



SERVICE BULLETIN # SVC2011-062 **DATE:** 26 August, 2011

Machine/Attachment: BC2100XL **Serial Numbers Involved:** 101 – 140, excluding 106 and 112

Subject:  **PRODUCT SAFETY ALERT**
FIRST NOTICE BC2100XL Frame Reinforcement Kit (IK00-1667)

Background: **FRONT MAIN FRAME WELDMENT FAILURE MAY OCCUR**
High stress levels during towing can result in bending and/or fatigue fractures of the front main frame weldment.

DEATH OR SERIOUS INJURY POSSIBLE
Fatigue fractures or a bend in the front main frame weldment may result in loss of vehicle control while towing on a public highway. **Death or serious injury may result.** Property or equipment damage is also possible

Solution: **IMMEDIATE MACHINE MODIFICATIONS REQUIRED**
IK00-1667 has been created to provide the necessary parts and instructions to replace the front main frame weldment with an updated design. **This kit must be installed as soon as possible by an authorized Vermeer dealer.**

DEALER PARTICIPATION
REVIEW REPORT, ORDER KITS, CONTACT CUSTOMERS

1. **Reports will be faxed** during the week of August 26, 2011, to dealerships shown in our records which have units in their territory affected by this Alert. Please review the report for accuracy, including owner and/or address changes.

If the information contained in the report is NOT correct, please notify the Product Safety Department on or before September 9, 2011 at:

Telephone: 641-621-7060
Fax: 641-621-7739
Email: productsafety@vermeer.com

2. **Dealership Order Kits** by contacting the Product Safety Department.
 - a. Each dealership should determine the quantity of Kits to order initially depending upon the number of units that may be available for immediate upgrade. **Do not order more Kits than needed for immediate installation.**

- b. Orders must be submitted by contacting Product Safety Department:
- by Phone: 641-621-7825
 - by Fax: 641-621-7739
 - by E-mail: productsafety@vermeer.com

When placing the Kit Order(s), you must provide:

- 17-digit VIN of the unit;
- Requested method of shipment.

If this information is not included, the processing of your order may be delayed.

- c. Upon receipt of the Kit order(s) from the dealerships, Product Safety Department will contact the Parts Distribution Center to ship the Kit(s) according to the shipping instructions received with the order(s). This will enable the Product Safety Department to better monitor the quantity of Kits being ordered and available Kit inventory. Please do not order Kits directly from the Parts Distribution Center as this will delay the processing of your order.
3. **Contact your affected customer(s)** to schedule a mutually acceptable time to upgrade their machine. *Note:* Letters will be sent to the customer(s) on or about **September 12, 2011**. *Also refer to Owner Notification section below.*

If you have any questions concerning the installation of IK00-1667, please contact the Environmental Service Department.

REIMBURSEMENT

Upon completion of each Kit installation, a Warranty Claim must be submitted to the Corporate Warranty Department for reimbursement of the cost of the Kit. The Work Completion Certificate indicating that the Kit was installed must also be submitted. Both documents (Claim and Work Completion Certificate) must be received prior to reimbursement of the parts or labor for this product safety alert. **This kit must be installed by an authorized Vermeer dealer.**

For those dealers submitting warranty claims via iWarranty, please submit a campaign claim with the Work Completion Certificate attached to the claim.

A Work Completion Certificate is attached below which indicates the labor hours. **Note:** *Future notices to dealers and owners are dependent upon the receipt of Work Completion Certificates by Product Safety Department.*

OWNER NOTIFICATION

Sample Letter: Included at the end of this Bulletin is a sample letter which will be sent by Vermeer Corporation directly to the Owners on or about **September 12, 2011**, via USPS certified/registered mail.

Owner notifications for units in non-English speaking countries will be translated into the primary language of that country, where **required by law** (European Community; Quebec, Canada; and Brazil). Owner notifications for this safety campaign will be translated into the following language:

- French.

Owner notifications for units in non-English speaking countries, where translations are not required by law, will be sent in English to the owner's service dealer for

delivery to the owner. However, if a translated owner notification is available due to translation of the owner notifications required by law, then those owner notifications will be sent directly to owner (example: Spanish sent to units in Mexico, if applicable for that safety campaign). All translated owner notices will also include English owner notification.

This owner notification/letter instructs the owner **to contact their local dealership** to arrange for a time to have the Kit installed. After receiving IK00-1667 from the Parts Center, you must contact your affected customer(s) immediately and schedule a mutually acceptable time to upgrade their machine.

We regret any inconvenience that these corrective measures may cause you. This required work is for safety of the towing vehicle occupants and other drivers and passengers traveling on the public roadways. We hope you agree that the safety benefits surpass the inconvenience.

PRODUCT SAFETY DEPARTMENT

Attachment:

IK00-1667 Kit Instructions

For Reference:	<u>Primary Part Number(s)</u> IK011667, IK021667	<u>For Model(s)</u> BC2100XL
TREAD Act Code: <i>(Choose one or more codes applicable)</i>	<input checked="" type="checkbox"/> -- Not Applicable <input type="checkbox"/> 02 Suspension <input type="checkbox"/> 03 Service brake system, hydraulic <input type="checkbox"/> 04 Service brake system, air <input type="checkbox"/> 05 Parking brake <input type="checkbox"/> 11 Electrical	<input type="checkbox"/> 12 Exterior lighting <input type="checkbox"/> 16 Structure <input type="checkbox"/> 17 Latch <input type="checkbox"/> 19 Tires <input type="checkbox"/> 20 Wheels <input type="checkbox"/> 21 Trailer hitch

Priority: <input checked="" type="checkbox"/> Mandatory <input type="checkbox"/> Recommended <input type="checkbox"/> Information only	Completion Schedule: <input type="checkbox"/> 30 days from date of this bulletin <input type="checkbox"/> 90 days from date of this bulletin <input type="checkbox"/> 180 days from date of this bulletin <input type="checkbox"/> Only Units within Standard Limited Warranty Period <input checked="" type="checkbox"/> Product Safety Alert: Install immediately <input type="checkbox"/> N/A
Dealer Distribution: <input type="checkbox"/> Domestic <input type="checkbox"/> International <input checked="" type="checkbox"/> Both	Reimbursement: <input type="checkbox"/> Only Units within Standard Limited Warranty Period <input checked="" type="checkbox"/> Product Safety Alert: Work Completion Certificate Required <input checked="" type="checkbox"/> All Serial Numbers Listed Above <input checked="" type="checkbox"/> Parts <input checked="" type="checkbox"/> Labor Paid(Labor Code: 9L50) <input type="checkbox"/> No Reimbursement

Return completed Work Completion Certificate for labor credit to:
 Product Safety Department: FAX: 641-621-7739
 EMAIL: productsafety@vermeer.com

WORK COMPLETION CERTIFICATE		<i>For Dealer Use:</i>	
IK00-1667: BC2100XL Frame Replacement Kit First Notice - **Dealer Installation Only**		<i>Warranty Claim #</i>	
17-Digit Serial Number is required			
BC2100XL	_ _ _ _ _		
I have properly installed the parts according to the Kit's written instructions and am returning this Certificate with the understanding that the Installer's Company will receive 10.0 hours reimbursement for labor from Vermeer Corporation.			
Date Work Completed:			
Work Completed By: <i>(Enter Installer's Name, Company's Name & Address)</i>			
Installer's Signature:	X	Phone #:	
	<i>(Name of Installer's Company, Address, and Signature Required)</i>		
Unit Owner's Name:			
Unit Owner's Address:			
	<i>(Name of Owner's Company and Address)</i>		



IK001667
Date: 26 Aug 2011

Frame Reinforcement Kit **Dealer Installation Only**			
Model	Serial Numbers		Kit # Version
	Including	Excluding	
BC2100XL	101 – 140	106, 112, 114, 132	IK01
BC2100XL	114, 132	101 – 140	IK02
Mandatory	<input checked="" type="checkbox"/>	Recommended	<input type="checkbox"/>
		Optional	<input type="checkbox"/>
<i>Dealer Reference:</i>		<i>Service Bulletin No.</i>	

**PRODUCT
SAFETY
ALERT**

PURPOSE:

FRONT MAIN FRAME WELDMENT FAILURE MAY OCCUR

High stress levels during towing can result in bending and/or fatigue fractures of the front main frame weldment.

DEATH OR SERIOUS INJURY POSSIBLE

Fatigue fractures or a bend in the front main frame weldment may result in loss of vehicle control while towing on a public highway. **Death or serious injury may result.** Property or equipment damage is also possible

This kit provides the necessary parts and instructions to replace the front main frame sub weldment and tongue assemblies. IK01-1667 is for units with hydraulic tongue jacks and IK02-1667 is for units with manual only tongue jack.

SPECIAL TOOLS AND CONDITIONS:

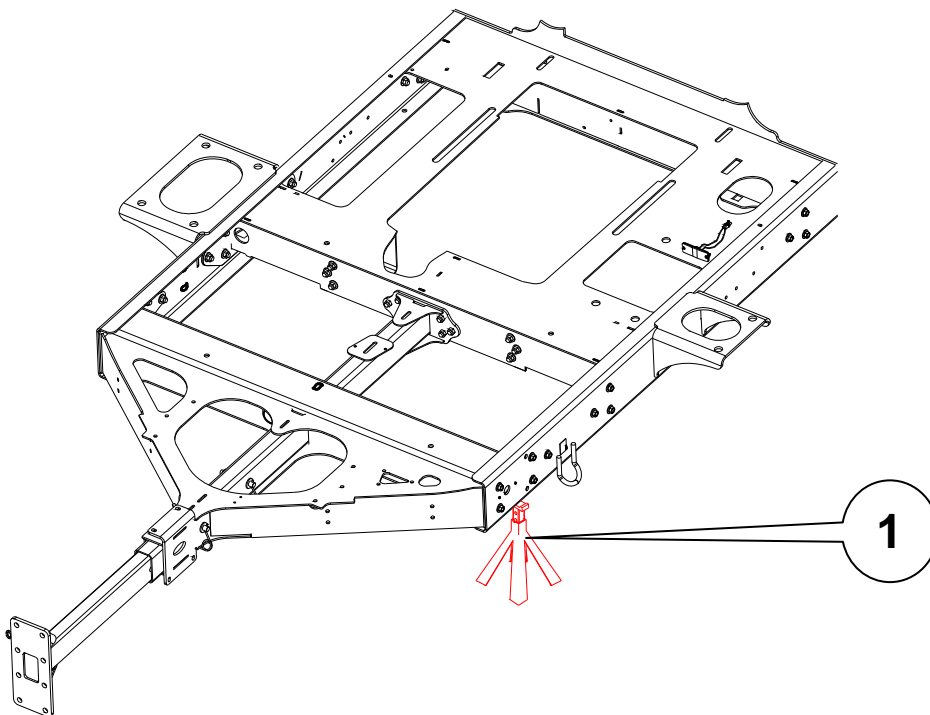
- Floor jack 2000 lb (907 kg)
- Jackstands (2) or blocking
- Overhead hoist and hoist chains rated for 5000 lb (2300 kg).



WARNING: Use the following shutdown procedure before attempting to do any work described in this kit.

1. Move Side Feed Control Bar to NEUTRAL position.
2. Reduce engine speed to LOW RPM. Wait for cutter drum to slow.
3. Place Cutter Drum (Clutch) Lever in the DISENGAGED position.
4. Park machine on flat, level surface and chock wheels.

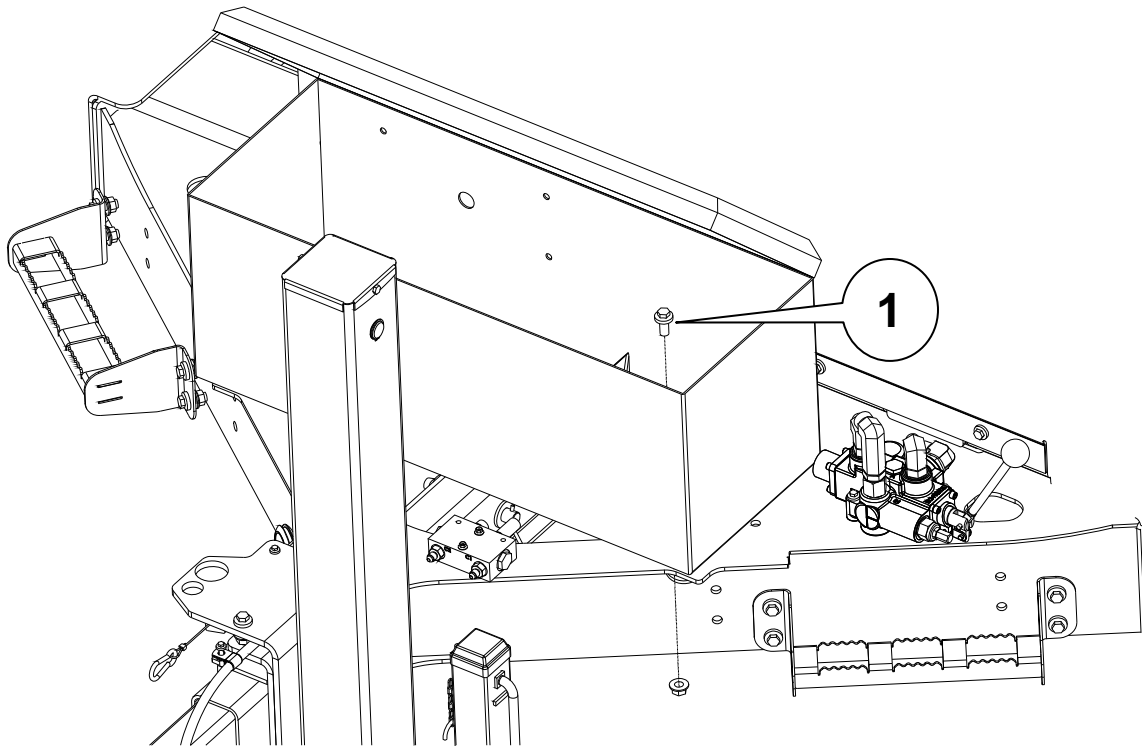
5. Using the manual or hydraulic tongue jack, raise front of machine up and put jack stands or blocking **(1)** under both front corners of frame side rails in positions shown.



6. Lower frame onto supports and raise tongue jack pad off ground.
7. Shut off engine and remove key.
8. Shut off remote control if in use.
9. Disconnect battery cables.

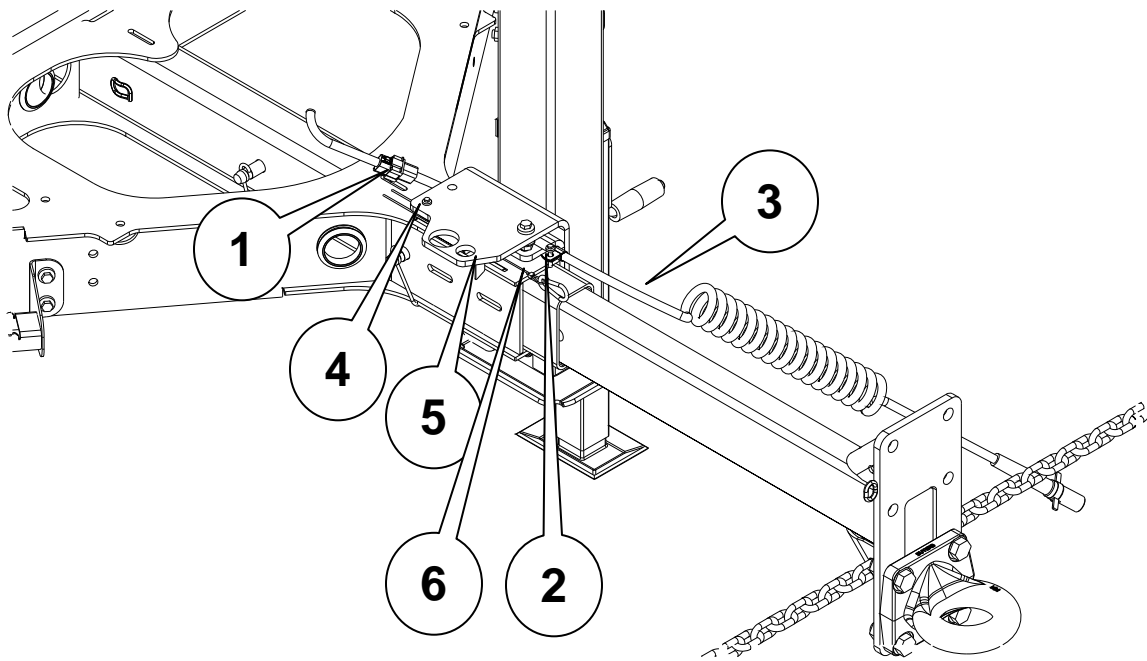
PROCEDURE: Removal of Toolbox

1. Open toolbox and remove four screws (1) and nuts inside at the bottom of the toolbox. Retain hardware.
2. Remove and retain toolbox.



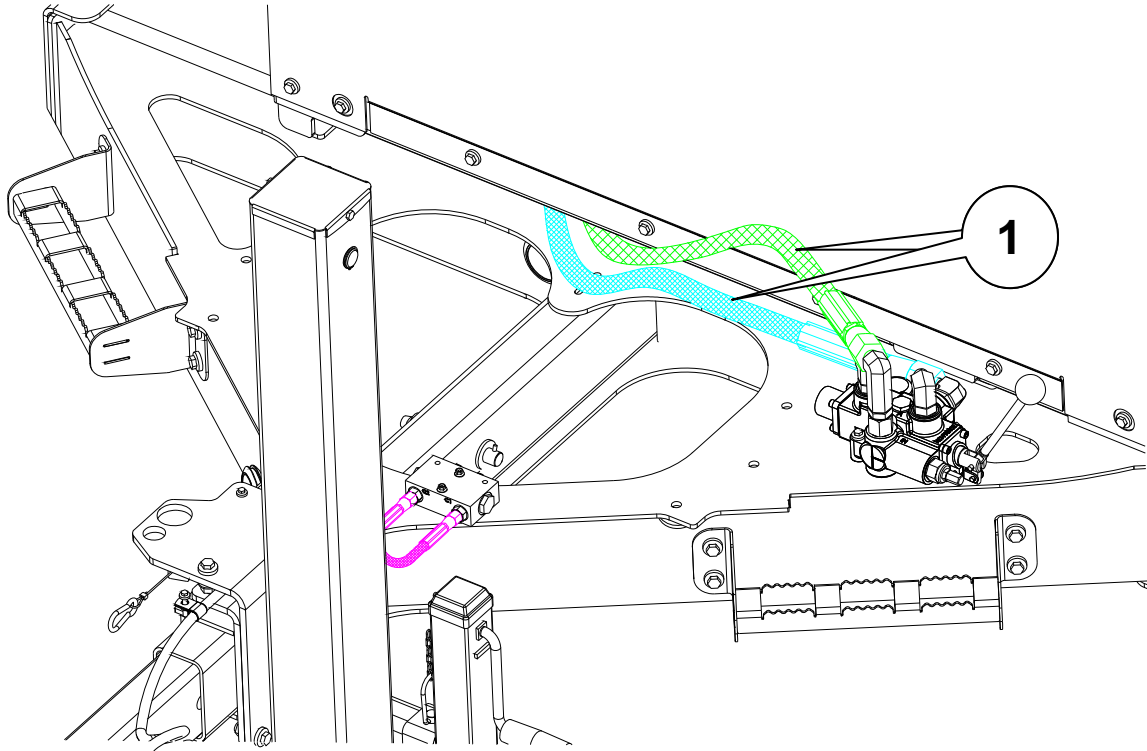
PROCEDURE: Removal of Trailer Harness

1. Unplug light harness at connector location **(1)**.
2. Remove screw and P-clip **(2)**. Pull front portion of harness assembly **(3)** out of tongue and retain for assembly later.
3. Pull breakaway cable and tab **(6)** out of breakaway switch **(5)**. Remove nut and bolt **(4)** from breakaway switch **(5)** (under plate) but leave switch connected to harness. Retain breakaway cable assembly and hardware for assembly later.
4. Remove ny-ties which hold the remaining portion of the harness in place and route harness back through the front main frame sub weldment while disconnecting the side marker lights.

