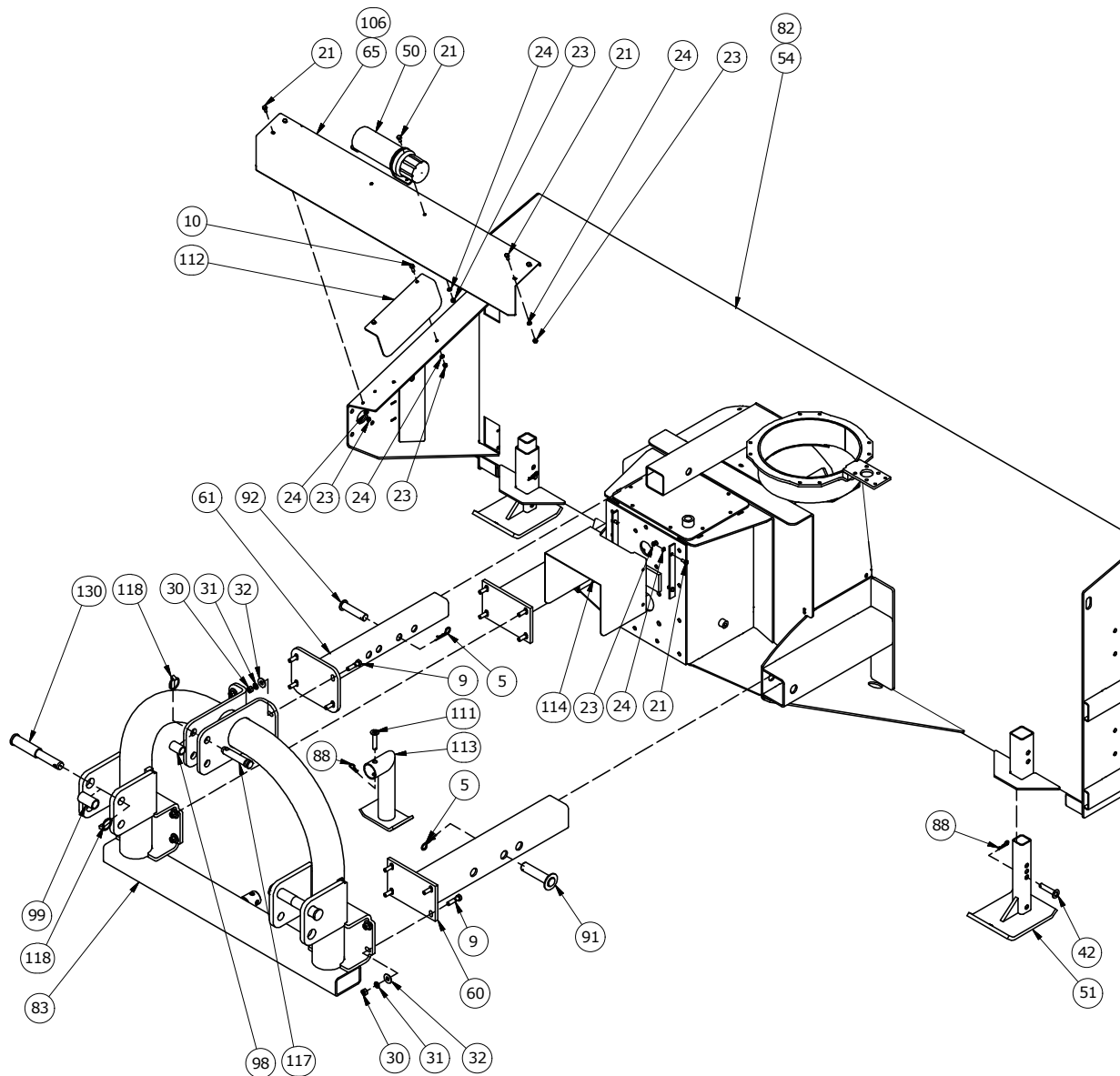
Item	Part #	Description
107	965284	Key 3/8" x 3/8" x 3-3/4"
108	965285	1/2" x 1/2" x 4-1/2" Key
109	965288	Idler Sprocket Spacer 27/32" Id x 1-3/64" Od x 9/16"
110	965290	Idler Arm Weldt
115	965660	Gbox Cover Weldt
116	965821	3/8" x 3/8" x 1-3/4" Key
124	967433	5/8" x 3-1/4" Hex Bolt Gr5 (PI)
125	967451	1/2" Sq Hd Pipe Plug
126	967452	1" Sq Hd Pipe Plug
127	967453	Oil Seal
128	967457	Flat Head Socket Cap Screw 0.625" x 2.25"
131	967464	3/8" x 1-1/4" Sq Hd Set Screw (Br)
133	968632	1-1/2" x 4-Bolt Hsg Ductile w/ Brg
134	968807	Key 3/8" x 3/8" x 1-1/2"
135	968898	5/8" x 4" Sq Hd Set Screw (Br)
137	9812361	1/2" x 1-1/4" Hex Bolt (Br)
138	9812369	1/2" x 1-1/2" Hex Bolt (Br)
139	9812373	5/8" x 2" Hex Bolt (Br)
141	9812412	1/2" Lock Wash (Br)
142	9812414	5/8" Lock Wash (Br)
143	9812421	5/8" Flat Wash (Br)
145	9812444	1-1/2" x 14 Ga Narrow Rim Wash (Br)
146	984241	5/8" Nc Hex Nut (Br)
147	985639	Ø 3/8" x 1/2" Socket Set Screw (Br)
148	F9231	Standard Shaft (21 Spline, 1-3/8") - 1000 RPM - Gr 2 Shear Bolt 1080
149	F9232	Option Shaft (20 Spline, 1-3/4") - 1000 RPM - Gr 2 Shear Bolt 1080
150	F9235	Standard Shaft (21 Spline, 1-3/8") - 1000 RPM - Gr 5 Shear Bolt 1200
151	F9236	Option Shaft (20 Spline, 1-3/4") - 1000 RPM - Gr 5 Shear Bolt 1200

