

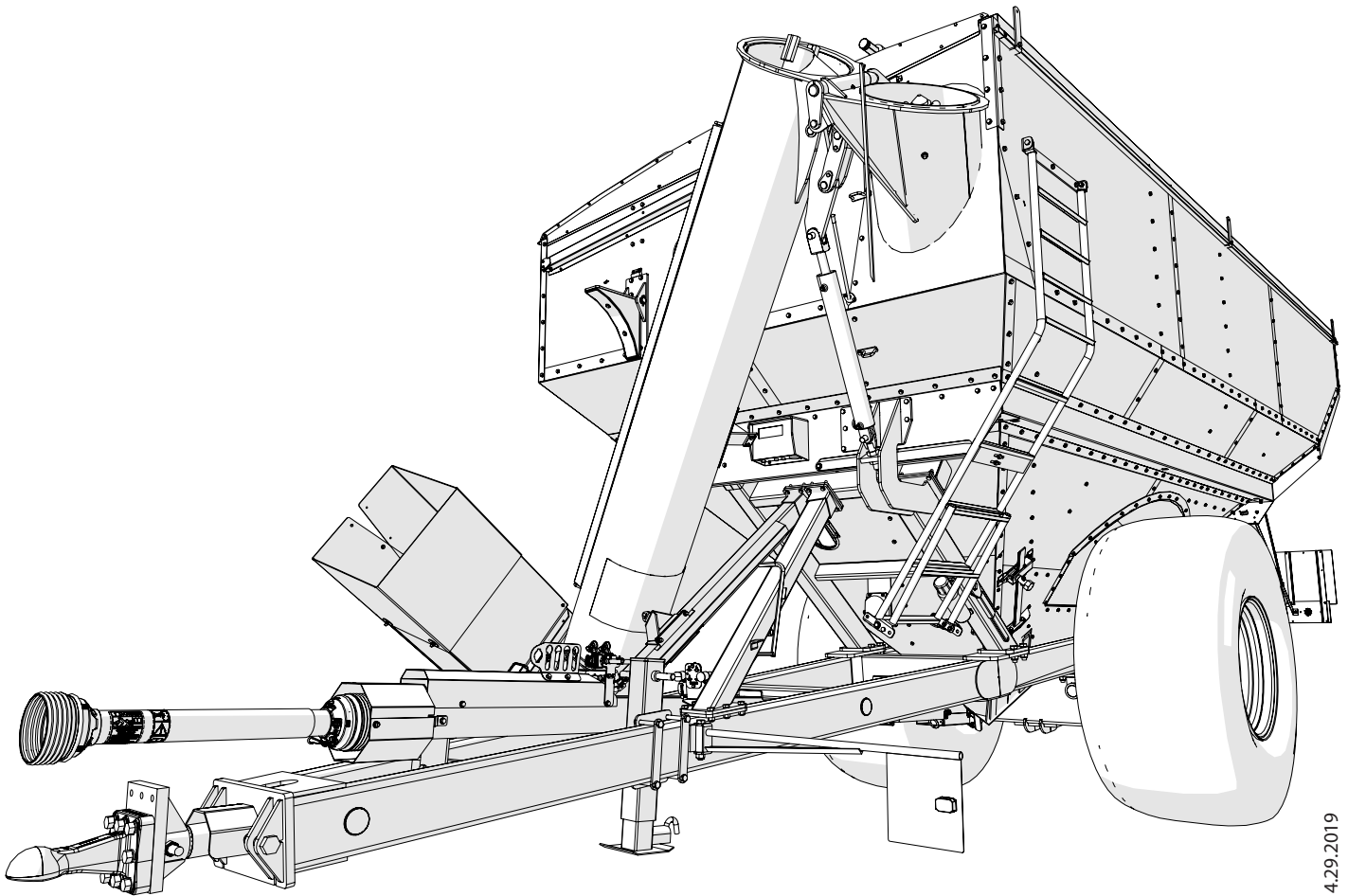


# International

## GRAIN CART

ASSEMBLY MANUAL

MODEL **x1925**  
**x2431**



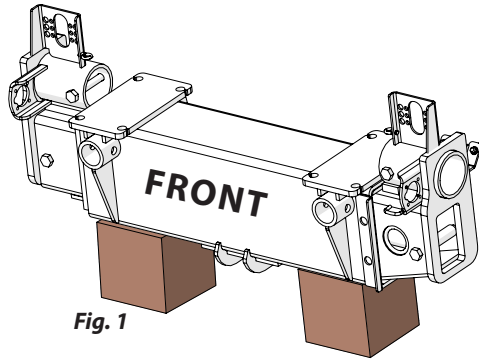
Rev. 4.29.2019

**J&M Manufacturing Co., Inc**

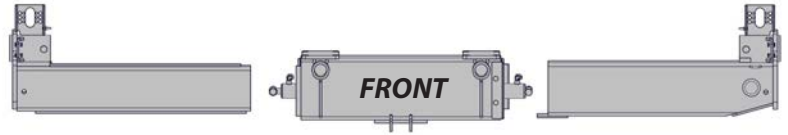
284 Railroad Street - P.O. Box 547 | Fort Recovery, OH 45846 | Ph: (419) 375-2376 | Fax: (419) 375-2708

[www.jm-inc.com](http://www.jm-inc.com)

## Step 1

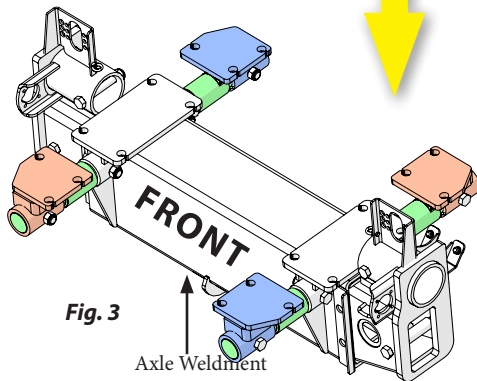
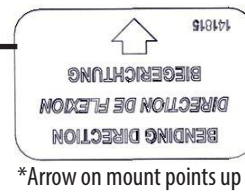
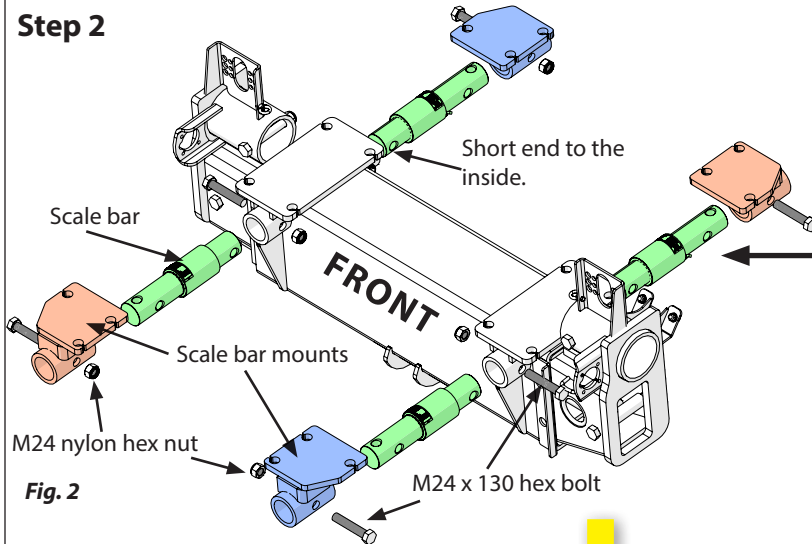


- For stability set the axle weldment on blocks using an overhead hoist and chain.



## Step 2

*If no scales then go to Step 3.*



- Insert the 4 weight bars into the axle weldment. The **short end** of the weight bars slide inside of the axle weldment.
- Attach the weight bars to the axle weldment using a M24 x 130 hex bolt and a M24 nylon locking hex nut for each bar.
- Slide the scale bar mounts onto the weight bars. Scale bar mounts should be orientated according to fig 2.
- Attach the scale bar mounts to the weight bars using a M24 x 130 hex bolt and a M24 nylon locking hex nut.
- Tighten all hardware.

