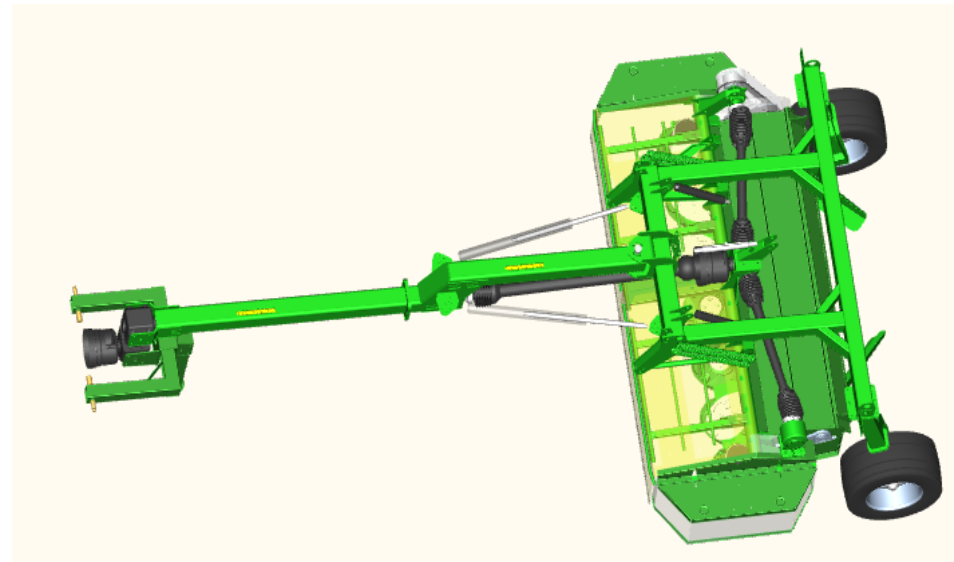


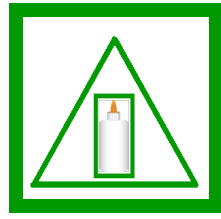
ASSEMBLY INSTRUCTIONS FOR KDC MOWERS



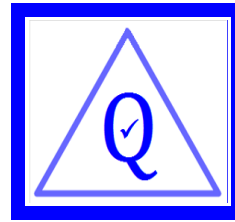
Designations and symbols used:



