

## Assembly instructions

Translation of the original assembly instruction

Edition	03
Date of print	09.2018
Language	EN
Document number	A132557840
Index number	2018-08

# INSTRUCTIONS FOR THE RECIPIENT

These instructions describe unpacking and assembly of the machine.  
For the transport from the factory to the user the machine has been dismantled in main components. The following assembly instructions will tell you how to reassemble the machine. Please follow the assembly order shown and use the types and sizes of bolts shown for assembly of the parts. Look for the following symbols:



Bolts with hexagon head



Bolts with round head



This warning symbol refers to instructions concerning your own safety and the safety of third party.

In general, assembly of machines should only be carried out by skilled service staff having knowledge of safe use of workshop tools. The assembly of some machine types also requires knowledge of the tractor hydraulics or hydraulic pump station.

Do not use loose-fitting clothes. They could be caught by machine parts!

Use the personal protection equipment which is necessary for the work in question.

Only use approved and adequate lifting equipment. Protect the lifting equipment from sharp edges and prevent strings/chains from winding.



Thoroughly read the instruction manual delivered with the machine before taking the machine into use for the first time and to ensure safe working.

## **Kverneland Group Kerteminde AS**

DK-5300 Kerteminde - Denmark

Phone / Fax +45 65 19 19 00 / +45 65 19 19 99

web: [www.kvernelandgroup.com](http://www.kvernelandgroup.com)



## Target group for these assembly instructions

These assembly instructions are intended for authorised dealers, workshops and subsidiaries qualified to work with technology for agricultural machinery.

### **For your safety**

You must ensure you have read these assembly instructions thoroughly before using or assembling the machine. This will ensure the best possible results are achieved, with optimum working safety.

The assembly instructions belong with the machine, and must remain easily accessible. This will allow you to:

- prevent accidents
- uphold the warranty conditions.

### **For employers**

Persons who have not received instruction and unauthorised persons are not permitted to assemble this machine.

### **For employees**

If the instructions or your understanding of the work is unclear, stop work immediately.

Contact your supervisor or employer. Your supervisor or your employer must then contact the Kverneland service for assistance.

## Meaning of the symbols



This pictogram indicates tips and additional information.



This warning triangle indicates important safety information and danger. Failure to observe this safety information can result in:

- Serious faults in the correct operation of the machine.
- Damage to the machine.
- Personal injury or accidents.



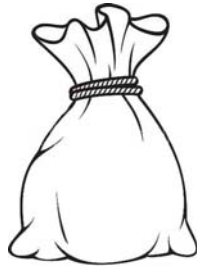
## Torque moment

Torque moment for bolts of quality 4.6 - 5.8 - 8.8 - 10.9 - 12.9 black and/or galvanized and ungreased when tightened on a smooth surface or a plain washer.








Dim.	Bolt quality									
	4.6		5.8		8.8		10.9		12.9	
	Nm	ft lbs	Nm	ft lbs	Nm	ft lbs	Nm	ft lbs	Nm	ft lbs
M5	2	1,6	3,5	2,5	5,5	4	8	6	10	7
M6	3,5	2,6	6	4,5	10	7	14	10	17	12
M8	9	6,4	15	10,5	24	17	33	23,5	40	28,5
M10	17	12	29	21	47	33,5	65	46,5	79	56,5
M12	30	21,5	51	36,5	81	58	114	81,5	136	97
M14	48	34	80	57	128	91,5	181	130	217	155
M16	74	53	123	88	197	141	277	200	333	238
M18	103	73,5	172	123	275	196,5	386	275	463	330
M20	144	103	240	171,5	385	275	541	386,5	649	463,5
M22	194	138,5	324	231,5	518	370	728	520	874	624
M24	249	178	416	297	665	475	935	668	1120	800










For safety reasons use only original parts.









### Standard bolts

	Qty	Dim.		Qty	Dim.		Qty	Dim.
	4	M8x20		14	M12x40		1	M10x25
	1	M8x30		4	M16x55			
	3	M10x35		4	M16x110			





	Qty	Dim.		Qty	Dim.		Qty	Dim.
	5	M10x19		2	M12x40		2	M10x50
	19	M10x25					4	M12x35
	4	M10x30					1	M12x45

### Standard washers































	Qty	Dim.		Qty	Dim.		Qty	Dim.
	4	M8		18	M12		1	φ24xφ8,5x2
	32	M10		4	M16		1	φ30xφ11x2

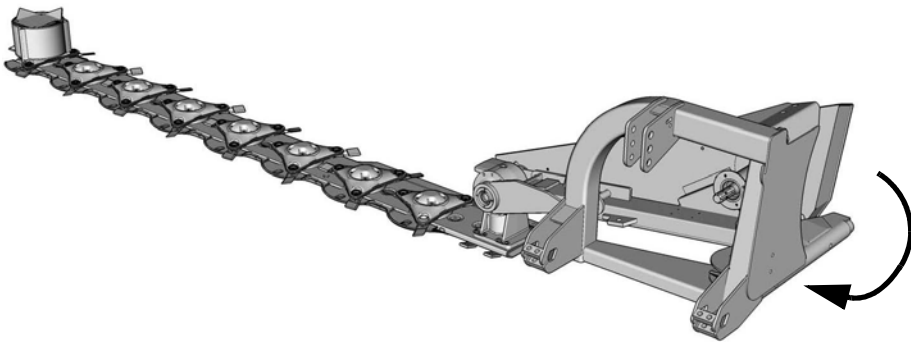
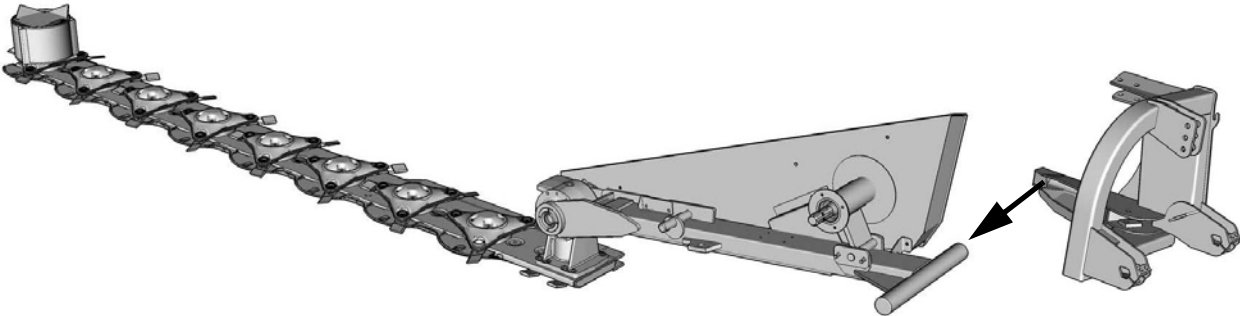
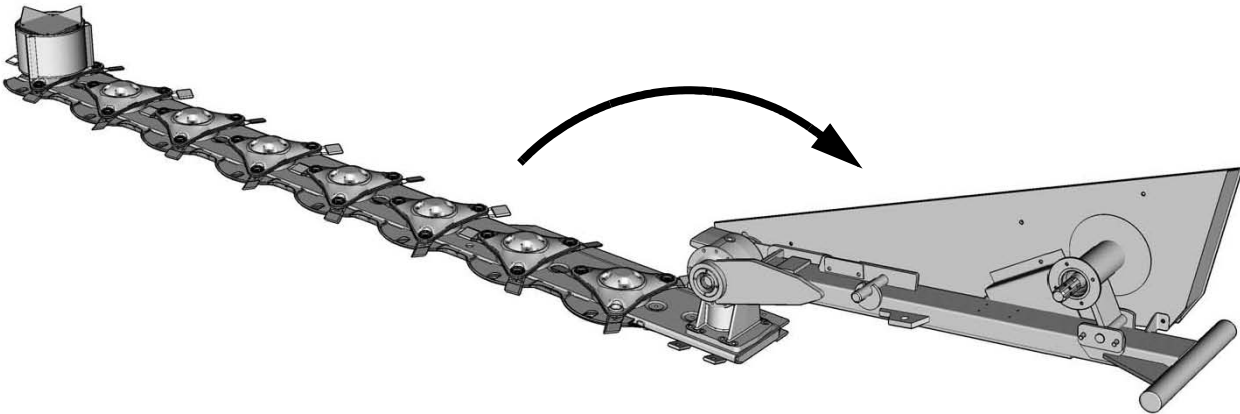
# Preface

