

Broce Broom

PARTS MANUAL



MODEL
MK-1



Serial Numbers
500079 thru 500080

Revision Date: 11/04/2004

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**Broce Manufacturing Company, Inc.
WARRANTY REGISTRATION**

Purchased From (Dealership)	
Company:	_____
Address:	_____
City:	_____ State: _____ ZIP: _____
Delivery Date to Dealer:	___ / ___ / ___ Unit Hours: _____
Model Number:	_____ Serial Number: _____

Purchaser	
Company:	_____
Address:	_____
City:	_____ State: _____ ZIP: _____
Delivery Date to Owner:	___ / ___ / ___ Unit Hours: _____

Purchaser - Type of Business			
Construction/Highway	Rental	Asphalt Contractor	
Equipment Dealer	Municipality	Other	

1. *The Purchaser has been instructed and/or has read the manual and understands proper preventive maintenance, operation and safety precautions.*
2. *The Warranty and Limitations of Liability are found in the Warranty pages enclosed in the Parts and Operators Manuals.*
3. *Broce Manufacturing Co. Inc. reserves the right to make design changes or modifications to Broce products at any time without incurring any obligation to make similar changes or modifications to previously sold units.*
4. *If this Document is not signed and returned to Broce Manufacturing Co. Inc., the warranty begins at the date of delivery to the Dealership.*

I hereby acknowledge acceptance of above and conditions in the Warranty Policy

Purchaser/Owner: _____

Dealer Representative: _____

Broce Manufacturing Co. Inc.
1460 South 2nd Avenue
Dodge City, KS 67801
(877) 227-8811

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BROCE MANUFACTURING COMPANY

BROCE BROOM LIMITED TWELVE MONTH WARRANTY

For a period of twelve (12) months or 1,000 hours whichever comes first, from the date of delivery of product to the original user, Broce Manufacturing of Dodge City, Kansas warrants each product to be free from manufacturing defects, subject to the limitations contained in this policy. This limited warranty covers parts and labor.

This warranty does not apply to defect caused, in whole or in part, by unreasonable use while in the possession of the user, including, but not limited to, failure to properly set up product, failure to provide reasonable and necessary maintenance, normal wear, routine tune ups or adjustments, improper handling, accidents, operation at speed or load conditions contrary to published specifications, improper or insufficient lubrication, or improper storage. This warranty is not a guarantee that the performance of each product will meet the expectations of the purchaser.

Broce Manufacturing shall not be liable for consequential damage of any kind, including, but not limited to: consequential labor costs or transportation charges in connection with the replacement or repair of defective parts, lost time or expense which may have accrued because of said defects. In no event shall Broce Manufacturing's total liability hereunder exceed the product purchase price.

Many components used by Broce Manufacturing are subject to the warranties of their respective manufacturers. These warranties will be considered void if the product is modified or repaired in any way not expressly authorized, or if closed components are disassembled prior to return. Closed components include, but are not limited to gearboxes, hydraulic pumps, motors, cylinders and actuators.

Our obligation under the warranty is expressly limited, at our option, to the replacement or repair at Broce Manufacturing of Dodge City, KS or at a service facility designated by us. We are not responsible for unauthorized repairs or replacements. Any implied or statutory warranties, including any warranty of merchantability or fitness for a particular purpose, are expressly limited to duration of this written warranty. We make no other express warranty. This warranty cannot be extended, broadened, or changed except in writing by an authorized officer of Broce Manufacturing. Broce Manufacturing reserves the right to make changes or improvements in its products in the future without incurring obligations to make these changes and improvements to products previously supplied.

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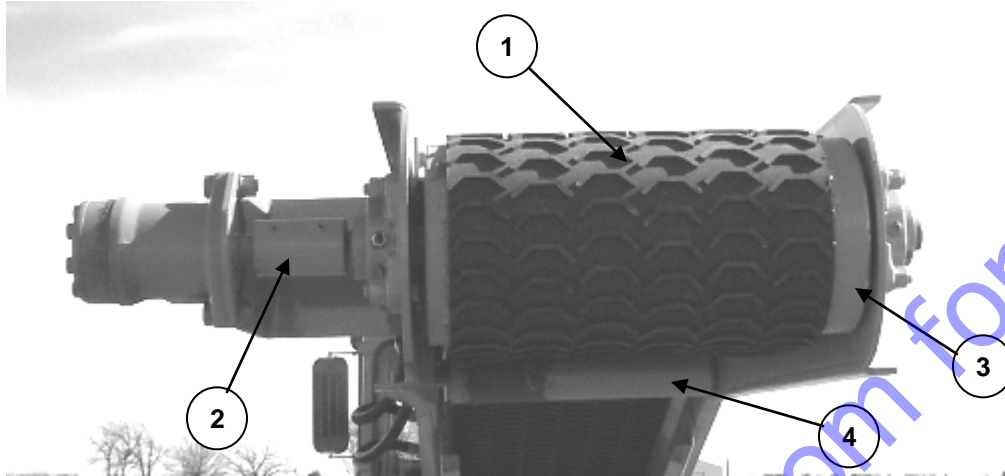
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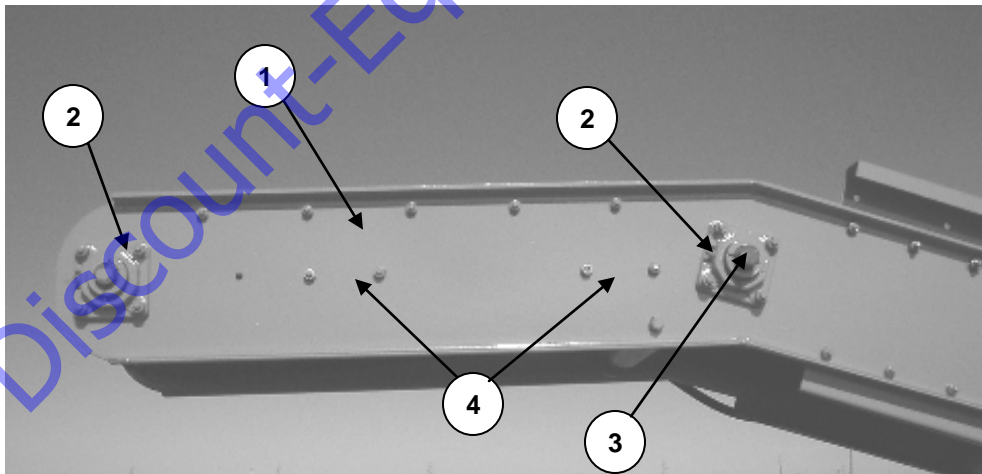
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BELT CONVEYOR - TOP END VIEW



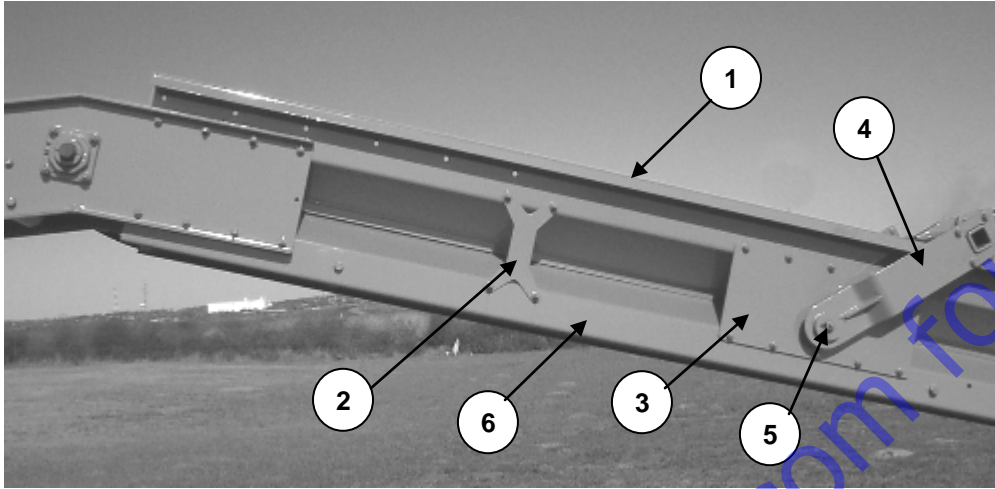
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	320617	Conveyor Belting, 12" x 33' 4"	1
2	205076	Conveyor Drive Coupling	1
3	320601	Head Pulley w/ Shaft	1
4	320622	Return Rollers	4

BELT CONVEYOR - TOP LEFT SIDE



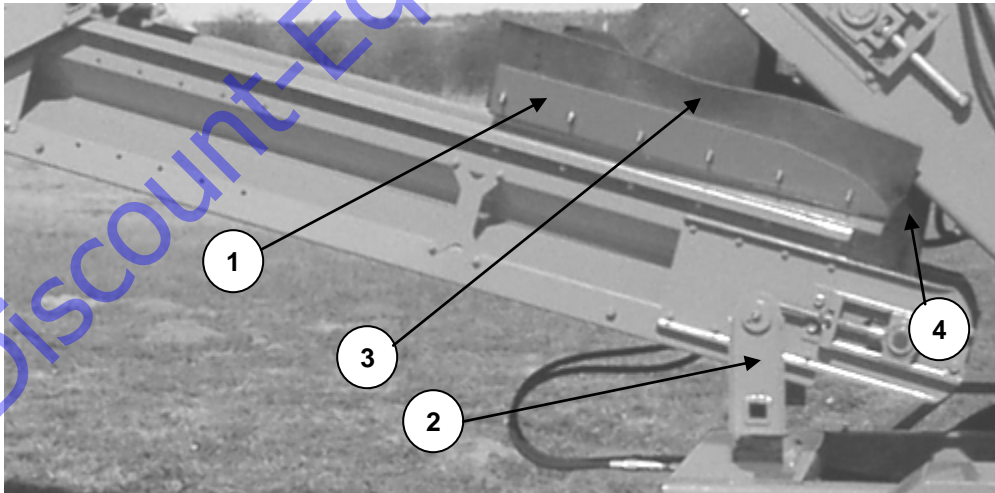
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205084	LH Upper Side Frame, 17.5°	1
2	320600	Head and Center Conveyor Bearings	4
3	320602	Center Wing Pulley w/ Shaft	1
4	205082	Conveyor Cross Member	2

BELT CONVEYOR – MIDDLE LEFT SIDE



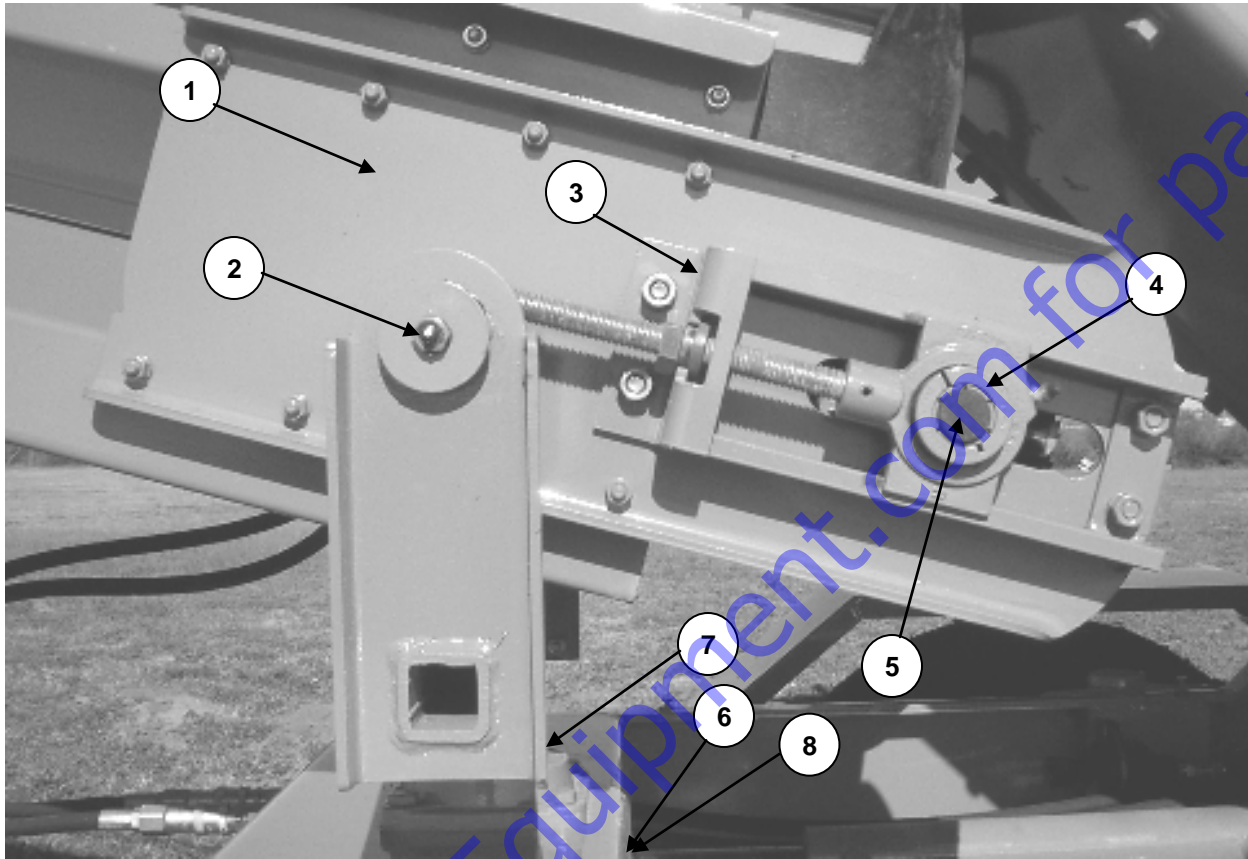
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205061	Upper Side Sheet	2
2	205060	Side Gusset	4
3	855066	Center Side Plate w/ bushing	2
4	855067	Lift Side Bracket	2
5	205086	1/2" x 1" Cap Screw w/ Zerk, LH & RH	2
6	205063	Return Sheet	1

BELT CONVEYOR – LOWER LEFT SIDE



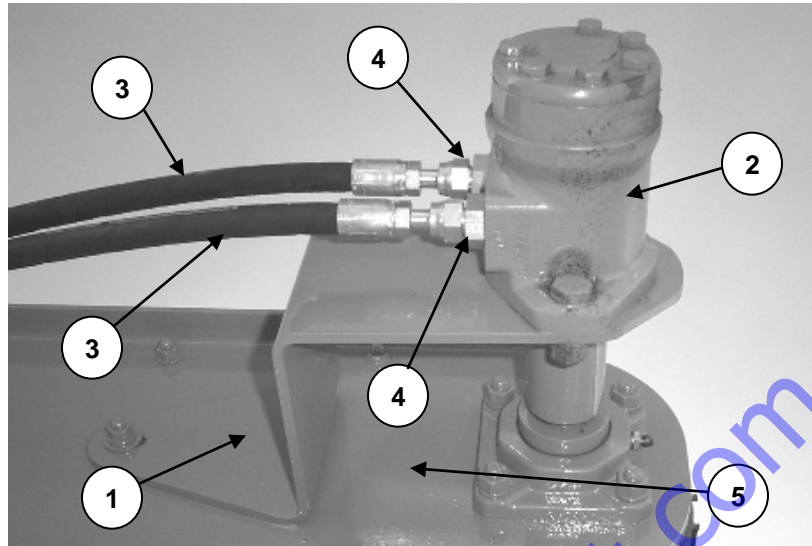
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205062	Lower Deflector, LH	1
2	855050	Belt Conveyor Cross Tube w/Left Side Support & Shaft	1
	205241	Shaft Sleeve Adapter for MK1 with S/N 5000XX and below	1
3	205229	Belt Conveyor Wing Rubber	2
4	205230	Lower Belt Conveyor Rubber	1

BELT CONVEYOR – BOTTOM LEFT SIDE



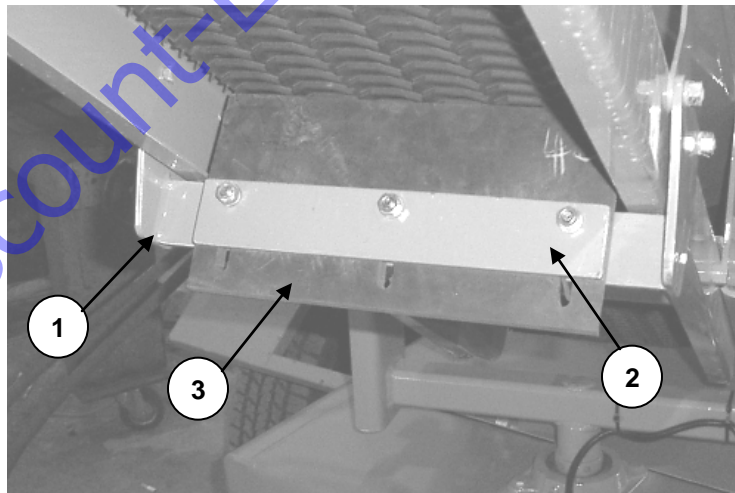
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855077	Take-Up Side Plate – Lower, LH	1
2	205086	1/2" x 1" Cap Screw w/ Zerk, LH & RH	2
3	320604	Lower Take-up Frame	2
4	320605	Lower Take-up Bearing	2
5	320603	Wing Pulley w/ Shaft	1
6	320611	Swing Bearing, Lower	1
7	320636	Swing Bearing, Upper	1
8	320634	Taper Lock	1

BELT CONVEYOR - TOP RIGHT SIDE



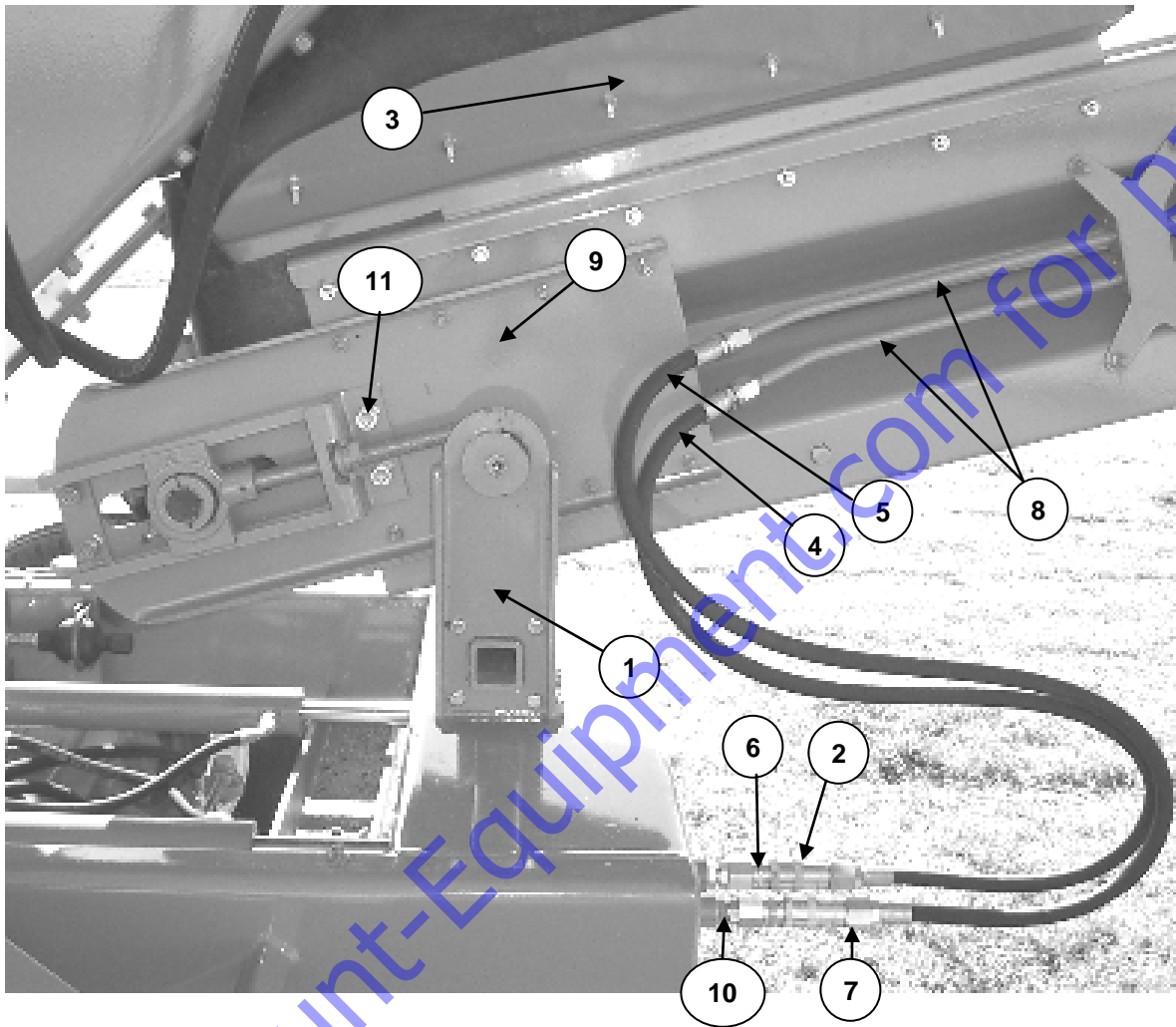
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205078	Conveyor Hydraulic Motor Mount	1
2	325008	Belt Conveyor Motor	1
3	N/A	Hydraulic Hose Assembly, 52" – 1AA8MR6 & 1AA6FR6	2
4	N/A	Hydraulic Adapter Fitting – FF1852T0610S	2
5	205083	RH Upper Side Frame, 17.5°	1

BELT CONVEYOR – BELT CLEANER



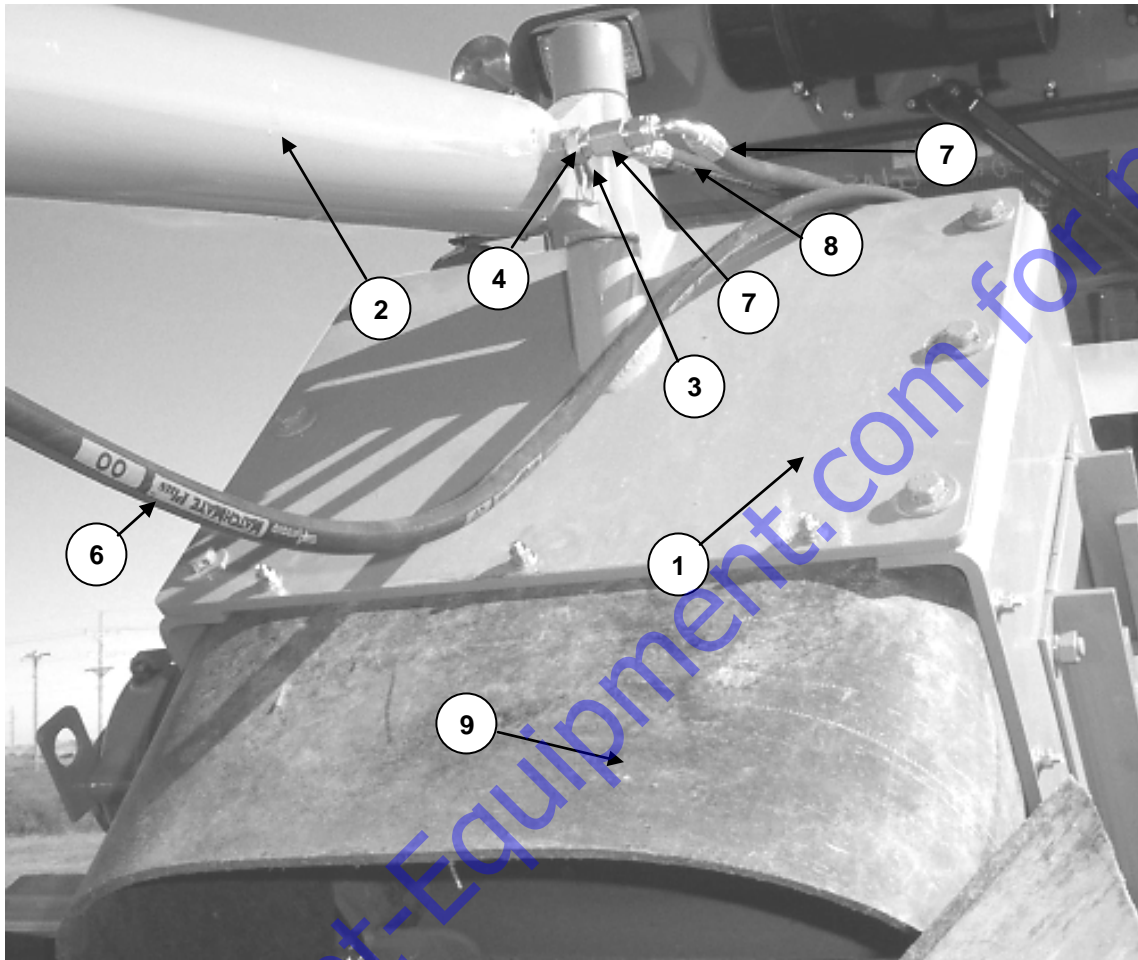
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855233	Belt Conveyor Cross Member	1
2	205235	Belt Conveyor Cleaner Blade Retainer	1
3	205232	Belt Conveyor Cleaner Blade	1

BELT CONVEYOR – BOTTOM RIGHT SIDE



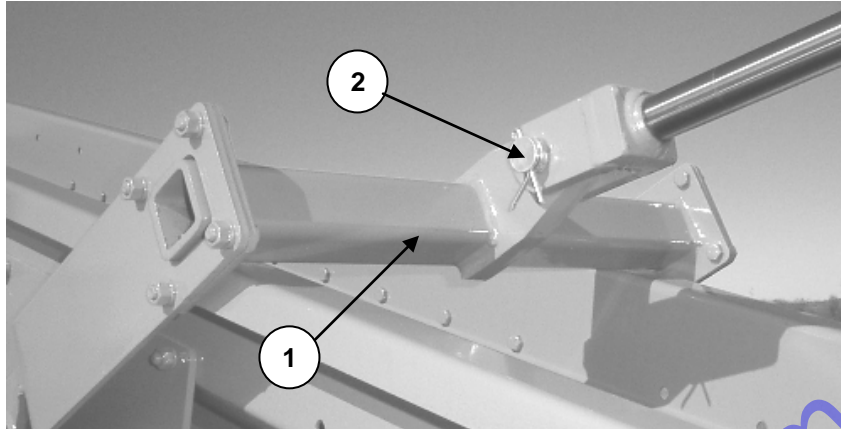
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855052	Right Side Support Bracket w/ Bushing	1
2	N/A	Quick Coupler – Female FD49-1005-08-06	2
3	205064	Lower Deflector, RH	1
4	N/A	Hydraulic Hose Assembly, 46" – 1AA8MB6 & 1AA8MR6	1
5	N/A	Hydraulic Hose Assembly, 44" – 1AA8MB6 & 1AA8MR6	1
6	N/A	Quick Coupler – Male FD49-1004-08-06	2
7	N/A	Hydraulic Adapter, 3474-08-08	2
8	N/A	Steel Hydraulic Line – 114"	2
9	855088	Take Up Side Plate - Lower, RH	1
10	N/A	Hydraulic Fitting	2
11	320604	Rear Belt Conveyor Cross Member	1

BELT CONVEYOR – LIFT CYLINDER MOUNT



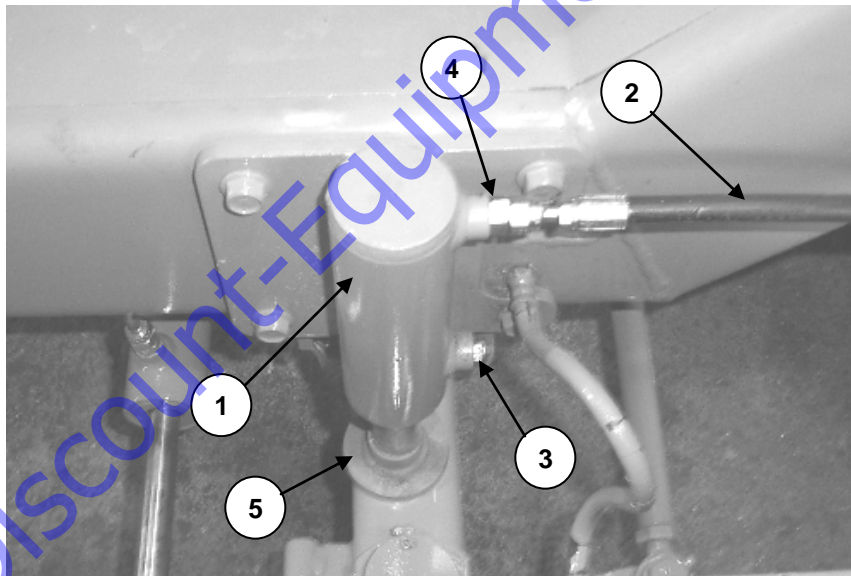
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855030	Bottom Lift Support w/ Bushings & Shaft	1
2	325012	Belt Conveyor Lift Cylinder, 3" x 29 5/8"	1
3	RC-19	Cylinder Pin	1
4	N/A	Hydraulic Fitting, FF1868T0406S	2
5	N/A	Hydraulic Hose Assembly, 115" – 1AA4FR4 & 1AA6FRB4	1
6	N/A	Hydraulic Hose Assembly, 84" – 1AA4FR4 (2)	1
7	N/A	Hydraulic Adapter Tee, FF1865T0406S	1
8	N/A	Hydraulic Hose Assembly, 52" – 1AA4FRB4 (2)	1
9	205231	Slat Conveyor Discharge Deflector (Rubber)	1

BELT CONVEYOR – LIFT CROSS TUBE



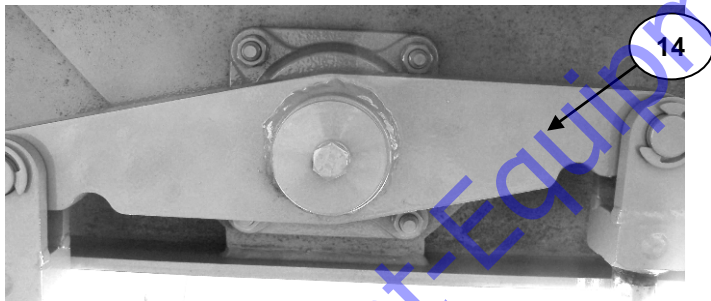
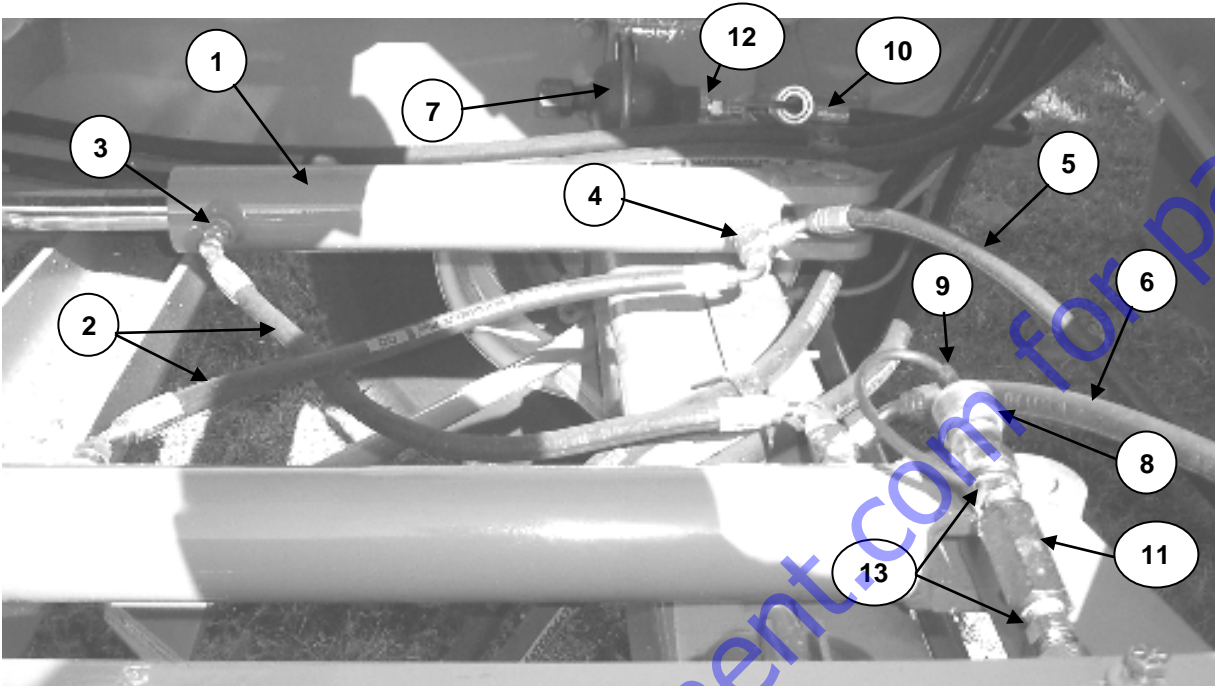
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855068	Belt Conveyor Lift Cylinder Cross Tube	1
2	RC-19	Cylinder Pin	1