safety



use adhesive



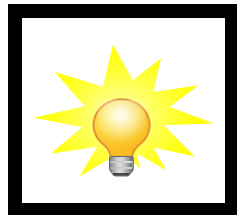
quality



use torque
wrench



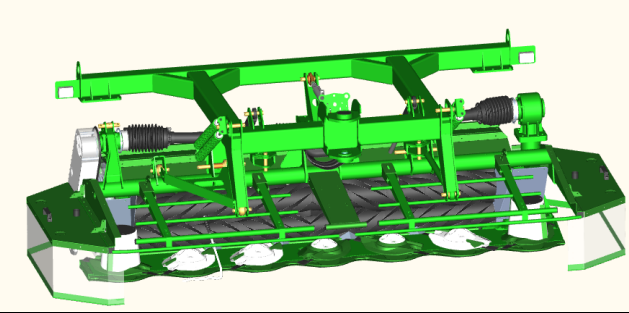
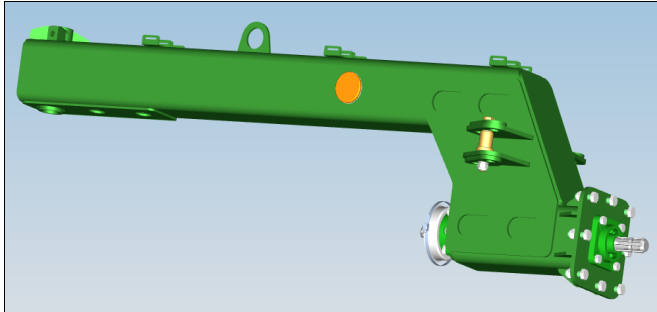
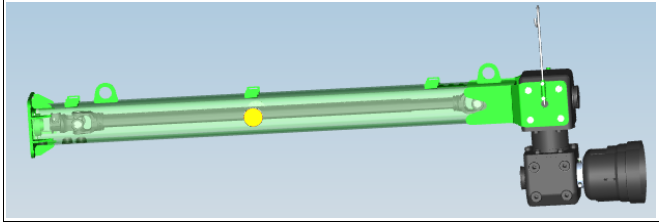
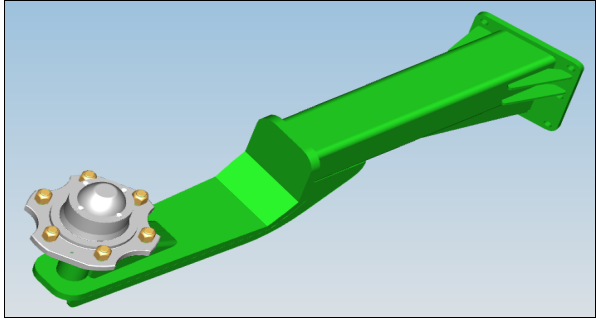
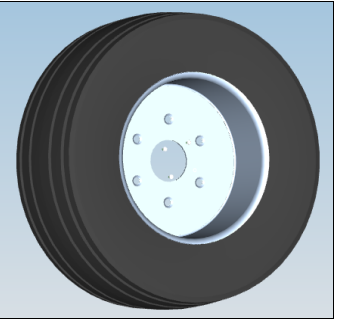
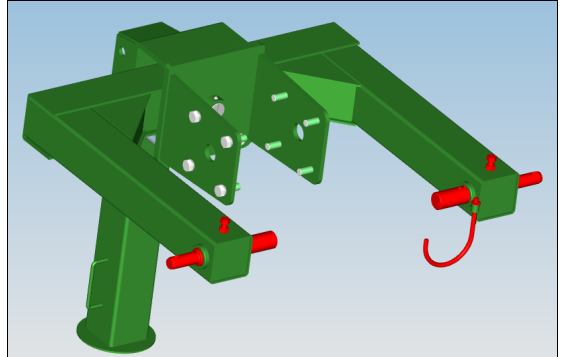
element lifting on
hook or sling

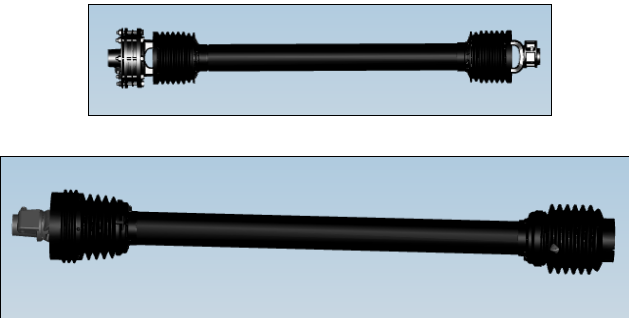
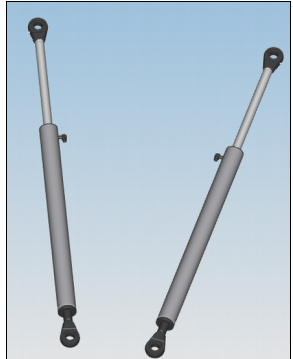



advice, recommendation

Checklist

MACHINE TYPE: KDC

A	B	C
<p>PALLET NO. 1</p> 	<p>PALLET NO. 1</p> 	<p>PALLET NO. 1</p> 
<ol style="list-style-type: none"> 1. Cutting unit – 0575.05.00.000 2. Main frame – 0633.04.00.003 3. Carrying frame – 0633.00.00.003 	<ol style="list-style-type: none"> 1. Rear drawbar – 0640.02.02.003 	<ol style="list-style-type: none"> 1. Front drawbar – 0630.02.01.002 2. Bevel gear - MIPS-124-001
D	E	F
<p>PALLET NO. 1</p> 	<p>PALLET NO. 1</p> 	<p>PALLET NO. 1</p> 
<ol style="list-style-type: none"> 1. Right leg – 0237.13.02.005 2. Left leg – 0237.13.03.005 	<ol style="list-style-type: none"> 1. Wheel 340x55 R16 – MIGK-340-005 – 2pcs. 	<ol style="list-style-type: none"> 1. Linkage – 0237.01.00.004