## Standard nuts

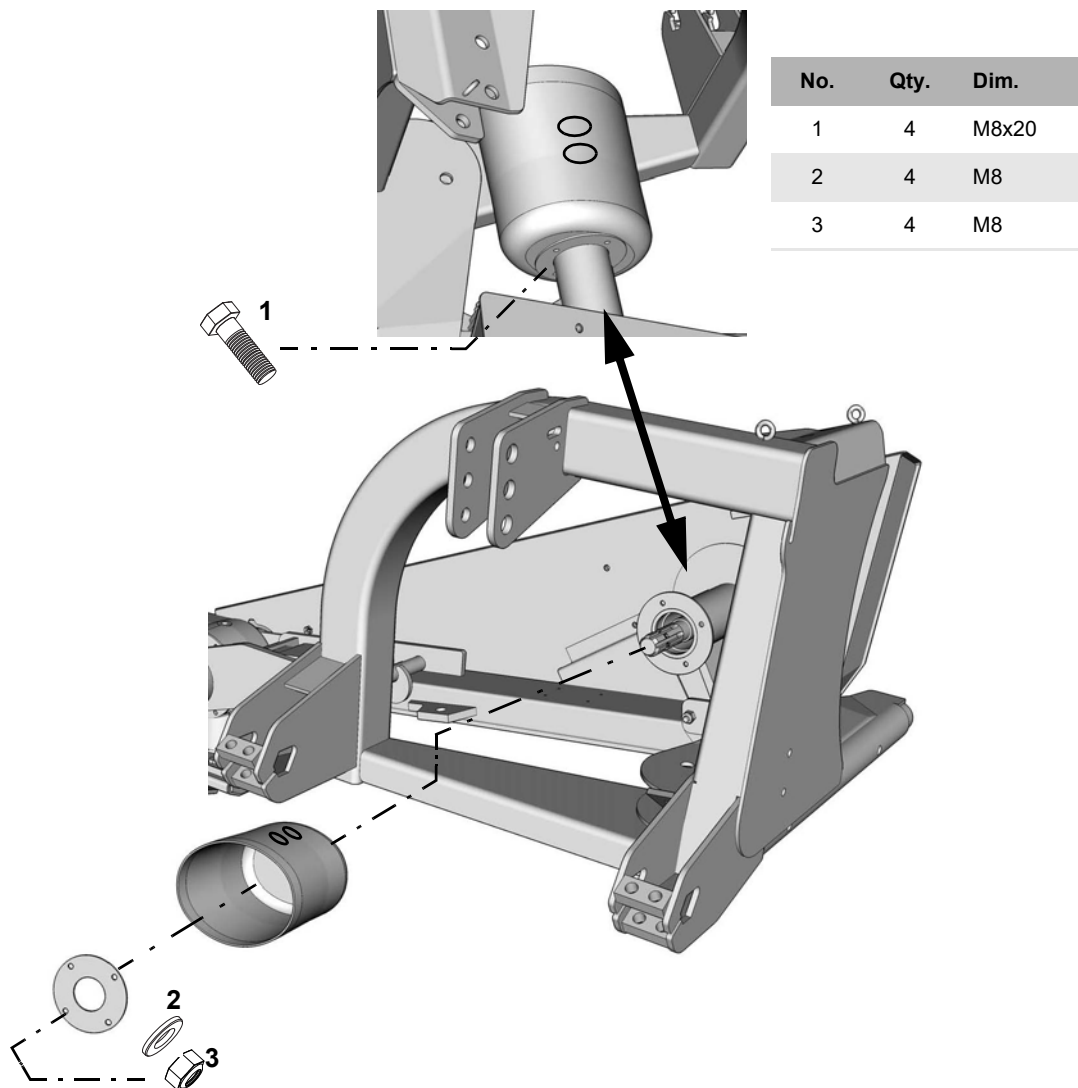
	Qty	Dim.		Qty	Dim.		Qty	Dim.
	5	M8		16	M12			
	33	M10		4	M16			

## Additional loose parts

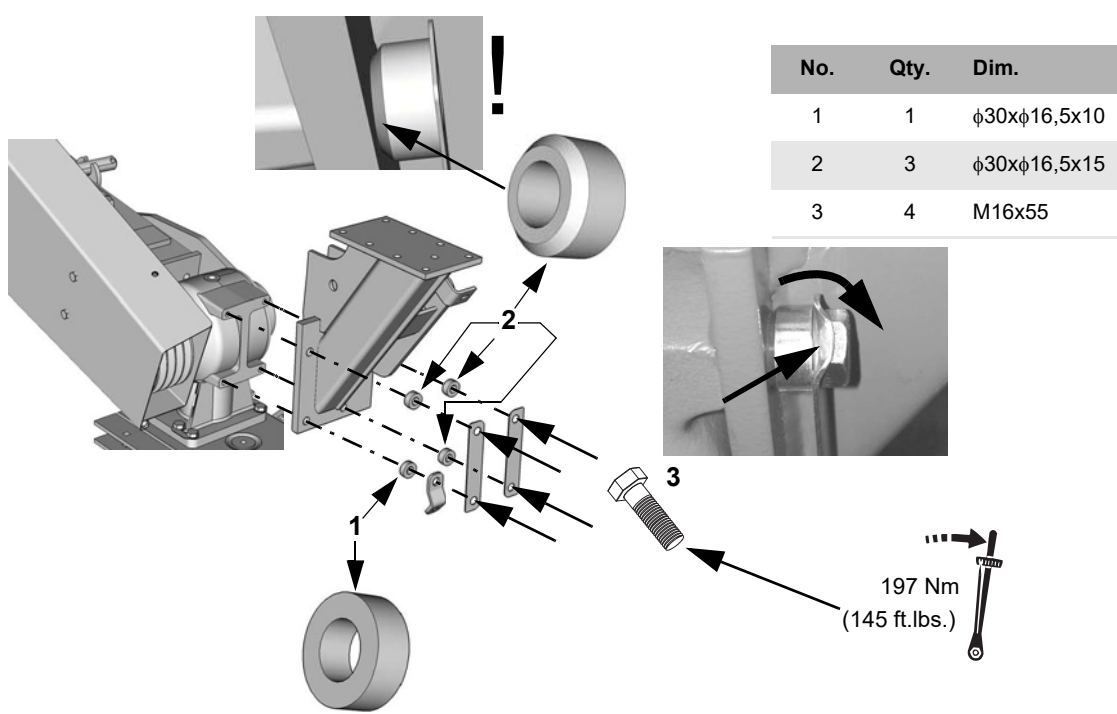
	Qty	Dim.		Qty	Dim.		Qty	Dim.
	1	$\phi 3,5 \times 30$		1	$\phi 12 \times 55$		1	$\phi 8$
	5	$\phi 6 \times 30$					1	$\phi 10$
	3	$\phi 30 \times \phi 16,5 \times 15$		1	$\phi 27 \times \phi 55$		1	-
	1	$\phi 30 \times \phi 16,5 \times 10$		1	$\phi 16 \times \phi 10,5 \times 5$		1	-
	2	$\phi 35 \times \phi 21 \times 21$		1	-		1	$\phi 31 \times \phi 45 \times 2$
	1	-		2	$\phi 20 \times 90$		1	$\phi 20 \times 108$
	1	-		1	$\phi 20 \times 70$		1	-
	2	-		1	M8		1	-
	1	-		1	$\phi 5 \times 4000$		1	-
	1	-		1	-		1	-
	1	-						



# Assembly

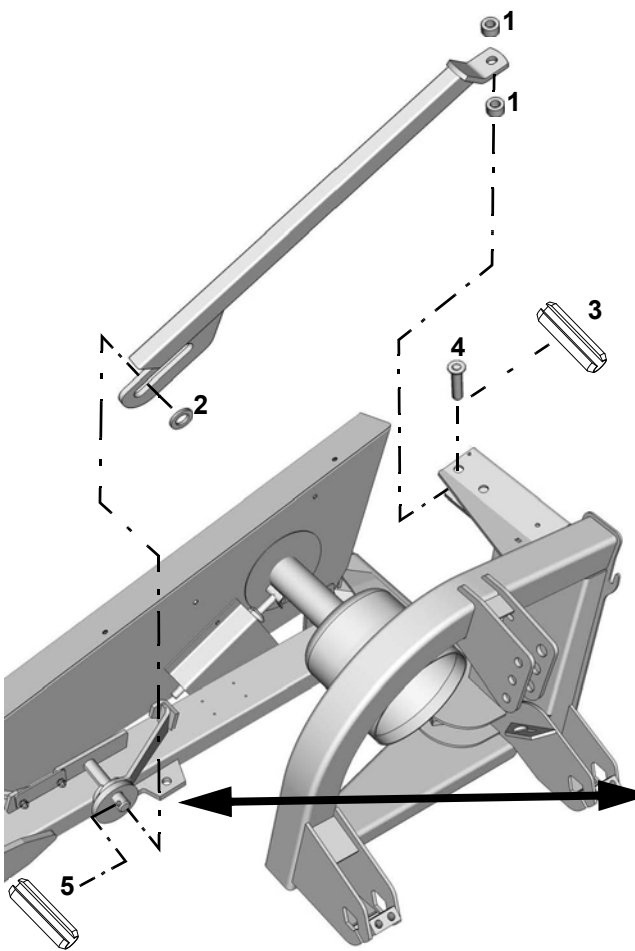
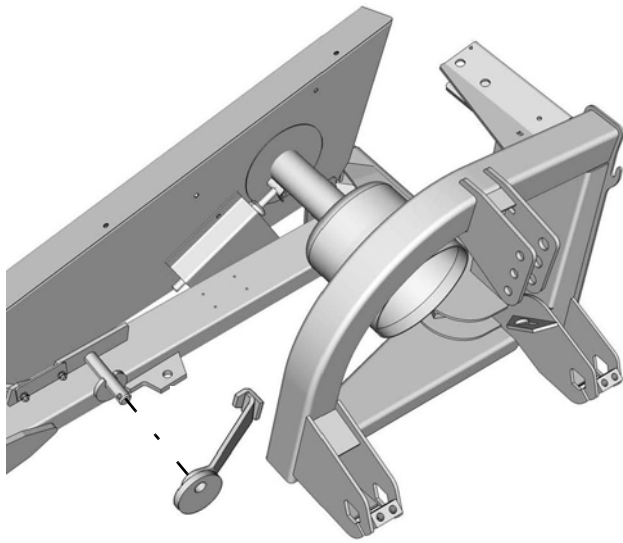


