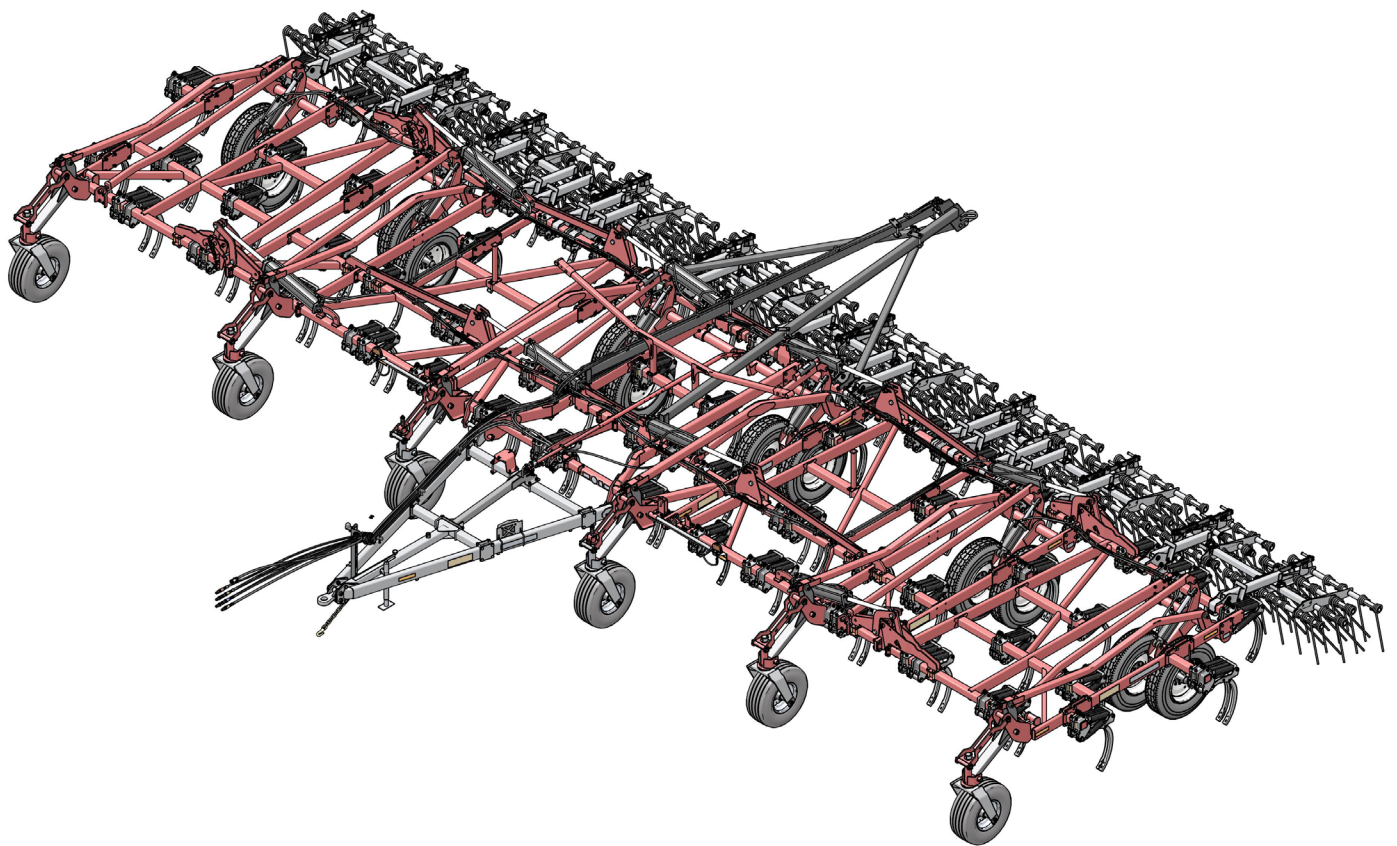


2500 Series
2550 55, 2550 55-59



2.1 Safety Alert Symbols

2.1.1 Safety Information

The Safety Alert Symbol(s) are intended to direct the attention of the machine user to important safety information both published in the Operator's Manual and applied to the machine. Any time Safety Alert Symbol(s) are seen, it means that associated information is provided for recognizing, appropriately responding to and avoiding potentially hazardous situation(s).

A triangle shape surrounding an exclamation point indicates a potentially hazardous situation. Information included in a safety sign or printed in the Operator's Manual describes the hazardous situation and indicates appropriate response(s) and/or avoidance procedures.

This Safety Alert Symbol means:



Attention Be Alert!

2.1.2 Signal Words



DANGER! Indicates an imminently hazardous situation that, if not avoided, WILL result in death or serious injury if the proper precautions are not taken.



WARNING! Indicates a potentially hazardous situation that, if not avoided, COULD result in death or serious injury if the proper precautions are not taken.



CAUTION! Indicates a potentially hazardous situation that, if not avoided, MAY result in minor or moderate injury if the proper practices are not taken, or, serves as a reminder to follow appropriate safety practices.



Used to clarify information.



The information next to this symbol may be worth noting since it is a hint containing particularly useful information on how to handle the machine.

2.2 Safety Sign Information

Safety Sign Legibility: All safety signs applied to the implement must be visible and legible. Keep dust and dirt cleared from safety signs and ensure that visibility is not obscured.

Safety Sign Replacement: Safety signs may be ordered through the dealer or distributor. Contact Väderstad Inc. if unable to obtain replacement safety signs from a dealer or distributor.

Damaged or Deteriorated Safety Signs: Remove and replace any safety signs that have either been damaged or show signs of deterioration.

Safety Signs on Replacement Parts: Ensure parts/components that are replaced on the implement that featured a safety sign originally include a safety sign.



For parts and decal replacement, visit the website at: <https://www.vaderstad.com/ca-en/service--parts/genuine-parts-online/>

Affixing Safety Signs to the Implement

1. Ensure proper position and orientation before installing.
2. Ensure installation area is clean and dry.
3. Ensure ambient temperature is above 10°C (50°F).
4. Remove backing material to expose label adhesive.
5. Place one edge of label to machine surface.
6. Slowly press the label onto the surface.
7. Ensure no air pockets are present/become trapped under surface or label. To remove air pockets, pierce the bubble with a pin, letting the trapped air out, then press the label down.

2.3 Maintenance Safety

Read and understand all information provided in the Operator's Manual covering operation, adjustment, maintenance and repair prior to performing any of these tasks. Plan work to ensure proper tools, equipment, and personal protective equipment is available prior to working on implement.

Wear appropriate clothing when performing tasks around implement. Ill-fitting and/or frayed clothing as well as loose or dangling items should not be worn when working near the implement.

Stop the engine, lower the implement, set the parking brake, remove the ignition key, and allow time for moving parts to stop prior to adjusting, maintaining, and/or repairing the implement.

Ensure that all moving parts have come to a complete stop before performing adjustments, maintenance and/or repairs.

Ensure that hydraulic oil pressure in hoses, lines, and components is fully relieved prior to performing any maintenance, and/or repairs.

Ensure that wings are either fully lowered or fully raised and secured with their safety chains and pins or securely block the wings if raised to perform adjustments, maintenance and/or repairs.

Securely block main frame and/or wings (any raised components) if adjustments, maintenance, and/or repairs are required.

Wear personal protective equipment, such as gloves, eye protection, etc. when inspecting the hydraulic system for leaks. Use a small piece of cardboard or wood to detect leaks.

Ensure that all guards and shields are intact and in place after performing adjustments, maintenance and/or repairs prior to operating implement.

Store flammable fluids in approved containers and store out of access by unauthorized persons, especially children.

Replace the safety chain if one or more links or end fittings are broken, stretched or otherwise damaged or deformed.

Do not allow children or other unauthorized persons within the implement operational area.

Do not modify the equipment or substitute parts in any way. Unauthorized modification may impair the function and / or safety of the machine.

Use a suitable lifting device for components which could cause personal injury by pinching, crushing or weight. Be sure lifting device is rated to handle the weight.

Always inspect lifting chains and slings for damage or wear.

2.4 Hydraulic Safety

Always place all tractor hydraulic controls in neutral before dismounting.

Ensure that all hydraulic system components are kept clean and in proper working condition.

Relieve pressure before working on hydraulic system.

Use a piece of cardboard or wood to check for hydraulic leaks.

Wear personal protective equipment, such as gloves, eye protection, etc. if unsure if residual pressure may exist in hydraulic components during troubleshooting and/or making repairs.

If injured by a concentrated high-pressure stream of hydraulic fluid, seek medical attention immediately.

Serious infection or toxic reaction can develop from hydraulic fluid piercing the skin surface.

Check hydraulic hoses regularly for wear and tighten/replace as needed. Contact your local Dealer parts department to purchase replacement hoses specifically designed for Wil-Rich machines.

When connecting the hoses to the cylinders, tubings or fittings; always use one wrench to prevent the hose from twisting and another wrench to tighten the union.

Excessive twisting will shorten hose life and loosen hose fittings.

DO NOT attempt any makeshift repairs to the hydraulic lines, fittings or hoses by using tape, clamps or cements.

The hydraulic system operates under extremely high pressure.

Such repairs will fail suddenly and create a hazardous and unsafe condition.

Do not over-tighten hydraulic fittings, excessive torque may cause them to crack.

Always contact the nearest Wil-Rich dealer or service professional when replacing hydraulic hoses.

When replacing hoses always route hoses the same as the one being replaced to ensure that the part is not subjected to wear, rubbing, kinking, etc. Make repairs following instructions provided by the manufacturer.

Ensure all fittings, couplings, and other hydraulic connections are intact and properly tightened before operating implement hydraulic system.



DO NOT touch pressurized hose assemblies with any part of the body. If fluid punctures the skin, seek immediate medical attention.

Hydraulic fluids are highly flammable. Always keep open flames and ignition sources away from hydraulic fluids.

2.5 Electrical Safety

Ensure that the machinery is shut off and all electrical components are disconnected before doing any work on the machine. Ensure all live connections are not receiving power.

Check electrical wires regularly for wear related to usage and weathering. Replace any damaged wires or components immediately.

Use insulated tools whenever performing service to any electrical system or components and always wear proper protective equipment.

2.6 Tire Safety

Ensure tire inflation pressure is maintained per specifications.

Do not attempt to mount a tire unless you have the proper equipment and experience to do the job.

Follow proper procedures for tire repairs, especially when mounting tire to the rim.

Seek assistance from a trained person for tire repairs or mounting, especially if specialized equipment is required.

2.1 Using This Manual

2.1.1 Using These Instructions

Follow the instructions in this document to safely assemble your machine.

Read and understand the safety information on the following pages before you begin assembly.

This FAI document and the Consolidated Pick List for your machine were placed in the manual holder at the factory. If you do not have both documents, contact the manufacturer for copies before beginning assembly.

The Item Numbers shown for parts in the illustrations in this FAI document may not be the correct numbers for your specific machine model. See the Consolidated Pick List to confirm your part numbers.

2.1.2 Using the Consolidated Pick List

Use the Consolidated Pick List to confirm the Item Number of parts you are assembling when you need to do so.

Small parts are packaged in bags or boxes. The packaging is labeled with a Point of Use number.

The Consolidated Pick List includes the Point of Use number and Item Number for each part. It also includes “Parent” information describing where the part is used in assembly.

These assembly instructions include the Point of Use information for parts you are assembling so you can find the correct bag or box of parts.

When you need to identify a specific part which is included in that bag or box of parts, see the Parent Description for that part in the Consolidated Pick List.

2.1 Assemble the Chisel Plow

- Use a safe lifting device to position the main frame on support stands.

Use at least X support stands with at least X lb. capacity to support the frame at least X feet off the floor for assembly.

- Follow the Install Wing Fold Assembly instructions.

Find parts in packaging labeled B40, C40, C40B, C40J.

- Follow the Install Axle Assemblies instructions for main frame installation.

Find parts in packaging labeled C40, C40A, C40F, C40K.

- Follow the Install Wheels on Axle Assemblies instructions for main frame installation.

Find parts in packaging labeled L40.

- Follow the Install Single Point Depth Control instructions.

Find parts in packaging labeled C40, C40B, C40P.

- Follow the Install Wings instructions.

Find parts in packaging labeled C40B.

- Follow the Install Wheel Wells instructions.

Find parts in packaging labeled B40, C40F.

- Follow the Install Axle Assemblies instructions for Outer Wing and Wheel Well installation.

- Follow the Install Wheels on Axle Assemblies instructions for the remaining wheels.

- Follow the Install Main Wing Fold Mast instructions.

Find parts in packaging labeled C40, C40B.

- Follow the Install Outer Wing Fold Assemblies instructions.

Find parts in packaging labeled C40, C40B.

- Follow the Install Shank Stub Kits instructions.

Find parts in packaging labeled C40, C40I.

- Follow the Install Shank Assemblies instructions.

Find parts in packaging labeled C40, C40N.

- Follow the Install Mast Tubes instructions.

Find parts in packaging labeled B40, C40, C40D.

- Follow the Install Caster Wheel Assemblies instructions.

Find parts in packaging labeled B40, C40, C40B, C40D, C40G.

- Follow the Install Front Hitch instructions.

Find parts in packaging labeled C40, C40H, C40M, C40U.

- Follow the Install Weight Balance Kit instructions.

Find parts in packaging labeled C40, C40A, C40W.

- Follow the Install Hydraulic Hoses instructions.

- Follow the Install Rear Hitch instructions.

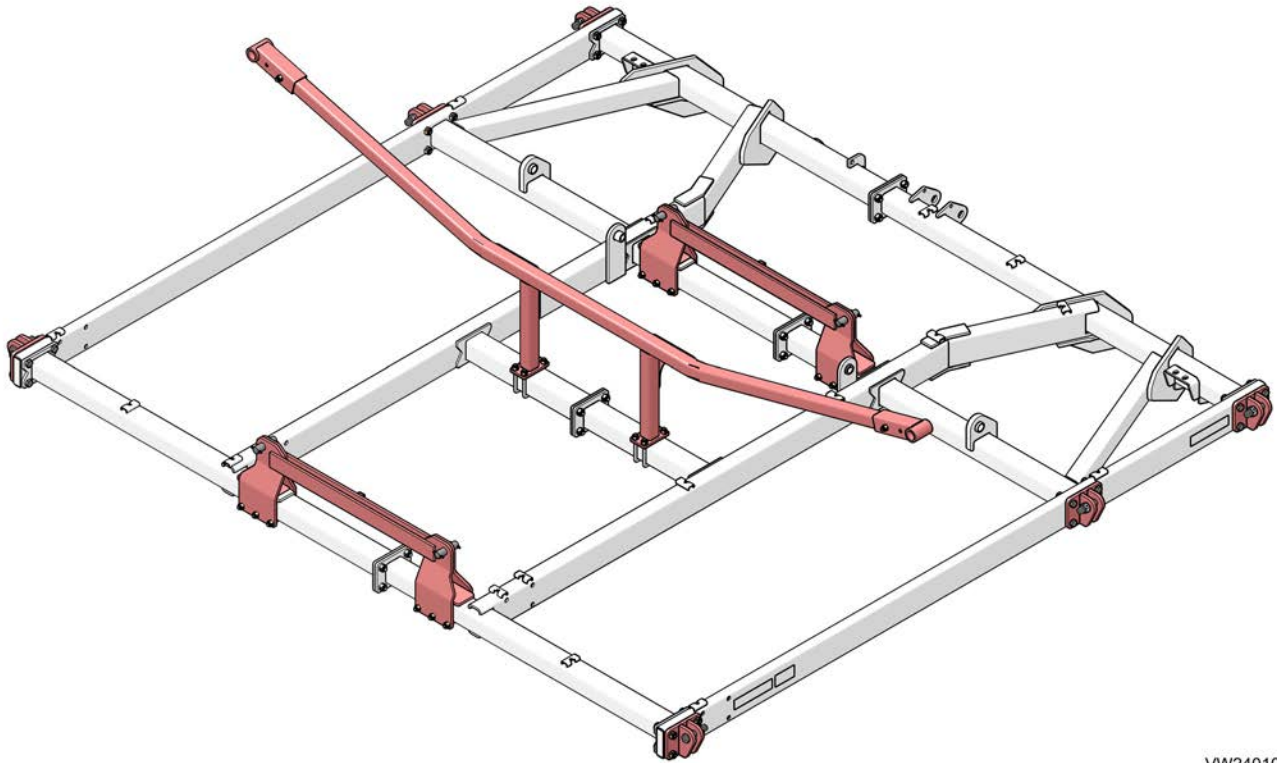
Find parts in packaging labeled C40, C40R.

- Follow the Install Lighting Kit instructions.

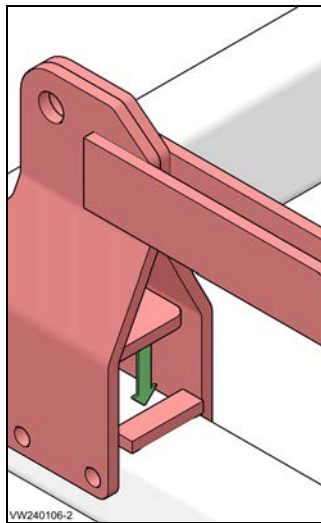
- Follow the Install Spare Tire Kit instructions.

Find parts in packaging labeled C40, C40X.

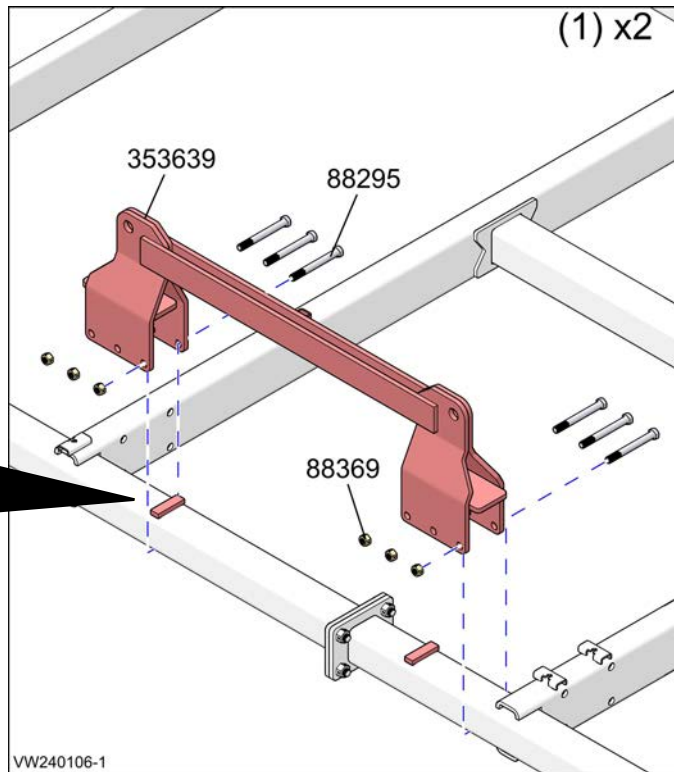
Install Wing Fold Assembly (Chisel Plow)



VW240106

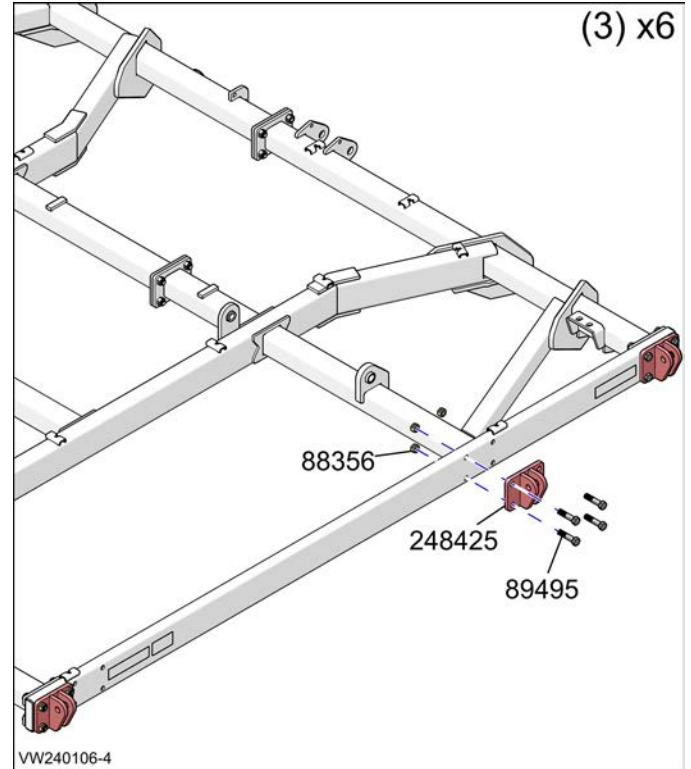
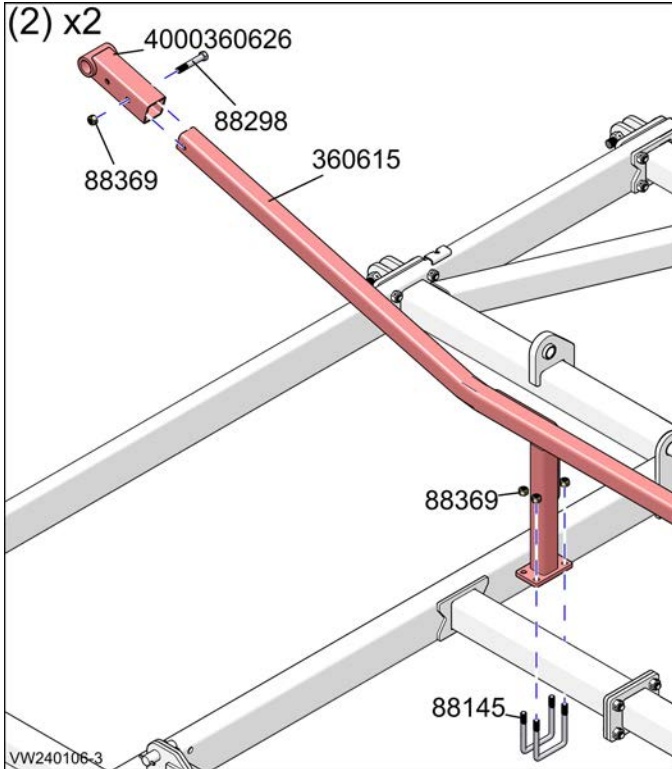


VW240106-2



VW240106-1

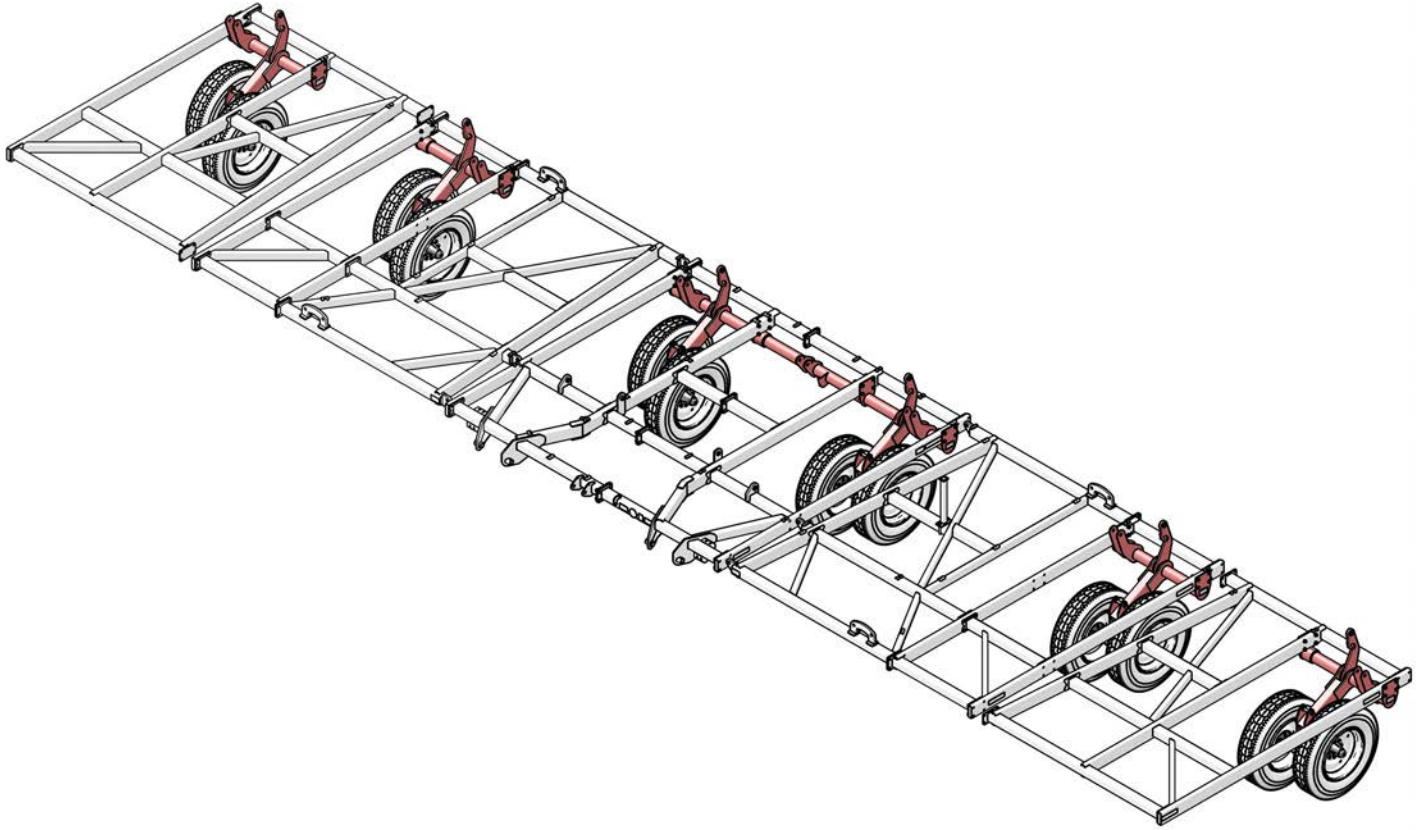
Install Wing Fold Assembly (Chisel Plow)



Install Wing Fold Assembly (Chisel Plow)

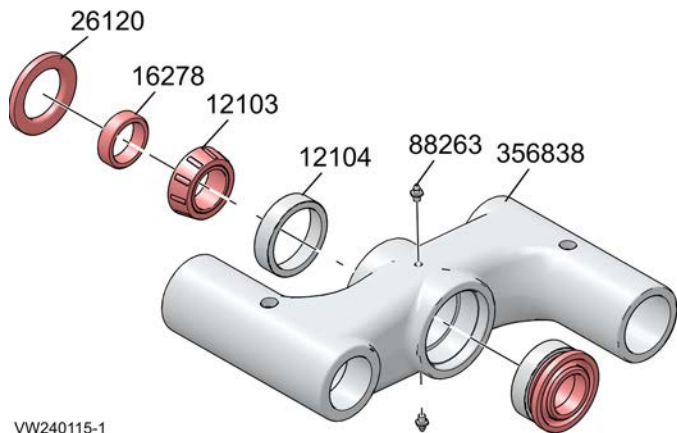
1. Install the main frame wing cylinder anchor against the stops as shown with six bolts and nuts.
2. Install the wing rest weldment at the center of the main frame with four u-bolts and eight nuts. Install the wing rest extension weldment on the end of the wing rest with one bolt and nut.
3. Install the inner hinge on the main frame with four bolts and nuts.

Install Axle Assemblies (Chisel Plow)



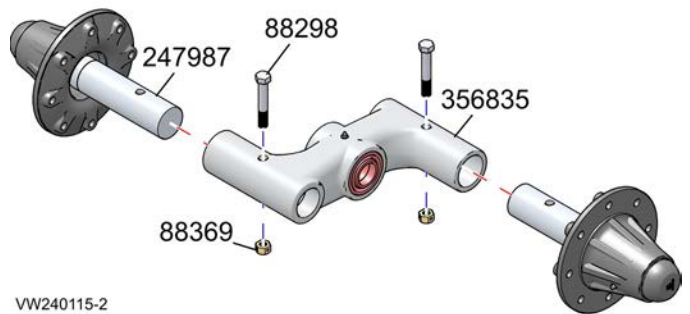
VW240115 Install Axle Assys

(1) x6



VW240115-1

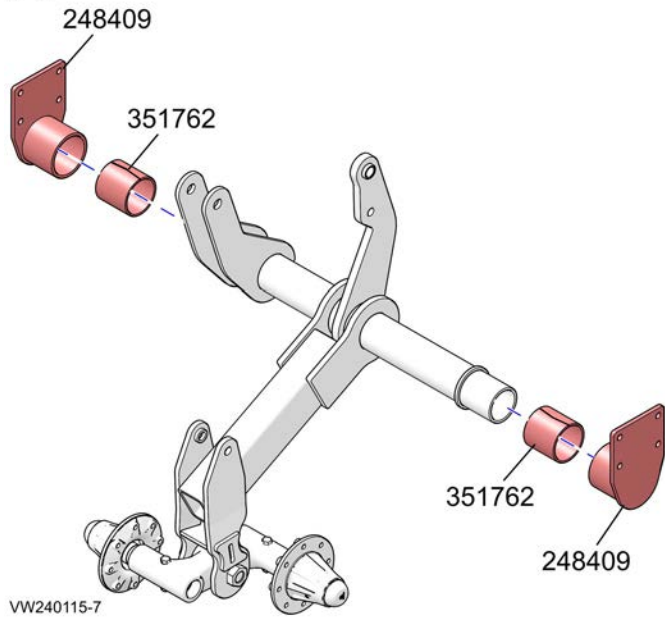
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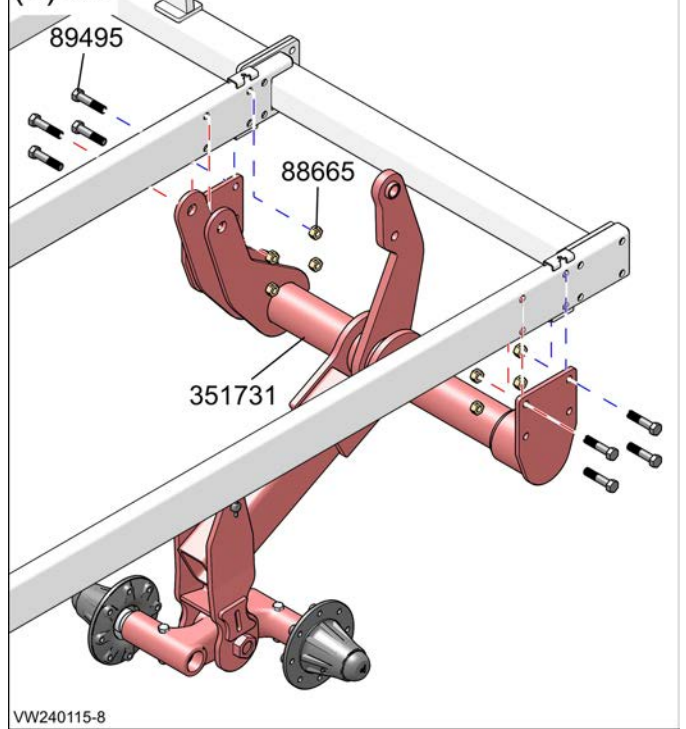
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Install Axle Assemblies (Chisel Plow)

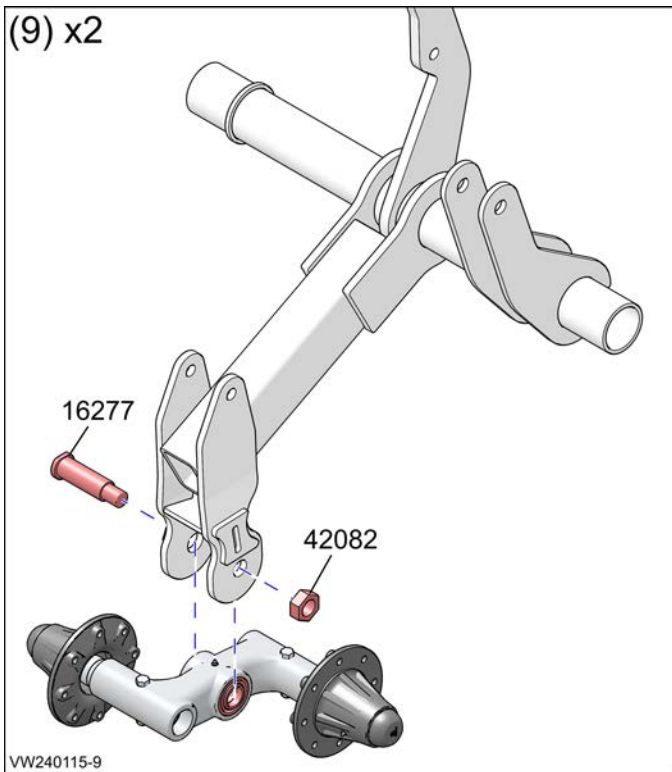
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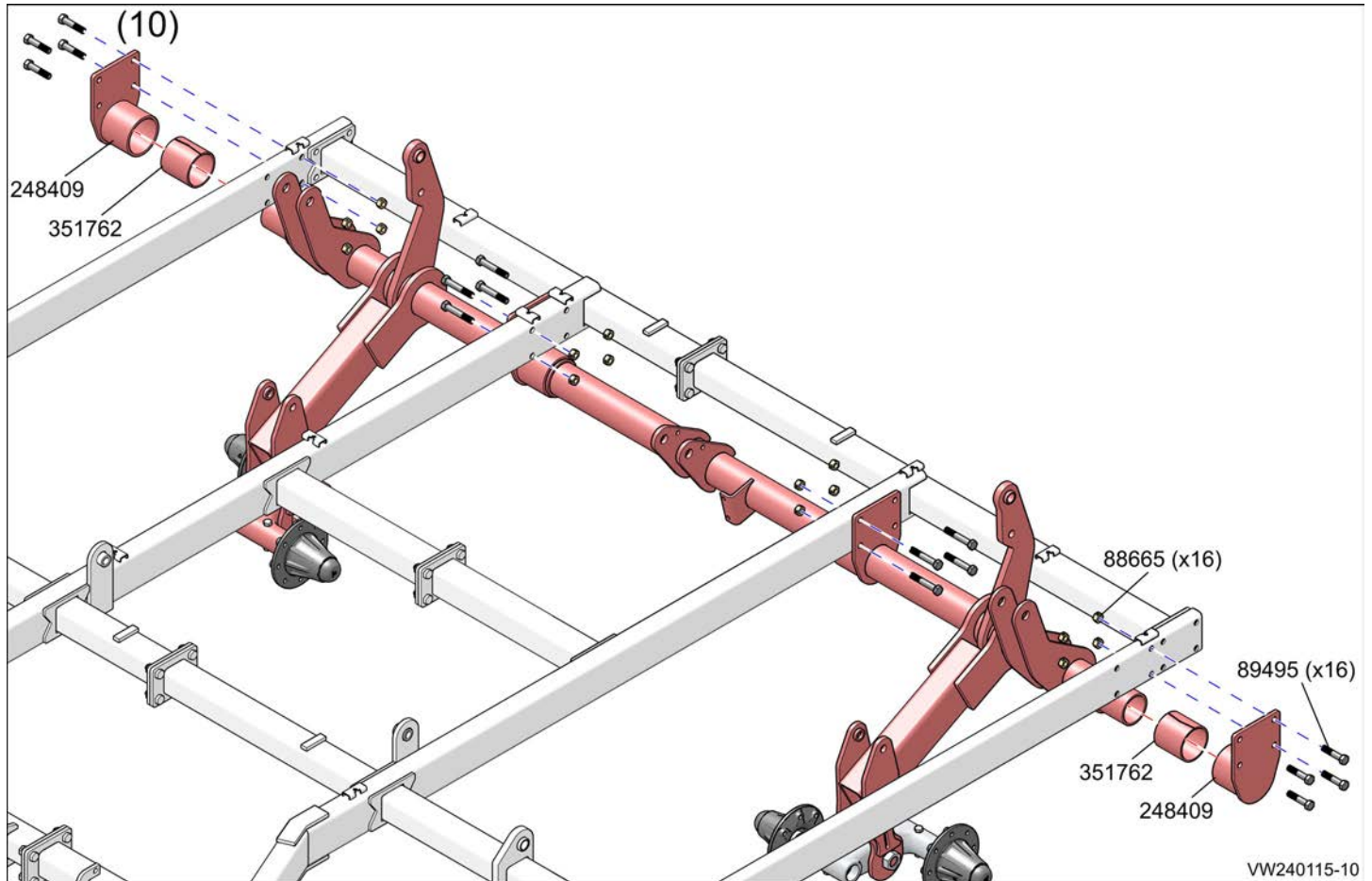
(8) x2



(9) x2



Install Axle Assemblies (Chisel Plow)



Install Axle Assemblies (Chisel Plow)

1. Assemble the walker short assembly.
2. Install the two hub and spindle assemblies on the walker short assembly with two bolts and nuts.