LEVELING CYLINDER VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325023	Leveling Cylinder Assembly w/ Mount Plate, LH	1
	325022	Leveling Cylinder Assembly w/ Mount Plate, RH	1
2	N/A	Hydraulic Hose Assembly, 21" – 1AA4FR4 & 1AA6FR4	2
3	N/A	Vent, BV-SAE-6	2
4	N/A	Hydraulic Fitting, FF1852T0406S	2
5	855092	Leveling Cylinder Foot	2
NS	325029	Seal Kit for Leveling Cylinder	1
NS	K00025	Cylinder Charge Kit	1

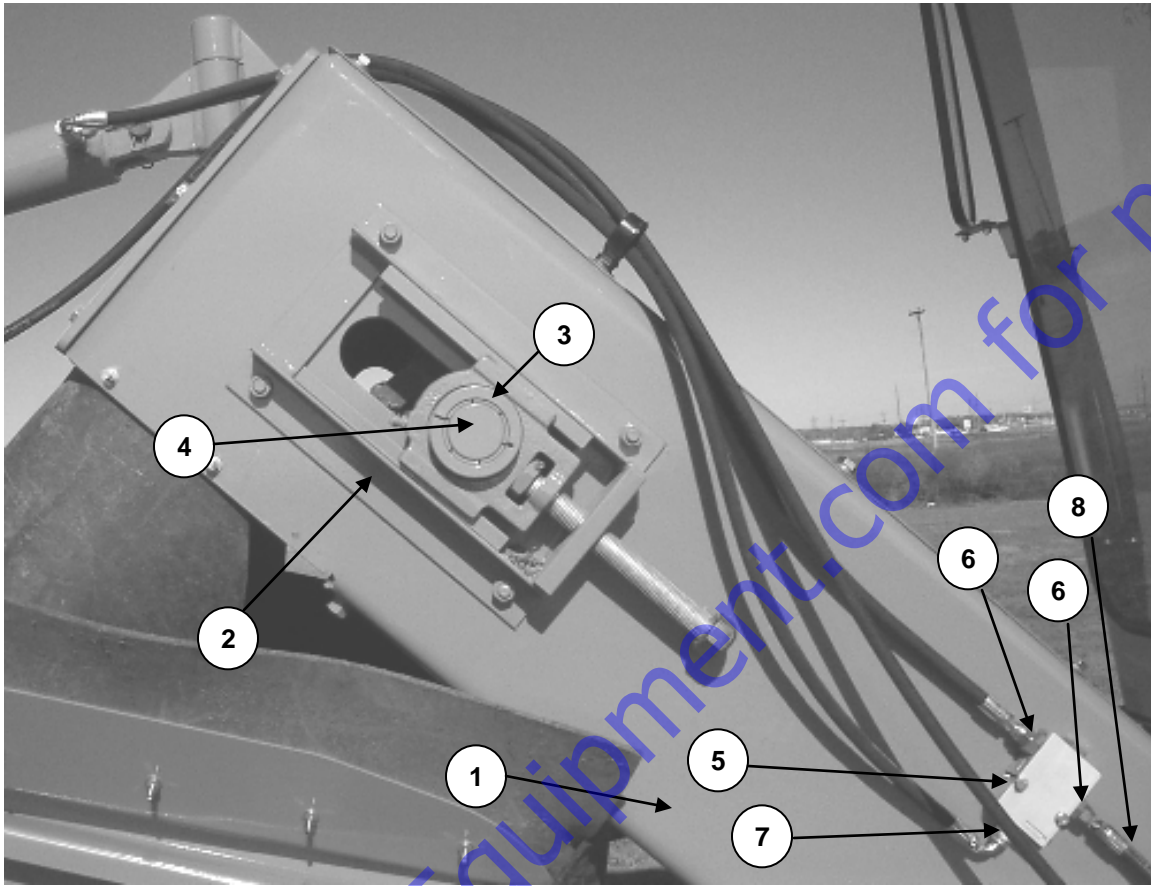
BELT CONVEYOR – PIVOT CYLINDER VIEW



UNDERSIDE VIEW

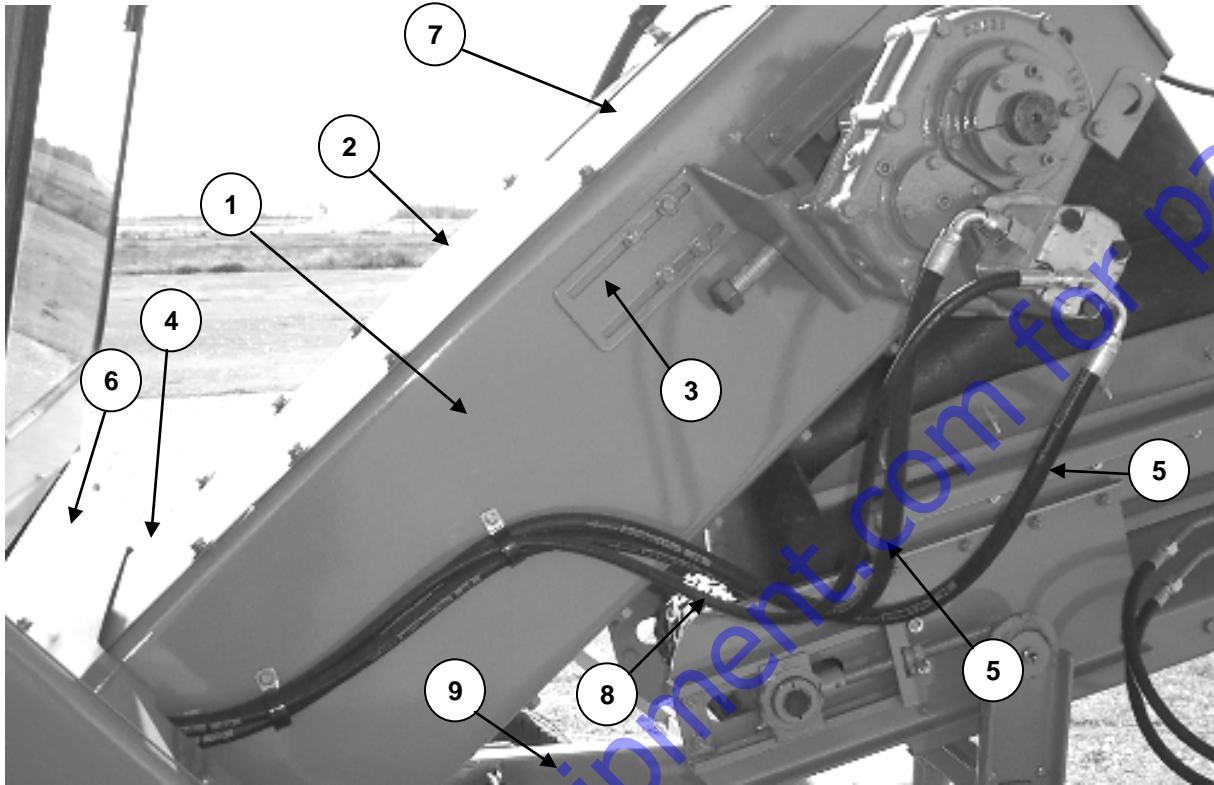
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325013	Swing Cylinder, 2" x 12"	2
2	N/A	Hydraulic Hose Assembly, 16" – 1AA4FRA4 & 1AA4FRB4	2
3	N/A	Hydraulic Fitting, FF1852T0406S	2
4	N/A	Hydraulic Fitting, FF1865T0406S	2
5	N/A	Hydraulic Hose Assembly, 92" – 1AA4FRA4 & 1AA6FRC4	1
6	N/A	Hydraulic Hose Assembly, 80" – 1AA4FRA4 & 1AA6FRB4	1
7	N/A	Accumulator	2
8	N/A	Female Quick Coupler, 5601-4-4S	2
9	N/A	Plug, 5659-4	2
10	N/A	CAT Tee, 8T2352	2
11	N/A	Check Valve, C20S-1/4"	2
12	N/A	Hydraulic Adapter, FF1852T0606S	2
13	N/A	Nipples, 2083-4-4S	4
14	855049	Lever Circle Cylinder with Keyway	1

SLAT CONVEYOR – LEFT SIDE VIEW



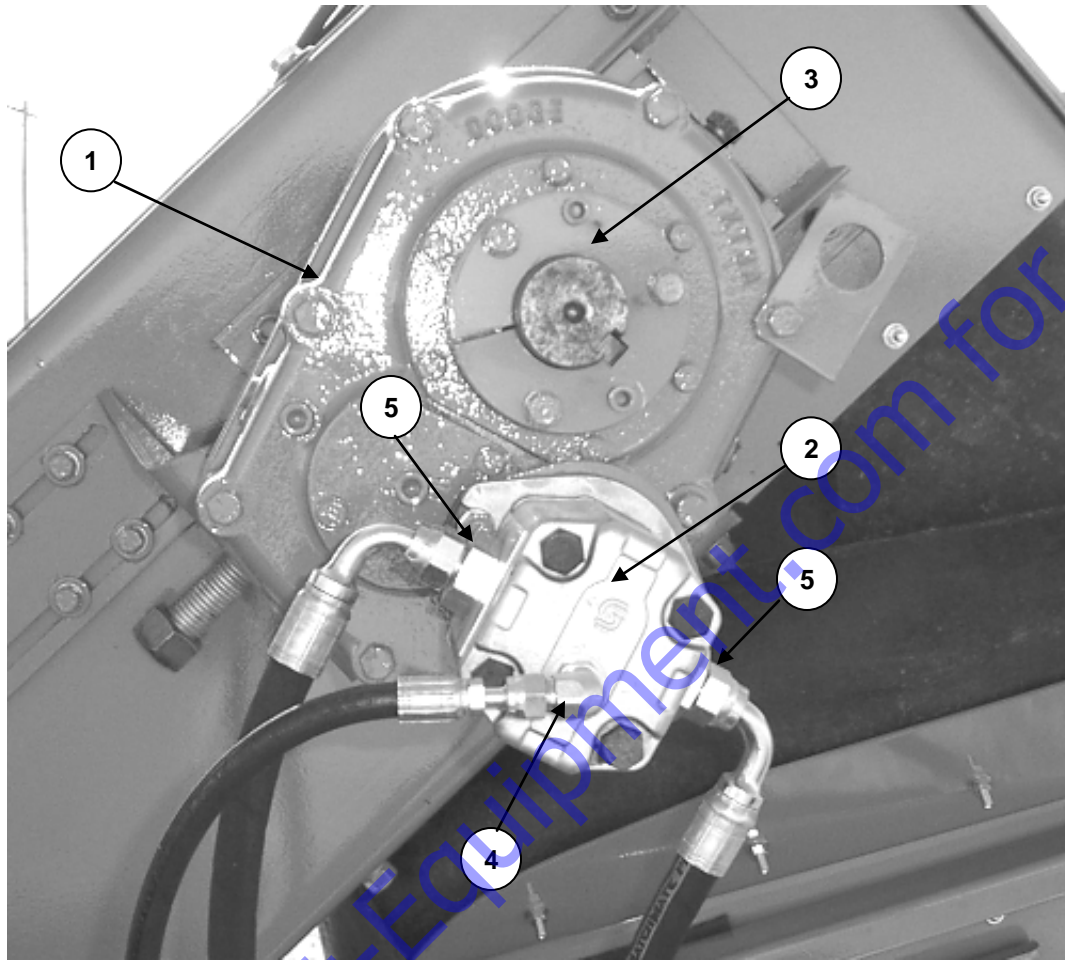
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205020	Slat Conveyor Side, LH	1
2	320607	Slat Conveyor Take-up Frame	2
3	320606	Slat Conveyor Take-up Bearing	2
4	205025	Slat Conveyor Head Shaft	1
5	325011	Load Holding Valve	1
6	N/A	Hydraulic Adapter, FF1852T0408S	2
7	N/A	Hydraulic Adapter, FF1852T0404S	1
8	N/A	Hydraulic Hose Assembly, 61" – 1AA4FR4 & 1AA6FRC4	1

SLAT CONVEYOR – RIGHT SIDE VIEW



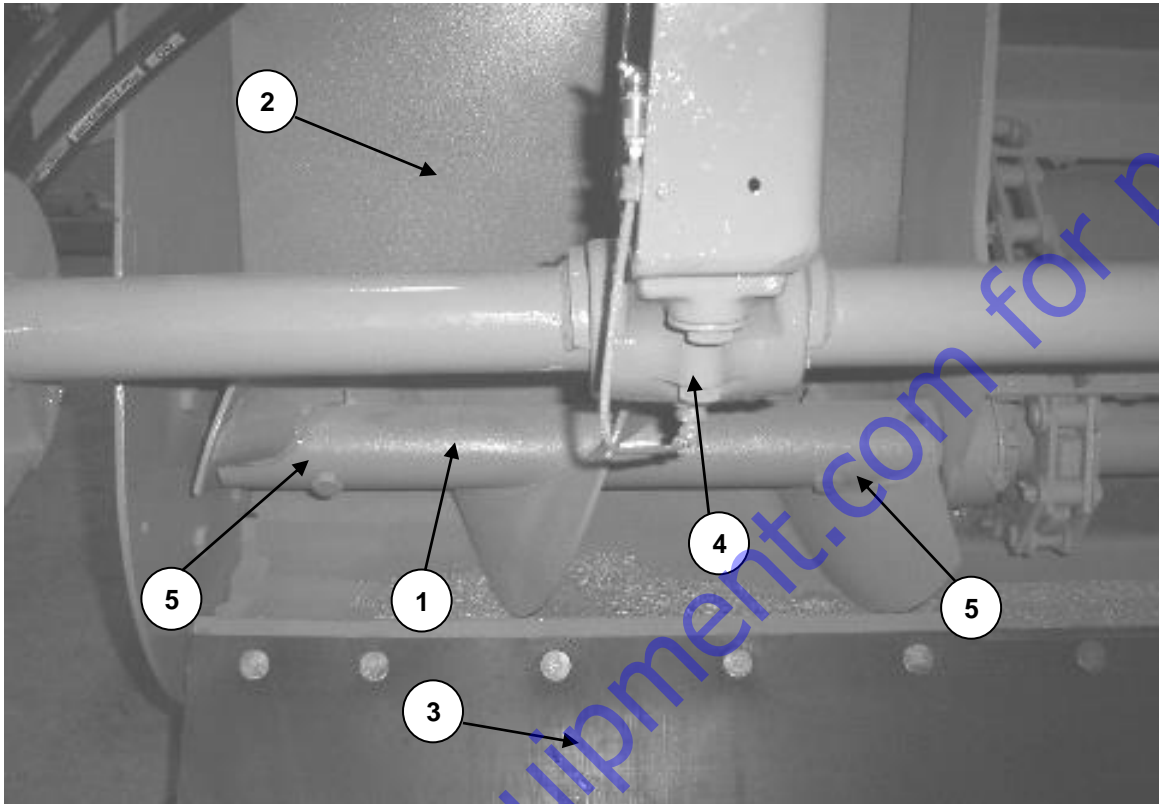
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205019	Slat Conveyor Side, RH	1
2	205031	Slat Conveyor Top Cover, Upper	1
3	205039	Speed Reducer Bracket	1
4	205032	Slat Conveyor Top Cover, Lower	1
5	N/A	Hydraulic Hose Assembly, 121" – 1AA8FRB8 (2)	2
6	205098	Front Frame Cover, Top	1
7	205040	Slat Conveyor Window	1
8	N/A	Hydraulic Hose Assembly, 190" – 1AA4FR4 & 1AA6FRC4	1
9	205099	Front Frame Cover, Bottom	1

SLAT CONVEYOR – DRIVE SIDE VIEW



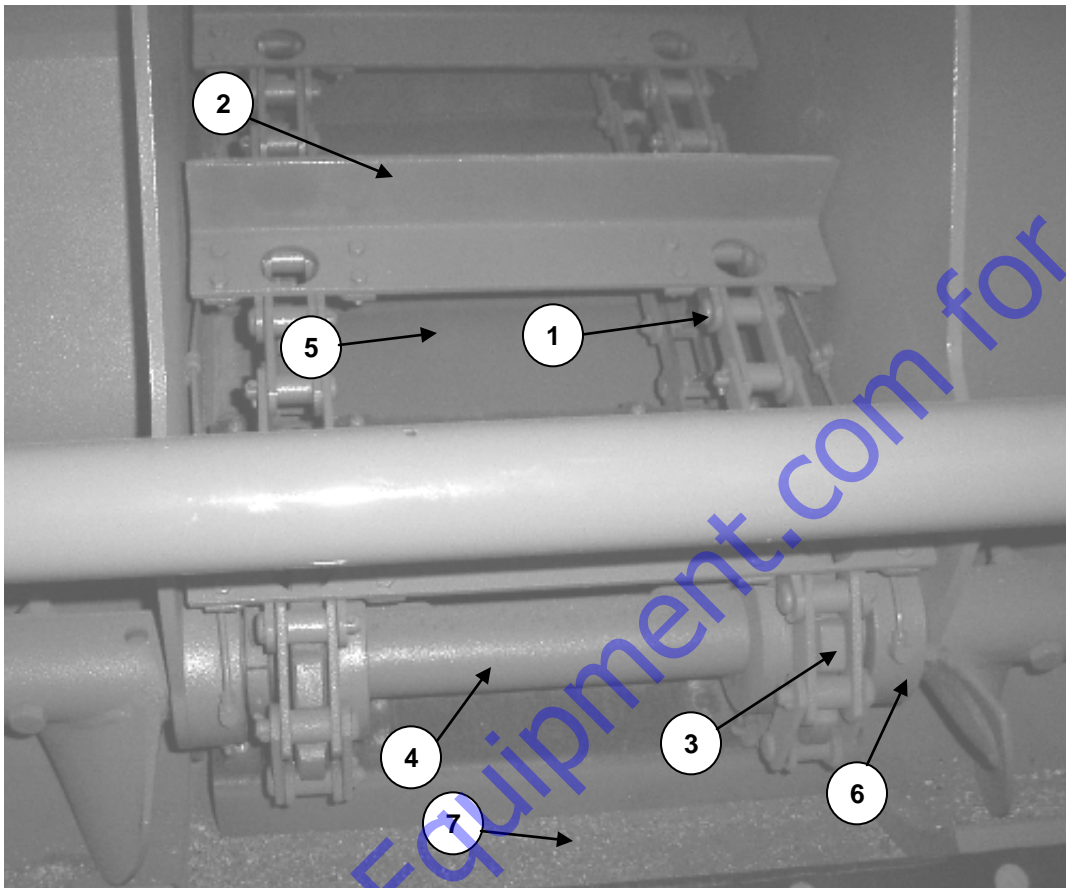
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	320615	Dodge Speed Reducer	1
2	325007	Slat Conveyor Motor	1
3	320616	Speed Reducer Shaft Adapters, Set of 2	1
4	N/A	Hydraulic Adapter, FF1868T0406S	1
5	N/A	Hydraulic Adapter, FF1852T0810S	2

SCREW CONVEYOR - LEFT SIDE VIEW



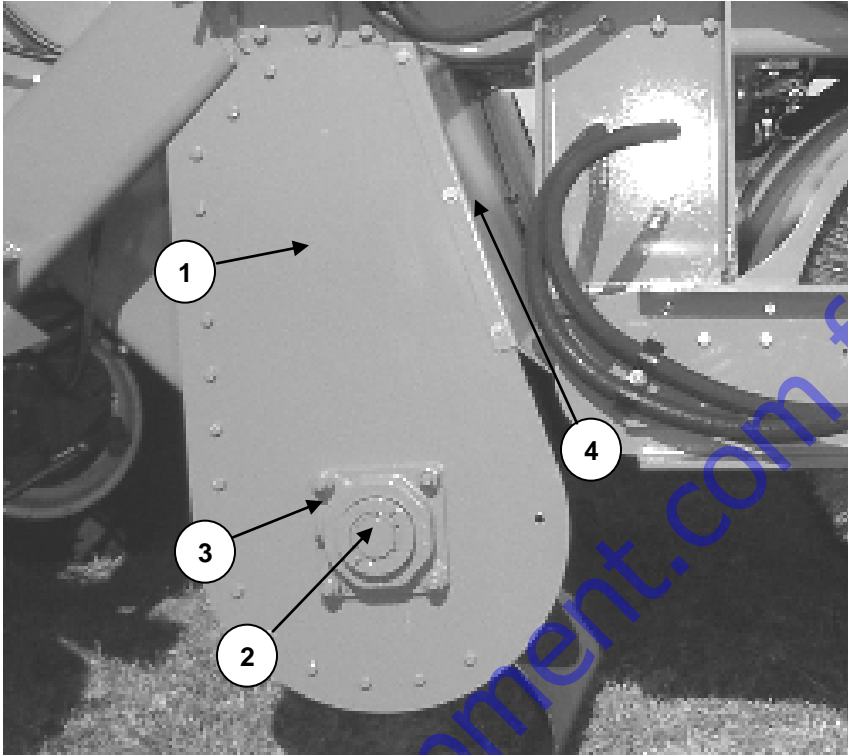
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	320618	Screw Conveyor, 25" – RH	1
	320619	Screw Conveyor, 25" – LH	1
2	855027	Screw Conveyor Box, LH	1
	855026	Screw Conveyor Box, RH	1
3	205227	Rock Shield, 14" x 7'	1
4	320609	Core Frame Support Bearing, LH & RH	2
5	320625	Auger Wedge Cutout (2 LH & 2 RH)	4

SCREW CONVEYOR – CENTER VIEW



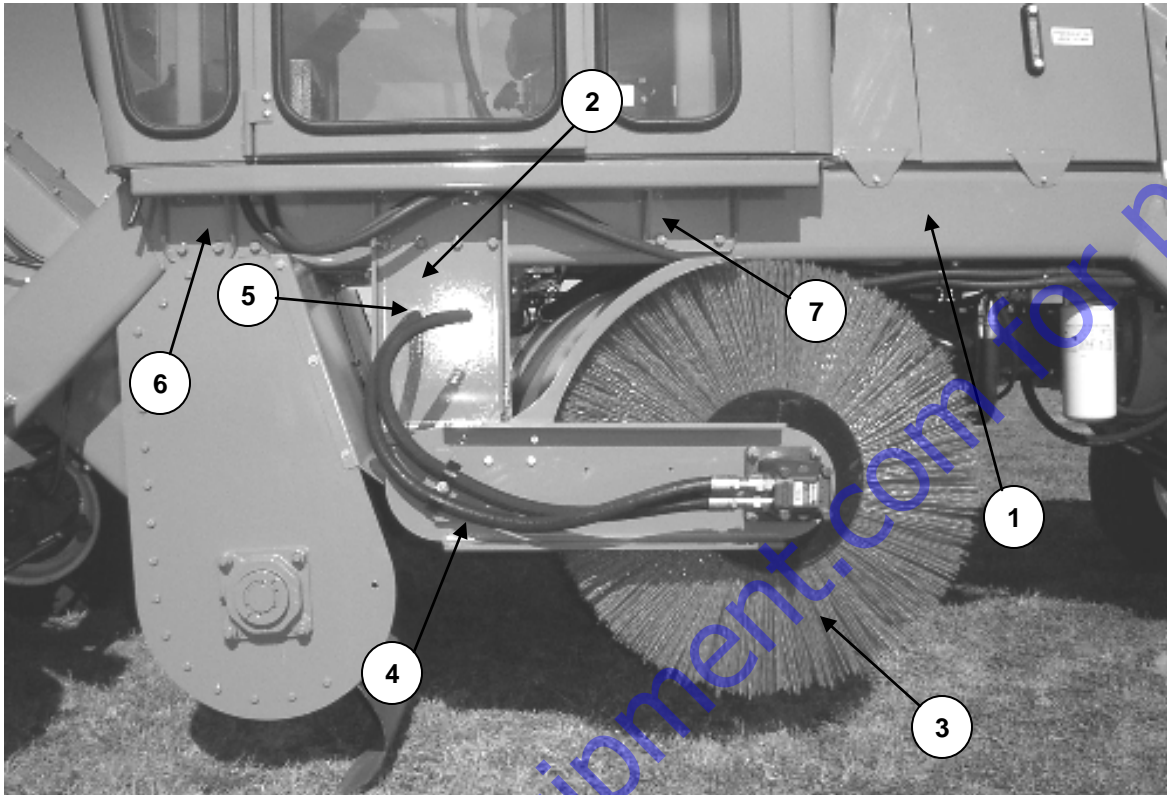
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	320621	Slat Conveyor Chain	2
2	205029	Slat	16
3	320620	Sprockets	4
4	205024	Center Conveyor Shaft	1
5	205028	Slat Conveyor Floor	1
6	320608	Lower Slat Conveyor Bearing	2
7	855021	Slat Conveyor Floor Connector Assembly	1

SCREW CONVEYOR – LEFT OUTER VIEW



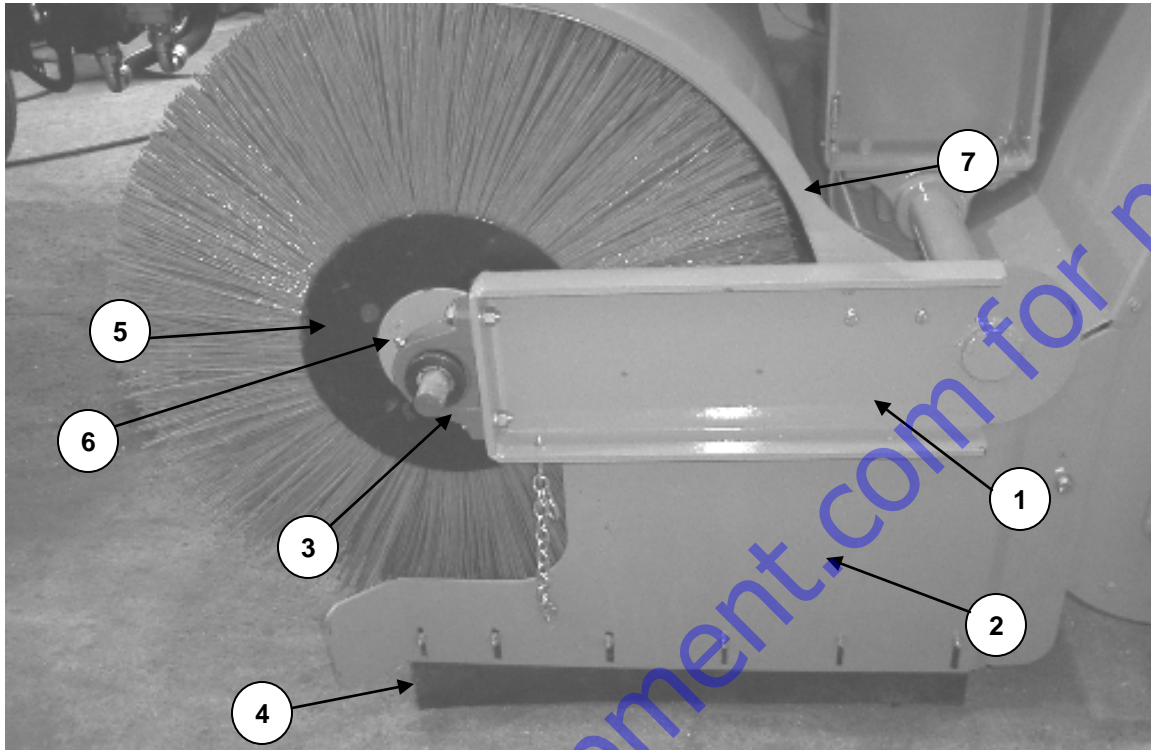
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	205016	Auger Conveyor End Plate, LH & RH	2
2	205023	Outboard Screw Conveyor Stub Shaft, LH & RH	2
3	320613	Outboard Auger Bearings	2
4	855141	Dust Shield, LH	1
	855140	Dust Shield, RH (Not Shown)	1

LEFT SIDE VIEW – BELOW CAB



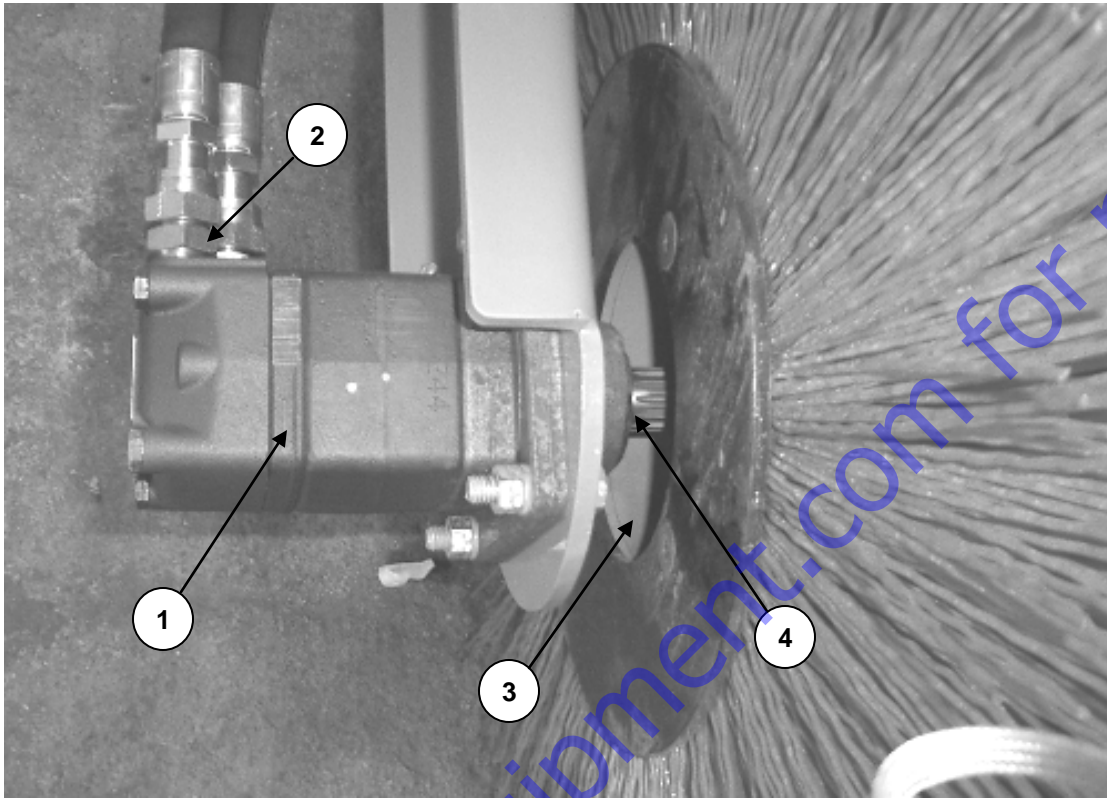
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855001	Frame Assembly	1
2	205000	Brush Support Bracket	2
3	RW-500	8' Set, Poly Wafers w/ Spacers	1
	RW-502	8' Set, Half Poly & Half Wire Wafers w/ Spacers	1
4	N/A	Hydraulic Hose Assembly, 46" – 1AA12FR12	2
5	N/A	Hydraulic Fitting, FF1944T1212S	2
6	205161	Front ROPS Attaching Bracket, LH	1
	205160	Front ROPS Attaching Bracket, RH	1
7	205162	Rear ROPS Attaching Bracket	2