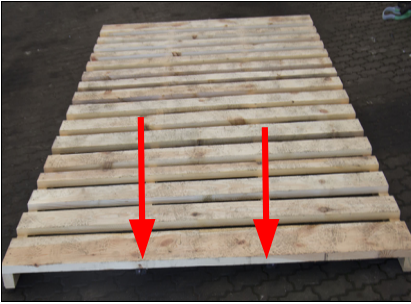

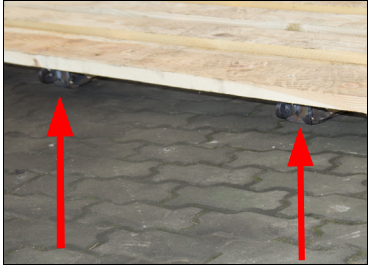
Checklist		MACHINE TYPE: KDC	
G	PALLET NO. 1	H	PALLET NO. 1
			
<ol style="list-style-type: none"> 1. Transmission shaft (short) – 8G7T065CE007003 2. Transmission shaft (long) - DS8R135FX014K01 		<ol style="list-style-type: none"> 1. Hydraulic cylinder – 0237.02.03.000 – 2pcs. 	
		I	PALLET NO. 1
			
		<ol style="list-style-type: none"> 1. Safety curtain 2. Box with fastening elements 	

Checklist – Machine completeness **KDC**

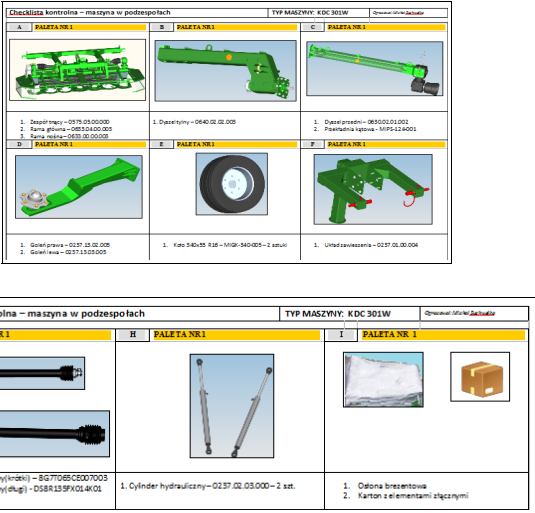
Date	
Machine number	



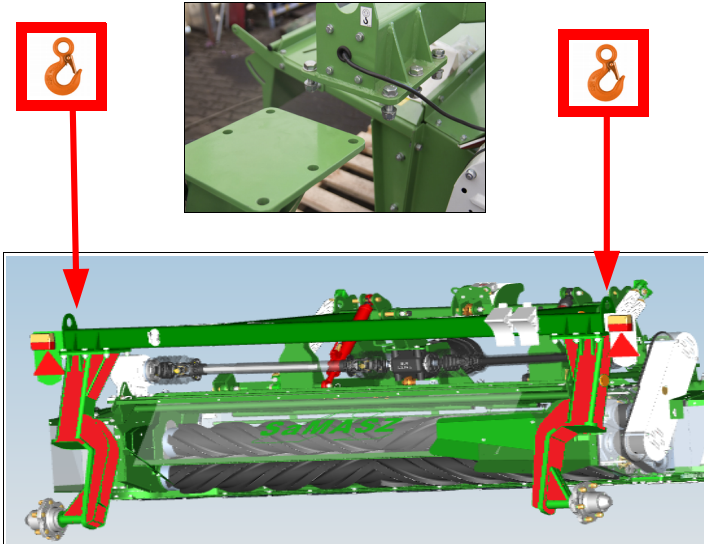
No.	Element name	Quantity	Name of sub-assembly where the element is assembled to			
B O X 1	BAG No. 1-10 – Machine elements			✓		✓
	1	Nut M18x1.5 DM	12pcs.	- wheel - leg right - 0237.13.02.005 - leg left - 0237.13.03.005		
	2	Washer d16	24pcs.	- carrying frame – 0633.03.00.003		
		Nut M16	12pcs.	- leg right – 0237.13.02.005		
		Bolt M16x50	12pcs.	- leg left - 0237.13.03.005		
	3	d45 L=295	1pce.	- carrying frame – 0633.03.00.003 - drawbar rear - 0640.02.02.003		
		Bolt M14x100	1pce.			
		Self-locking nut M14	1pce.			
		Washer d14	1pce.			
		Cirelip z 45	1pce.			
		Static seal	2pcs.			
		Spacer d45x0.1	2pcs.			
	4	Washer d16	16pcs.	- drawbar rear – 0640.02.02.003 - drawbar front - 0630.02.01.002.		
		Nut M16	8pcs.			
		Bolt M16x50	8pcs.			
	5	Bolt M16xr45	4pcs.	- drawbar front – 0630.02.01.002		
		Washer d16	pcs	- linkage – 0237.01.00.004		
	6	Pin 30x25.4 L=128x49	4pcs.	- carrying frame – 0633.03.00.003		
		Washer d16	4pcs.	- drawbar rear – 0640.02.02.003		
		Self-locking nut M16	4pcs.	- cylinders – 0237.02.03.000		