## Step 3

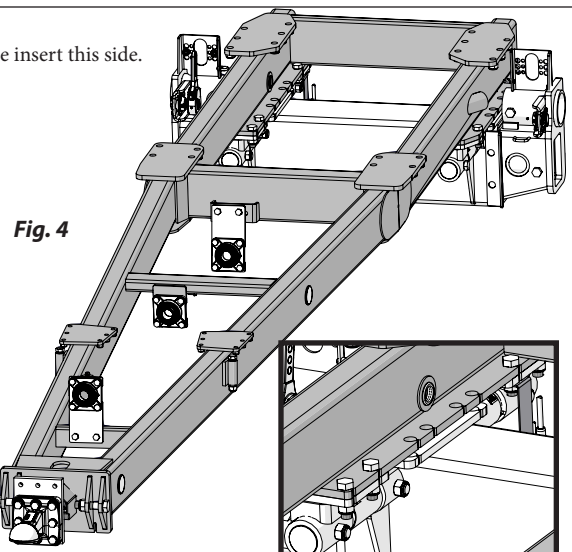
### Non-Scales

- Attach the main frame to the axle weldment. Set the rear end onto the axle and the front end onto another block. Use (8) M24 x 75MM hex bolts and (8) M24 nylon locking hex nuts to fasten the main frame to the axle.
- Tighten all hardware.

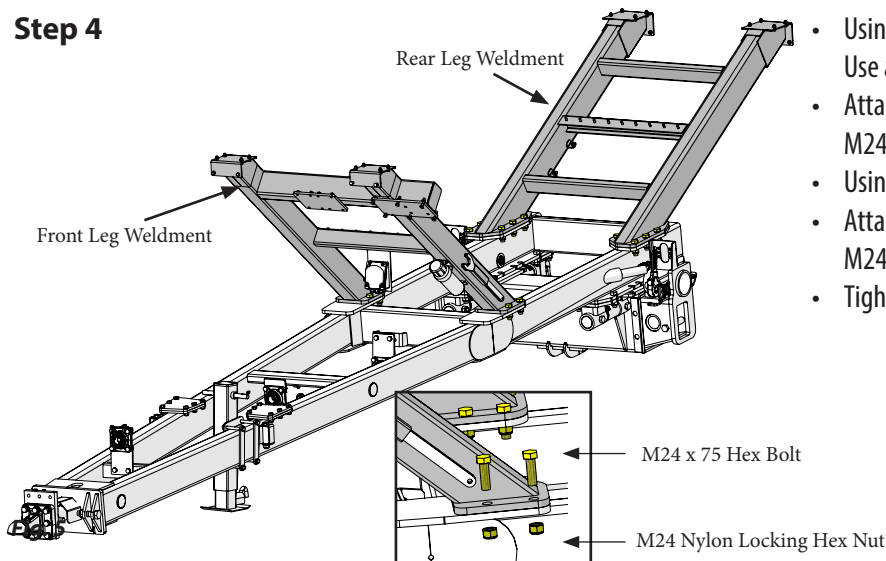
### Scales

- Attach the main frame to the scale bar mounts. Set the rear end onto the scale bar mounts and the front end onto another block. Use (12) M24 x 75mm hex bolts and (12) M24 nylon locking hex nuts.
- Tighten all hardware.

Smallest axle insert this side.