Flighting Drawing



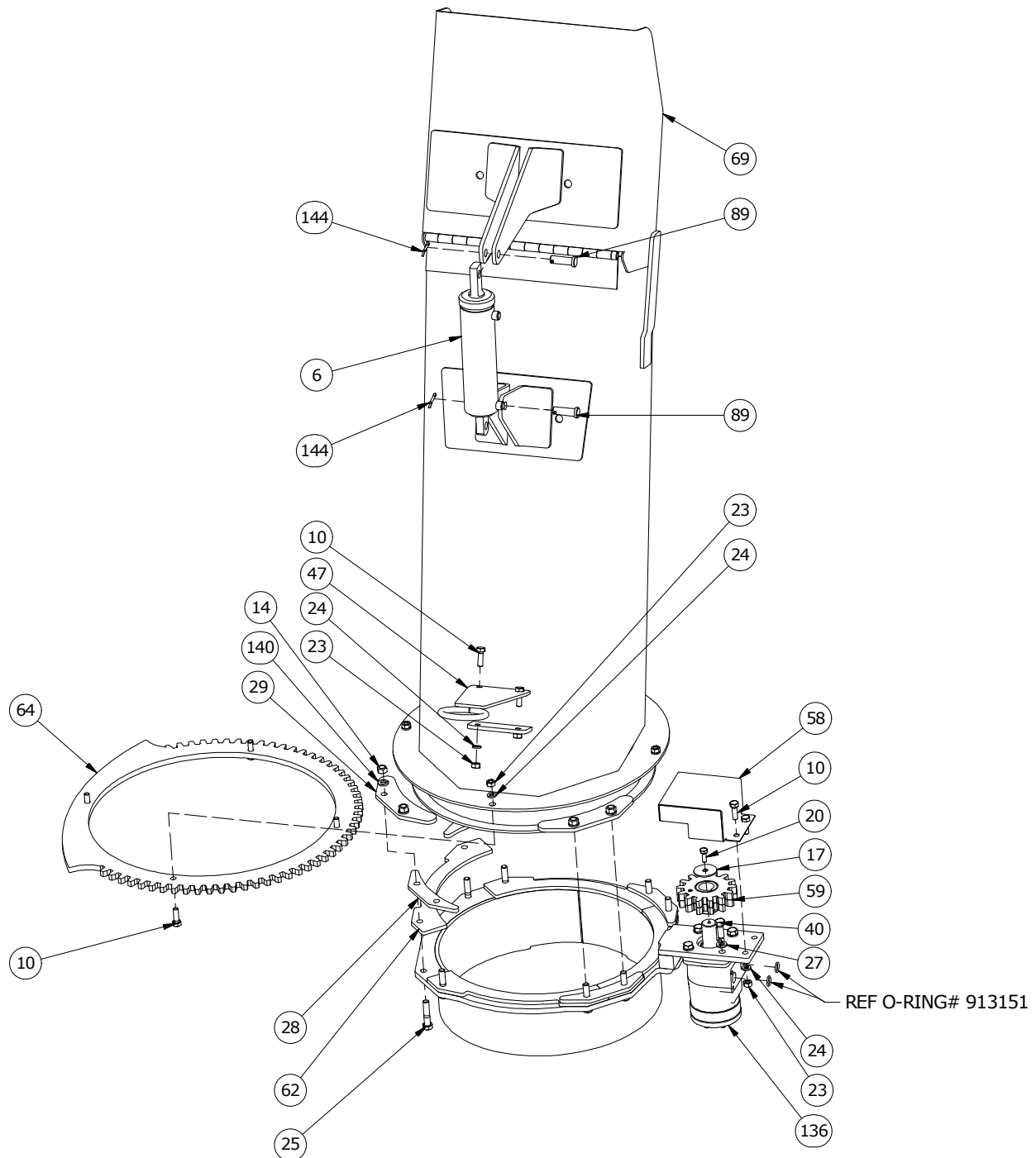
Item	Part #	Description
26	81592	3/8" Hex Nut (PI)
27	81593	3/8" Lock Washer (PI)
30	81636	1/2" Hex Nut (PI)
31	81637	1/2" Lock Washer (PI)
33	81678	5/8" Flat Washer Std (PI)
37	84270	5/8" x 1-3/4" Hex Bolt (PI)
38	84277	Bolt Hex 0.500 Nc x 1.50 Gr5 (PI)
40	86170	3/8" x 1" Hex Bolt (PI)
43	902058	Aug Assy 1080
43.1	965216	Aug Weldt 1080
56	912563	Snow Fan Weldt
63	912592	Chain Guard
66	912596	Cutting Edge 1200
68	912599	Fan Housing Liner
71	912606	Aug Assy 1200
71.1	965222	37/64" W x 13-5/16" Od x 1-1/2" Bore 40T Sprkt #80
71.2	81592	3/8" Hex Nut (PI)
71.3	81593	3/8" Lock Washer (PI)
71.4	912607	Aug Weldt 1200
71.5	9812357	3/8" x 1-1/2" Hex Bolt (Br)
86	913045	Roller Chain 80-1R x 114P
92	965209	Cutting Edge 1080
97	965226	3/8" x 3/8" x 5" Key
122	967431	Flat Head Socket Cap Screw 0.375" x 1.00"
132	967475	Flat Head Socket Cap Screw 0.50" x 1.75"
133	968632	1-1/2" x 4-Bolt Hsg Ductile w/ Brg

Hitch Drawing



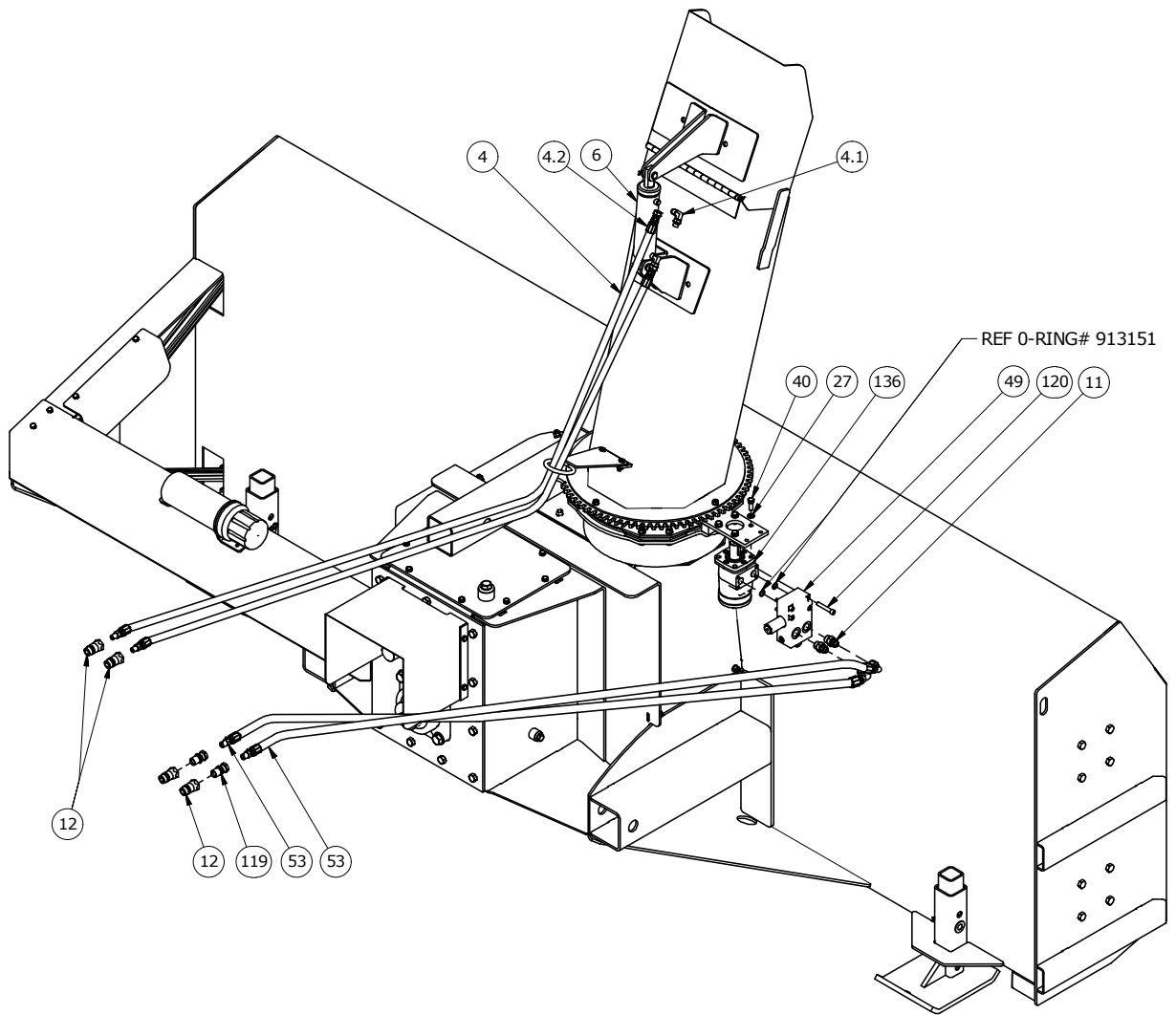
Item	Part #	Description
5	12779	Hairpin Clip #9
9	811791	1/2" x 2" Hex Bolt (PI)
10	812026	5/16" x 1" Hex Bolt (PI)
21	81549	5/16" x 3/4" Hex Bolt (PI)
23	81568	5/16" Hex Nut (PI)
24	81569	5/16" Lock Washer (PI)
30	81636	1/2" Hex Nut (PI)
31	81637	1/2" Lock Washer (PI)
32	81638	1/2" Bs Flat Washer (PI)
42	900712	Pin Weldment
50	909277	Manual Holder 3-1/2" x 12"
51	910191	Skid Weldt
54	912530	Body Weldt 1200
60	912586	Lower Hitch Tube Weldt
61	912588	Top Hitch Tube Weldt
65	912594	Drive Shaft Guard 1200
82	912874	Body Weldt 1080
83	912880	Hitch Weldt
88	961012	#16 Hair Pin Clip
91	965205	Lwr Htch Pin Weldt
92	965206	Upr Htch Pin Weldt
98	965266	Cat 2-3 Link Pin Bushing
99	965267	Lift Pin Bushing
106	965281	Drive Shaft Guard 1080
111	965294	Stand Pin Weldt
112	965295	14 Ga x 7-1/2" x 12" Ider Shld
113	965308	Stand Weldt
114	965655	14 Ga x 9" x 29" PTO Guard
117	965910	Cat 2 Top Link Pin
118	965911	7/16" Linch Pin
130	967461	Cat 2-3 Lift Pin