No.	Qty.	Dim.
1	4	M8x20
2	4	M8
3	4	M8

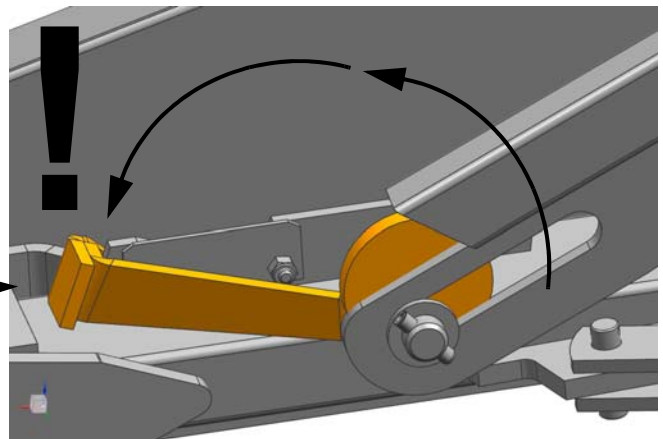


No.	Qty.	Dim.
1	1	$\phi 30 \times \phi 16,5 \times 10$
2	3	$\phi 30 \times \phi 16,5 \times 15$
3	4	M16x55

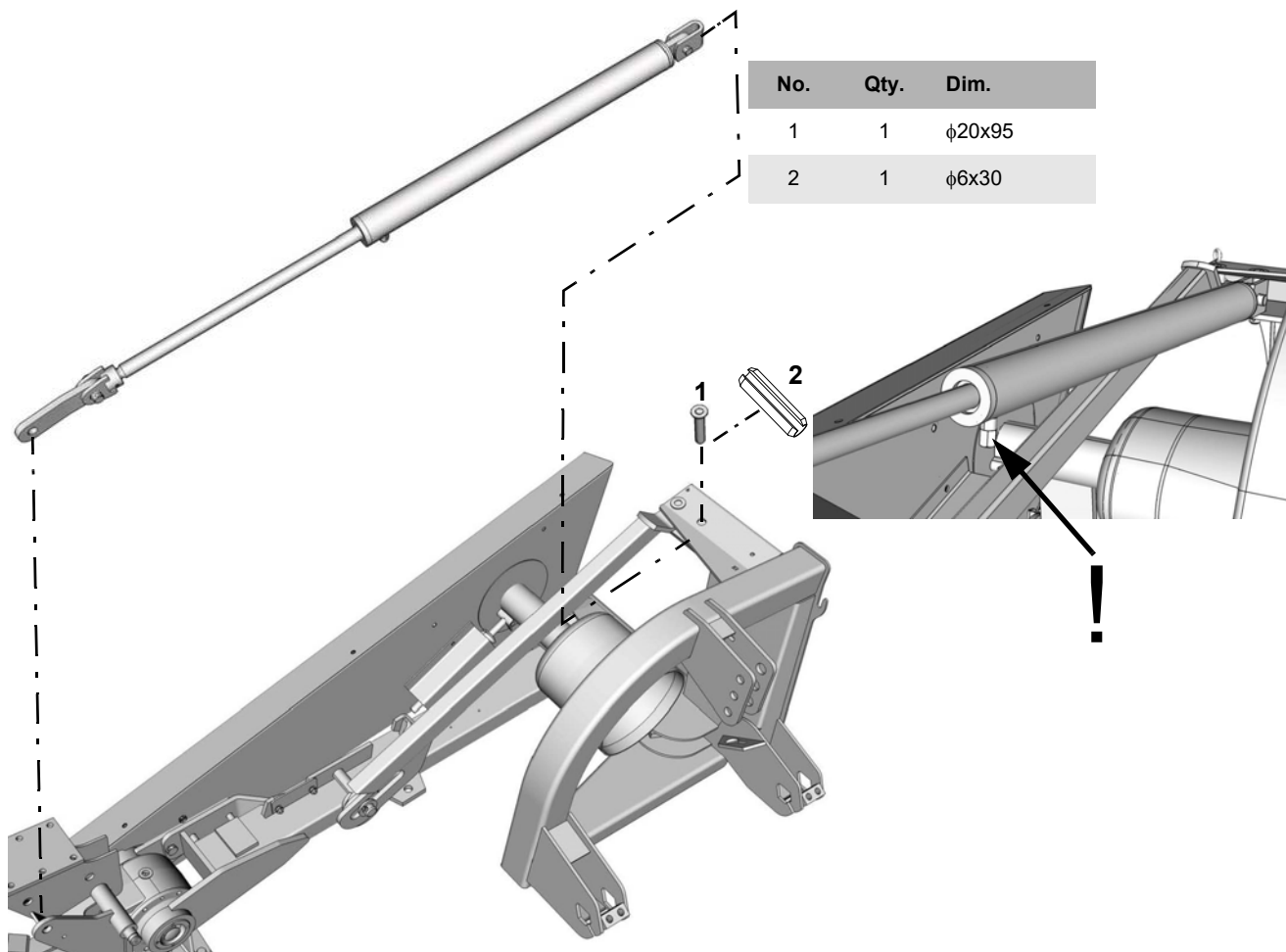
197 Nm  
(145 ft.lbs.)



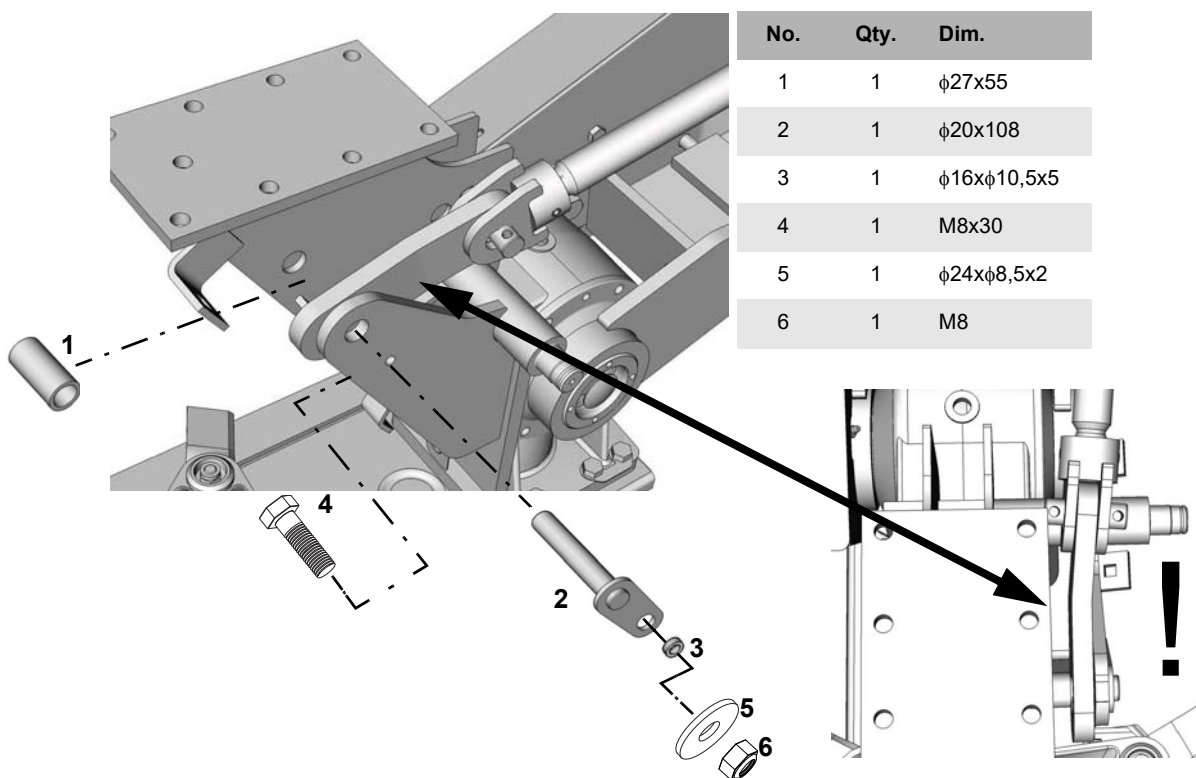
No.	Qty.	Dim.
1	2	$\phi 35 \times \phi 21 \times 21$
2	1	$\phi 31 \times \phi 45 \times 2$
3	1	$\phi 6 \times 30$
4	1	$\phi 20 \times 90$
5	1	$\phi 12 \times 55$