Checklist – completeness of the box with fastening elements				Machine no.	
				Date	
No.	Name	Reference	Quantity		
Box	Main pin str. d45 L=295	0237.02.05.005	1		
	Pin 30x25.4 L=128x49	0640.03.12.003	4		
	Spacer tube	0640.02.07.003	4		
	Metal band clip 130-150	MIIO-130-000	1		
	Cable tie L=280	MIIO-000-280	6		
	Static seal	MZIU-000-004	2		
	Circlip Z 45	MZSE-045-001	1		
	Lock washer d8.2	MZPS-008-001	6		
	Washer d14 zinc-pl.	MZPP-014-001	1		
	Washer d16	MZPP-016-001	44		
	Spacer d45x0.1	-	2		
	Spacer d45x0.2	-	2		
	Spacer d45x0.3	-	2		
	Self-locking nut M14 cl. 8 zinc-pl.	MZNS-014-004	1		
	Self-locking nut M16	MZNS-016-005	24		
	Nut M18x1.5 DM	MZNS-018-001	12		
	Bolt M8x20 cl. 8.8 zinc-pl.	MZSZ-008-001	6		
	Bolt M14x100 cl. 8.8 zinc-pl. (82101)	MZSZ-014-008	1		
	Bolt M16x45 cl. 8.8 zinc-pl.	MZSZ-016-001	8		
	Bolt M16x50 cl. 8.8 zinc-pl.	MZSZ-016-002	20		