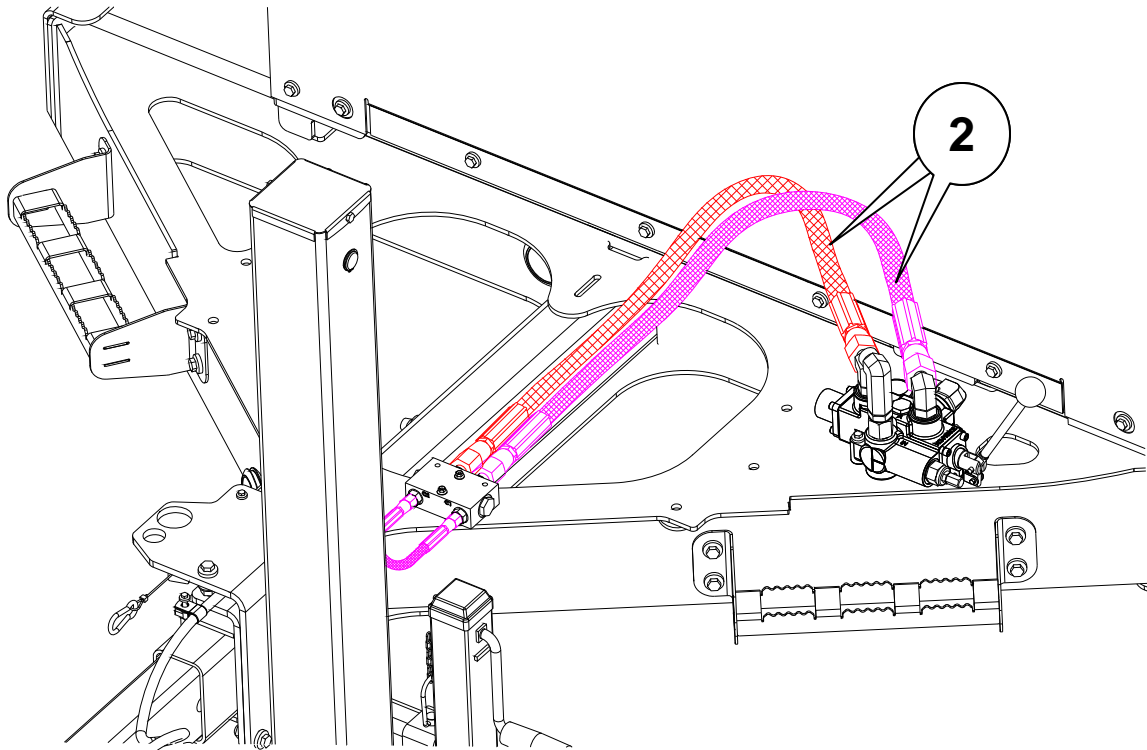


PROCEDURE: Removal of Hosing (IK01 Only)

1. Label and remove supply and return hoses **(1)** to tongue jack valve. Plug hoses using plugs 83322001 and cap fittings with caps 83330001.

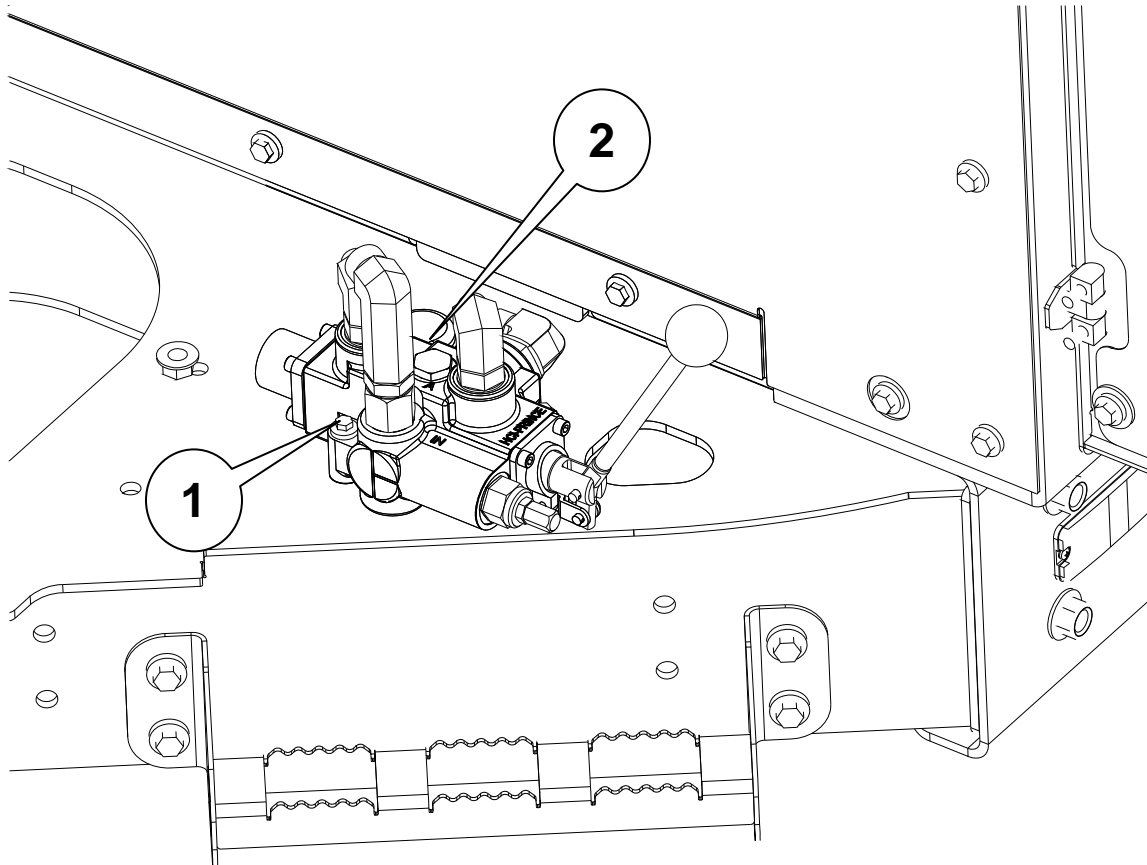


2. Remove and discard two hoses **(2)** that connect the tongue jack valve to the jack lock valve. Cap fittings at both valves with caps 83328001.



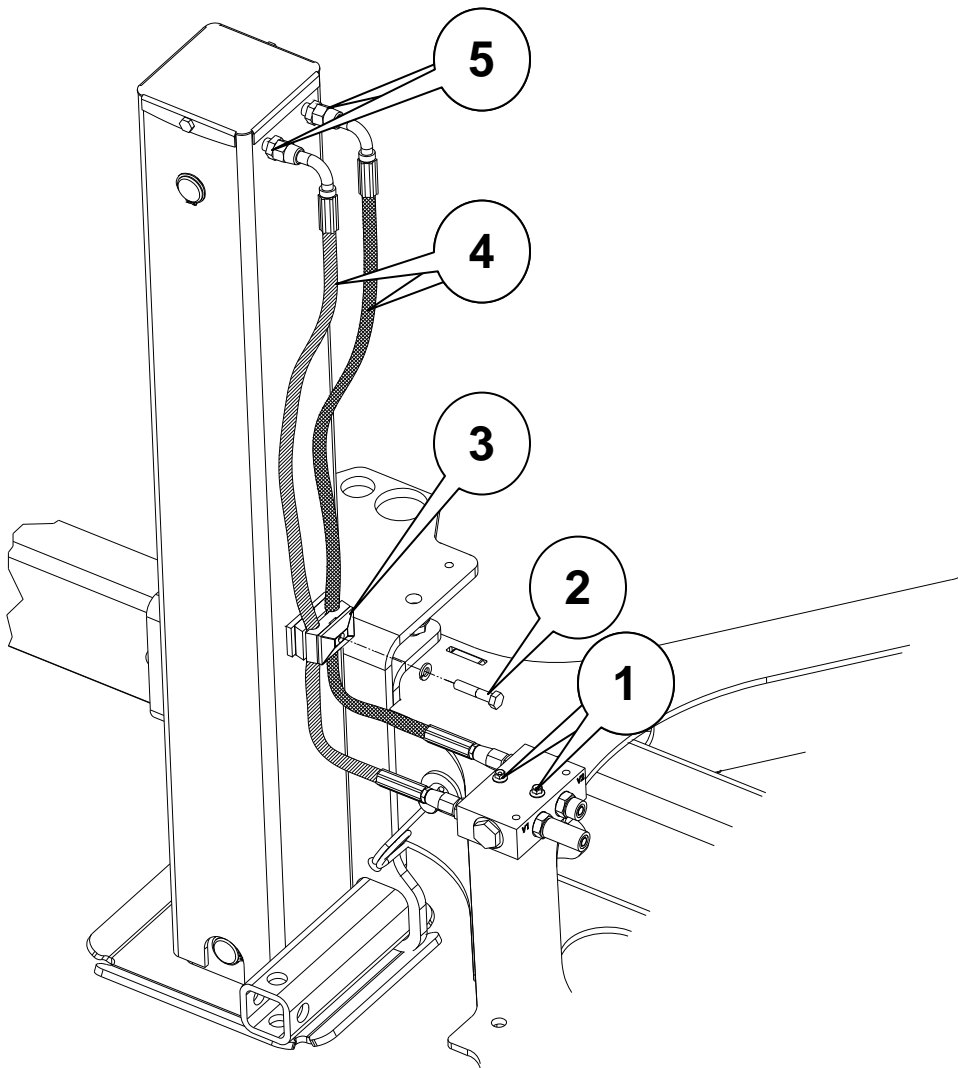
PROCEDURE: Removal of Tongue Jack Valve (IK01 Only)

1. Remove and retain valve mounting hardware **(1)** and Tongue Jack Valve **(2)** and retain for assembly later.



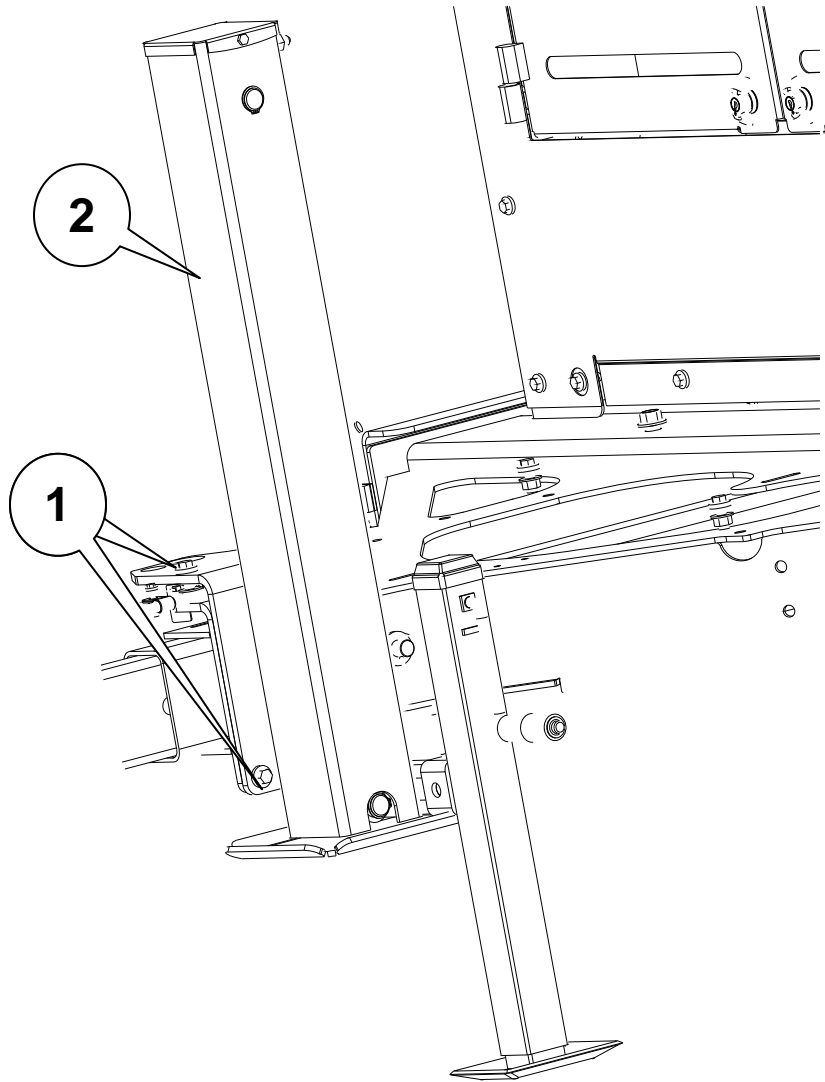
**PROCEDURE: Removal of Jack Lock Valve and Hosing Assemblies
(IK01 Only)**

1. Remove and retain two screws **(1)** and nuts from jack lock valve.
2. Remove and retain screw **(2)** and washer from hose clamp assembly **(3)**, then remove and retain hose clamp assembly.
3. Disconnect and retain hoses **(4)** from fittings **(5)** at top of hydraulic jack tube. Plug hoses with plugs 66330001.
4. Remove and retain jack lock valve and hose assemblies.



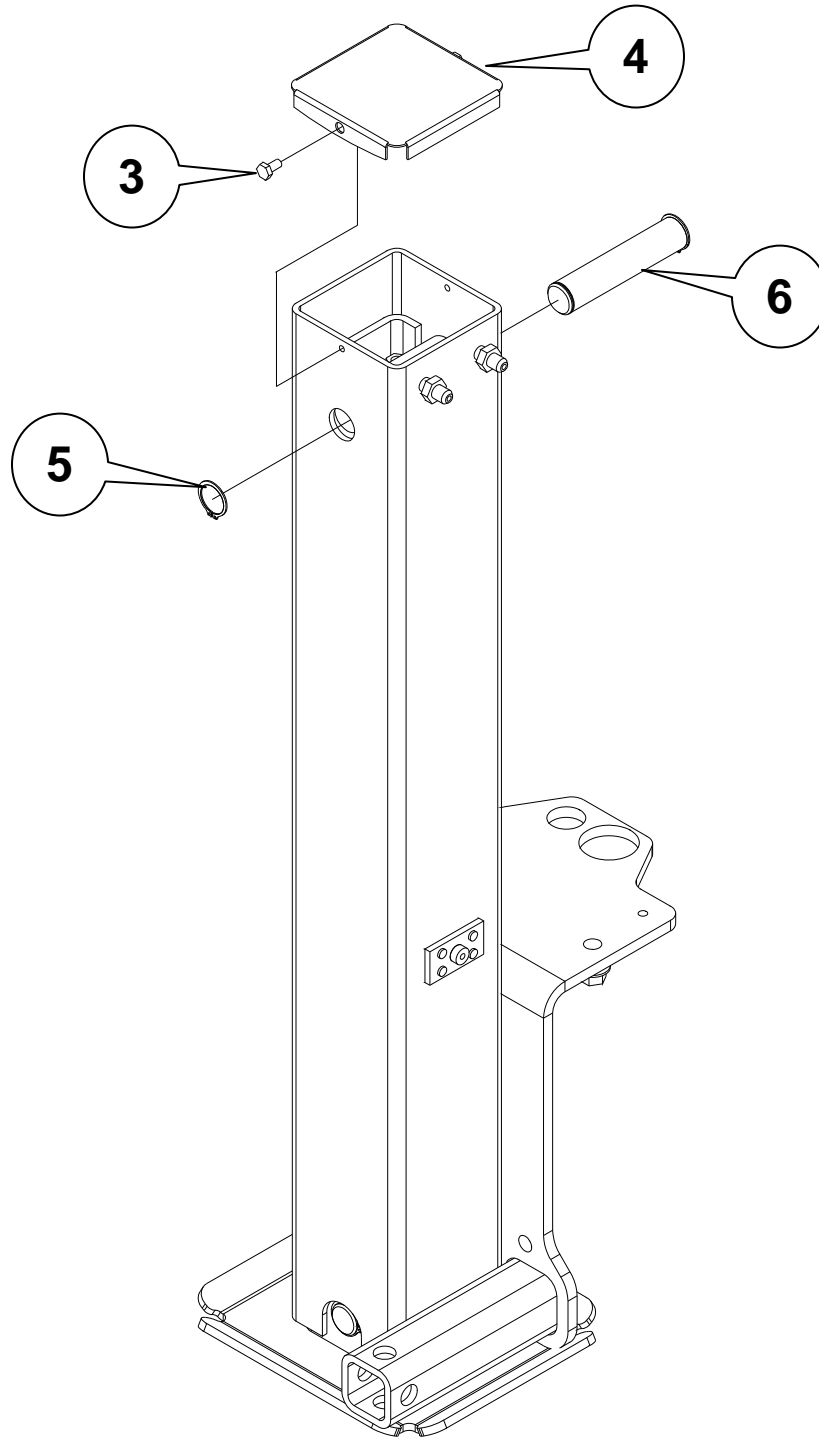
PROCEDURE: Removal of Hydraulic Jack Assembly (IK01 Only)

1. Remove and retain four screws (1) and nuts from hydraulic jack assembly.
2. Remove hydraulic jack assembly (2) from tongue.