Outer Wing Installation

3. Attach the assemblies to the wing axle with one tandem shaft and nut.
4. Install the weld bearing and composite bearing bushing on both ends of the wing axle.
5. Install the wing axle on the outer wing with eight bolts and nuts.

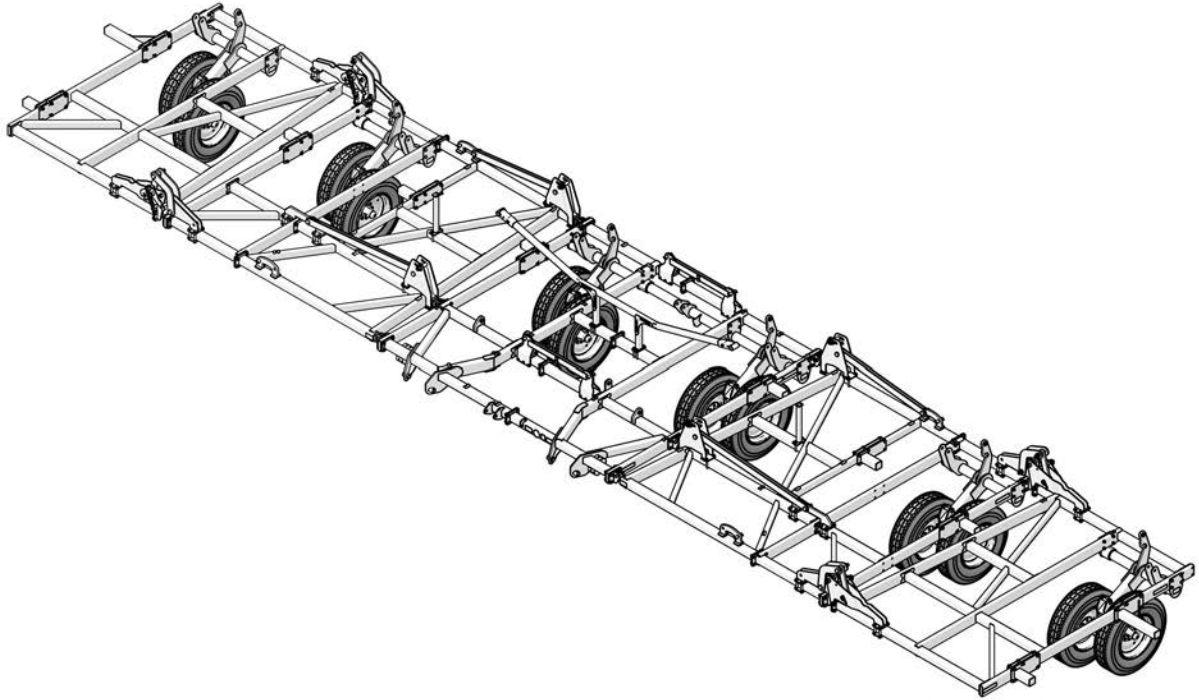
Wheel Well Installation

6. Attach the assemblies to the wing axle with one tandem shaft and nut.
7. Install the weld bearing and composite bearing bushing on both ends of the wing axle.
8. Install the wing axle on the wheel well with eight bolts and nuts.

Main Frame Installation

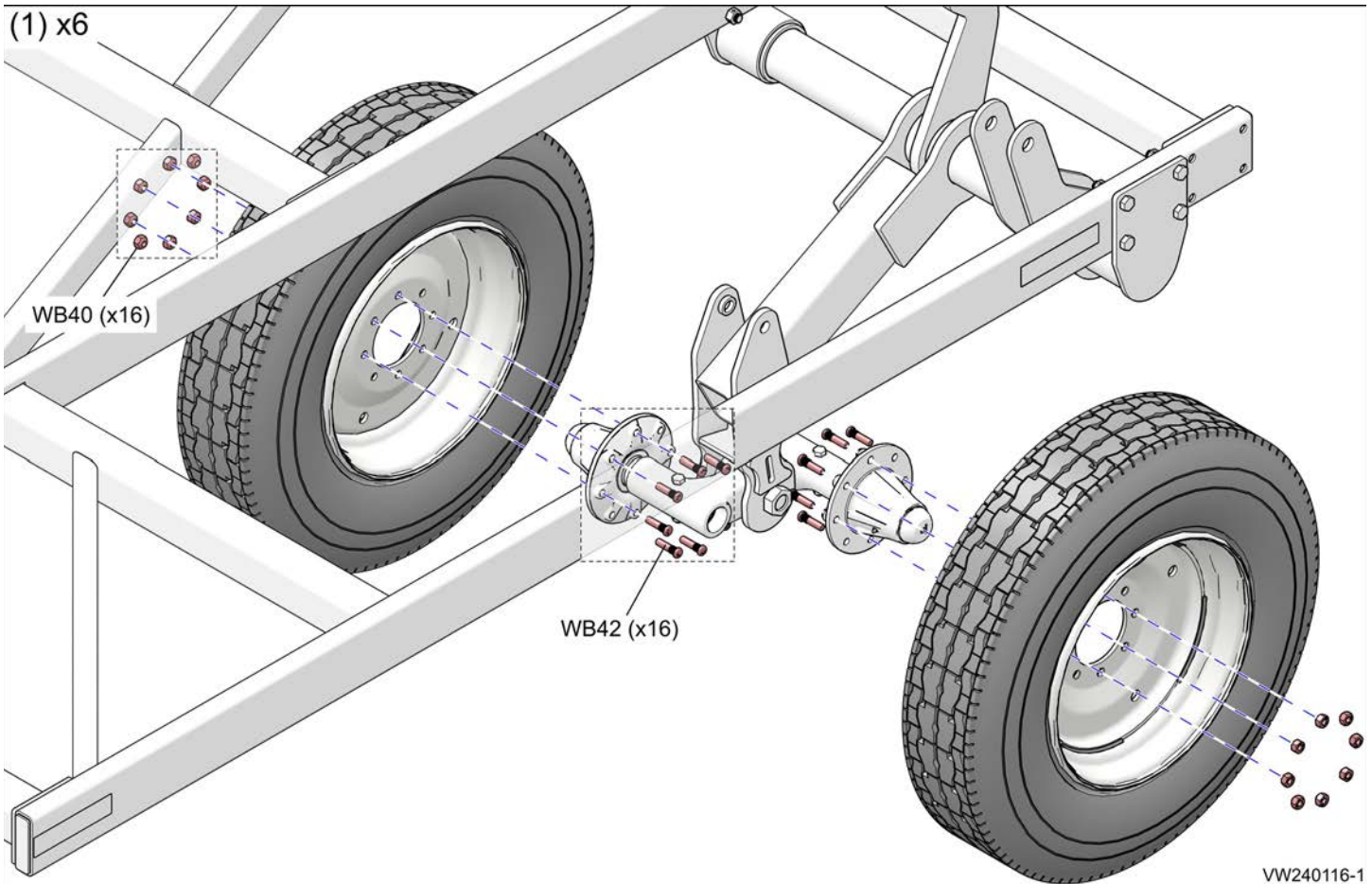
9. Attach the assemblies to the main frame axle with one tandem shaft and nut.
10. Install the main frame axle on the main frame with two weld bearings and composite bearings, and sixteen bolts and nuts.

Install Wheels on Axle Assemblies (Chisel Plow)



VW240116 Install Wheels on Axle Assys

(1) x6

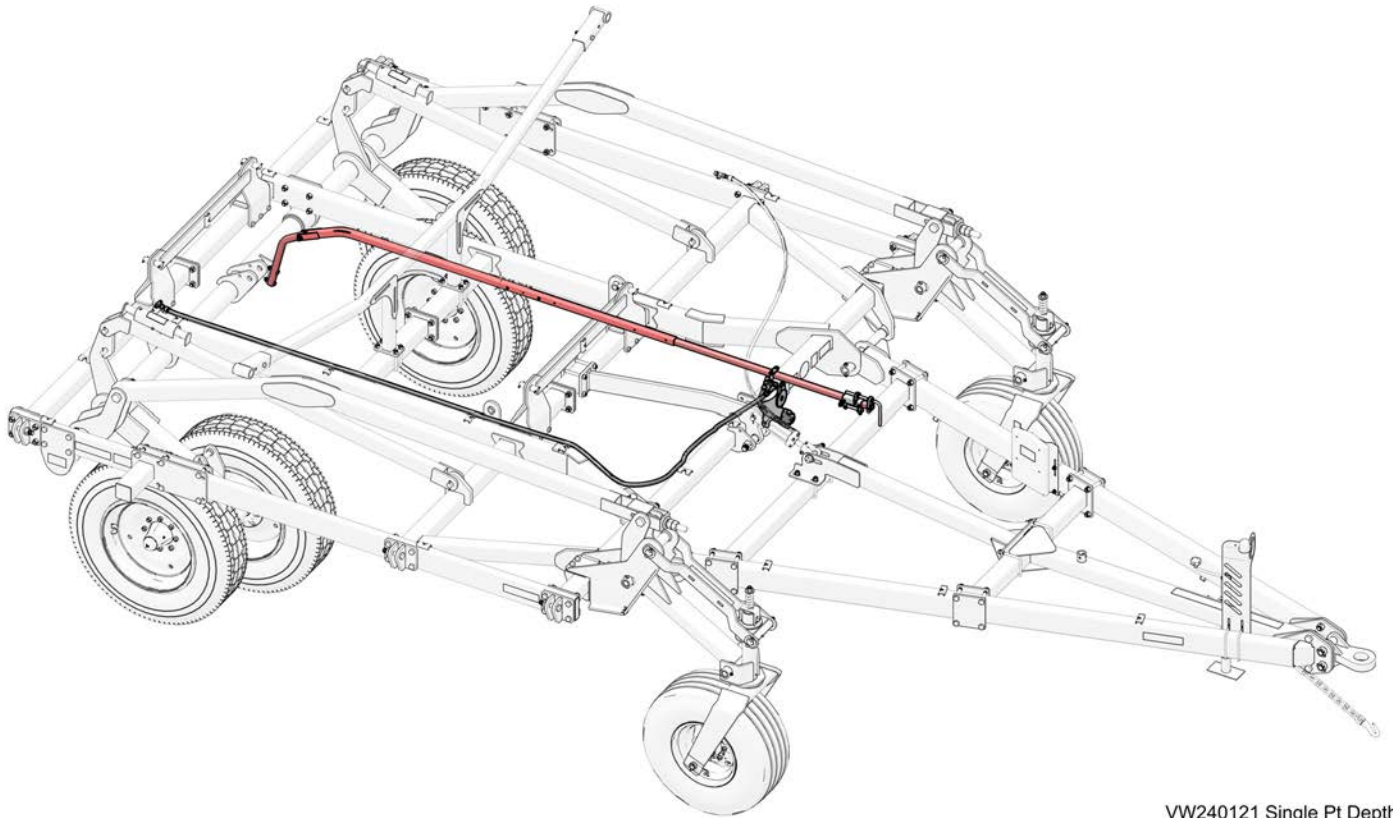


VW240116-1

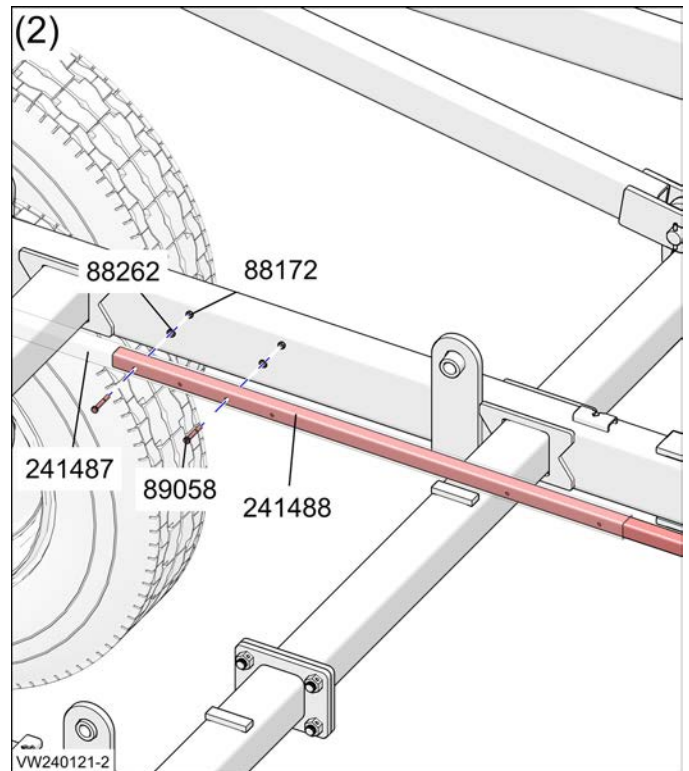
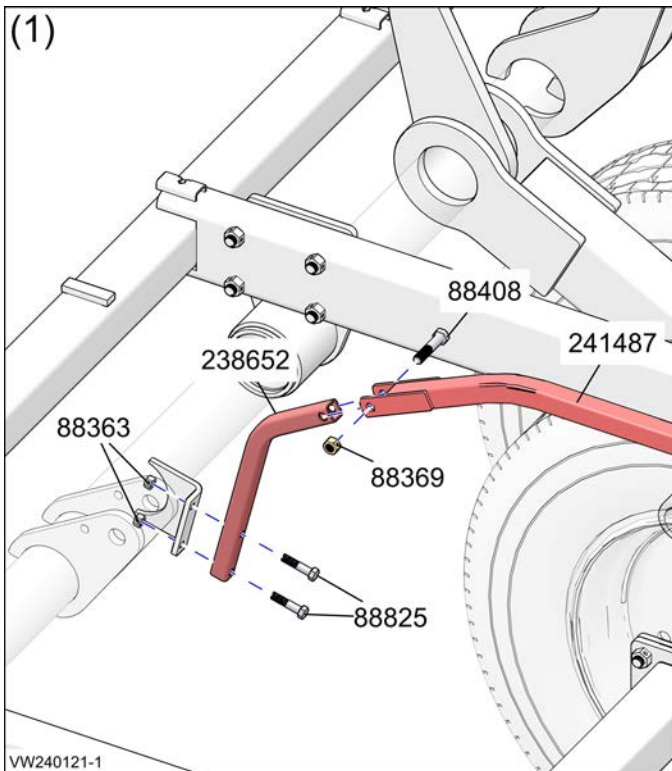
Install Wheels on Axle Assemblies (Chisel Plow)

1. Install the wheel assemblies on the hub and spindle assemblies with 16 bolts and nuts.

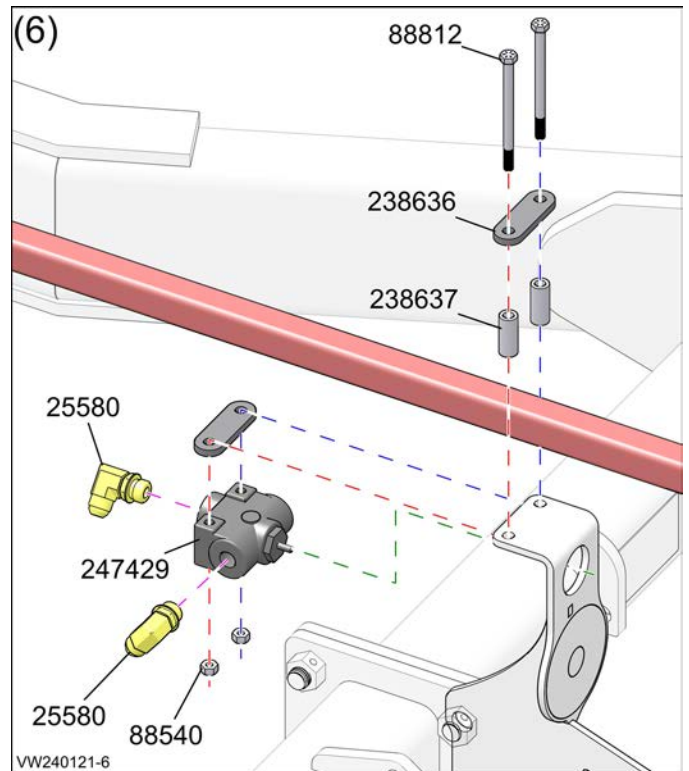
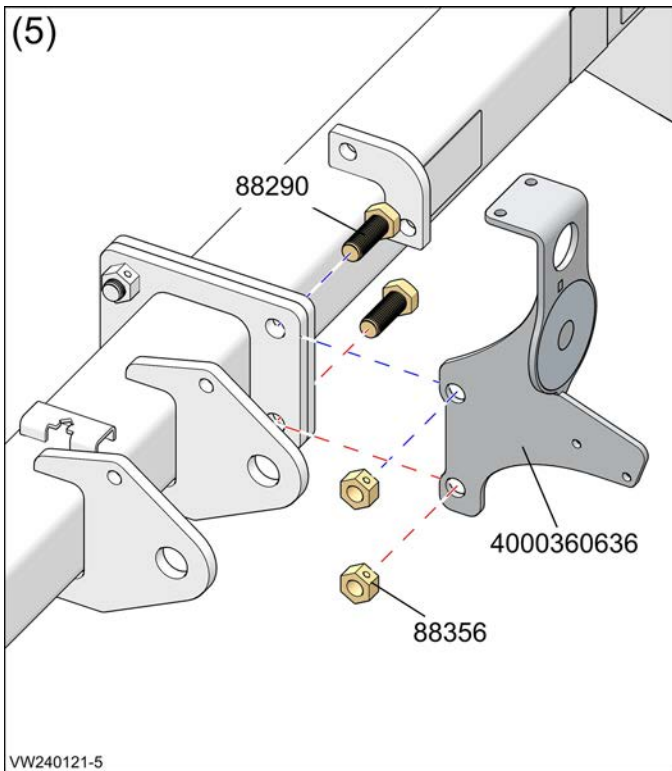
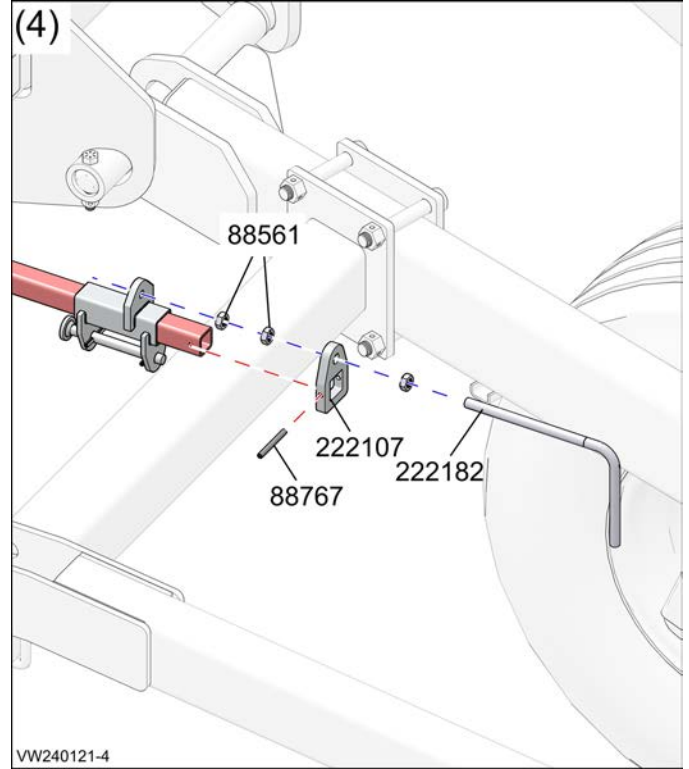
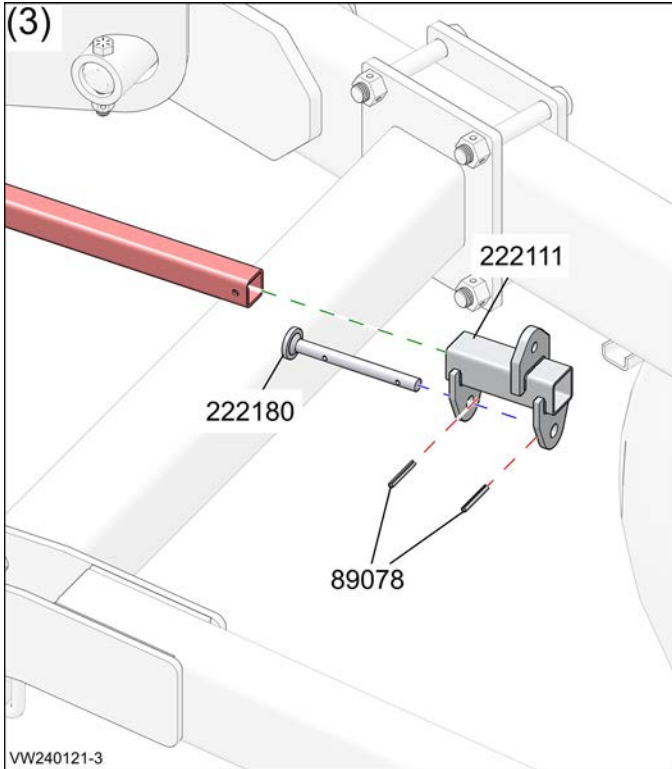
Install Single Point Depth Control (Chisel Plow)



VW240121 Single Pt Depth



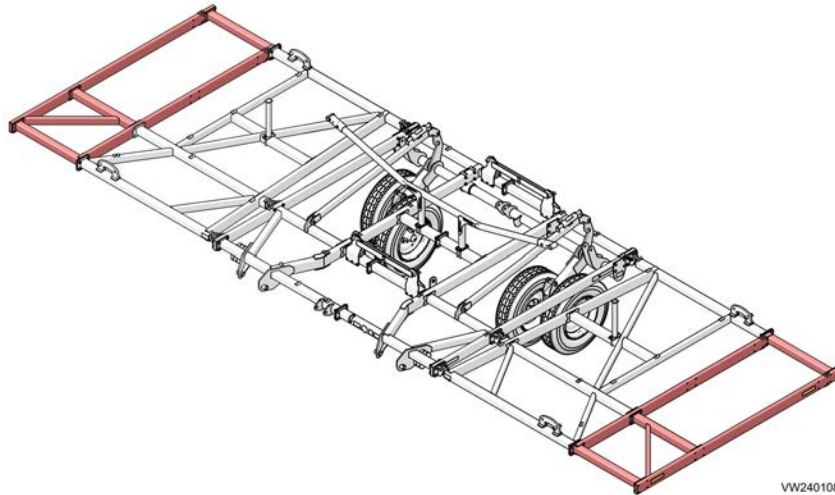
Install Single Point Depth Control (Chisel Flow)



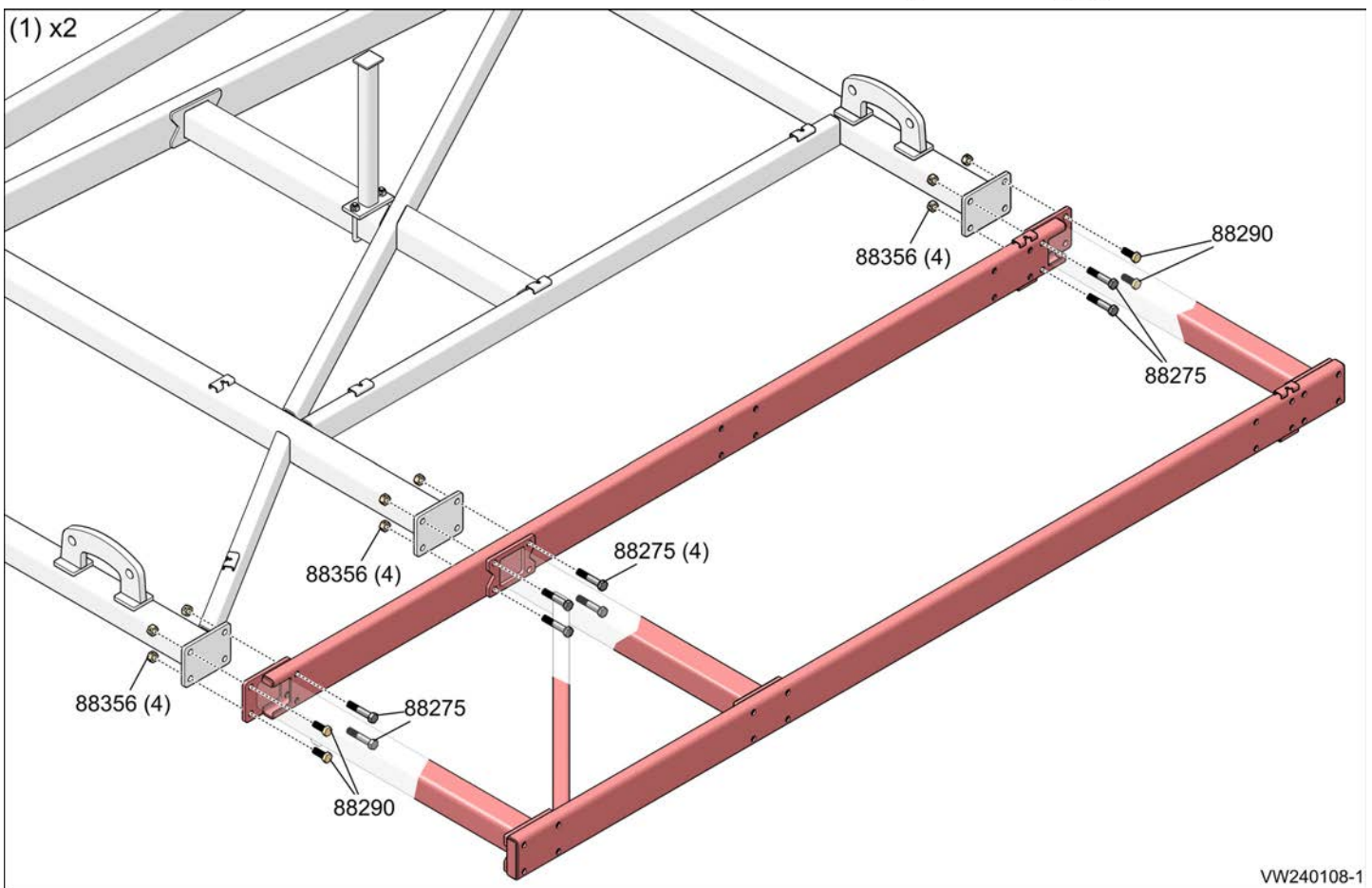
Install Single Point Depth Control (Chisel Plow)

1. Install the single point tube on the single point ear of the main frame axle with two bolts and nuts.
Attach the single point bent tube weldment to the single point tube with one bolt and nut.
2. Insert the inner tube into the single point tube and attach it with two bolts, washers and nuts.
3. Attach the 5.5 inch pin to the SPDC slide adjustment with two roll pins.
Install the slide adjustment onto the end of the single point inner tube behind the tube holes.
4. Install the SPDC adjustment ear plate on the inner tube with one roll pin.
Install the SPDC adjustment crank rod with three nuts on to the slide adjustment and ear plate.
5. Attach the depth valve mount to the main frame with two bolts and nuts.
6. Position the single point inner tube for installation on top of the depth valve mount.
Install the two fittings on the DCV valve.
Position the valve with one SPDC valve spacer plate for installation inside the mount; and attach the tube and valve to the mount with two bolts, another spacer plate, and two SPDC valve spacer tubes and nuts.