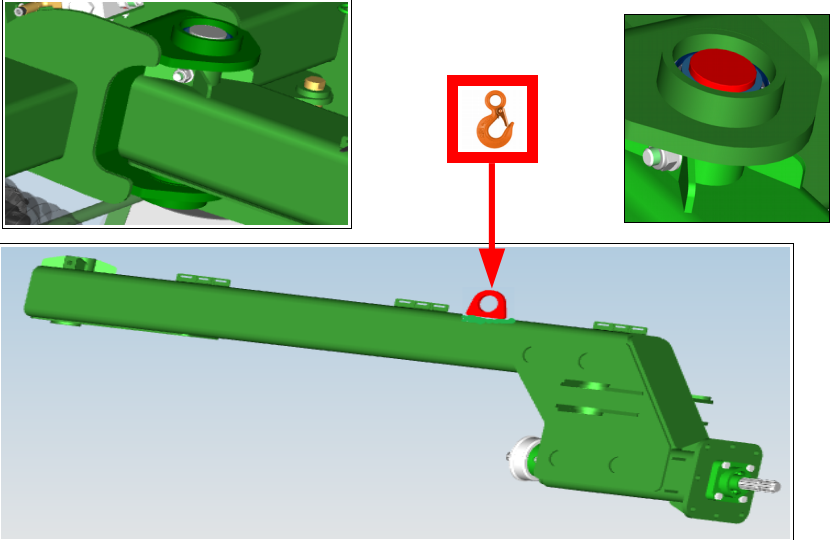

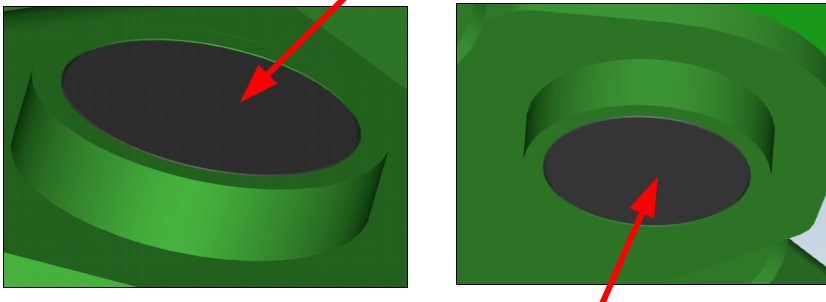
		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
1	Unloading container with machines.		The KDC machines are stacked as complete assemblies on special large-size pallets. Depending on the machine width (3m or 3.4m) a container holds 6 or 8 sets.	
		 	<p>Depending on a type of available forklift truck take either first two machine sets at the same time or in sequence, starting with the one on the top.</p> <p>Once first sets are taken attach straps on eyebolts by beams of the bottom pallet and move it at the container door so that they can be taken from the pallet using the forklift truck. For this purpose us shackles d14 delivered.</p>	  