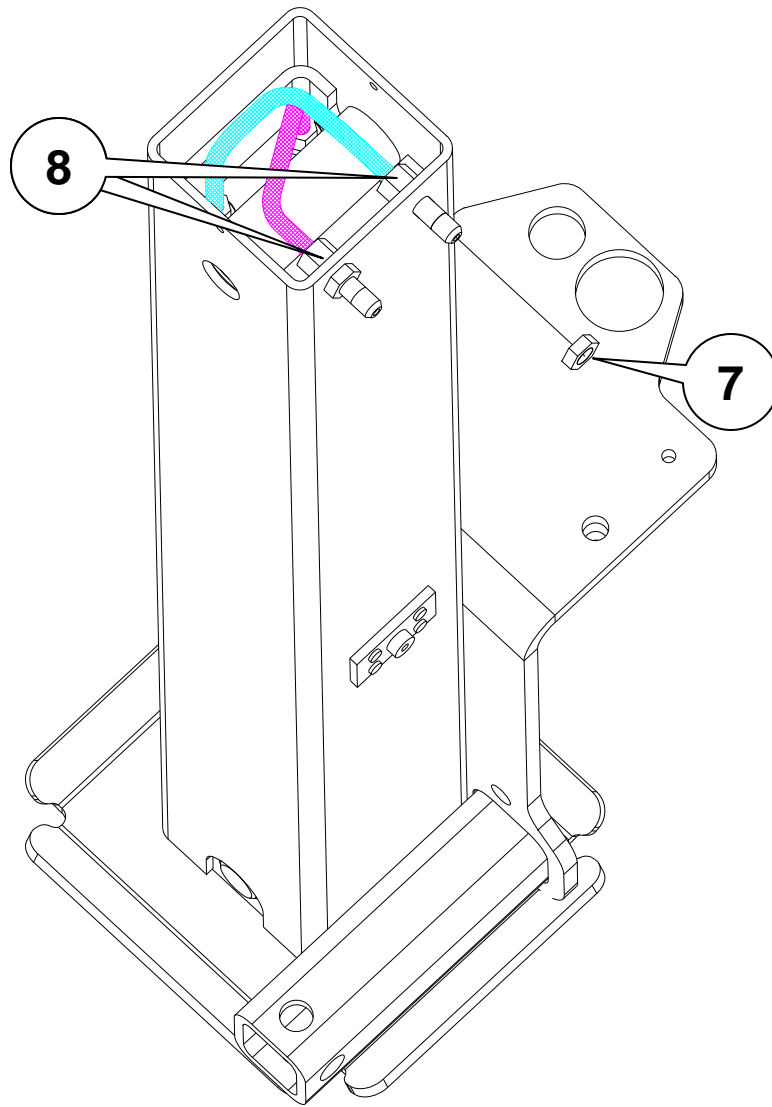


PROCEDURE: Replacement of Hydraulic Jack Tube (IK01 Only)

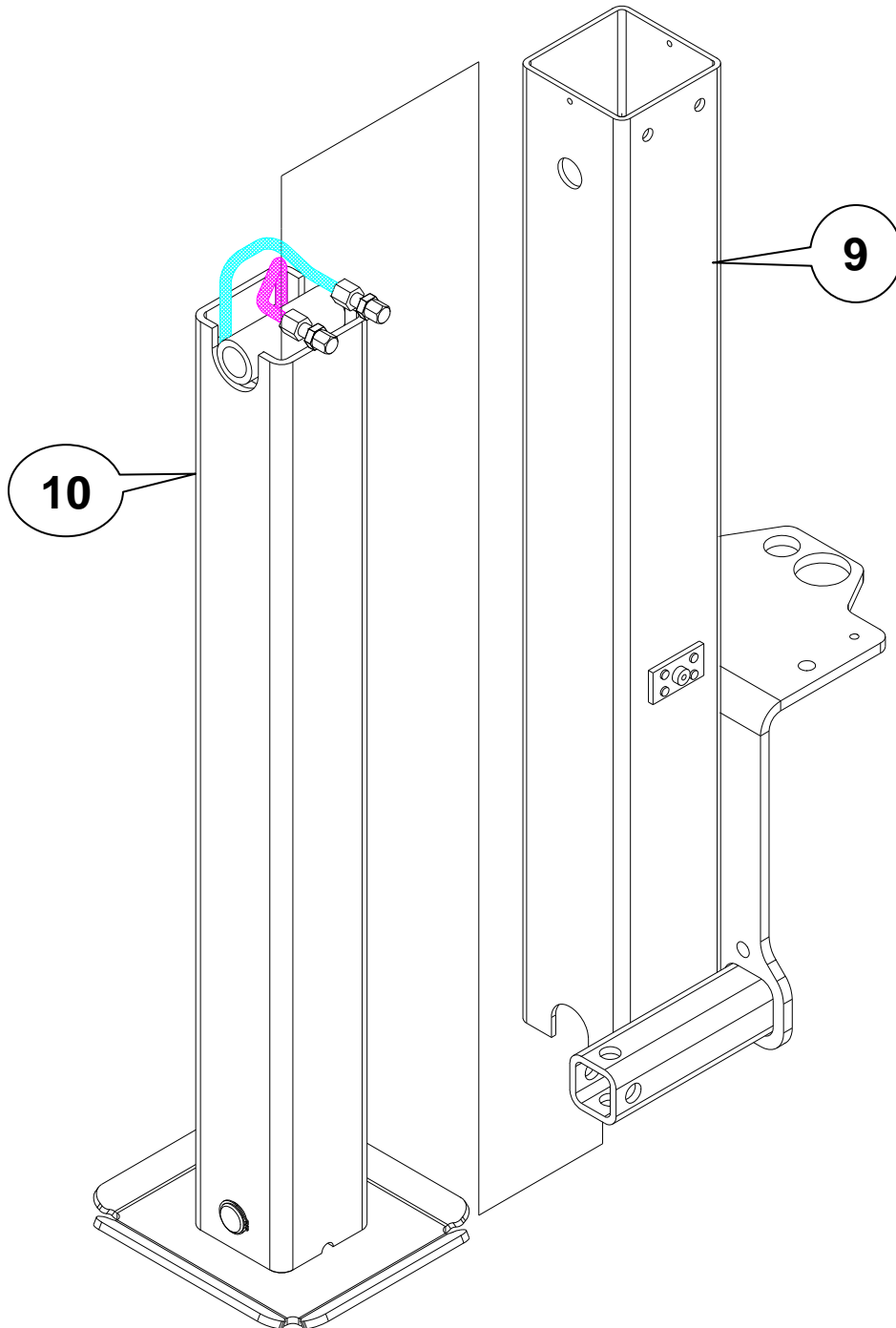
1. Remove and retain two screws (3) from hydraulic jack assembly, then remove cap (4).
2. Remove snap ring (5) and pin (6).



3. Remove jam nut **(7)** from each fitting **(8)**.
4. Pull each fitting **(8)** back through hydraulic jack tube, making note that the hoses cross each other as shown. Fittings will need to be reinstalled in the same way when reassembling.
5. Replace jam nuts **(7)** onto fittings, then cap fittings with caps 61664001.

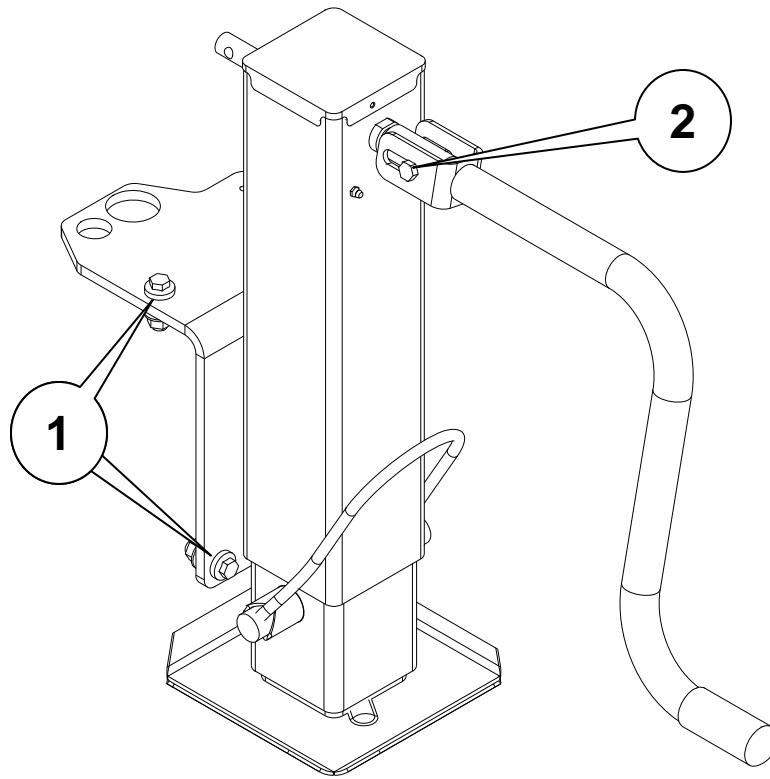


6. Remove and discard hydraulic jack tube **(9)** and retain inner jack tube assembly **(10)** for reassembly later.



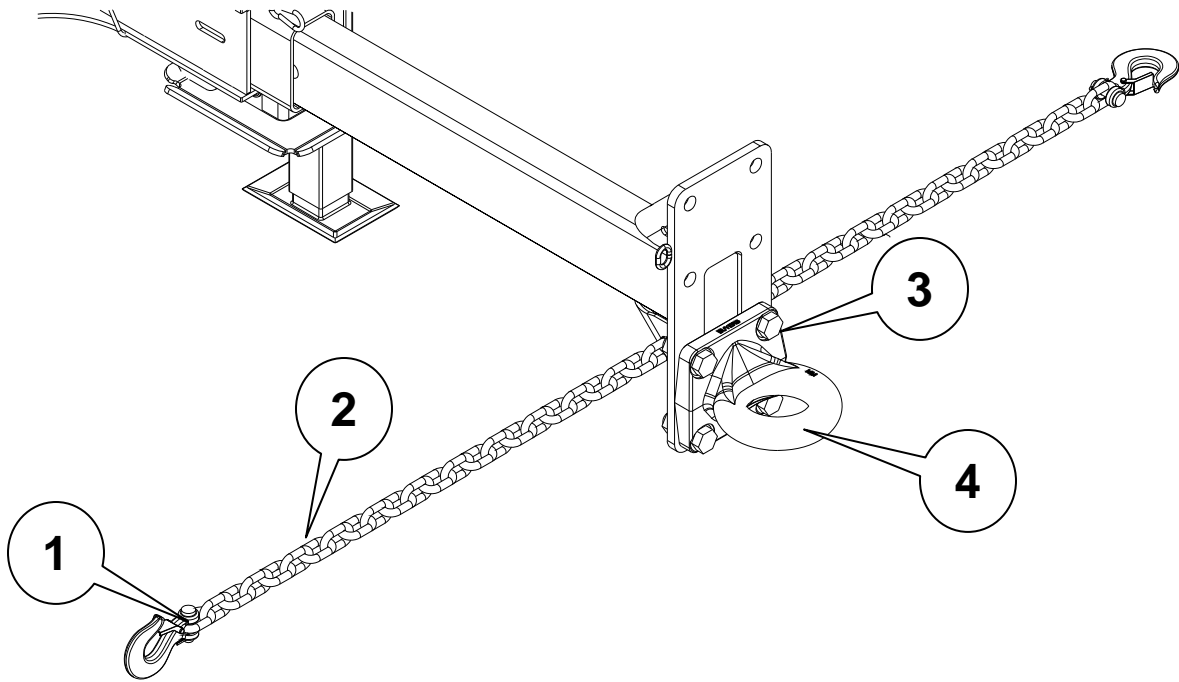
PROCEDURE: Removal of Manual Jack (IK02 Only)

1. Remove and retain four screws (1) and nuts from manual jack assembly. Also remove and retain hardware (2) and the handle for reuse.
2. Remove manual jack and discard. A new manual jack is included with IK02 and will be installed later.



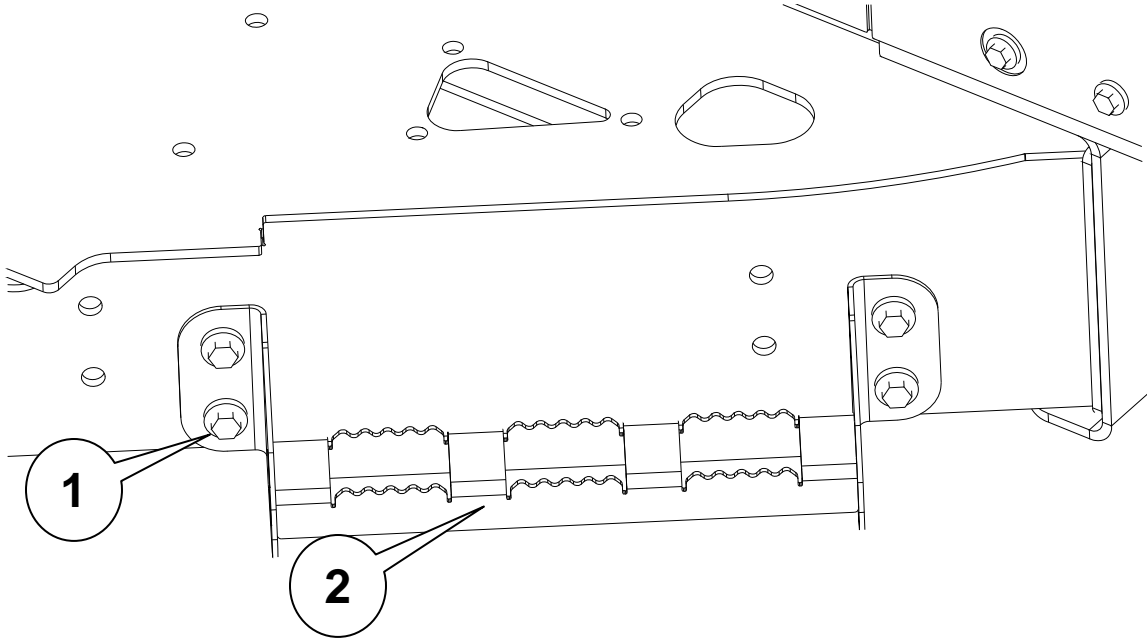
PROCEDURE: Removal of Hitch Ring

1. Remove cotter pin **(1)**, hook pin, and hook from safety chain. Remove safety chain assembly **(2)** from tongue. Discard cotter pin and retain all other parts.
2. Remove and discard hardware **(3)** from pintle ring **(4)**. Retain pintle ring **(4)**.



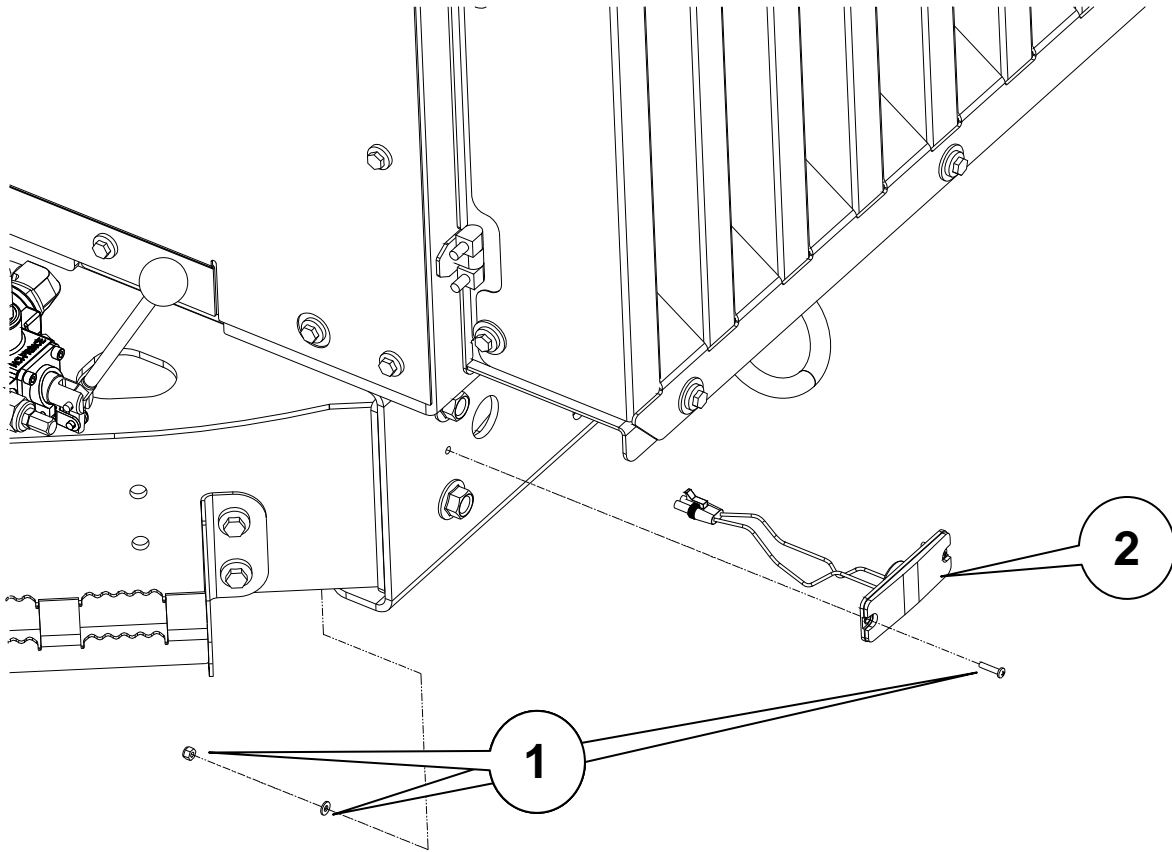
PROCEDURE: Removal of Step

1. Remove and retain hardware **(1)** and step assembly **(2)** from both sides of frame sub weldment.

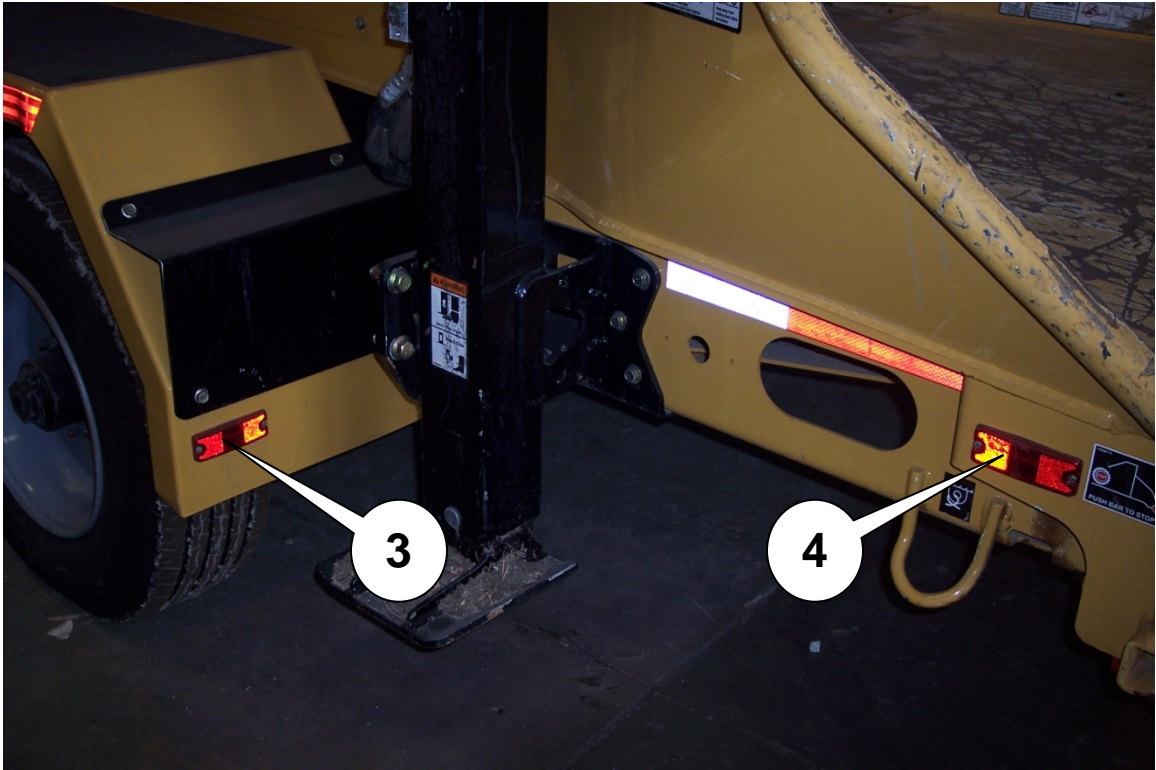


PROCEDURE: Removal of Side Markers and Removal of Light Harness from Frame

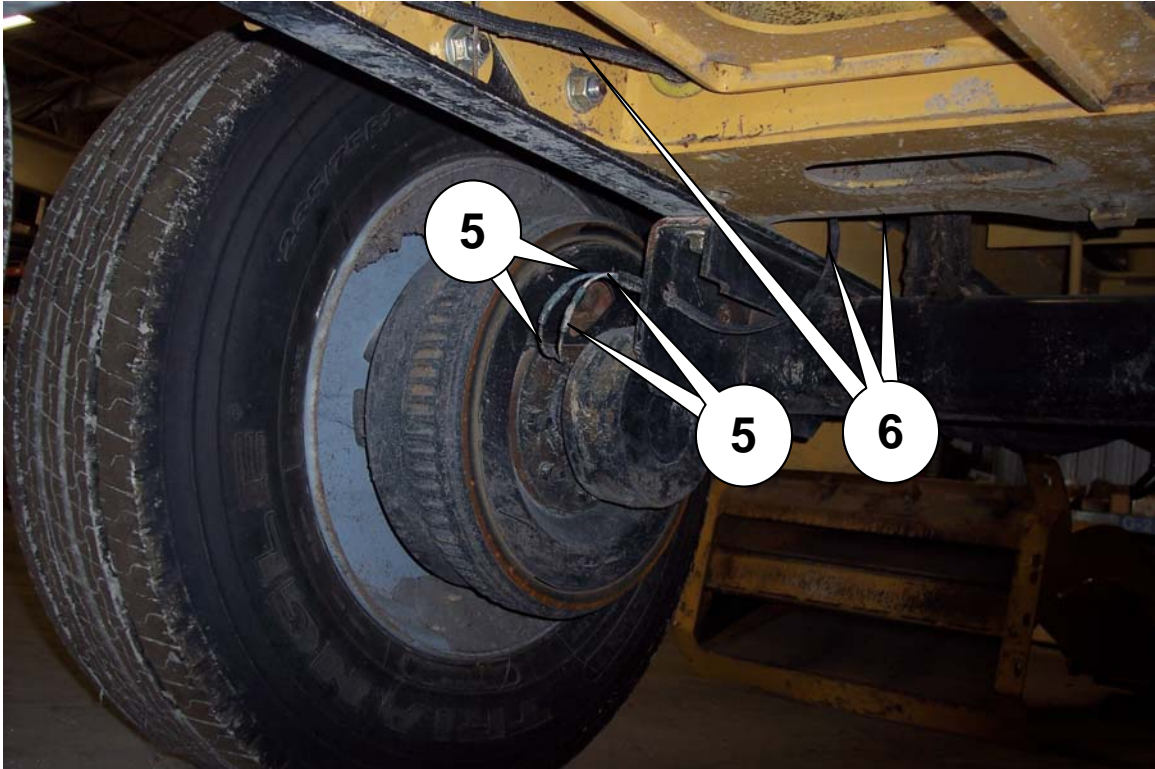
1. Remove and retain hardware **(1)** from yellow clearance LED light **(2)** at front of machine. Retain hardware and yellow clearance LED light. Repeat procedure on opposite side of machine.