Install Wheel Wells (Chisel Plow)



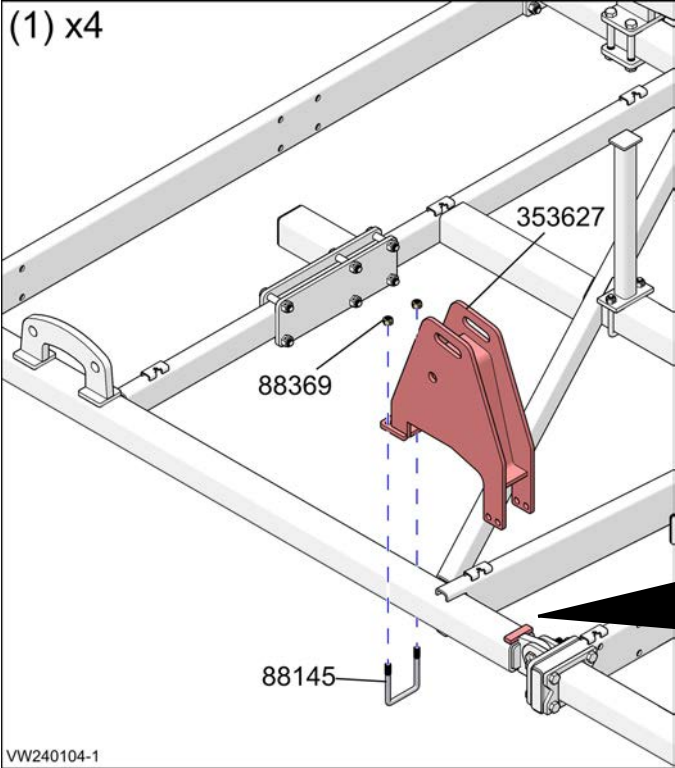
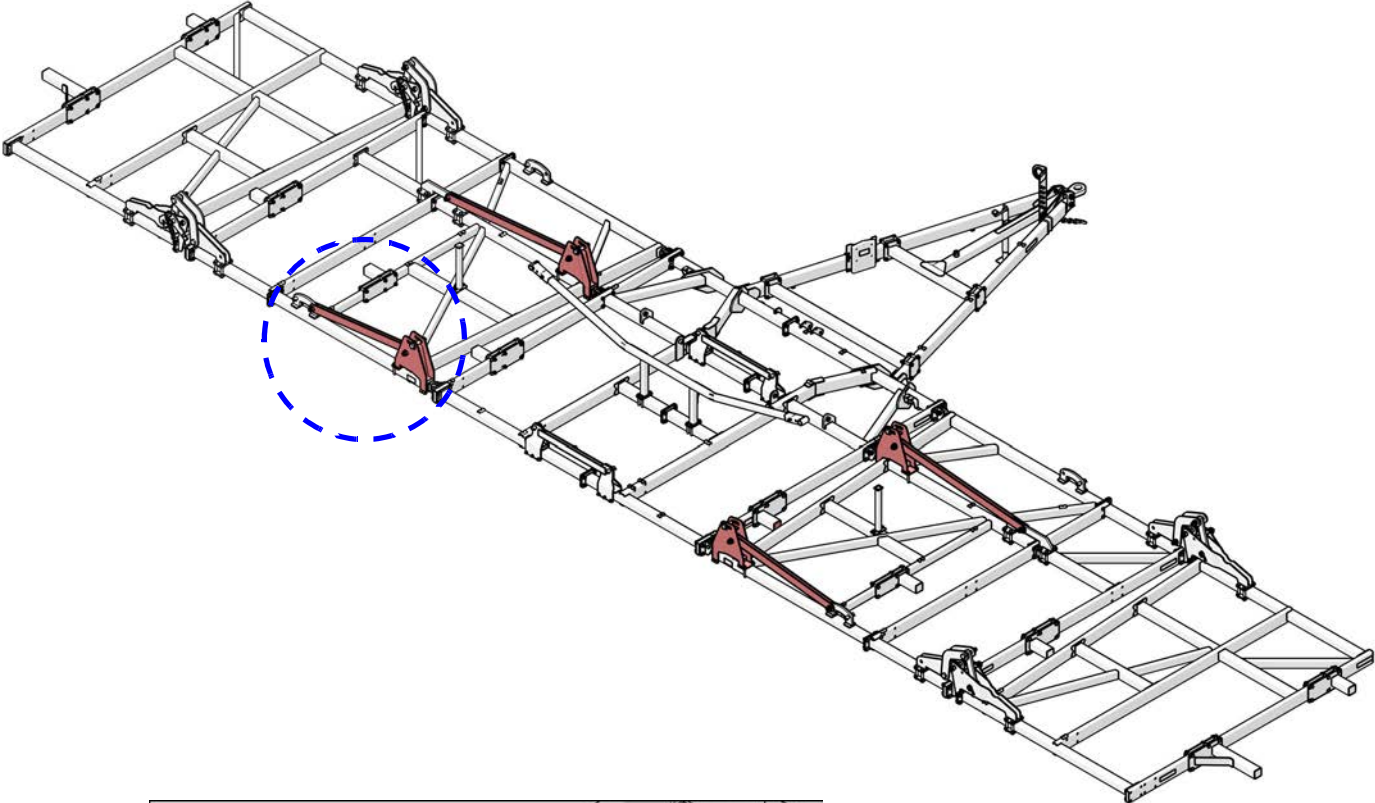
VW240108



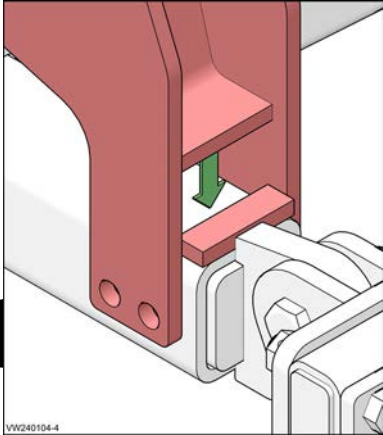
Install Wheel Wells (Chisel Plow)

1. Attach the wheel well to the wing with 12 bolts and nuts.

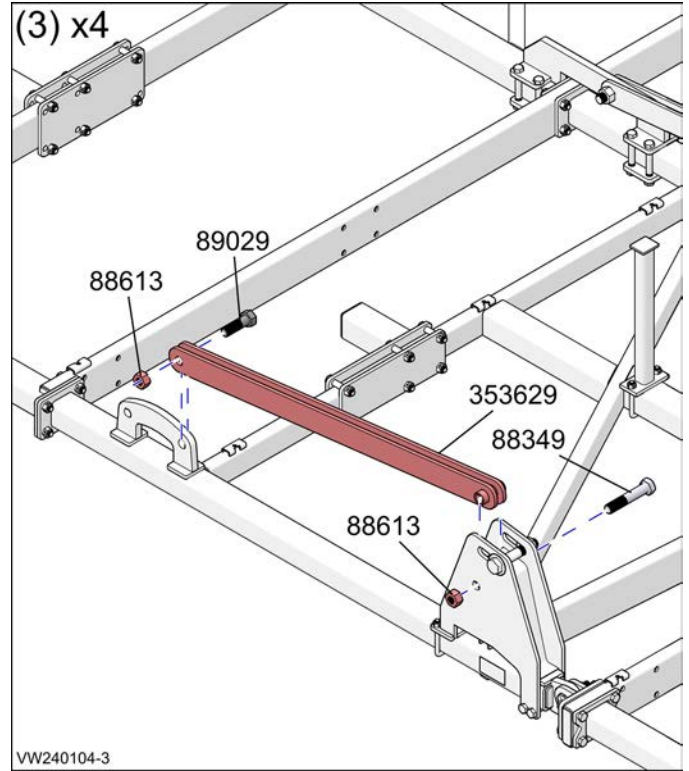
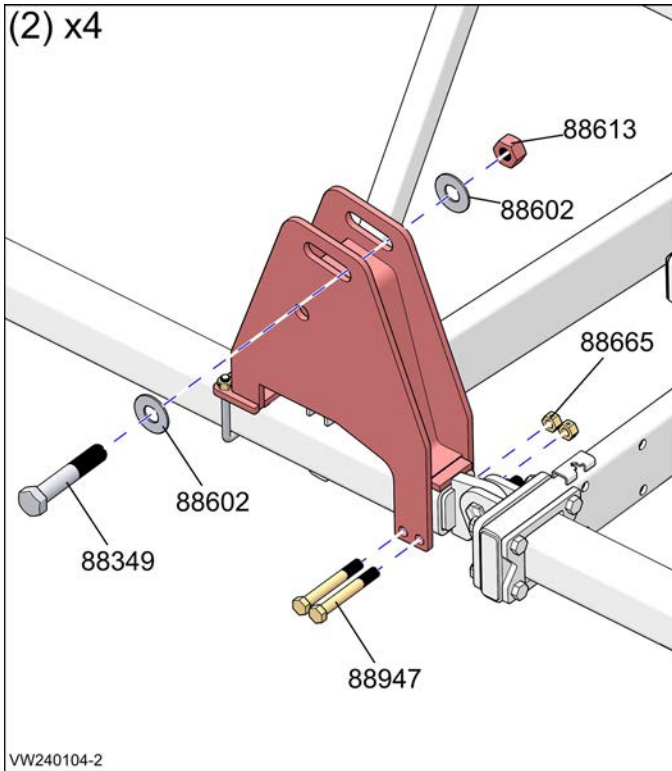
Install Main Wing Fold Mast (Chisel Plow)



VW240104



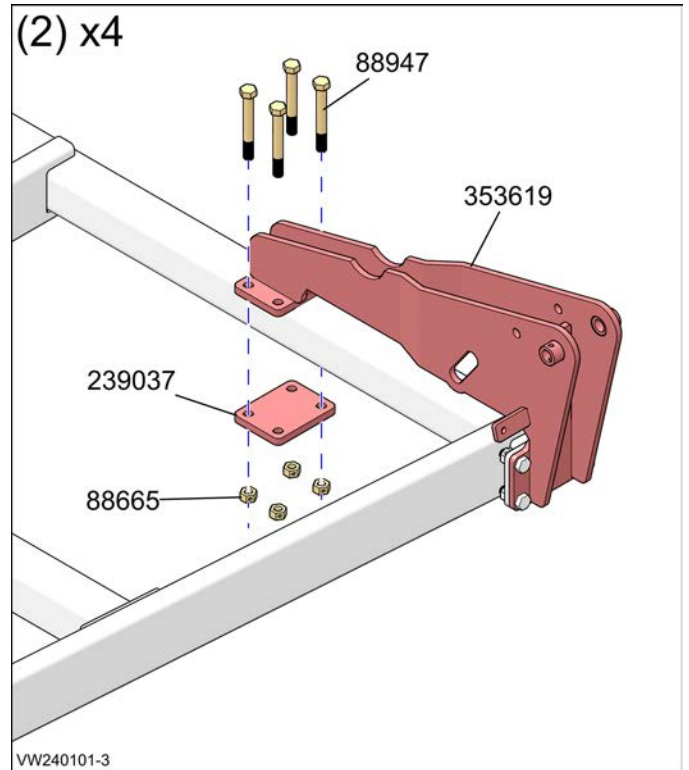
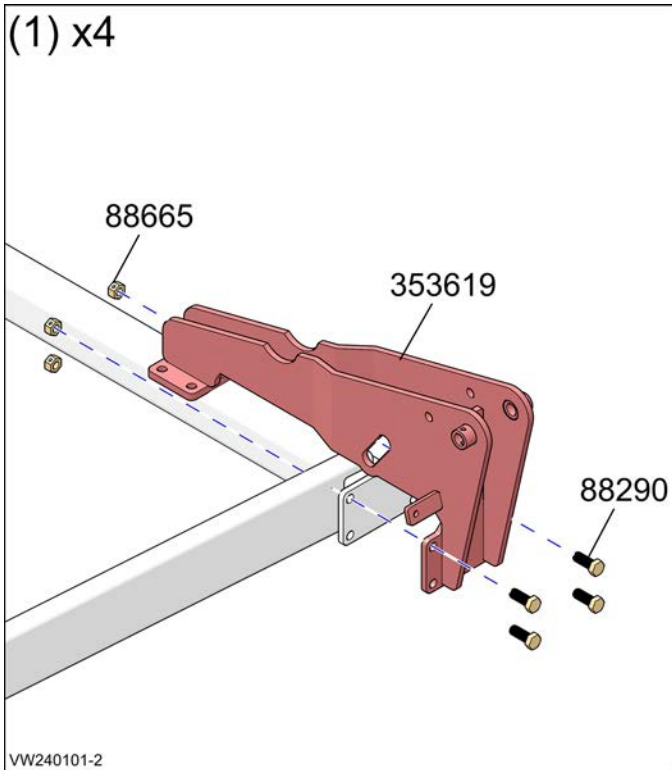
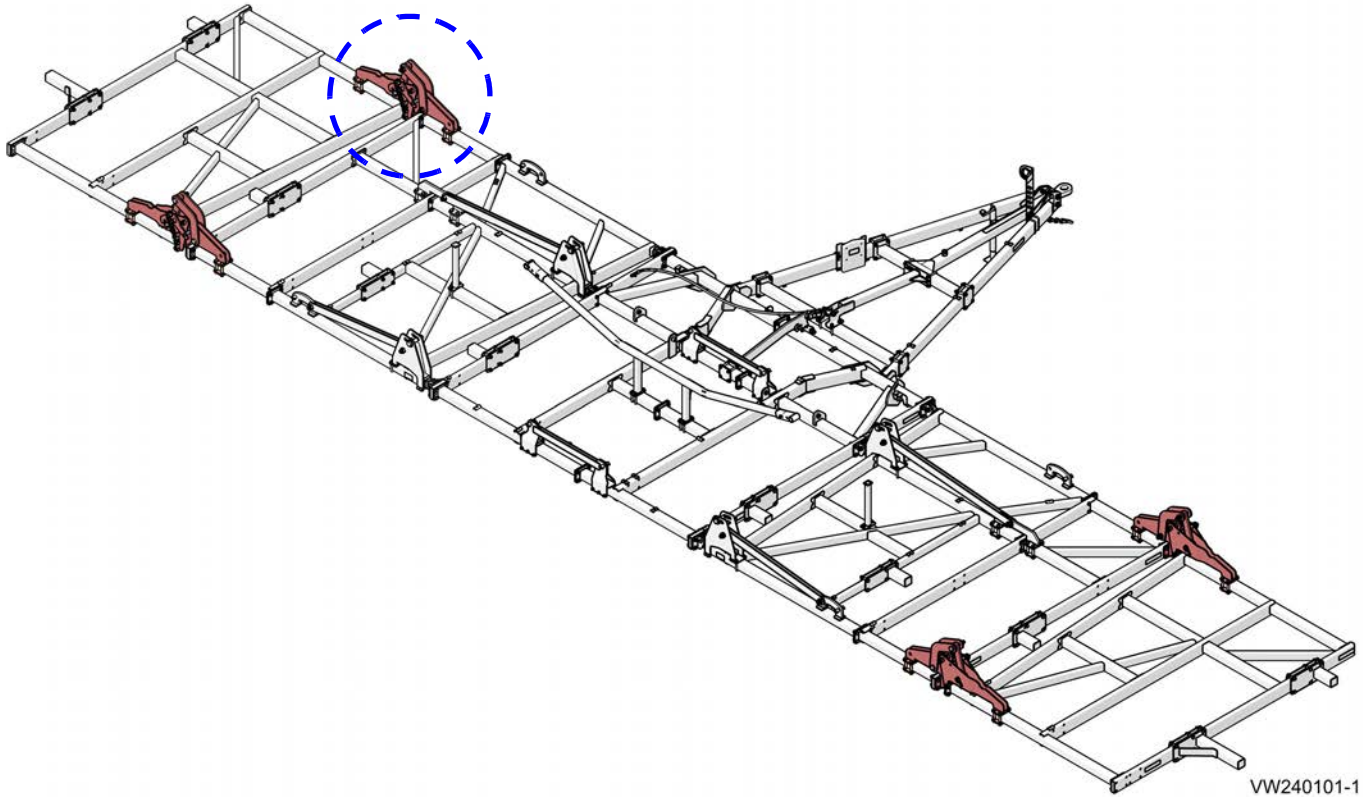
Install Main Wing Fold Mast (Chisel Plow)



Install Main Wing Fold Mast (Chisel Plow)

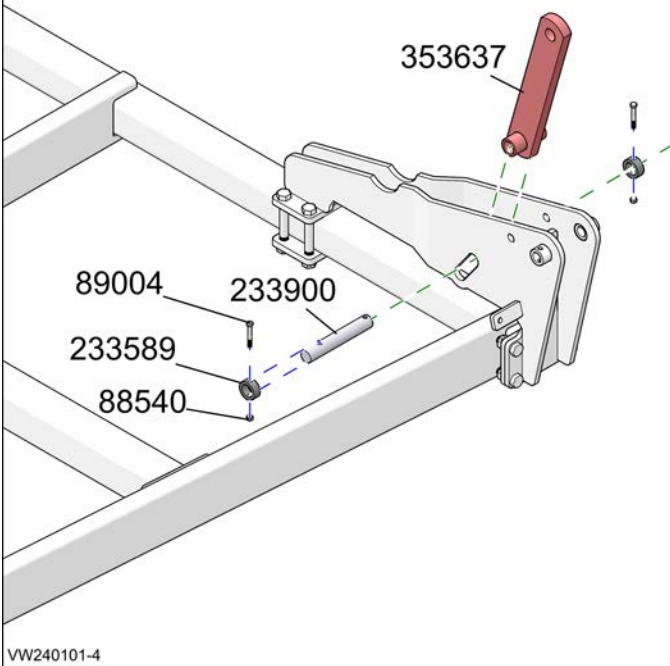
1. Install the main wing fold mast against the stop on the inner wing with one U-bolt and two nuts.
2. Install the main wing fold mast on the inner wing with two bolts and nuts.
Install the bolt with two washers and one nut in the slots in the main wing fold mast.
3. Install the short wing fold strap on the main wing fold mast with one bolt and nut.
Install the short wing fold strap on the anchor weld on the main wing fold mast with one bolt and nut.

Install Outer Wing Fold Assemblies (Chisel Plow)

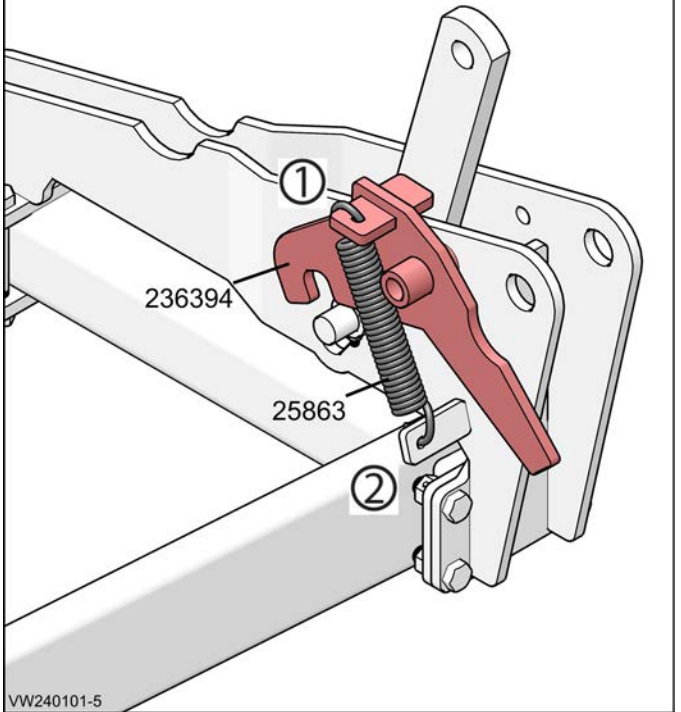


Install Outer Wing Fold Assemblies (Chisel Plow)

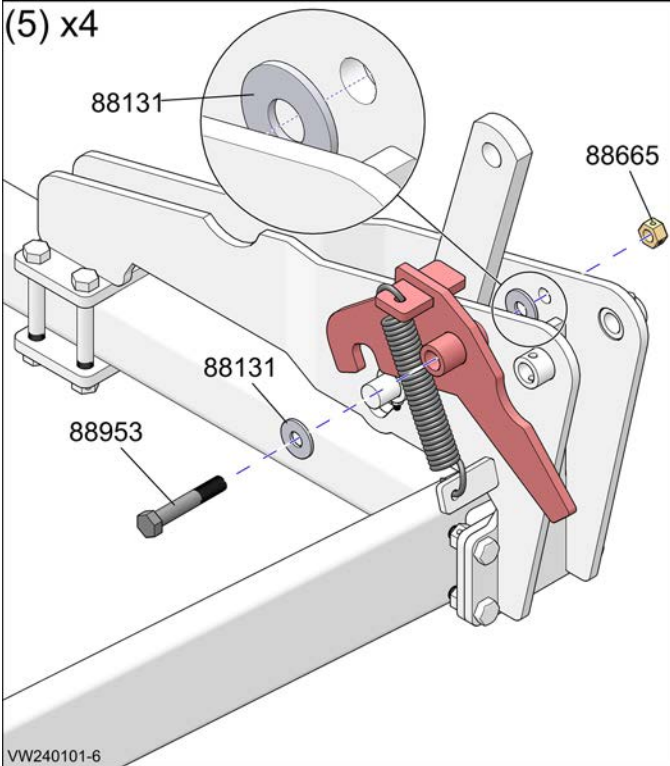
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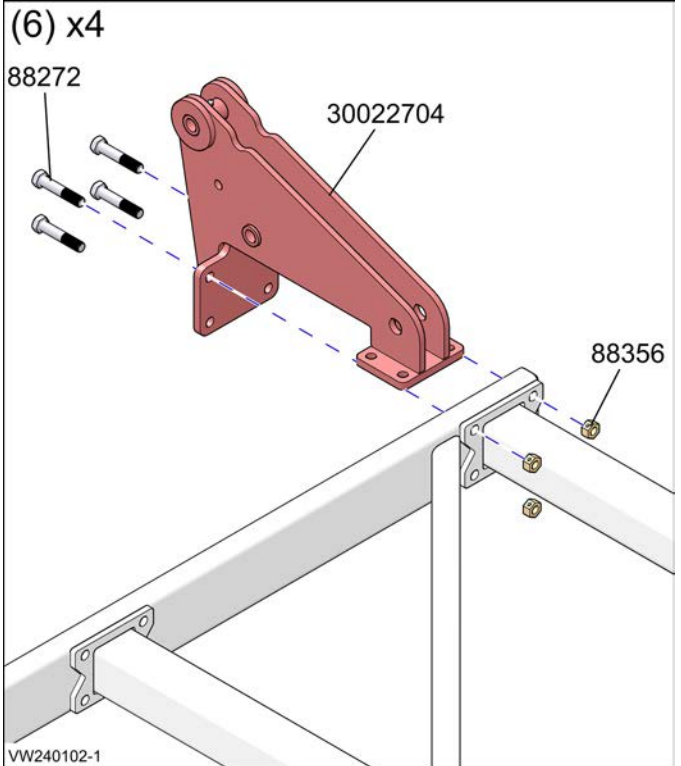
(4) x4



(5) x4

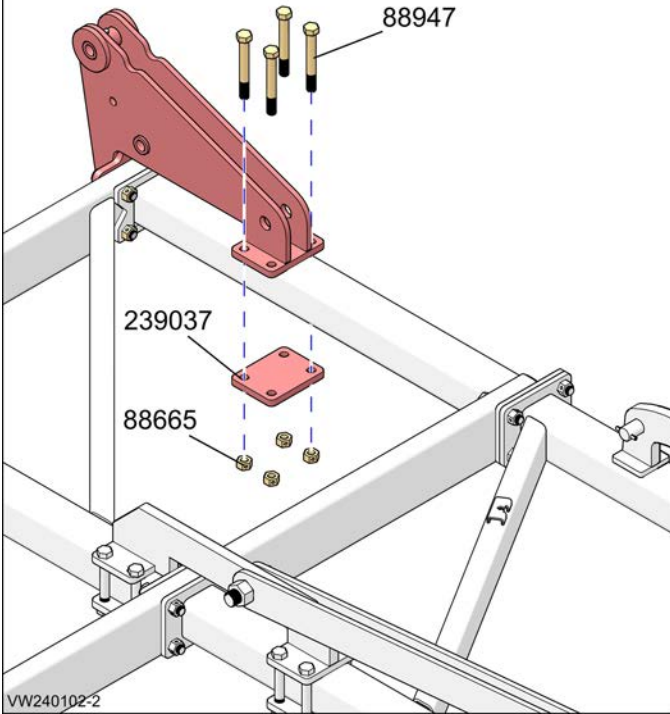


(6) x4

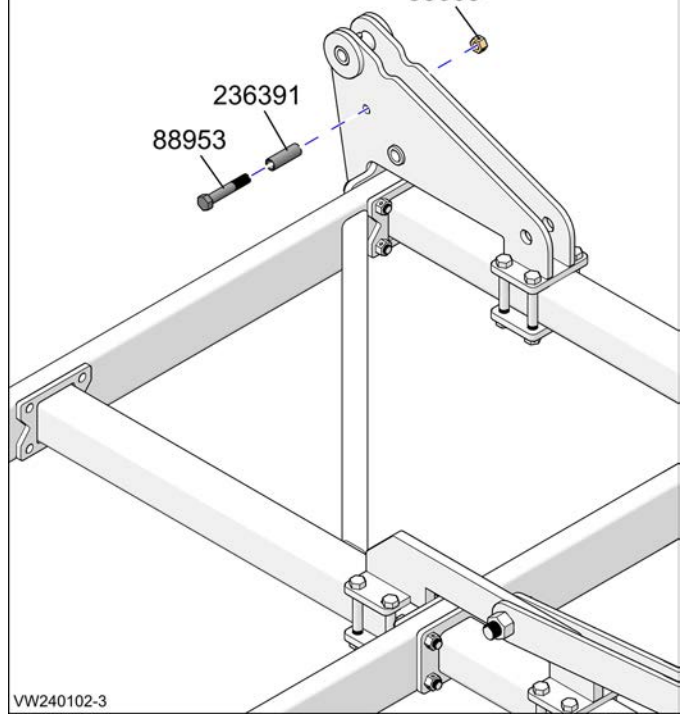


Install Outer Wing Fold Assemblies (Chisel Plow)

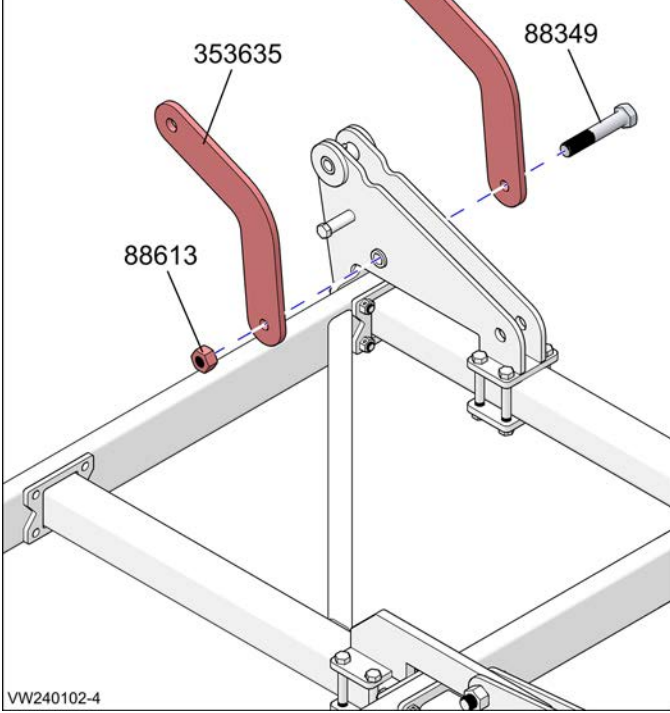
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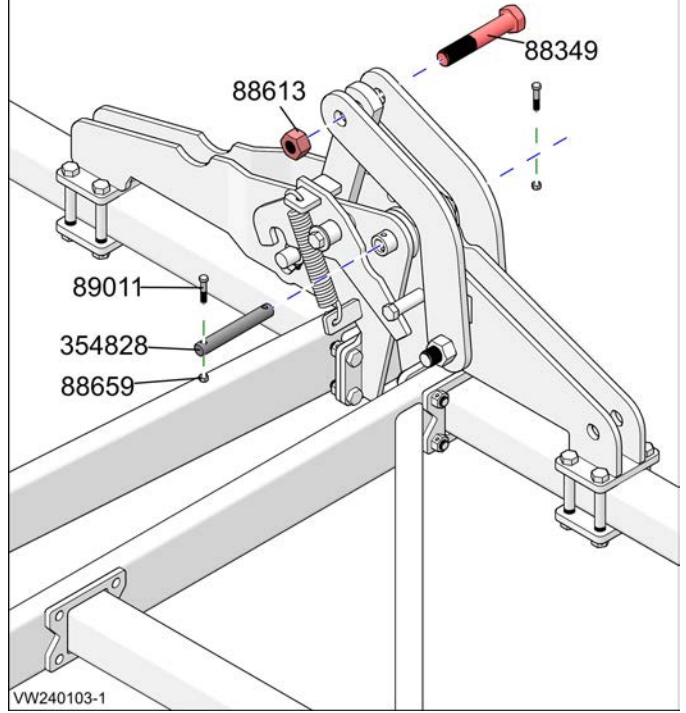
(8) x4



(9) x4



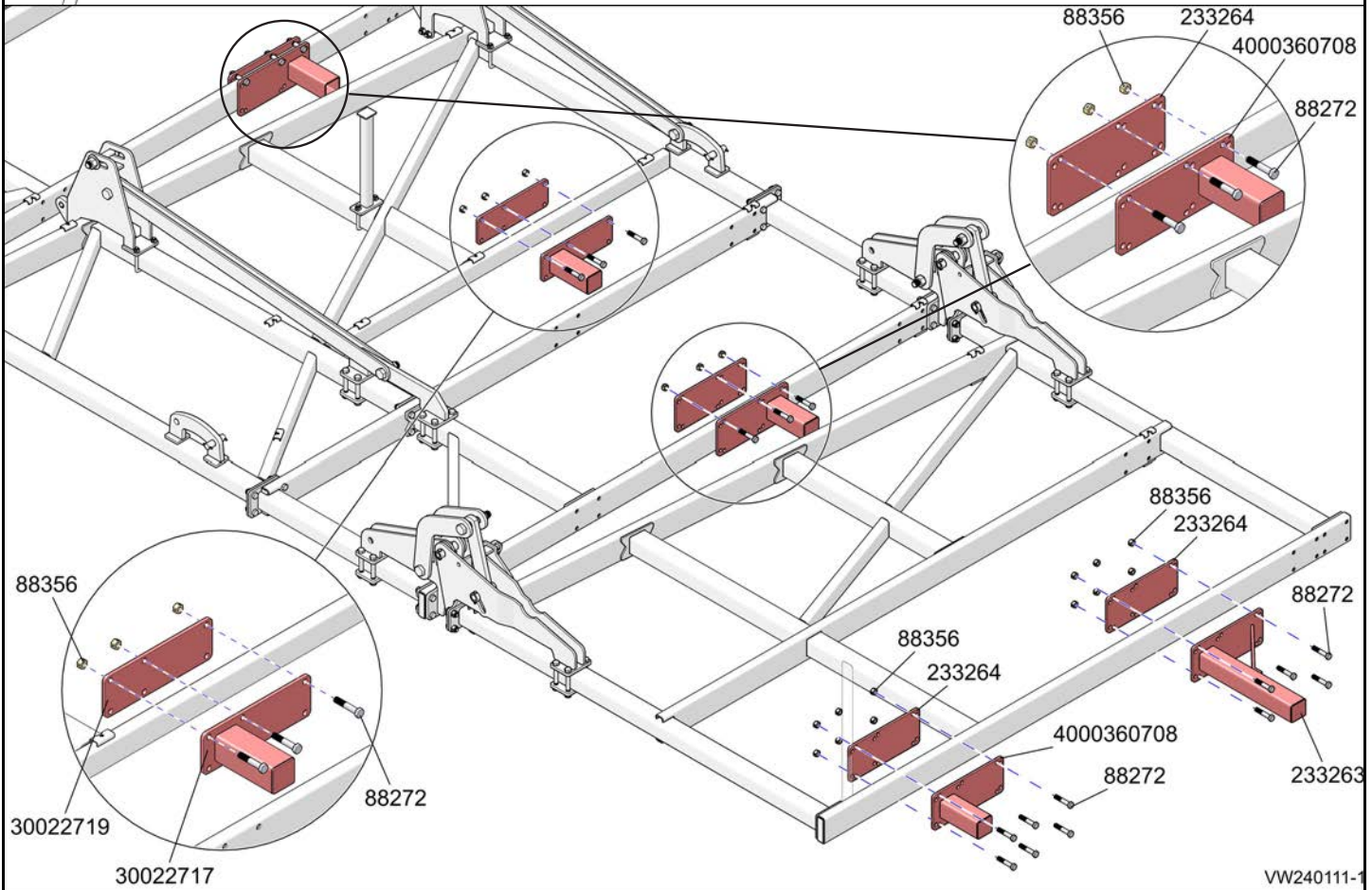
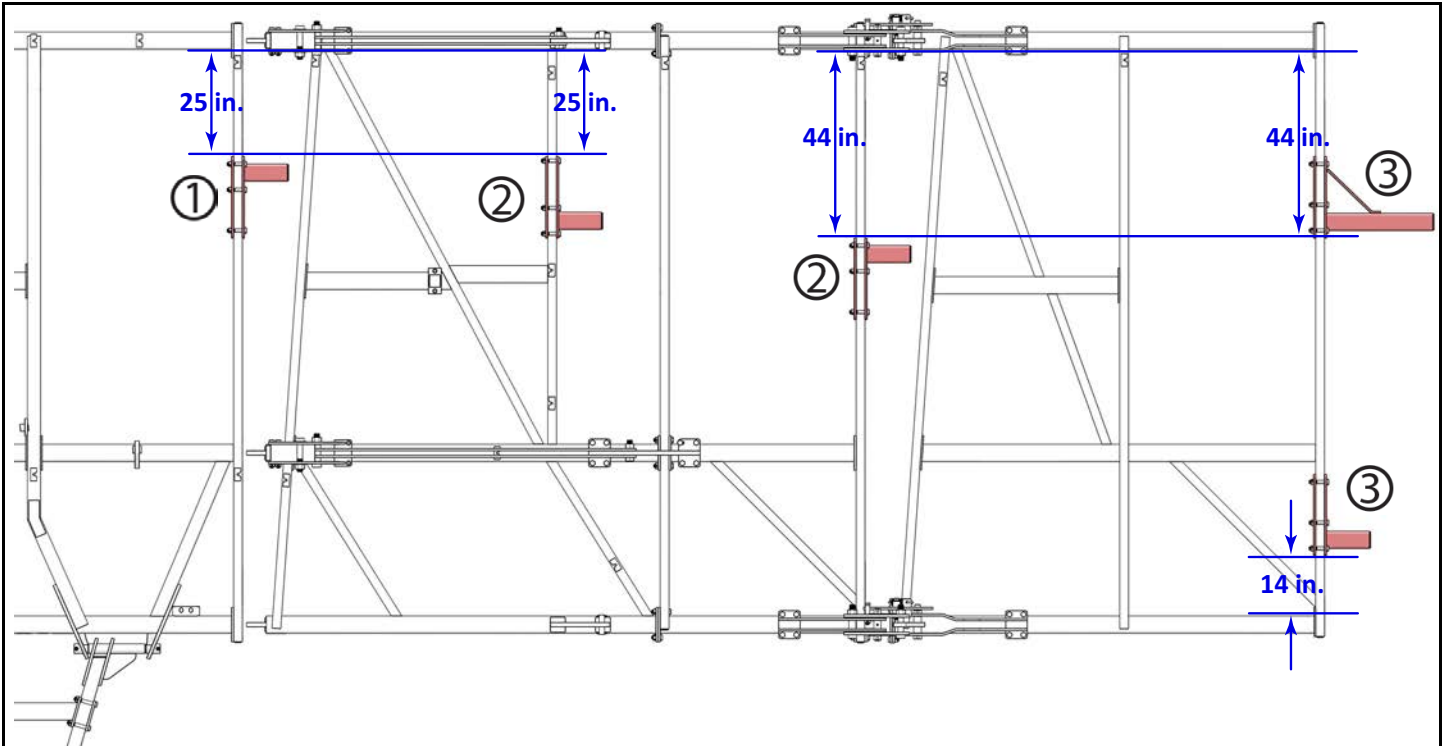
(10) x4



Install Outer Wing Fold Assemblies (Chisel Plow)

1. Install the outer wing hinge on the outer wing with four bolts and nuts.
2. Install the outer wing hinge on the outer wing with one hinge tie plate, and four bolts and nuts.
3. Install the outer wing link cylinder pin on the outer wing hinge with one pin, two bushing pins, and two bolts and nuts.
4. Attach the spring to the outer wing latch bracket (1) and the spring tab on the outer wing hinge (2).
5. Install the outer wing latch bracket on the outer wing hinge with one bolt, two washers and one nut.
6. Install the inner wing hinge on the wheel well with four bolts and nuts.
7. Install the inner wing hinge on the wheel well with one hinge tie plate, and four bolts and nuts.
8. Install the pivot tube on the inner wing hinge with one bolt and nut.
9. Install the two outer wing links on the inner wing hinge with one bolt and nut.
10. Attach the inner wing hinge to the outer wing hinge with one pin, and two bolts and nuts.
Attach the two outer wing links to the outer wing link cylinder pin with one bolt and nut.

Install Shank Stub Kits (Chisel Plow Main Frame, Wings and Outer Wings)



Install Shank Stub Kits (Chisel Plow)

Mark the frame at the distance shown to position the stub plate for installation.