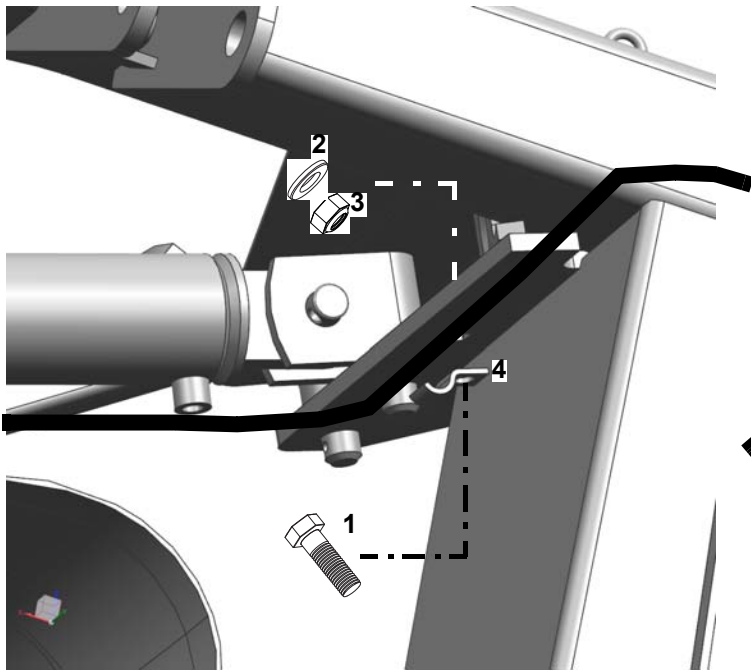
# Assembly



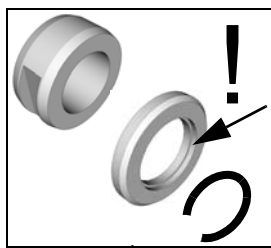
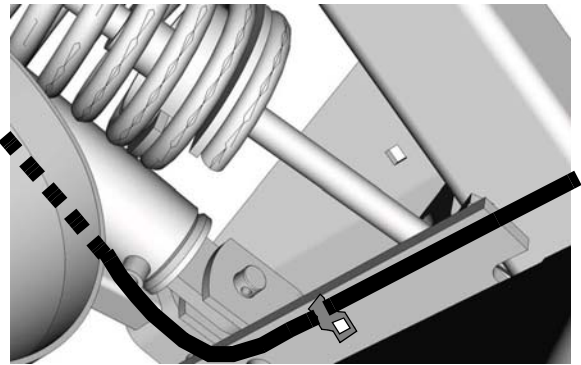
No.	Qty.	Dim.
1	1	φ20x95
2	1	φ6x30



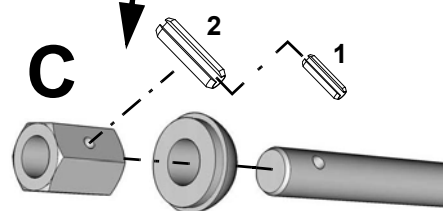
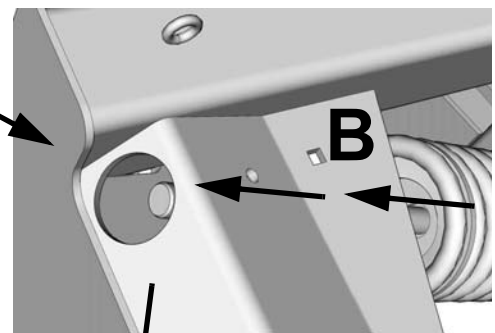
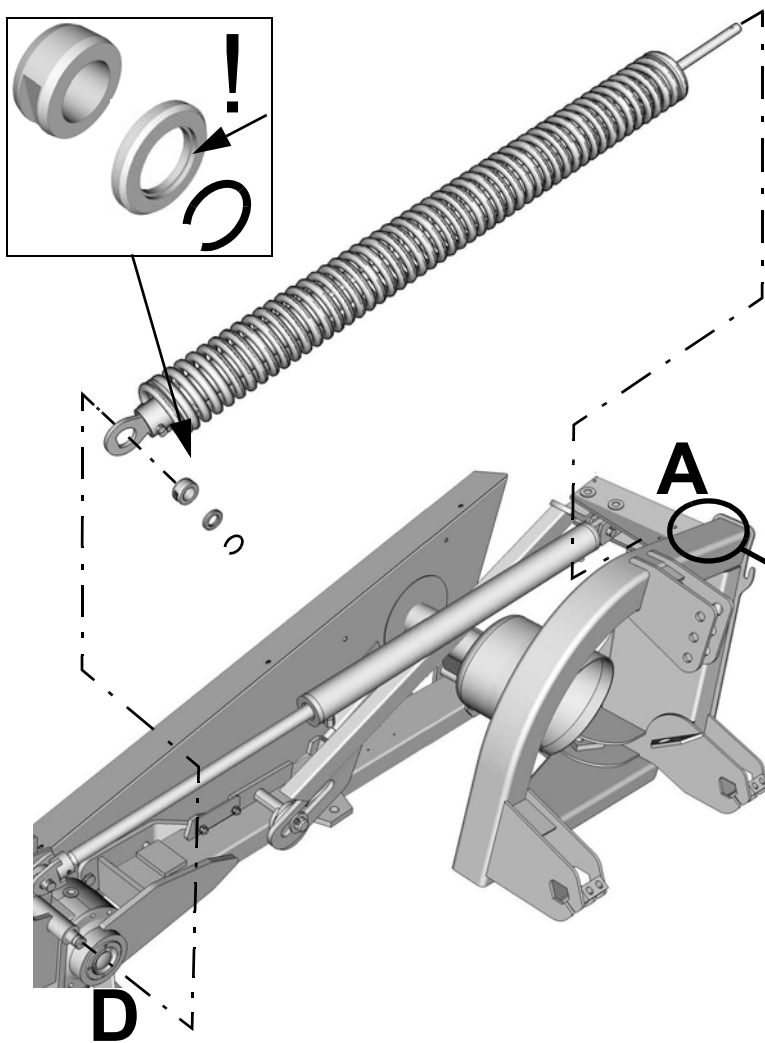
No.	Qty.	Dim.
1	1	φ27x55
2	1	φ20x108
3	1	φ16xφ10,5x5
4	1	M8x30
5	1	φ24xφ8,5x2
6	1	M8



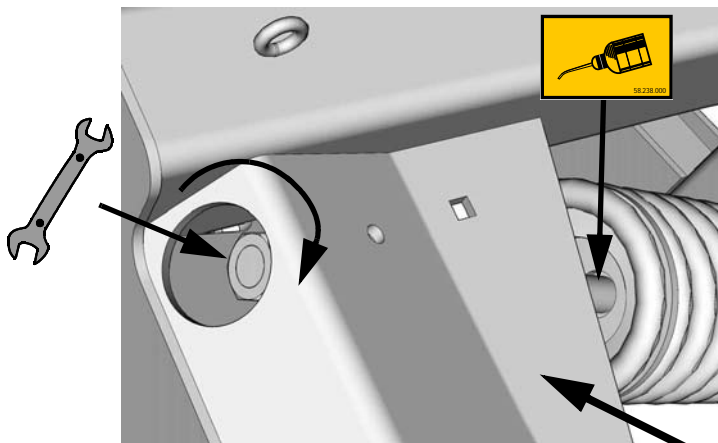
No.	Qty.	Dim.
1	1	M10x25
2	1	M10
3	1	M10
4	1	-



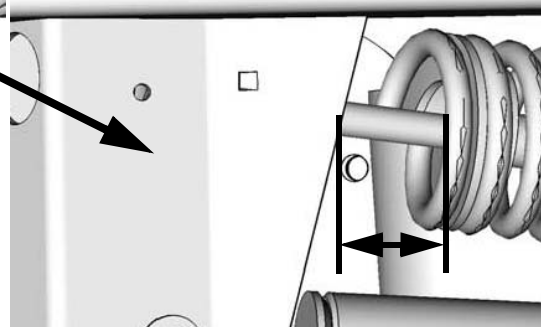
No.	Qty.	Dim.
1	1	$\phi 3,5 \times 30$
2	1	$\phi 6 \times 30$

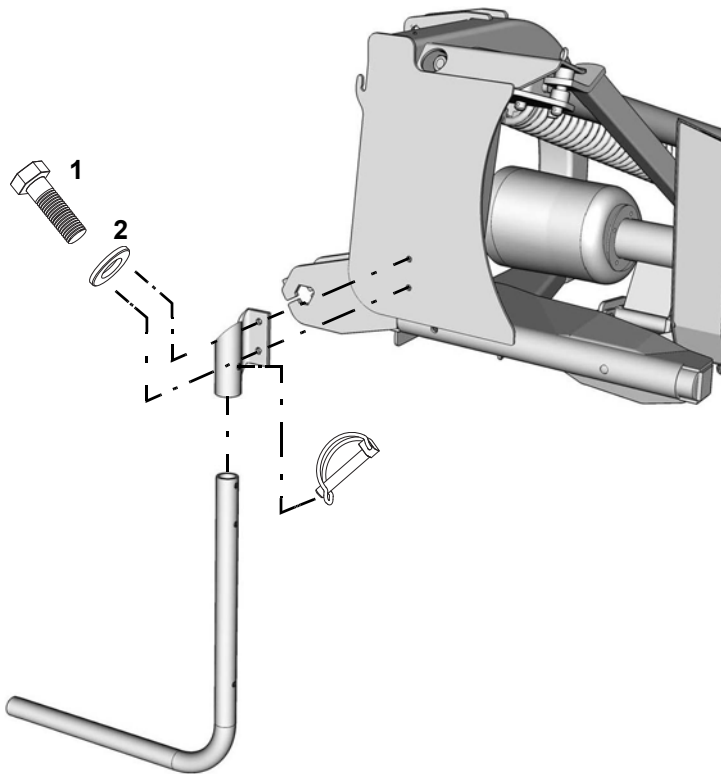


# Assembly



Model	mm / "
2624M / 224 / 2024	80 / 3
2628M / 228 / 2028	150 / 6
2632M / 232 / 2032	120 / 4 <sup>3</sup> / <sub>4</sub>