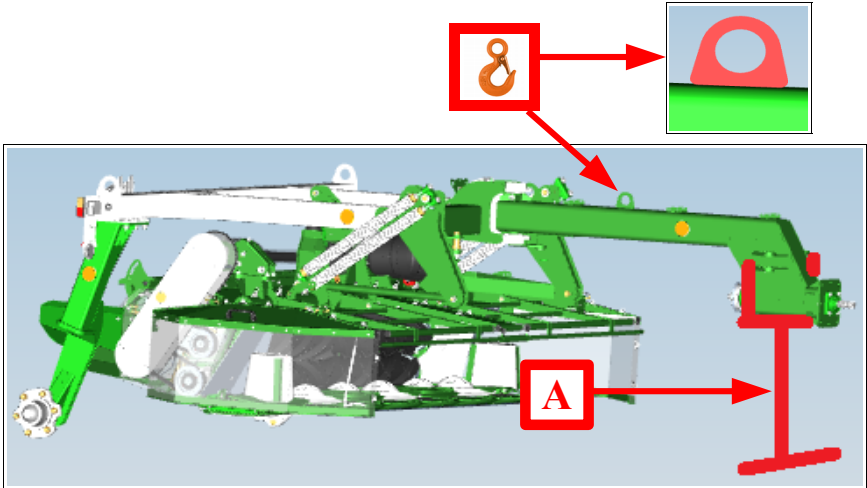


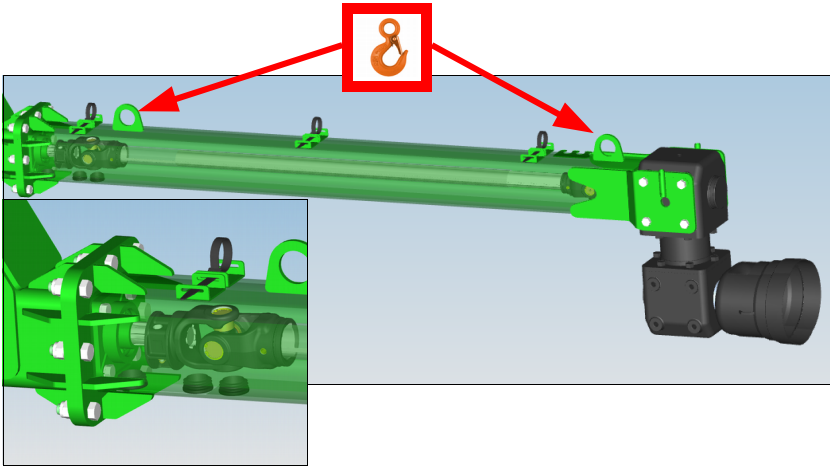
MACHINE: **KDC**



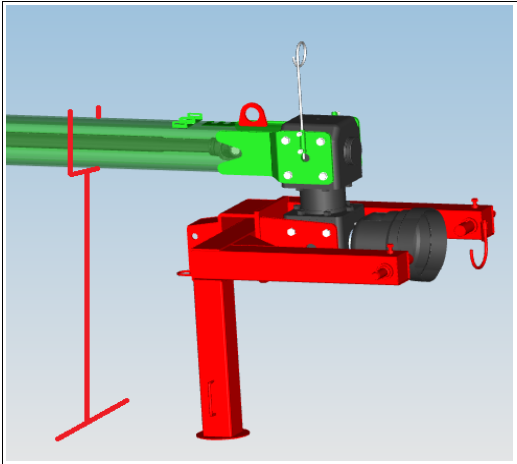
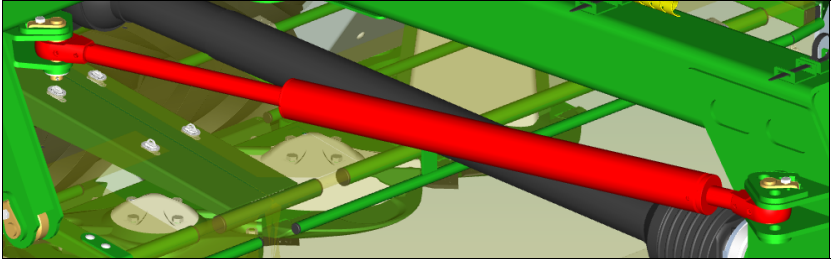
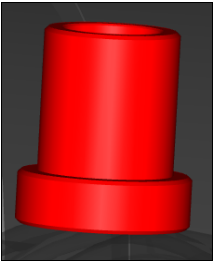
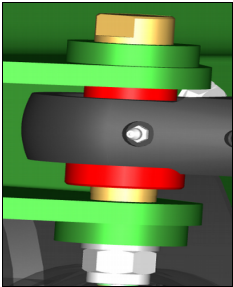

No.	ACTION		DESCRIPTION	FIGURE / PHOTO
2	Checking for completeness.		<p>Once unloaded from container, check items for completeness with the checklist, and fastening elements in the box for completeness with the checklist above. If everything is in order start assembling the mower.</p> <p>If any part is missing, contact the supplier within 7 days from the delivery.</p>	

4	Mounting legs to main frame.	 	<p>Lift the frame to enable mounting of legs. Mount legs to the main frame using bolts M16x50 cl. 8.8 zinc-pl. + washer d16 zinc-pl. at both sides + self-locking nut M16 cl. 8. Install bolts from the top to the bottom. Slightly tighten (for further correction and toe-in adjustment).</p>	
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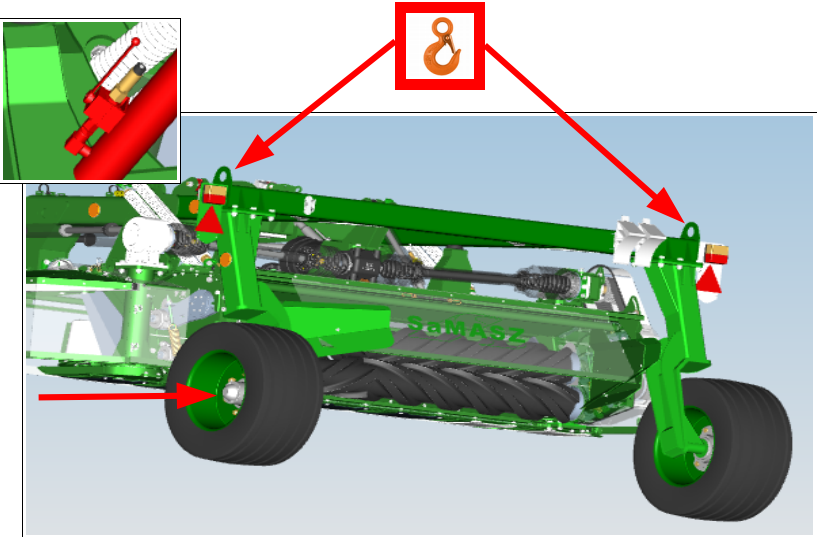