(1) Main Frame Installation (x2)

1. Attach the stub plate to the stub with six bolts and nuts.

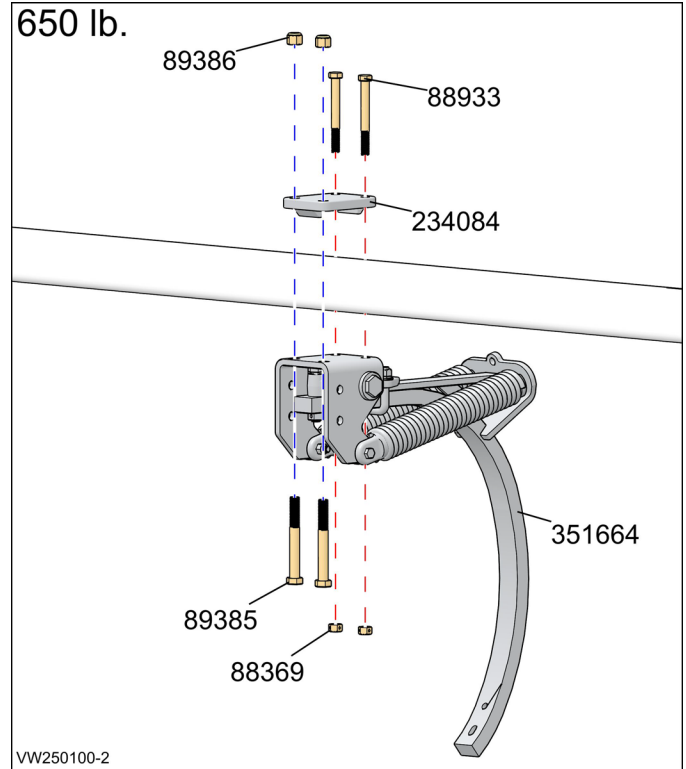
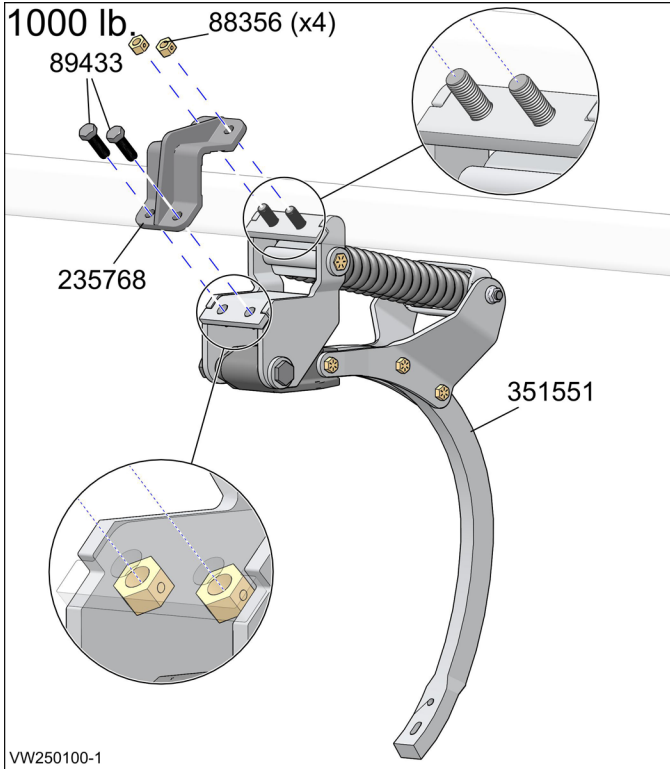
(2) Wings Installation (x2)

1. Attach the two stub plates to the two stubs with twelve bolts and nuts.

(3) Outer Wings Installation (x2)

1. Attach the two stub plates to the two stubs with twelve bolts and nuts.

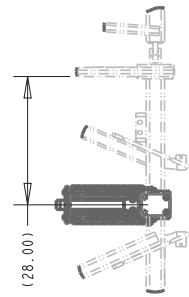
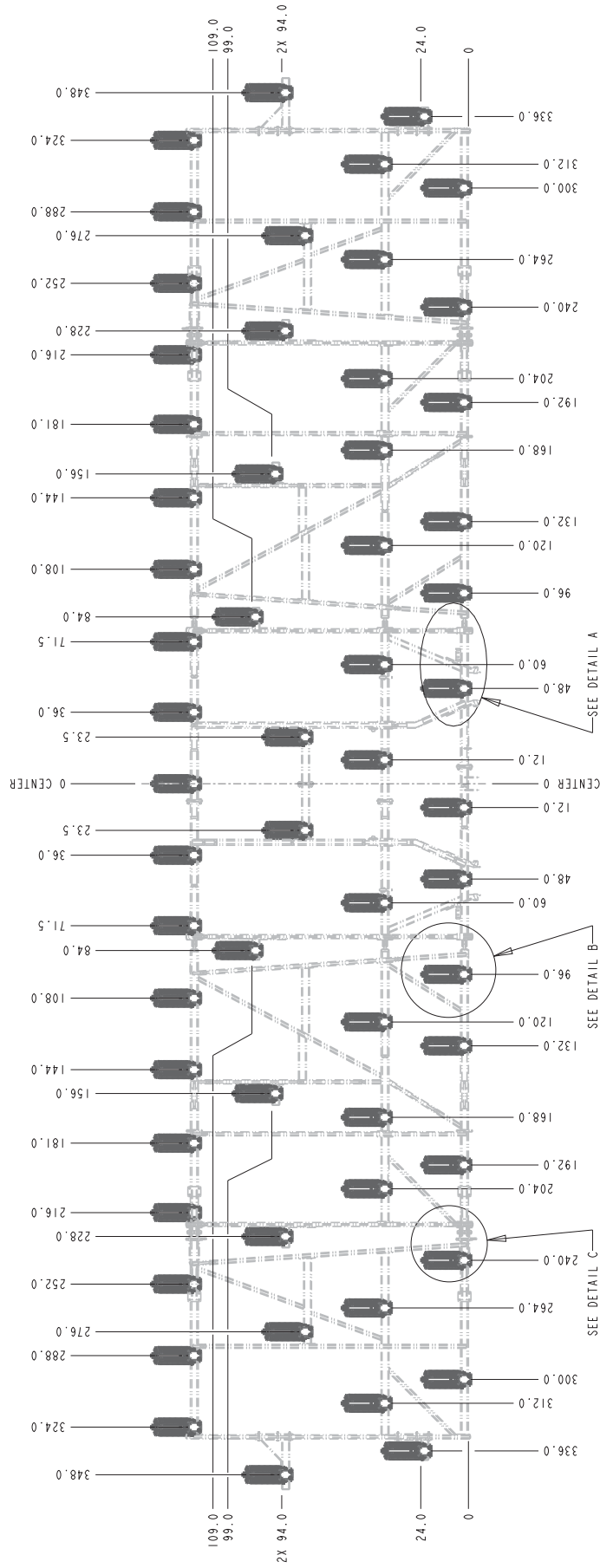
Install Shank Assemblies (Chisel Plow)



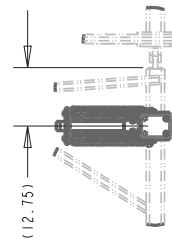
Install Shank Assemblies (Chisel Plow)

1. Use the illustration on the following pages to locate and mark the center lines for installation on the top of the frame sections.
2. Position and attach the assemblies at the marked locations.
 - Attach the 1000 lb assembly to the frame with one cast corner cap, two bolts and four nuts.
 - Attach the 650 lb assembly to the frame with one top plate, and four bolts and nuts.

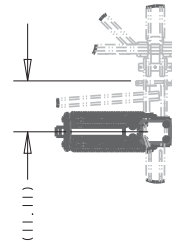
650 lb 12 in. Shank Assembly Spacing
30016289



DETAIL A
SCALE 0.040

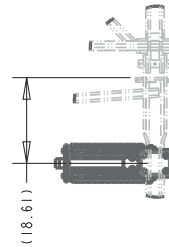
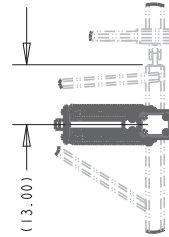
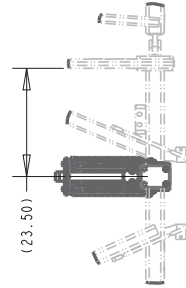
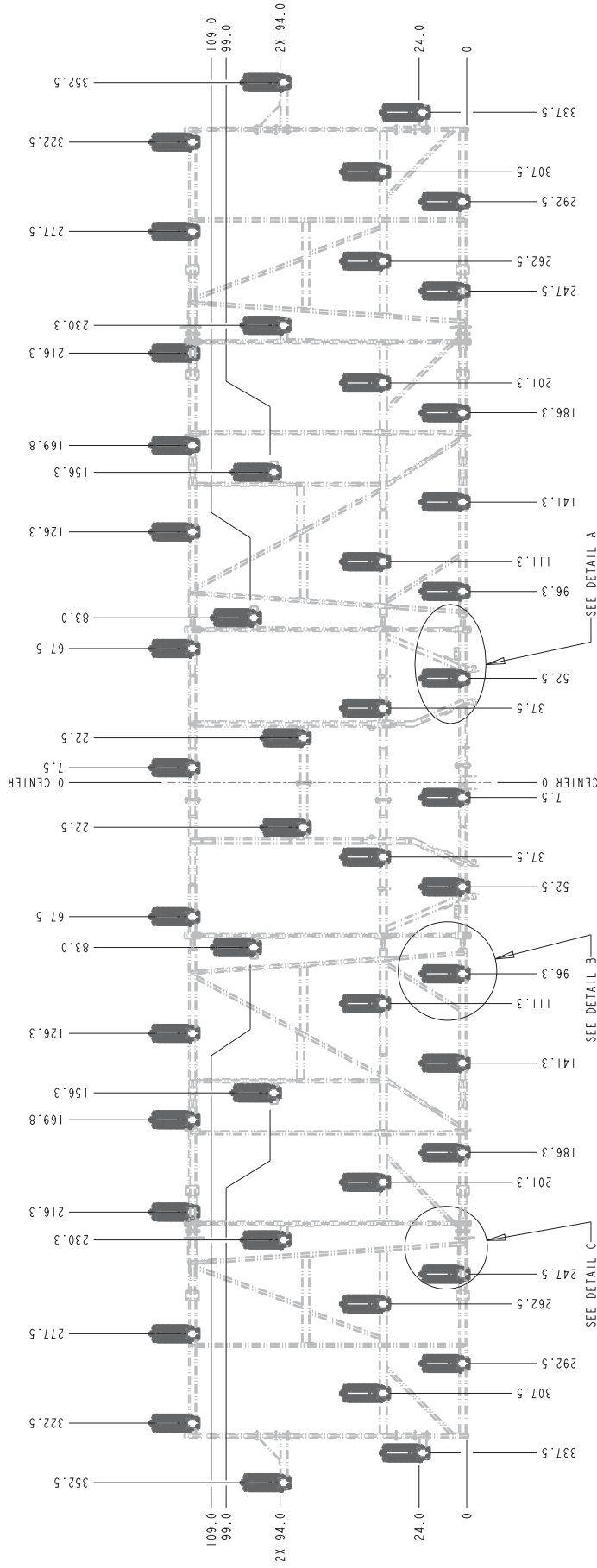


DETAIL B
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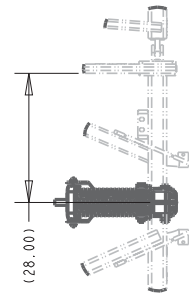
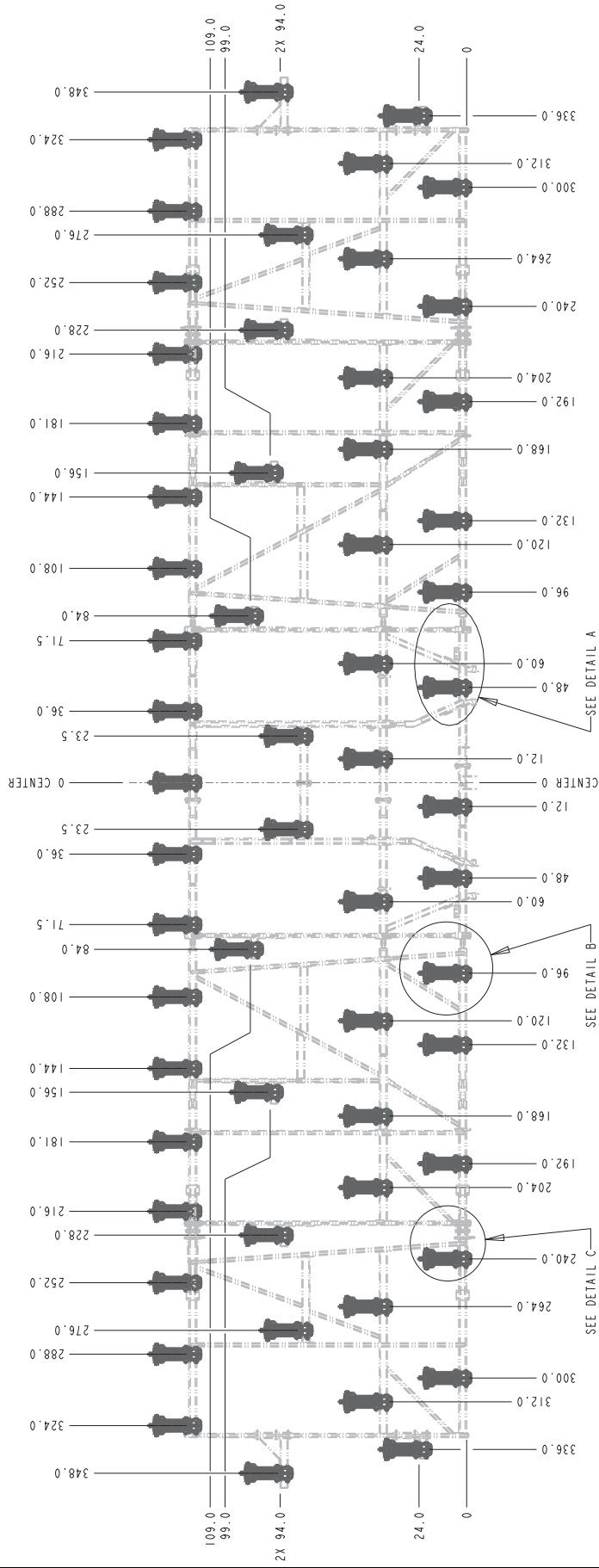


DETAIL C
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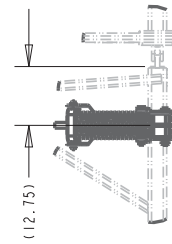
650 lb 15 in. Shank Assembly Spacing
30016314



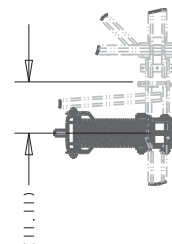
1000 lb 12 in. Shank Assembly Spacing
30016302



DETAIL A
SCALE 0.040

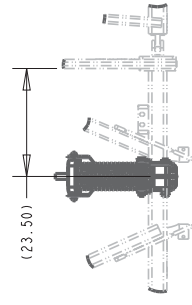
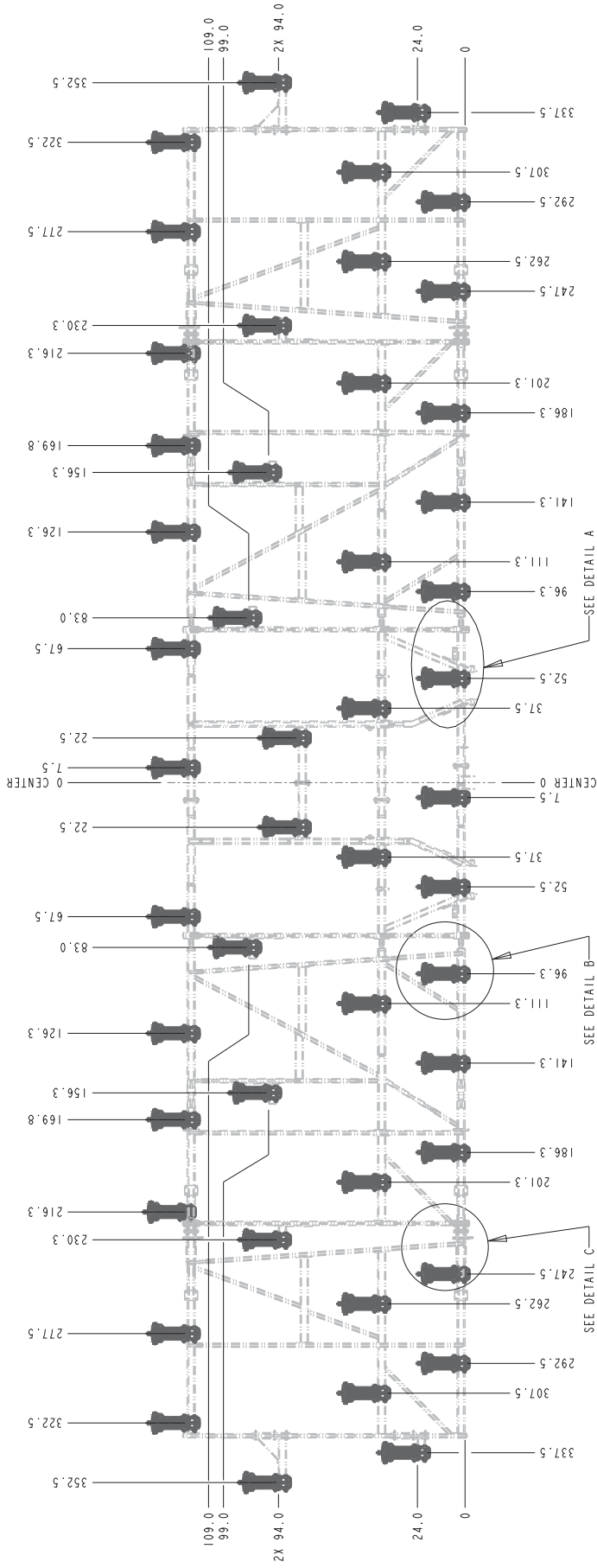


DETAIL B
SCALE 0.040

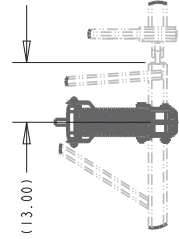


DETAIL C
SCALE 0.040

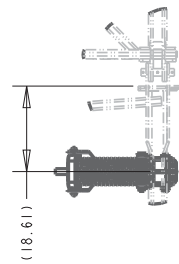
1000 lb 15 in. Shank Assembly Spacing
30019269



DETAIL A
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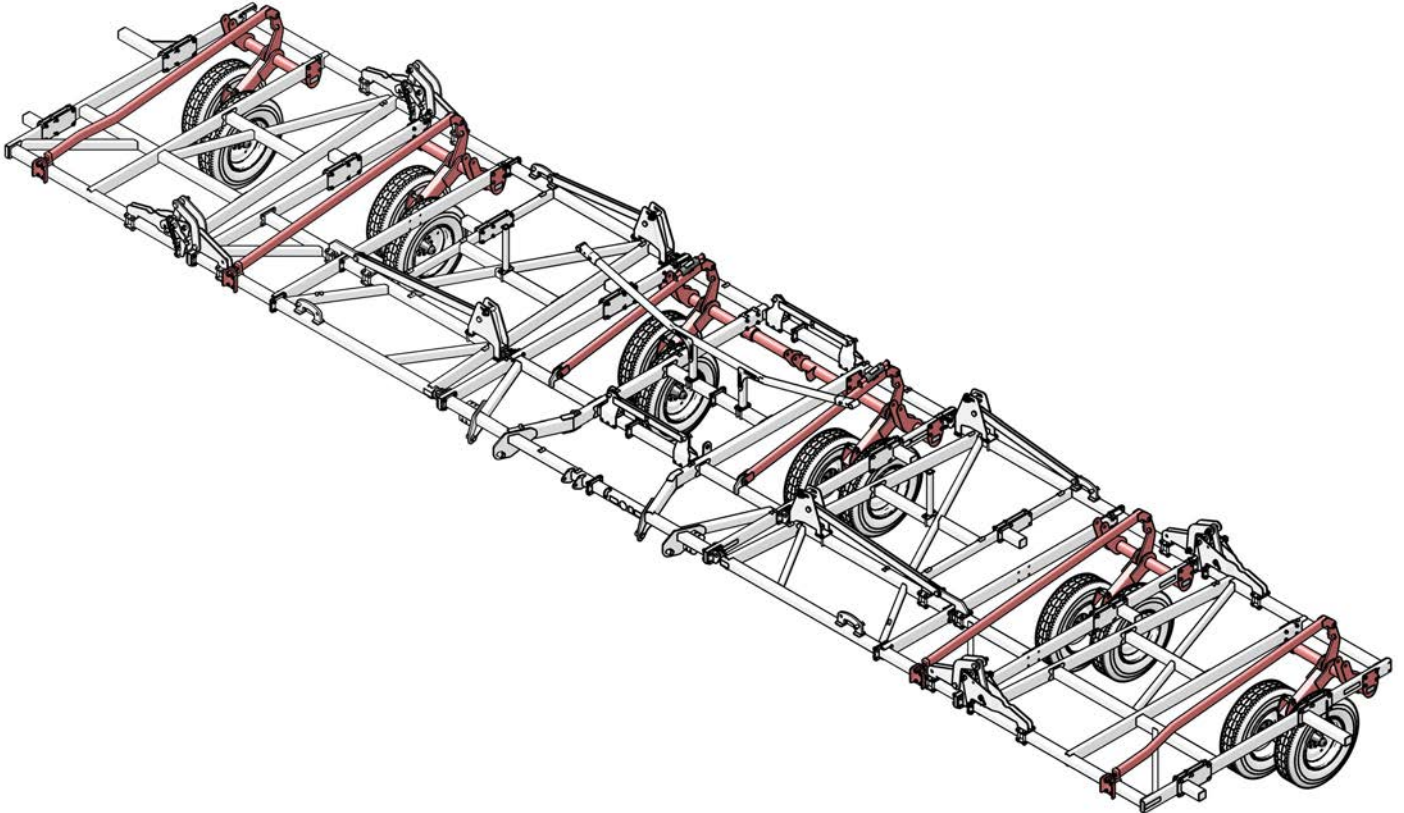


DETAIL B
SCALE 0.040

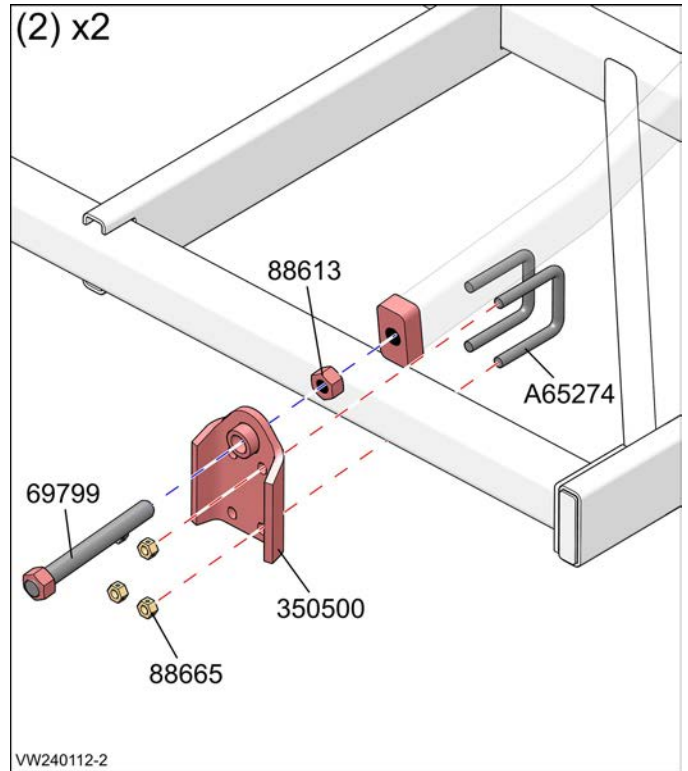
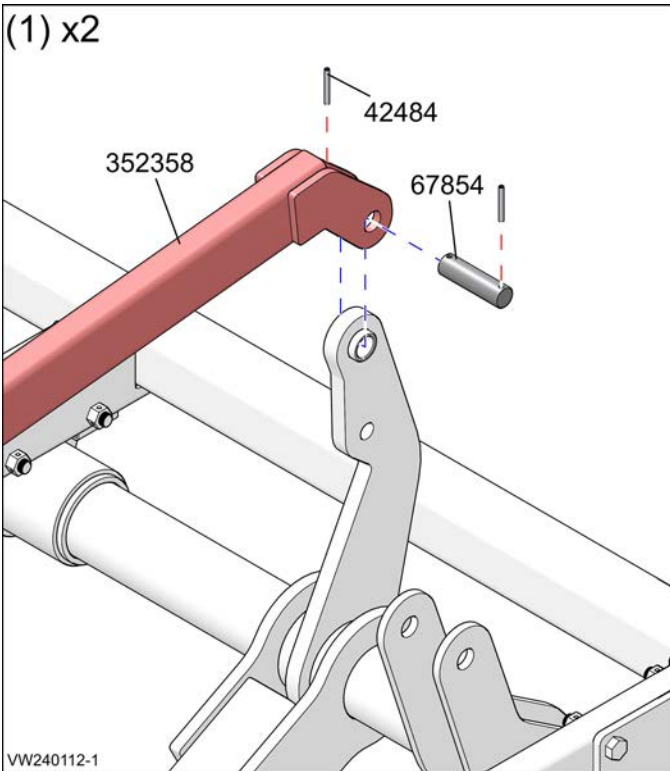


DETAIL C
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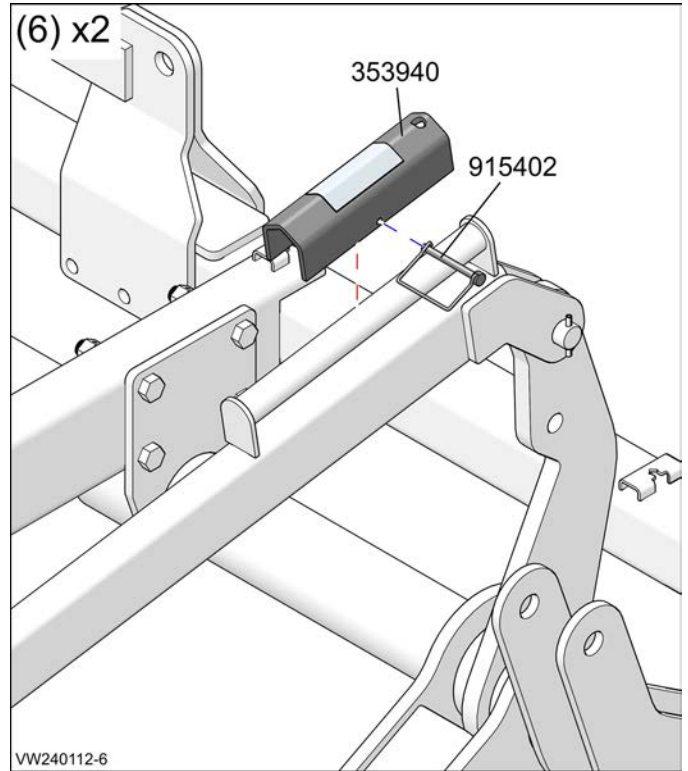
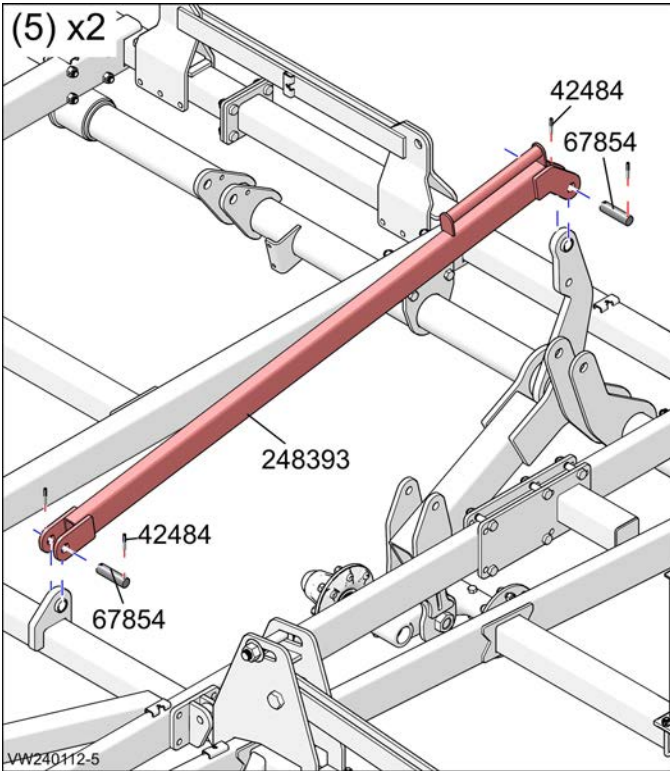
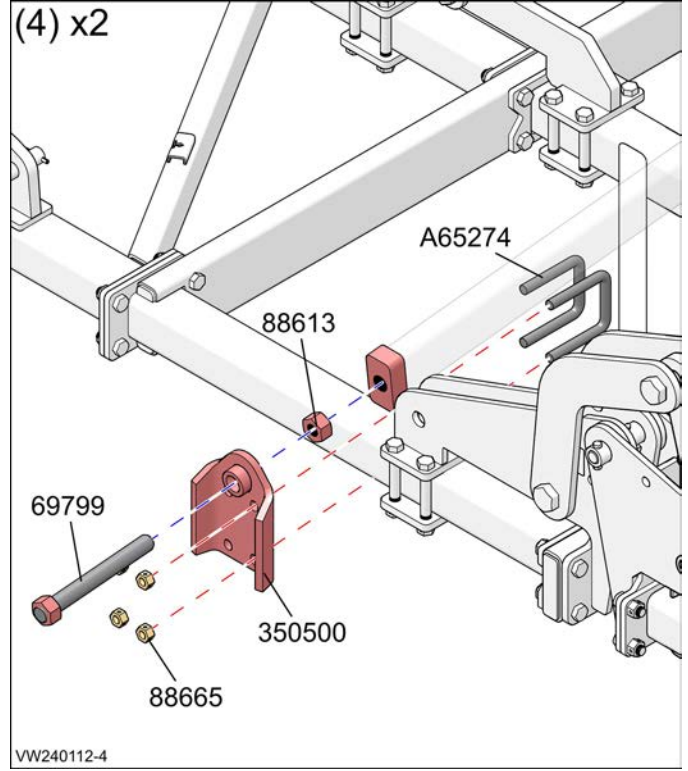
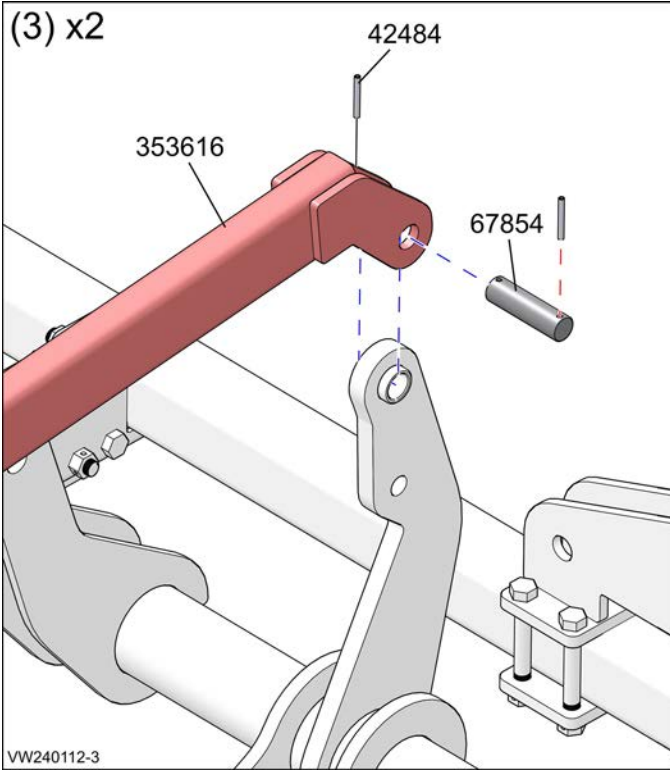
Install Mast Tubes (Chisel Plow)



VW240112 Install Mast Tubes



Install Mast Tubes (Chisel Plow)



Install Mast Tubes (Chisel Plow)

Outer Wing Installation

1. Install the wing mast tube on the wing axle main anchor with one headless pin and two roll pins.
2. Attach the wing mast tube to the front of the frame with one wing mast anchor and two u-bolts and four nuts.
Attach the wing mast tube with one adjuster rod and nut.