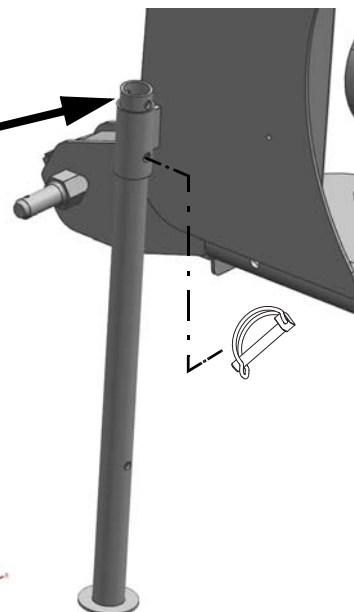
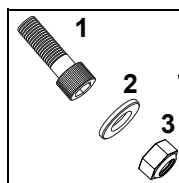




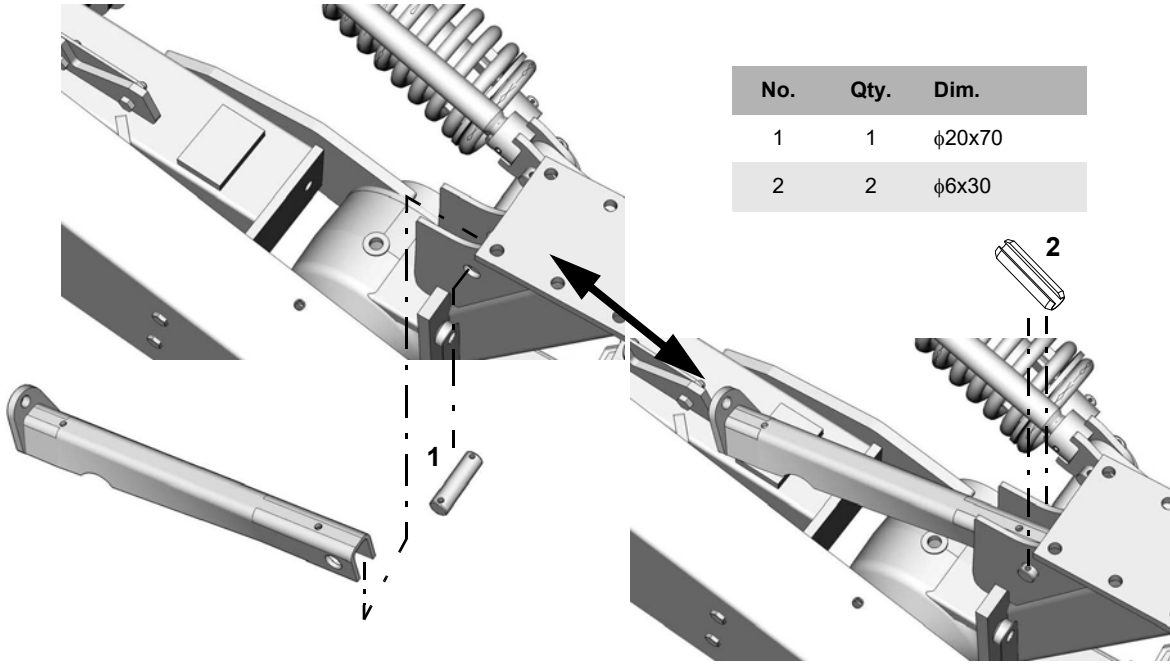
No.	Qty.	Dim.
1	2	M12x40
2	2	M12

No.	Qty.	Dim.
1	1	M10x25
2	1	M10
3	1	M10

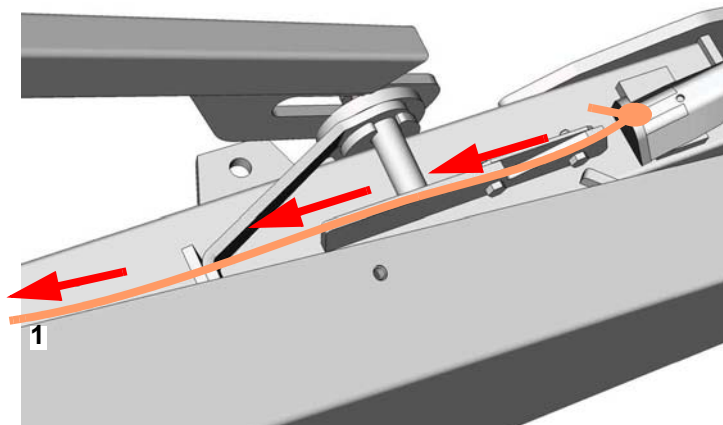
## USA / CANADA



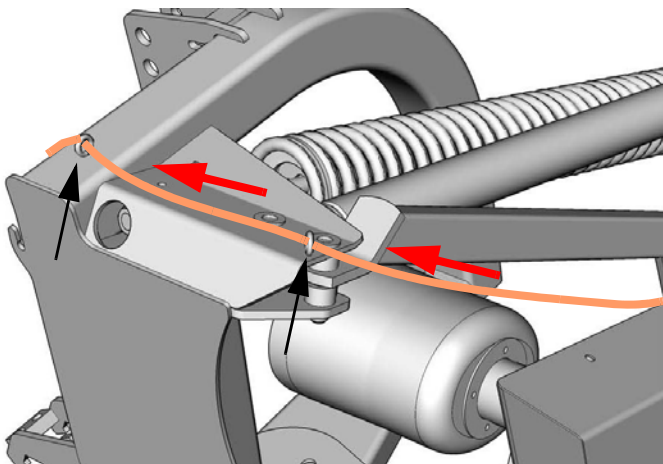
# Assembly

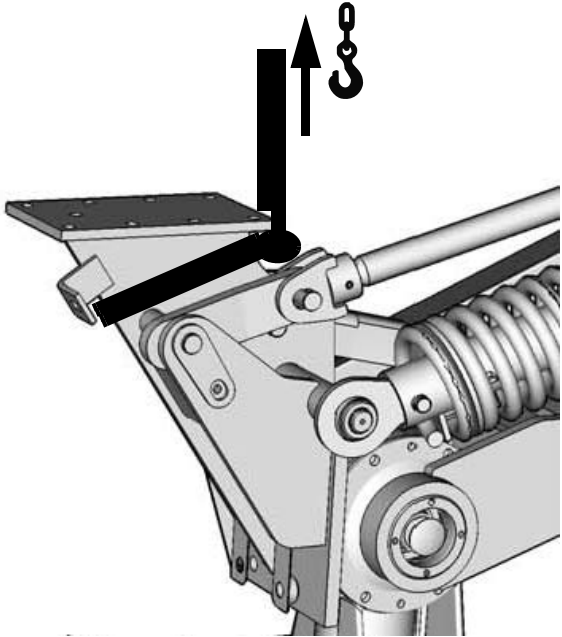


No.	Qty.	Dim.
1	1	φ20x70
2	2	φ6x30

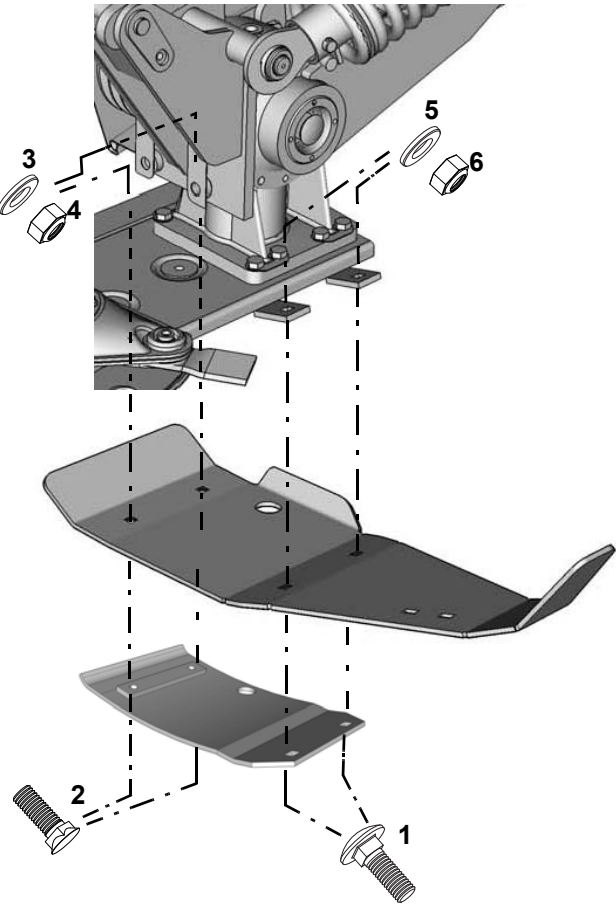


No.	Qty.	Dim.
1	1	φ5x4000



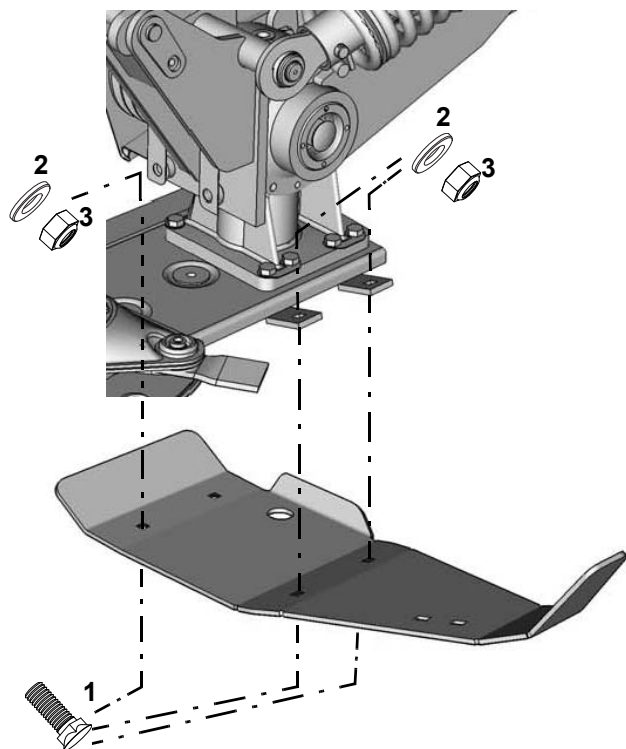