4' Spout Drawing



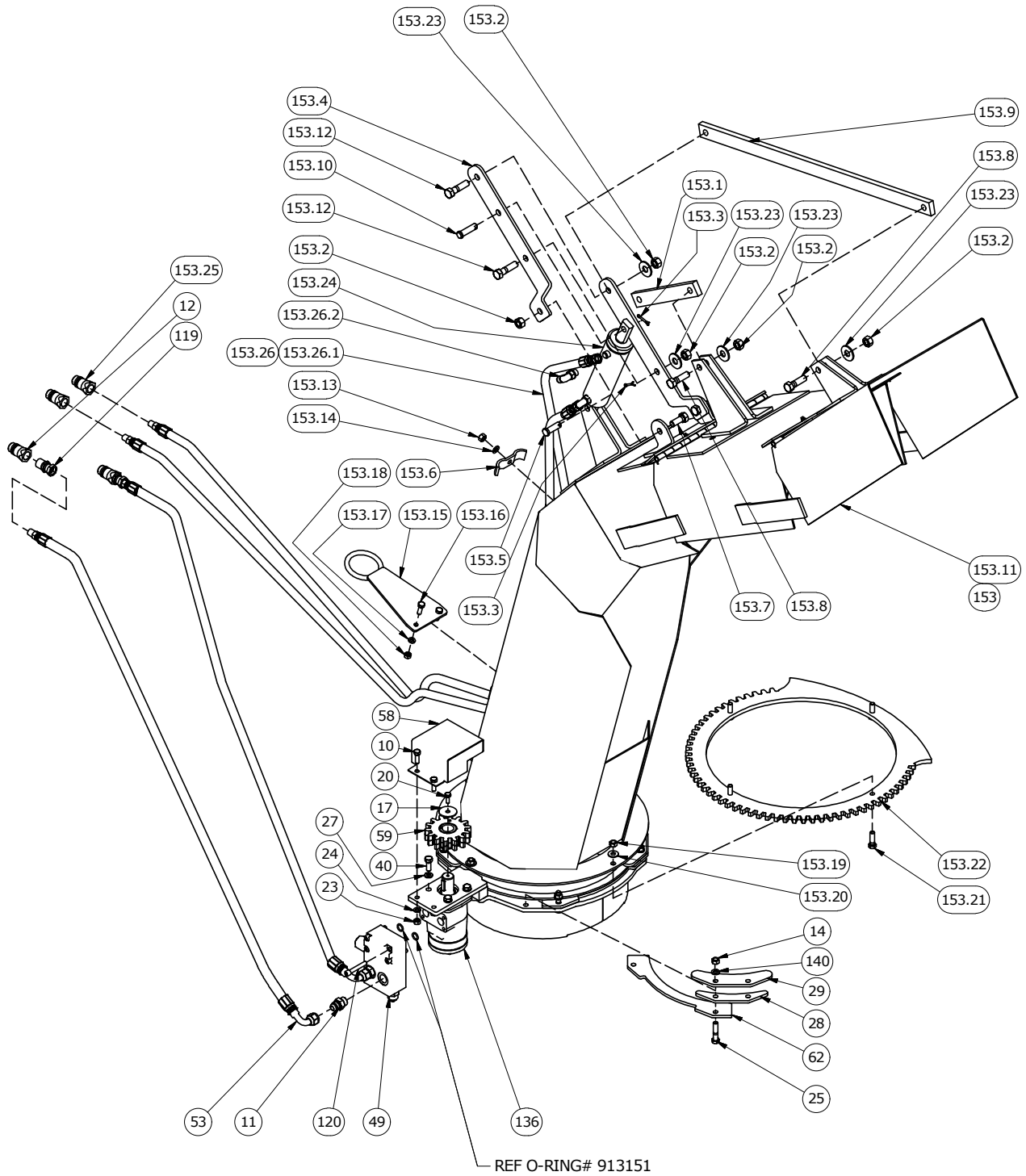
Item	Part #	Description
6	24995M	Ø 1.75" x 5.0" Stroke Cylinder Assembly - Cream
10	812026	5/16" x 1" Hex Bolt (PI)
14	812363	Nut Lock (Steel) 0.375 Grb (PI)
17	813748	Washer, Fender, 1-1/2" Od x 5/16" Id (PI)
20	81525	1/4" x 3/4" Hex Bolt (PI)
23	81568	5/16" Hex Nut (PI)
24	81569	5/16" Lock Washer PI
25	81578	3/8" x 1-3/4" Hex Bolt (PI)
27	81593	3/8" Lock Washer (PI)
28	815932L	Spout Spacer
29	815933L	Spout Clamp
40	86170	3/8" x 1" Hex Bolt (PI)
47	907590	Spt Hose Hldr Weldt
58	912571	Gear Guard Weldt
59	912574	Gear Hub Weldt
62	912591	Neck Protection
64	912593L	Spout Gear 54 Teeth
69	912604	Spout Weldt
89	961876	1/2" x 1-1/2" Clev Pin (PI)
136	971518	Hydraulic Motor
140	9812410	3/8" Lock Washer (Br)
144	9812430	1/8" x 1" Cotter Pin (PI)