RIGHT SIDE VIEW – BROOM CORE



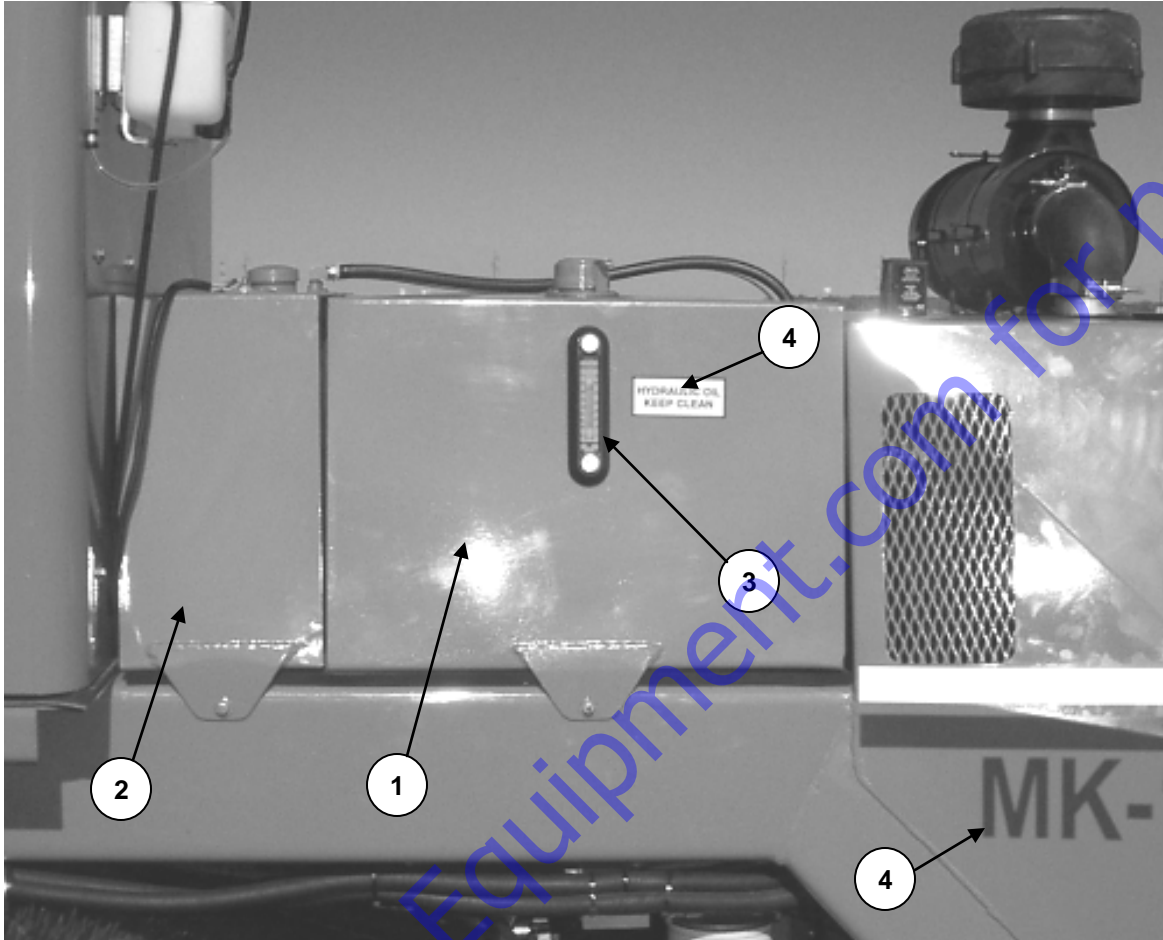
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855004	Core Frame Assembly	1
2	205043 205044	Brush End Gate, RH Brush End Gate, LH	1 1
3	320610	Core Support Bearing, RH	1
4	205228	Core Side Sheet Rubber	2
5	203010	End Plate	2
6	D-17	Core Idle Assembly	1
7	855037	Core Cover Assembly	1

CORE MOTOR VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325010	Core Motor OMSW 400	1
2	N/A	Hydraulic Fitting, FF1852T1210S	2
3	855005	Core Assembly	1
4	DD-257-R	Core Drive Assembly (Splined Hub)	1

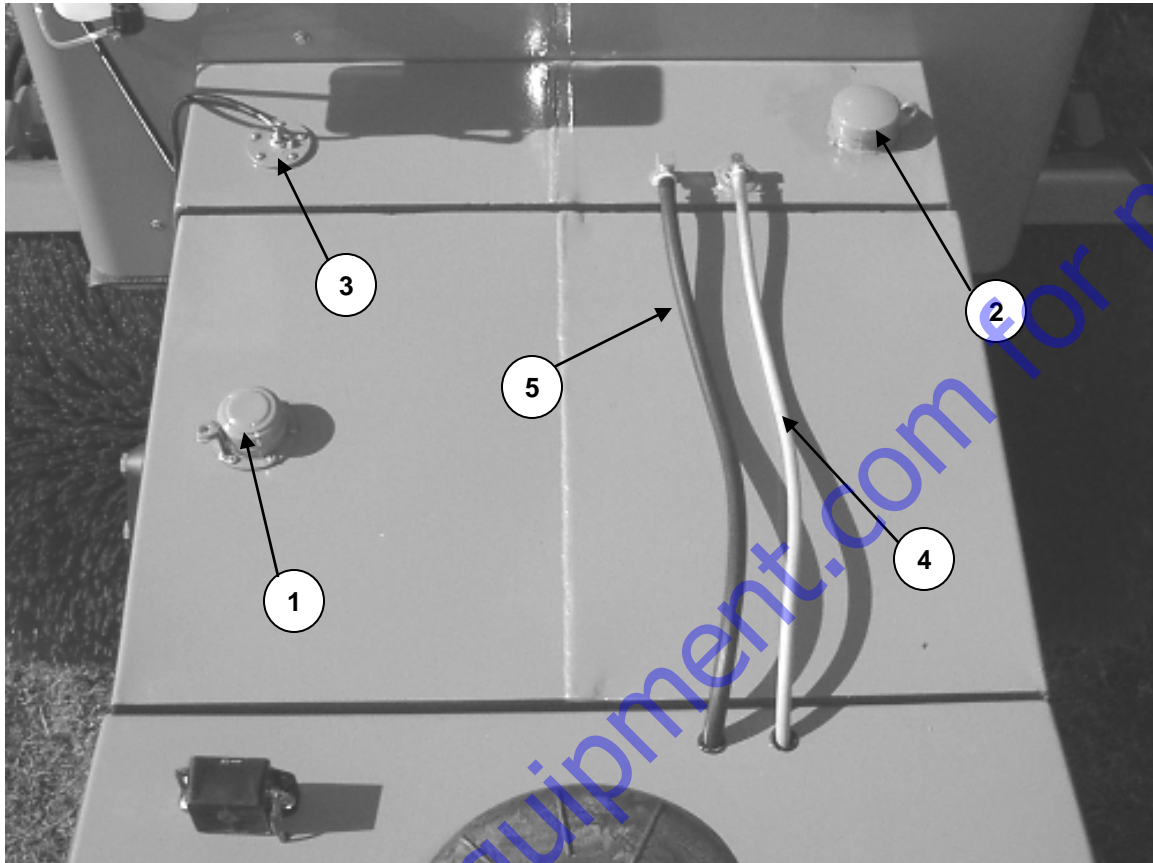
MIDDLE LEFT SIDE VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855153	Hydraulic Tank Assembly	1
2	855158	Fuel Tank Assembly	1
3	305505	Sight Glass	1
4	311665	Decal Kit	1

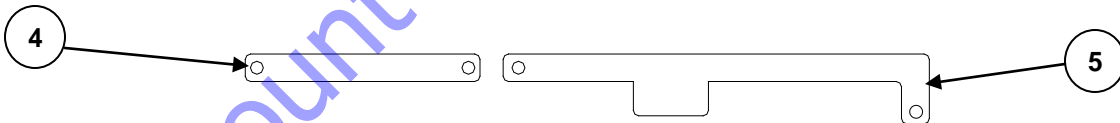
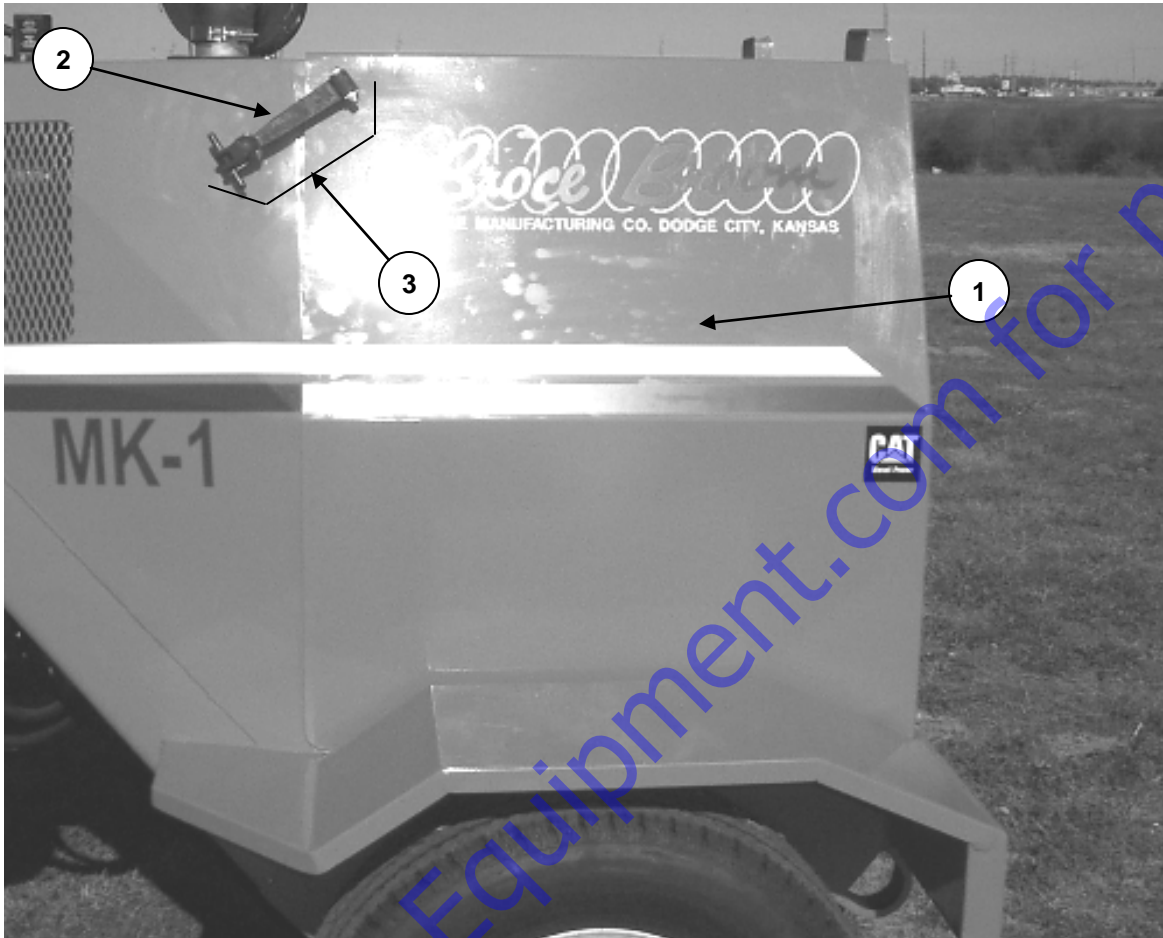
NOTE: Decal Kit includes all exterior decals including safety stickers. Decals may be ordered separately. Request individual decals when ordering.

FUEL/HYDRAULIC TANK TOP VIEW



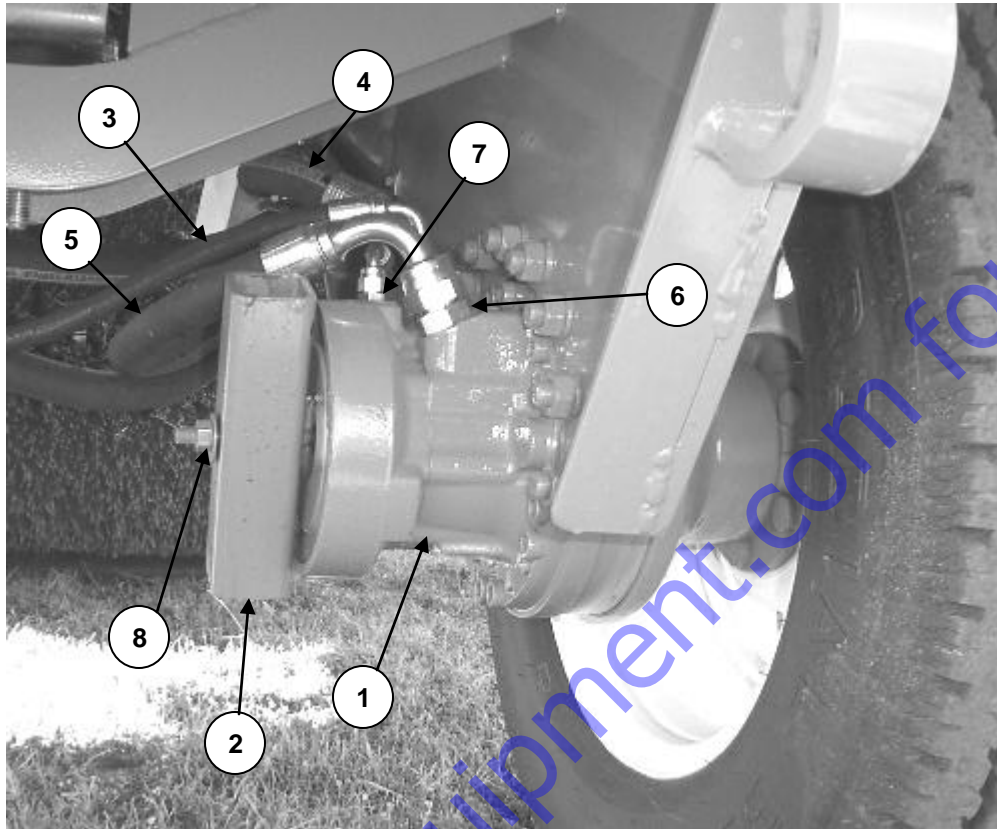
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	T-703-BA	Hydraulic Cap	1
2	T-702-B	Fuel Cap	1
3	344175	Fuel Gauge Assembly	1
4	304172	3/8" Fuel Hose, 48"	1
5	304172	3/8" Fuel Hose, 60"	1

REAR LEFT SIDE VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855215	Hood Assembly	1
2	VF-803-R	Hood Catch (Rubber Strap Only)	2
3	VF-319-RA	Catch Assembly (Complete)	2
4	205221	Front Hood Retract Support Linkage	2
5	203274	Rear Hood Retract Support Linkage	2
NS	VF-317-B	Hinge, Set of 2	1

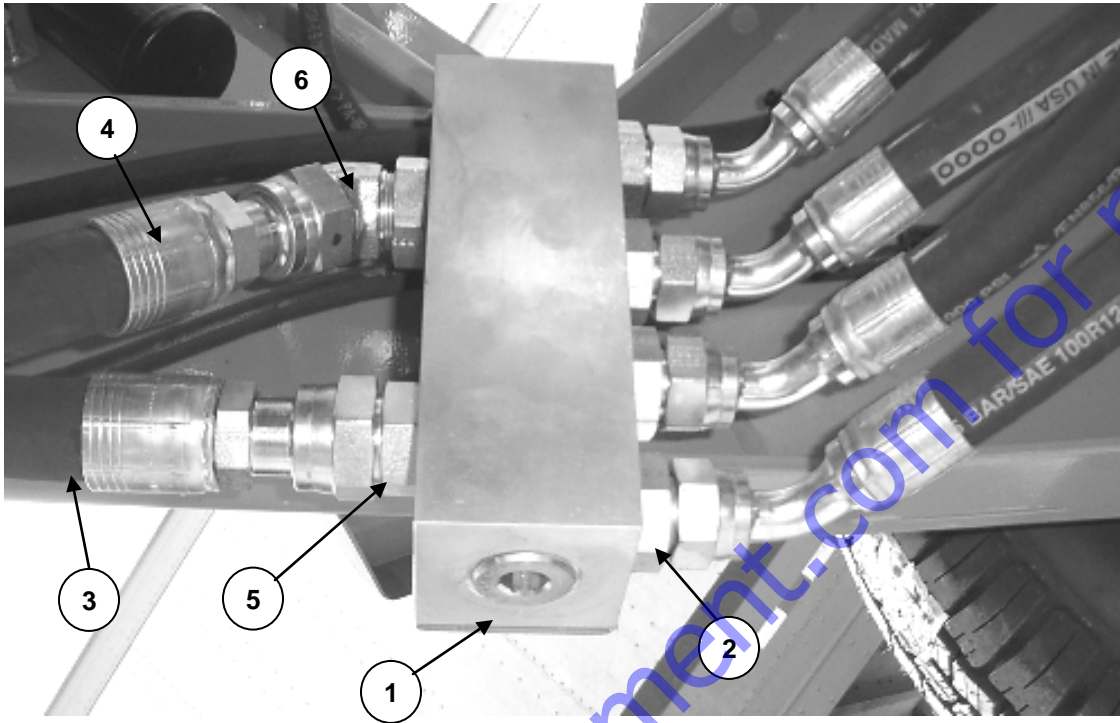
REAR DRIVE VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325002 325001	Poclain 34ci Motor with parking brake, LH and RH Poclain 34ci Motor, no brake S/N 500001-500050, LH only	2 1
2	K00024	Brake Release, 2" x 2" Square Tube, RH Only	1
3	N/A	Hydraulic Hose Assy., 68" – 1AA6FRA6 & 1AA6FRC6, RH Hydraulic Hose Assy., 25" – 1AA6FRA6 & 1AA6FRC6, LH	1 1
4	N/A	Hydraulic Hose Assy., 10.5" – 1BA12FRA12 (2) (R-Port, RH) Hydraulic Hose Assy., 50" – 1BA12FRA12 (2) (R Port, LH)	1 1
5	N/A	Hydraulic Hose Assy., 19" – 1BA12FRA12 & 1BA12FRB12 (L-Port, RH) Hydraulic Hose Assy., 46.5" – 1BA12FRA12 (R-Port, LH)	1 1
6	N/A	Hydraulic Fitting, FF1852T1212S (2 per Side, L & R-Port)	4
7	N/A	Hydraulic Fitting,	2
8	Included in Item 2	Brake Release, 12mm x 110 mm Stud	1

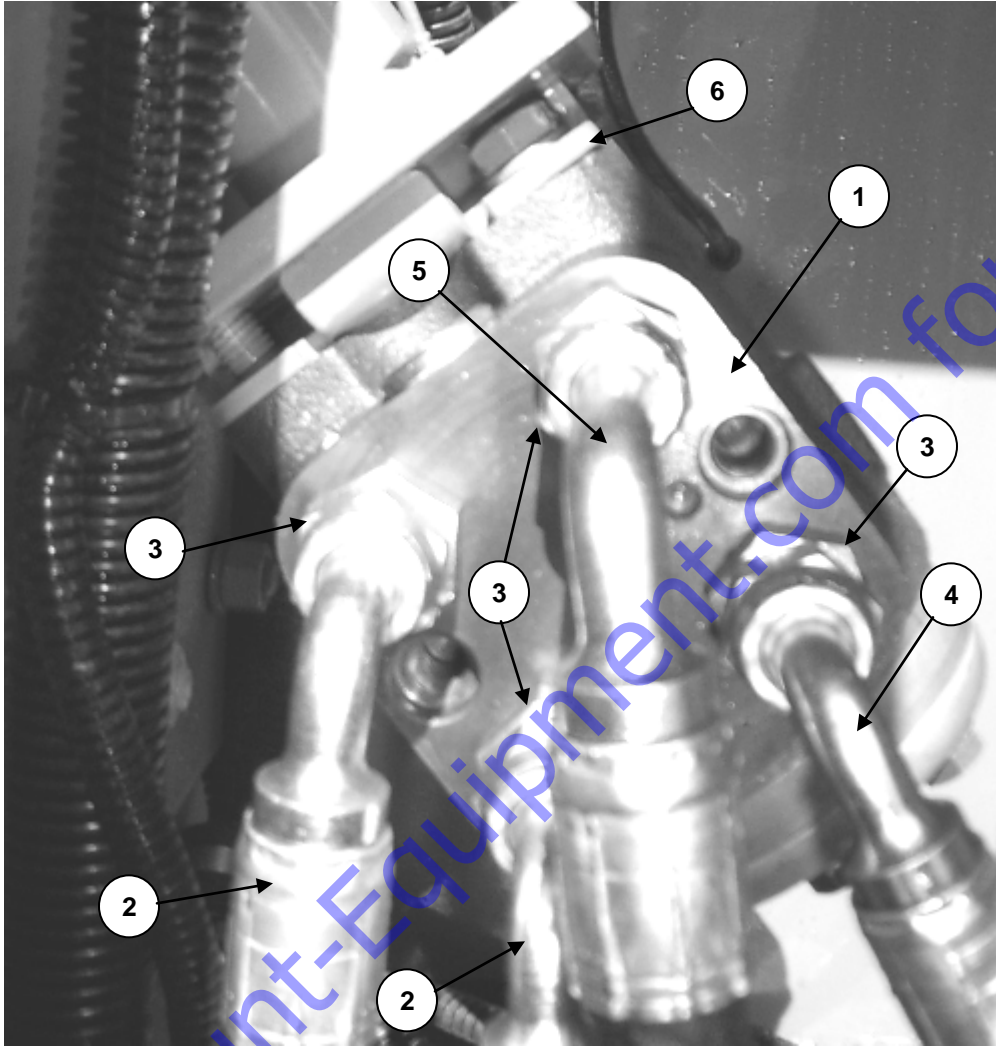
Note: Picture shows RH Rear Drive Motor with brake release assembly attached. Brake release, Items #2 & #8, are to be used only to release Drive Motor Brake if needed. Items must be removed for normal operation.

PRESSURE MANIFOLD VIEW



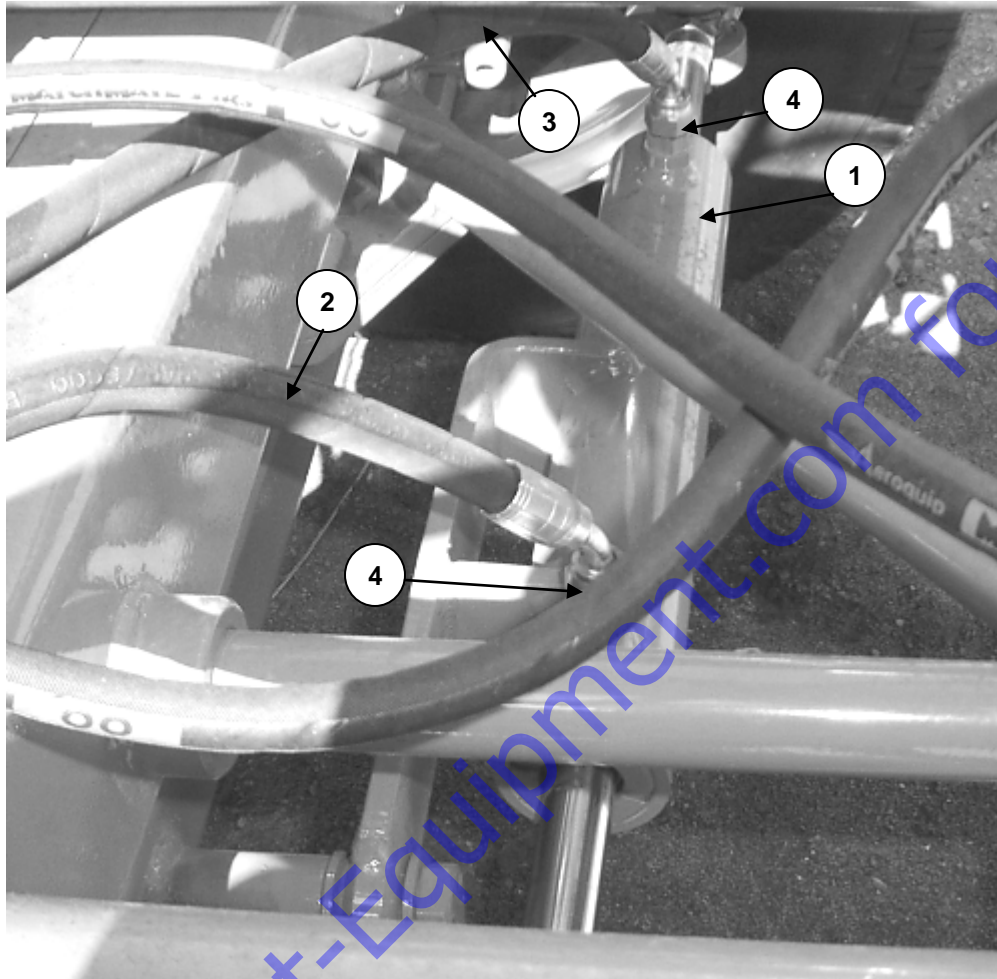
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325017	Pressure Manifold	1
2	NA	Hydraulic Fitting, FF1852T1216S	4
3	NA	Hydraulic Hose Assy., 27" – 1BA16FR16 & 1BA16FRB16	1
4	NA	Hydraulic Hose Assy., 28" – 1BA16FR16 & 1BA16FRB16	1
5	NA	Hydraulic Fitting, FF1852T1616S	1
6	NA	Hydraulic Fitting, FF2068T1616S	1

STEERING MOTOR VIEW



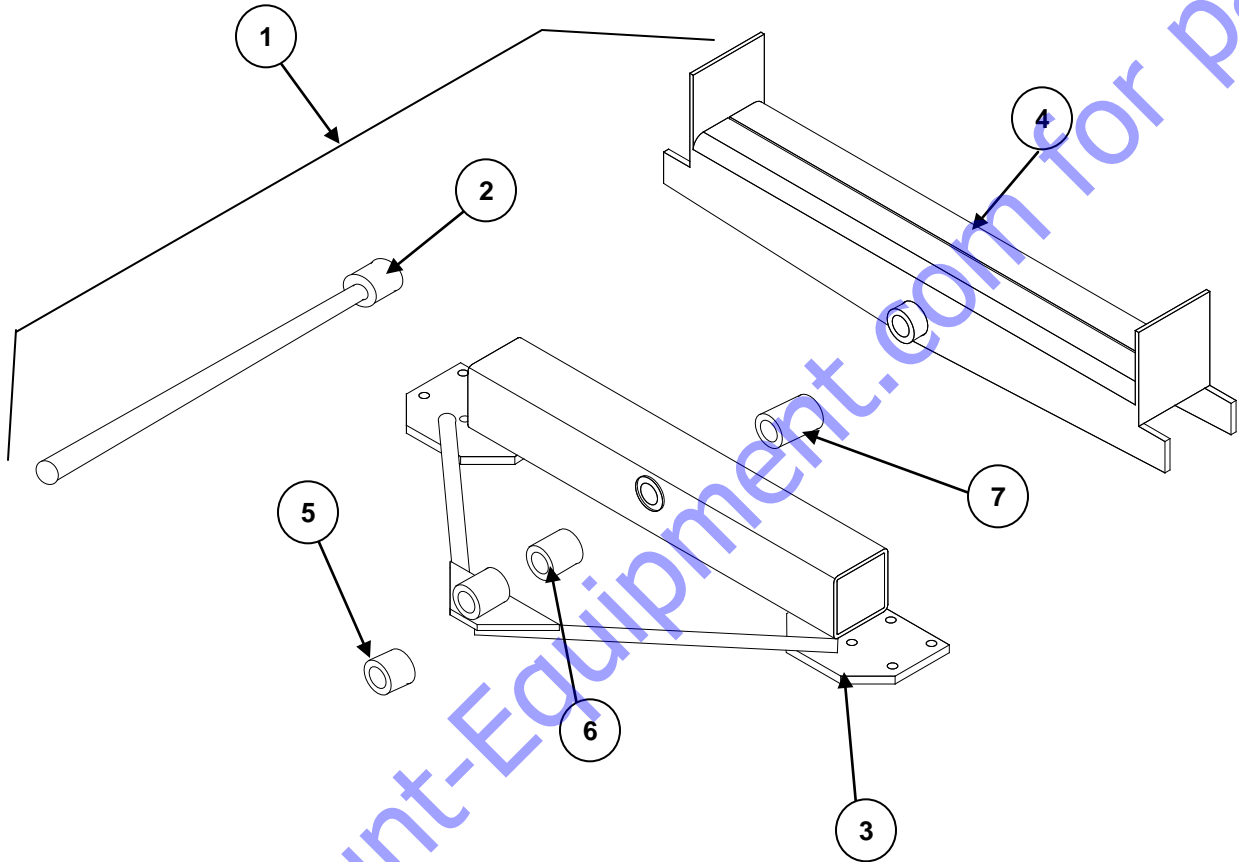
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325009	Steering Motor	1
2	NA	Hydraulic Hose Assembly, 20" – 1AA6FR6 & 1AA6FRB6	2
3	NA	Hydraulic Fitting, FF1852T0608S	4
4	NA	Hydraulic Hose Assembly, 18" – 1AA6FR6 & 1AA6FRB6	1
5	NA	Hydraulic Hose Assembly, 12" – 1AA6FRB6 & 1AA6FRC6	1
6	203250	Power Steering Unit Mount	1

STEERING CYLINDER VIEW



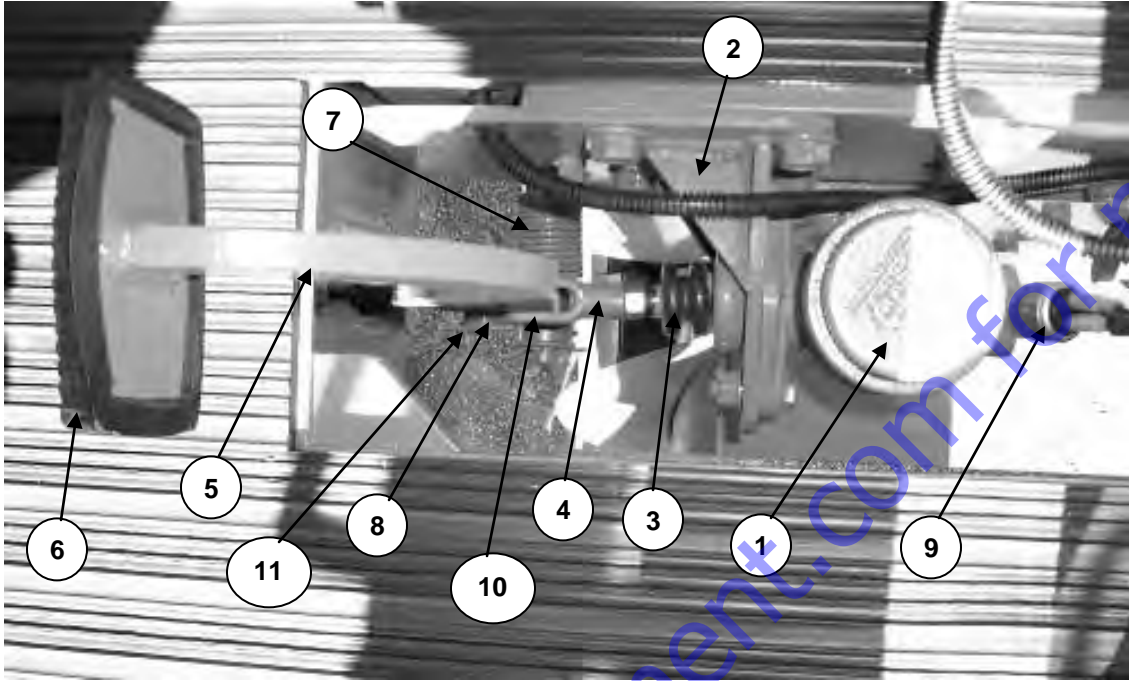
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	See Front Axle View	Steering Cylinder	1
2	NA	Hydraulic Hose Assembly, 66" – 1AA6FRA6 & 1AA6FRB6	1
3	NA	Hydraulic Hose Assembly, 74" – 1AA6FRA6 & 1AA6FRB6	1
4	NA	Hydraulic Fitting, FF1852T0606S	2