2. Disconnect the left side only rear clearance (3) and rear side marker lights (4) from the light harness.



3. Cut the two wires **(5)** on the left side only of the rear axle on both sides of the connector as shown below, and discard connectors.
4. Repeat procedure for front axle on left side only.

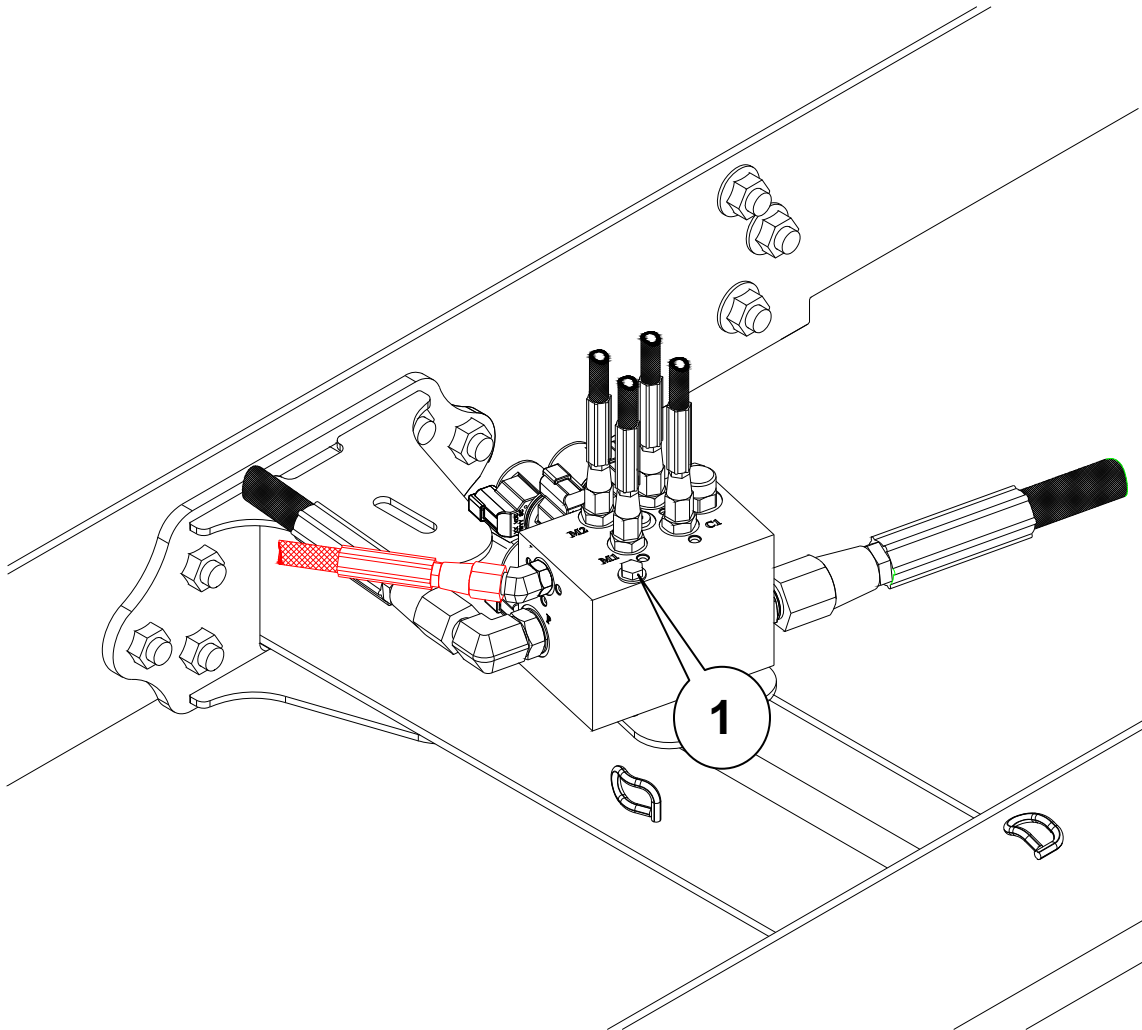


5. Clip all ny-ties and pull left side of light harness **(6)** forward out of main frame and front main frame sub.
6. Clip all ny-ties that secure right side of light harness to front main frame sub. **ONLY**. Do not cut brake wires or pull any harness from right side of frame.

PROCEDURE: Removal of Discharge Chute Valve – If Equipped

NOTE: The discharge chute valve is located behind the engine housing on the top of the frame sub weldment.

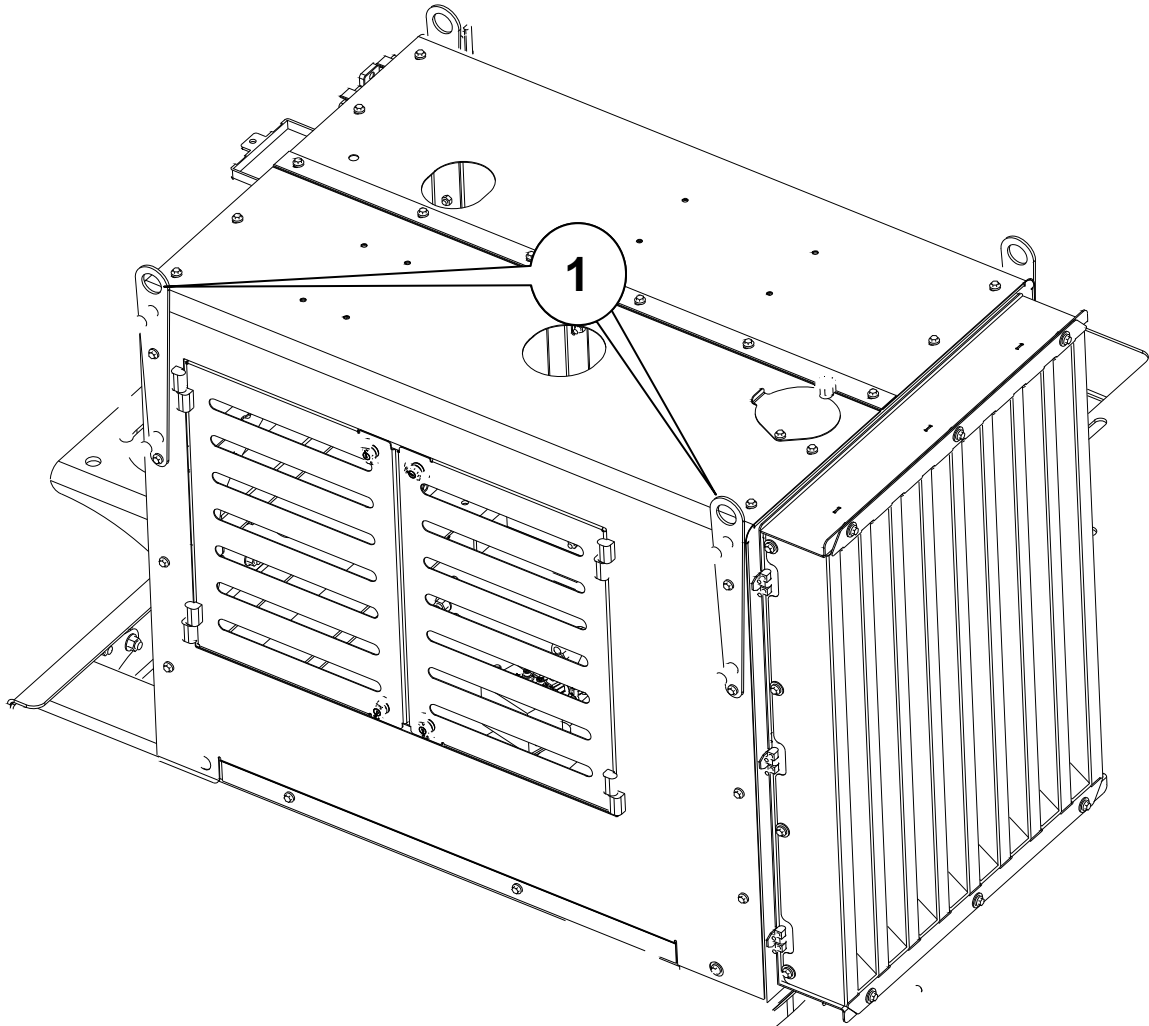
1. Remove and discard hardware **(1)** that attaches valve to frame.
2. Remove discharge chute valve from frame but leave attached to hoses.



PROCEDURE: Installation of Overhead Hoist

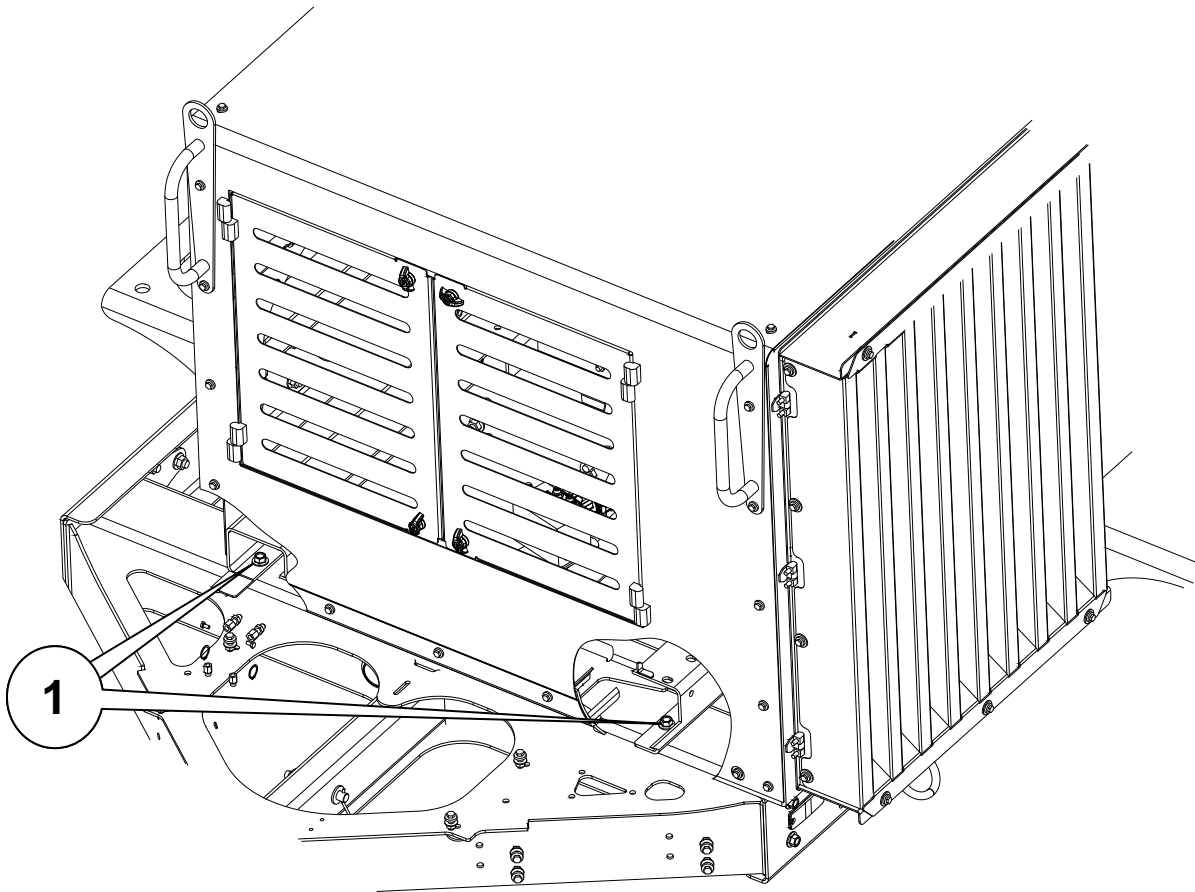
1. Attach overhead hoist lift chains with 5000 lb (2300 kg) lift capacity to lift points **(1)** on engine housing. Take up slack in chains.

Note: Front of engine assembly will only be supported by hoist while frame weldment sub is replaced. Do not raise engine assembly.



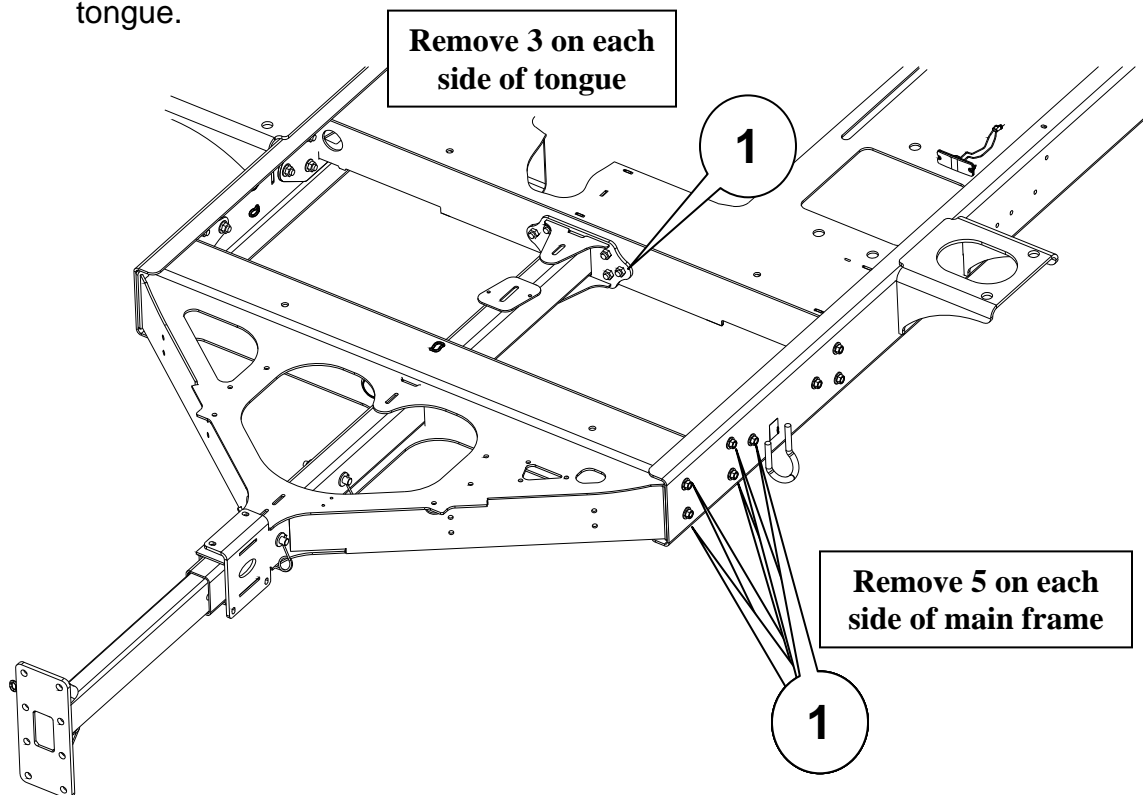
PROCEDURE: Removal of Engine Housing Screws

1. Remove and discard hardware **(1)** that attaches engine housing to main frame.
2. Use hoist to remove pressure off front main frame sub weldment.



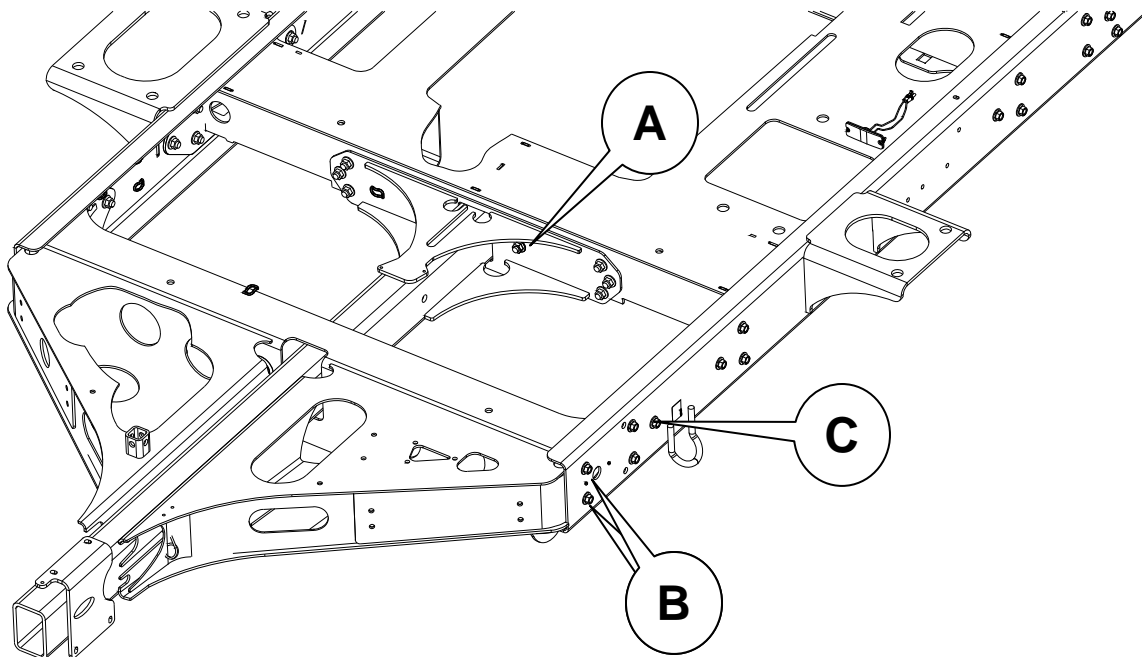
PROCEDURE: Removing the Front Main Frame Sub Weldment and Tongue

1. Ensure floor jacks (or blocking) are properly positioned and supporting each side of frame side rails.
2. Place floor jack under center of frame sub weldment for support while removing hardware.
3. Remove and discard 16 side and center screws and nuts **(1)** that attach the front main frame sub to frame.
4. Ensure all electrical harness and hose ny-ties have been cut and removed from frame sub weldment.
5. Slide forward and remove and discard front main frame sub weldment and tongue.