Hydraulics Drawing



Item	Part #	Description
4	115371	Hose 3/8" x 156" c/w Fittings
4.1	811918	Elbow 90 9/16 Swmorb x 9/16 Mjic
4.2	115369	3/8" x 156" Hose 1/2" Mnpt x 9/16" Swfjic
6	24995M	Ø 1.75" x 5.0" Stroke Cylinder Assembly - Cream
11	812080	Adaptor Str 3/4 Morb x 3/4Mjic
12	812208	Nipple 1/2" Body 1/2" - 14 Nptf Quick Connect
27	81593	3/8" Lock Washer (PI)
40	86170	3/8" x 1" Hex Bolt (PI)
49	909169	Manifold
53	912250	Hose 1/2" x 138-1/2" Mnpt x 3/4" Swfjic 90
119	966307	Adaptor 1/2" Mnpt x 1/2" Fnpt - .0520R Flow Restrictor
120	967249	5/16" x 2" Sckt Head Bolt (Br)
136	971518	Hydraulic Motor

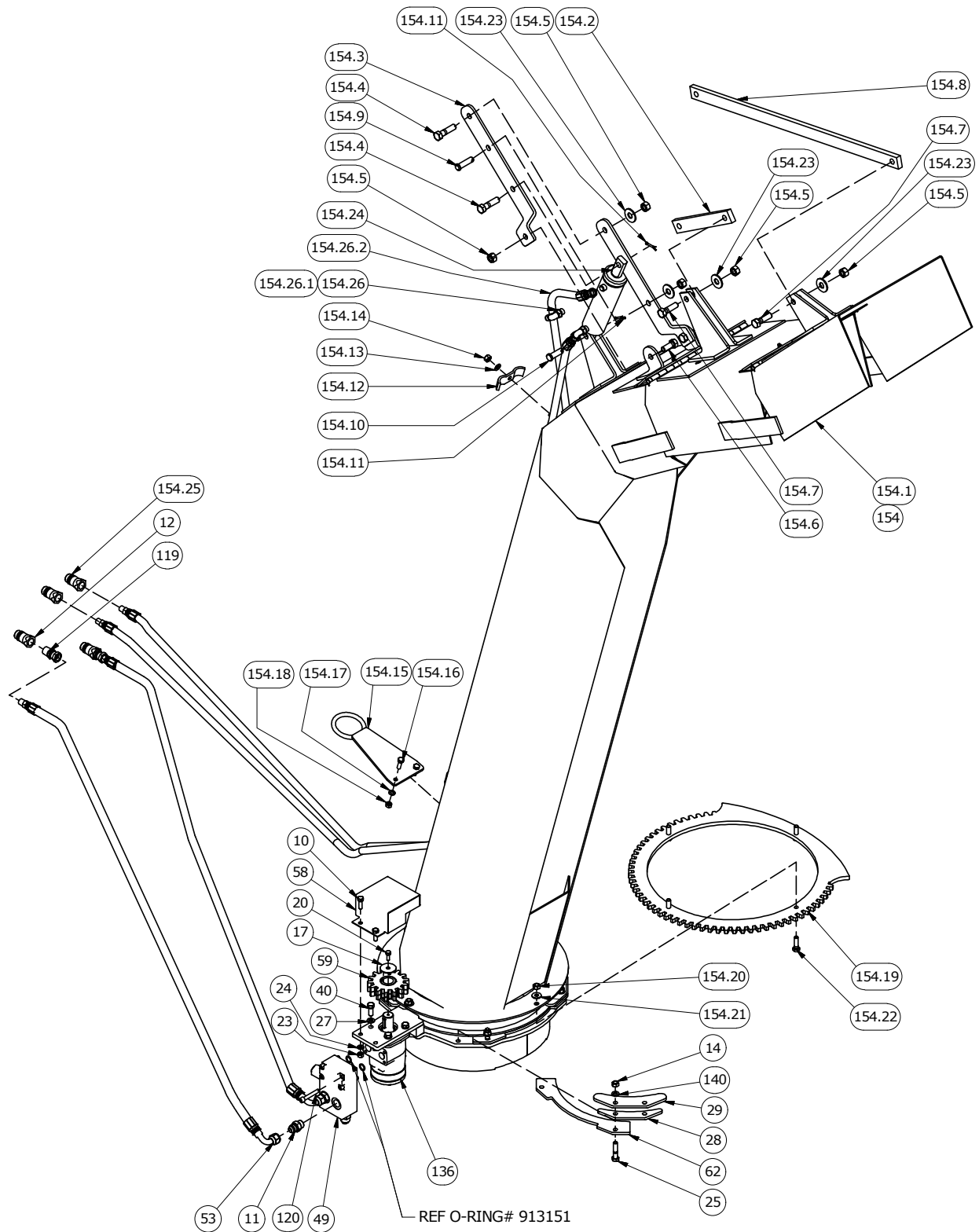
7' Spout Drawing



Item	Part #	Description
10	812026	5/16" x 1" Hex Bolt (PI)
11	812080	Adaptor Str 3/4 Morb x 3/4 Mjic
12	812208	Nipple 1/2" Body 1/2" - 14 Nptf Quick Connect
14	812363	Nut Lock (Steel) 0.375 Grb (PI)
17	813748	Washer, Fender, 1-1/2" Od x 5/16" Id (PI)
20	81525	1/4" x 3/4" Hex Bolt (PI)
23	81568	5/16" Hex Nut (PI)
24	81569	5/16" Lock Washer PI
25	81578	3/8" x 1-3/4" Hex Bolt (PI)
27	81593	3/8" Lock Washer (PI)
28	815932L	Spout Spacer
29	815933L	Spout Clamp
40	86170	3/8" x 1" Hex Bolt (PI)
49	909169	Manifold
53	912250	Hose 1/2" x 138-1/2" Mnpt x 3/4" Swfjic 90
58	912571	Gear Guard Weldt
59	912574	Gear Hub Weldt
62	912591	Neck Protection
119	966307	Adaptor 1/2" Mnpt x 1/2" Fnpt - .0520R Flow Restrictor
120	967249	5/16" x 2" Sckt Head Bolt (Br)
136	971518	Hydraulic Motor
140	9812410	3/8" Lock Washer (Br)
153	Y911	7' Spout Assy c/w Cyl & Hoses Gear Dr
153.1	965305	Spout Link 1/2" x 1-1/4" x 8-3/4"
153.2	812364	1/2" Lock Nut (PI)
153.3	9812430	1/8" x 1" Cotter Pin (PI)
153.4	965238	Cylinder Arm 1/4" x 2" x 15-1/8"
153.5	961876	1/2" x 1-1/2" Clev Pin (PI)
153.6	965239	3/16" x 1" x 4-1/2" Hose Clp
153.7	81620	1/2" x 1-1/4" Hex Bolt (PI)
153.8	87553	1/2" x 1-3/4" Hex Bolt (PI)
153.9	965304	Spout Link 1/2" x 1-1/4" x 28-1/8"
153.10	960913	1/2" x 1-13/16" Clev Pin (PI)
153.11	913055	7' Spt Weldt
153.12	811791	1/2" x 2" Hex Bolt (PI)
153.13	81592	3/8" Hex Nut (PI)
153.14	81593	3/8" Lock Washer (PI)
153.15	907590	Spt Hose Hldr Weldt
153.16	812026	5/16" x 1" Hex Bolt (PI)
153.17	81569	5/16" Lock Washer PI
153.18	81568	5/16" Hex Nut (PI)