BOLSTER ASSEMBLY



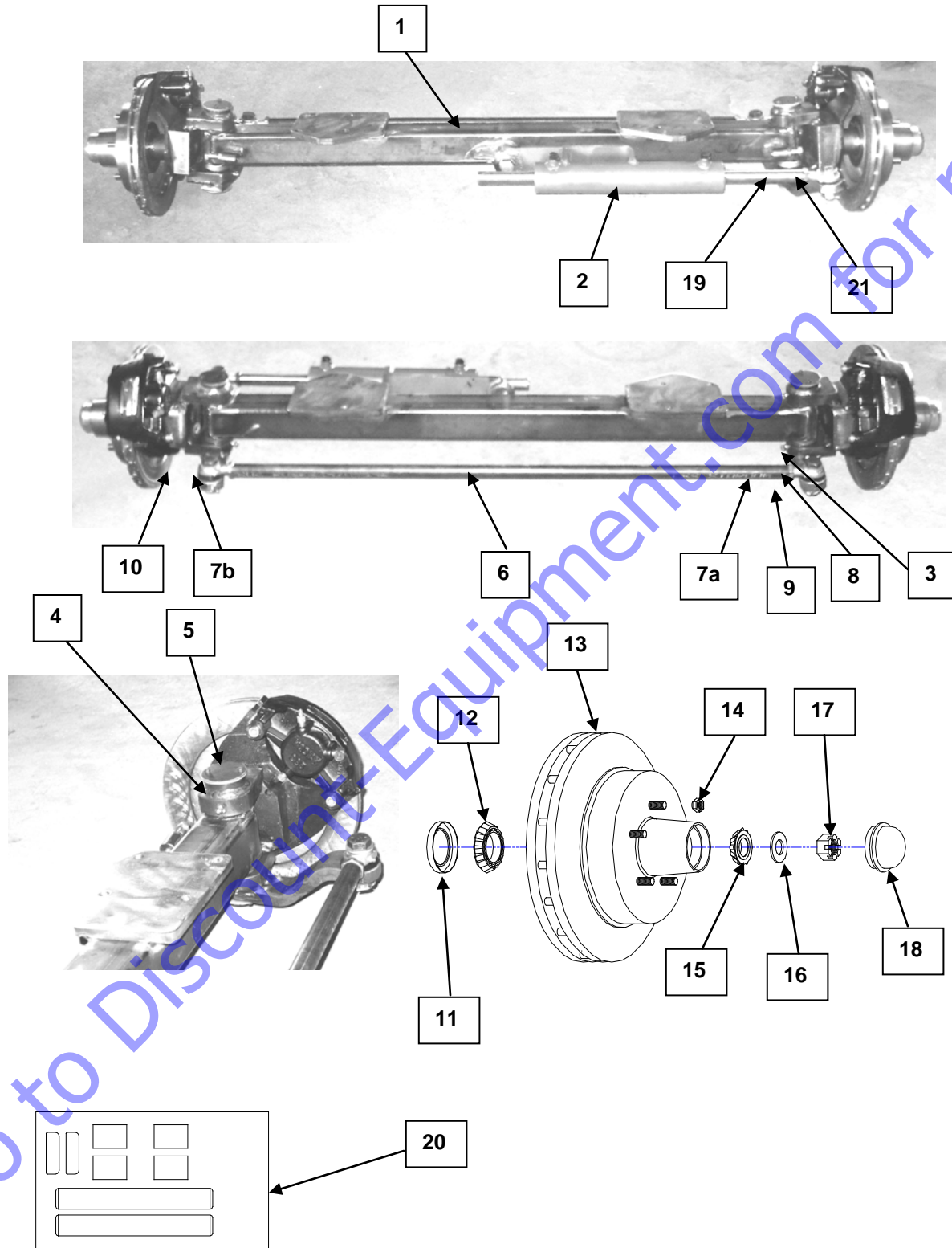
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	752002	Bolster Assembly, Complete	1
2	203002	Bolster Pin	1
3	852002	Bolster A-Frame Assembly	1
4	852003	Bolster Support	1
5	309507	Oil Light Bushing, 1 1/4" x 1 1/2" x 1 1/2"	1
6	309505	Oil Light Bushing, 1 1/4" x 1 1/2" x 2"	1
7	309506	Oil Light Bushing, 1 1/4" x 1 1/2" x 2 1/4"	1

BRAKE CONTROL ASSEMBLY



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	B-240-R	Master Cylinder	1
2	855188	Master Cylinder Mount	1
3	B-284	Rubber Boot	1
4	401216	Push Rod	1
5	855191	Brake Pedal	1
6	B-241-R	Brake Pedal Pad	1
7	344460	Tension Spring	1
8	205197	Pedal Bushing	2
9	BLS-15	Brake Light Switch	1
10	B-27084A	Clevis	1
11	HC-229-R	Clevis Pin	1

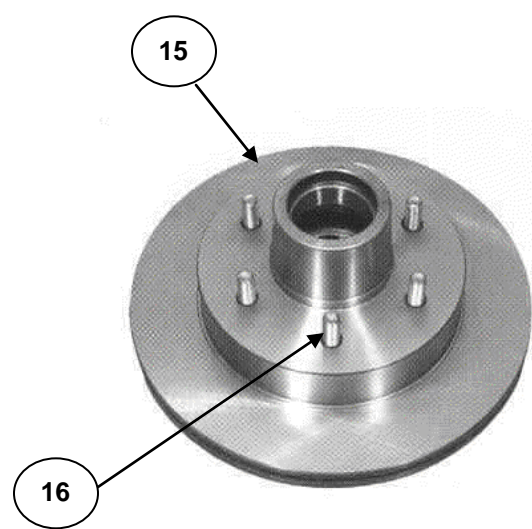
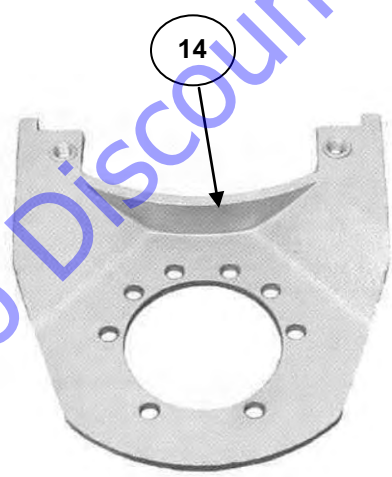
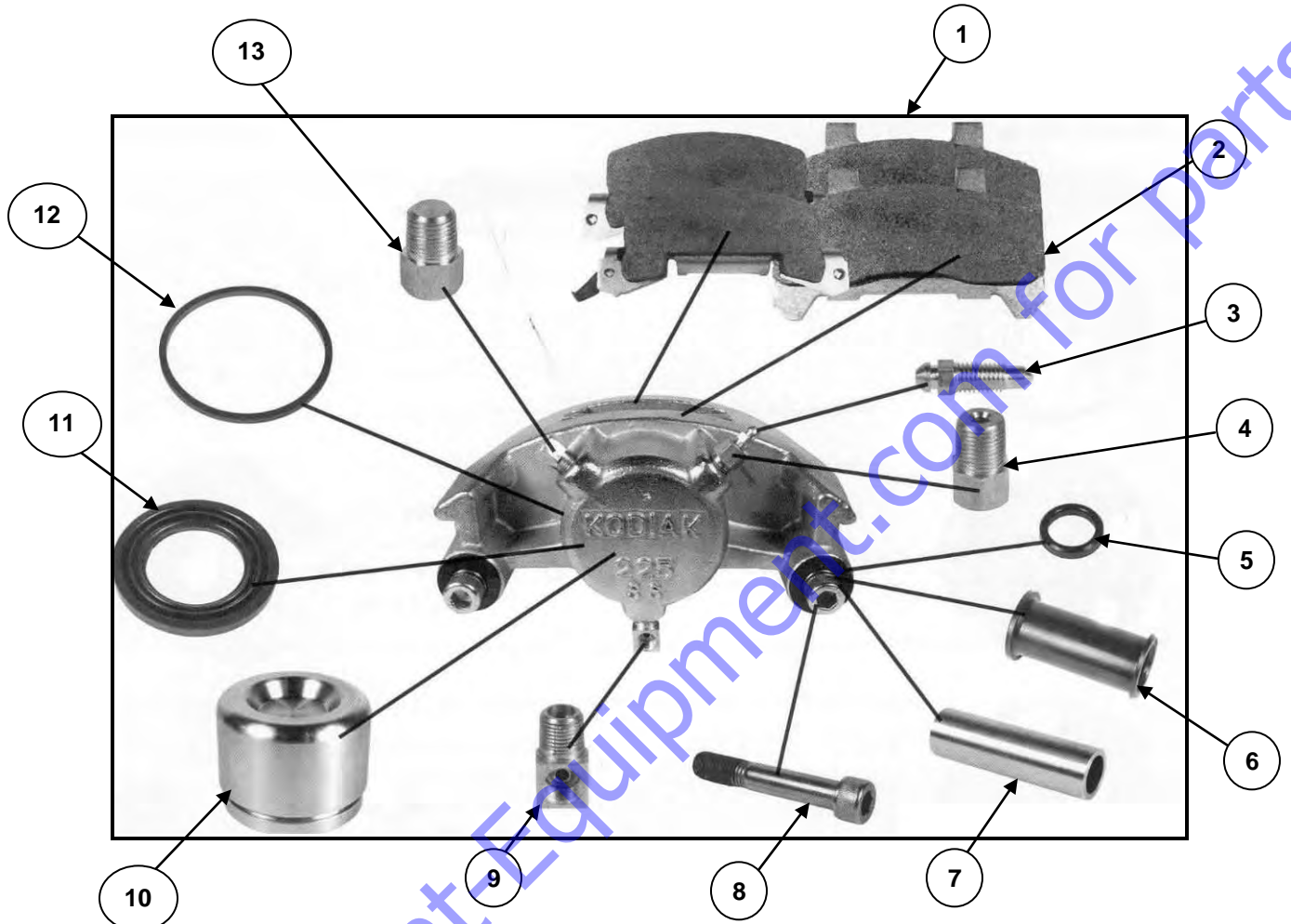
FRONT AXLE ASSEMBLY



FRONT AXLE ASSEMBLY

Reference	Part No.	Description	Qty.
1	403090	Front Axle Assembly (6 Lug x 5 1/2)	1
2	203526	Steering Cylinder Assembly	1
4	403091	Knuckle w/Spindle, LH	1
	403092	Knuckle w/ Spindle, RH	1
5	BF4454	King Pin Cap	2
6	403093	Tie Rod Tube	1
7a	BF4470	Jam Nut, RH Thread	1
7b	BF4471	Jam Nut, LH Thread	1
8	BF4465L	Tie Rod End, RH Thread	1
9	203523	Lock Nut	2
10	BF4465R	Tie Rod End, LH Thread	1
11	BF4460	Seal	2
12	BF4461X	Inner Bearing Kit (w/Race)	2
13	203544	Hub Assembly, (6 Lug x 5 1/2)	2
14	69957B	Lug Nut	10
15	752547	Outer Bearing Kit (w/Race)	2
16	400195	Washer	2
17	203549	Lock Nut	2
18	203550	Hub Cap	2
19	BF4470	Jam Nut, RH Thread	1
20	BF4455	King Pin Kit	1
21	203520	Steering Cylinder Heims End	1
Not Shown	203553	Steering Cylinder Seal Kit	1
Not Shown	304039	Wheel – 6 Lug	1

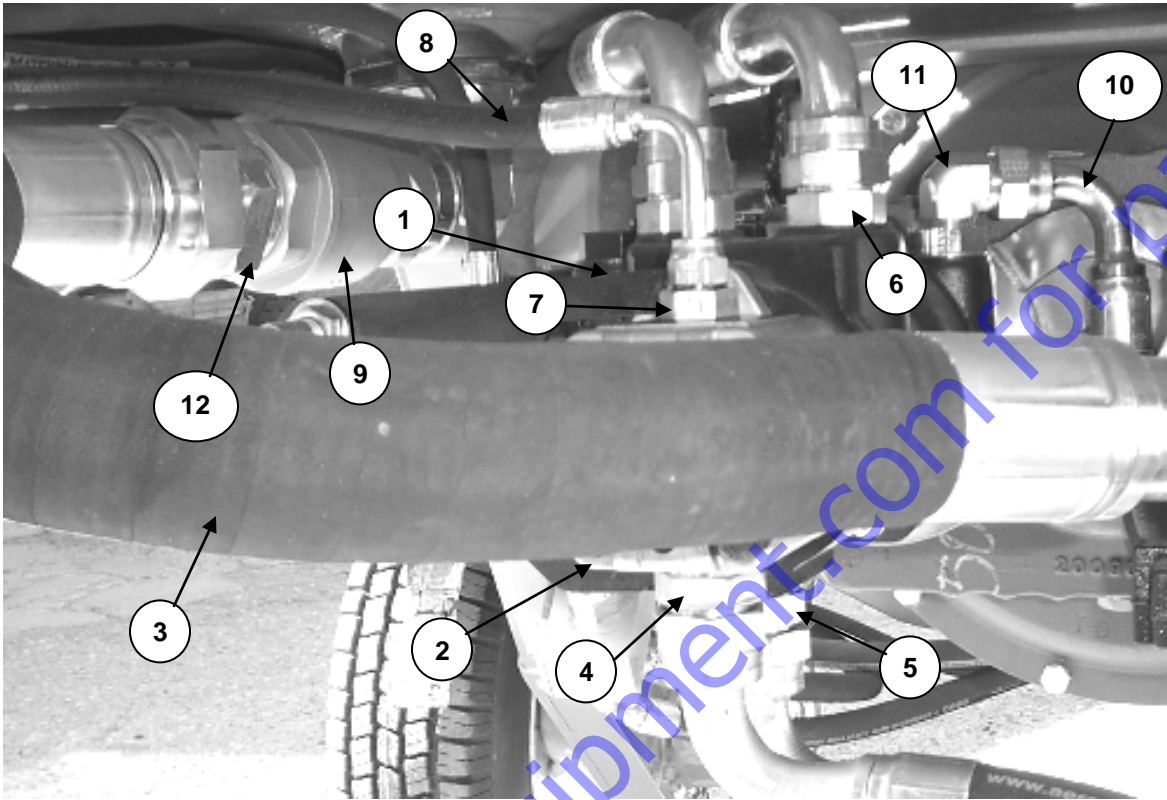
5200-6000 LB FRONT BRAKE ASSEMBLY



5200-6000 LB FRONT BRAKE ASSEMBLY

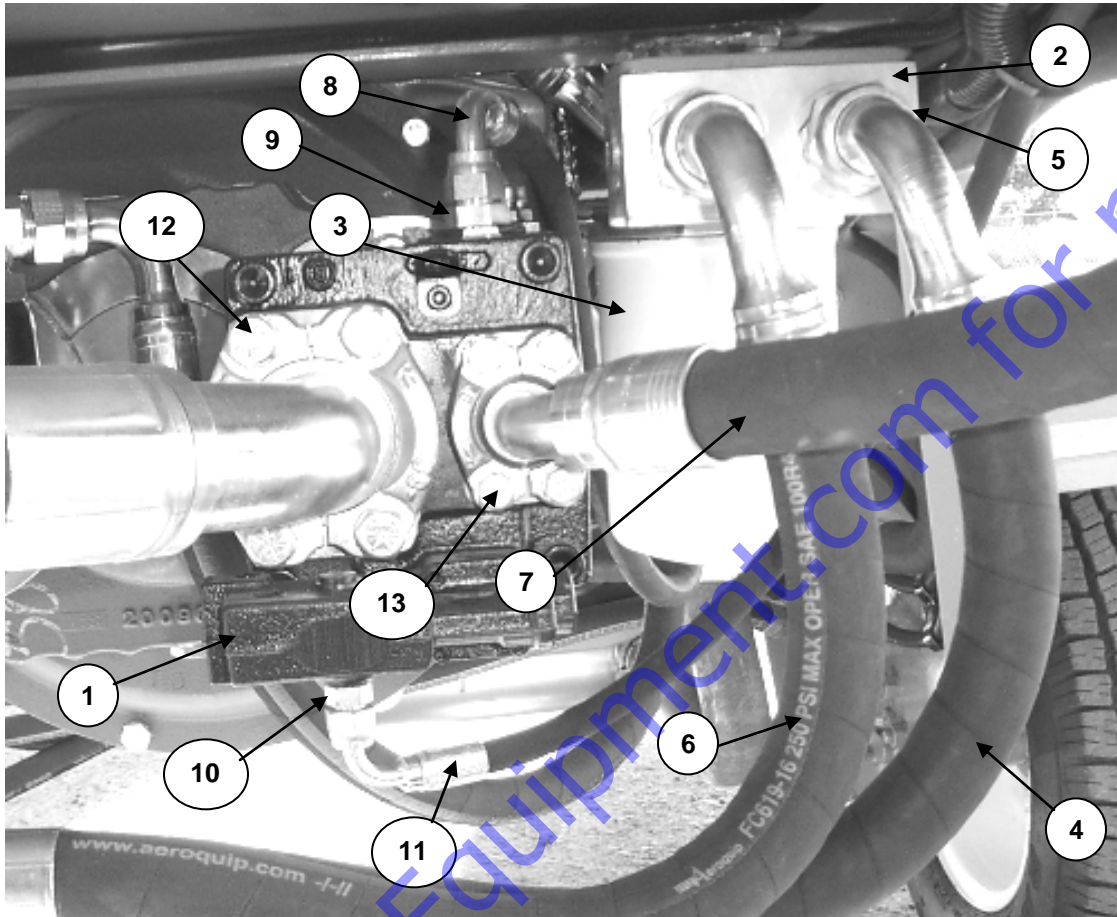
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	203554	Complete Caliper Assembly w/ Pads	1
2	203530	Friction Pads, Organic	1
3	203531	Brass Bleed Screw, 1/4" – 28	1
4	203532	Brass Bleed Screw Adapter, 1/8"	1
5	203533	Guide Bolt Sleeve O-Ring	1
6	203534	Guide Bolt Rubber Sleeve	1
7	203535	Guide Bolt Stainless Steel Sleeve	1
8	203536	Guide Bolt (M11 x 1.5) w/ Thread Locker	1
9	203537	90° 1/8" NPT to 3/16" F.I.F.	1
10	203538	Caliper Piston, 2 1/4" Stainless Steel	1
11	203539	Rubber Dust Boot	1
12	203540	Piston Rubber Seal	1
13	203541	1/8" NPT Brass Plug	1
14	203542	Caliper Mounting Bracket	1
15	203543	12" Integral Rotor w/ Hub, 5 Lug x 5 1/2	1
	203544	12" Integral Rotor w/ Hub, 6 Lug x 5 1/2	1
16	203555	Wheel Stud	5 or 6
NS	FA-306-R	Brake Hose	2

M-46 HYDROSTAT VIEW



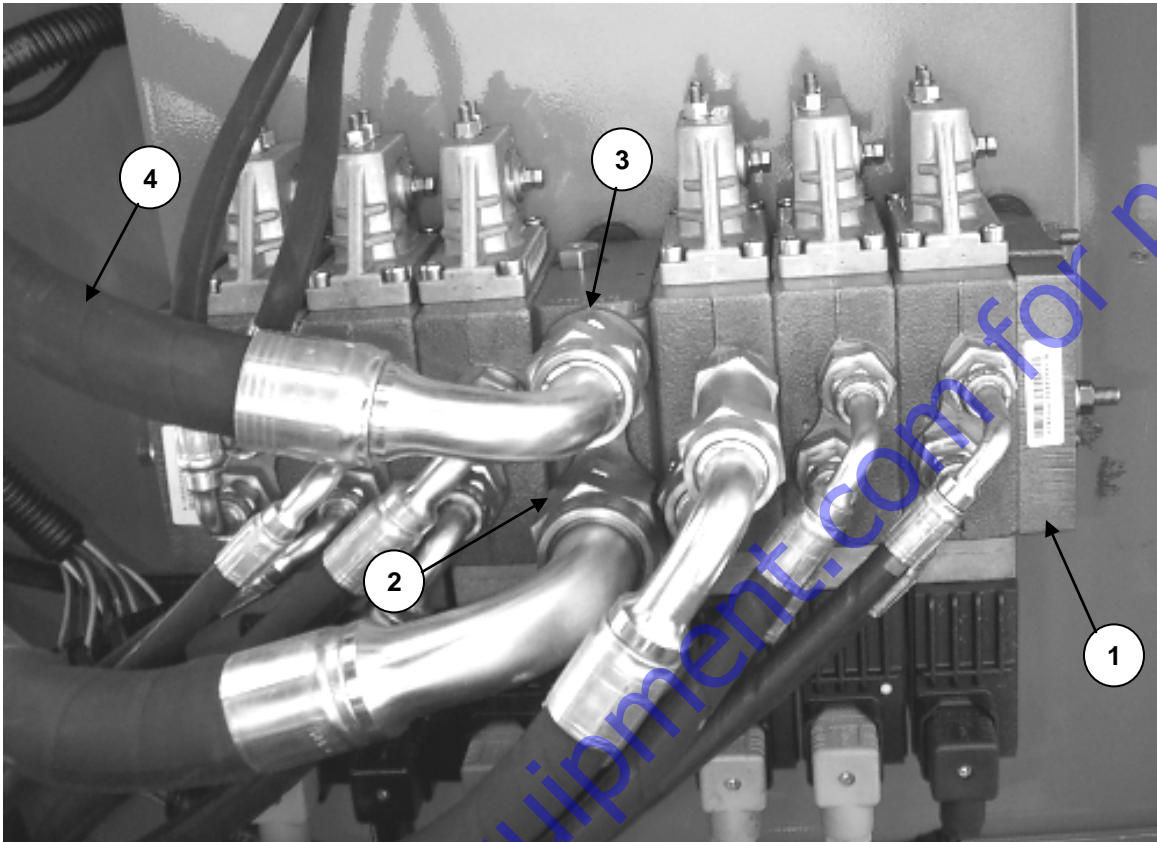
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325003	M-46 Hydrostat	1
2	325005	Steering Pump	1
3	N/A	Hydraulic Hose Assy., 25" – 1GA32FJ32 & 1 G32FLA32	1
4	N/A	Hydraulic Fitting, FF1852T1612S	1
5	N/A	Hydraulic Fitting, FF1852T1616S	1
6	N/A	Hydraulic Fitting, FF1852T1216S	2
7	N/A	Hydraulic Fitting, FF1852T0610S	1
8	N/A	Hydraulic Hose Assy., 76" – 1AA6FRB6 & 1AA6FRC6	1
9	N/A	2" Ball Valve	1
10	N/A	Hydraulic Hose Assy., 28" – 1AA12FRB12 (2)	1
11	N/A	Hydraulic Fitting, FF1868T1212S	1
12	N/A	Hydraulic Fitting, 2021-32-32	1

M-45 PISTON PUMP VIEW



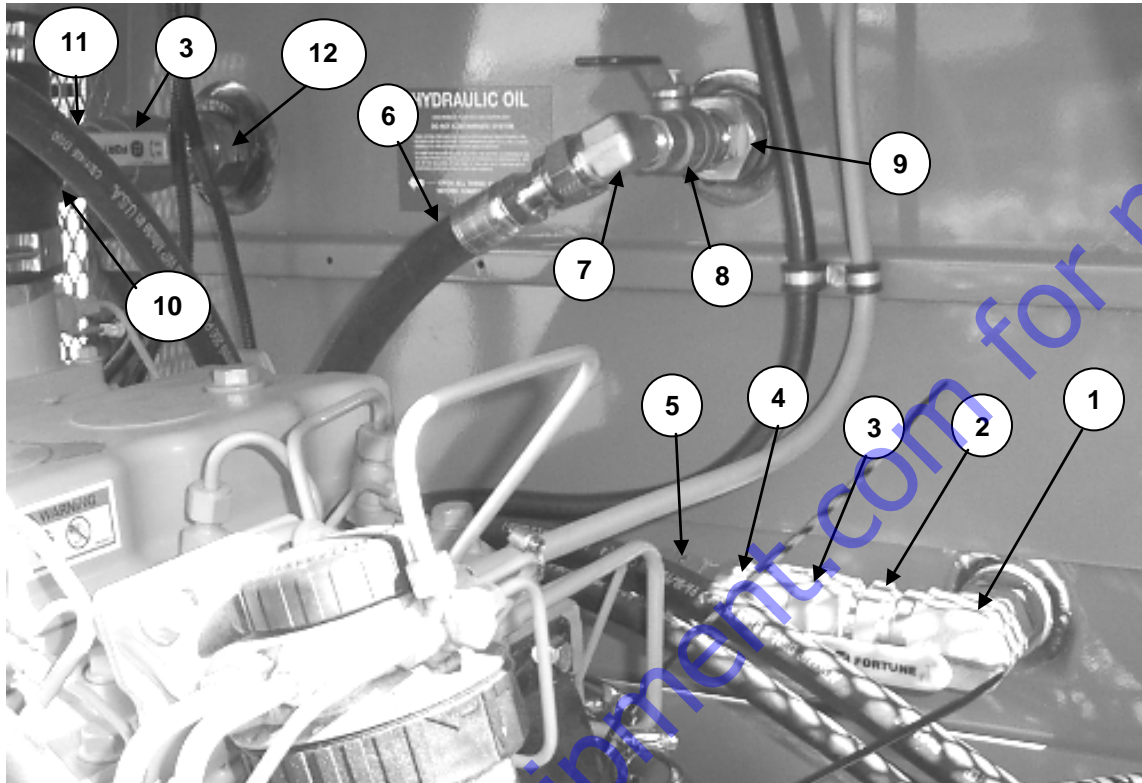
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325004	M-45 Piston Pump, 75cc	1
2	325015	Suction Manifold	1
3	325020	Hydraulic Oil Filter	2
4	N/A	Hydraulic Hose Assy., 22" – 1GA16FRB16 (2)	1
5	N/A	Hydraulic Fitting, FF1852T1616S	2
6	N/A	Hydraulic Hose Assy., 19" – 1GA16FRB16	1
7	N/A	Hydraulic Hose Assy., 48.5" – 1BA16FRB16 & 1B16FLA16	1
8	N/A	Hydraulic Hose Assy., 27" – 1AA8FRB8 (2)	1
9	N/A	Hydraulic Fitting, FF1852T0810S	1
10	N/A	Hydraulic Fitting, FF1852T0404S	1
11	N/A	Hydraulic Hose Assy., 76" – 1AA4FRB4 & 1AA4FRC4	1
12	N/A	Flange Kit, FF593-449-74446-32	1
13	N/A	Flange Kit, FF593-449-74446-16	1

PVG VALVE VIEW



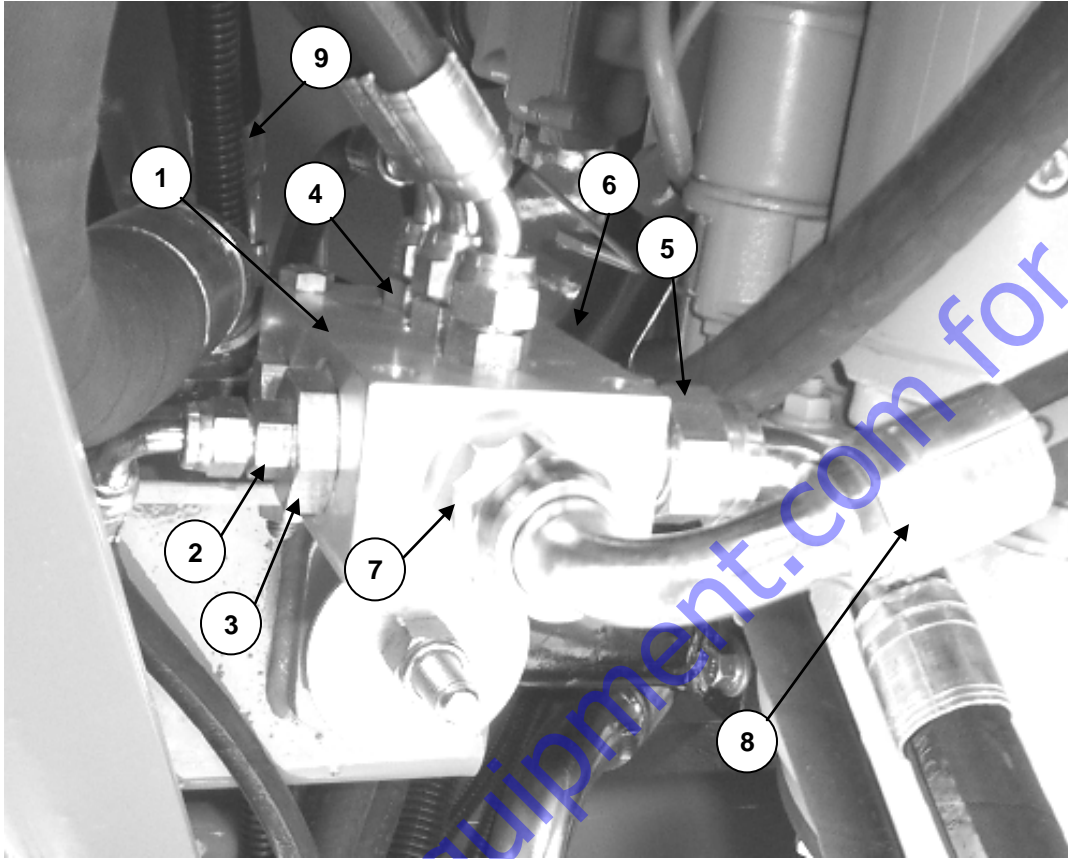
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325006	PVG32/6 Control Valve	1
2	N/A	Hydraulic Fitting, FF1852T1616S	1
3	N/A	Hydraulic Fitting, FF1852T2016S	1
4	N/A	Hydraulic Hose Assy., 7.5" – 1GA20FR20 & 1GA20FRB20	1

HYDRAULIC TANK VIEW



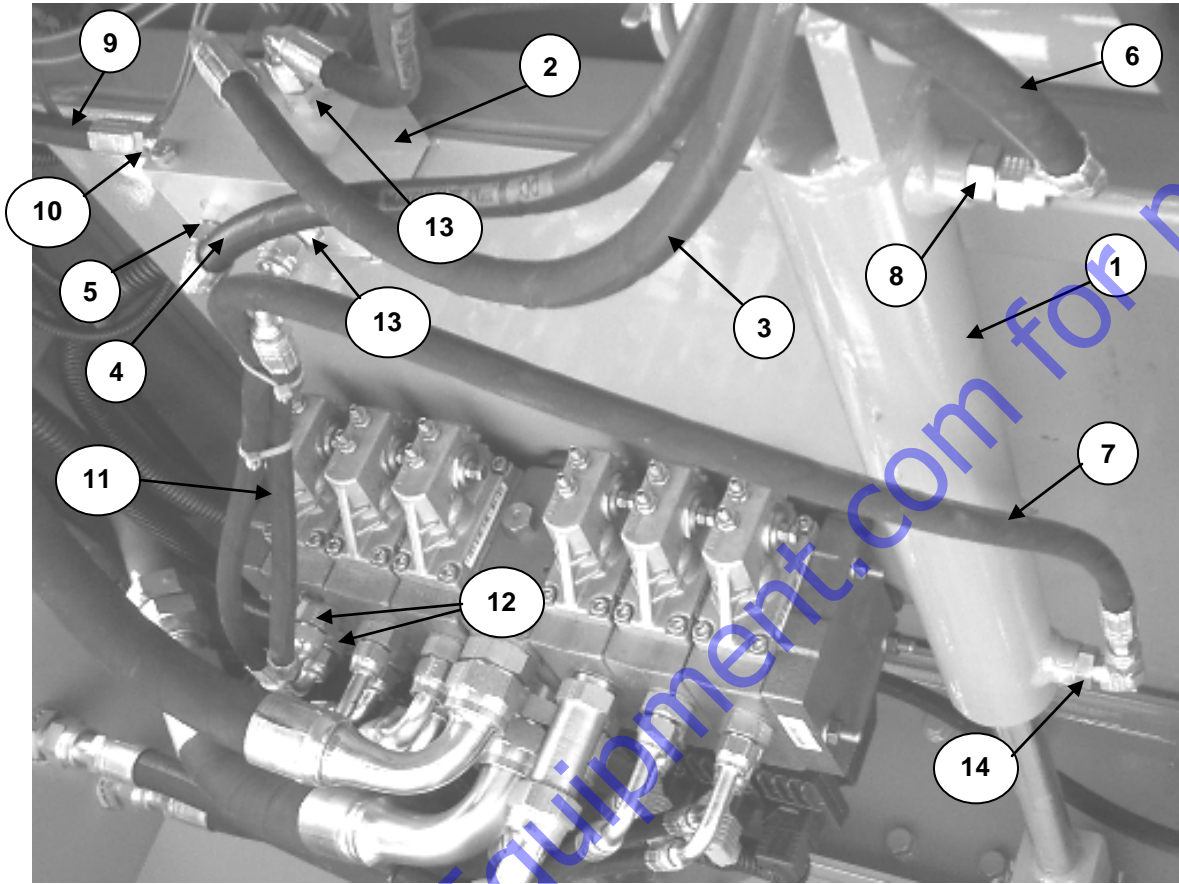
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	N/A	Hydraulic Fitting – Elbow, 6805-20-20FG	1
2	N/A	Hydraulic Fitting, 2083-20-20S	1
3	306538	1 1/4" Ball Valve – 1/4 Turn Valve	1
4	N/A	Hydraulic Fitting, FF2031T2020S	1
5	N/A	Hydraulic Hose Assy., 12"–1GA20FR20 & 1GA20FRB20	1
6	N/A	Hydraulic Hose Assy., 65" – 1AA12FR12 (2)	1
7	N/A	Hydraulic Fitting, FF2032T1212S	1
8	306535	3/4" Ball Valve	1
9	N/A	Hydraulic Adapter Fitting, 6401-12-12	1
10	N/A	Hydraulic Hose Assy., 26" – 1GA20FR20 & 1GA20FRA20	1
11	N/A	Hydraulic Adapter Fitting, FF2031T2020S	1
12	N/A	Hydraulic Adapter Fitting, 6401-20-20	1