Wheel Well Installation

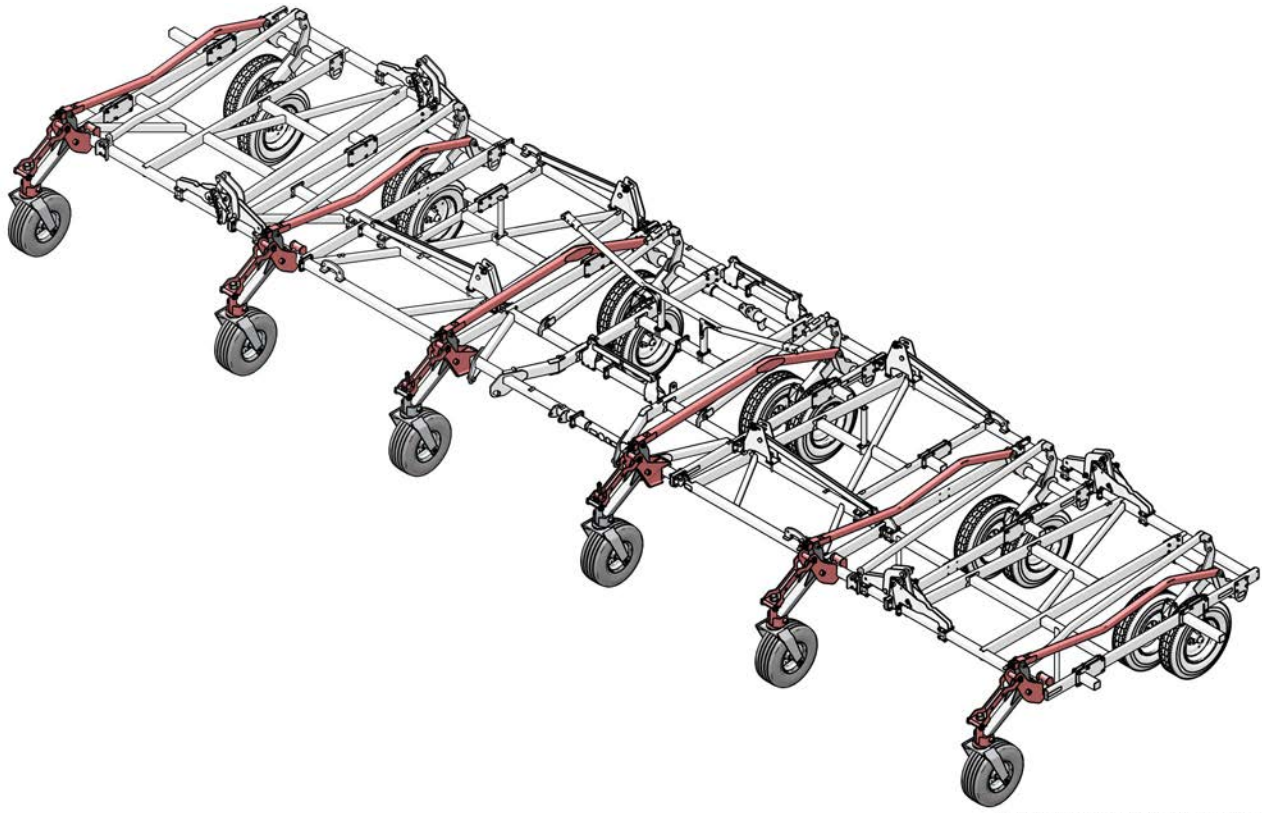
3. Install the wing mast tube on the wheel well axle main anchor with one headless pin and two roll pins.
4. Attach the wing mast tube to the front of the frame with one wing mast anchor and two u-bolts and four nuts.
Attach the wing mast tube with one adjuster rod and nut.

Main Frame Installation

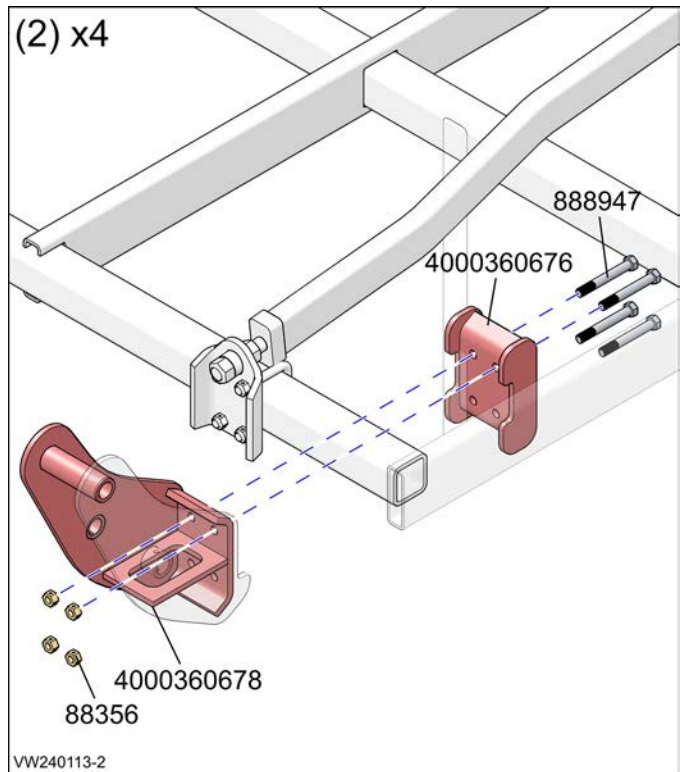
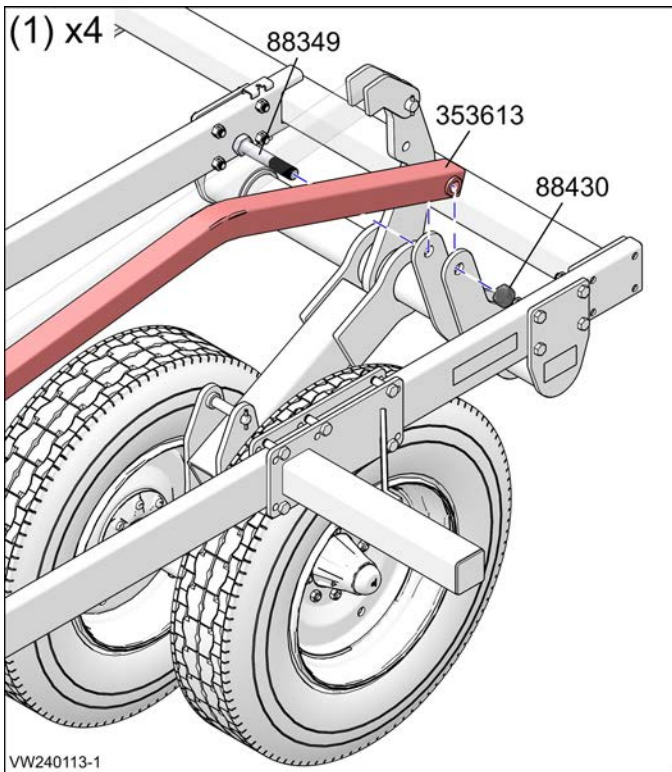
5. Install the main frame mast tube on the main frame axle/walker assembly main anchor with one headless pin and two roll pins.
Attach the main frame mast tube to the front of the frame with one headless pin and two roll pins.
6. Install the two inch cylinder lock channel on the stop collar bracket with the lynch pin.

Install Caster Wheel Assemblies (Chisel Plow)

Outer Wing and Wheel Well Installation

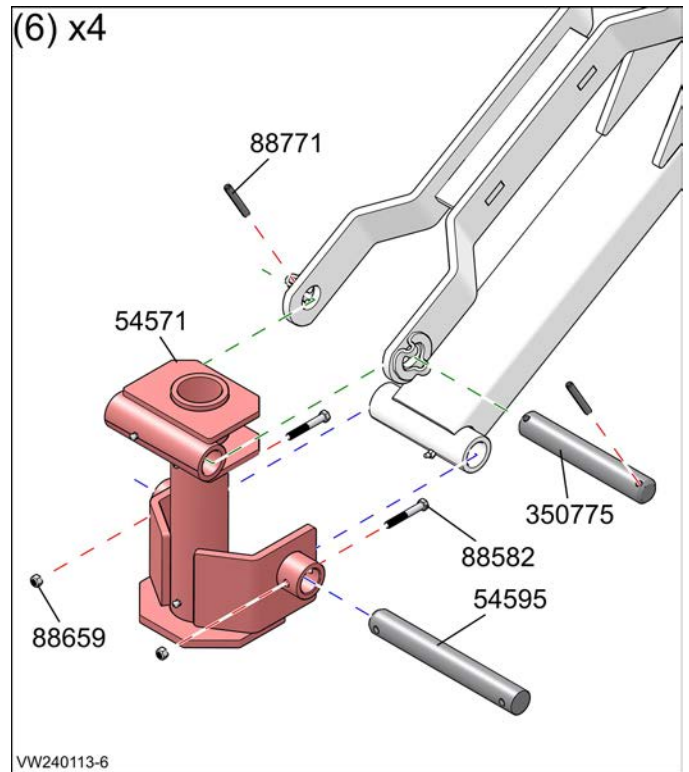
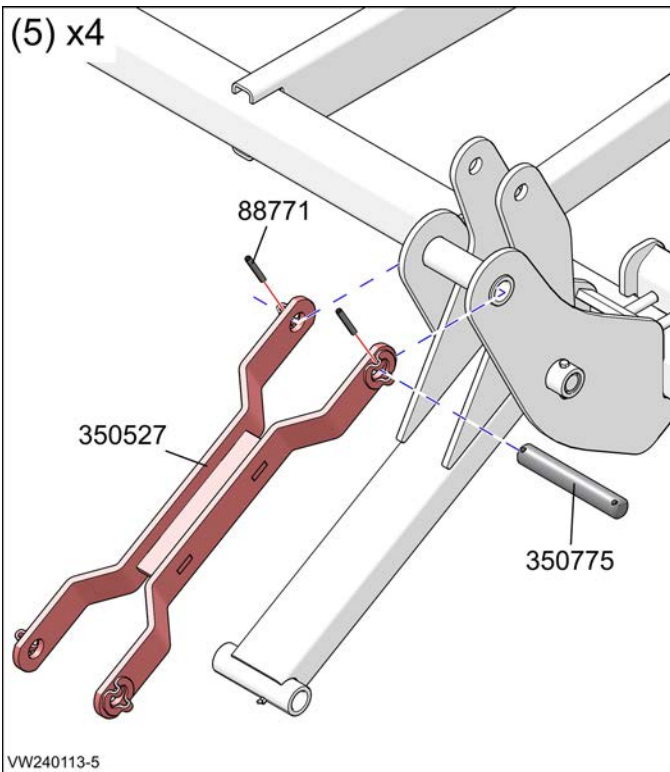
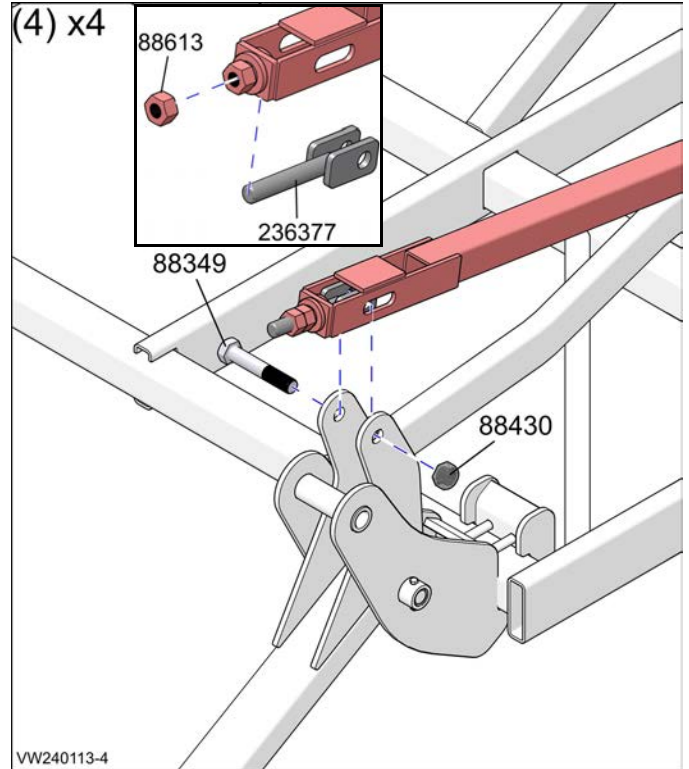
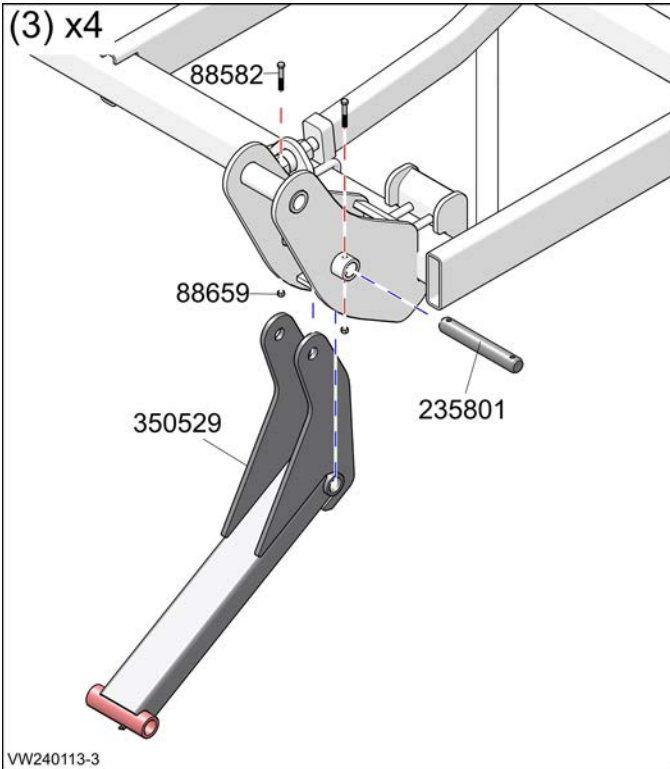


VW240113 Install Caster Wheel Assys



Install Caster Wheel Assemblies (Chisel Plow)

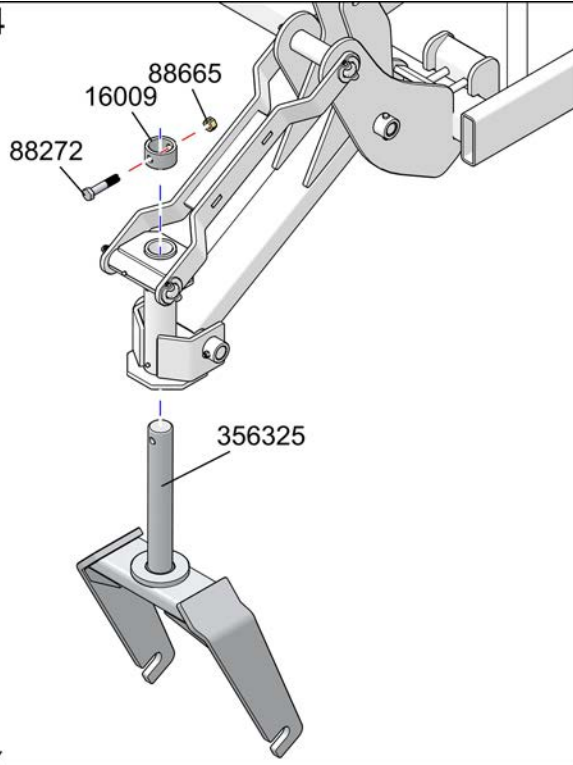
Outer Wing and Wheel Well Installation



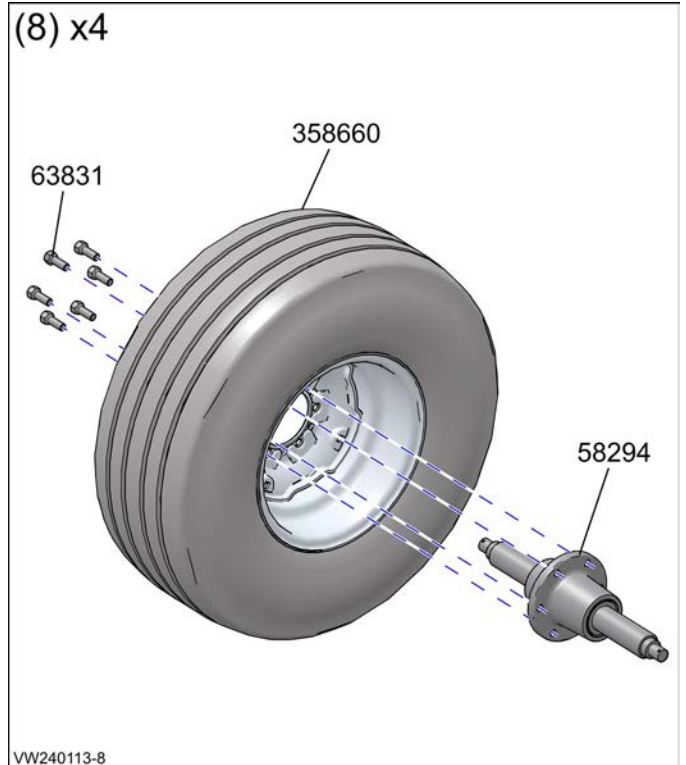
Install Caster Wheel Assemblies (Chisel Plow)

Outer Wing and Wheel Well Installation

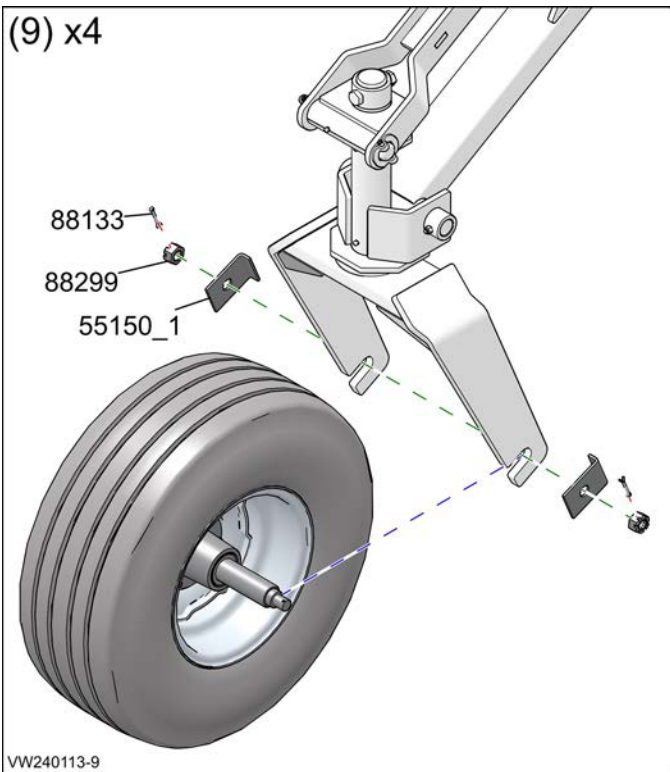
(7) x4



(8) x4



(9) x4



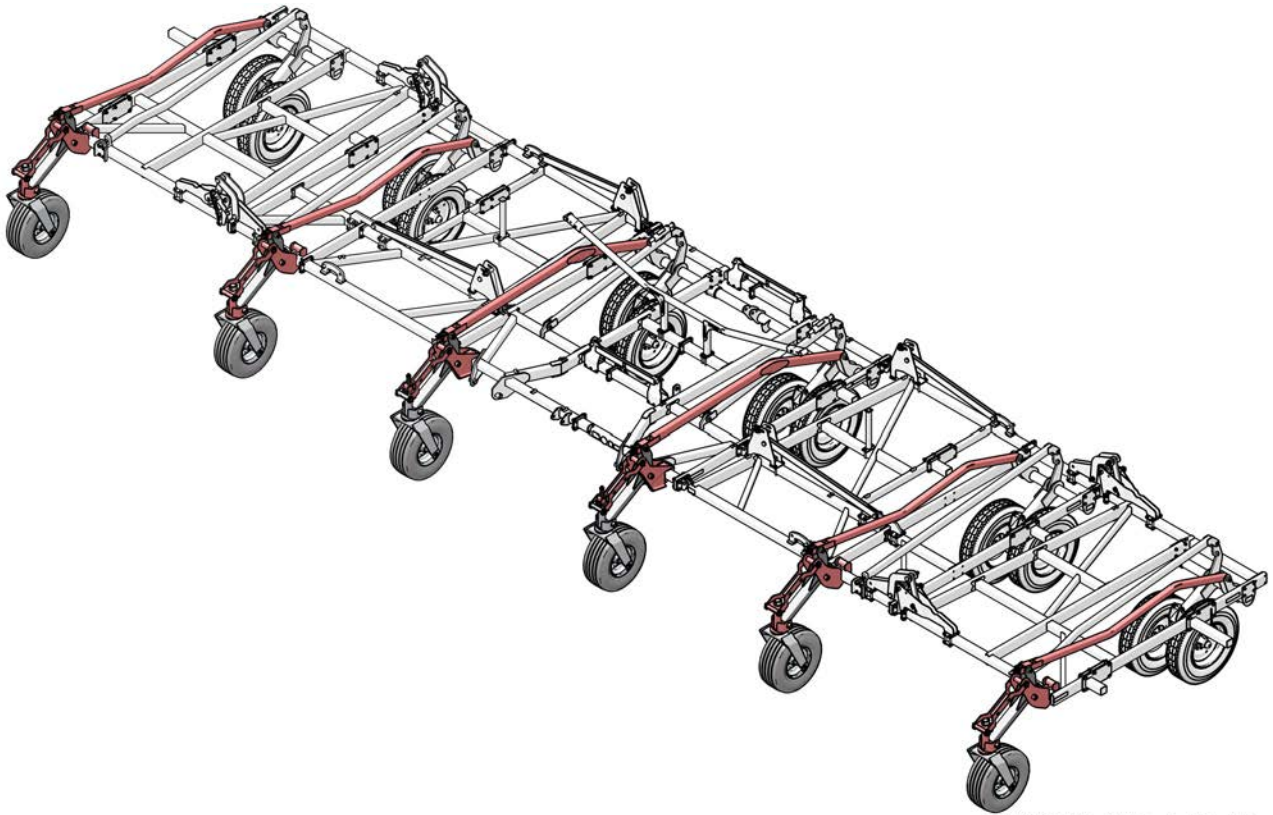
Install Caster Wheel Assemblies (Chisel Plow)

Outer Wing and Wheel Well Installation

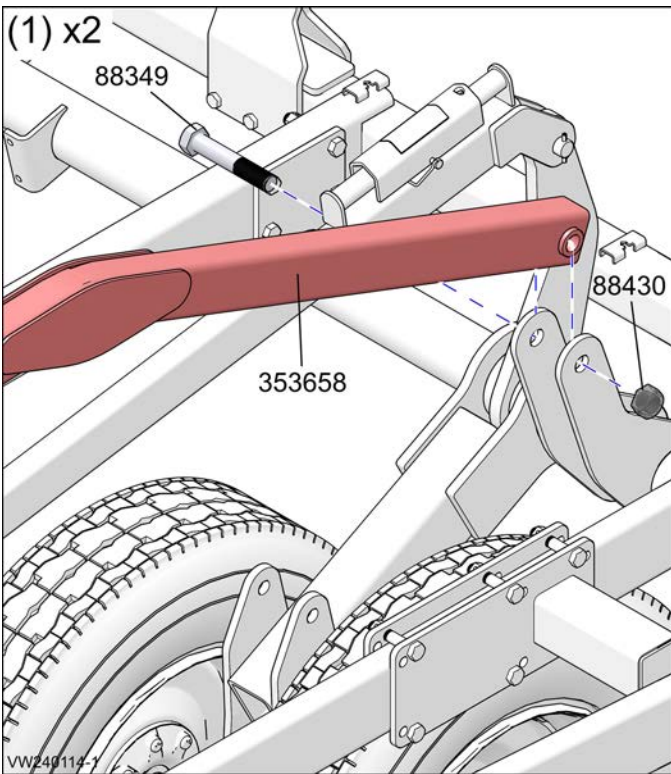
1. Install the wing mast tube on the wing axle anchor with one bolt and nut.
2. Install the front mast weldment on the frame with the tube clamp weldment and four bolts and nuts.
3. Install the bottom lift arm on the front mast weldment with one pin and two bolts and nuts.
4. Install the adjust link on the wing mast tube with one nut. Attach the wing mast tube to the bottom lift arm with one bolt and nut.
5. Attach the top link arm to the bottom lift arm with one pin and two roll pins.
6. Attach the gauge wheel pivot to the top lift arm with one pin and two roll pins. Attach the gauge wheel pivot to the bottom lift arm with one pin and two bolts and nuts.
7. Attach the gage wheel yoke to the gauge wheel pivot with the collar and one bolt and nut.
8. Attach the yoke hub assembly to the wheel assembly with six wheel bolts.
9. Install the wheel assembly on the gage wheel yoke with two spindle locks and two nuts and cotter pins.

Install Caster Wheel Assemblies (Chisel Plow)

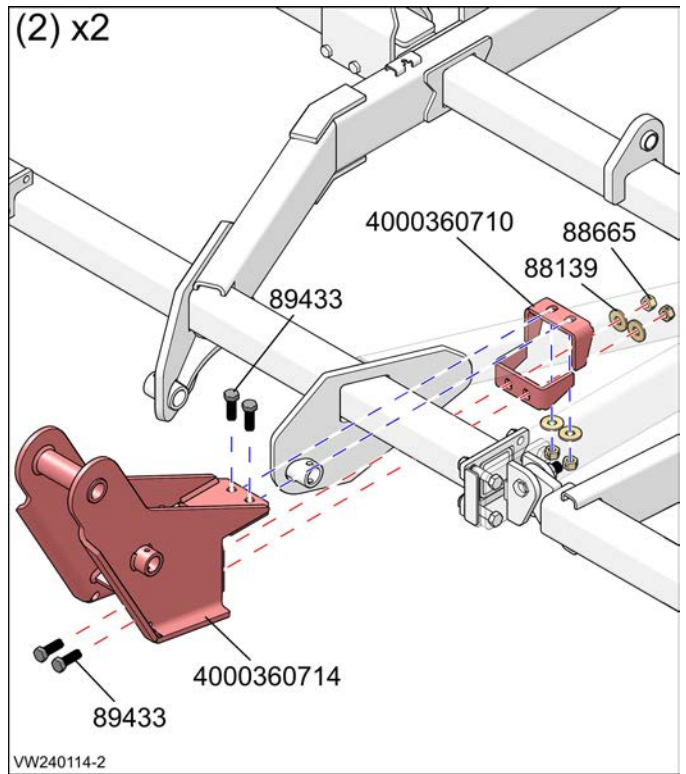
Main Frame



VW240114 Install Caster Wheel Assys



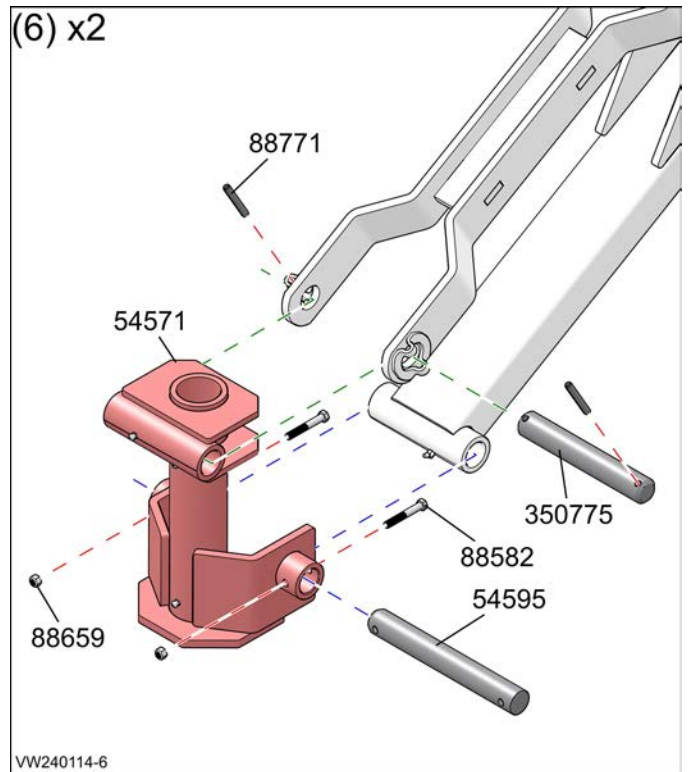
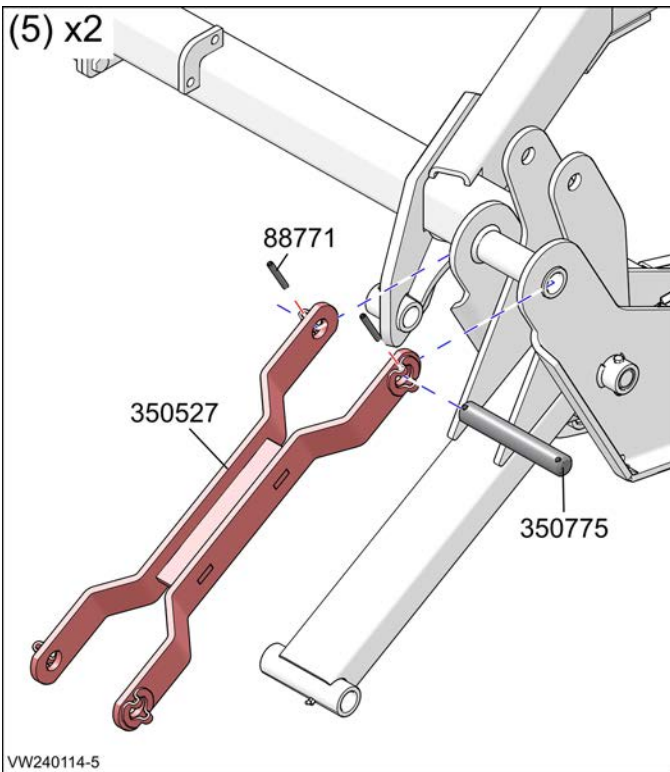
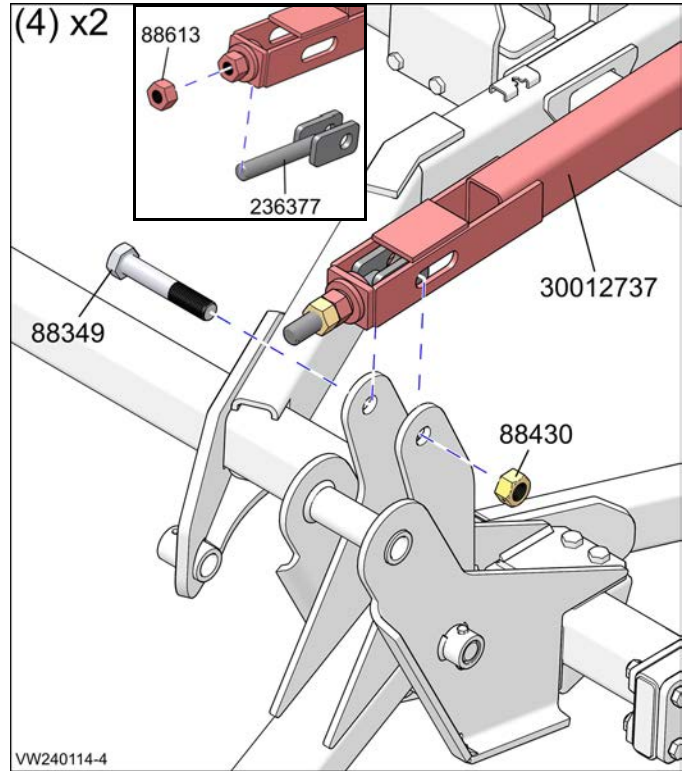
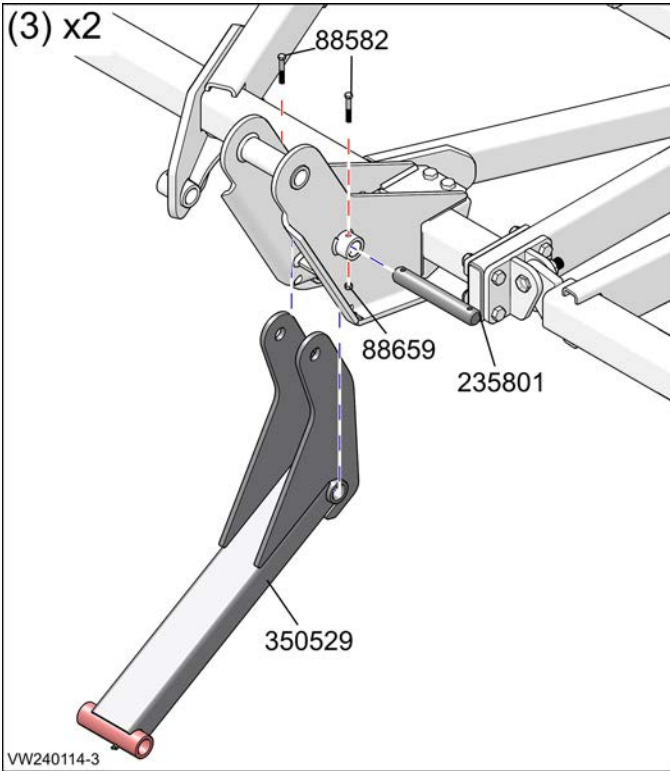
VW240114-1