Item	Part #	Description
153.19	812363	Nut Lock (Steel) 0.375 Grb (PI)
153.20	81570	3/8" Std Flat Wash (PI)
153.21	86171	3/8" x 1-1/4" Hex Bolt (PI)
153.22	912593L	Spout Gear 54 Teeth
153.23	81638	1/2" Bs Flat Washer (PI)
153.24	24995M	Ø 1.75" x 5.0" Stroke Cylinder Assembly - Cream
153.25	812208	Nipple 1/2" Body 1/2" - 14 Nptf Quick Connect
153.26	115371	Hose 3/8" x 156" c/w Fitting
153.26.1	115369	3/8" x 156" Hose 1/2" Mnpt x 9/16" Swfjic
153.26.2	811918	Elbow 90 9/16 Swmorb x 9/16 Mjic

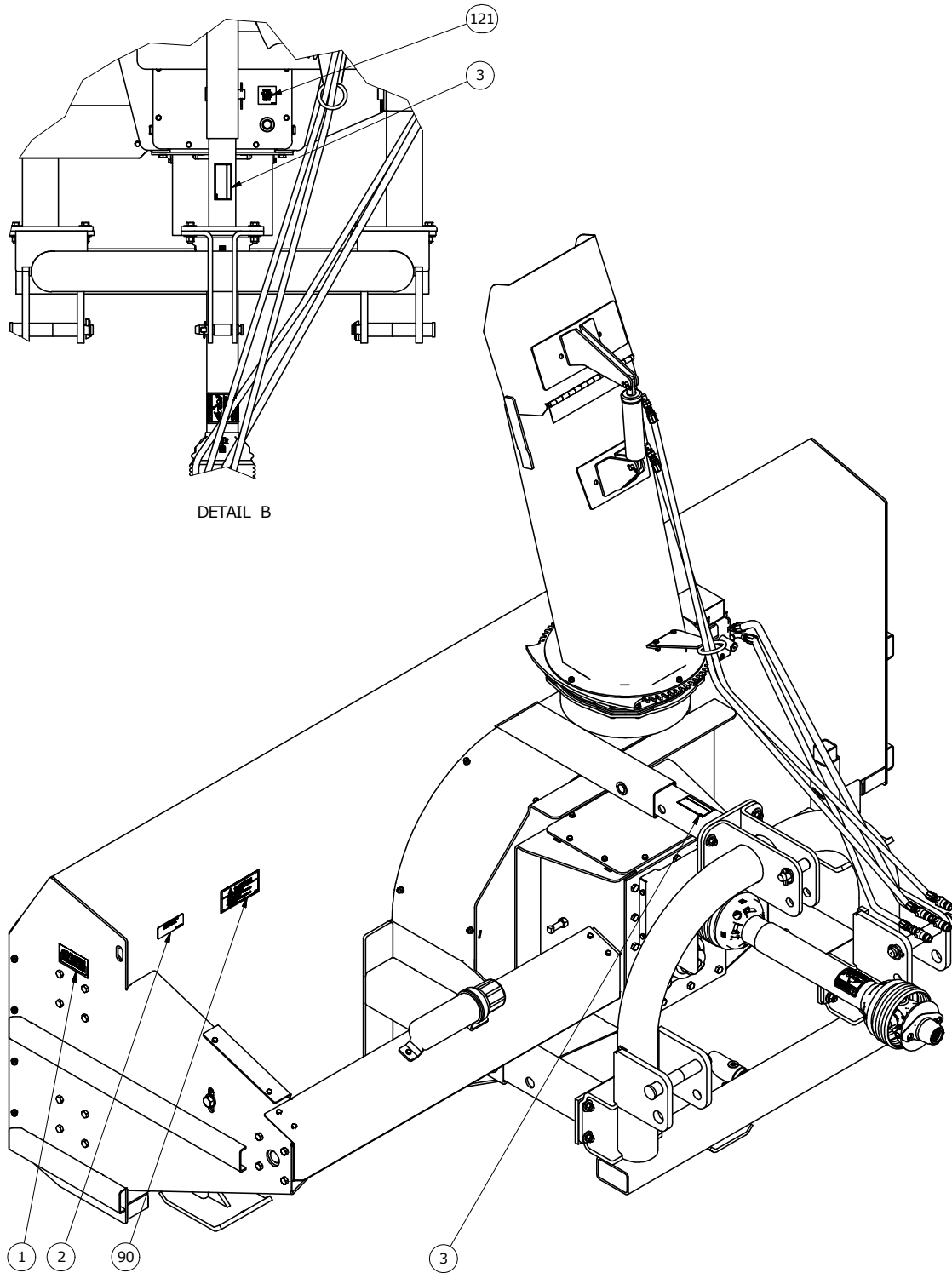
10' Spout Drawing



Item	Part #	Description
10	812026	5/16" x 1" Hex Bolt (PI)
11	812080	Adaptor Str 3/4 Morb x 3/4 Mjic
12	812208	Nipple 1/2" Body 1/2"- 14 Nptf Quick Connect
14	812363	Nut Lock (Steel) 0.375 Grb (PI)
17	813748	Washer, Fender, 1-1/2" Od x 5/16" Id (PI)
20	81525	1/4" x 3/4" Hex Bolt (PI)
23	81568	5/16" Hex Nut (PI)
24	81569	5/16" Lock Washer (PI)
25	81578	3/8" x 1-3/4" Hex Bolt (PI)
27	81593	3/8" Lock Washer (PI)
28	815932L	Spout Spacer
29	815933L	Spout Clamp
40	86170	3/8" x 1" Hex Bolt (PI)
49	909169	Manifold
53	912250	Hose 1/2" x 138-1/2" Mnpt x 3/4" Swfjic 90
58	912571	Gear Guard Weldt
59	912574	Gear Hub Weldt
62	912591	Neck Protection
119	966307	Adaptor 1/2" Mnpt x 1/2" Fnpt - .0520R Flow Restrictor
120	967249	5/16" x 2" Sckt Head Bolt (Br)
136	971518	Hydraulic Motor
140	9812410	3/8" Lock Washer (Br)
154	Y912	10' Spout Assy c/w Cyl & Hoses Gear Dr
154.1	913056	10' Spt Weldt
154.2	965305	Spout Link 1/2" x 1-1/4" x 8-3/4"
154.3	965238	Cylinder Arm 1/4" x 2" x 15-1/8"
154.4	811791	1/2" x 2" Hex Bolt (PI)
154.5	812364	1/2" Lock Nut (PI)
154.6	81620	1/2" x 1-1/4" Hex Bolt (PI)
154.7	87553	1/2" x 1-3/4" Hex Bolt (PI)
154.8	965304	Spout Link 1/2" x 1-1/4" x 28-1/8"
154.9	960913	1/2" x 1-13/16" Clev Pin (PI)
154.10	961876	1/2" x 1-1/2" Clev Pin (PI)
154.11	9812430	1/8" x 1" Cotter Pin (PI)
154.12	965239	3/16" x 1" x 4-1/2" Hose Clp
154.13	81593	3/8" Lock Washer (PI)
154.14	81592	3/8" Hex Nut (PI)
154.15	907590	Spt Hose Hldr Weldt
154.16	812026	5/16" x 1" Hex Bolt (PI)
154.17	81569	5/16" Lock Washer (PI)
154.18	81568	5/16" Hex Nut (PI)