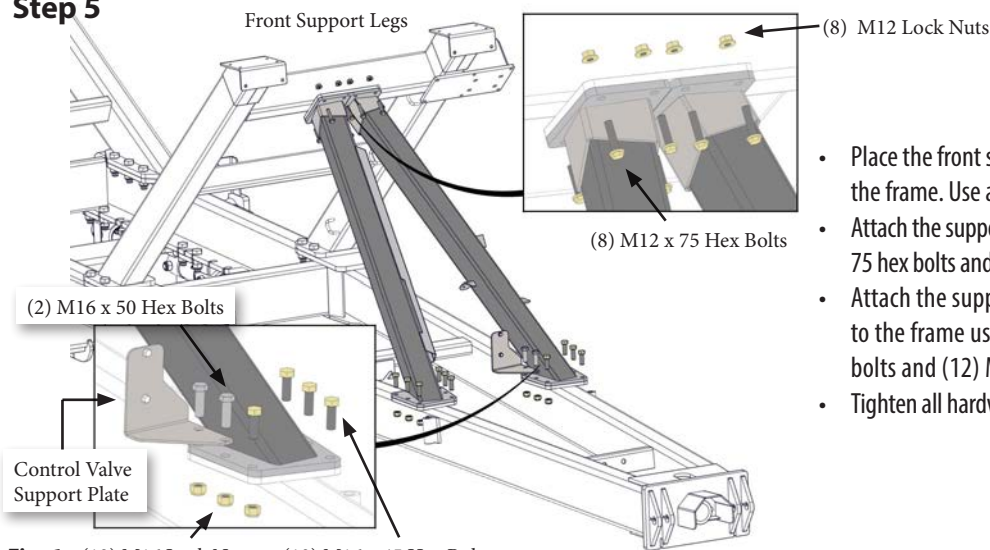


## Step 4



- Using an overhead hoist, place the front leg onto the frame. Use a drift pin to help line up the holes.
- Attach the front leg using (8) M24 x 75 hex bolts and (8) M24 nylon locking hex nuts.
- Using an overhead hoist, place the rear leg onto the frame.
- Attach the rear leg using (12) M24 x 75 hex bolts and (12) M24 nylon locking hex nuts.
- Tighten all hardware.

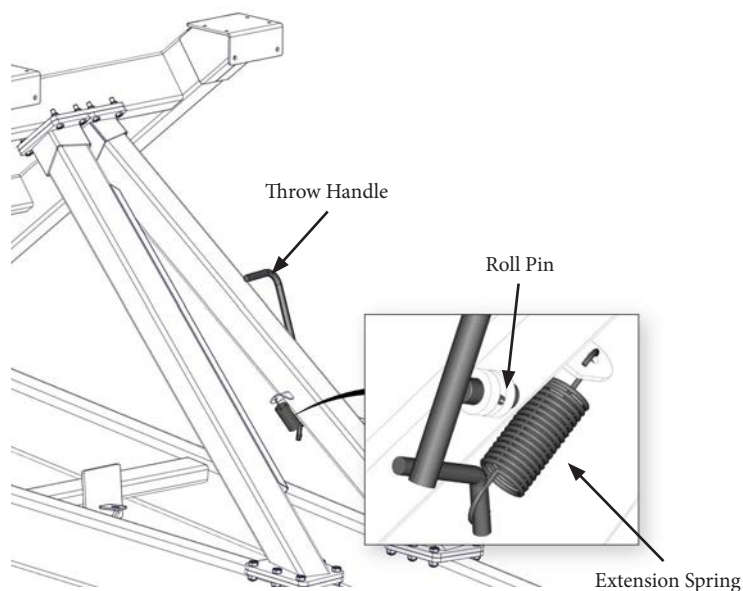
## Step 5



**Fig. 6** (12) M16 Lock Nuts (10) M16 x 45 Hex Bolts

- Place the front support legs and control valve support plate onto the frame. Use a drift pin to help line up the holes.
- Attach the support legs to the front leg weldment using (8) M12 x 75 hex bolts and (8) M12 lock nuts.
- Attach the support legs and the control valve support plate to the frame using (10) M16 x 45 hex bolts, (2) M16 x 50 hex bolts and (12) M16 lock nuts.
- Tighten all hardware.