**2624-28-32M / 224-28-32 / 2024-28-32  
(USA / Canada)**



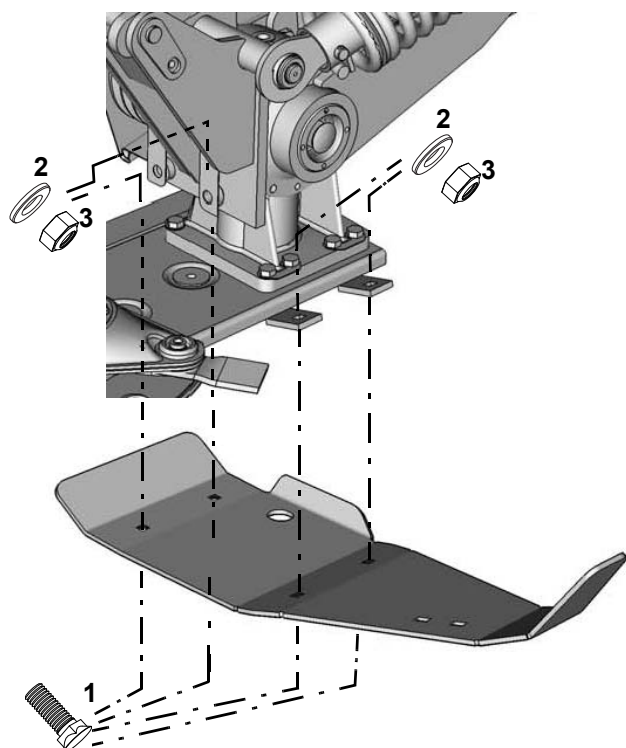
No.	Qty.	Dim.
1	2	M12x40
2	2	M10x50
3	2	M10
4	2	M10
5	2	M12
6	2	M12

## 2624M / 224 / 2024



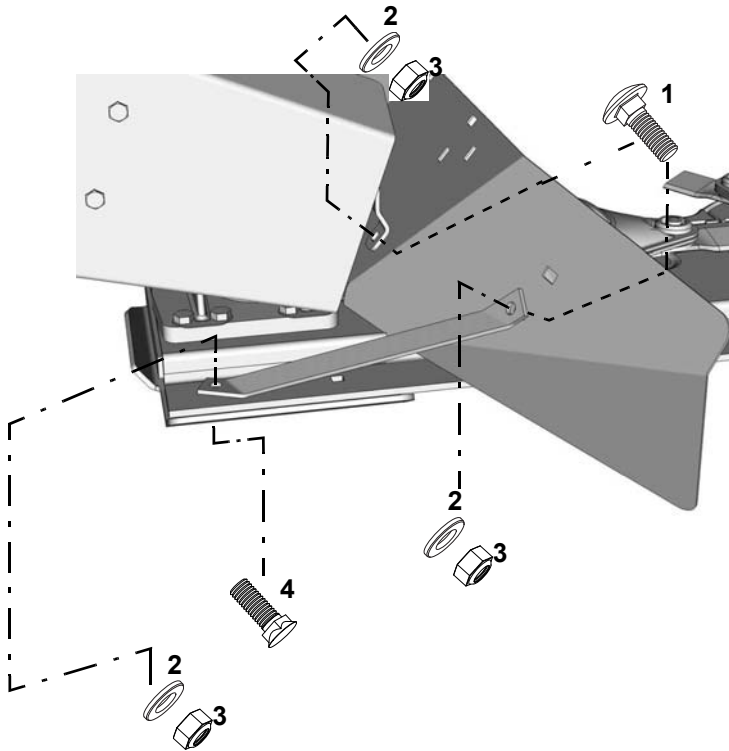
No.	Qty.	Dim.
1	3	M12x35
2	3	M12
3	3	M12

## 2628M-2632M / 228-232 / 2028-2032



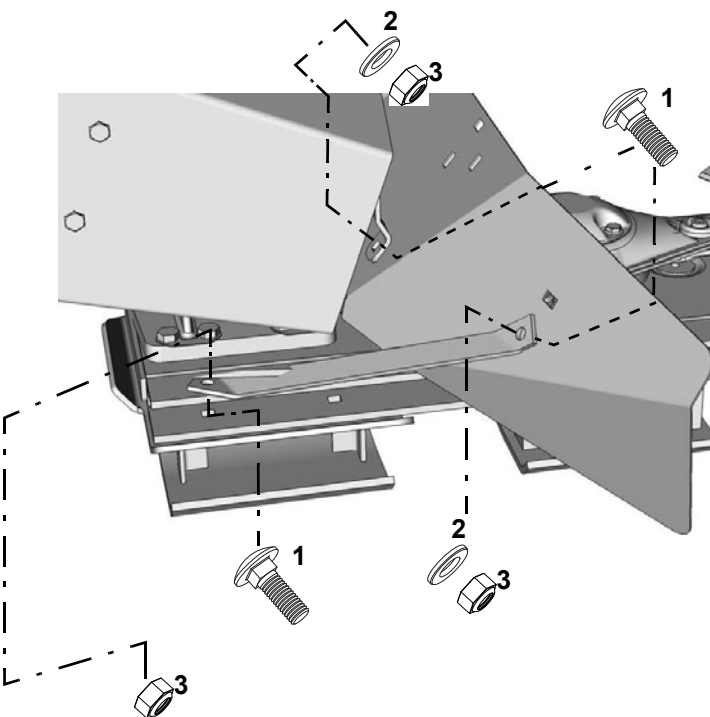
No.	Qty.	Dim.
1	4	M12x35
2	4	M12
3	4	M12

**2624M / 224 / 2024**



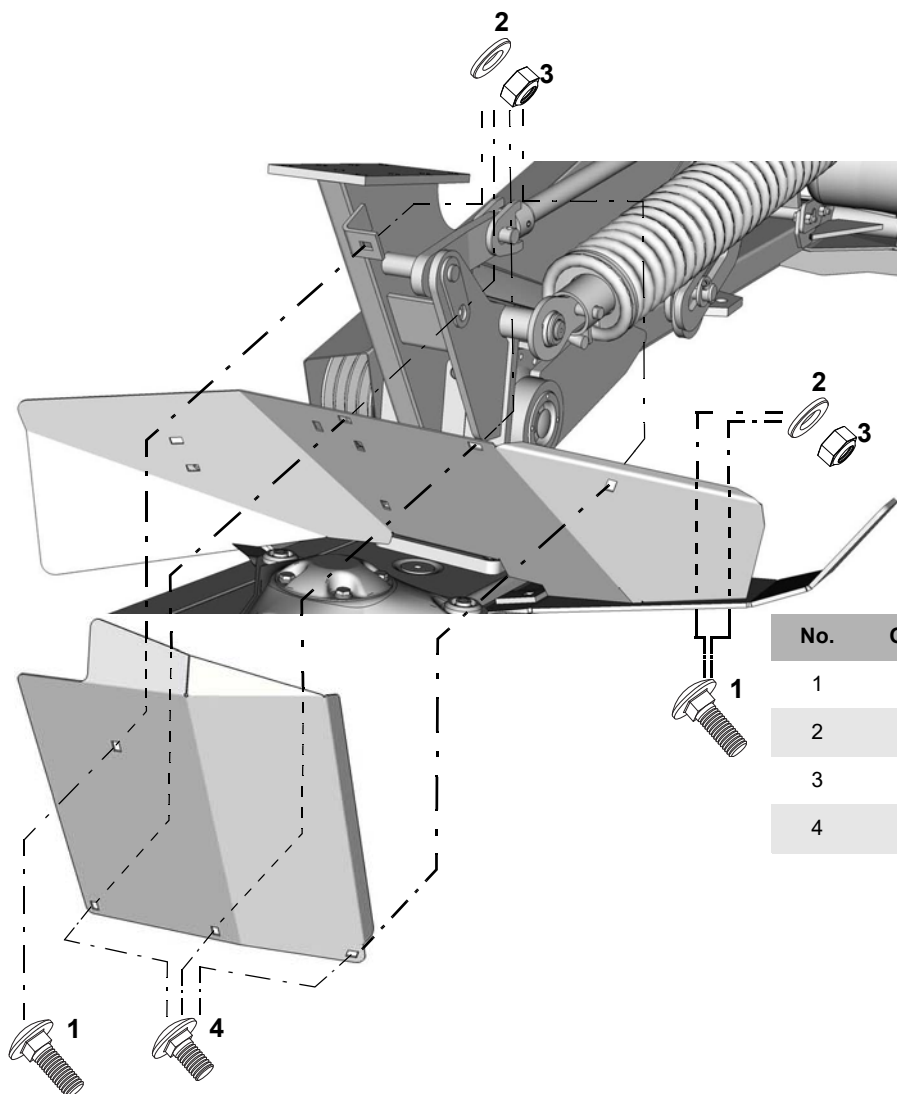
2624M / 224 / 2024		
No.	Qty.	Dim.
1	2	M10x25
2	3	M10
3	3	M10
4	1	M12x45