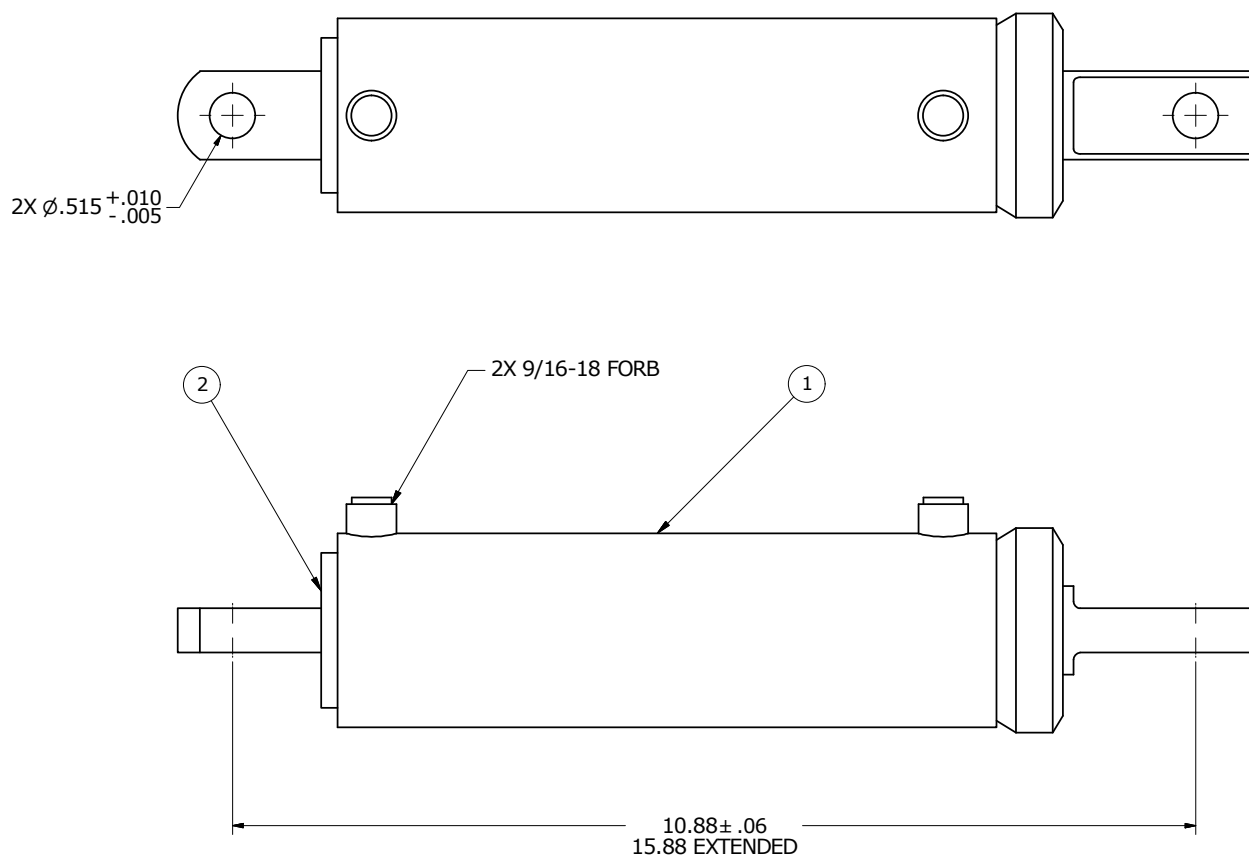
Item	Part #	Description
154.19	912593L	Spout Gear 54 Teeth
154.20	812363	Nut Lock (Steel) 0.375 Grb (PI)
154.21	81570	3/8" Std Flat Wash (PI)
154.22	86171	3/8" x 1-1/4" Hex Bolt (PI)
154.23	81638	1/2" Bs Flat Washer (PI)
154.24	24995M	Ø 1.75" x 5.0" Stroke Cylinder Assembly - Cream
154.25	812208	Nipple 1/2" Body 1/2"- 14 Nptf Quick Connect
154.26	115371	Hose 3/8" x 156" c/w Fittings
154.26.1	811918	Elbow 90 9/16 Swmorb x 9/16 Mjic
154.26.2	115369	3/8" x 156" Hose 1/2" Mnpt x 9/16" Swfjic

Decal Drawing



Item	Part #	Description
1	102893	Danger Decal
2	105420	Reference Plate JBI/FK Serial #
3	108431	Warning Check PTO Shaft
90	963206	Caution Decal
121	967388	Check Oil