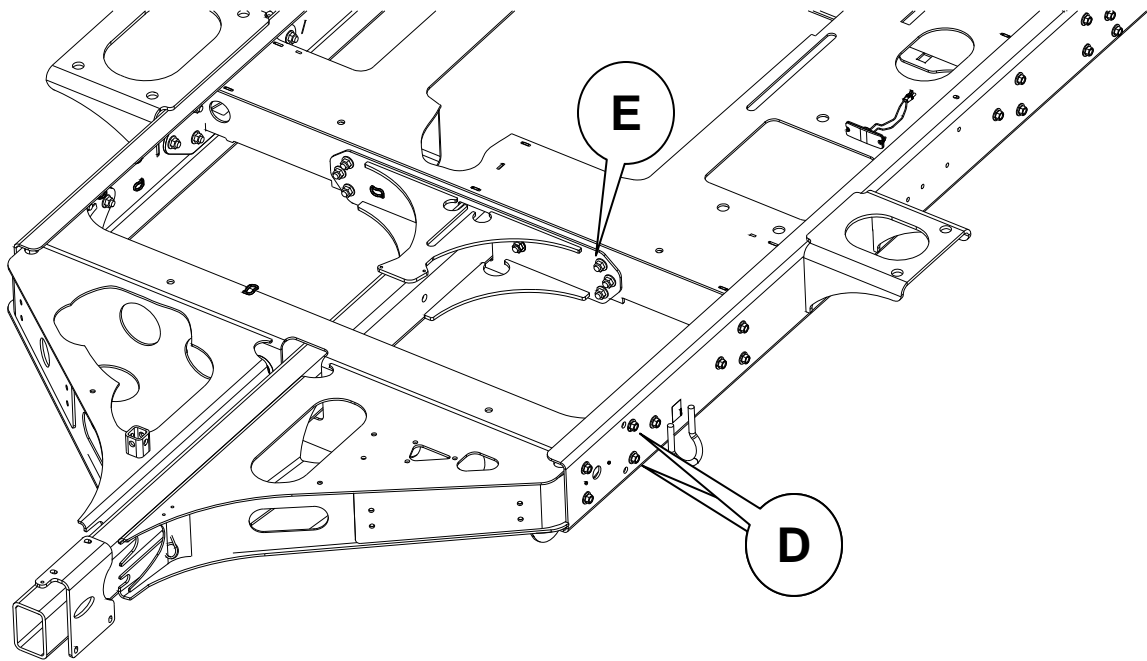
PROCEDURE: Installation of New Front Main Frame Sub

1. Place center of new front main frame sub weldment (PN 180016813) onto floor jack. Raise and align new frame and slide into main frame.
2. Line up new front main frame sub weldment by installing one screw (PN 507614035) and one nut (PN 507085016) in each hole closest to tongue as shown at location **(A)**. Snug hardware but do not tighten.
3. Next, install two screws (PN 507614035) and two nuts (PN 507085016) in two holes on each side of main frame as shown at location **(B)**. Snug hardware but do not tighten.
4. Next, install one screw (PN 507614035) and one nut (PN 507085016) in one hole on each side of main frame as shown at location **(C)**. Snug hardware but do not tighten.



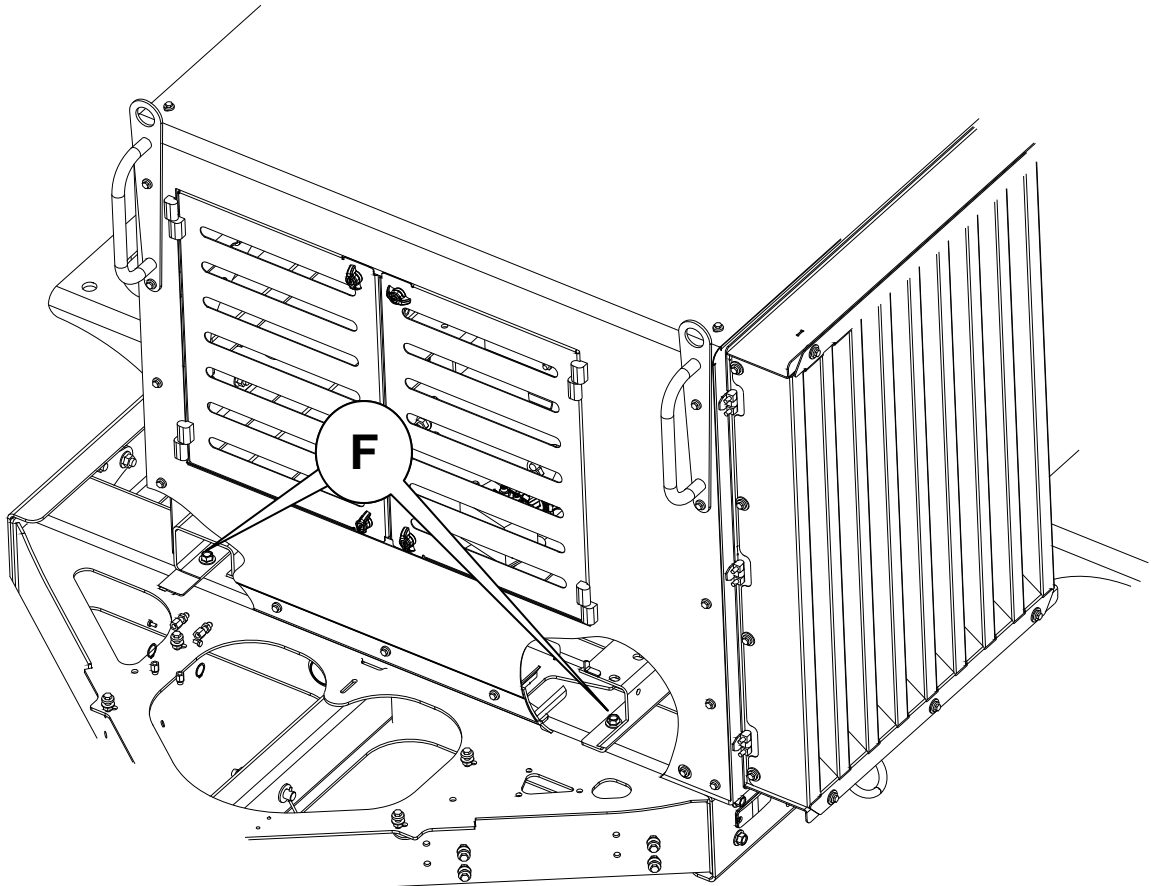
NOTE: The remaining screws and nuts on each side need to have new holes drilled into the main frame to accommodate the hardware locations on the new front main frame sub weldment.

5. Using the new main frame sub weldment as a template, drill two 11/16 inch (17 mm) holes on each side of the main frame as shown at location **(D)**.
6. Using the center tongue section of the new main frame sub weldment as a template, drill three 11/16 inch (17 mm) holes on each side of tongue as shown at location **(E)**.



7. Install 5 new screws (PN 507614035) and nuts (PN 507085016) on each side of main frame and tongue at locations **(D)** and **(E)**, where the new holes were drilled. Torque all 18 screws listed in this section to 195 ft-lb (264 Nm).

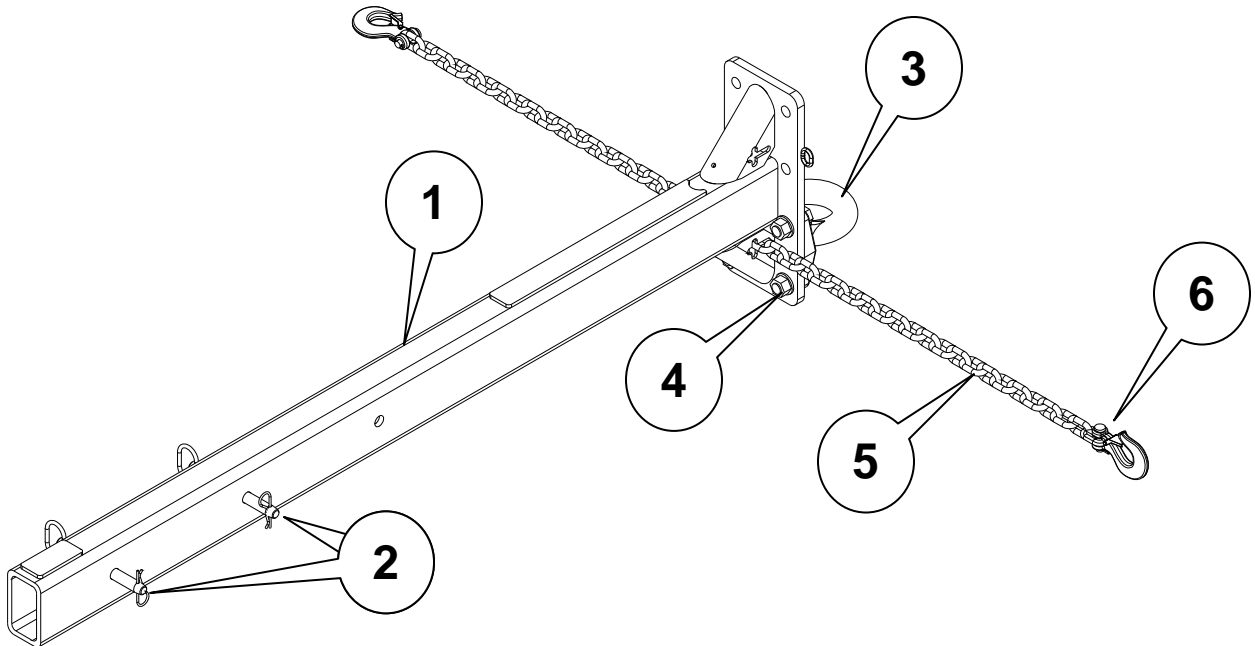
8. Install two new front engine mounting screws (**F**) (PN 507164035) and nuts (PN 507085016) and torque to 195 ft-lb (264 Nm).



9. Remove chain hoist from engine assembly.

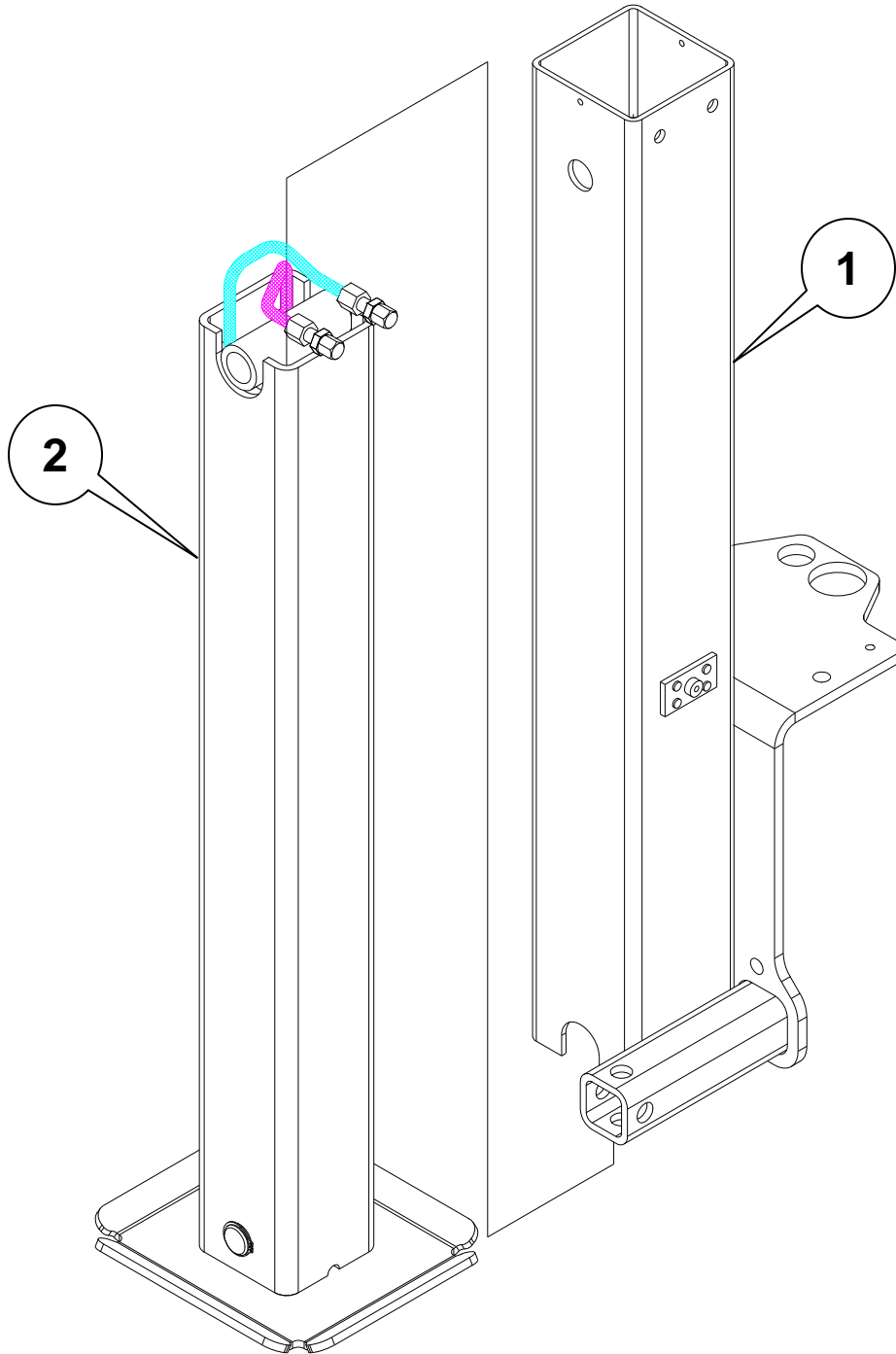
PROCEDURE: Installation of Inner Tongue and Hitch

1. Insert new inner tongue weldment (PN 180016835) **(1)** into new main frame sub.
2. Install two hitch pins (PN 2107007) **(2)** to achieve desired tongue position (i.e., retracted or extended).
3. Install retained pintle ring **(3)** onto inner tongue (at same location as on old tongue) using four new screws (PN 243921001) **(4)** and new washers (PN 295016001). Torque screws to 300 ft-lb (407 Nm).
4. Install safety chain assembly **(5)** into new inner tongue. Re-assemble hook, hook pin and new cotter pin **(6)** (PN 510049) onto end of safety chain.

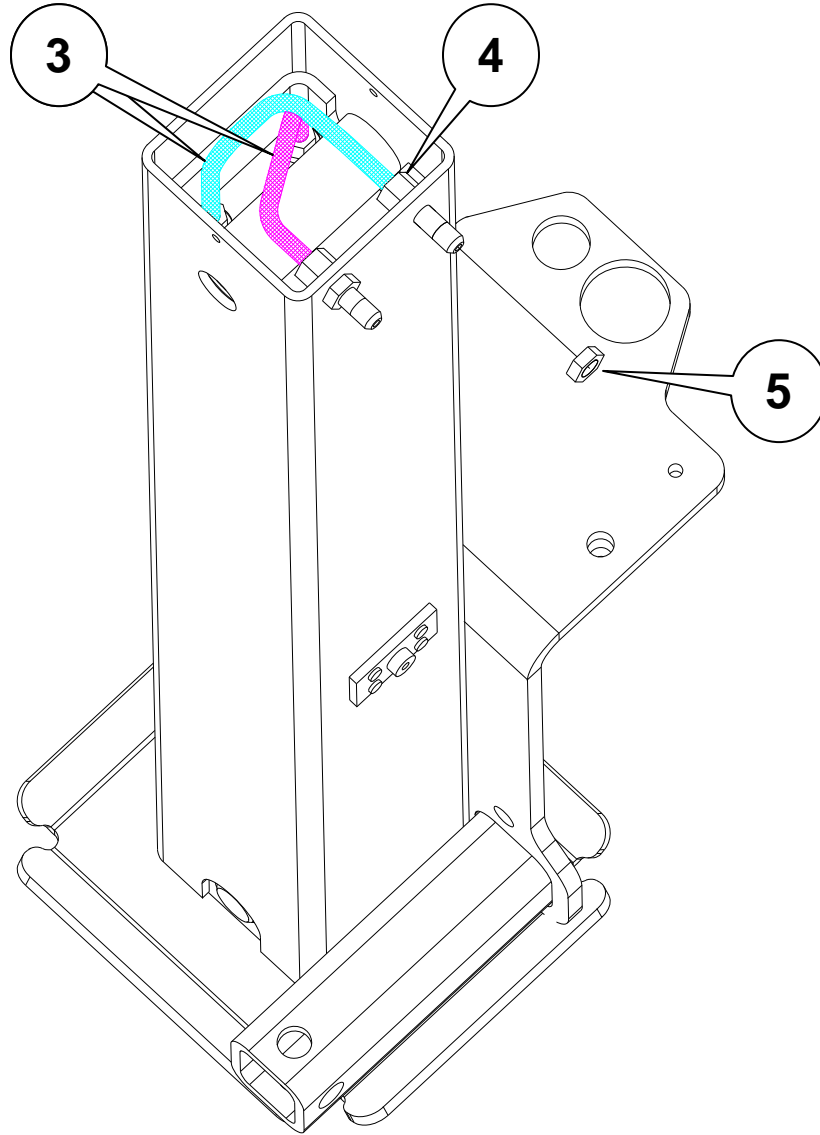


PROCEDURE: Assembly of Hydraulic Jack (IK01 Only)

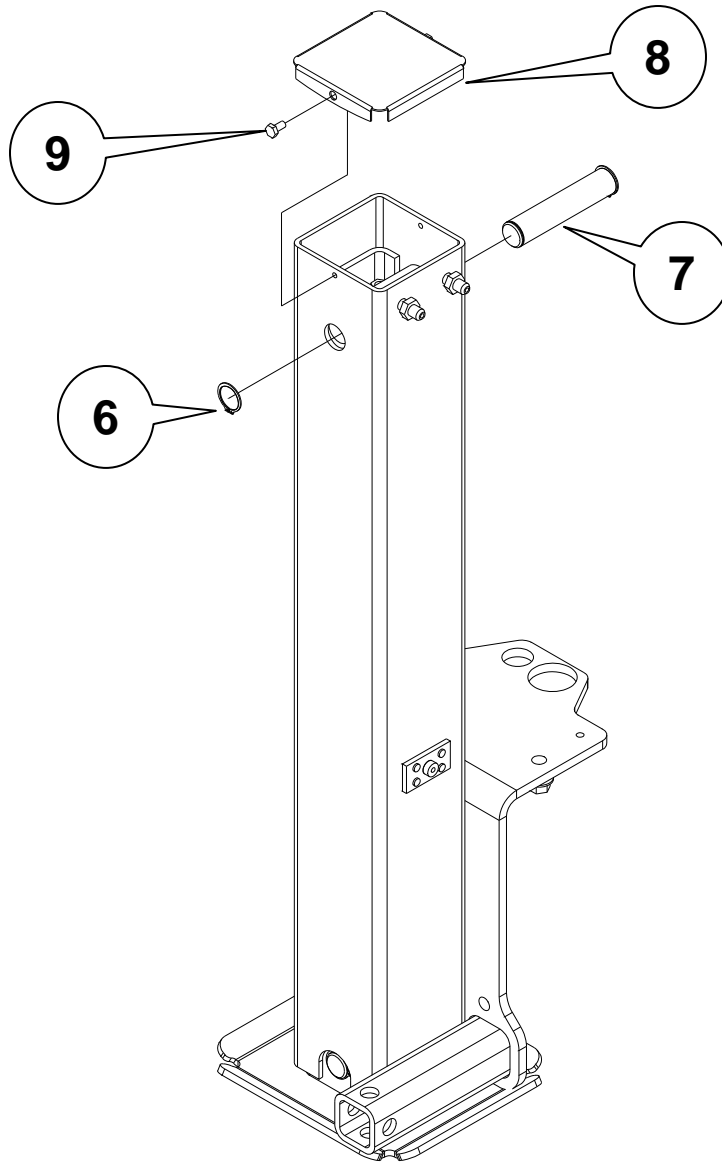
1. Place new hydraulic jack tube (PN 180016843) **(1)** over retained inner jack tube **(2)** to create hydraulic jack assembly.