CASE DRAIN MANIFOLD VIEW



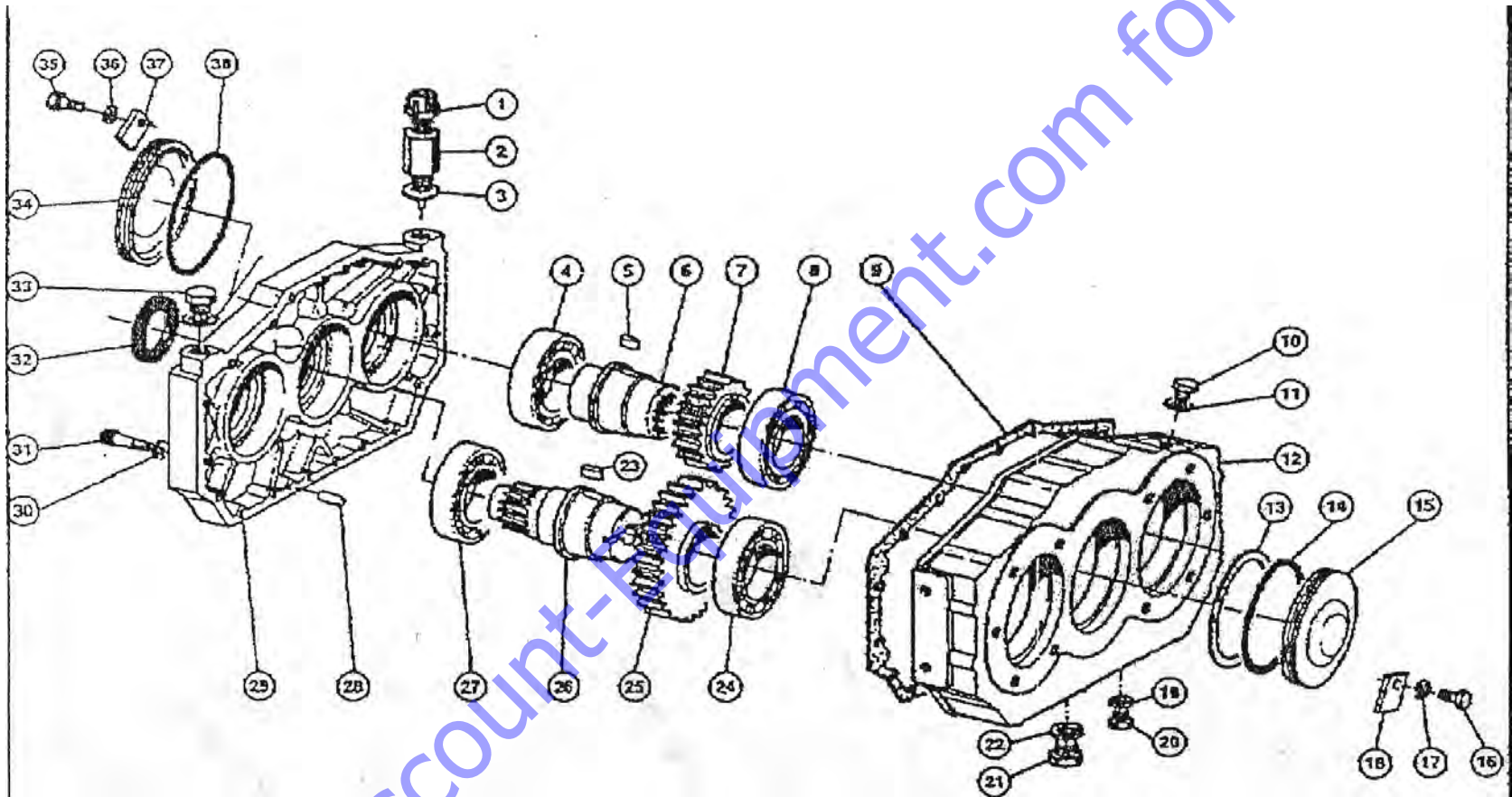
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325016	Case Drain Manifold	1
2	N/A	Hydraulic Adapter, FF1852T0406S	1
3	N/A	Hydraulic Bushing, FF1010-1206S	1
4	N/A	Hydraulic Fitting, FF1852T0606S	3
5	N/A	Hydraulic Fitting, FF1852T1212S	1
6	N/A	Hydraulic Fitting (Port 7), FF1852T0812S	1
7	N/A	Hydraulic Fitting, FF1852T1212S (3054B Cat Engine Only)	1
7	N/A	Hydraulic Fitting, FF1868T1212S (3054C Cat Engine Only)	1
8	N/A	Hydraulic Hose Assy., 40" – 1AA12FR12 & 1AA12FRB12	1
9	N/A	Hydraulic Hose Assy., 93" – 1AA6FRA6 & 1AA6FRB6 Hydraulic Fitting (Port 5), FF1852T0612S	1 1

CORE LIFT CYLINDER VIEW



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	325014	Core Lift Cylinder, 2" x 12"	1
2	325019	Dual Locking Valve – Lift Lock Solenoid	1
3	N/A	Hydraulic Hose Assy., 43" – 1AA4FR4 & 1AA4FRB4	1
4	N/A	Hydraulic Hose Assy., 88" – 1AA4FRB4	1
5	N/A	Hydraulic Fitting, FF1852T0406S	1
6	N/A	Hydraulic Hose Assy., 20" – 1AA4FRB4 (2)	1
7	N/A	Hydraulic Hose Assy., 39.5" – 1AA4FR4 & 1AA6FRB4	1
8	N/A	Hydraulic Fitting, FF1852T0406S	1
9	N/A	Hydraulic Hose Assy., 63" – 1AA4FR4 & 1AA4FRB4	1
10	N/A	Hydraulic Fitting, FF1852T0406S	1
11	N/A	Hydraulic Hose Assy., 14" – 1AA4FRB4 & 1AA6FRB4	1
12	N/A	Hydraulic Fitting, FF1852T0610S	2
13	N/A	Hydraulic Fitting, FF1852T0406S	1
14	N/A	Hydraulic Fitting, FF1868T0406S	1

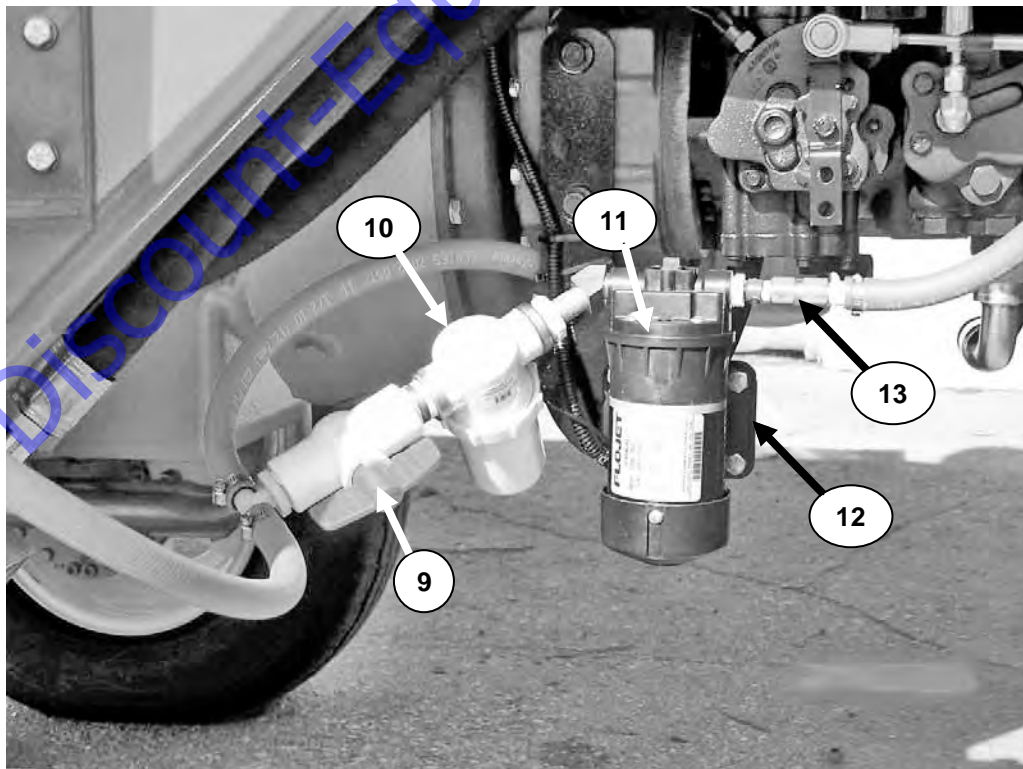
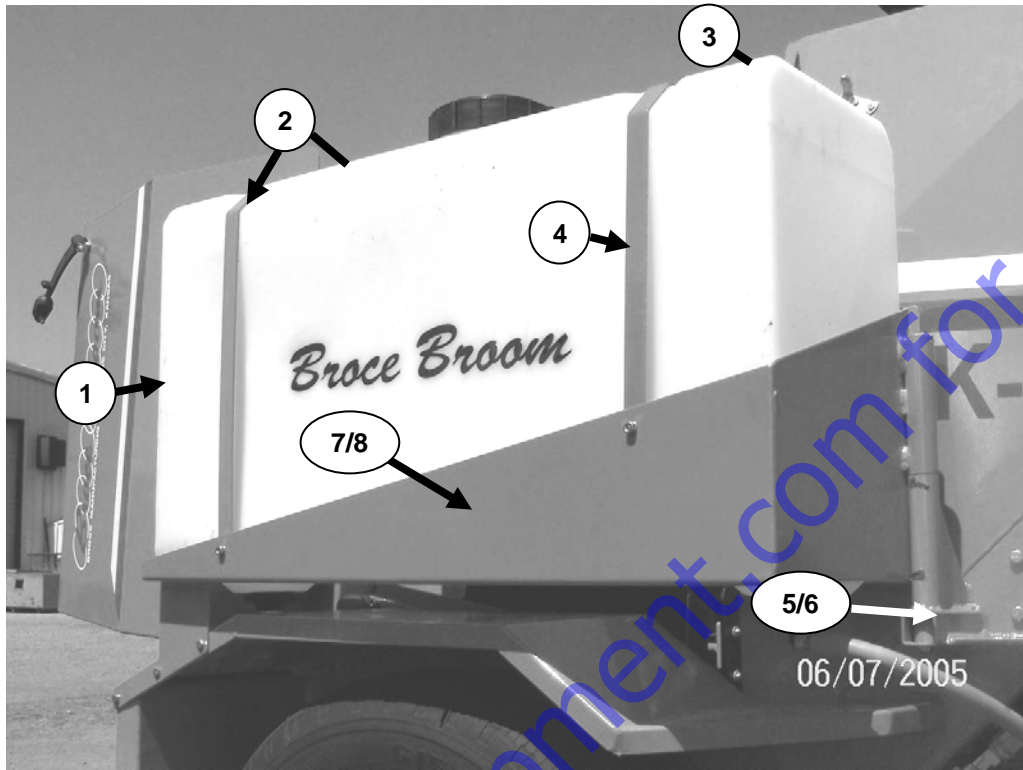
GEAR BOX ASSEMBLY



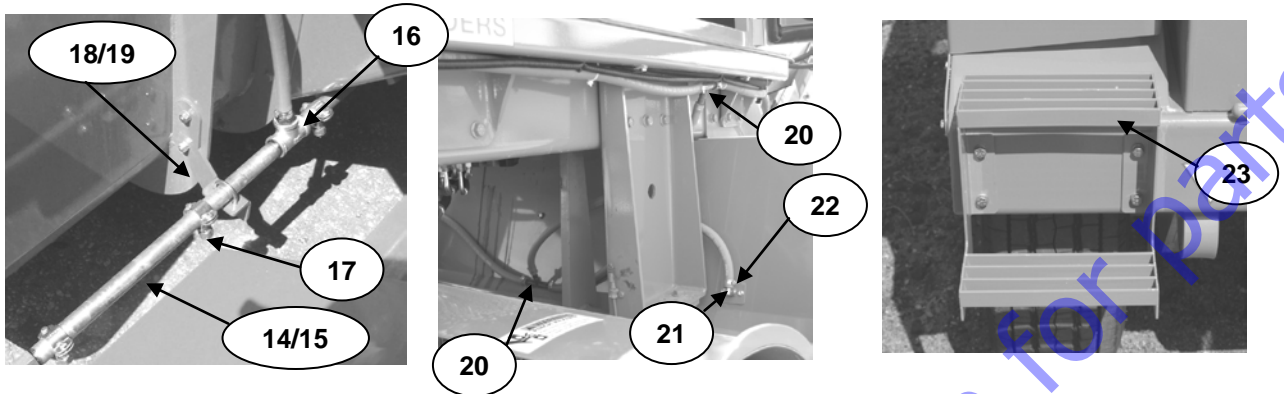
GEAR BOX ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	2070106	Oil Gauge	1
4	4605257	Ball Bearing	2
5	4620054	Key	2
6	2021180	Driven Shaft	2
7	2061243	Gear	2
8	4605257	Ball Bearing	2
9	4574013	Silicone Sealant Tube	1
12	2009044	Housing	1
13	2013240	Shim	X
14	4598030	O-Ring	1
15	2010119	Plate	1
21	4588040	Plug	1
22	4609020	Washer	1
23	4620054	Key	1
24	4605257	Ball Bearing	1
25	2061243	Gear	1
26	2021179	Main Shaft	1
27	4605257	Ball Bearing	1
28	4614014	Pin	1
29	2010117	Cover	1
30	4611108	Washer	19
31	4615227	Screw	19
32	4597165	Oil Seal	1
33	4588040	Plug	1
39	4609020	Washer	1

WATER SPRAY SYSTEM

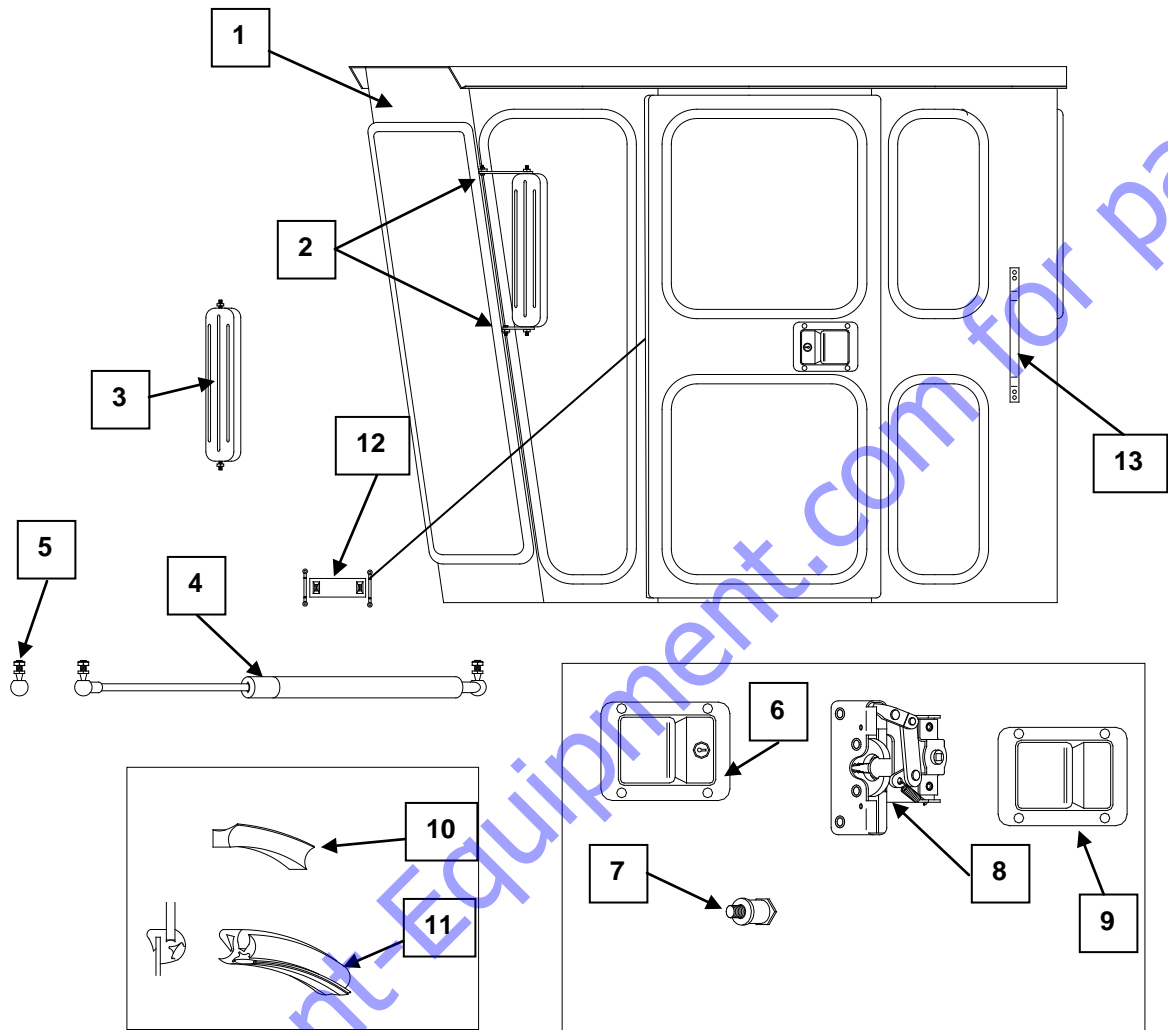


WATER SPRAY SYSTEM



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	344178	Water Tank	2
2	205254	Tank Strap Rear	4
3	205255	Tank Strap Front Inside	2
4	205253	Tank Strap Front Outside	2
5	855251	Frame Bracket Assembly RH	1
6	855252	Frame Bracket Assembly LH	1
7	855249	Tank Basket Assembly RH	1
8	855250	Tank Basket Assembly LH	1
9	344254	Ball Valve	1
10	WS-148	Inline Strainer, Complete	1
NS	1700-0044	Strainer Gasket	1
NS	3800-0025	Strainer Screen	1
NS	3351-0005	Strainer Cup	1
11	302402	Pump	1
12	205262	Pump Mounting Bracket	1
13	306950	Check Valve	1
14	205247	Spray Bar RH	1
15	205248	Spray Bar LH	1
16	306125	T-Fitting	1
17	WS-155	Nozzle Assembly	9
NS	WS-158	Nozzle Screen	9
NS	TP8002	Nozzle Spray Tip	9
NS	1458	Nozzle Cap	9
18	205245	Bracket RH	1
19	205246	Bracket LH	1
20	306901	Barb Tee 1/2"	2
21	306925	Brass Nozzle Housing	2
22	345007	Fitting, Hose Barb to 1/2 FNPT 90 Deg	2
23	855270	Water System Step	2

CAB ASSEMBLY

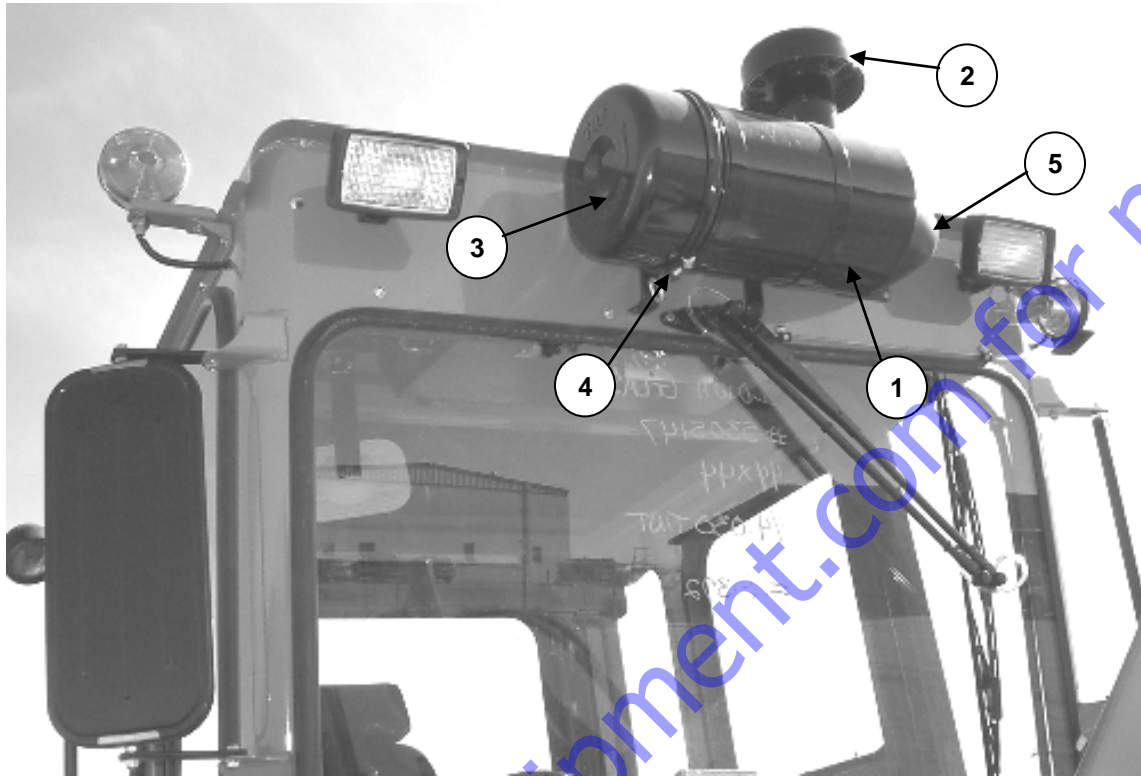


CAB ASSEMBLY

Reference	Part No.	Description	Qty.
1	P-315-B 345055	Cab Assembly, Complete Cab Keys, (Sold as a Pair)	1 1
2	202116	Mirror Bracket, (2 per Side)	4
3	P-353-R	West Coast Style Mirror (1 per Side)	2
4	P-352-B	Strut, (1 per Side)	2
5	309406	Ball for Strut	2
6	345051	Outside Door Handle (Paddle Style)	2
7	P-320-B	Striker Assembly	2
8	345053	Latch Assembly	2
9	345050	Inside Door Handle (Paddle Style)	2
10	304089	Door Seal, 14' per door	1
11	P-325-R P-316-R	Window Rubber Molding, (As Required) Floor Mat, 5' x 4' Blank	1 1
12	K00002	Door Tether Strap, Inside (1 per Side)	2
13	B239920C	Outside Grab Handle	1
Not Shown	345052	Inside Grab Handle	2
Not Shown	AC-708-R	Air Cleaner Assembly	1
Not Shown	AC-785-R	Air Cleaner Bonnet (Top Cap)	1
Not Shown	P10-3113	Air Cleaner End Cap	1
Not Shown	P00-3951	Air Cleaner Clamp	2
Not Shown	110-20027	Air Cleaner Flex Hose	1
Not Shown	P10-2114	Air Cleaner Vent	1
Not Shown	AC-709-R	Air Cleaner Filter	1

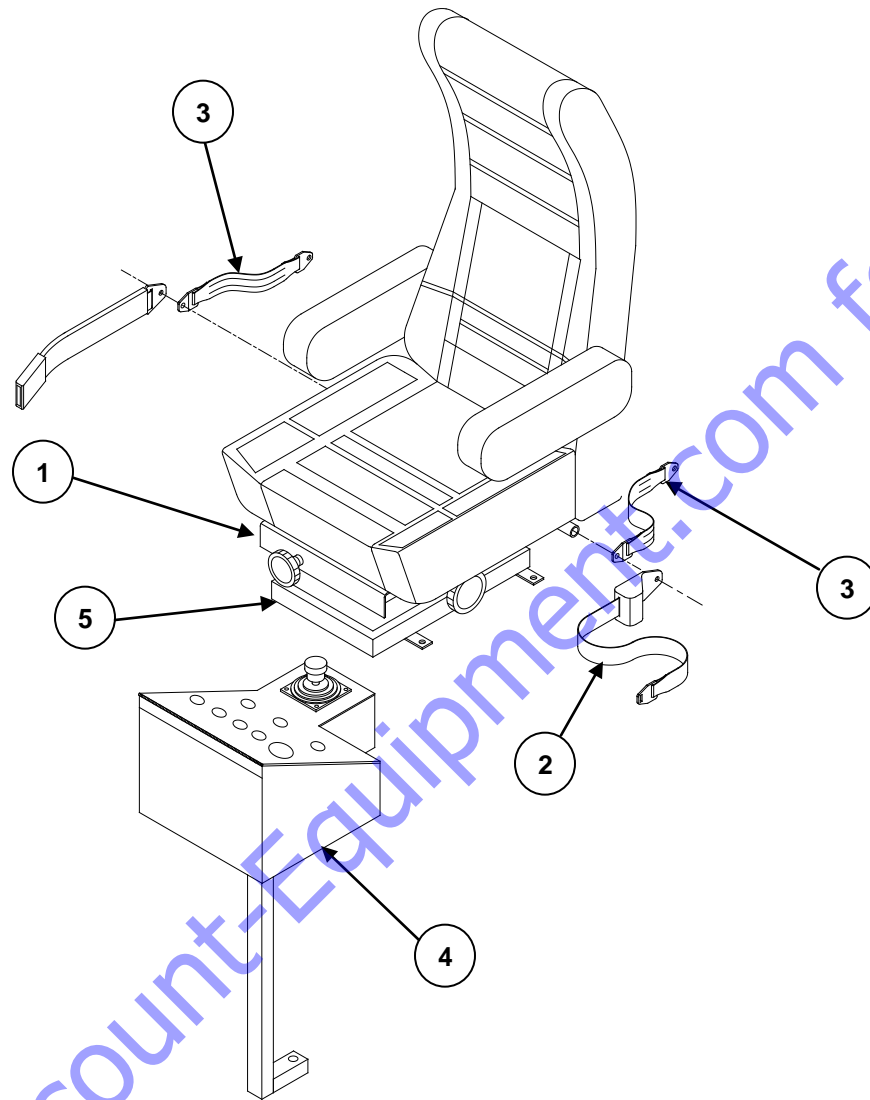
Note: Items 10 & 11 are sold by the foot. Floor mat is a "Cut to Fit" item.