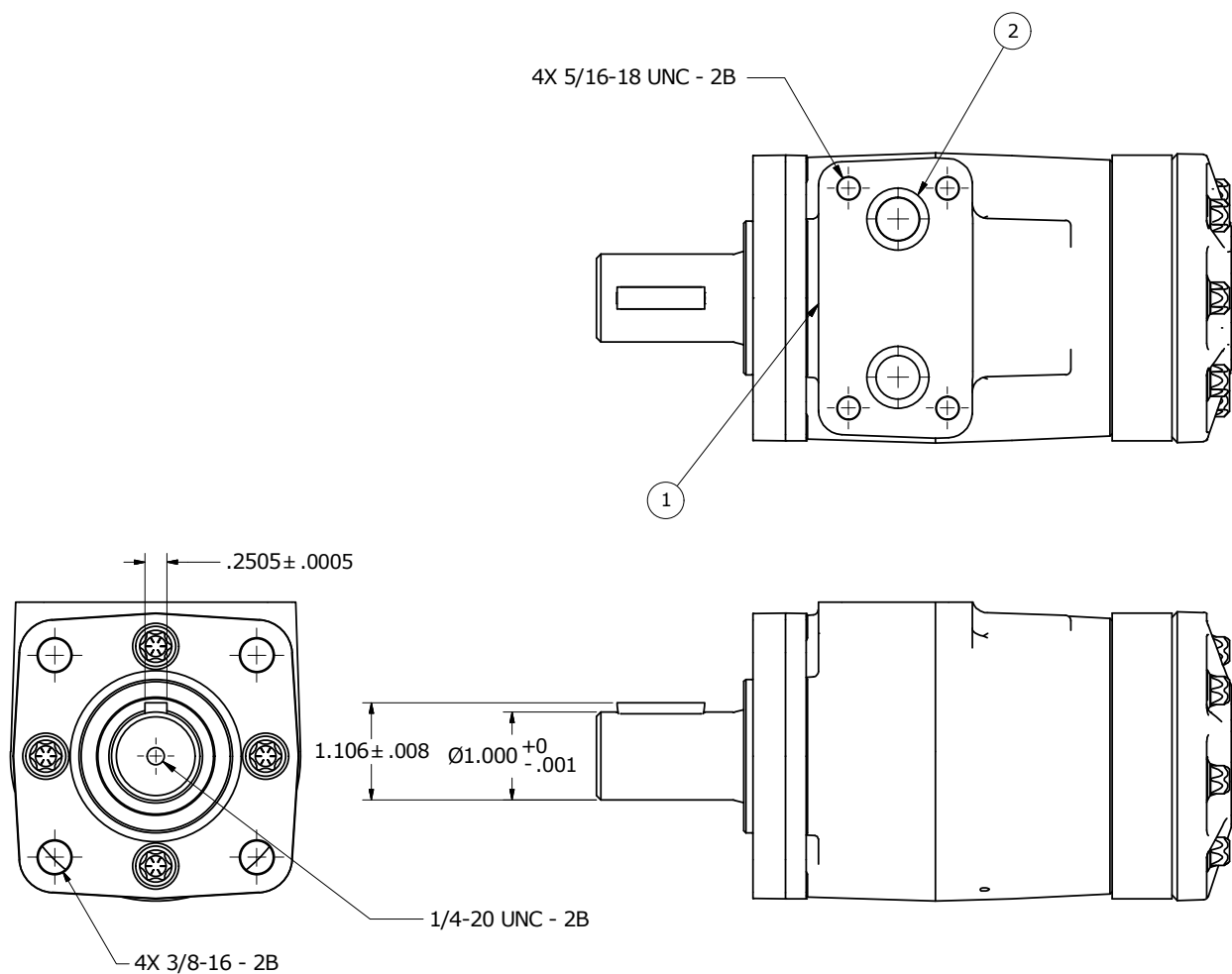
Spout Cylinder Drawing



SEAL KIT: P/N X3913

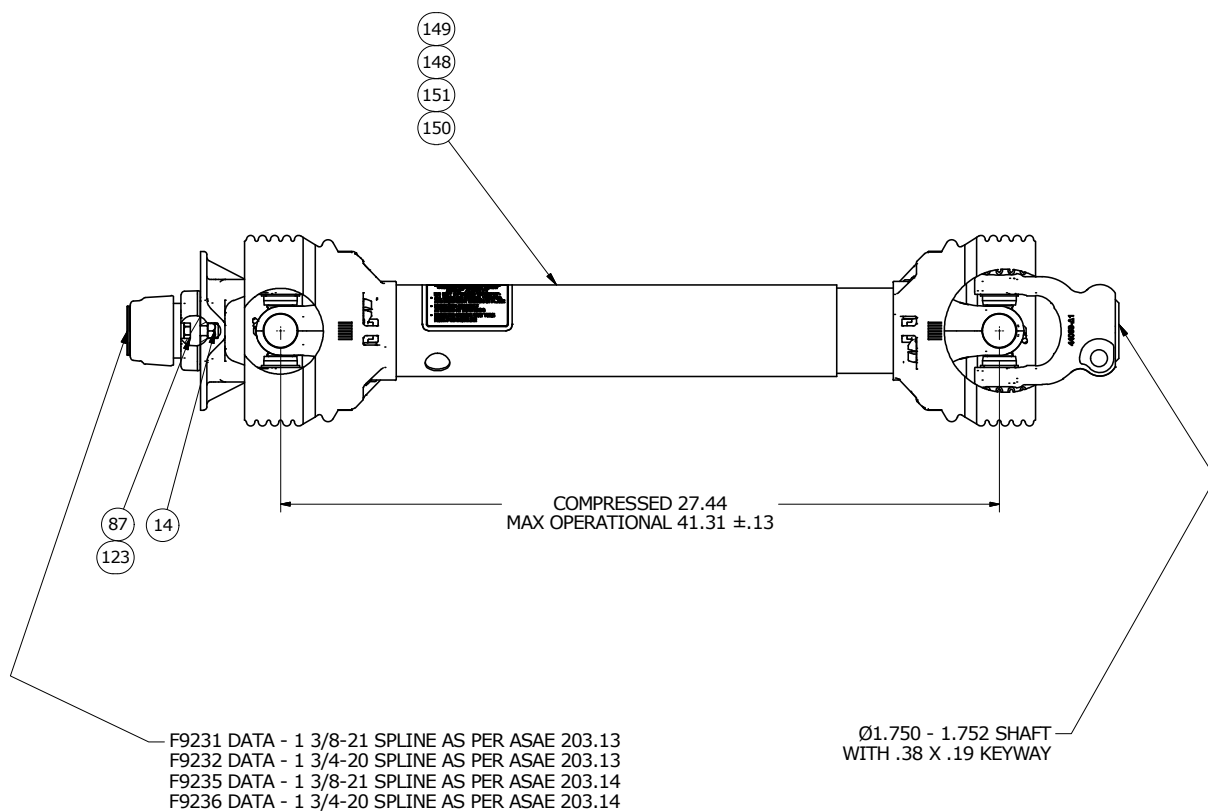
Item	Part #	Description
1	24995M	Cylinder - 1.75 x 5.00
2	X3913	Seal Kit - Cylinder 1.75

Hydraulics Motor Drawing



Item	Part #	Description
1	971518	Hydraulic Motor
2	913151	O-Ring Nom Id 1/2 x Nom Cs 3/32 x Nom Od 11/16

PTO Drawing



Item	Part #	Description
14	812363	Nut Lock (Steel) 0.375 Grb (Pl)
87	913152	Shear Bolt, 3/8 - 16 x 1.00 Lg Gr5
123	967432	Shear Bolt, 3/8 - 16 x 1.00 Lg Gr2
148	F9231	Standard Shaft (21 Spline, 1-3/8") - 1000 RPM - Gr2 Shear Bolt 1080
149	F9232	Option Shaft (20 Spline, 1-3/4") - 1000 RPM - Gr2 Shear Bolt 1080
150	F9235	Standard Shaft (21 Spline, 1-3/8") - 1000 RPM - Gr5 Shear Bolt 1200
151	F9236	Option Shaft (20 Spline, 1-3/4") - 1000 RPM - Gr5 Shear Bolt 1200

Shipping Kit and Bundle Numbers

The following is a list of Kit Numbers for this product and the Bundle Numbers, Descriptions, and Quantities for each Kit.

Quantity	Bundle Number	Description
1000 RPM with Standard Spout (Y1200C)		
1	F1452	Spout Reg
1	F1453	Carton of Parts
1	F1486	Hitch SB Round
1	F1487	Main Body and Arms SB 1200
1	F9235	PTO - 1-3/8" 21 Spline Gr5 Shear Bolt

1000 RPM with Standard Spout (Y1080C)		
1	F1452	Spout Reg
1	F1453	Carton of Parts
1	F1485	Main Body and Arms SB 1080
1	F1486	Hitch SB Round
1	F9231	PTO - 1-3/8" 21 Spline Gr2 Shear Bolt

Optional Bundle Numbers

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

Quantity	Bundle Number	Description
1	F9232	1-3/4" x 20 Spline Gr2 Shear Bolt
1	F9236	1-3/4" x 20 Spline Gr5 Shear Bolt
1	Y911	Opt 7' Spout c/w Cyl & Hoses Gear
1	Y912	Opt 10' Spout c/w Cyl & Hoses Gear

Allied by Farm King Limited Warranty

This document limits your warranty rights.