VW240114-2

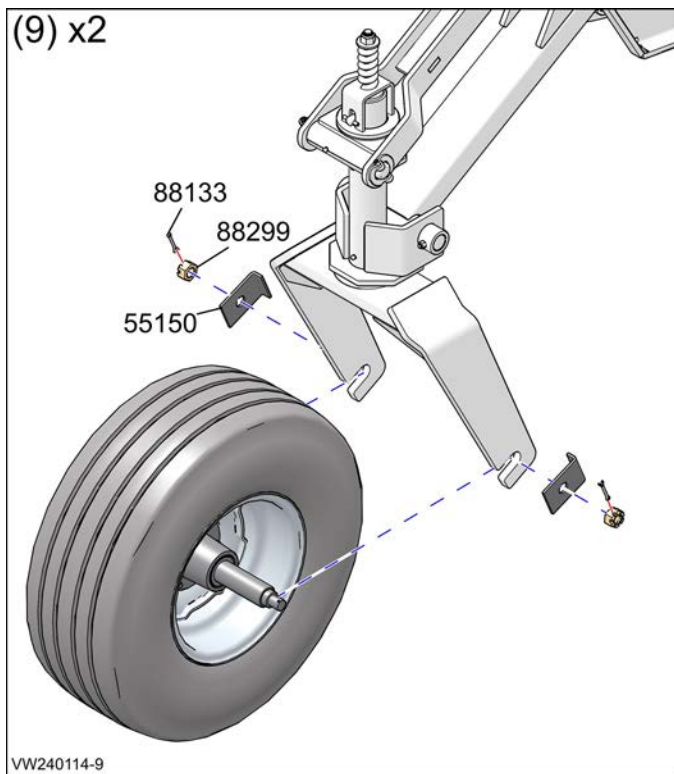
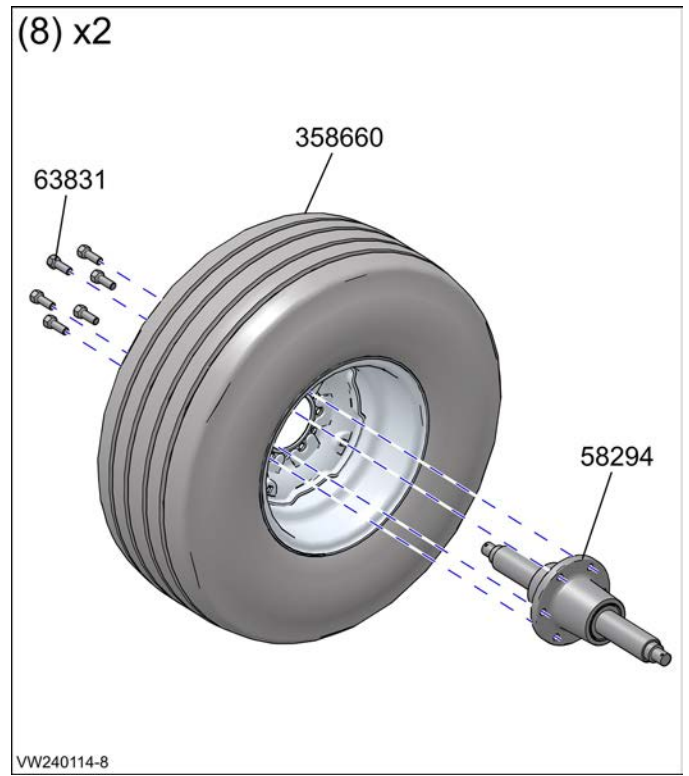
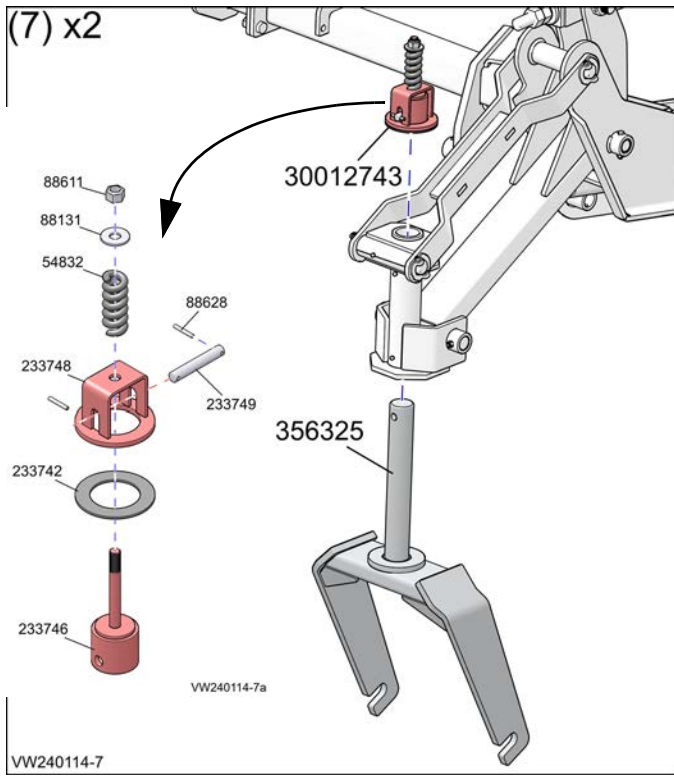
Install Caster Wheel Assemblies (Chisel Plow)

Main Frame



Install Caster Wheel Assemblies (Chisel Plow)

Main Frame

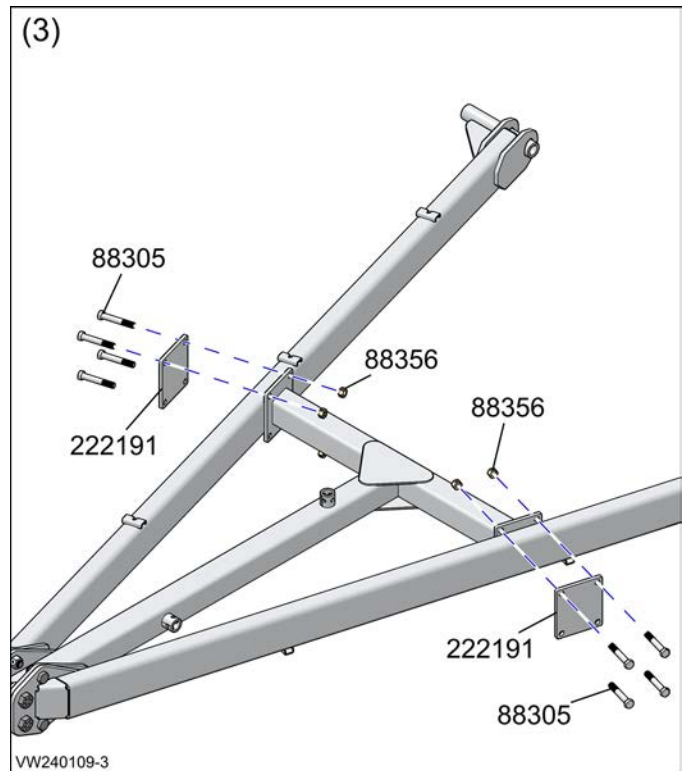
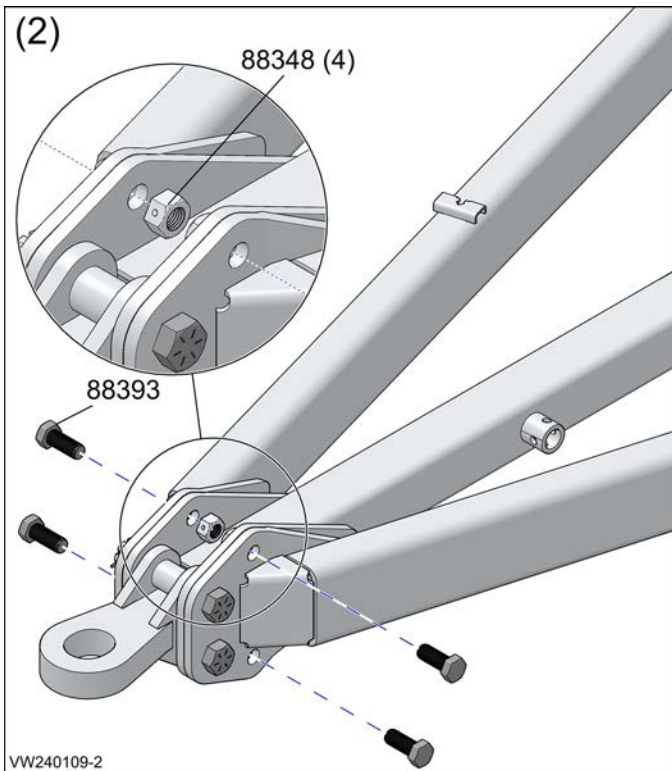
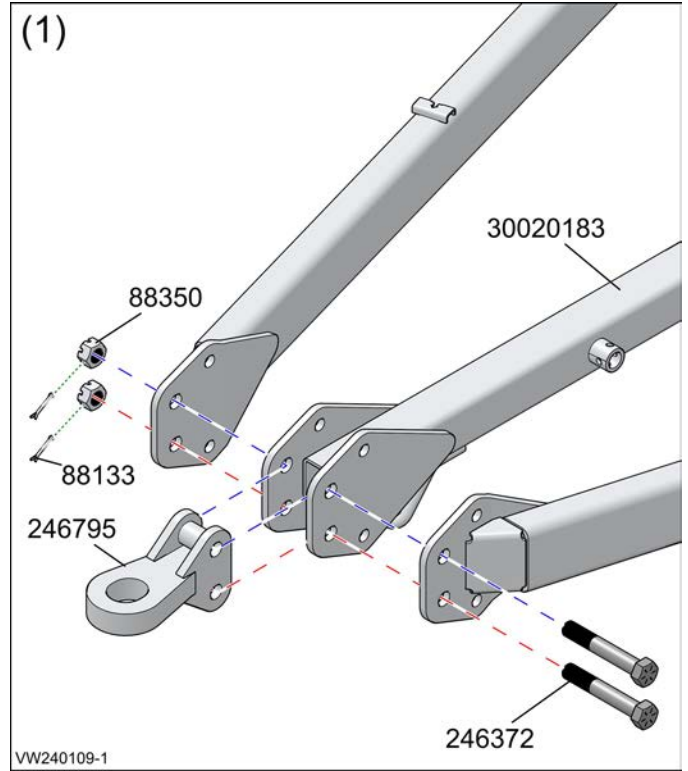
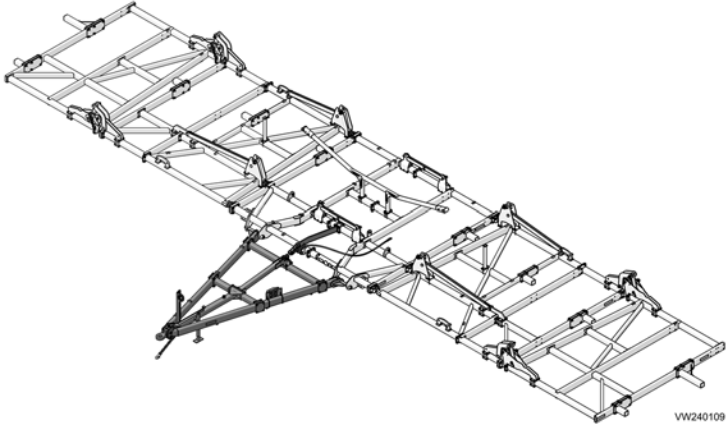


Install Caster Wheel Assemblies (Chisel Plow)

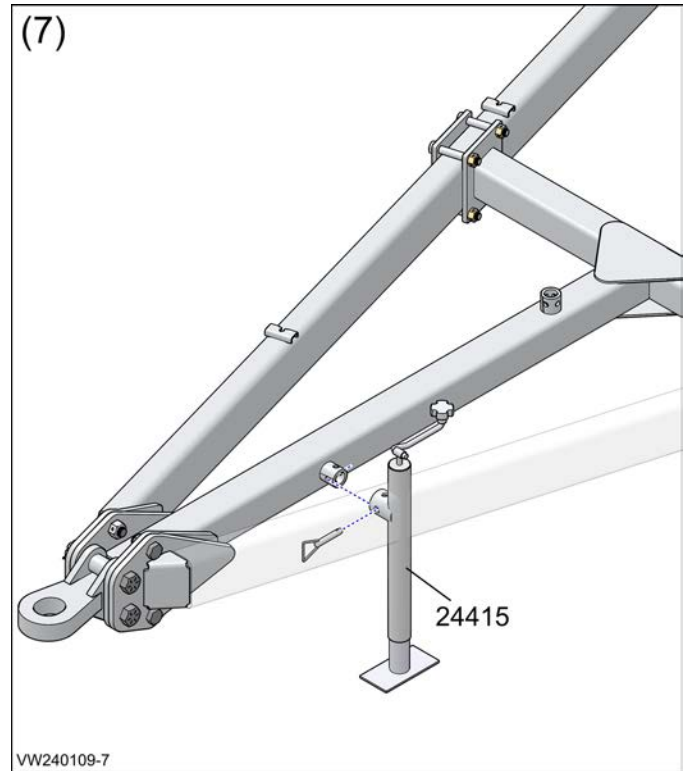
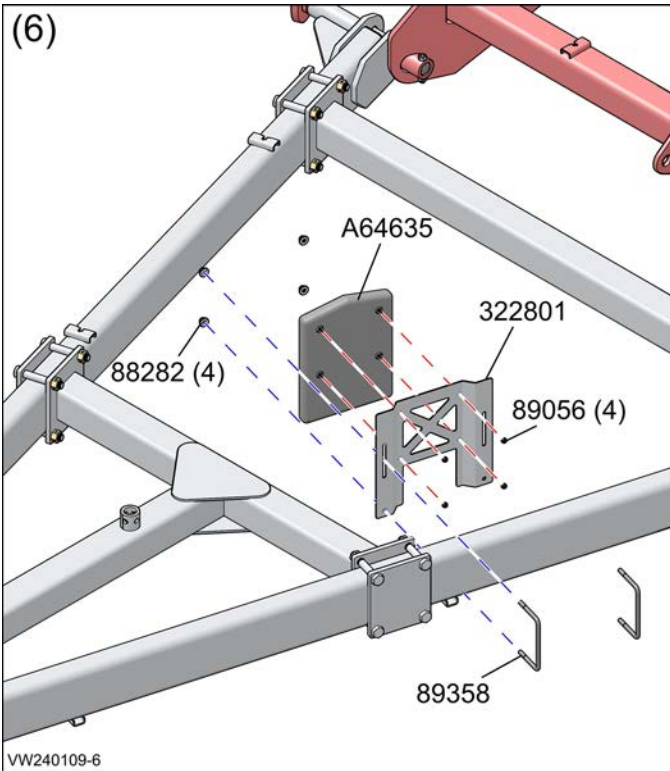
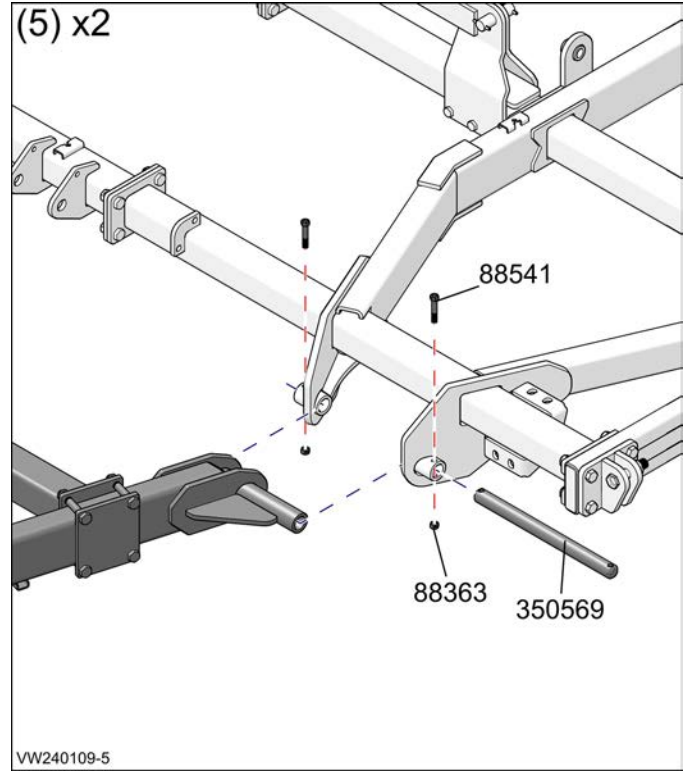
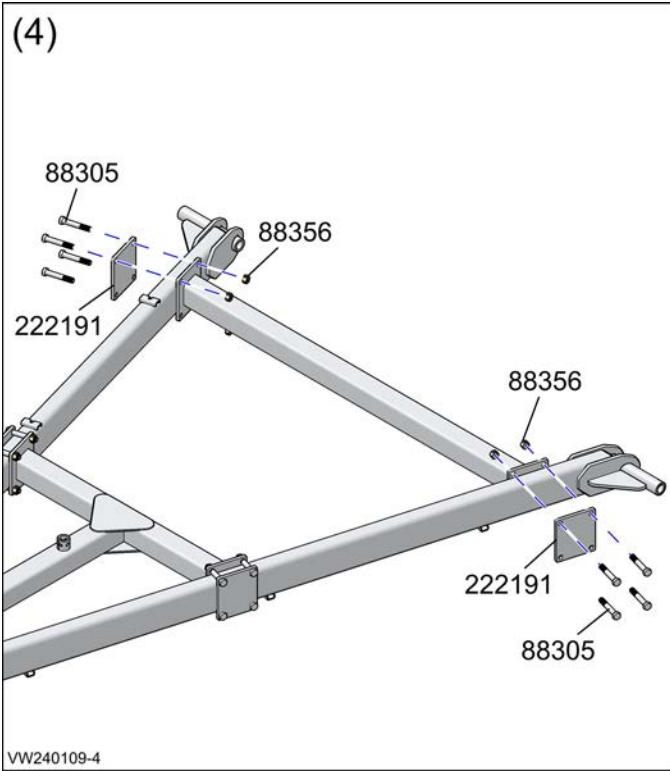
Main Frame

1. Install the main wheel mast tube on the wing axle anchor with one bolt and nut.
2. Install the extended front mast on the frame with the two lift mount plates and four bolts, washers and nuts.
3. Install the bottom lift arm on the extended front mast with one pin and two bolts and nuts.
4. Install the adjust link on the main frame link tube with one nut.
Attach the main frame link tube to the bottom lift arm with one bolt and nut.
5. Attach the top link arm to the bottom lift arm with one pin and two roll pins.
6. Attach the gauge wheel pivot to the top lift arm with one pin and two roll pins.
Attach the gauge wheel pivot to the bottom lift arm with one pin and two bolts and nuts.
7. Attach the gage wheel yoke to the gauge wheel pivot with the damper brake kit pin and two roll pins.
8. Attach the yoke hub assembly to the wheel assembly with six wheel bolts.
9. Install the wheel assembly on the gage wheel yoke with two spindle locks and two nuts and cotter pins.

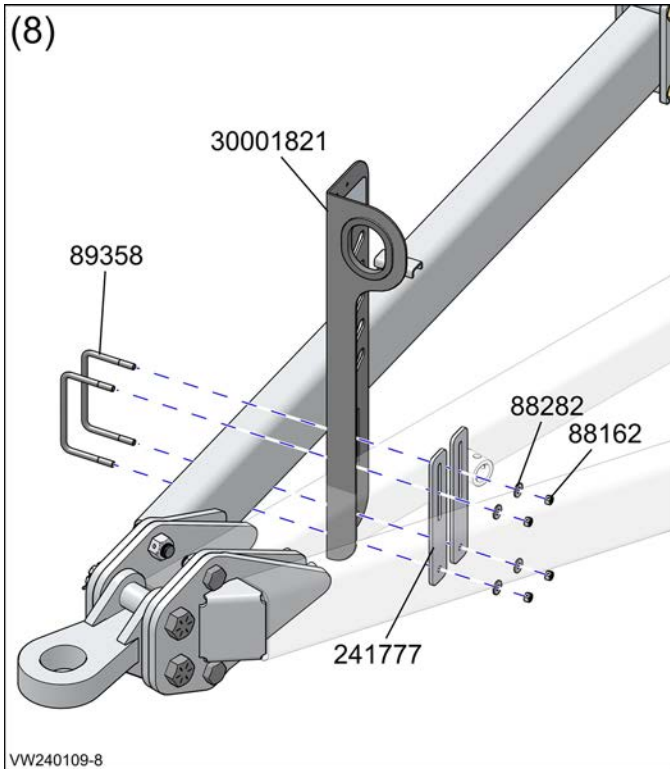
Install Front Hitch (Chisel Plow)



Install Front Hitch (Chisel Plow)



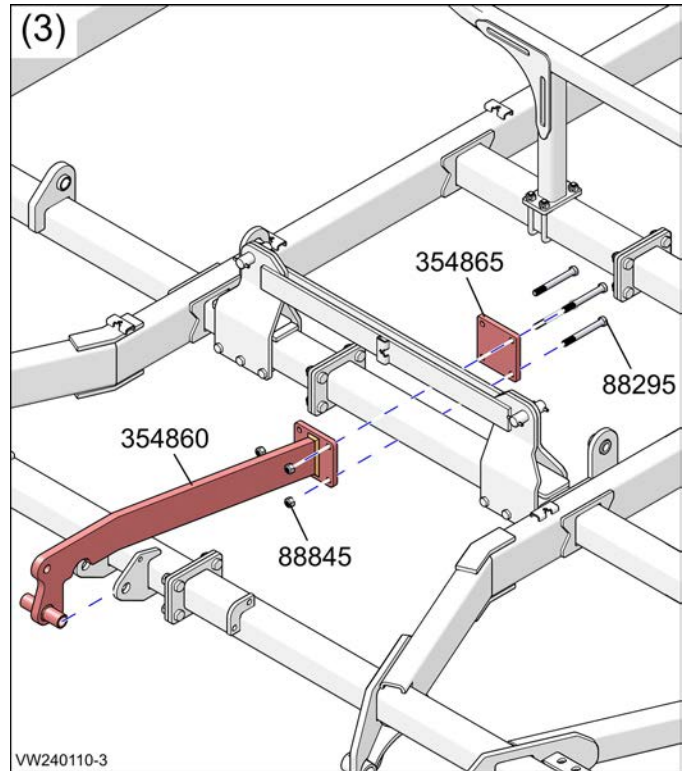
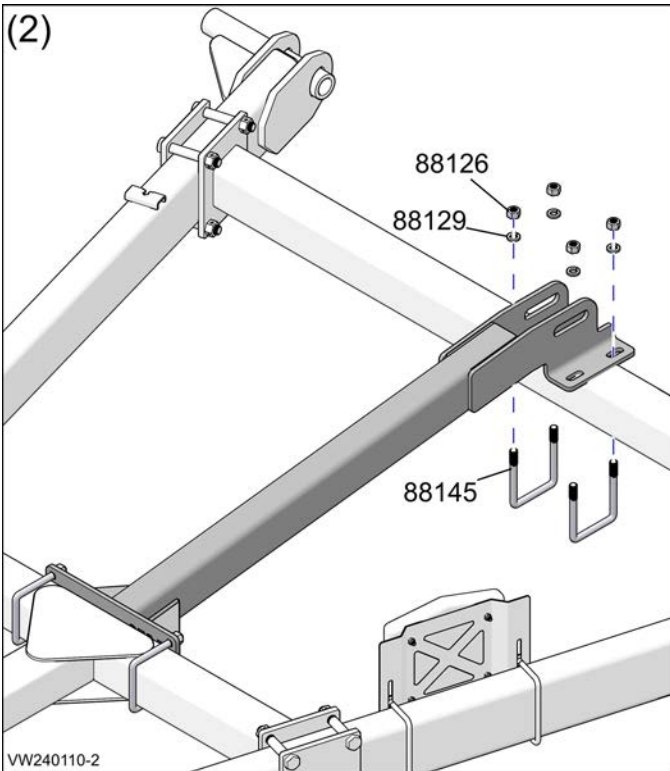
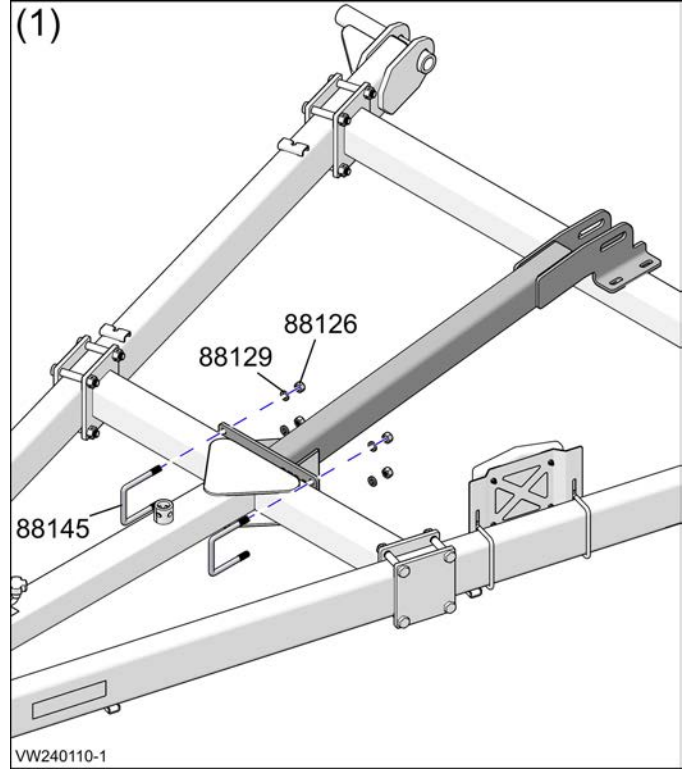
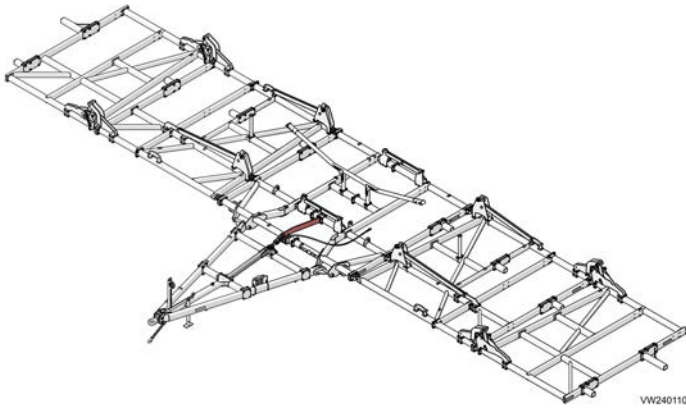
Install Front Hitch (Chisel Plow)



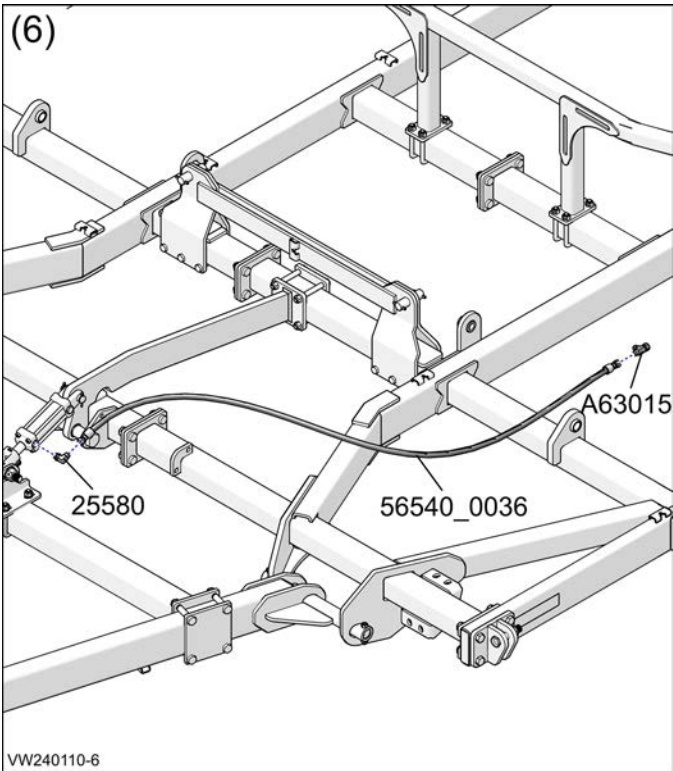
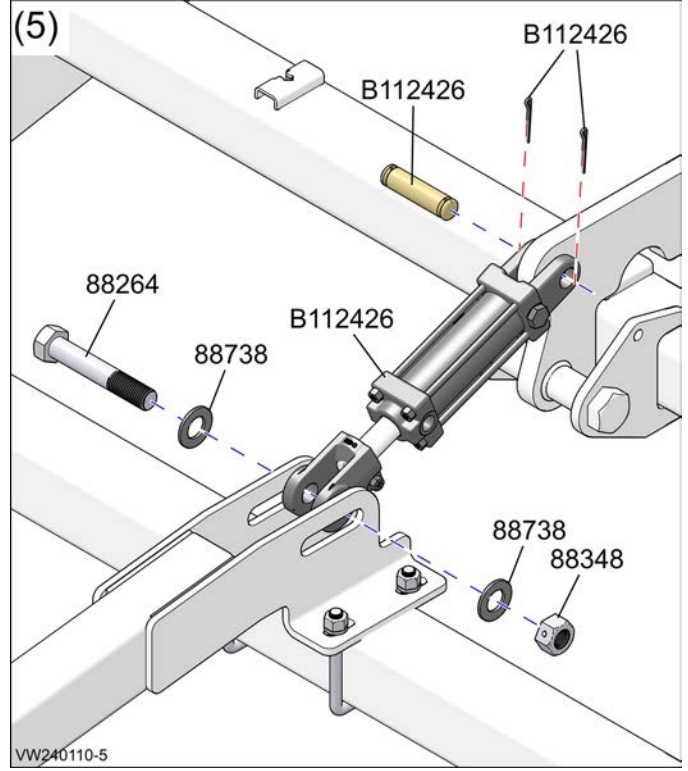
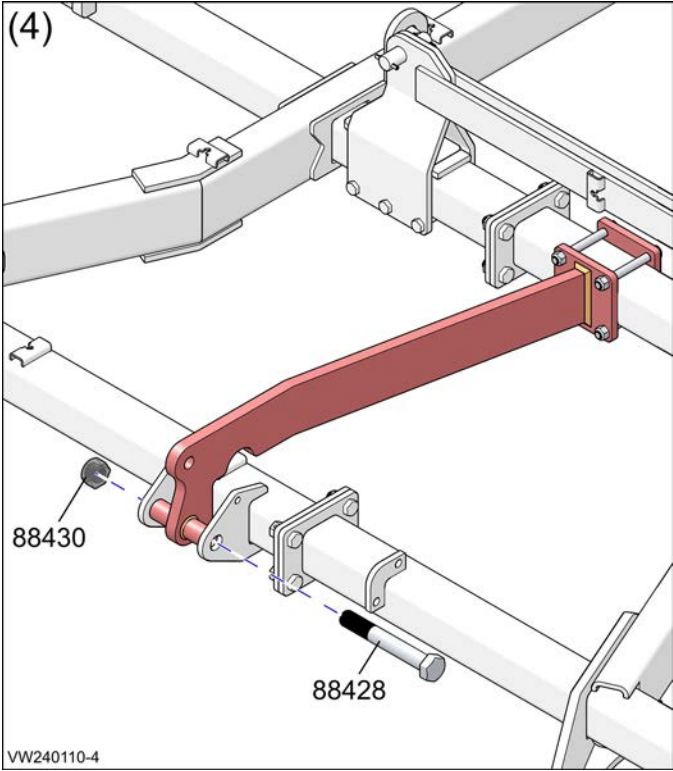
Install Front Hitch (Chisel Plow)

1. Attach the category 5 cat hitch to the front brace and the two five section poles with two bolts, castle nuts and cotter pins.
2. Install the two five section poles on the front brace with four bolts and nuts.
3. Attach the front brace to the two five section poles with two stub plates, and eight bolts and nuts.
4. Attach the rear cross tube to the two five section poles with two stub plates, and eight bolts and nuts.
5. Attach the assembled hitch to the pin tubes on the main frame with two pins, and four bolts and nuts.
6. Attach the manual storage case to the sheet mount manual holder with four nuts.
Attach the sheet mount manual holder to the left five section pole with two u-bolts and four nuts.
7. Attach the jack to the front brace with the pin.
8. Attach the hydraulic hose holder channel plate to the right five section pole with the two hydraulic hose holder backer plates, two u-bolts, and four washers and nuts.

Install Weight Balance Kit (Chisel Plow)



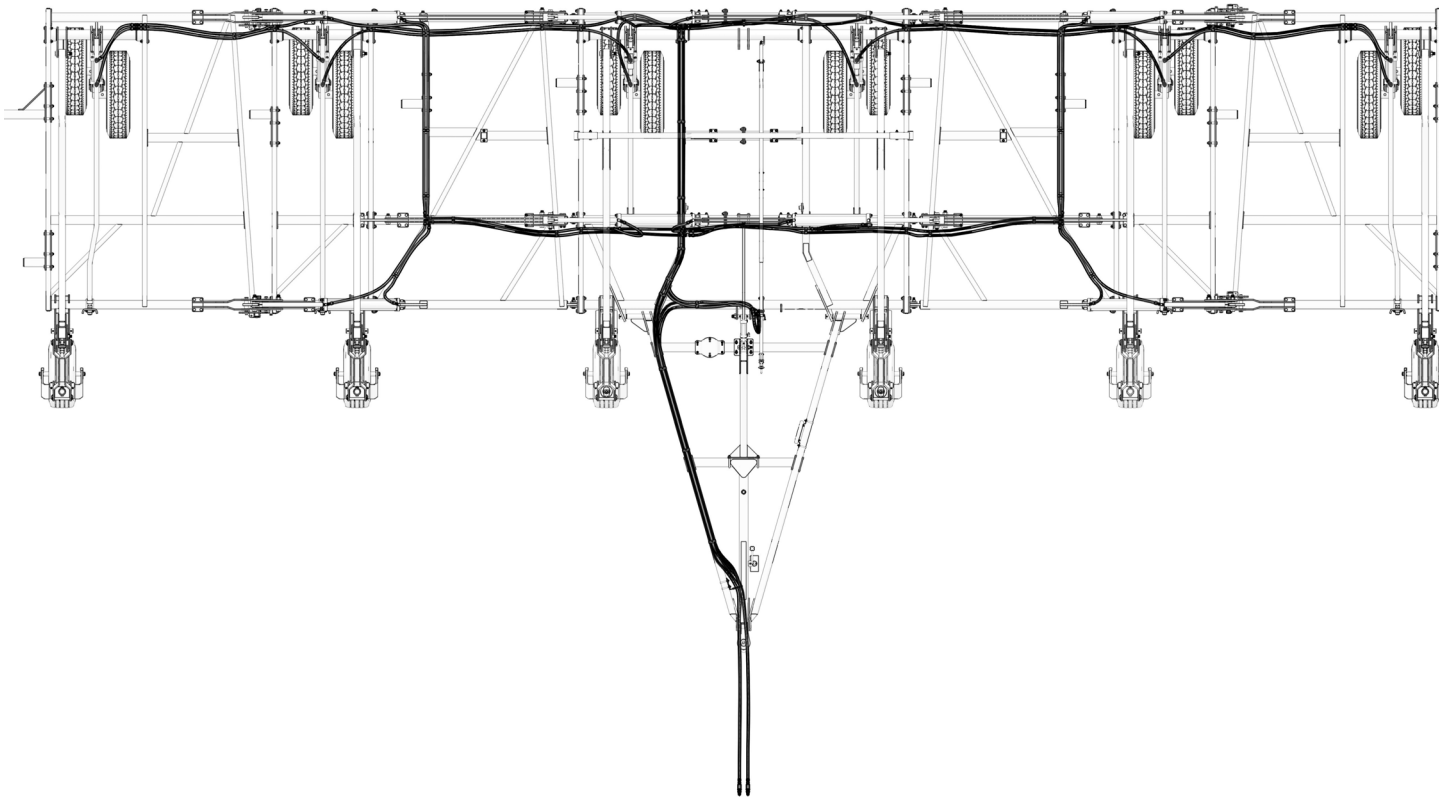
Install Weight Balance Kit (Chisel Plow)



Install Weight Balance Kit (Chisel Plow)

1. Attach the T front brace to the front hitch with 2 u-bolts, and four washers and nuts.
2. Attach the T front brace to the front hitch with 2 u-bolts, and four washers and nuts.
3. Attach the rear weight balance to the main frame with one plate, and four bolts and nuts.
4. Attach the rear weight balance to the main frame with one bolt and nut.
5. Attach the hydraulic cylinder rod end to the T front brace with one bolt, two washers and one nut.
Attach the hydraulic cylinder base end to the rear weight balance with one pin and two cotter pins.
6. Attach the fitting to the hydraulic cylinder.
Attach the hose to the fitting.
Attach the fitting to the end of the hose.