CAB – FRONT VIEW



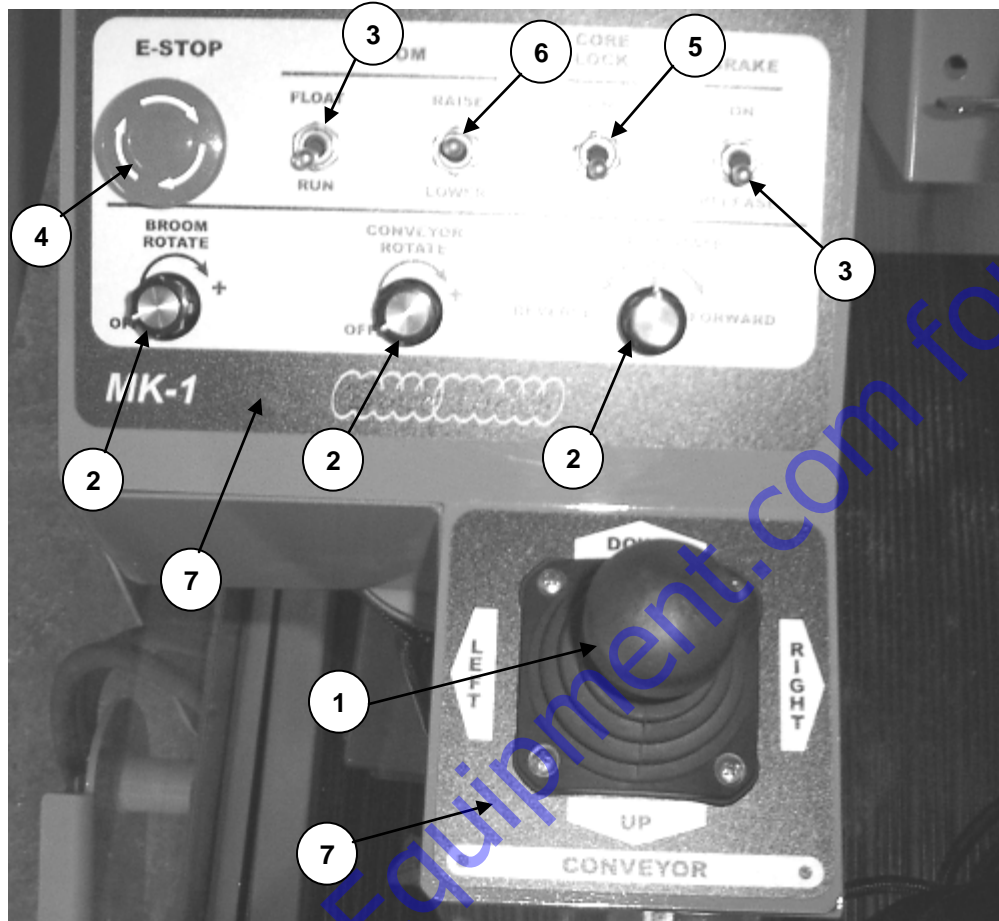
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	AC-708-R	Air Cleaner Assembly	1
2	AC-785-R	Bonnet	1
3	P10-3113	End Cap	1
4	P00-3951	Clamp	1
5	110-20027	Flex Hose	1
NS	P10-2114	Vent	1
NS	AC-709-R	Filter	1

SEAT AND SUSPENSION COMPONENTS



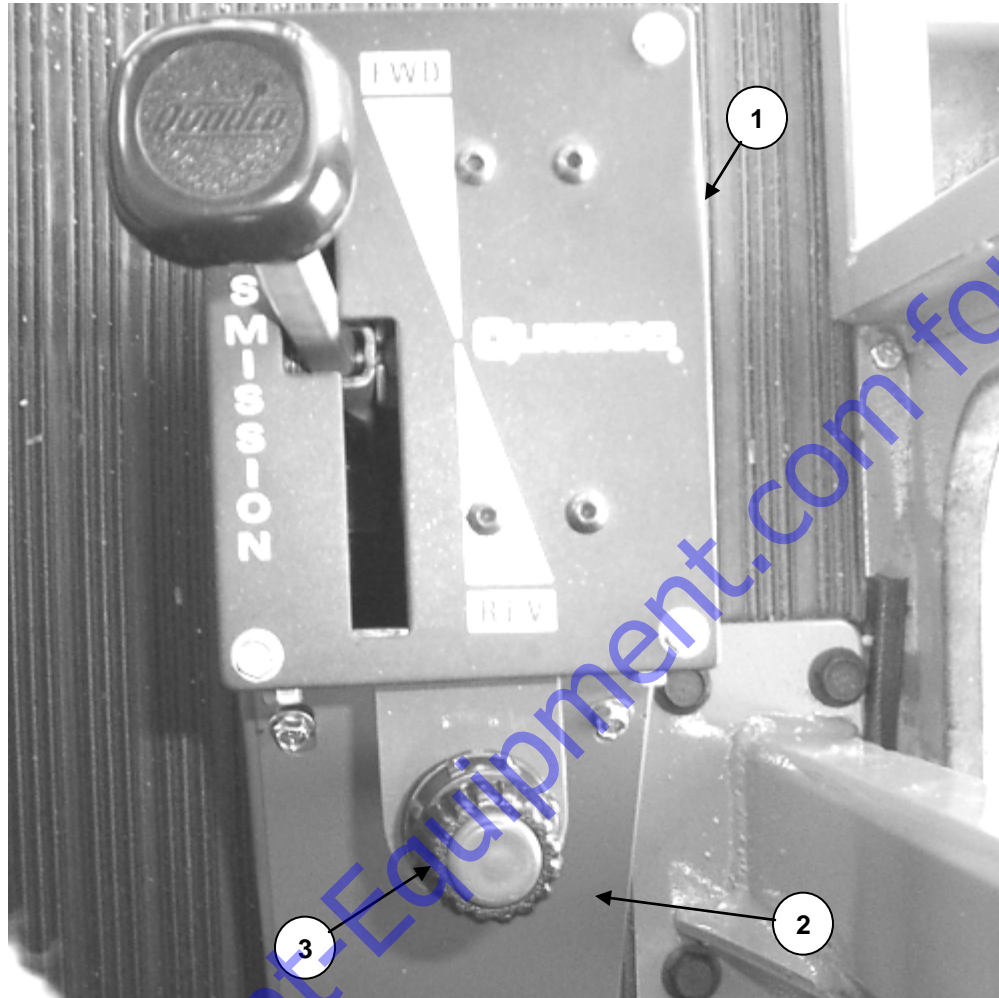
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	BS-1050	Seat	1
2	C-211-R	Retractable Seat Belt (Shown)	1
	C-211-SH	Retractable Seat Belt w/ Shoulder Harness (Not Shown)	1
3	C-211-RT	Tether Strap Set (for use w/ Suspension Seat)	1
4	855182	Control Box Assembly	1
5	BS-1054	Suspension Assembly	1

BROOM/CONVEYOR CONTROL BOX



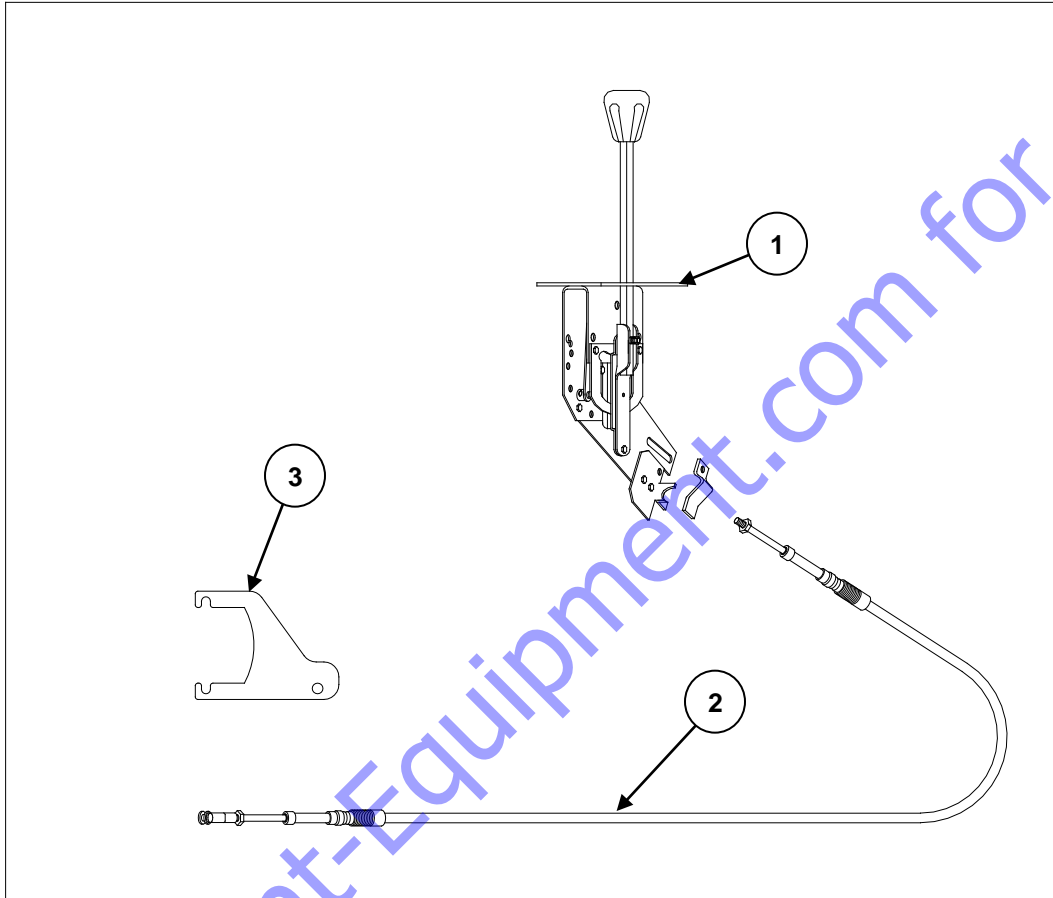
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	307432	Conveyor Joystick Control	1
2	307417	Broom, Conveyor, & Auger Speed Pot Control	3
3	307416	Broom Float/Run & Emergency Brake Switches	2
4	307427	Emergency Stop Switch	1
5	307071	Core Lock On/Off Switch	1
6	307415	Broom Raise/Lower	1
7	311165	Control Panel Decals (Set of 2)	1

TRANSMISSION CONTROL BOX



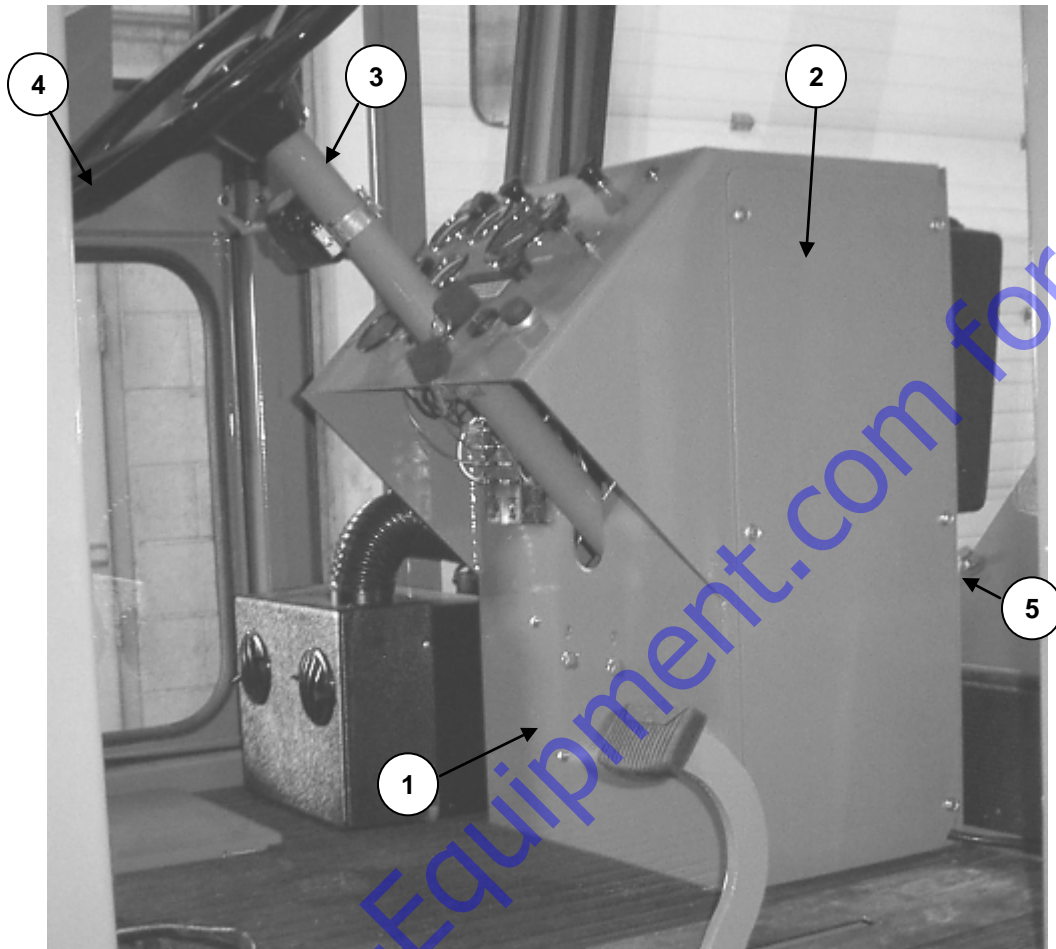
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855171	Transmission Hand Control Box	1
2	855172	Hand Control Box Cover	1
3	309456	Throttle Cable	1

HYDROSTATIC CONTROL ASSEMBLIES



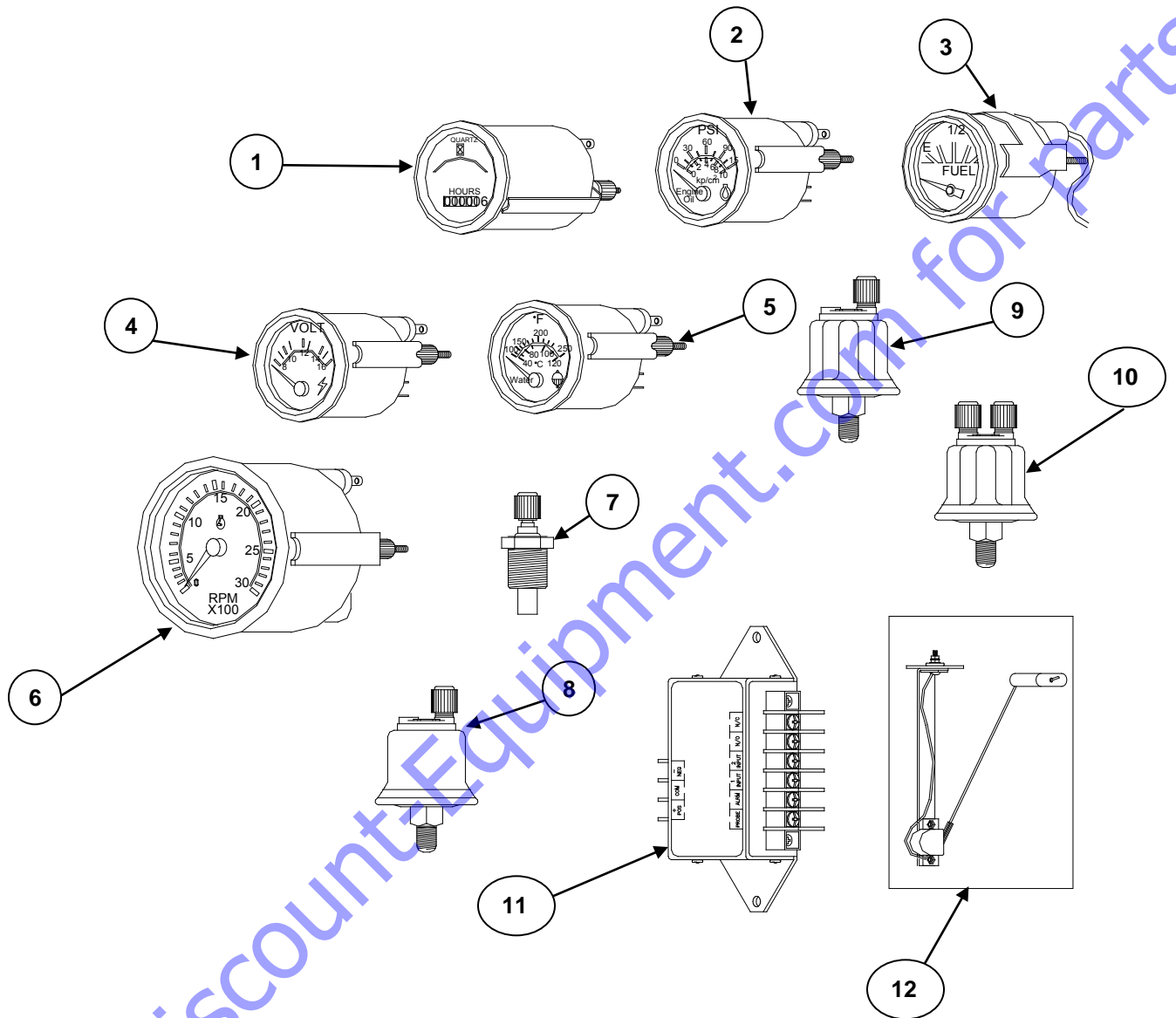
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	403035	Hand Control Kit	1
2	309470	Hand Control Cable	1
3	205175	Bracket	1

DASH/STEERING ASSEMBLY



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	855168	Dash Housing	1
2	205169	Dash Side Cover	1
3	305945	Steering Column	1
4	S-253-R	Steering Wheel Assembly	1
5	001665	Dash Back Cover	1

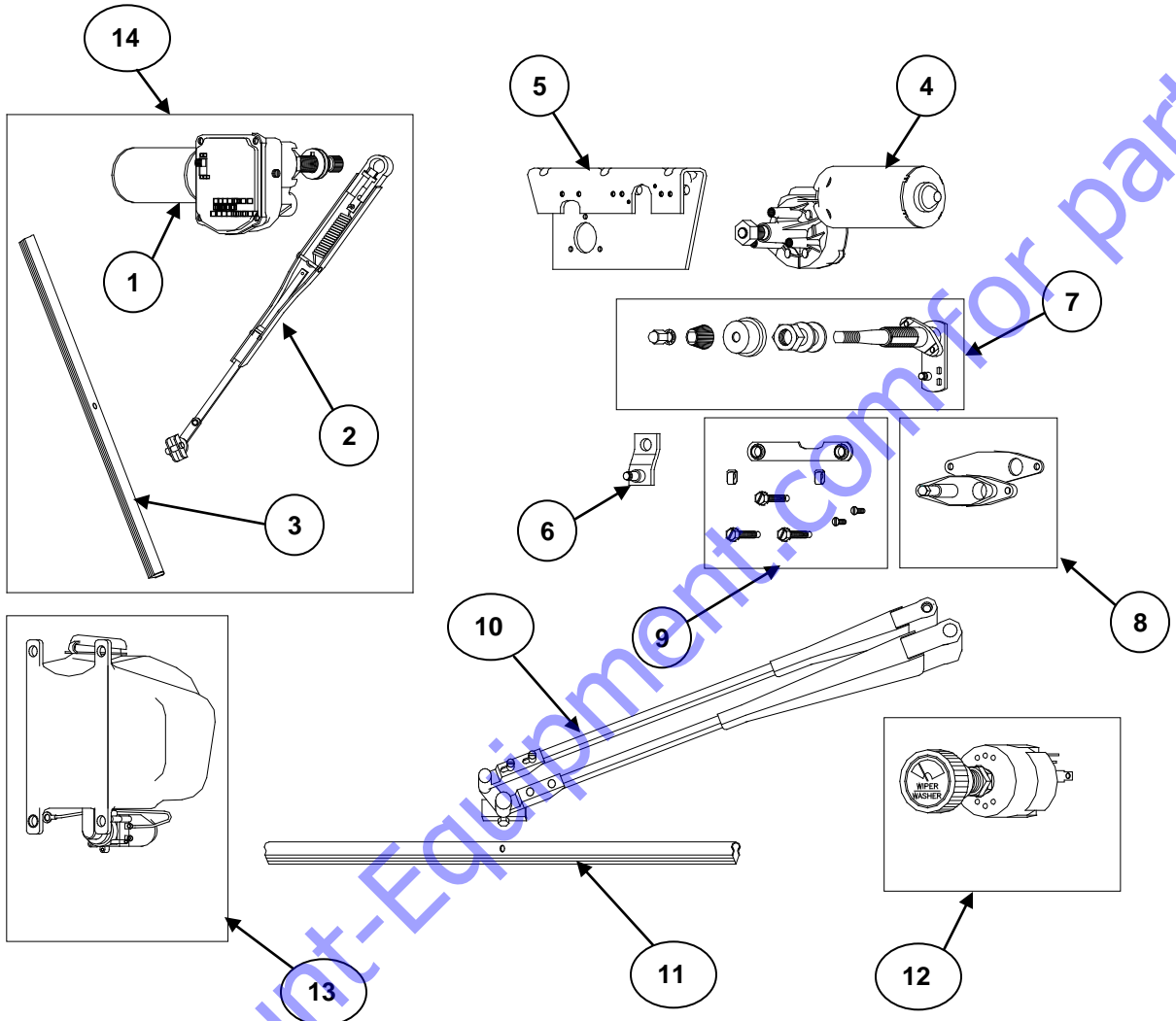
GAUGES AND SENDERS



GAUGES AND SENDERS

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	I-222-HO	Hour Meter	1
2	I-221-R	Oil Pressure Gauge	1
3	I-223-R	Fuel Gauge	1
4	I-220-V	Voltmeter	1
5	I-219-R	Temperature Gauge (Engine)	1
6	I-222-B	Tachometer	1
7	307084	Temperature Sender, CAT 3054C	1
	307088	Temperature Sender, CAT 3054B	1
8	76502	Hour Meter Sending Unit	1
9	IS-221-R	Oil Pressure Sender	1
10	IS-221-WC	Pressure Sender w/ Contact Note: Use w/ warning or shutdown system	1
11	W117	Murphy Switch, Engine shutdown system	1
12	344175	Fuel Sender	1
NS	IS-219-WC	Warning Shutdown Water Sender	1

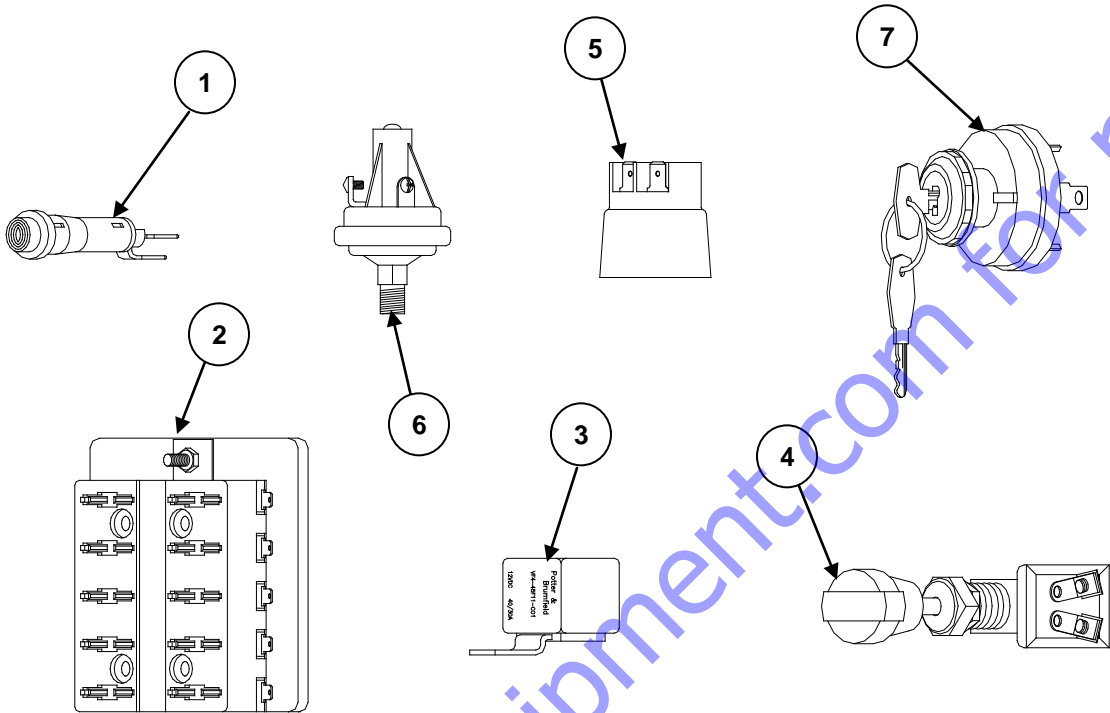
WINDSHIELD WIPERS & WASHER



WINDSHIELD WIPERS & WASHER

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	1-182-54MO	Wiper Motor	1
2	LE581022-1	Drive Arm	1
3	2-615-2218	18" Blade (Canopy Windshield)	1
	2-615-2214	14" Blade (Rear)	
4	2-615-15	Wiper Motor	1
5	BK721005	Wiper Motor Mount	1
6	2-615-19	Wiper Drive Arm (Tapered Motor Shaft)	1
7	2-615-60	Wiper Shaft & Arm Assembly	1
8	2-615-17	Pantograph Adapter & Gasket	1
9	721014	Link & Bolt Kit (Includes Bolts, Washers, & Clips)	1
10	2-615-24	Pantograph Drive Arm	1
11	2-615-2226	26" Blade	1
12	2-686-67	Two Speed Wiper Switch	1
13	66-01	Washer Pump & Reservoir	1
	66-01A	Washer Kit (Includes Tubing & Hardware)	1
14	1-182-54	Wiper Kit – Canopy Windshield (Motor, Blade, Arm)	1
	1-182-54R	Wiper Kit – Rear (Motor, Blade, Arm)	1

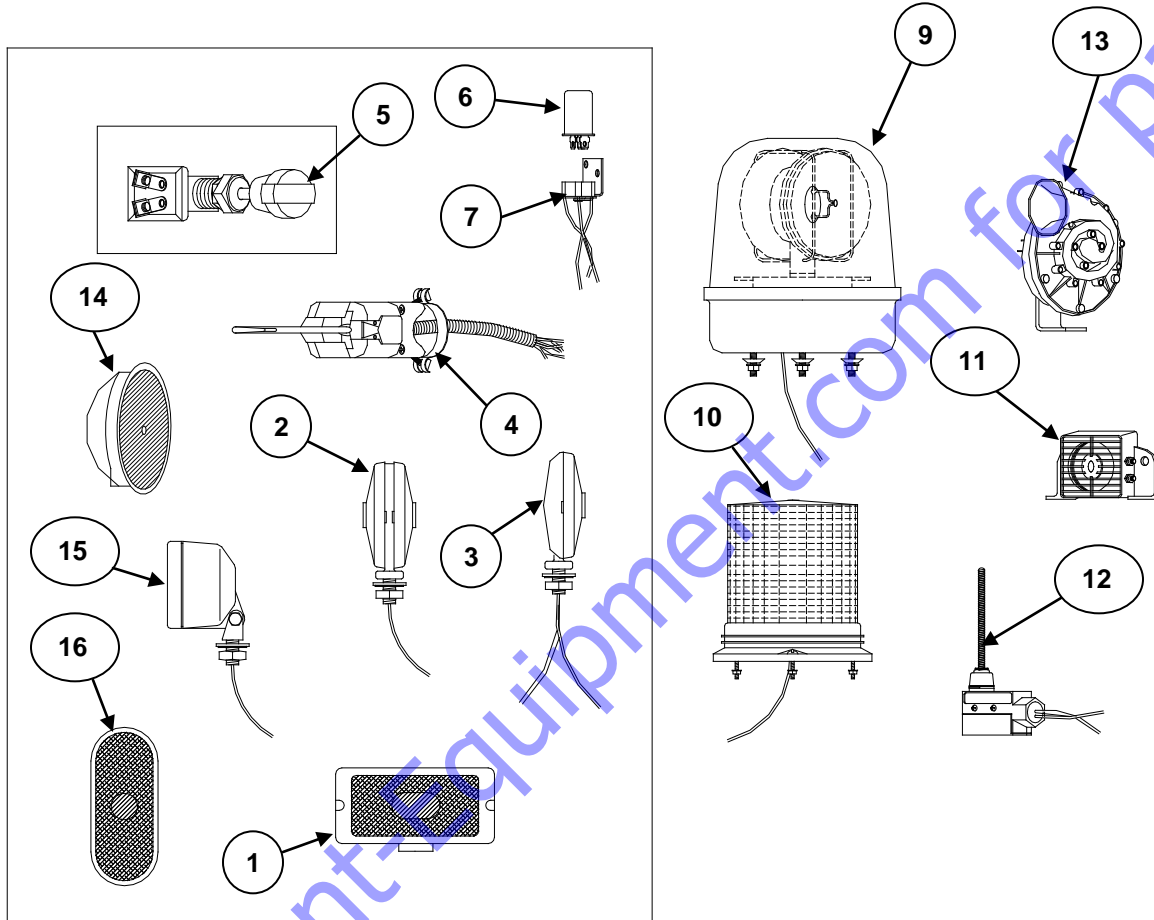
MISC. SWITCHES, FUSES, ETC.



MISC. SWITCHES, FUSES, ETC.

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	PBL-12	Warning Light	1
2	46050-12	Fuse Block (12 Fuse Capacity)	1
	46050-10	Fuse Block (10 Fuse Capacity)	1
3	WH4411201	Relay – Air Conditioning Shutoff	1
4	23836	Universal Accessory Switch	1
5	X770050	Air Restrictor Sender (Air Cleaner Ind.)	1
6	76052	Pressure Switch (Air Conditioner Shutoff)	1
7	307044	Ignition Switch	1
	307045	Key (Pair)	1
NS	307235	Push Button Switch for Preheat	1

LIGHTS – HORNS

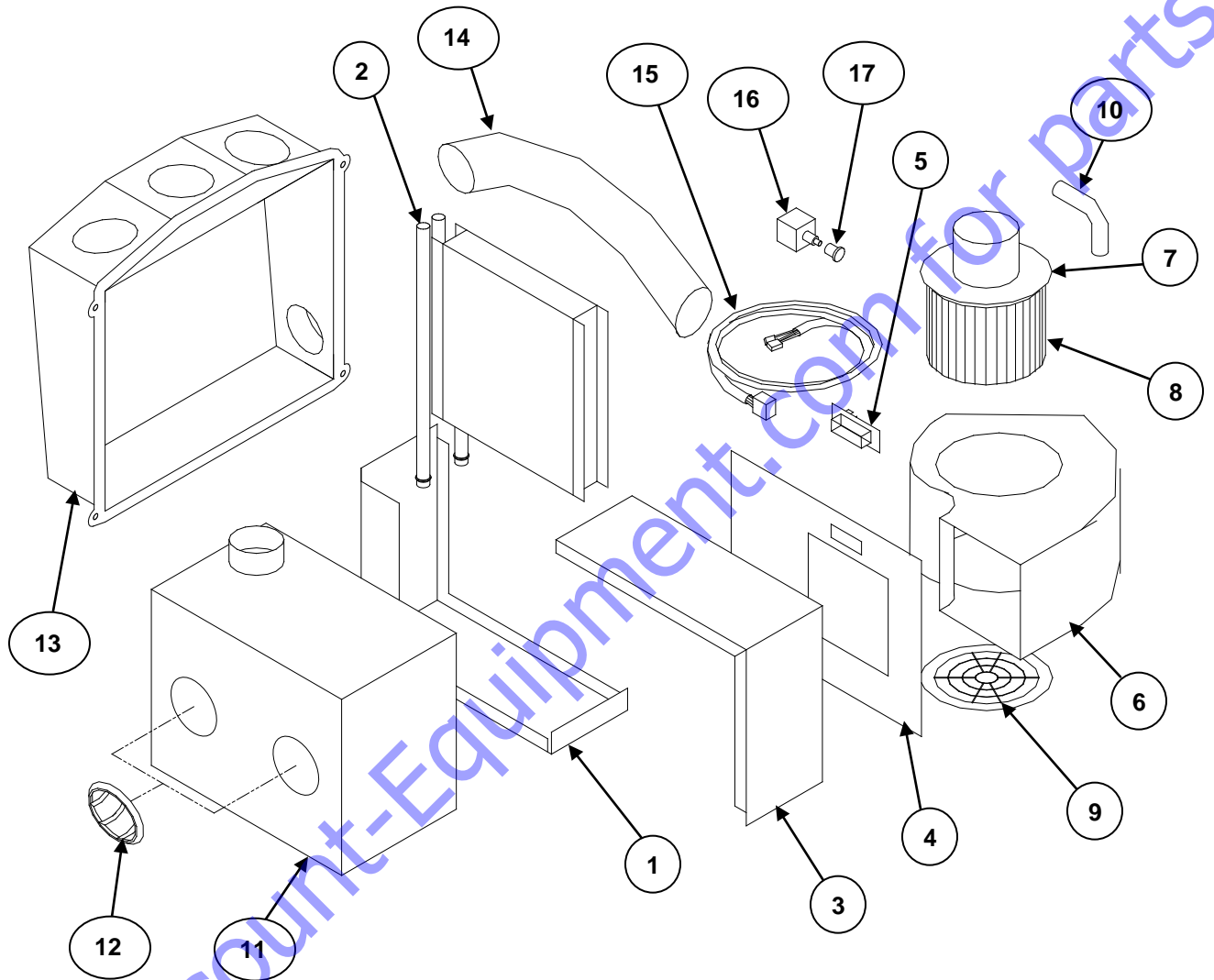


LIGHTS - HORNS

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9-50004-SBA	Driving Light	A/R
2	4-75001	Turn Signal	2
3	6-70001	Stop/Turn Signal	2
4	16-35800	Turn Signal Switch	1
5	23836	Universal Accessory Switch	1
6	550	Flasher	1
7	550FH	Flasher Socket	1
8	LG-100-SBA	Light Group Kit w/ 950004-SBA Driving Lights	See Note
9	7-40004	Amber Beacon	A/R
10	3614A	Amber Strobe Light	A/R
11	RH-250	Reverse Alarm	1
12	LDA-50-1R	Reverse Alarm Switch	1
13	4-302	Traffic Horn	1
14	307031	Flush Mount Tail/Brake Lights	2
15	108-00-132	Work Light	A/R
16	307228	Back Up Light	2

Note: Light Group Kit, Part Number LG-100-SBA, contains all signals, switches, lights, and wiring harness required for field installation.