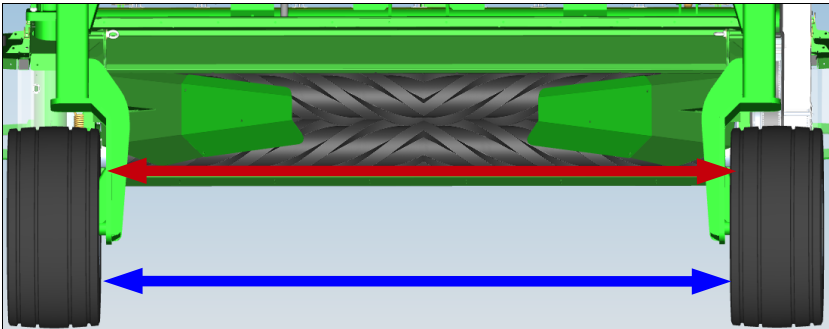
MACHINE: KDC

No.	ACTION		DESCRIPTION	FIGURE / PHOTO
5	Assembling rear drawbar.		<p>Connect rear drawbar to welded frame using main pin d45 L=295. Secure the pin with bolt M14x100 cl. 8.8 zinc-pl. + standard washer d14 zinc-pl. + self-locking nut M14 cl. 8. Secure the pin from the bottom using Seeger ring Z-45. Eliminate the clearance using spacers d45 delivered with the machine. Before installing static seals grease bearings 33209.</p>	
			<p>Install static seals EC 85x12 from the top and the bottom.</p>	


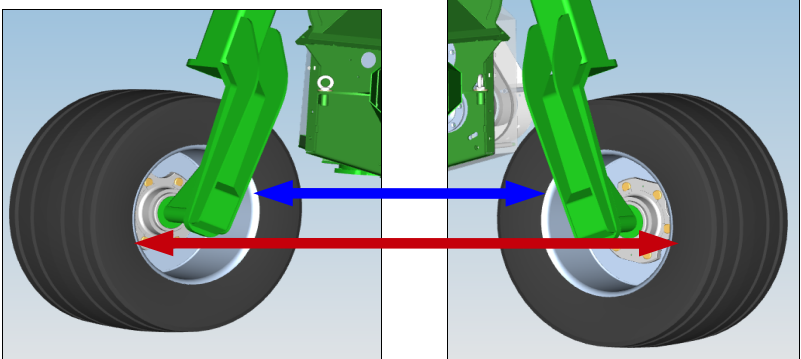

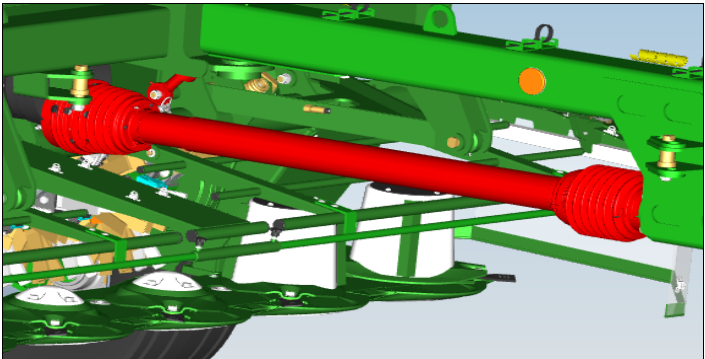
		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
			Lift the machine by the attached drawbar, and remove stands from underneath the frame. Put a stand under the drawbar – A .	
6	Assembling front drawbar.	 	Connect PTO shaft of the front drawbar to splined shaft of the rear drawbar. Make sure the latch is properly engaged. The PTO shaft is of telescopic design. When installing pay attention not to retract it for a length greater than permissible. Connect the rear and the front drawbars using bolts M16x50 cl. 8.8 zinc-pl. + washer d16 zinc-pl. at both sides + self-locking nut M16 cl. 8. Torque 220Nm .	


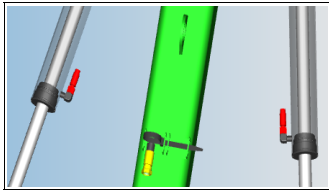
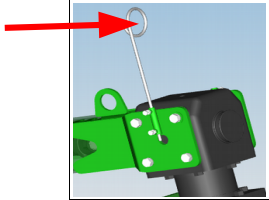



		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
7	Assembling linkage.	 	<p>Connect linkage to transmission using bolts M16x50 cl. 8.8 zinc-pl. + washers d16 zinc-pl. Use blue assembly adhesive. Lift by the drawbar, remove the stand from underneath the foot and put the drawbar on the mower's support foot.</p>	
8	Assembling rotation cylinders.		<p>Assemble rotation cylinder as shown. Install spacer tubes into cylinder eyes. Secure pin 30x25.4 L=128x49 using washer d16 and self-locking nut M16. Assemble the other cylinder following the same procedure. Before installing grease the pins.</p>	   