**2628M-2632M / 228-232 / 2028-2032  
(USA / Canada)**

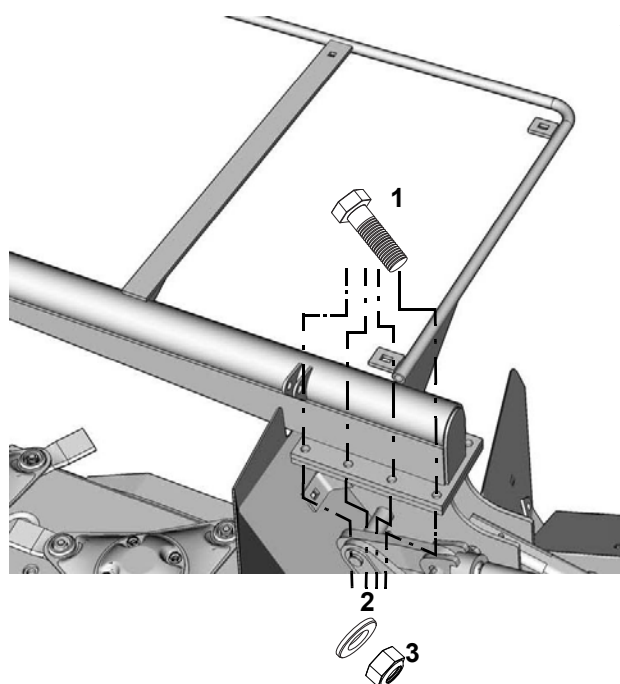


2628M-2632M / 228-232 / 2028-2032		
No.	Qty.	Dim.
1	3	M10x25
2	2	M10
3	3	M10

# Assembly

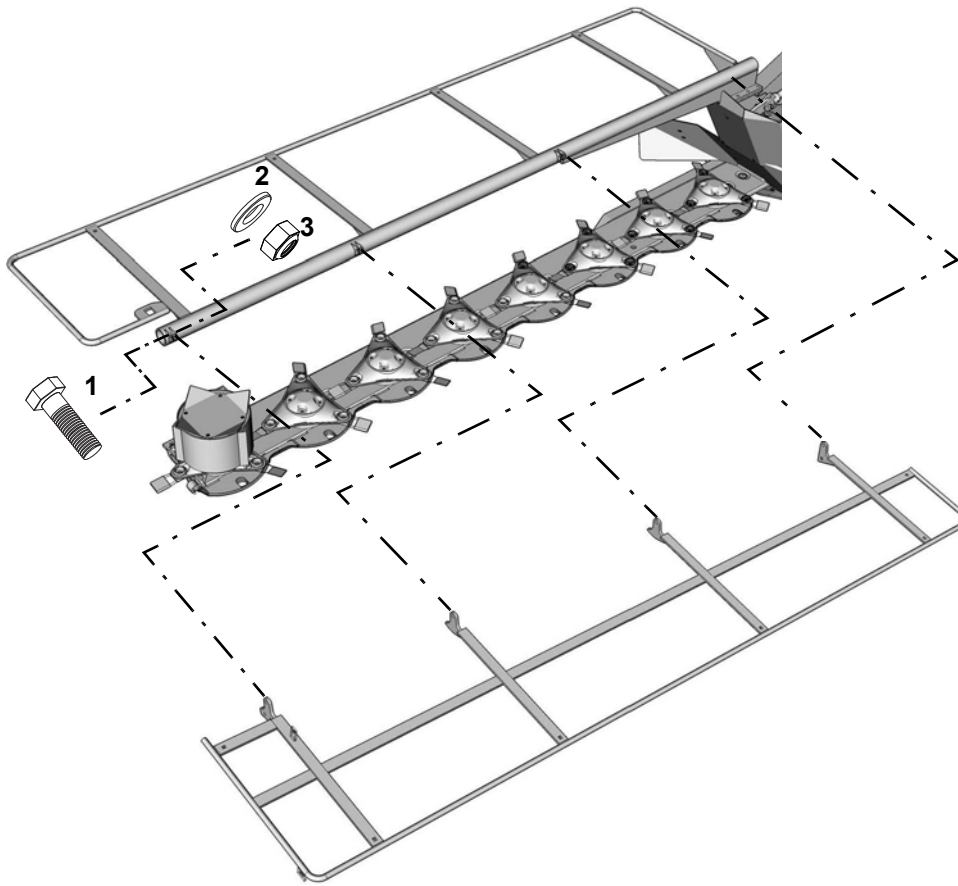


No.	Qty.	Dim.
1	3	M10x25
2	6	M10
3	6	M10
4	3	M10x19



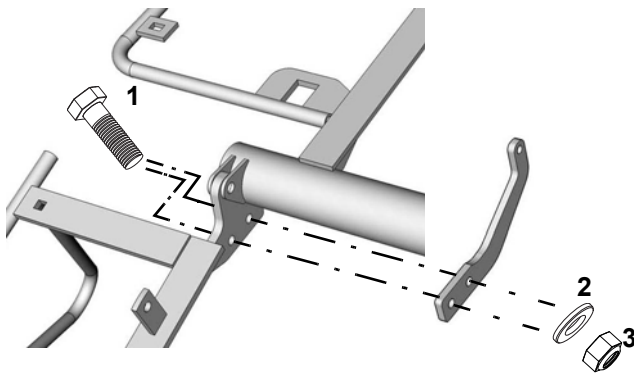
→ »Torque moment« page 4

No.	Qty.	Dim.
1	8	M12x40
2	8	M12
3	8	M12



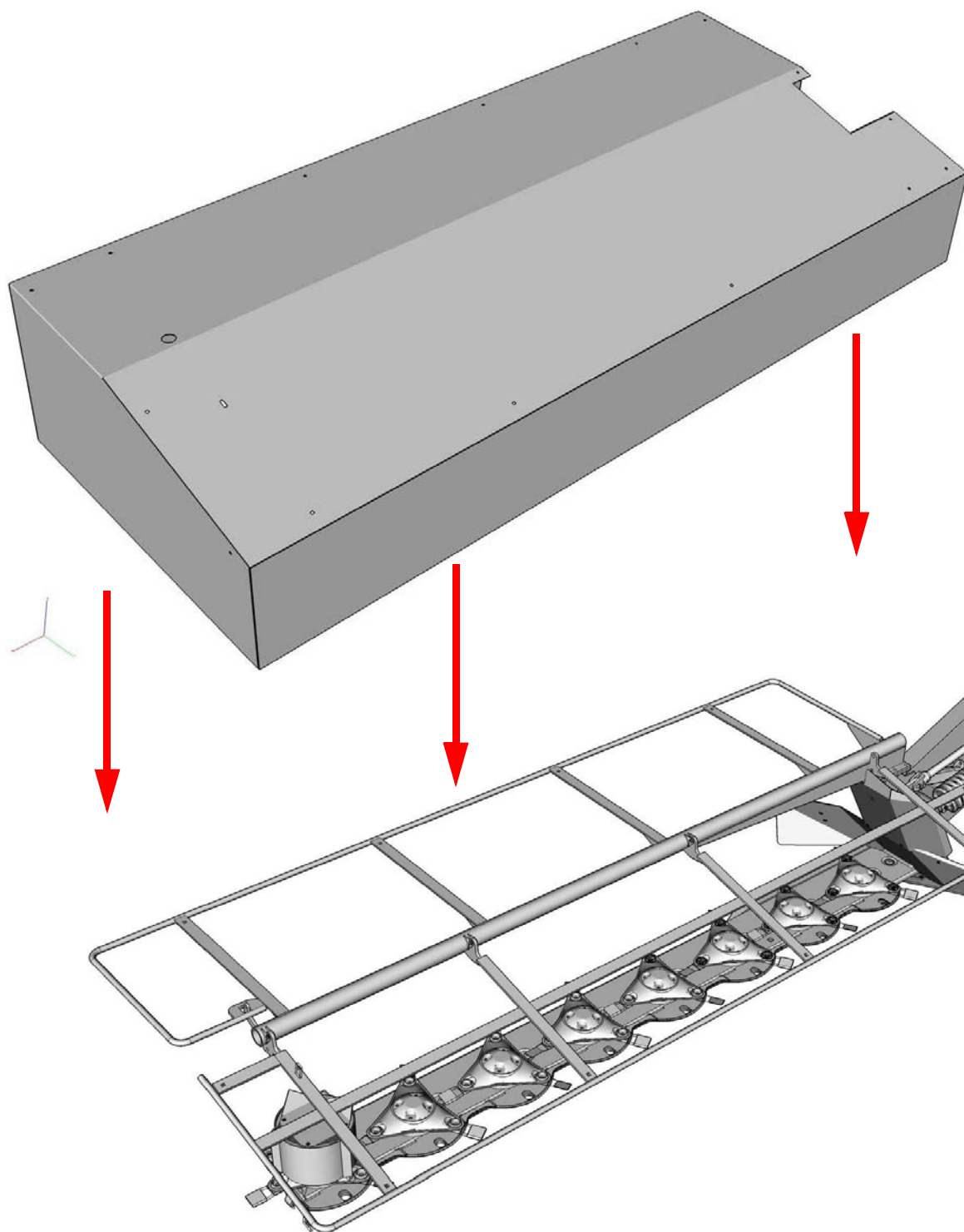
2624M / 224 / 2024		
No.	Qty.	Dim.
1	3	M12x40
2	3	M12
3	3	M12