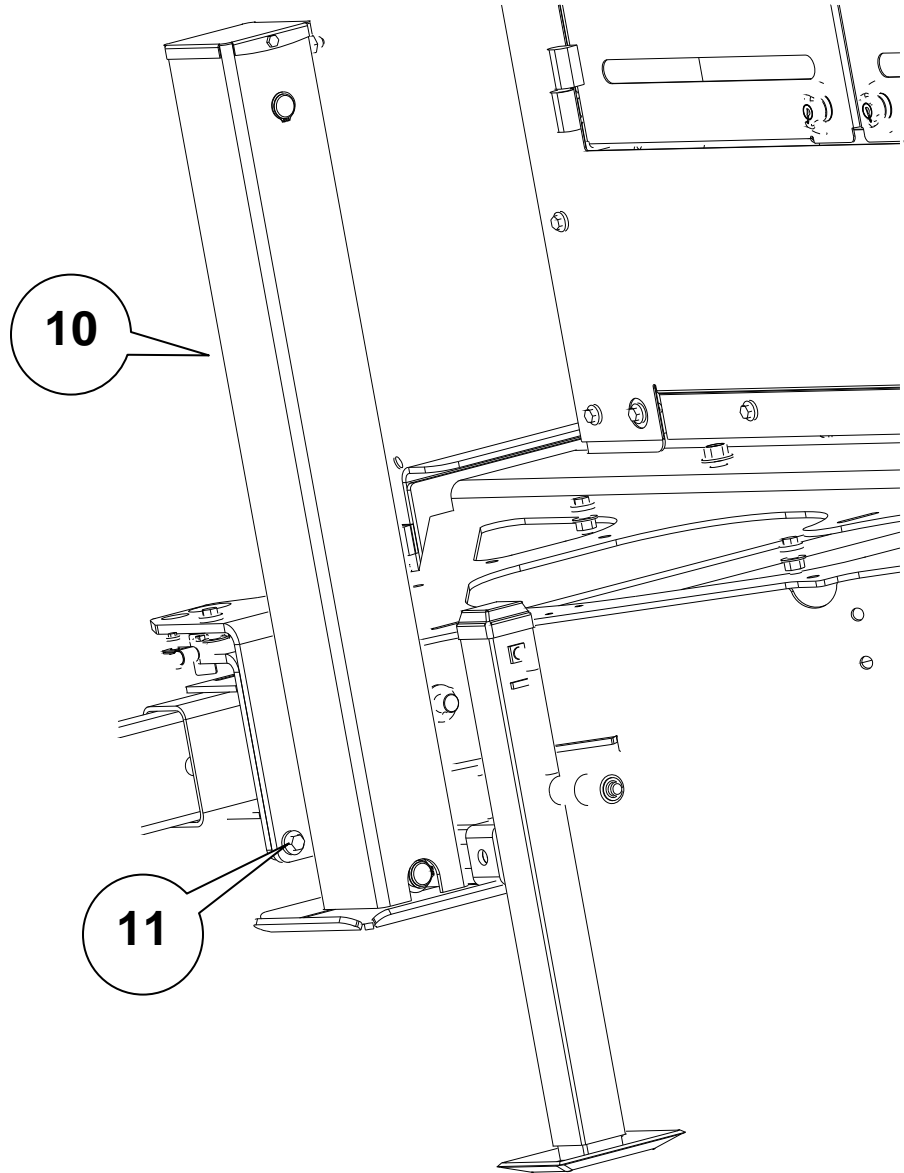
2. Cross hose **(3)** as shown and install fittings **(4)** into new jack tube.
3. Install retained jam nuts **(5)** on fittings and reinstall caps.



4. Install retained pin (7) and snap ring (6).
5. Install retained cap (8) using retained hardware (9).

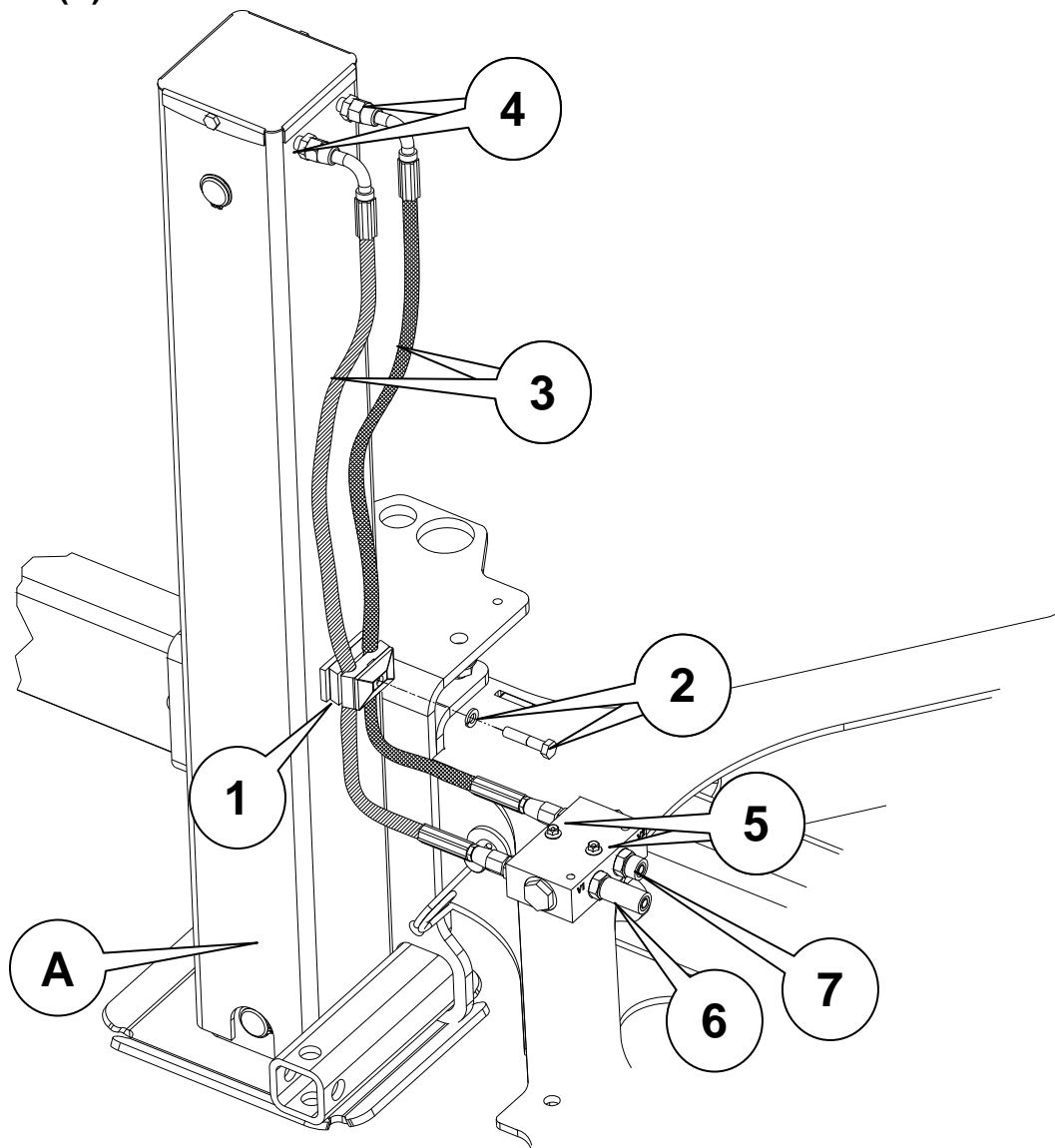


6. Attach hydraulic jack assembly **(10)** to new main frame sub weldment using four screws and nuts **(11)** retained previously.
7. Torque screws to 83 ft-lb (113 Nm).



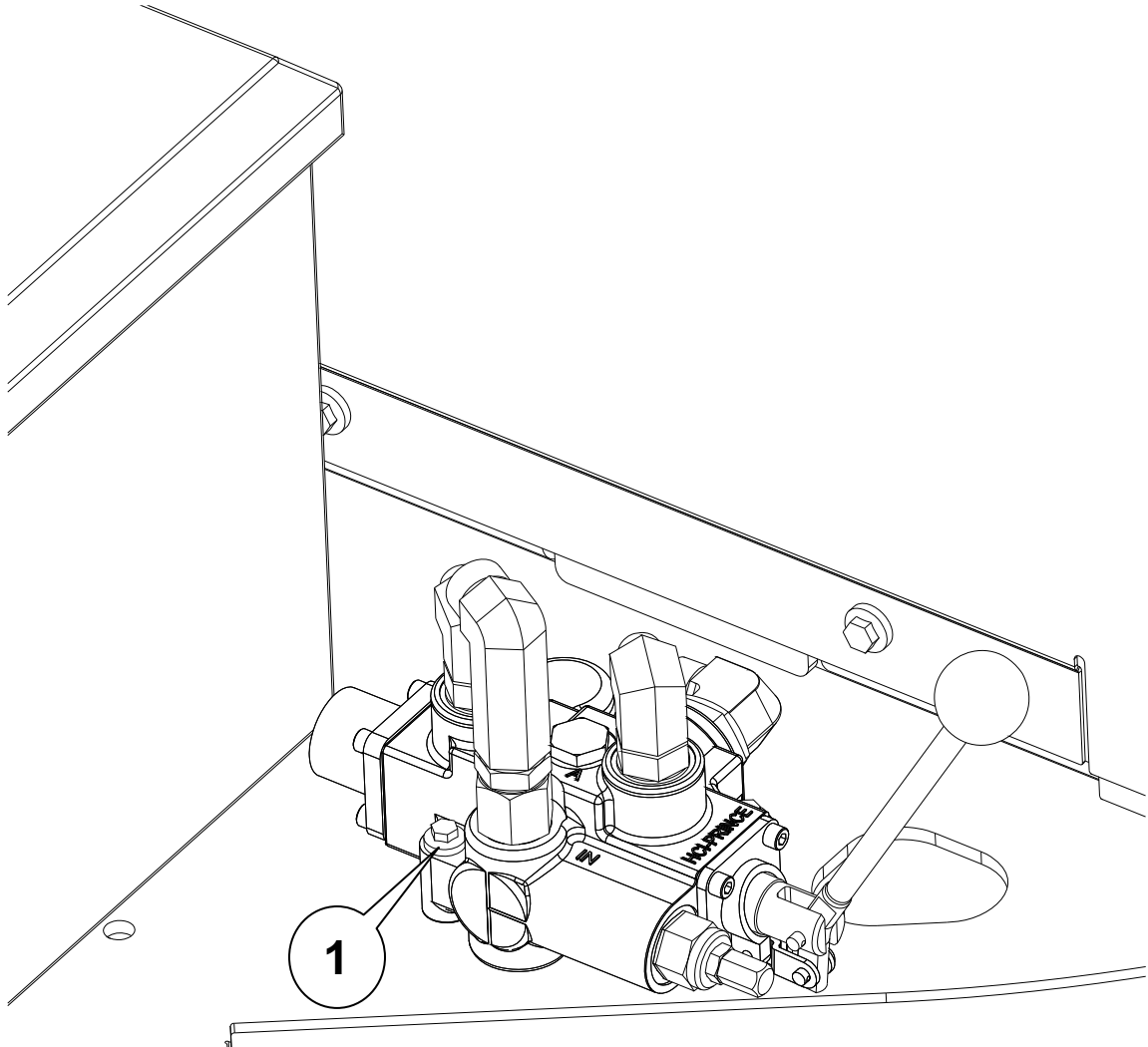
PROCEDURE: Installation of Hosing and Jack Lock Valve (IK01 Only)

1. Install retained jack lock valve using retained hardware **(5)**.
2. Connect jack lock valve hoses **(3)** to fittings **(4)** at top of hydraulic jack assembly.
3. Route hoses through hose clamp assembly **(1)** and install retained hardware **(2)**.
4. Install fitting **(6)** (PN 72442001) and fitting **(7)** (PN 83328001).
5. Install new decal (PN 7000B853) onto hydraulic jack assembly at location **(A)**.

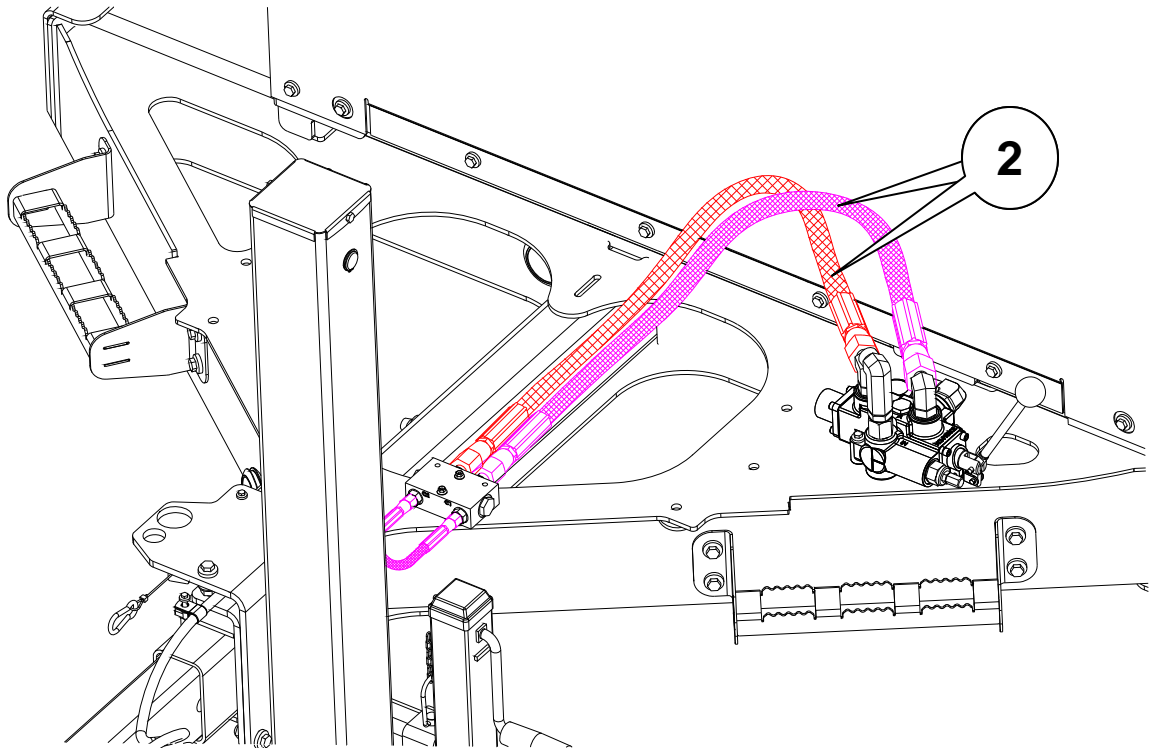


PROCEDURE: Installation of Jack Lift Valve (IK01 Only)

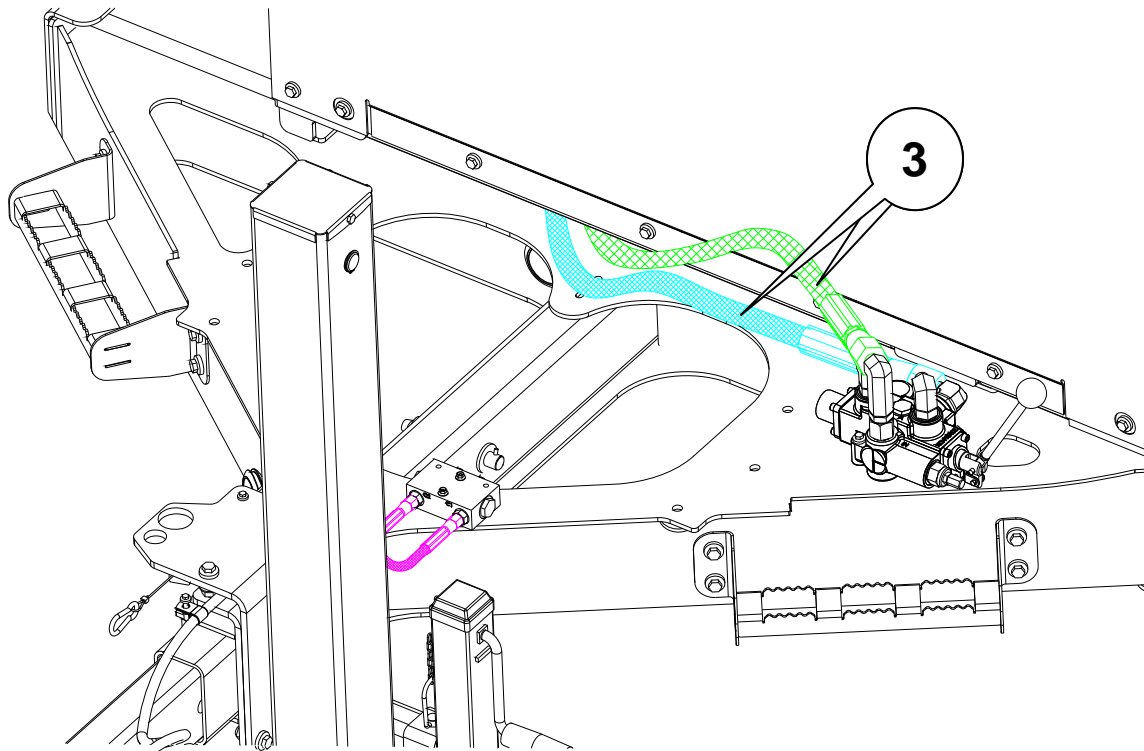
1. Install retained jack lift valve using retained hardware **(1)**.



2. Install two new hoses (PN 163661325) **(2)** that connect the jack lift valve to the jack lock valve. Route hoses as shown.