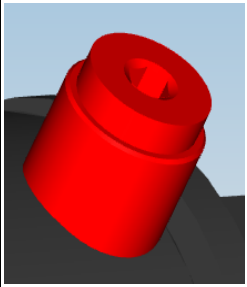

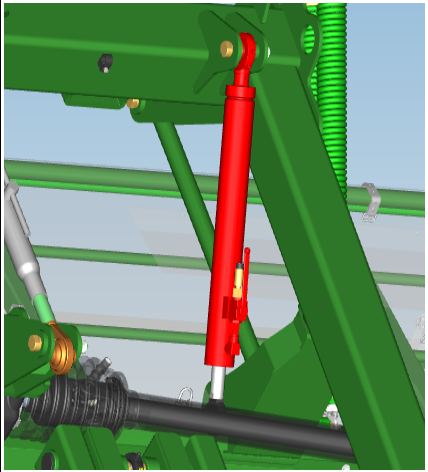
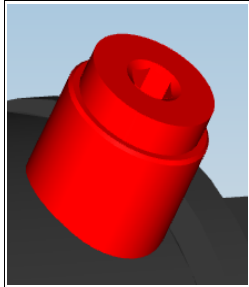
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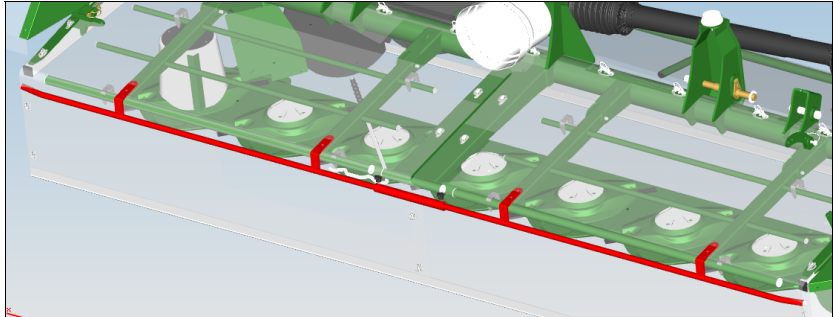
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
9	Mounting wheels on legs.	 	Close valves on cylinders for cutting unit lifting. Lift the linkage with cutting unit at a height enabling wheels to be mounted on legs. Install wheels on legs using nuts M18x1.5DM. Torque 260Nm .	
10	Toe-in adjusting.		Adjust the toe-in. A difference between the indicated measurements may be 2mm.	

MACHINE: **KDC**

No.	ACTION		DESCRIPTION	FIGURE / PHOTO
			<p>Take measurement from inner sides of the rims at opposite points at the rim front or rear. Once the adjustment is complete tighten bolts for mounting legs to the frame applying 220Nm.</p>	
11	Assembling PTO shaft.		<p>Assemble the PTO shaft. Pay attention that holes in shaft guards are on the bottom. Use metal band clip 130–150. From the bar side, attach the shaft protection chain on eye of conical guard.</p>	

		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
12	Installing hydraulic hoses.		<p>Unfold coiled hoses remaining on the mower on the top of drawbars. Connect two hoses (which are not connected anywhere) to rotation cylinders. Attach all braided hoses to drawbars using band clips. Put ends of hoses through hose coils.</p>	  
13	Assembling lighting.		<p>Using bolts mount bracket with lights. Use blue assembly adhesive.</p>	 

		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
14	Venting rotation cylinders.		Mount the mower on tractor. Lift cutting unit by means of tractor's hydraulic system. Gently and carefully drive off from the pallet. Remove vent from rotation cylinder, retract it to its maximum, and close the vent. Do the same with the other cylinder.	 
15	Venting cylinders for cutting unit lifting.		Lower the cutting unit onto the ground. Remove vents, retract cylinders by means of hydraulic system, and close the vents again.	 

		MACHINE: KDC		
No.	ACTION		DESCRIPTION	FIGURE / PHOTO
16	Assembling safety curtain.		Remove front guards (marked in the figure).	
			Unfold safety curtain. Secure the guard with swivel eyes and swivel and swing eyes – B . Fasten safety curtain to lifted guards – C .	