HEATER/DEFROSTER SYSTEM



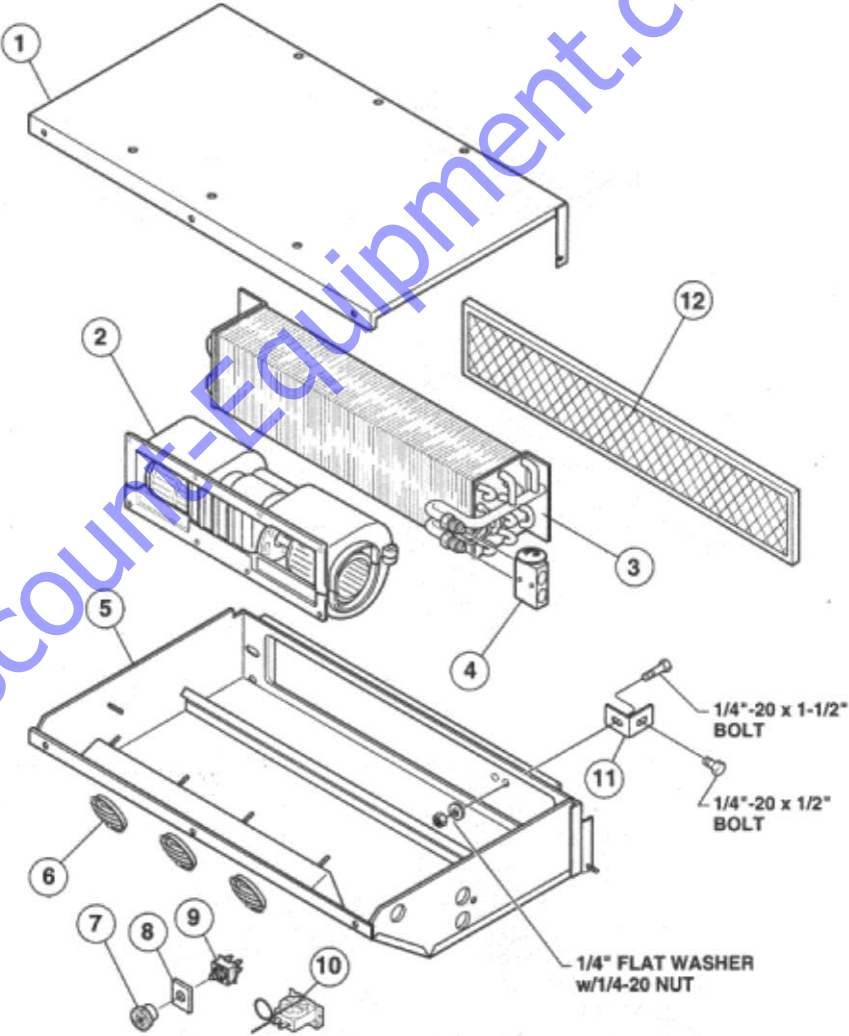
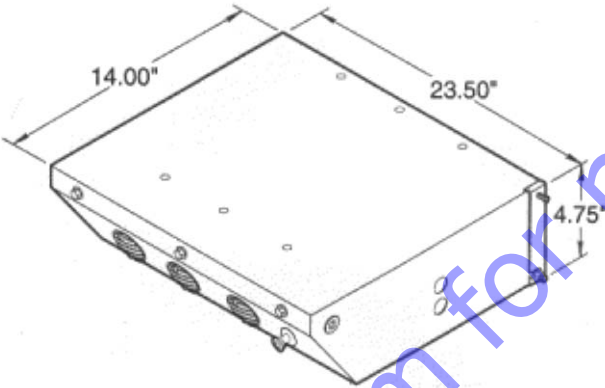
HEATER/DEFROSTER SYSTEM

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	403153	Case, Bottom/Side	1
2	403154	Coil	1
3	403155	Cast, Top/Side	1
4	403156	Panel, Blower	1
5	403157	Resistor, 3-Speed	1
6	403158	Housing, Blower	1
7	403159	Motor, CCW	1
8	403160	Wheel, Blower	1
9	403161	Ring, Venturi	1
10	403162	Hose, Vent Motor Blower	1
11	Call	Plenum, Heater	1
12	403164	Louver, 3" Round	1
13	403193	Plenum, Defrost	1
14	403166	Hose – Flex, Wire, Metal, 2.5" Dia.	1
15	403167	Wire Harness – Heater	1
16	403168	Switch, 4 Position Rot.	1
17	403169	Knob – Rotary Switch	1
KIT	Call	Heater/Defroster Kit, CAT 3054B & 3054C	1

AIR CONDITIONING SYSTEM

Features:

- 255 CFM
- Heavy Duty Powder Coated Finish all steel case.
- Low Profile for maximum headroom.
- Filtered, recirculated air.



AIR CONDITIONING SYSTEM

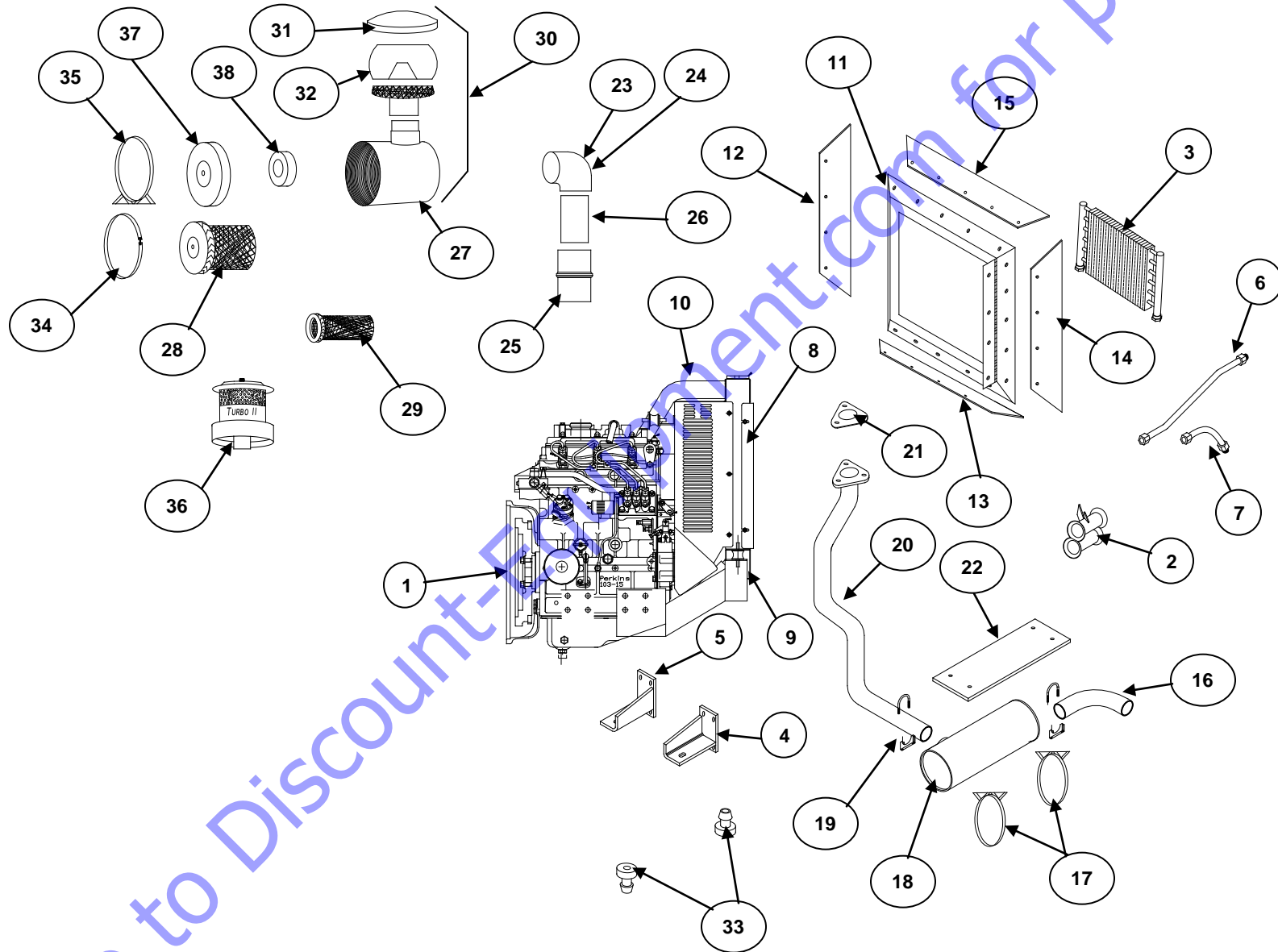
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	403184	Cover, Evaporator	1
2	403180	Blower Assembly	1
3	403175	Coil, Evaporator	1
4	403174	Valve, Exp., Block, R134a	1
5	403183	Housing, Evaporator	1
6	403164	Louver, 3" Round	1
7	403177	Knob, Fan	1
8	403181	Decal, Fan	1
9	403173	Switch, Rotary	1
10	403176	Thermostat	1
11	403187	Bracket, Mounting, Exp. Valve	1
12	403178	Filter	1
NS	403182	TSTAT Knob	1
NS	403185	Binary Switch	1

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ENGINES AND RELATED PARTS

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3054B ENGINE AND RELATED PARTS

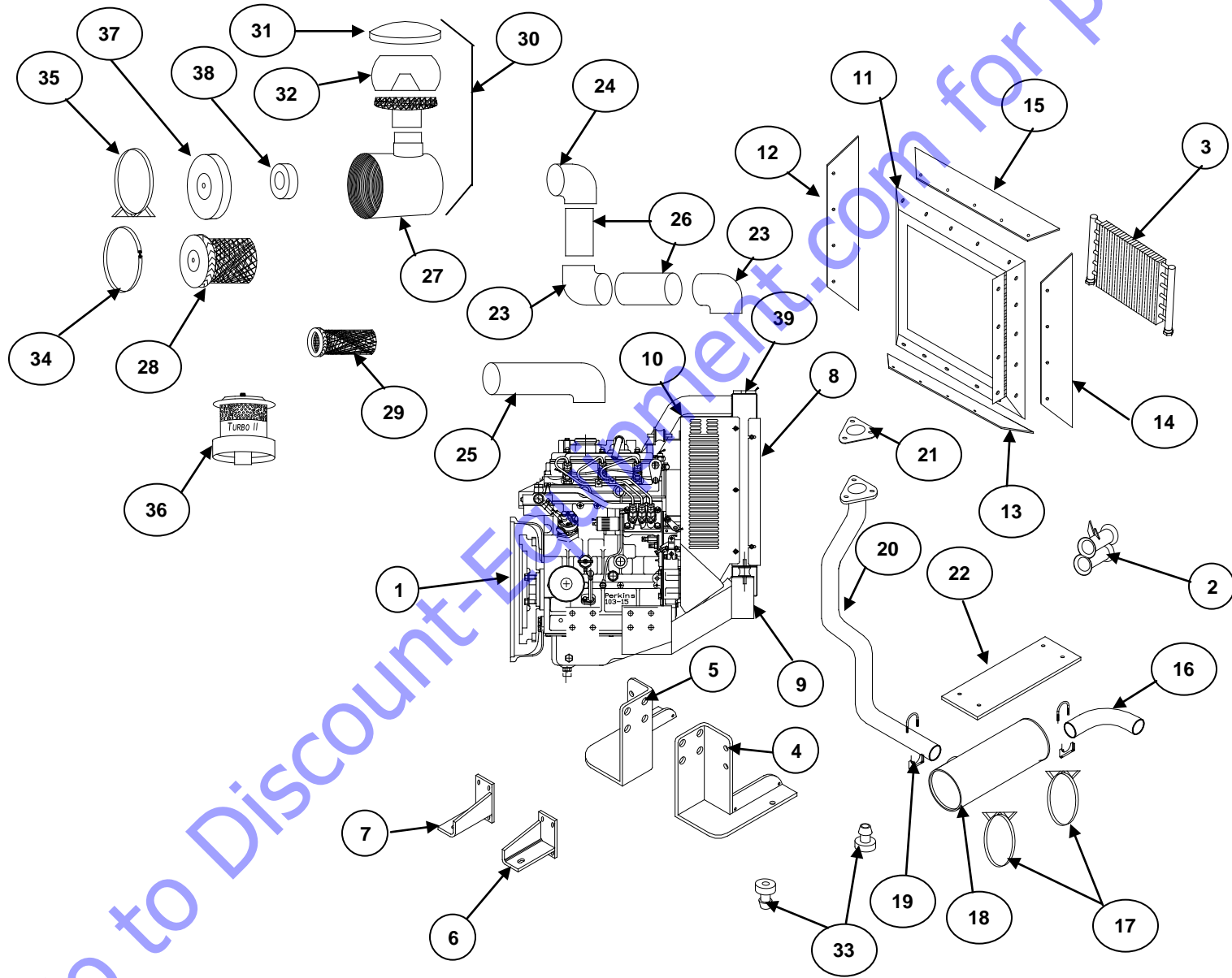


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3054B ENGINE AND RELATED PARTS

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	344062	CAT 3054B Diesel Engine	1
2	852045	Oil Cooler Sleeve	1
3	305766	Oil Cooler	1
4	852043	Right Rear Motor Mount (front of broom)	1
5	852042	Left Rear Motor Mount (front of broom)	1
6	852051	Oil Cooler Tube, 23 1/2"	1
7	852052	Oil Cooler Tube, 6 1/2"	1
8	163-1934	Radiator Assembly	1
9	344506	Lower Radiator Hose	1
10	344505	Upper Radiator Hose	1
11	852075	Oil Cooler Mount	1
12	203193	Right Side Oil Cooler Seal	1
13	203190	Lower Seal (Rubber)	1
14	203192	Left Side Oil Cooler Seal	1
15	203191	Upper Seal (Rubber)	1
16	344040	Tail Pipe	1
17	203123	Muffler Clamp	2
18	JE-705-B	Muffler	1
19	JE-758-B	Head Pipe Clamp	2
20	853605	Exhaust Pipe	1
21	344031	Exhaust Gasket	1
22	203105	Exhaust Heat Shield	1
23	AC-760-R	Rubber Elbow, 3" x 3"	2
24	AC-760-B	Rubber, 3.5" x 3"	1
25	304061	Rubber Hump Hose, 3" x 3"	1
26	AC-763-R	Connecting Tube, Short	1
27	DE-770-R	Air Cleaner (Dual Element)	1
28	P182059	Service Element	1
29	P119410	Safety Element	1
30	PC-710-B	Precleaner, 4"	1
31	PC-765-R	Precleaner, Top	1
32	PC-711-R	Precleaner Bowl	1
33	304095	Engine Isolator Kit	4
34	P003951	Clamp	1
35	AC-764-R	Strap	2
36	TT-771-R	Turbo II Precleaner	1
37	P103113	Cup	1
38	P102980	Air Cleaner Baffle	1
NS	344507	CAT Fan	1
NS	344504	Fan Belt	1
NS	304027	Compressor Belt, A/C Only	1
NS	344079	Fuel Filter	1
NS	344078	Oil Filter	1

3054C ENGINE AND RELATED PARTS



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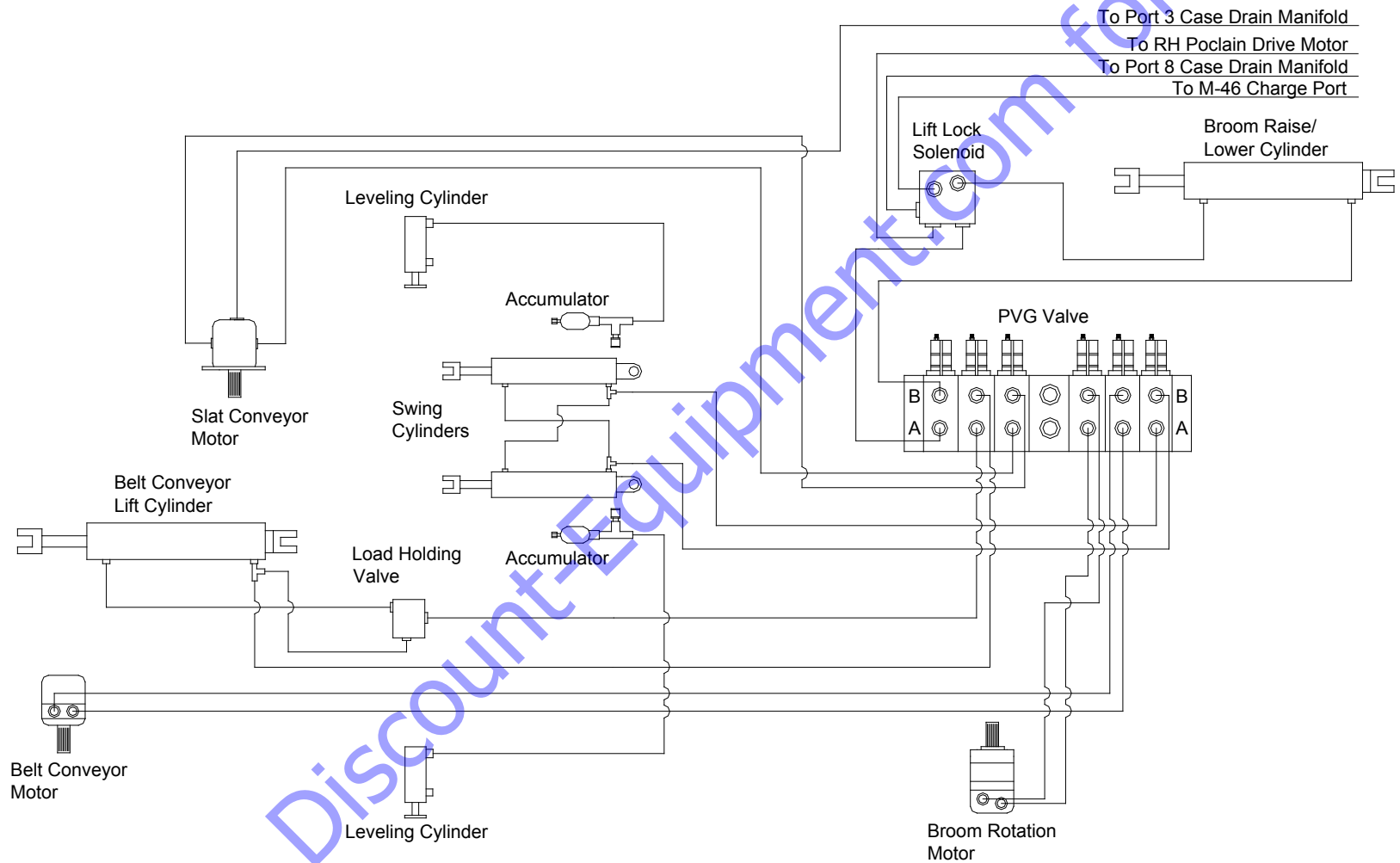
3054C ENGINE AND RELATED PARTS

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	344062	CAT 3054C Diesel Engine	1
2	852045	Oil Cooler Hose Guide Sleeve	1
3	305767	Oil Cooler	1
4	203600	Right Front Motor Mount	1
5	203601	Left Front Motor Mount	1
6	852042	Right Rear Motor Mount	1
7	852043	Left Rear Motor Mount	1
8	344508	Radiator Assembly	1
9	344511	Lower Radiator Hose	1
10	344510	Upper Radiator Hose	1
11	853606	Oil Cooler Mount	1
12	203187	Right Side Oil Cooler Seal	1
13	203188	Lower Seal (Rubber)	1
14	203186	Left Side Oil Cooler Seal	1
15	203189	Upper Seal (Rubber)	1
16	344010	Tail Pipe	1
17	203123	Muffler Clamp	2
18	JE-705-B	Muffler	1
19	JE-758-B	Head Pipe Clamp	2
20	853605	Exhaust Pipe	1
21	344031	Exhaust Gasket	1
22	203105	Exhaust Heat Shield	1
23	AC-760-R	Rubber Elbow, 3" x 3"	2
24	AC-760-B	Rubber Elbow, 3.5" x 3"	1
25	304195	Heater Hose	1
26	202152	Connecting Tube, Short	2
27	DE-770-R	Air Cleaner (Dual Element)	1
28	P182059	Service Element	1
29	P119410	Safety Element	1
30	PC-710-B	Precleaner, 4"	1
31	PC-765-R	Precleaner, Top	1
32	PC-711-R	Precleaner Bowl	1
33	304095	Engine Isolator Kit	4
34	P003951	Clamp	1
35	AC-764-R	Strap	2
36	TT-771-R	Turbo II Precleaner	1
37	P103113	Cup	1
38	P102980	Air Cleaner Baffle	1
39	344509	Radiator Cap	1
NS	101-3770	CAT Fan	1
NS	5M8155	Fan Belt	1
NS	304196	Compressor Belt, A/C Only	1
NS	344079	Fuel Filter	1
NS	344078	Oil Filter	1

HYDRAULIC DIAGRAMS

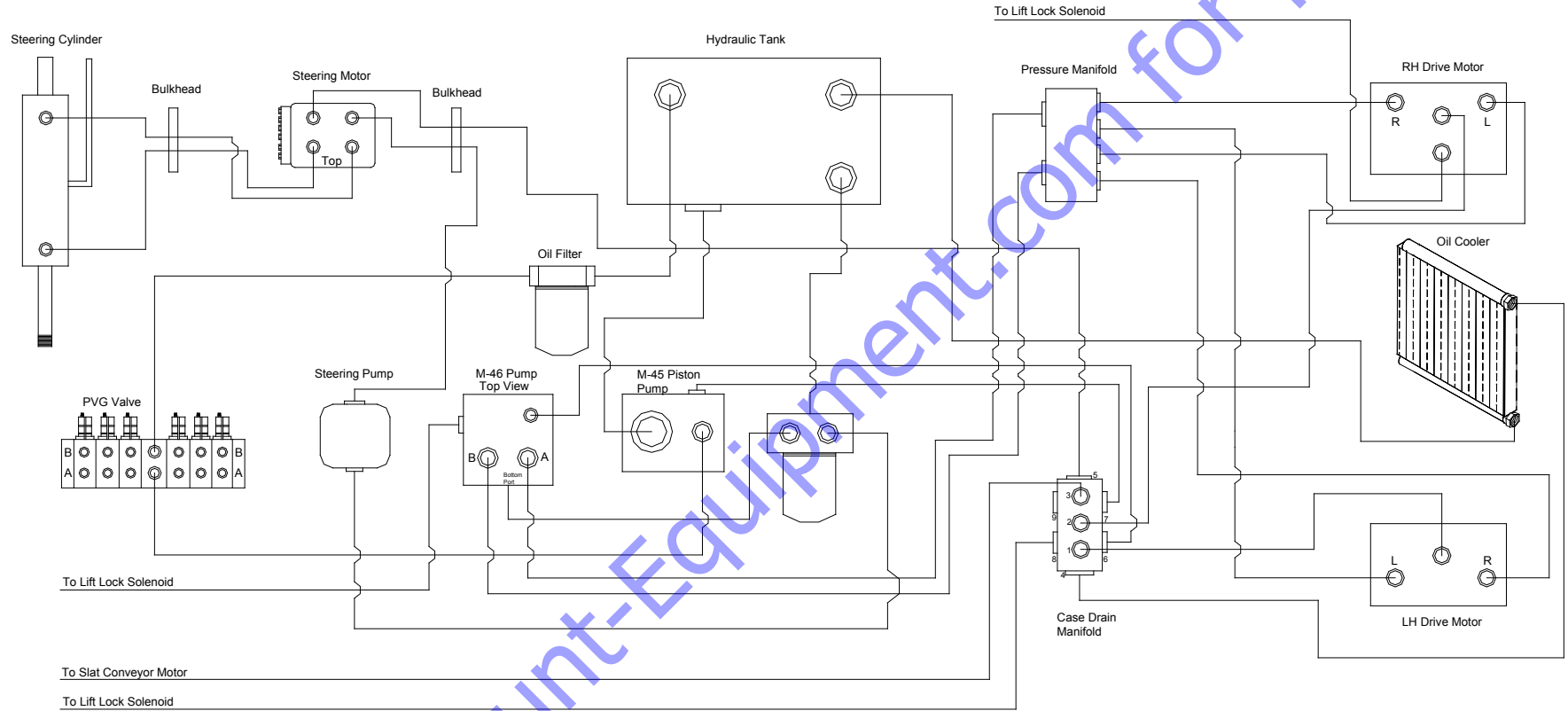
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HYDRAULIC VALVE DIAGRAM



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HYDRAULIC DIAGRAM



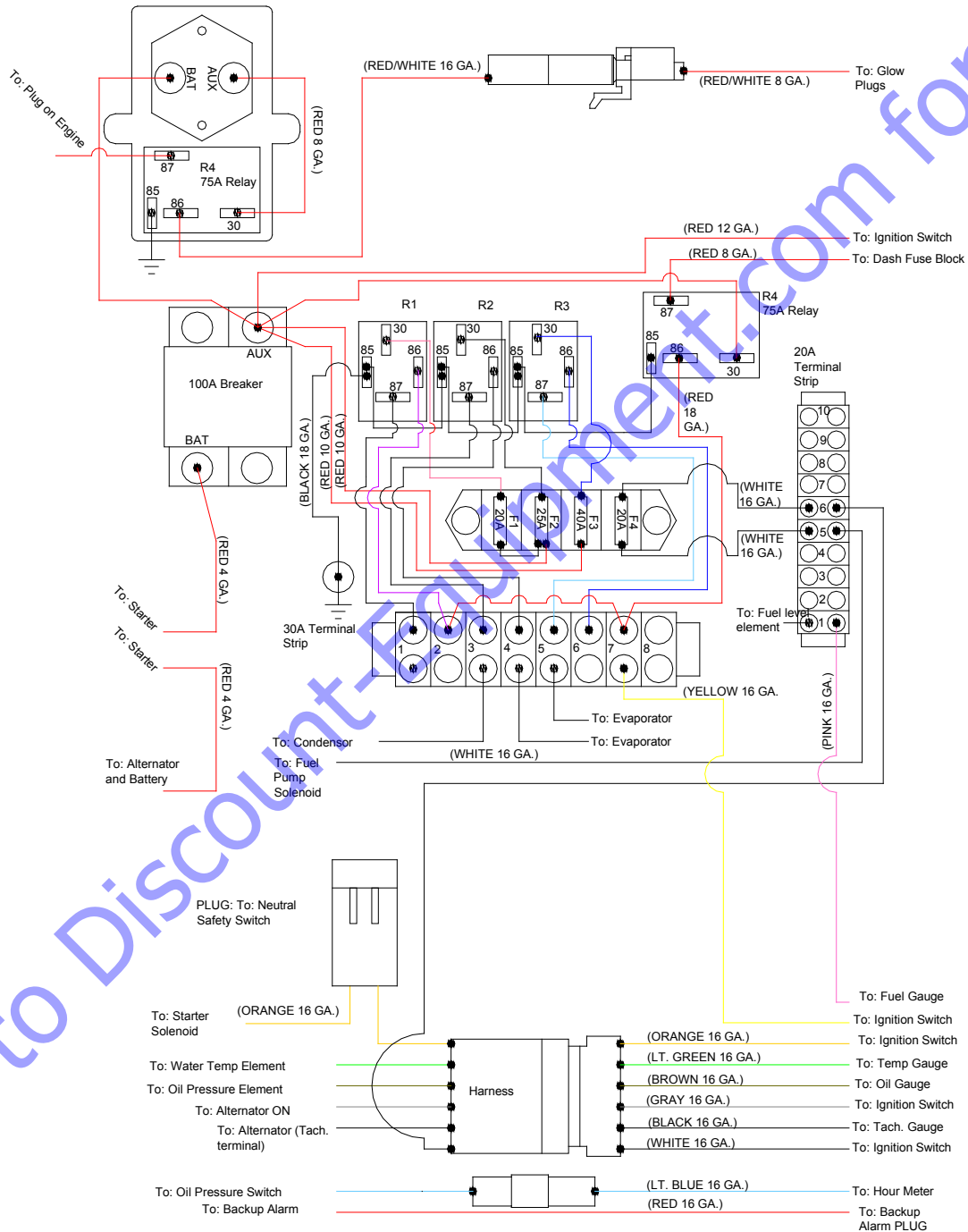
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WIRING DIAGRAMS

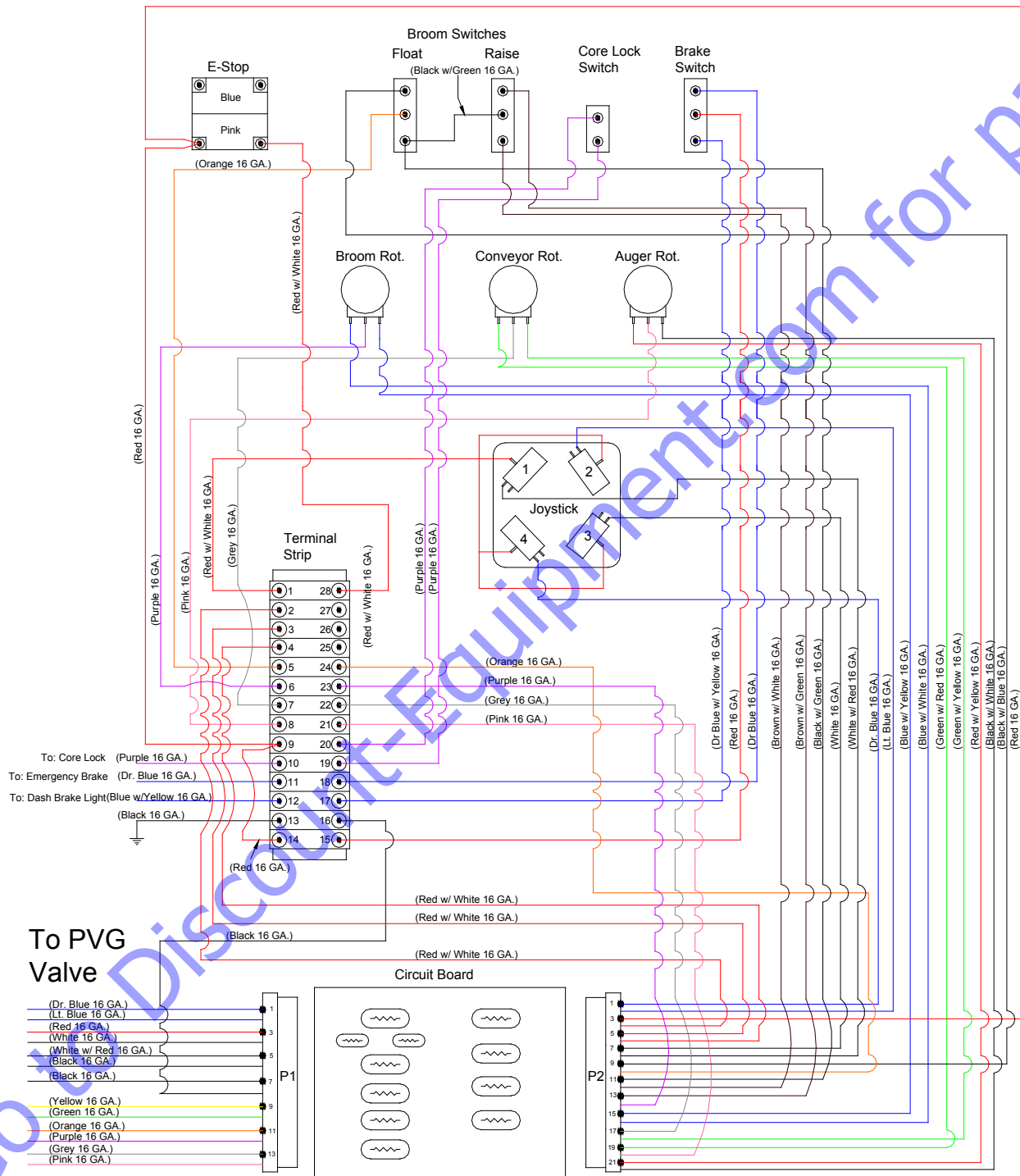
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Broce Broom Wiring Diagram Engine Wiring-CAT 3054C