Install Hydraulic Hoses (Chisel Plow)



VW240118 Install Hyd Hoses

Cylinders with fittings and connecting hoses may be installed earlier in the assembly process. For some machine models you will connect a single hose between two cylinders. For others you will join two hoses with a fitting before connecting those hoses to the two cylinders.

To begin installation, gather and identify all hydraulic hoses. See the following illustrations and parts lists to confirm whether you will be installing one or two hoses between cylinders.

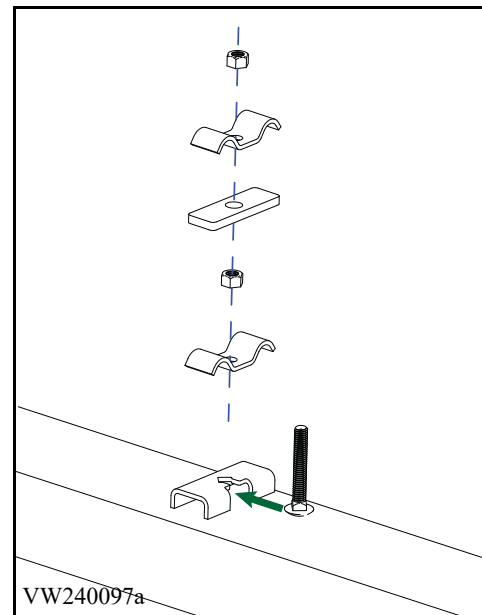
Installing Tie Straps

Loosely route hoses as shown, and install tie straps as needed.

- See the illustrations and parts lists to confirm whether additional hoses will be routed with the hose you are installing. If there will be additional hoses, wait to install tie straps until after all hoses have been routed.

Installing Hose Clamps

Loosely route hoses as shown, and install hose clamps as needed. Hose clamps are installed onto the hose clamp bolt mounts welded onto the machine frames.



1. Slide the carriage bolt into the slot in the mount.

2. Loosely install two tube clamps and one plate onto the bolt with two nuts.
3. Route hose(s) under the tube clamps and tighten the nuts to secure the hoses to the frame.

Install Lift Cylinder Fittings and Hoses

See the Install Lift Cylinder Fittings and Hoses illustrations to connect and route the hoses. Hose part numbers are listed in Table 1.

1. Install two 25580 elbow fittings on all cylinders (A-F).
2. Connect Hose 1 to the rod end fitting on Cylinder A.
3. Connect Hose 2 to Hose 1 with one 13239 Fitting.
4. Connect Hose 3 to Hose 2 with one 13238 T-fitting.
5. Connect Hose 4 to Hose 3 with one 13239 Fitting.
6. Connect Hose 4 to the rod end fitting on Cylinder F.
7. Connect Hose 5 to the 13238 T-fitting and route to the Single Point Depth Control DCV valve.
8. Connect Hose 5 to the 25580 elbow fitting in the side of the valve.
9. Connect Hose 6 to the base end fitting on Cylinder A.
10. Connect Hose 7 to Hose 6 with one 13239 Fitting.
11. Connect Hose 7 to the rod end fitting on Cylinder B.
12. Connect Hose 8 to the base end fitting on Cylinder B and to the rod end fitting on Cylinder C.
13. Connect Hose 9 to the base end fitting on Cylinder C.
14. Connect Hose 10 to Hose 9 with one 1328 T-fitting.
15. Connect Hose 10 to the base end fitting on Cylinder D.
16. Connect Hose 11 to the rod end fitting on Cylinder D and to the base end fitting on Cylinder E.
17. Connect Hose 12 to the rod end fitting on Cylinder E.
18. Connect Hose 13 to Hose 12 with one 13239 Fitting.
19. Connect Hose 14 to the 13238 T-fitting and route to the pilot operated check valve.
20. Connect Hose 14 to the 24024 fitting in the #2 port in the valve.

Table 1: Lift Cylinder Hoses

Hose	Part No.
1	13263
2	67576
3	240609
4	13263
5	241494
6	13263
7	13483
8	234947
9	56539
10	13482
11	234947
12	13483
13	13263
14	241494

Install Fold Cylinder Fittings and Hoses

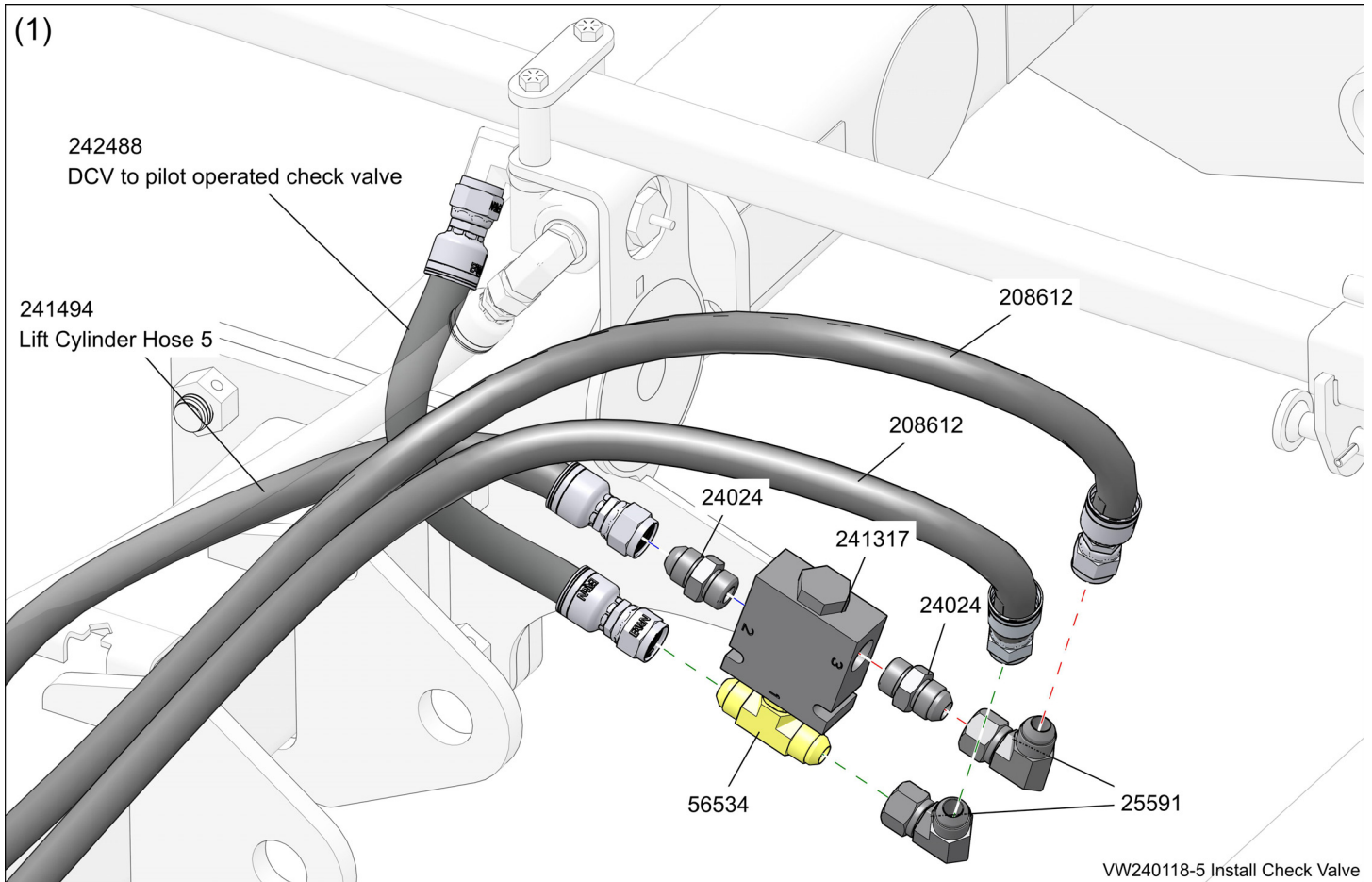
See the Install Fold Cylinder Fittings and Hoses illustrations to connect and route the hoses. Hose part numbers are listed in Table 2.

1. Install two A65901 elbow fittings on all cylinders (A-H).
2. Follow the illustrations to connect and route the hoses.
3. Route Hose 7 and Hose 15 to the front hitch and through the hydraulic hose holder.

Table 2: Fold Cylinder Hoses

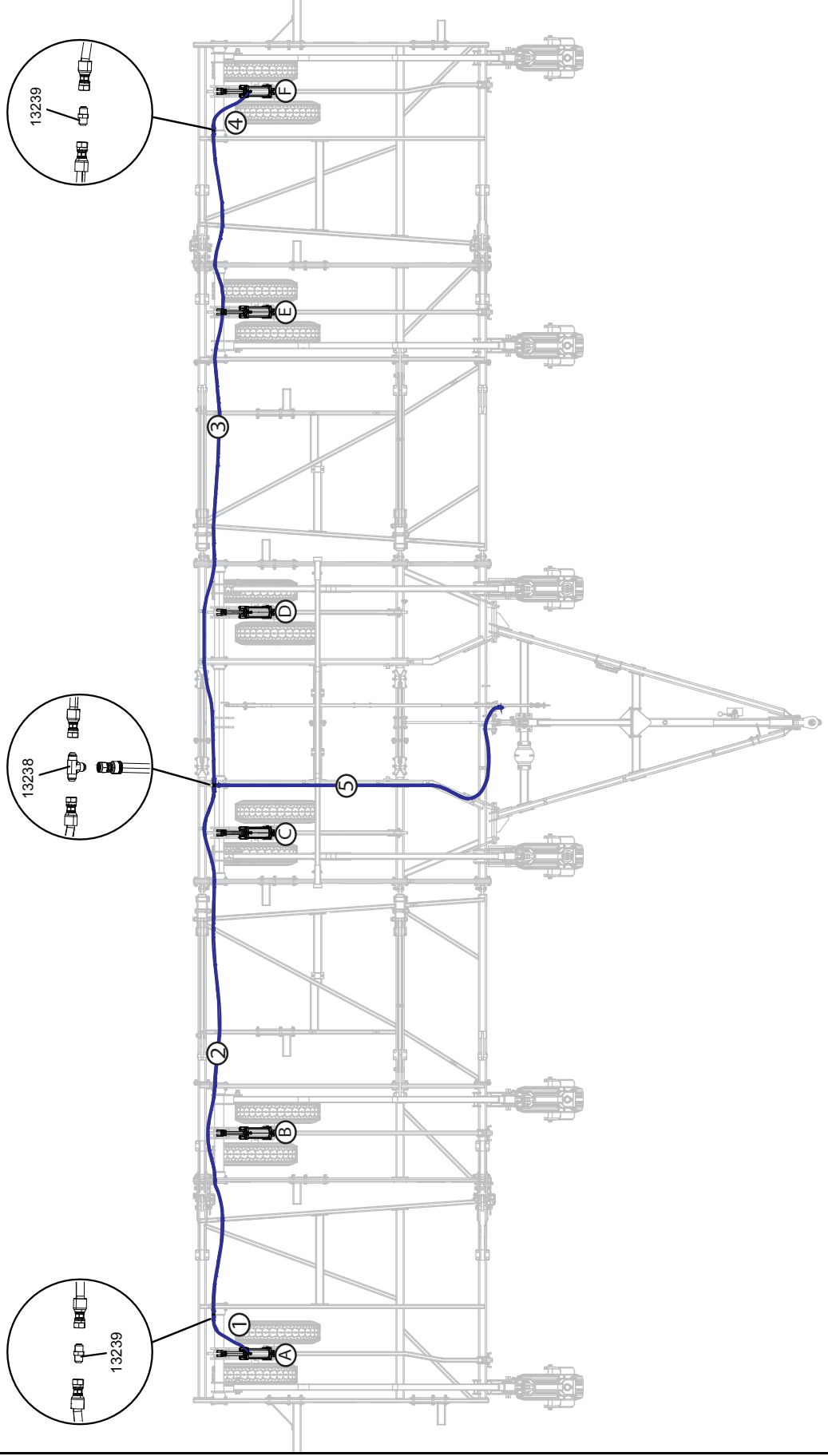
Hose	Part No.
1	235386
2	67636
3	235388
4	56540
5	14644
6	13261
7	237155
8	13482
9	13265
10	235386
11	14850
12	15155
13	235388
14	234947
15	237155

Connect Hoses to Pilot Operated Check Valve

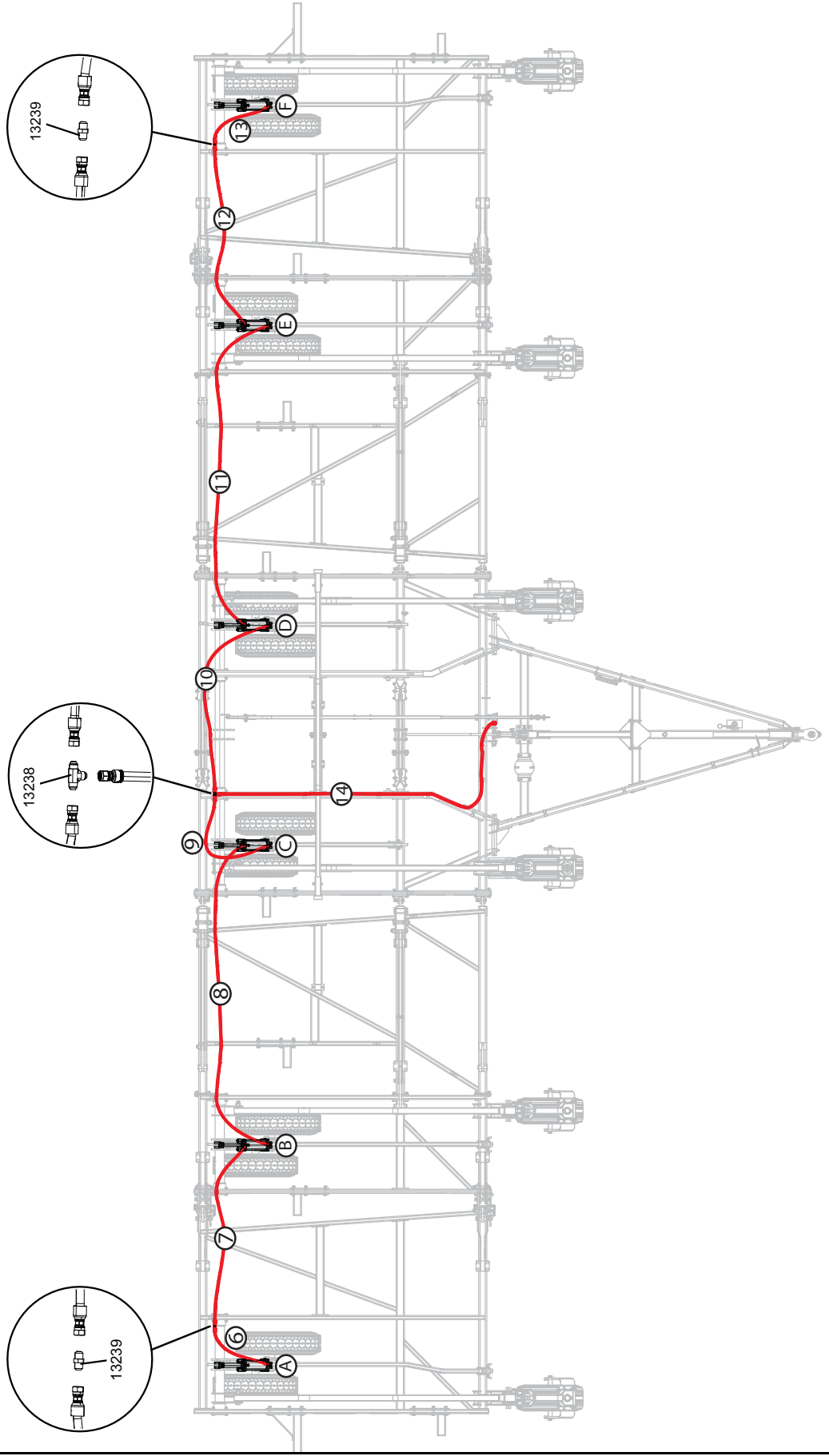


1. Install two straight fittings and one T-fitting on the pilot operated check valve.
2. Install two elbow fittings.
3. Attach the hoses to the fittings.
4. Route the two hoses attached to the elbow fittings to the front hitch and through the hydraulic hose holder.

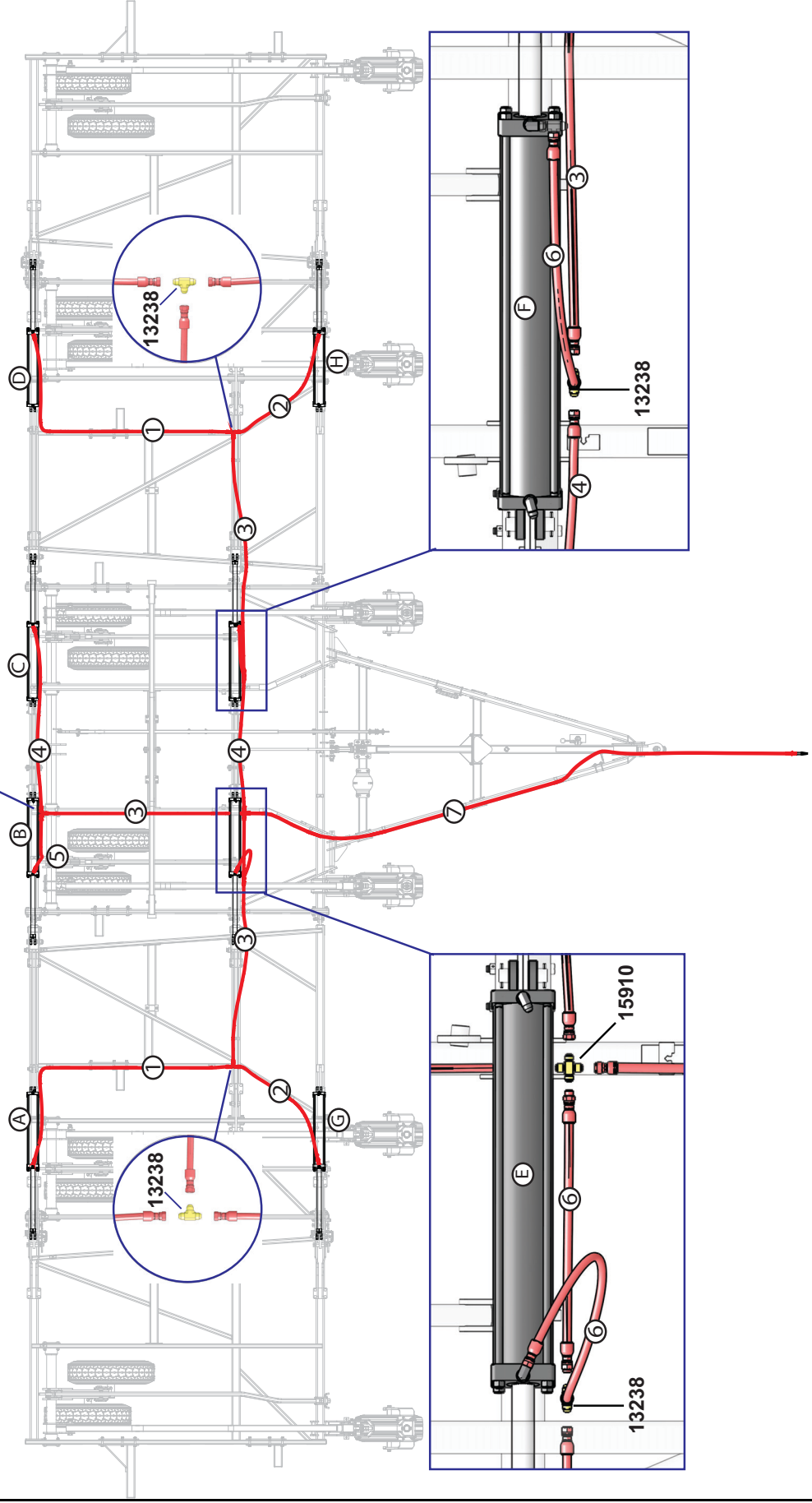
Install Lift Cylinder Fittings and Hoses (1)



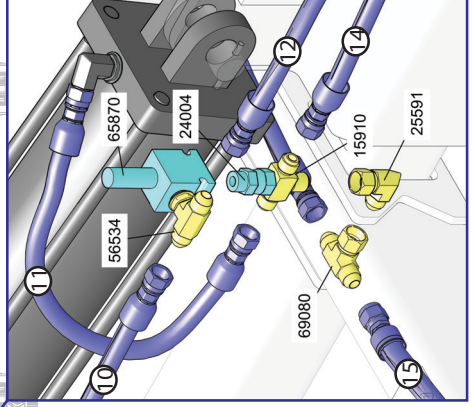
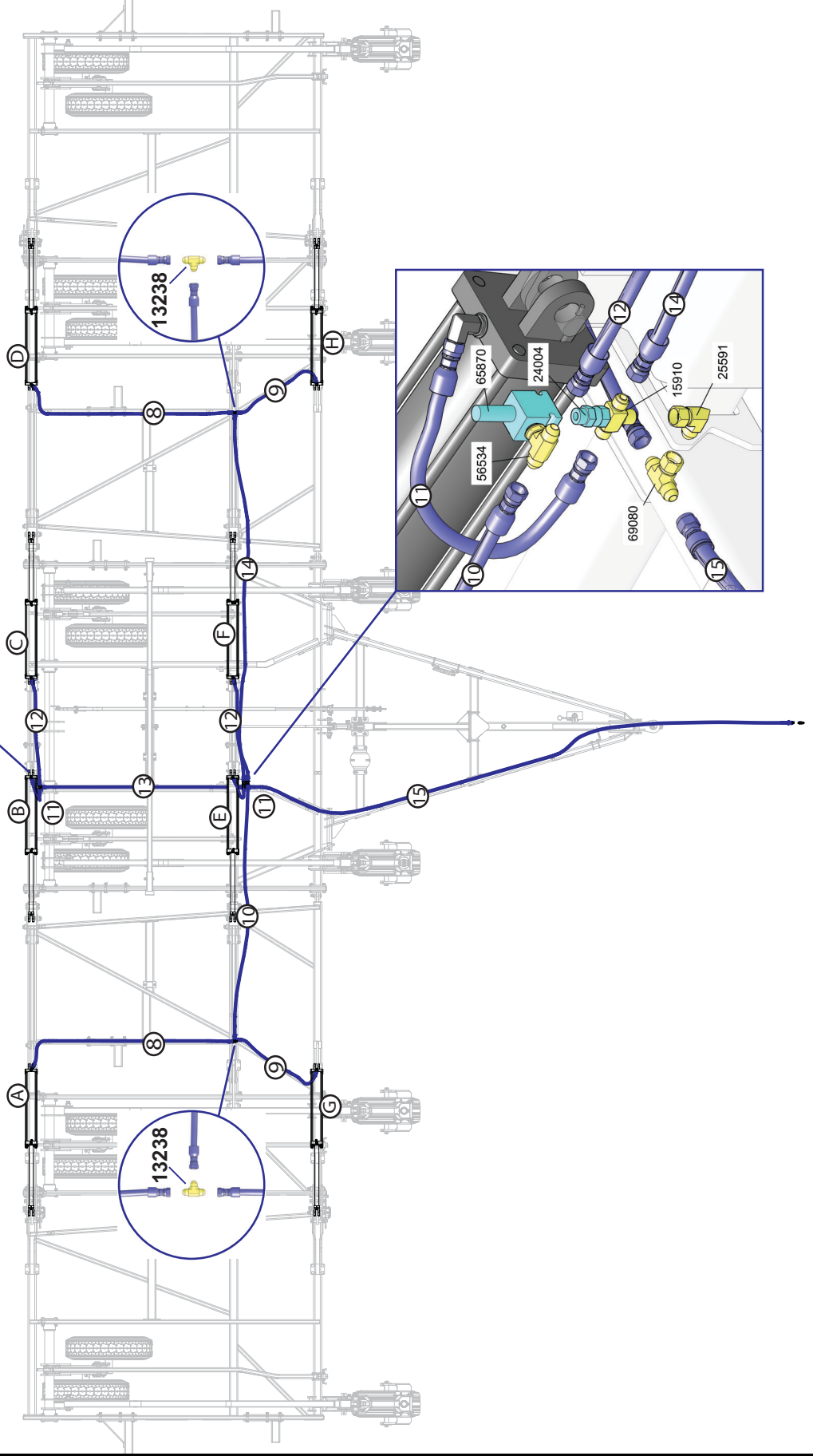
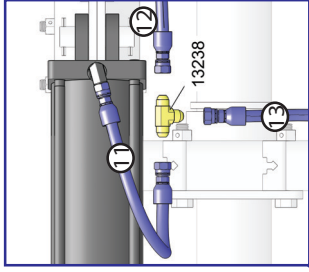
Install Lift Cylinder Fittings and Hoses (2)



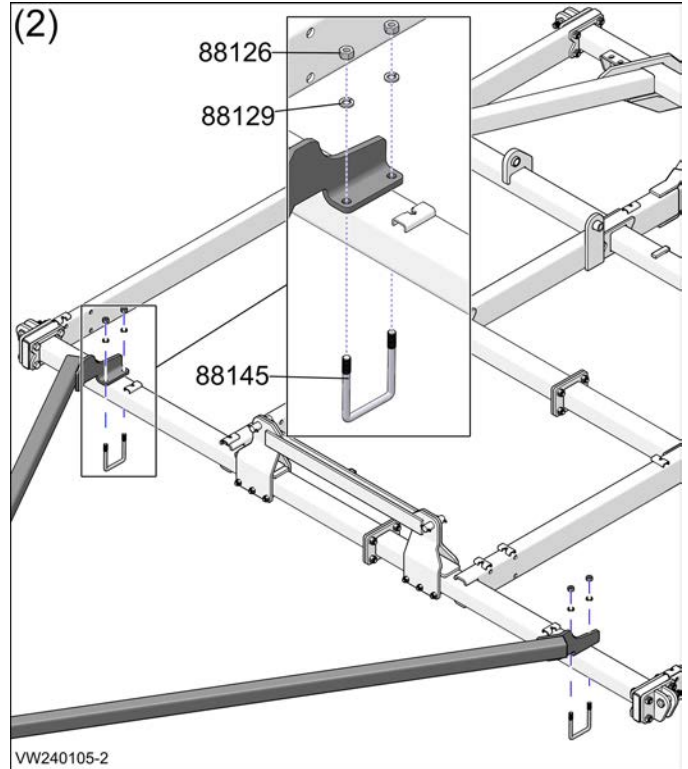
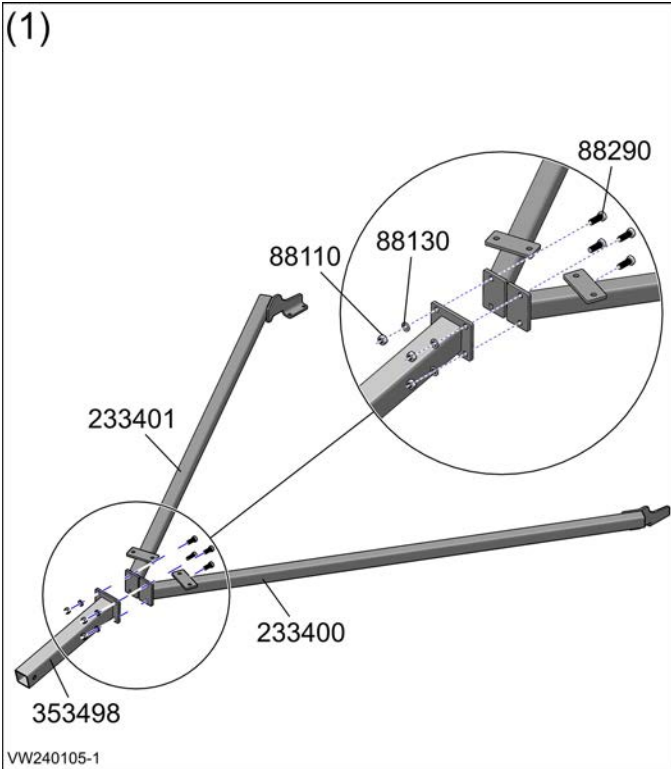
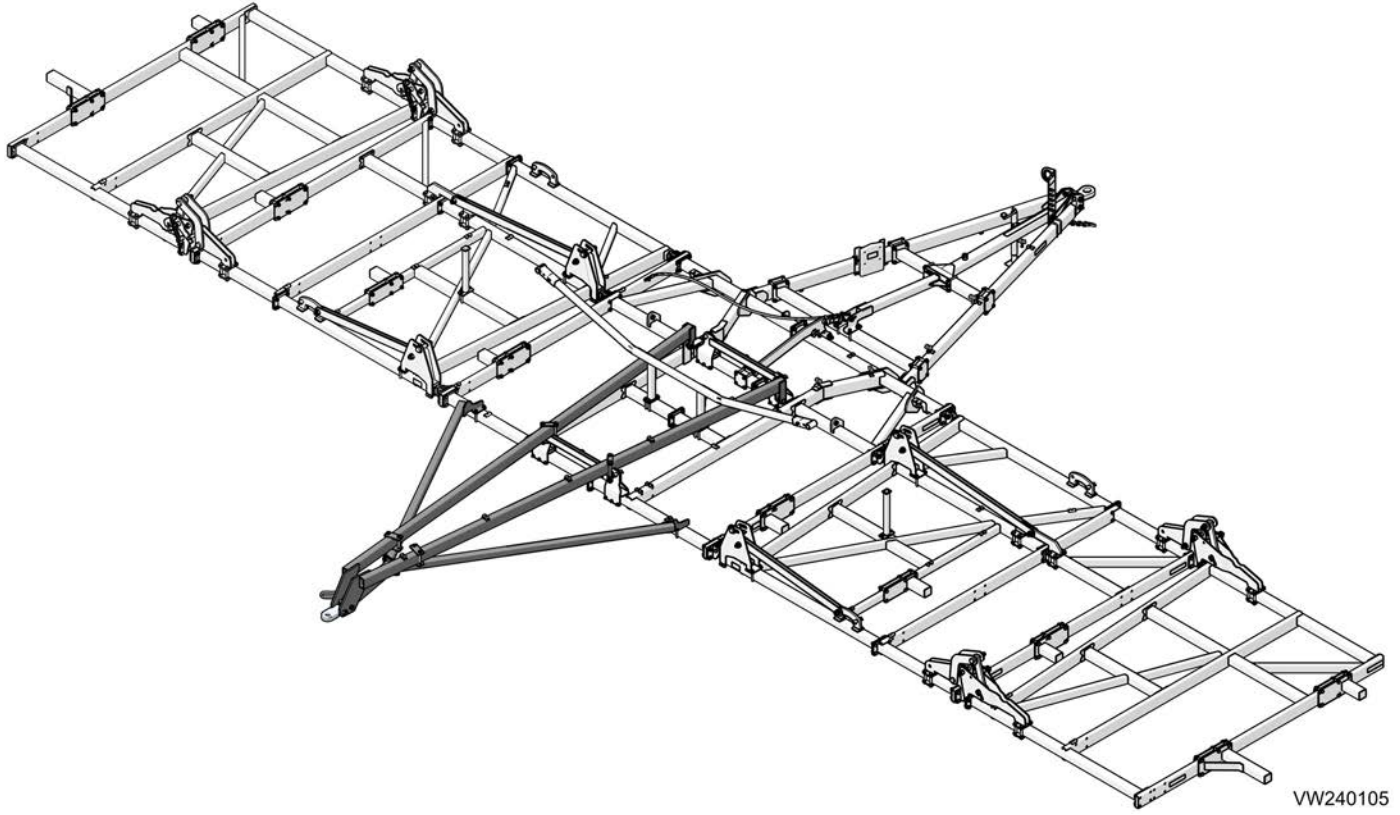
Install Fold Cylinder Fittings and Hoses (1)



Install Fold Cylinder Fittings and Hoses (2)

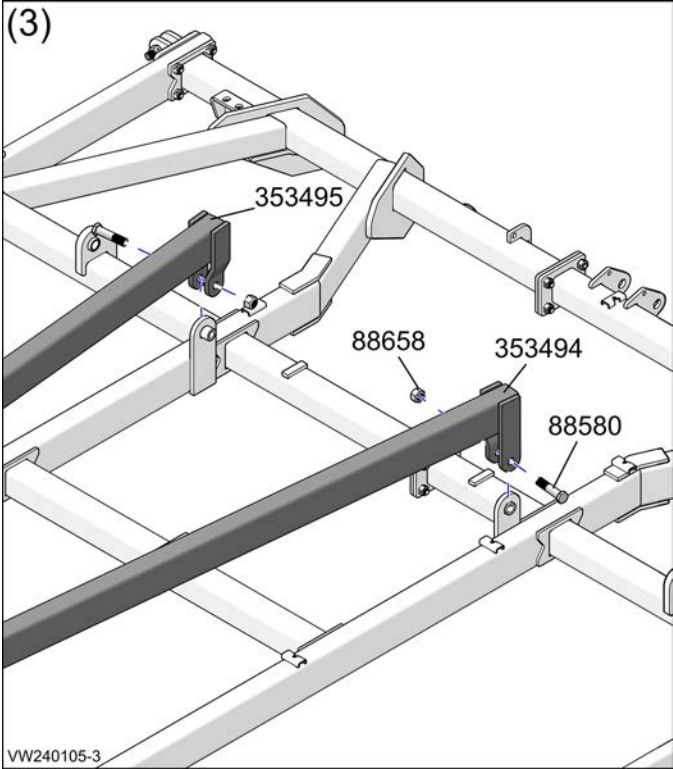


Install Rear Hitch (Chisel Plow)