Base Limited Warranty

Buhler Industries Inc. provides this warranty only to original retail purchasers of its product. Buhler Industries Inc. warrants to such purchasers that all Buhler Industries Inc. manufactured parts and components used and serviced as provided for in the Operator's Manual shall be free from defects in materials and workmanship for a period following delivery to the original retail purchaser of 12 months (80 days for commercial applications). This limited warranty applies only to those parts and components manufactured by Buhler Industries Inc. Parts and components manufactured by others are subject to their manufacturer's warranties, if any.

Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Buhler Industries Inc. reserves the right to either inspect the product at the buyer's location or have it returned to the factory for inspection. Parts must be returned through the selling representative and the buyer must prepay transportation charges.

Buhler Industries Inc. will not be responsible for repairs or replacements that are necessitated, in whole or part, by the use of parts not manufactured by or obtained from Buhler Industries Inc. Under no circumstances are component parts warranted against normal wear and tear. There is no warranty on product pump seals, product pump bearings, rubber product hoses, pressure gauges, or other components that require replacement as part of normal maintenance. Also: Buckets and Bucket Tines carry no warranty, Bent Spears carry no warranty, Snowblower Fan Shafts carry no warranty, Mower Blades carry no warranty, Portable Auger Parts Have Two (2) Year Warranty, Loader Parts Have Two (2) Year Warranty. The purchaser is solely responsible for determining suitability of goods sold. This warranty is expressly in lieu of all other warranties expressed or implied. Buhler Industries Inc. will in no event be liable for any incidental or consequential damages whatsoever. Nor for any sum in excess of the price received for the goods for which liability is claimed.

Repair Parts Limited Warranty

Buhler Industries Inc. warrants Farm King replacement parts purchased after the expiration of the Buhler Industries Inc. Limited Warranty, and used and serviced as provided for in the Operator's Manual, to be free from defects in materials or workmanship for a period of thirty (30) days from the invoice date for the parts. Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Such parts must be shipped to Buhler Industries Inc. at the purchaser's expense.

What is Not Covered

Under no circumstances does this limited warranty cover any components or parts that have been subject to the following: negligence; alteration or modification not approved by Buhler Industries Inc.; misuse; improper storage; lack of reasonable and proper maintenance, service, or repair; normal wear; damage from failure to follow operating instructions; accident; and/or repairs that have been made with parts other than those manufactured, supplied, and or authorized by Buhler Industries Inc.

Authorized Dealer and Labor Costs

Repairs eligible for labor under this limited warranty must be made by Buhler Industries Inc. or an authorized Farm King dealer. Buhler Industries Inc. retains the exclusive discretion to determine whether it will pay labor costs for warranty repairs or replacements, and the amount of such costs that it will pay and the time in which the repairs will be made. If Buhler Industries Inc. determines that it will pay labor costs for warranty work, it will do so by issuing a credit to the dealer's or distributor's account. Buhler Industries Inc. will not approve or pay invoices sent for repairs that Buhler Industries Inc. has not previously approved. Warranty service does not extend the original term of this limited warranty.

Warranty Requirements

To be covered by warranty, each Farm King new product must be registered with Buhler Industries Inc. within thirty (30) days of delivery to original retail purchaser. If the customer decides to purchase replacement components before the warranty disposition of such components is determined, Buhler Industries Inc. will bill the customer for such components and then credit the replacement invoice for those components later determined to be covered by this limited warranty. Any such replacement components that are determined not be covered by this limited warranty will be subject to the terms of the invoice and shall be paid for by the purchaser.

Warranty Claims:

Warranty requests must be prepared on Buhler Industries Inc. Warranty Claim Forms with all requested information properly completed. Warranty Claims must be submitted within a thirty (30) day period from date of failure repair.

Warranty Labor:

Any labor subject to warranty must be authorized by Buhler Industries Inc. The labor rate for replacing defective parts, where applicable, will be credited at 100% of the dealer's posted shop rate.

Exclusive Effect of Warranty and Limitation of Liability

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY WARRANTIES, REPRESENTATIONS, OR PROMISES, EXPRESS OR IMPLIED, AS TO THE QUALITY, PERFORMANCE, OR FREEDOM FROM DEFECT OF THE COMPONENTS AND PARTS COVERED BY THIS WARRANTY AND NOT SPECIFICALLY PROVIDED FOR HEREIN.

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ON ITS PRODUCTS COVERED HEREIN, AND DISCLAIMS ANY RELIANCE BY THE PURCHASER ON BUHLER INDUSTRIES INC.'S SKILL OR JUDGMENT TO SELECT OR FURNISH GOODS FOR ANY PARTICULAR PURPOSE. THE PURCHASER'S ONLY AND EXCLUSIVE REMEDIES IN CONNECTION WITH THE BREACH OR PERFORMANCE OF ANY WARRANTY ON PRODUCTS MANUFACTURED BY BUHLER INDUSTRIES INC. ARE THOSE SET FORTH HEREIN. IN NO EVENT SHALL BUHLER INDUSTRIES INC. BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING, BY WAY OF EXAMPLE ONLY AND NOT LIMITATION, LOSS OF CROPS, LOSS OF PROFITS OR REVENUE, OTHER COMMERCIAL LOSSES, INCONVENIENCE, OR COST OF REPLACEMENT OF RENTAL EQUIPMENT). IN NO EVENT SHALL FARM KING'S CONTRACT OR WARRANTY LIABILITY EXCEED THE PURCHASE PRICE OF THE PRODUCT.

(Note that some provinces or states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitations and exclusion may not apply to you.) This warranty gives you specific legal rights and you may also have other rights, which vary from province to province or state to state.

Buhler Industries Inc. neither assumes nor authorizes any person or entity, including its selling representatives, to assume any other obligations or liability in connections with the sale of covered equipment, or to make any other warranties, representations, or promises, express or implied, as to the quality, performance, or freedom from defect of the components and parts covered herein. No one is authorized to alter, modify, or enlarge this limited warranty, or its exclusions, limitations and reservations.

Corrections of defects and improper workmanship in the manner, and for the applicable time periods, provided for herein shall constitute fulfillment of all responsibilities of Buhler Industries Inc. to the purchaser, and Buhler Industries Inc. shall not be liable in negligence, contract, or on any other basis with respect to the subject equipment.

This limited warranty is subject to any existing conditions of supply which may directly affect Buhler Industries Inc.'s ability to obtain materials or manufacture replacement parts.

Buhler Industries Inc. reserves the right to make improvements in design or changes in specifications to its products at anytime, without incurring any obligation to owners of units previously sold.

Government Legislation:

Warranty terms and conditions are subject to provincial or state legislation.

Important Note: This warranty does not apply to rentals.

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