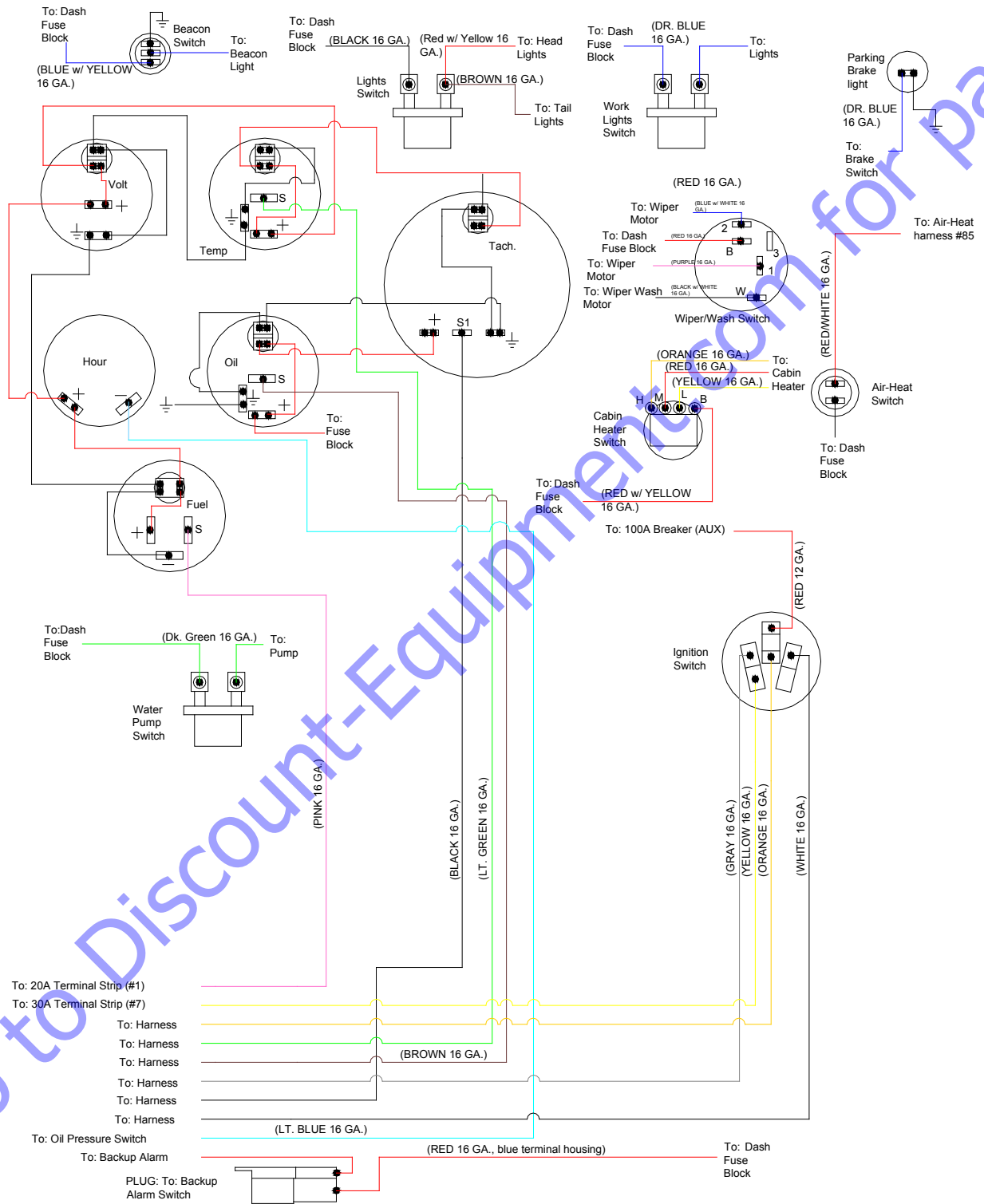


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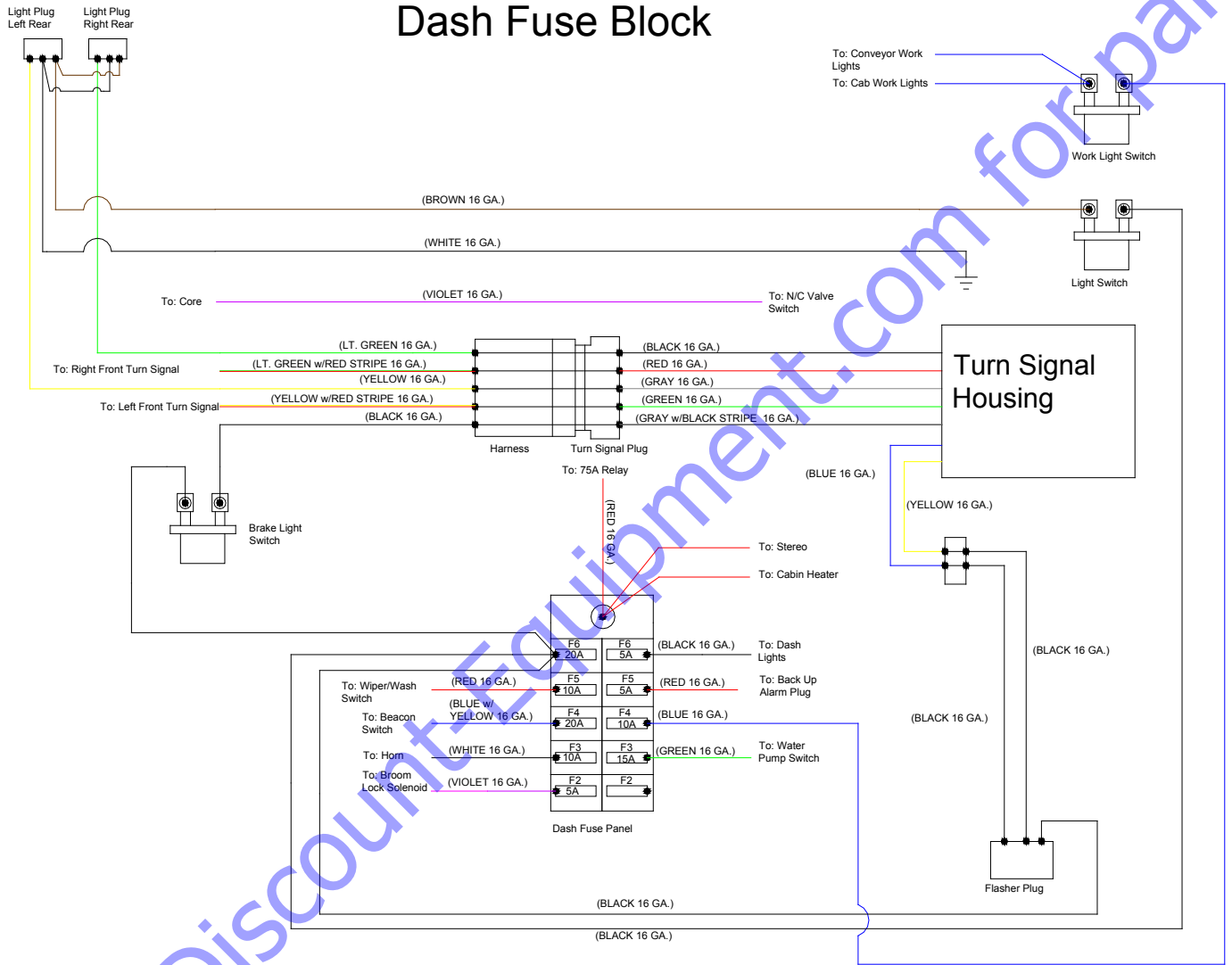
Broce Broom Wiring Diagram MK-1 Control Panel Wiring



Broce Broom Wiring Diagram MK-1 Dash Wiring Diagram

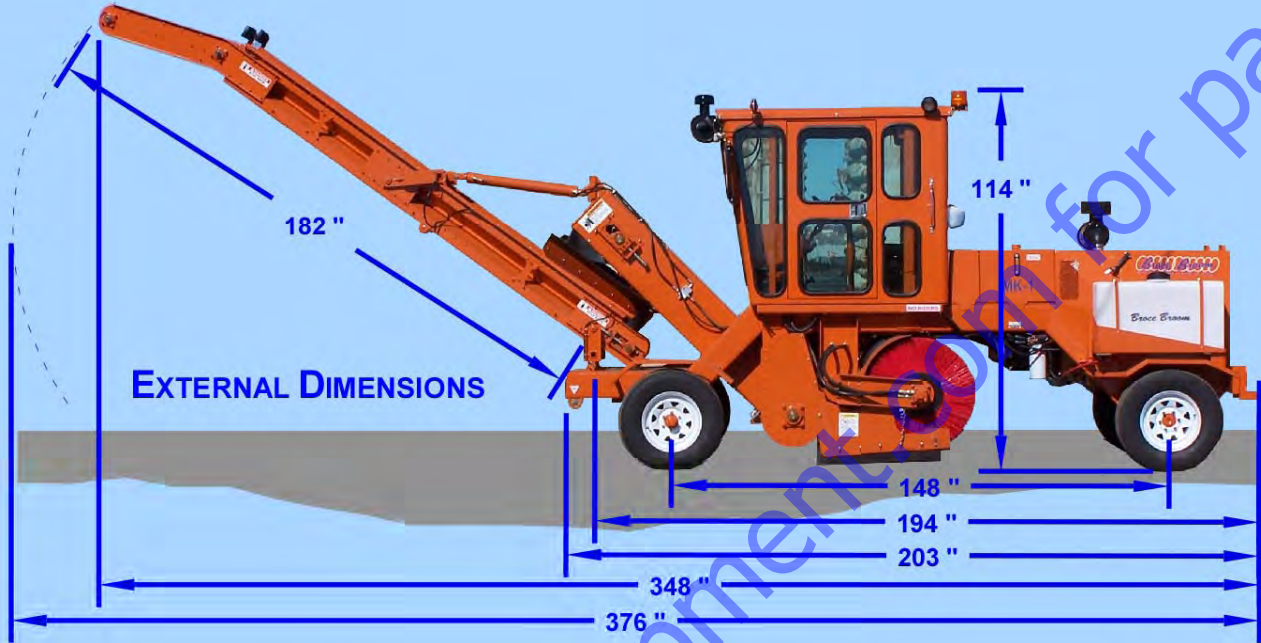


Broce Broom Wiring Diagram Light Wiring Diagram Dash Fuse Block



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BROCE MK-1 MODEL TRANSFER SWEEPER



FRONT AXLE	CG	REAR AXLE
5,660 LBS.	9,340 LBS. TOTAL	3,680 LBS.
WEIGHTS (EMPTY WATER TANKS, NO OPERATOR)		

2007 - Broce Manufacturing CO., Inc. 1460 S. 2nd Ave., Dodge City, KS 67801 (620) 227-8811

INSTRUCTION MANUAL

DODGE® GRIP-TIGHT ADAPTER MOUNT BALL BEARINGS

⚠ WARNING

To ensure that drive is not unexpectedly started, turn off, lock out, and tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

Shaft & Mounting Surface Inspection

Shaft should be smooth, straight, & within commercial tolerances (Table 1). Remove burrs & align mounting surfaces within 2 degrees.

Assemble Adapter & Bearing

1) If the locknut is loose from the bearing, **FIRST** place locknut into bearing inner ring groove, **THEN** insert adapter into bearing bore until it rests against the locknut. Rotate locknut clockwise to engage adapter sleeve.



Pillow Blocks & Tapped Base Housings

NOTE: For Tapped Base (TB) housings drill mounting holes with 1/16" minimum bolt clearance to assist with proper installation.

2) During installation it is best practice is to remove all of the weight from the bearing via slings or jacks. However, if it is difficult to remove all weight then insure the dead weight on the bearing during installation does not exceed the values listed in Table 2.

Series	Maximum Dead Load Per Bearing (lbs)
203-206	60
207-210	65
211-214	70
215-218	75

3) Slide the unit into position onto the shaft. If the unit will not slip onto the shaft, turn locknut counter-clockwise to expand adapter sleeve.

4) Wearing gloves, rotate locknut clockwise, by hand, as tight as possible until adapter sleeve grips and does not spin on the shaft or move axially. If needed, tap on locknut outer diameter while turning locknut to assist with this step. Scribe the line on the locknut above the adapter sleeve slot.

5) Lock bearing to shaft by rotating locknut, with a spanner wrench or brass bar & hammer, clockwise by amount shown in Table 3. NOTE: The use of air chisels is not recommended.

6) Center housing & mounting bolts over mounting holes & tighten bolts to proper torque (Table 4). Tighten locknut setscrew until 3/32" Allen key bends (25 in-lbs).

7) Repeat above steps for mounting 2nd housing. **Do not tighten mounting bolts on 2nd housing until second bearing has been completely locked to the shaft.** Bolts must fit freely between housing & mounting surface. If the mounting bolts do not fit freely, loosen mounting bolts on **both** housings & center both units. If the bolts still will not fit freely, remove one unit from the shaft, reposition housing, & reinstall.

Shaft Size (in)	Commercial Shaft Tolerances (in)
Up to 1 1/2"	+0.000" / - 0.002"
1 5/8" - 2 1/2"	+0.000" / - 0.003"
2 11/16" - 3 7/16"	+0.000" / - 0.004"

Series	Shaft Size GT (Normal Duty)	Shaft Size GTM (Medium Duty)	Locknut Rotation
203 - 204	1/2" - 3/4" 17 - 20 mm	---	1/2 Turn
205 - 210	7/8" - 1 3/4" 25 - 45 mm	3/4" - 1 1/2" 20 - 40 mm	2/3 Turn
211 - 218	1 15/16" - 2 15/16" 50 - 75 mm	1 11/16" - 3 1/2" 45 - 85 mm	1 Turn

Metal Housings		Non-Metallic Polymer Housing			
All Housing Types		Pillow Block, 2 & 4 Bolt Flange, Flange Bracket		Tapped Base	
Bolt Size (in)	Dry Torque (in lbs)	Bolt Size (in)	Dry Torque (18-8 Stainless) (in lbs)	Bolt Size (in)	Dry Torque (18-8 Stainless) (in lbs)
3/8	240	3/8	225	3/8	175
7/16	384	7/16	350	7/16	350
1/2	600	1/2	500	1/2	400
5/8	1200	9/16	650		
3/4	2100	5/8	1000		
7/8	2040				



⚠ WARNING

Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that the correct procedure be followed. Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance, and operating procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to ensure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Baldor Electric Company nor are the responsibility of Baldor Electric Company. This unit and its associated equipment must be installed, adjusted, and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and potential hazards involved. When risk to persons or property may be involved, a holding device or shear bars must be an integral part of the driven equipment.

All Flange Housings

WARNING: Special attention to the installation procedure for flange bearings is necessary to maintain the proper internal clearance & achieve maximum life. The installation of the first flange differs from the installation of the second flange.

(See step 1 **Assemble Adapter & Bearing** page 1)

2) During installation it is best practice is to remove all of the weight from the bearing via slings or jacks. However, if it is difficult to remove all weight then insure the dead weight on the bearing during installation does not exceed the values listed in Table 2.

3) Slide the FIRST unit into position onto the shaft. If the bearing will not slip onto the shaft or more axially, turn locknut counter clockwise to expand adapter sleeve.

4) (Using gloves) rotate locknut clockwise by hand until it is tight & adapter sleeve grips & does not spin on the shaft. This is the starting point. Scribe a line on the locknut above the adapter sleeve slot.

(If needed, tap on locknut outer diameter while turning locknut to assist with this step.)

5) Lock bearing to shaft by rotating locknut, with a spanner wrench or brass bar & hammer, clockwise by amount shown in Table 2.
NOTE: The use of air chisels is not recommended.

6) Tighten locknut setscrew until 3/32" Allen key bends (or 25 in-lbs). Tighten housing bolts to proper torque (Table 3).

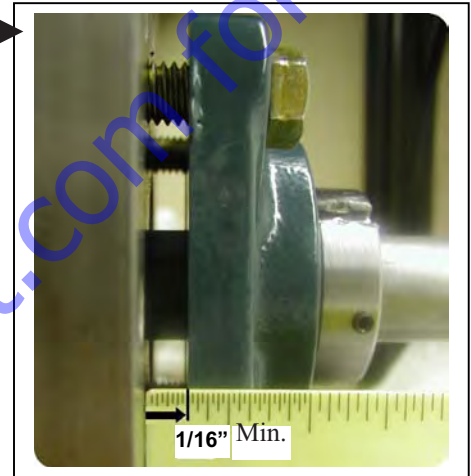
7) Slide the **SECOND** flange onto the shaft and hand tighten as in step 4 but leave 1/16" minimum gap between the flange housing & the mounting surface. See picture to the right.

8) It is important to note that the 1/16" minimum gap between the flange housing and the mounting surface must be maintained while getting the bearing hand tight to the shaft. Wearing gloves, rotate the locknut clockwise, by hand, until adapter sleeve grips and does not spin or move axially on the shaft. If needed, tap on the locknut outer diameter while turning the locknut to assist with this step. At this point you should have difficulty in rotating the locknut by hand and you should not be able to move the bearing axially along the shaft by hand. If the bearing can be moved axially along the shaft by hand then continue rotating the nut gradually until it grips the shaft. Scribe a line on the locknut above the adapter sleeve slot.

9) Insert housing bolts & pull the housing flush with mounting surface by alternately tightening the bolts to the proper torque (Table 4).

10) Lock bearing to shaft by rotating locknut, with a spanner wrench or drift pin & hammer, clockwise by amount shown in Table 3. Tighten locknut setscrew until 3/32" Allen key bends (25 in-lbs).

11) Rotate the shaft by hand, no binding or excessive drag should be felt. If excessive drag is felt, loosen the second bearing & reinstall starting at step 8.



Dismounting All Units

1) Remove all weight from the bearing via slings or jacks & secure the shaft from rotation.

2) **LOOSEN THE HOUSING MOUNTING BOLTS & COMPLETELY REMOVE SETSCREW IN THE LOCKNUT.**

3) Rotate locknut counter clockwise with spanner wrench or drift pin & hammer until bearing is free.

Hours Run Per Day	RPM							
	1 to 250 RPM	251 to 500 RPM	501 to 750 RPM	751 to 1000 RPM	1001 to 1500 RPM	1501 to 2000 RPM	2001 to 2500 RPM	2500 to Max RPM
8	12	12	10	7	5	4	3	3
16	12	7	5	4	2	2	1	1
24	10	5	3	2	1	1	1	1

Lubrication: (Use compatible Lithium base NGLI #2 grease & see Table 5)

The Dodge Grip-Tight bearing has been greased from the factory & is shaft ready. When re-lubricating slowly add grease until fresh grease is seen purging past the seal. In the higher speed ranges, excess grease may cause temporary bearing overheating. The amount of grease a bearing will take for a specific high speed application is best determined by experience. When establishing a re-lubrication schedule, note that a small amount of grease at frequent intervals is preferred to a large amount of grease at infrequent intervals.

Lubrication recommendations are intended for standard products applied in general operating conditions. For modified products, high temperature applications, and other anomalous applications contact product engineering at 864-284-5700



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Baldor Electric Company Headquarters

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Baldor - DODGE/Reliance

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This material is not intended to provide operational instructions. Appropriate instruction manuals and precautions should be studied prior to installation, operation or maintenance of equipment.



IM499312

CHAIN CARE & TROUBLE SHOOTING



Stress Corrosion

Stress Corrosion and Hydrogen Embrittlement

These closely related failures are similar in appearance and nature. They appear as cracks which initiate at the point of highest stress and tend to extend in an arc-like path parallel to the rolling grain of the material. Often, more than one crack will appear on a side plate.

This type of failure can be caused by operating in an acidic or caustic medium or atmosphere. Carbon steel and certain grades of stainless steel are subject to stress corrosion cracking when exposed to a corrosive environment. Also, exposure of carbon steel chain to moisture can lead to rusting and stress corrosion cracking.

The reactions of many chemical agents with metals liberate hydrogen, which attacks and weakens the metal grain structure.

If stress corrosion failure occurs, check the installation to see if the chain is exposed to chemicals, gases, moisture, or other possible causes. If the chain has been cleaned with a detergent solution, the detergent could be at fault. For cleaning purposes, use only detergent-free fluids. Never use acids, such as in acid bath degreasing.



Fatigue Failure



Bushing Fatigue

Fatigue Failure

Fatigue failures are a result of repeated cyclic loading beyond the chain's endurance limit, or rated capacity. Extent of the overload and frequency of its occurrence are factors which determine when fatigue will occur. The overloading can be continuous or intermittent.

Continuous overloading may be caused by worn teeth or pocket buildup, imposing overloads with each cycle. Impulse overloads can be from motor overload torque, dynamic overloading due to sudden stops, or impact loading on conveyors.

Generally, a fatigue crack starts at the point of highest stress, which is the aperture of the pin or bushing plate. Repeated cyclic stresses cause the crack to extend approximately perpendicular to the pitch line of the chain until the plate breaks. Unlike a pure tension failure, there is no noticeable yielding (stretch) of the material.

When fatigue failure occurs, the application should be examined for continuous or impulse overloading conditions. Determine the cause of the overload and eliminate it if possible. (Be sure to check sprockets for worn teeth or pocket buildup.) If the cause cannot be eliminated, determine the extent of the overload and increase chain size (capacity) to accommodate the operating conditions.

Bushing fatigue is another type of fatigue failure. Such fatigue manifests itself as circumferential cracks near the bushing link plate or longitudinally along the length of the bushing. Both types of cracks may also appear in the same bushing. If bushing cracks are evident, do not try to repair the chain. Determine and correct the cause of the failure, then replace the entire chain.

Allied-Locke Industries Inc.

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CHAIN CARE & TROUBLE SHOOTING

Tension Failure

This type of failure occurs when the ultimate tensile strength of a chain is exceeded (when the chain is subjected to a one-time load greater than it can withstand). Normally, tension failure can be identified by fractured side plates showing a definite yield in the metal itself.

Pin fracture, either near the center of the pin or a pin shear failure between the side plates, can also be a result of tension failure. When a chain breaks because of shocks or overloads, all of its components are affected, even though the unbroken parts may appear sound. To avoid repetitive failures, the entire chain should be replaced.

Tension failures can result from any condition which creates improper engagement between links and sprockets, characterized by the chain riding up on the sprocket teeth.

In addition, dirt and foreign matter buildup in the sprocket tooth pockets will prevent proper seating of the chain, creating an overload condition between link and tooth. Sprockets should be checked periodically; if any foreign material has accumulated, it should be promptly removed.

Another variation of tension failure is cracked bushings. In applications contaminated by dirt or grit, abrasive material may penetrate the links. When it reaches the inside and outside bushing surfaces, this material literally grinds into the bushings during articulation, reducing their wall thickness and lowering chain tensile strength. Eventually the bushings crack under load.

Galling (Abnormal Wear)

Galling, or the tearing away of metal particles from the load-bearing surfaces, occurs as a result of inadequate lubrication or excessive operating speed. The mating surfaces of the pins and bushings actually weld together, then break away as the joints flex over the sprockets. Once started, galling accelerates rapidly and is highly destructive.

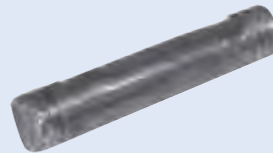
Galling can occur at high speed (within allowable speed limits) if lubrication is inadequate or misdirected. Check lubrication system to be sure that: a) proper type of lubricant is being used; b) lubricant flow is not obstructed; c) lubricant is penetrating chain joints.

Galling at speeds beyond allowable limits cannot be solved by lubrication changes. It can be prevented only by making necessary design changes to comply with speed limitations.

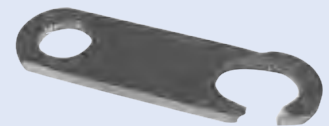
Importance of Lubrication

One of the most important, but overlooked, factors affecting chain life is proper lubrication. Besides minimizing metal-to-metal contact, lubrication provides cooling and impact damping at high speeds. It also reduces corrosion and carries away foreign matter, which is vital in abrasive environments.

Pin Galling



Side Plate Fracture Due to Tension Failure



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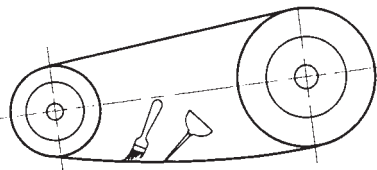
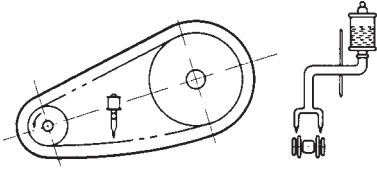
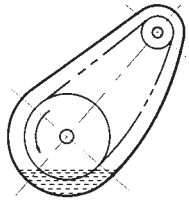
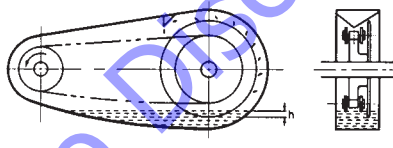
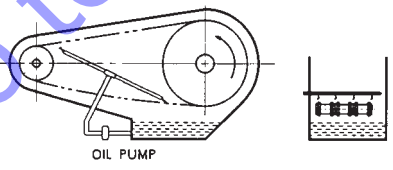
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CHAIN CARE & TROUBLE SHOOTING



Lubrication plays an important role for chain life because chain wear and its stretch results from friction in the area between pin and bushing. Proper lubrication is necessary to reduce metal to metal contact and interference at chain joints.

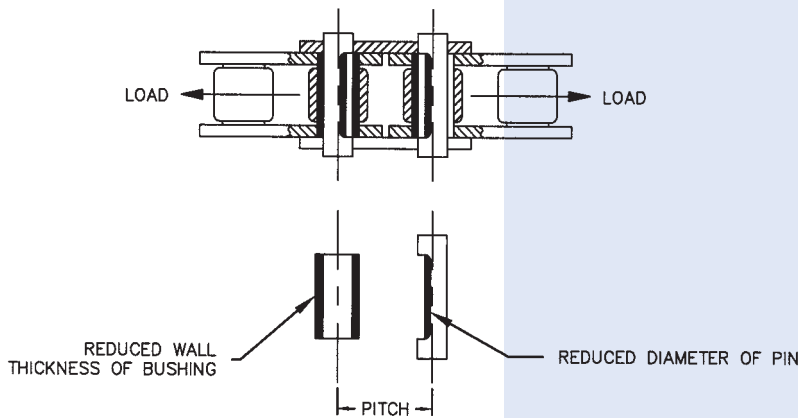
Method and amount of lubrication

Type	Method	Amount
A	 <p>Apply oil with a brush or spout can aiming at clearance between pins and roller links on the slack side of chain in operation.</p>	periodically to keep chain joints from drying (generally about every 8 hours)
	 <p>Drip lubrication Use simple casing and apply oil drops from a drip cup.</p>	at a rate of 5 to 20 drops per minute for each strand of chain, the higher the speed the more the drops per minute.
B	 <p>Oil bath lubrication Chain runs through an oil reservoir kept in leak-proof casing.</p>	too much oil kept in reservoir (if h dimension is too high) can generate heat in oil and deteriorate its quality, therefore oil level should be kept in such a way as to maintain h dimension to be about 6 to 12mm.
	 <p>Slinger disc lubrication Oil disc mounted on lower sprocket picks up oil from the oil reservoir kept in leak-proof casing and splashes it on chain. Disc should run at rim speed of more than 200 meters per minute. If chain width exceeds 125mm, oil disc should be used on both sides of chain.</p>	Oil level should be kept lower than chain lowest point to maintain h dimension to be about 12 to 25mm
C	 <p>Forced lubrication Oil pump is used to force continuous spray of oil after cooling to chain within a leak-proof casing. No. of spray oil holes should be N+1 if the number of chain strand is N.</p>	

In all types of lubrication, roller chain should be cleaned periodically using light oil or gasoline. In order to see if lubrication is performed satisfactorily, remove chain from drive and check its pin and bushing. If pin and bushing show flaking or being colored to red or dark brown, poor lubrication generally exists.



CHAIN CARE & TROUBLE SHOOTING



Bushing and Pin Wear Surfaces

Excessive Wear

If the load-bearing surfaces show discoloration (brown-red oxide), lubrication is insufficient. Fretting corrosion has set in, and the abrasive oxide produced will greatly increase the wear rate. Among other causes of excessive wear are:

- **Tight Chain**—insufficient sag in the slack strand. Lessen idler tension or distance between sprockets until slack is 2% to 3% of the sprocket center-to-center distance.
- **Excessive Slack**—chain whips and creates noise. Adjust idlers or sprocket distances for proper slack.
- **Worn or Misaligned Sprockets**—can cause chain overloads and accelerate the wear rate. Replace sprockets when teeth show excessive wear or are hook-shaped.

Proper sprocket size is also important to minimize the wear rate. Use sprockets with a minimum of fifteen teeth for smoothest operation and longest life. The fewer teeth there are in a sprocket, the greater the wear rate because of the high angle of articulation.

Normal Wear

Wear normally takes place in the pin and bushing load-bearing areas. As they wear, the chain gradually elongates. The rate of chain wear is greatly affected by lubrication. When properly lubricated, load-bearing surfaces of the pin and bushing will look shiny and smooth.

Tips on Trouble Shooting Chain Life Expectancy

Chain life expectancy can be expressed as a maximum percent of elongation. When using up to 67-tooth sprockets, normal life expectancy is approximately 3% elongation. Thus, to avoid sudden tension failure, chain should be replaced when its length increases 0.36" per foot on the average. When using sprockets with over 67 teeth, life expectancy is reduced in relationship to the following formula: permissible chain elongation = $\frac{200}{N}$

where N is the number of teeth in the larger sprocket.

$$\text{Example } \frac{200}{N} = 1.8\%$$

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CHAIN CARE & TROUBLE SHOOTING



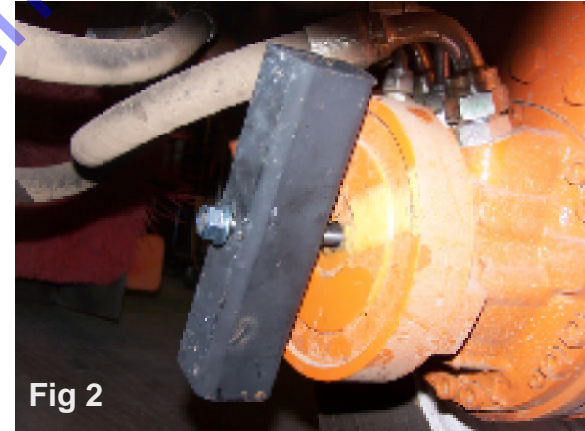
CHAIN CARE & TROUBLESHOOTING

Problem	Possible Causes	What To Do
Excessive noise	<ul style="list-style-type: none"> ■ Misalignment of sprocket ■ Loose casings or bearings ■ Too little or too much slack ■ Chain and/or sprocket wear ■ Inadequate lubrication or no lubrication ■ Chain pitch size too large 	<ul style="list-style-type: none"> ■ Realign sprockets and shafts ■ Tighten set-bolts ■ Adjust center or idler take-up ■ Replace chain and/or sprocket ■ Lubricate properly ■ Check chain drive recommendation
Chain vibration	<ul style="list-style-type: none"> ■ Resonance to the vibration cycle of machine to be installed ■ High load fluctuation 	<ul style="list-style-type: none"> ■ Change vibration cycle of chain or machine ■ Use torque converter or fluid coupling
Wear on inside of link plate and one side of sprocket teeth	<ul style="list-style-type: none"> ■ Misalignment 	<ul style="list-style-type: none"> ■ Realign sprockets and shafts
Chain climbs sprockets	<ul style="list-style-type: none"> ■ Excessive chain slack ■ Heavy overload 	<ul style="list-style-type: none"> ■ Adjust center or idler take-up ■ Reduce load or install stronger chain
Broken pins, bushings or rollers	<ul style="list-style-type: none"> ■ Chain speed too high for pitch and sprocket size ■ Heavy shock or suddenly applied loads ■ Material build-up in sprocket tooth pockets ■ Inadequate lubrication ■ Chain or sprocket corrosion 	<ul style="list-style-type: none"> ■ Use shorter pitch chain or install larger diameter sprockets ■ Reduce shock load or install stronger chain ■ Remove material build-up or install side gashed sprockets ■ Lubricate properly ■ Install anti-corrosive chain or sprockets
Chain clings to sprocket	<ul style="list-style-type: none"> ■ Center distance too big or high load fluctuation ■ Excessive chain slack 	<ul style="list-style-type: none"> ■ Adjust the center distance or install idler take-up ■ Same as above
Chain gets stiff	<ul style="list-style-type: none"> ■ Misalignment ■ Inadequate lubrication ■ Corrosion ■ Excessive load ■ Material build-up in chain joint ■ Peening of link plate edges 	<ul style="list-style-type: none"> ■ Realign sprockets and shafts ■ Lubricate properly ■ Replace with anti-corrosive chain ■ Reduce load or replace with chain of suitable strength ■ Shield drive from foreign matter ■ Check for chain interference
Breakage of link plate	<ul style="list-style-type: none"> ■ Subjected to shock load ■ Vibration ■ Moment of load inertia is too big 	<ul style="list-style-type: none"> ■ Reduce shock (e.g., install a shock absorber) ■ Install a device to absorb vibration (e.g., tightener, idler wheel) ■ Chain section should be checked (increase number of strands or select next larger size chain)

Broce MK-1 Rear Drive Motor Emergency Brake Release Procedure

This procedure to be used only under emergency or service situations such as, moving a disabled vehicle to a safe location.

1. Shut off engine and block wheels to prevent vehicle from rolling.
2. Remove Rubber Dust Plug in rear Drive Motors (Fig 1)
3. Install Brake Release Tool in Drive Motor (Fig 2)
4. Tighten 12mm nut to release brakes (Fig 3)
5. Brake Release Tool must be removed for safe normal operation
6. Reinstall Rubber Dust Plug



WARNING

Vehicle will roll freely with Brake Release Tool installed. Vehicle braking ability will be greatly reduced or disabled. Serious injury or death can occur.

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