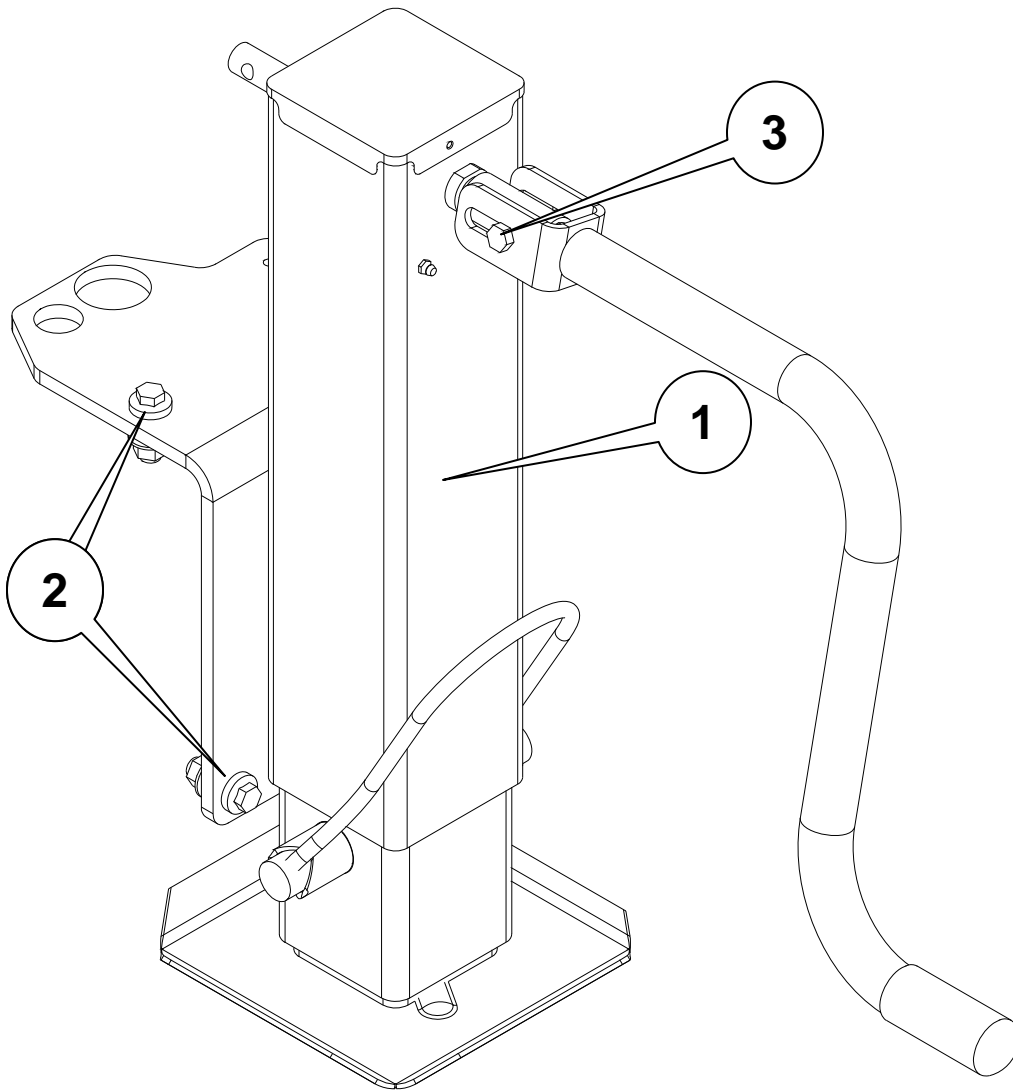


3. Note labeling and connect two retained hoses (3) to jack lift valve.



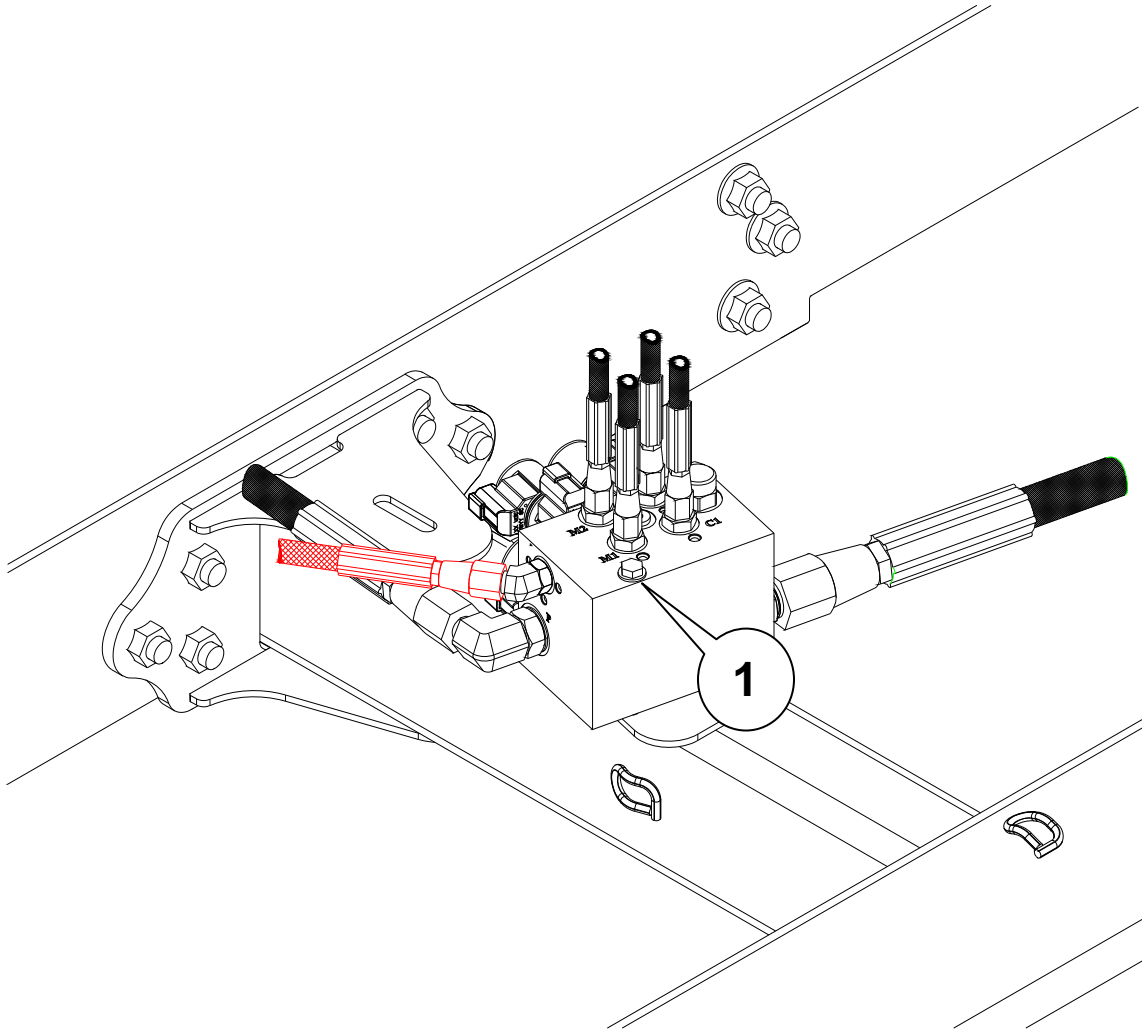
PROCEDURE: Installation of Manual Jack (IK02 Only)

1. Install new manual jack (PN 163642032) **(1)** using retained screws **(2)** and nuts.
2. Torque hardware to 83 ft-lb (113 Nm).
3. Reinstall retained handle and hardware **(3)**.



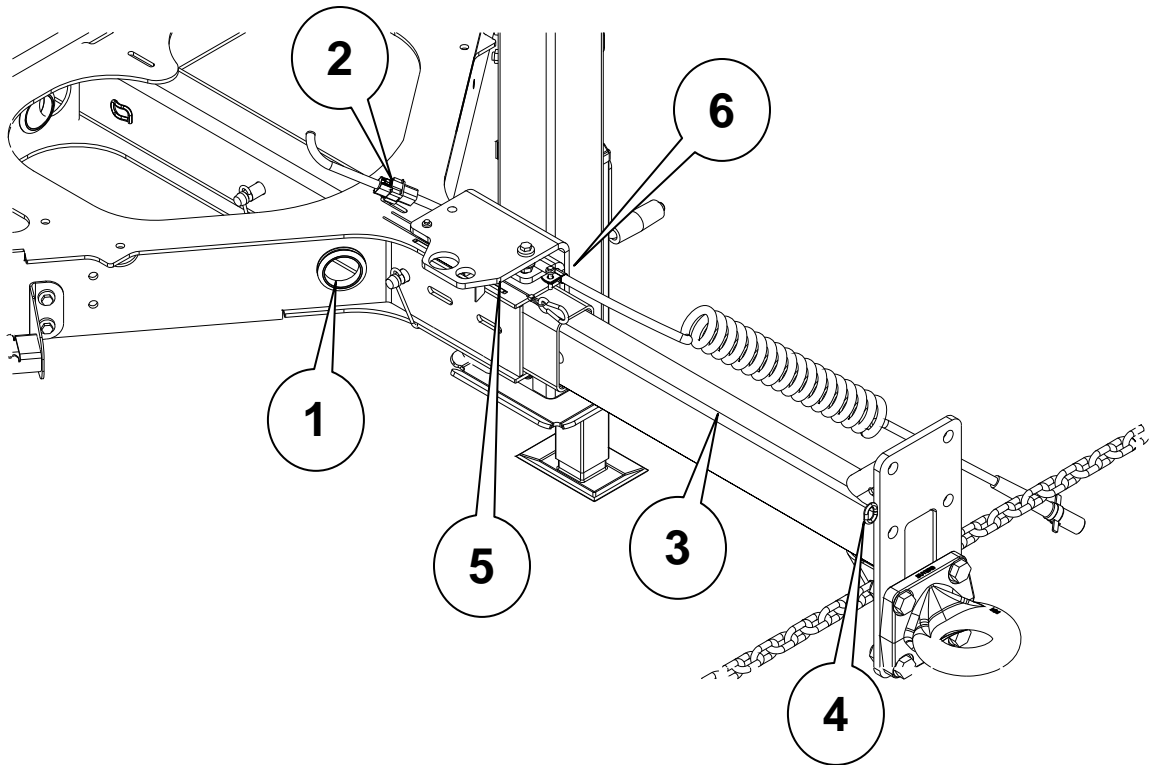
PROCEDURE: Installation of Discharge Chute Lock Valve

1. Install retained discharge chute lock valve onto new sub weldment using two new screws (PN 351044) **(1)**.



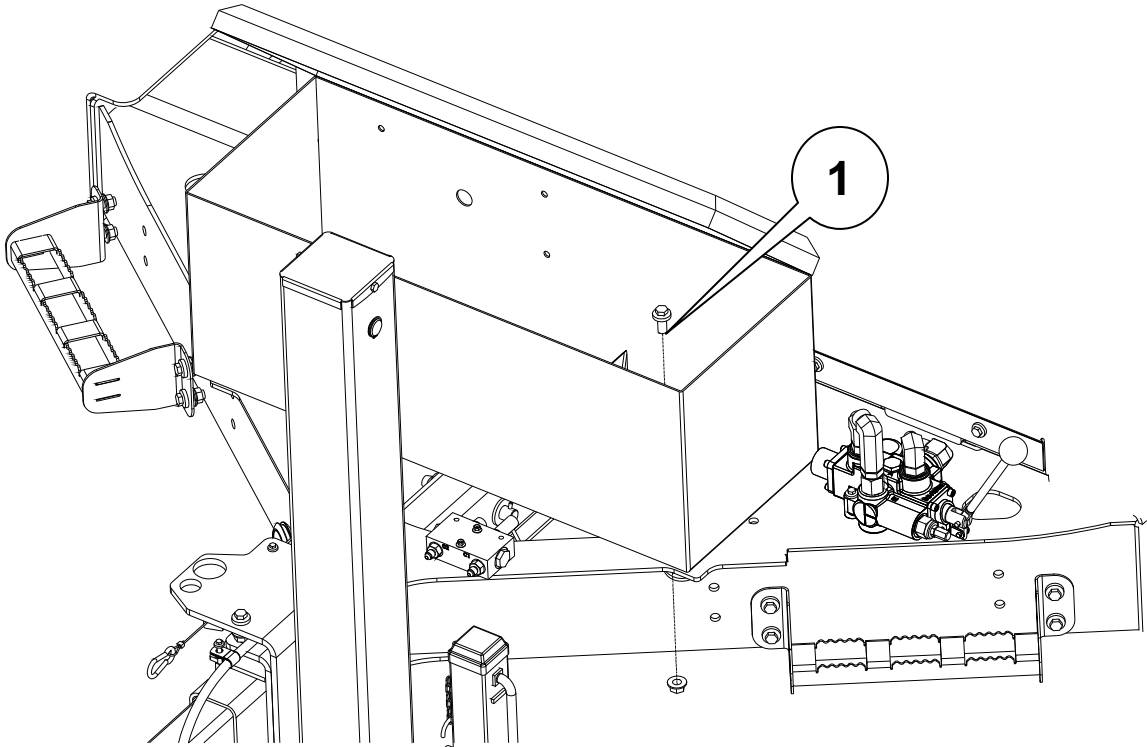
PROCEDURE: Installation of Trailer Harness

1. Install grommet **(1)** (PN1865001) on each side of new main frame sub weldment.
2. Route harness through new main frame sub weldment using ny-tyies (PN 59634001). Retrace the original routing used on old main frame sub weldment.
3. Connect light harness **(2)** to connector.
4. Install retained screw and P-clip **(6)**.
5. Route breakaway cable **(3)** through loop **(4)** and install tab into breakaway switch **(5)**



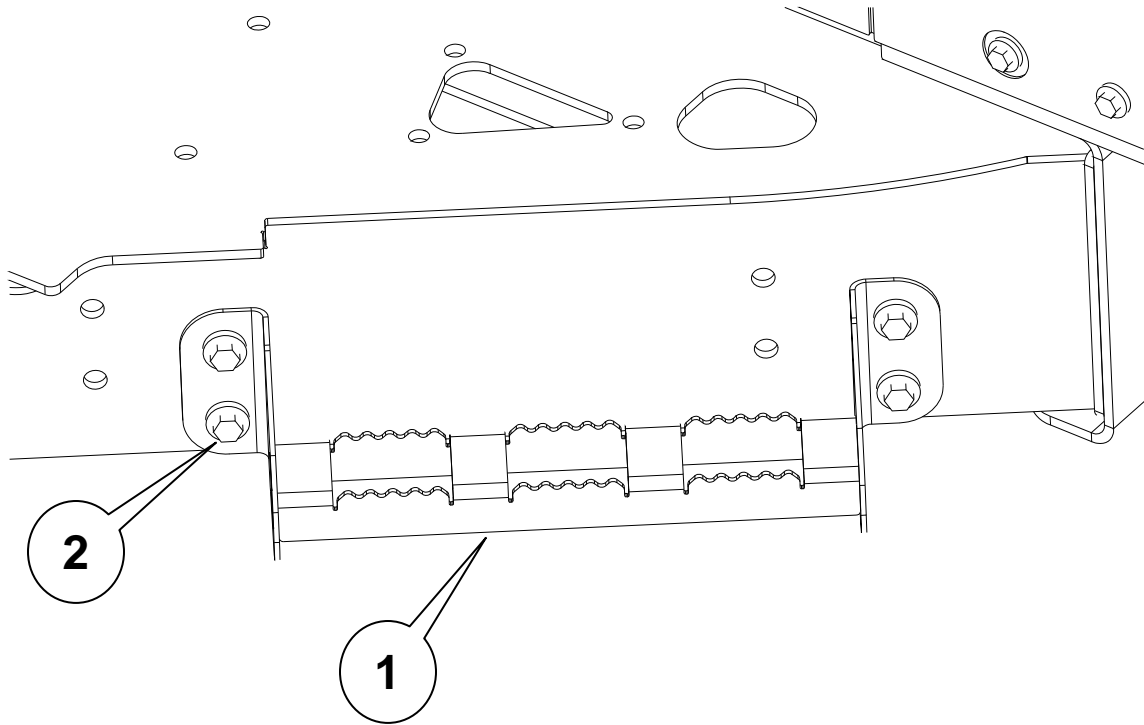
PROCEDURE: Installation of Toolbox

1. Install retained toolbox onto new front main frame sub weldment using retained hardware **(1)**.



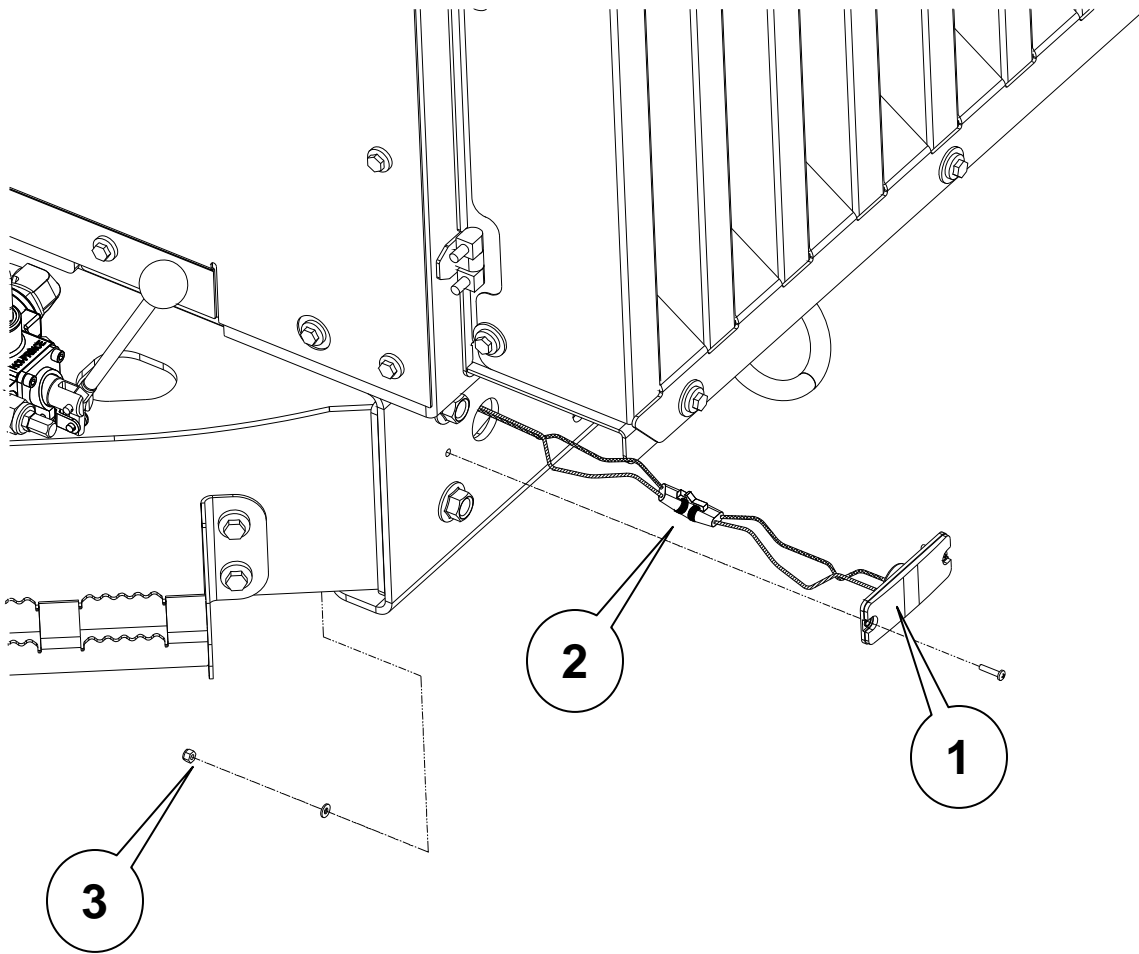
PROCEDURE: Installation of Steps

1. Install retained steps **(1)** to both sides of new frame sub weldment using retained screws and nuts **(2)**.



PROCEDURE: Installation of Light harness and Connection of Side Markers

1. Route wire harness connectors through frame and connect retained yellow clearance LED light **(1)** to wire assembly **(2)**. Use ny-ties (PN 5963400) to secure harness to underside of frame.
2. Connect light to machine using retained hardware **(3)**.
3. Repeat for other side.