2628M-2632M / 228-232 2028-2032		
No.	Qty.	Dim.
1	4	M12x40
2	4	M12
3	4	M12



No.	Qty.	Dim.
1	2	M10x35
2	2	M10
3	2	M10

# Assembly

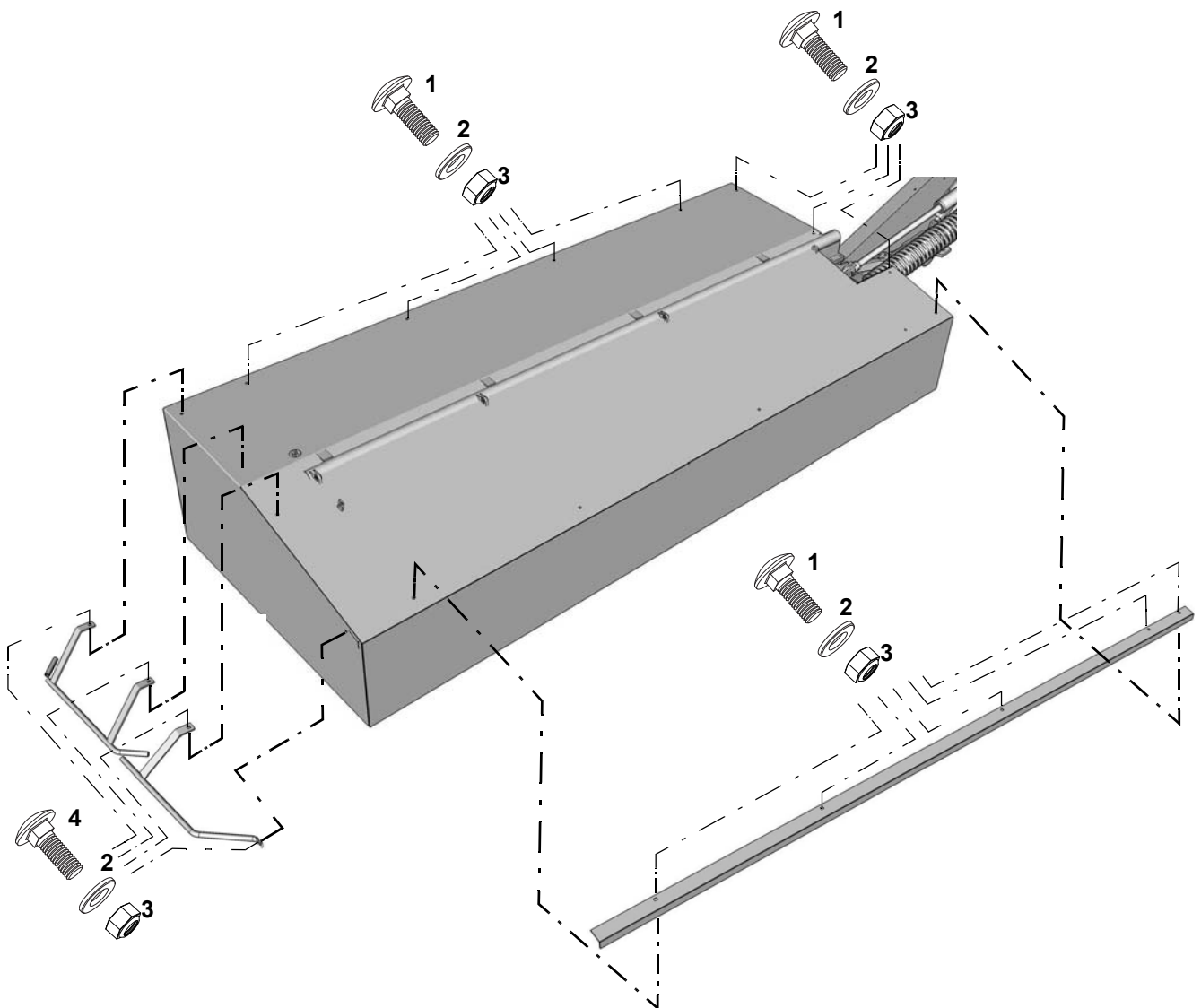


## 2624M / 224 / 2024

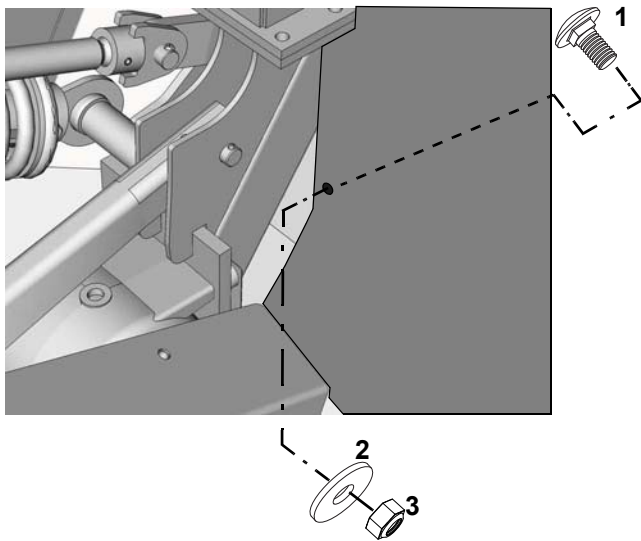
No.	Qty.	Dim.
1	10	M10x25
2	14	M10
3	14	M10
4	4	M10x30

## 2628M-2632M / 228-232 2028-2032

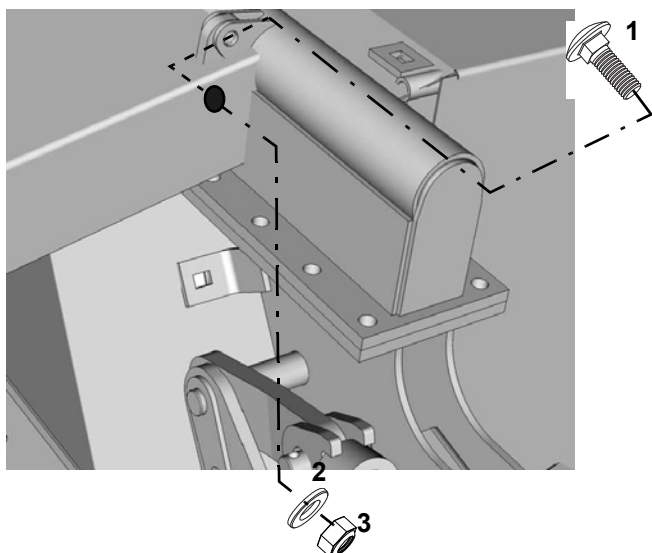
No.	Qty.	Dim.
1	12	M10x25
2	16	M10
3	16	M10
4	4	M10x30



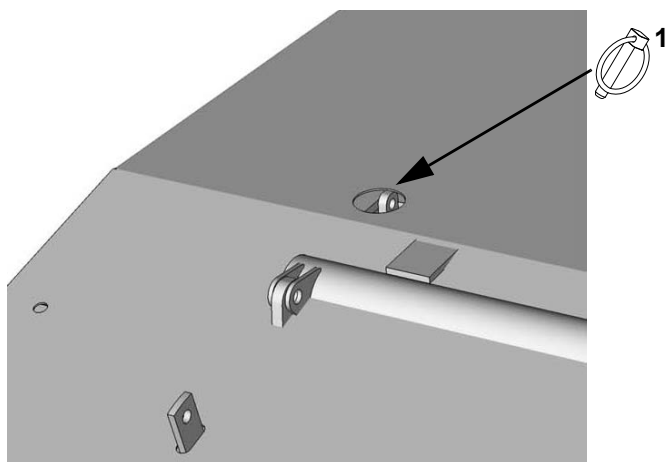
# Assembly



No.	Qty.	Dim.
1	1	M10x19
2	1	φ30xφ11x2
3	1	M10



No.	Qty.	Dim.
1	1	M10x25
2	1	M10
3	1	M10



No.	Qty.	Dim.
1	1	φ8