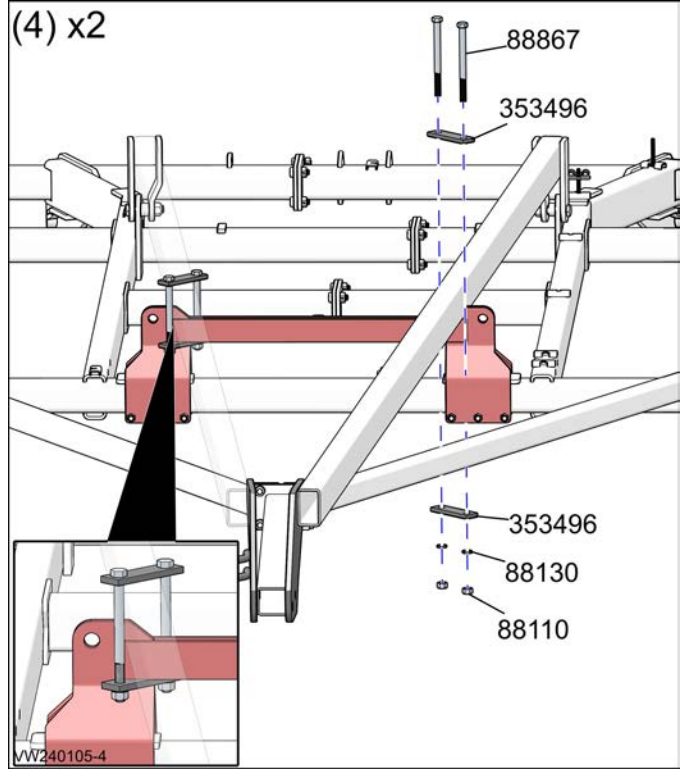


Install Rear Hitch (Chisel Plow)

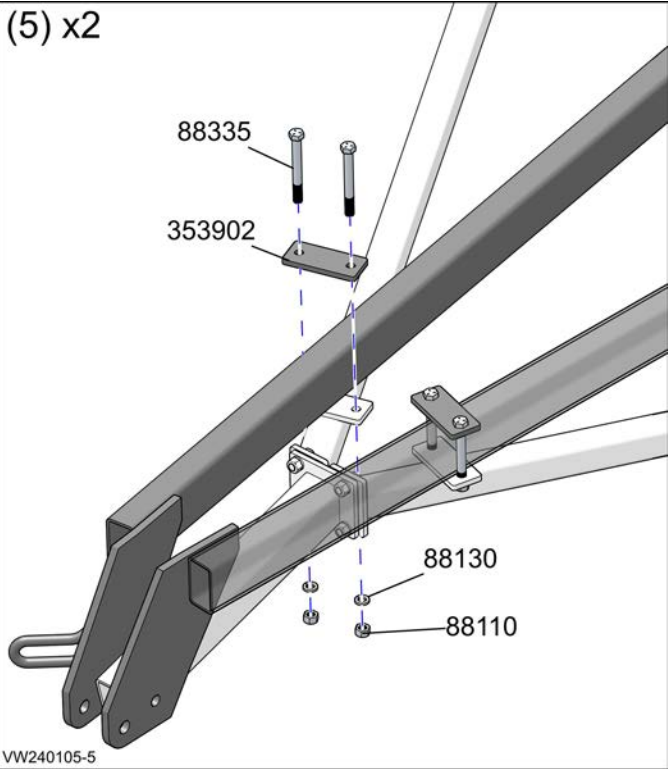
(3)



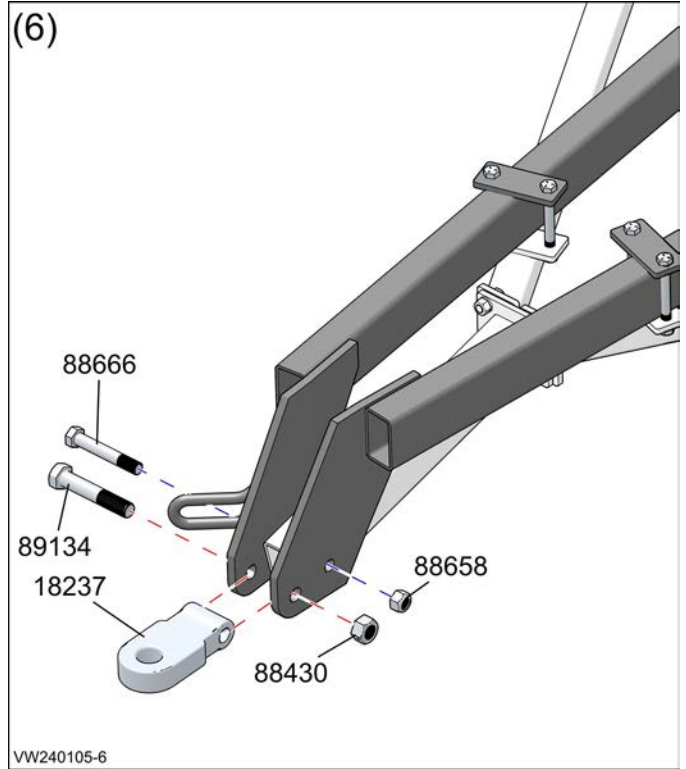
(4) x2



(5) x2



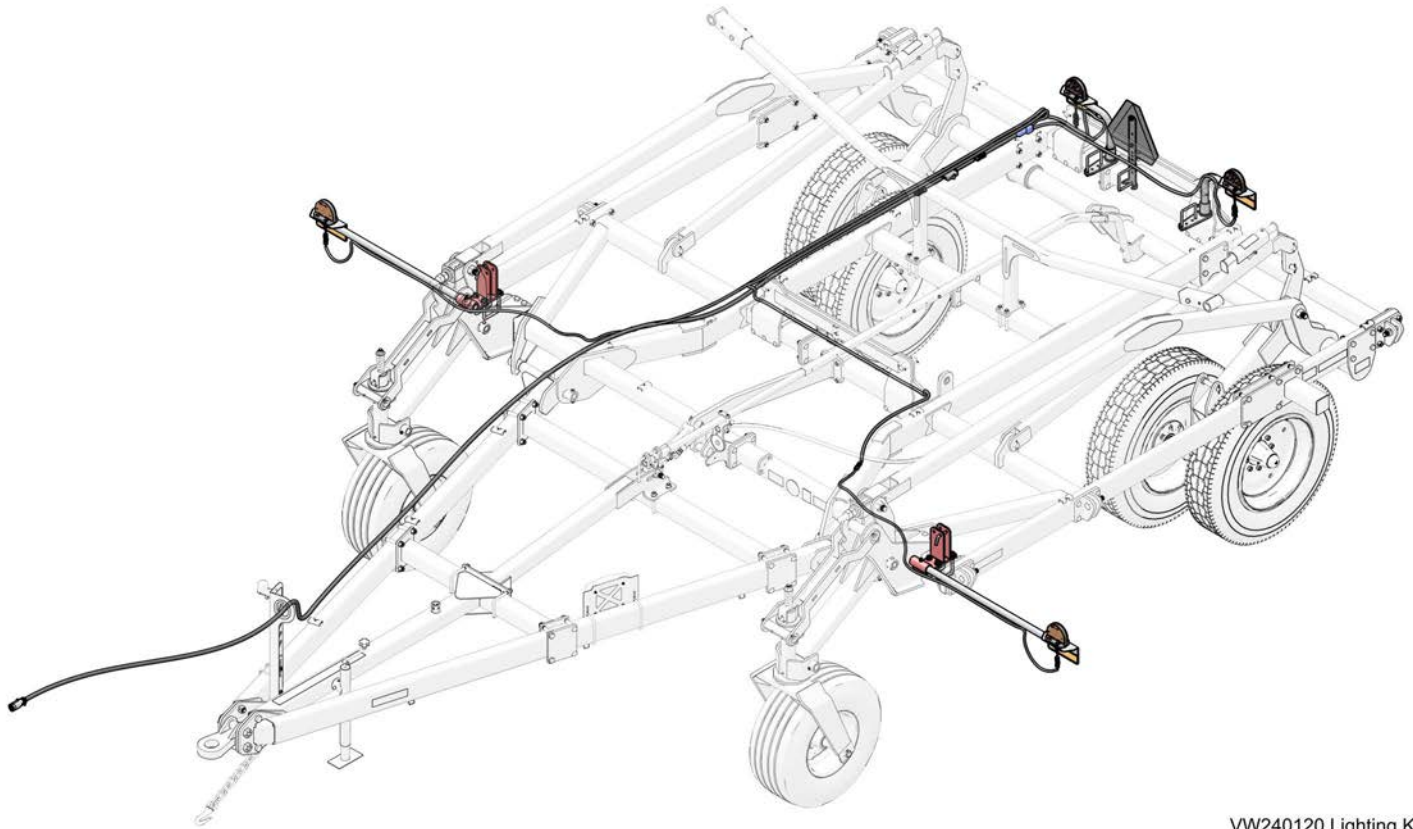
(6)



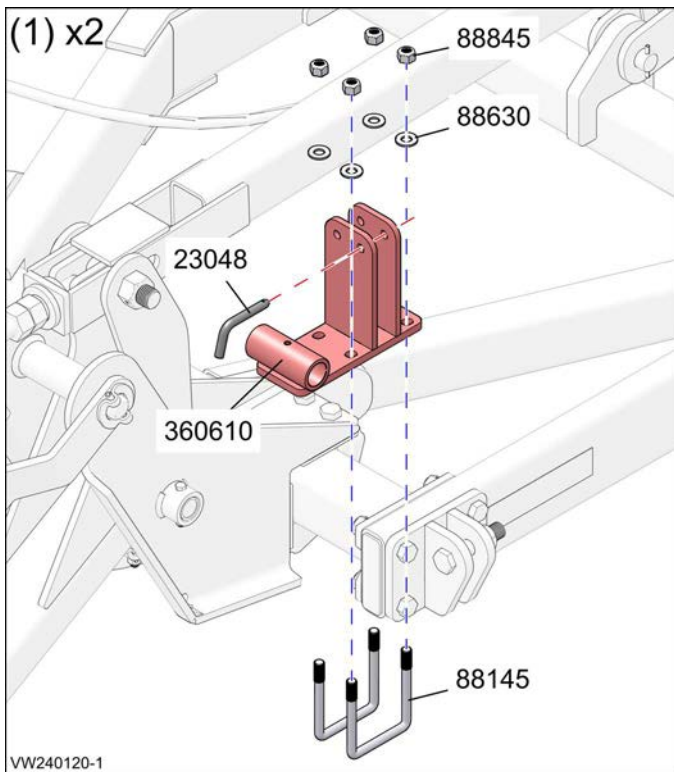
Install Rear Hitch (Chisel Plow)

1. Install the left and right outer hitch braces on the down tube with four bolts, washers and nuts.
2. Attach the assembly to the rear and center of the main frame with two u-bolts, and four washers and nuts.
3. Attach the left inner rear hitch tube and the right inner rear hitch tube to the main frame with two bolts and nuts.
4. Secure the inner hitch tubes to the flats on the main frame wing cylinder anchor with four 2x7 plates, four bolts and nuts.
5. Attach the rear hitch tubes to the outer hitch braces with two 3x7 tie plates, and four bolts, washers and nuts.
6. Attach the rear hitch tubes to the down tube with one bolt and nut.
Attach the cast hitch to the rear hitch tubes with one bolt and nut.

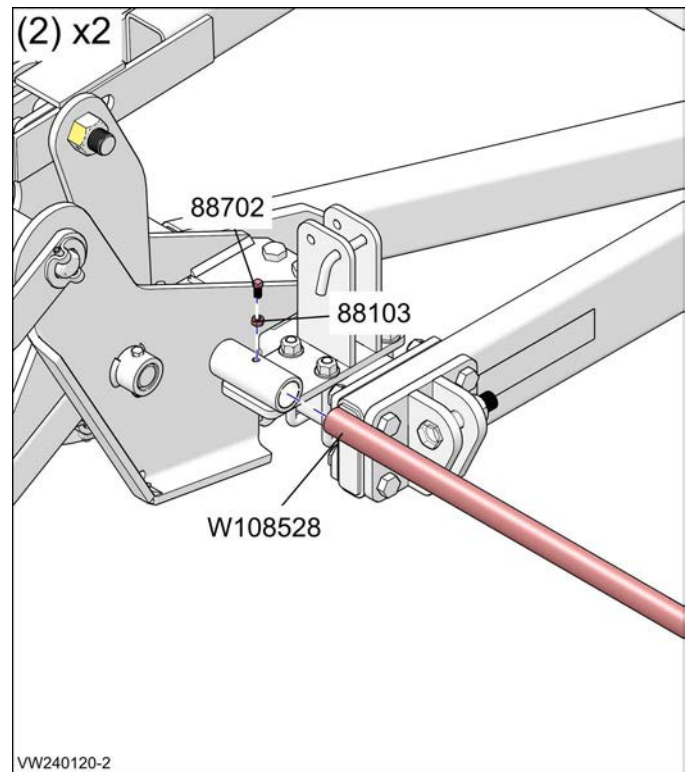
Install Lighting Kit (Chisel Plow)



VW240120 Lighting Kit



VW240120-1

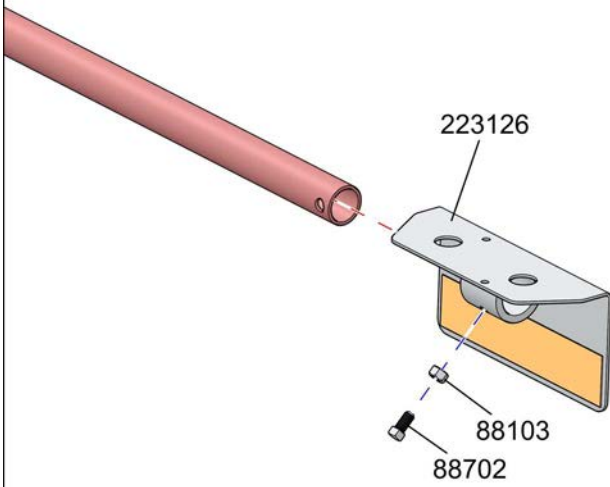


VW240120-2

Picture Note: Main frame installation shown. Part numbers shown may not be for your machine model. See the Packing List to confirm part numbers if needed.

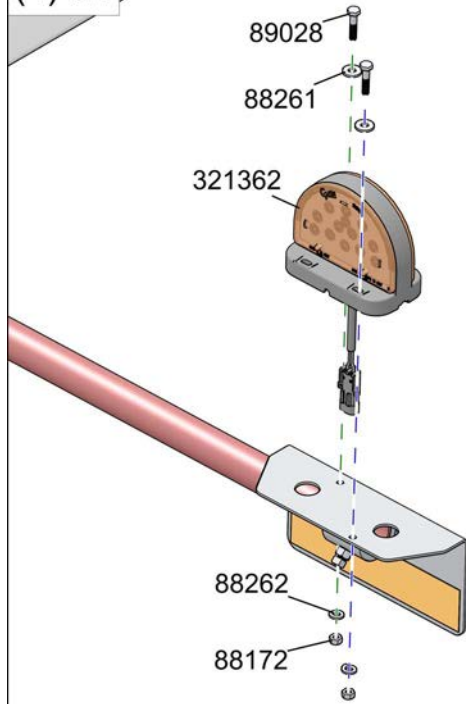
Install Lighting Kit (Chisel Plow)

(3) x2



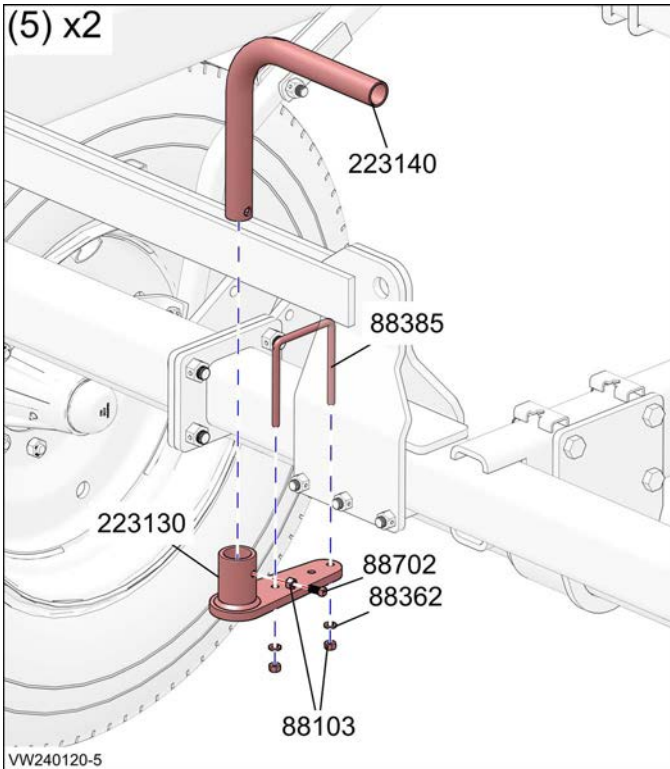
VW240120-3

(4) x2



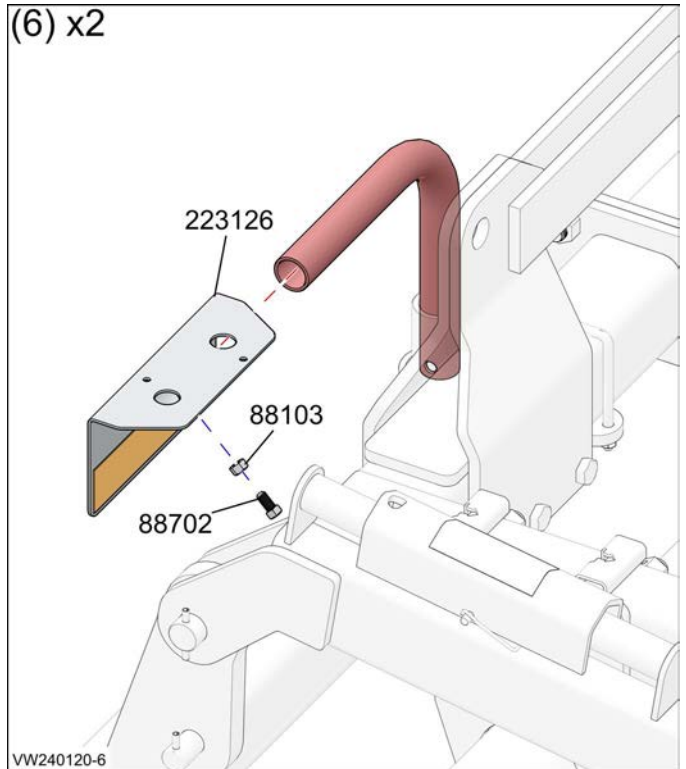
VW240120-4

(5) x2



VW240120-5

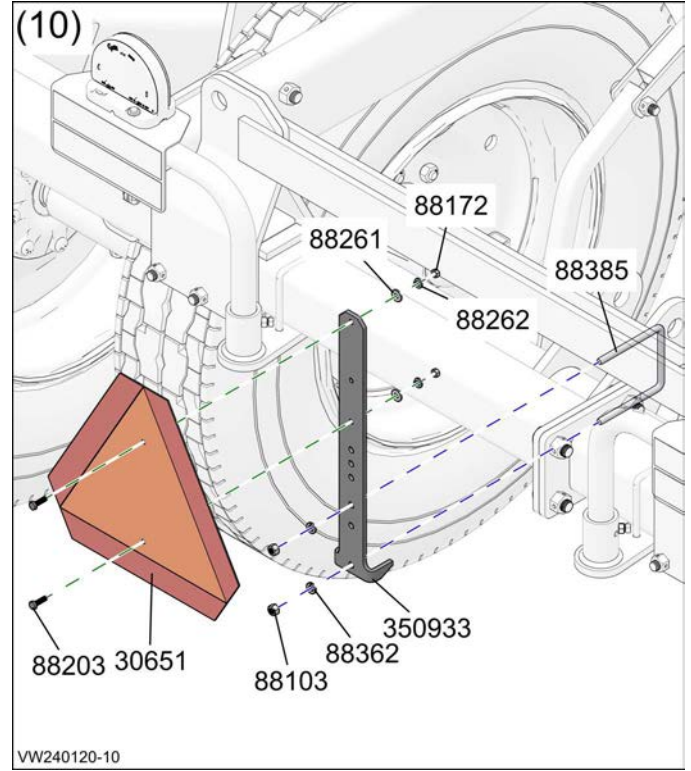
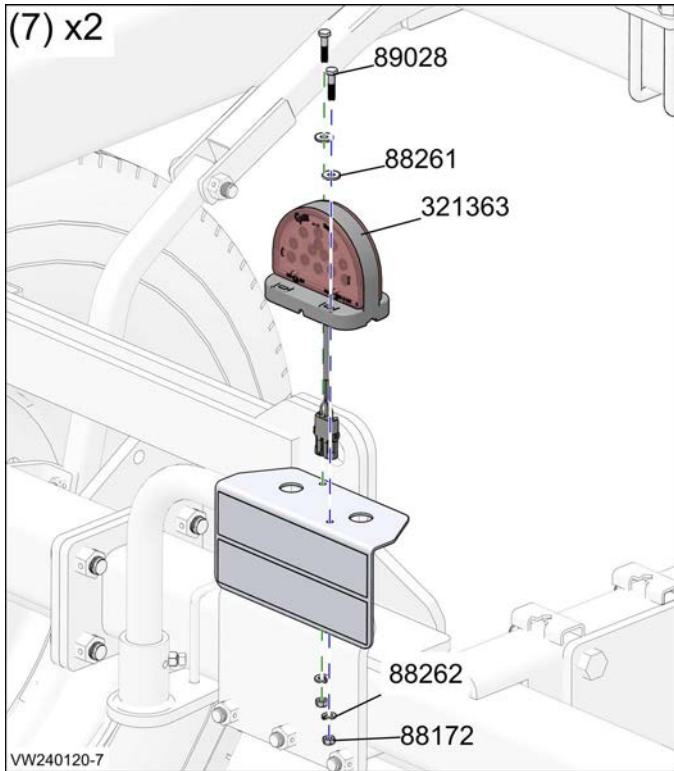
(6) x2



VW240120-6

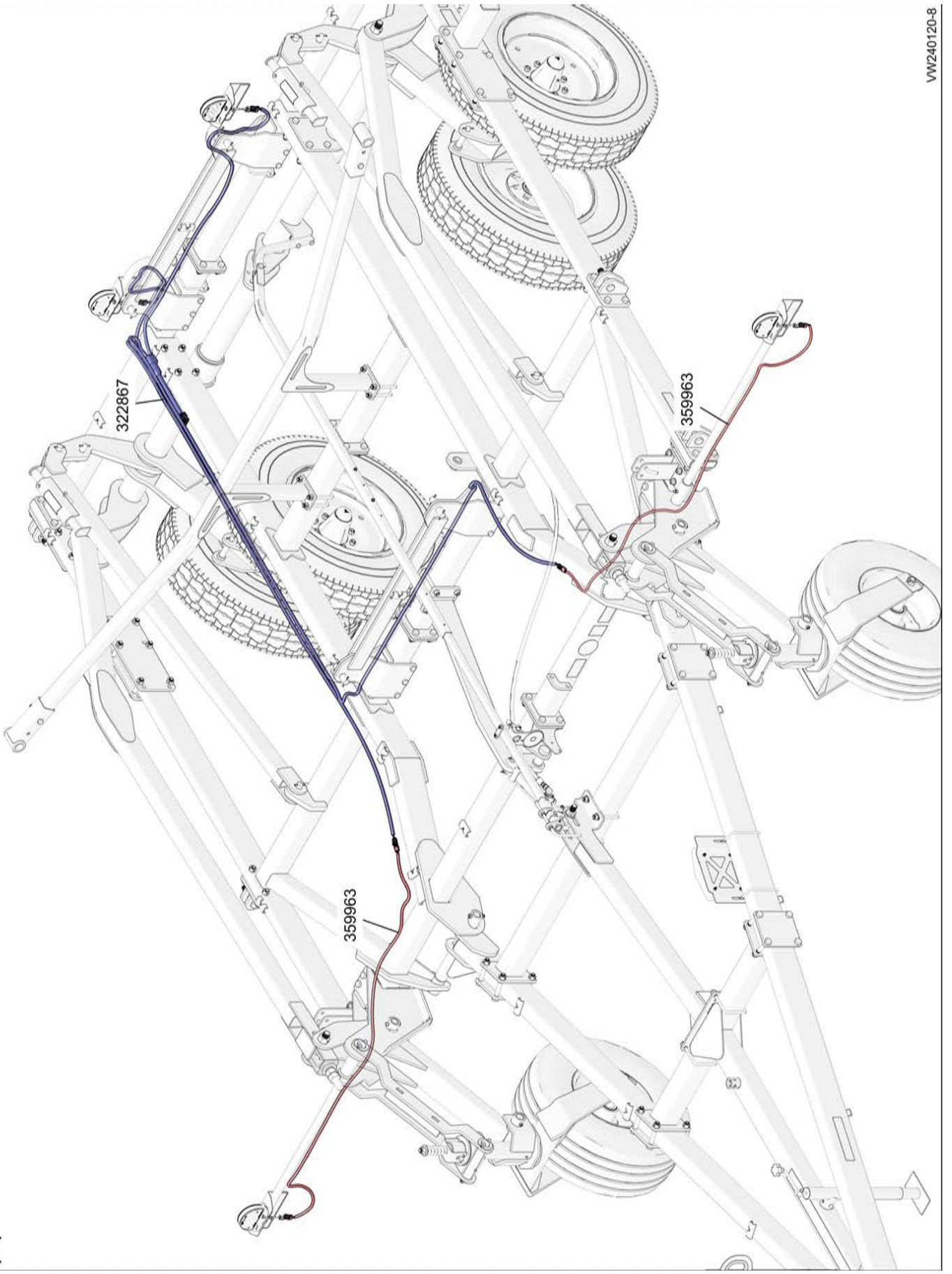
Picture Note: Main frame installation shown. Part numbers shown may not be for your machine model. See the Packing List to confirm part numbers if needed.

Install Lighting Kit (Chisel Plow)

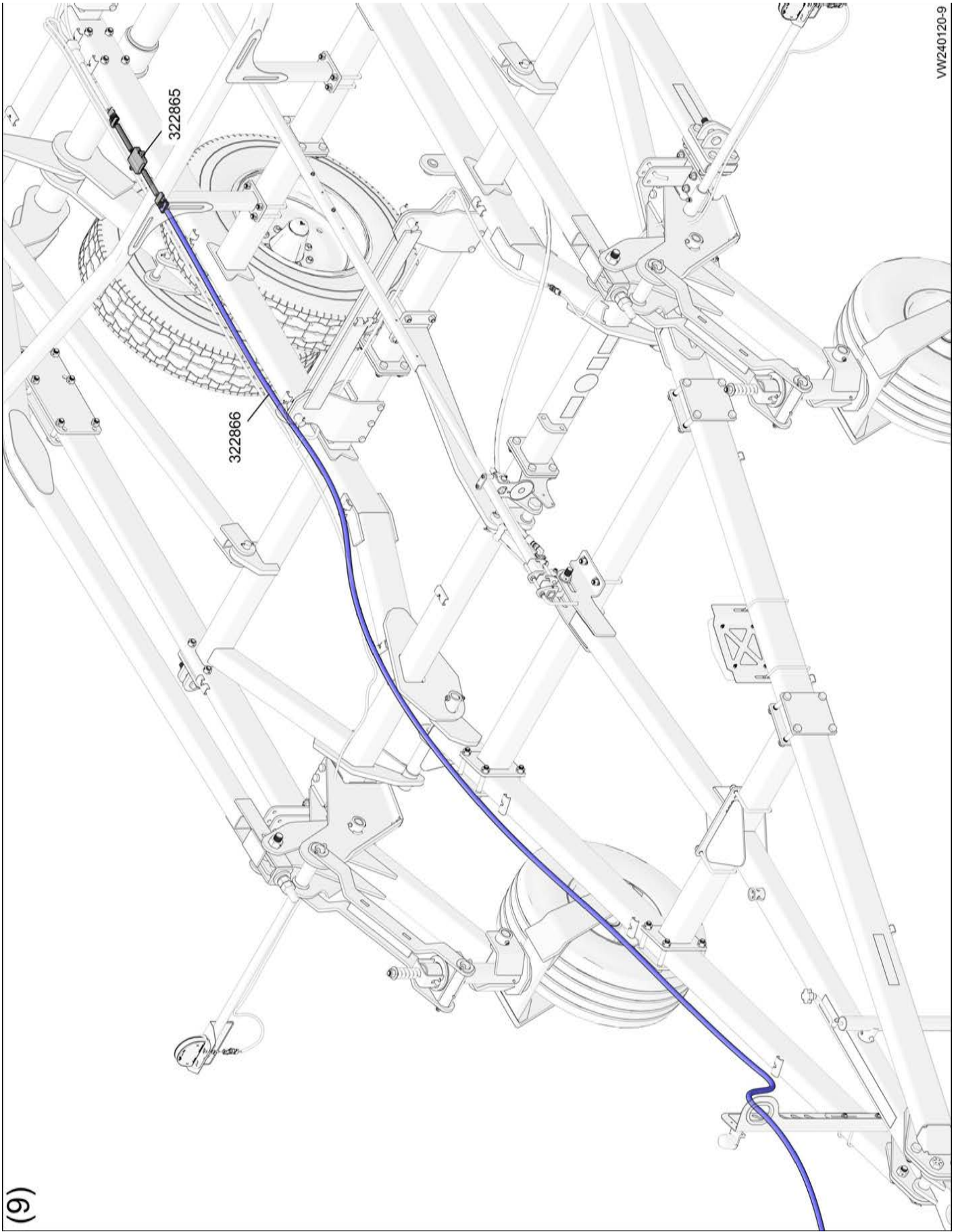


Picture Note: Main frame installation shown. Part numbers shown may not be for your machine model. See the Packing List to confirm part numbers if needed.

(8)



(9)

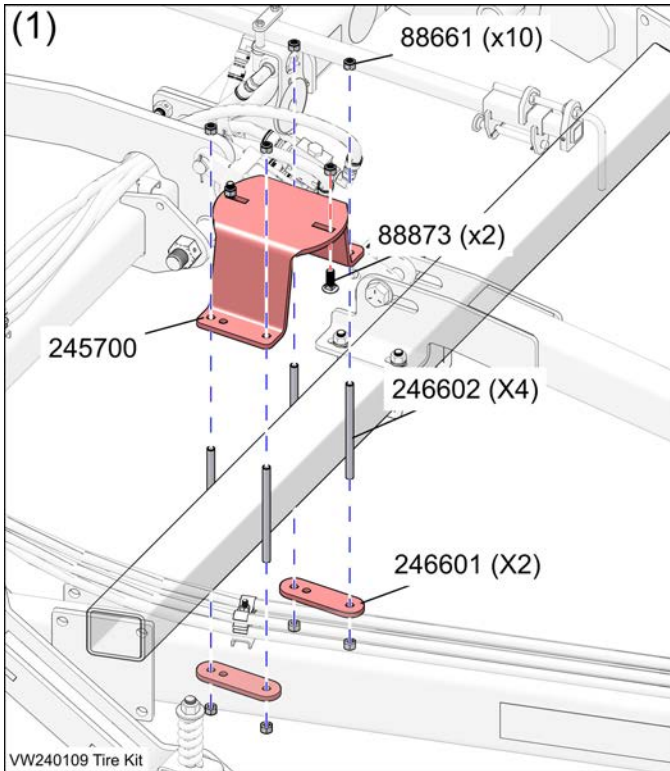


Install Lighting Kit (Chisel Plow)

Find small parts for assembly in packaging labeled C40, C40B, C40L.

1. Install the wing lock and light mount on the front corner of the main frame with two u-bolts, and four washers and nuts.
Install the hitch pin in the mount.
2. Install the light arm on the wing lock and light mount with one nut and set-screw.
3. Install the light/reflector bracket on the light arm with one nut and set-screw.
4. Install the amber hazard LED surf light on the bracket with two bolts, washers, lockwashers and nuts.
5. Install the short pivot base on the back of the main frame with one u-bolt, and two washers and nuts.
Install the light arm in the pivot base with one nut and set-screw.
6. Install the light/reflector bracket on the light arm with one nut and set-screw.
7. Install the red stop/tail LED surf light on the bracket with two bolts, washers, lockwashers and nuts.
8. Connect the wishbone AG light harness to the two red stop/tail LED surf lights and route the harness as shown.
Connect the two harnesses to the amber hazard LED surf lights and route the harnesses as shown to connect to the wishbone AG light harness.
9. Attach the flasher interface module to the AG light harness.
Attach the main AG light harness to the module and route to the front of the machine through the hydraulic hose holder channel.
10. Install the SMV bracket on the back of the main frame with one u-bolt, and two washers and nuts.
Install the SMV emblem on the bracket with two bolts, washers, lockwashers and nuts.

Install Spare Tire Kit (Chisel Plow)



Install Spare Tire Kit (Chisel Plow)

1. Attach the spare tire holder to the hitch frame with four threaded rods, two tire mount straps and eight nuts.
2. Install two bolts and nuts on the holder to secure the spare tire.