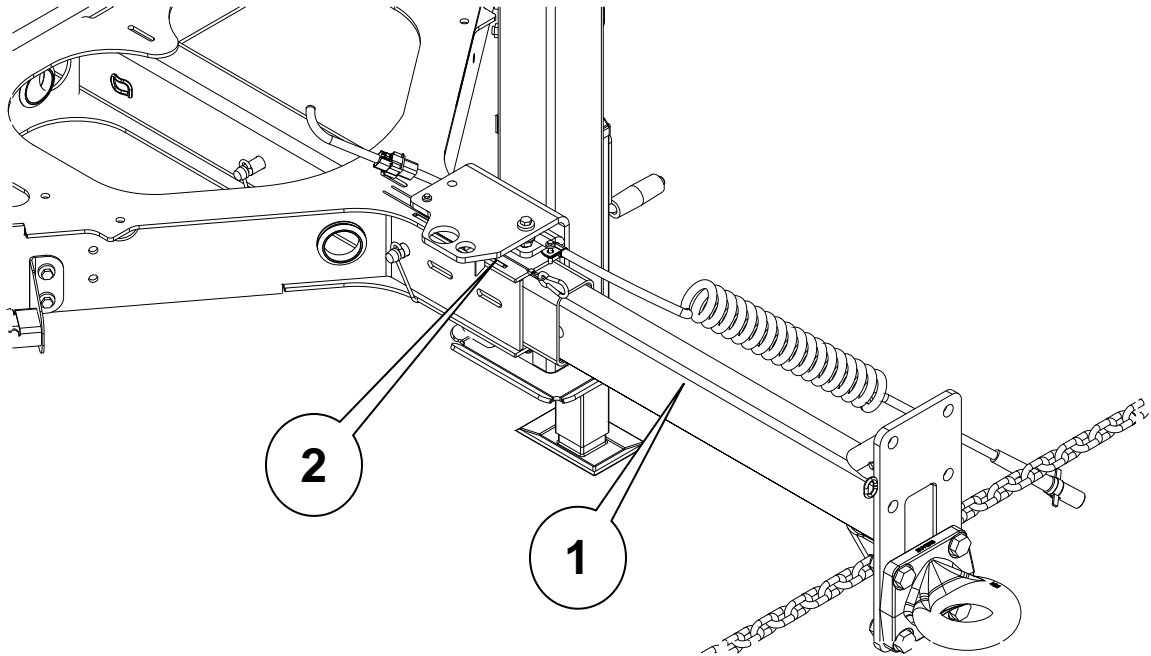


4. Strip wires that were previously cut, and install new crimp connectors (4) (PN 69153001) on all four brake wires (left side) .
5. Use a heat gun to seal the ends of the crimp connector.



PROCEDURE: Final Machine Checks

1. Reconnect battery cables, start engine and check operation of hydraulic functions to ensure controls work correctly and no leaks exist.
2. Check that breakaway cable **(1)** applies brakes on all four wheels when tab is pulled from breakaway switch **(2)**



3. Check that highway lights are functioning properly.
4. Remove frame jack stands (or blocking) and wheel chocks.
5. Remove Figures 1 – 5 and provide to unit owner to place with existing Parts Manual. The delivery of these pages to the unit owner can be accomplished by attaching the pages to the customer's copy of the Invoice or placing the pages in the unit's manual storage box.

FIGURE 1

[IK01 Only]

UNIT OWNER COPY: Insert in Parts Manual for future reference.

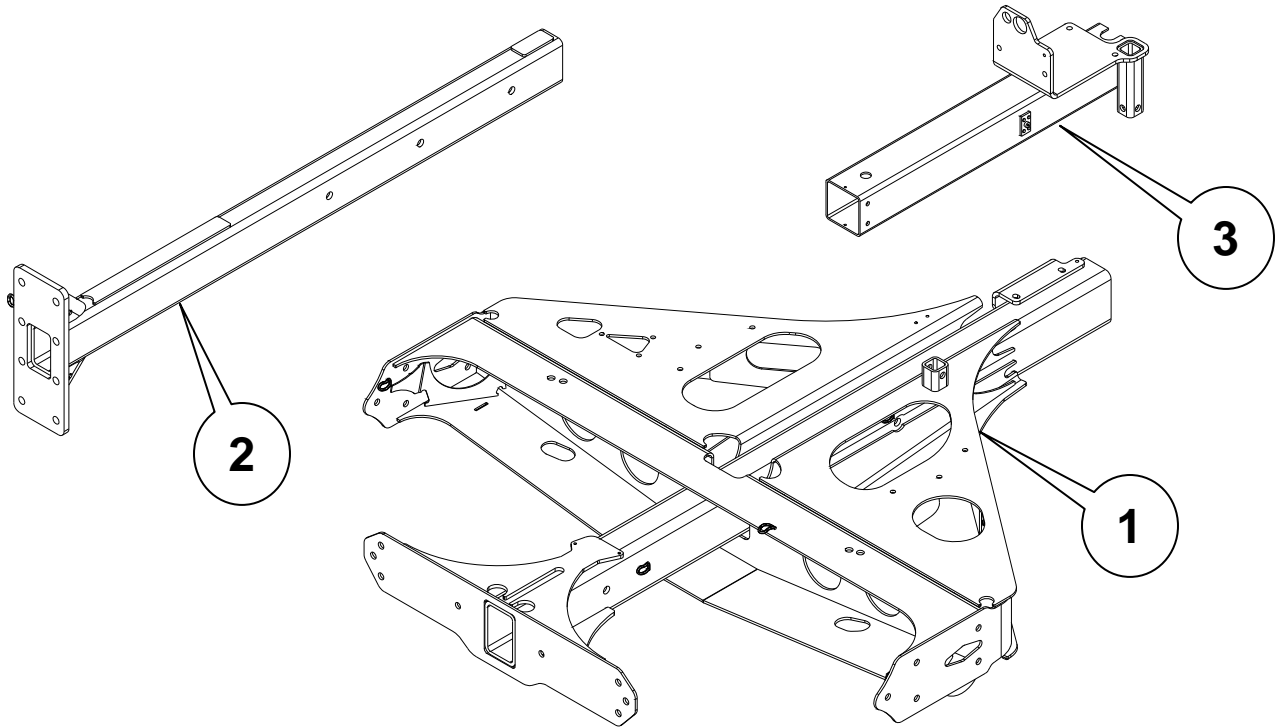


FIGURE 1			
REF. NO.	PART NO.	DESCRIPTION	QTY.
1	180016813	Weldment – Main Frame Front Sub	1
2	180016835	Tongue – Inner 5 x 3 Weldment BC2100XL	1
3	180016843	Tongue – Hydraulic Jack	1
	IK01-1667	Includes Items 1 – 3	

FIGURE 2
[IK01 Only]

UNIT OWNER COPY: Insert in Parts Manual for future reference.

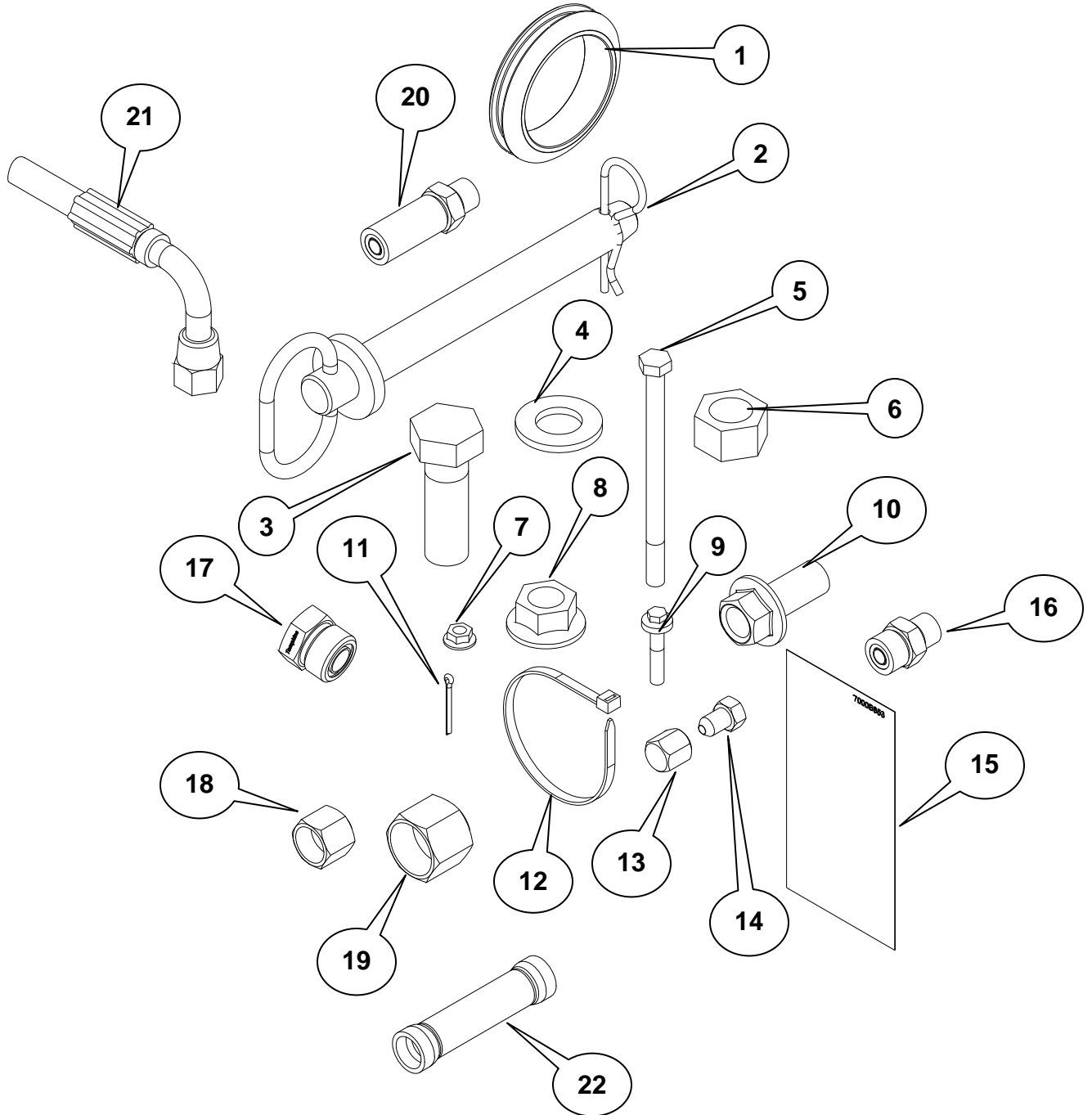


FIGURE 2			
REF. NO.	PART NO.	DESCRIPTION	QTY.
1	1865001	GROMMET – ¼ X 2 ½	2
2	2107007	PIN-HITCH ¾ X 6	2
3	243921001	SCREW-HCS - .75 – 10X2.25 GR8 YZ	4
4	295016001	WASHER-FLAT SAE .75 - .81 X 1.50 – 14- YZ	4
5	351044	BOLT – 5/16 – 18 X 4 ½ GR 5 HEX HD	2
6	397001	NUT-3/4-10 GR I SLTL	4
7	507085006	NUT-HEXFLNG LOCK, M6-1.00, 10.9, YZ, D6927	2
8	507085016	NUT-HEXFLNG LOCK, M16-2.00, 10.9, YZ, D6927	20
9	507610030	SCREW-HFS, M6-1.00X30, 10.9, YZ, D6921, PT	2
10	507614035	SCREW-HFS, M16-2.00X35, 10.9, YZ, ANSI, B18.2.3.9M, FT	20
11	510049	PIN-3/32X1 COTTER	1
12	59634001	SINGLE NYTIE – 8"	20
13	61664001	CAP NUT-#4 JIC	2
14	66330001	PLUG-4 JIC MALE	2
15	7000B853	DECAL-WARNING OUTRIGGER	1
16	72442001	FITTING-STR-6MORFF – 6MORB	1
17	83322001	PLUG-10MORS	2
18	83328001	FITTING – CAP – 6FSORFF	4
19	83330001	CAP-10FORS	2
20	100369001	FITTING – 6FF5OLO STRAIGHT LONG	1
21	163661325	HOSE-1/4X30-4FS JIC-ST/90-3000 PSI SLEEVED	2
	IK01-1667	INCLUDES ITEMS 1 - 21	

FIGURE 3
[IK02 Only]

UNIT OWNER COPY: Insert in Parts Manual for future reference.

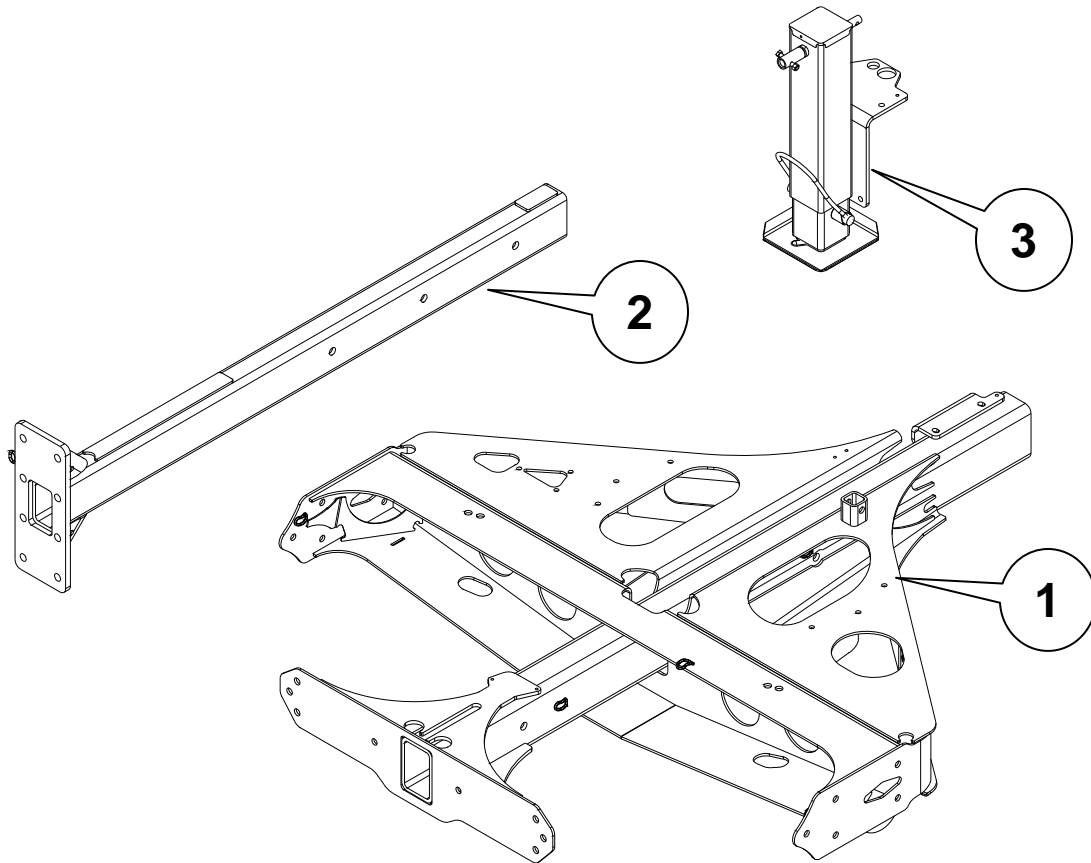


FIGURE 3			
REF. NO.	PART NO.	DESCRIPTION	QTY.
1	180016813	Weldment – Main Frame Front Sub	1
2	180016835	Tongue – Inner 5 x 3 Weldment BC2100XL	1
3	180016876	Mount – Jack Manual Assy	1
	IK02-1667	Includes Items 1 - 3	

FIGURE 4
[IK02 Only]

UNIT OWNER COPY: Insert in Parts Manual for future reference.

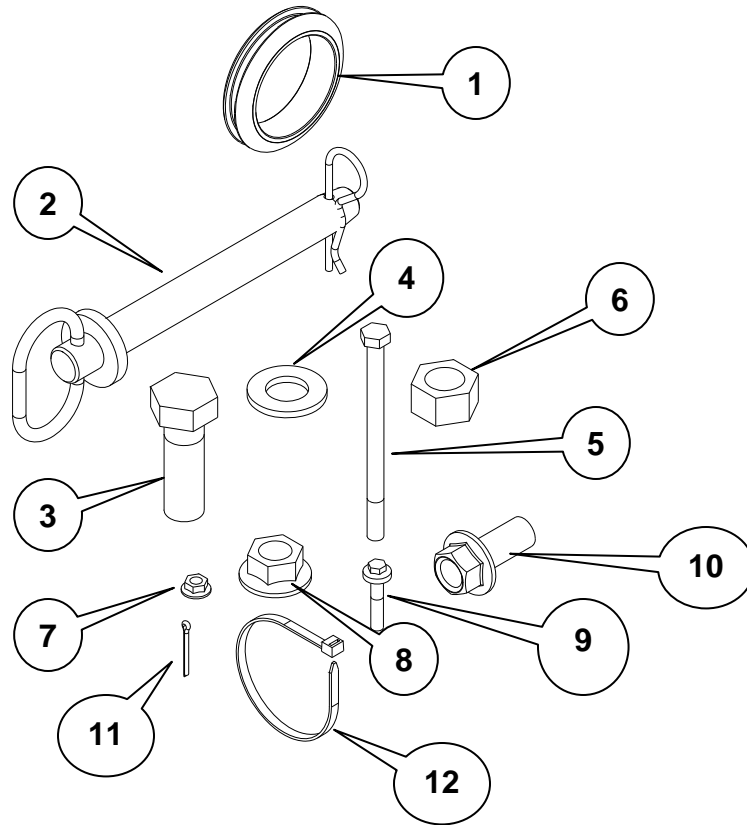
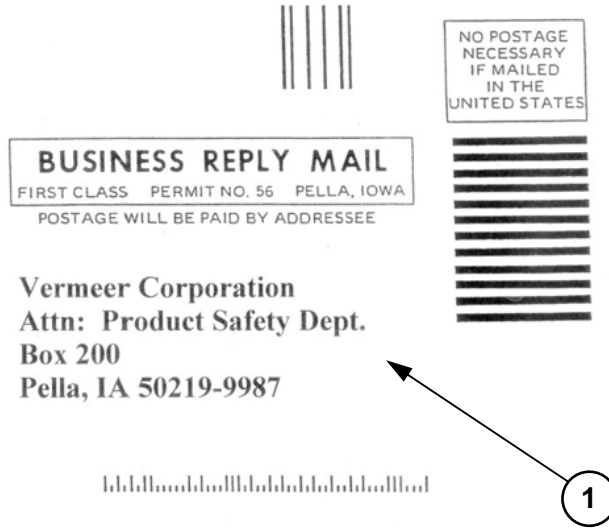


FIGURE 4			
REF. NO.	PART NO.	DESCRIPTION	QTY.
1	1865001	GROMMET - 1/4 X 2 1/2	2
2	2107007	PIN-HITCH 3/4 X 6	2
3	243921001	SCREW-HCS-.75-10X2.25-GR8-YZ	4
4	295016001	WASHER-FLAT SAE-.75-.81X1.50-14-YZ	4
5	351044	BOLT-5/16-18X4 1/2 GR 5 HEX HD	2
6	397001	NUT-3/4-10 GR 8 SLTL	4
7	507085006	NUT-HEXFLNG LOCK,M6-1.00,10.9,YZ,D6927	2
8	507085016	NUT-HEXFLNG LOCK, M16-2.00,10.9,YZ,D6927	20
9	507610030	SCREW-HFS,M6-1.00X30,10.9,YZ,D6921,PT	2
10	507614035	SCREW-HFS,M16-2.00X35,10.9,YZ,ANSI,B18.2.3.9M,FT	20
11	510049	PIN-3/32X1 COTTER	1
12	59634001	SINGLE NYTIE - 8"	20
13	69153001	CRIMP CONNECTOR	4
	IK02-1667	Includes Items 1 - 13	

Figure 5



UNIT OWNER COPY: Insert in Parts Manual for future reference.

FIGURE 5			
REF. NO.	PART NO.	DESCRIPTION	QTY.
1	296287039	Work Completion Certificate	1
		Each kit includes item No. 1 in Figure 5	

Vermeer



Vermeer
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P.O. Box 200
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<Model> <Serial Number>

<Company>

<First Name> <Last Name>

<Address>

<City> <State>, <Zip Code>

<Country>

**IMPORTANT:
SAFETY RECALL
NOTICE**