## Step 6

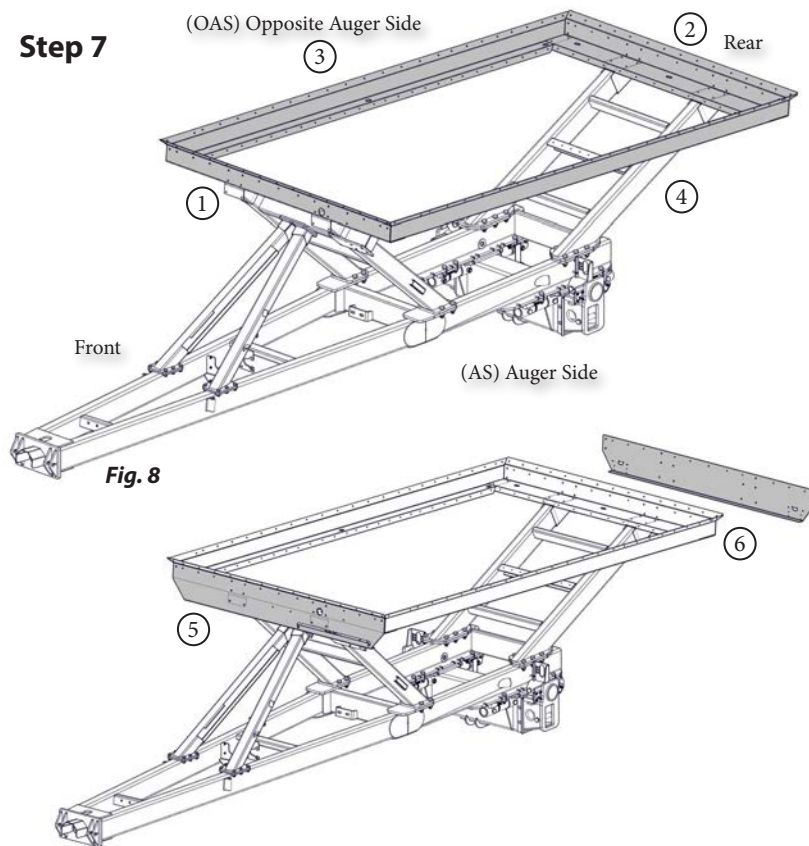


**Fig. 7**

- Attach the auger rest throw handle to the front auger side support leg.
- Use a hammer to install the roll pin.
- Install the extension spring. Use a screwdriver or drift pin to assist with installation.

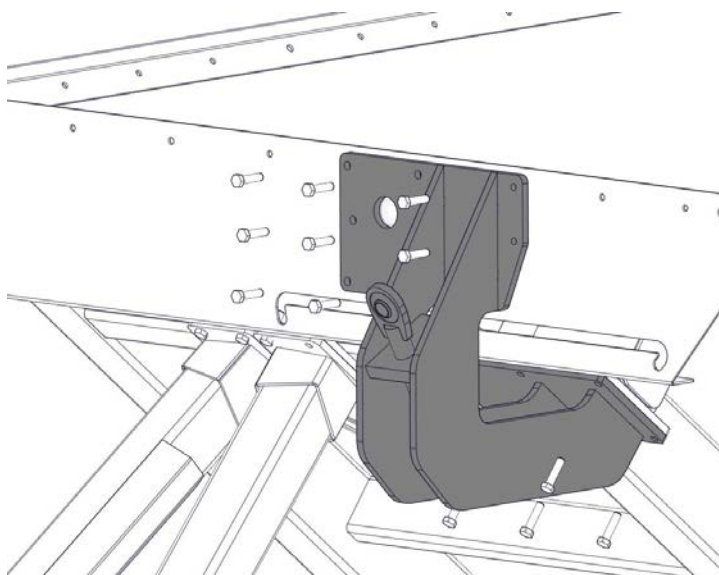


## Step 7



- Attach the front rail to the front leg.
- Use (8) M10 x 25 hex bolts and (8) M10 hex nuts.
- Attach rear rail to rear leg.
- Use (8) M10 x 25 hex bolts and (8) M10 hex nuts.
- Attach OAS rail to the front and rear rails. Use (4) M10 x 25 hex bolts and (4) M10 hex nuts.
- Attach AS rail to the front and rear rails.
- Use (4) M10 x 25 hex bolts and (4) M10 hex nuts.
- Attach the front face-plate.
- Use (19) M10 x 25 hex bolts and (19) M10 hex nuts.
- Attach the rear face-plate. Use (19) M10 x 25 hex bolts and (19) M10 hex nuts.
- Tighten all hardware.

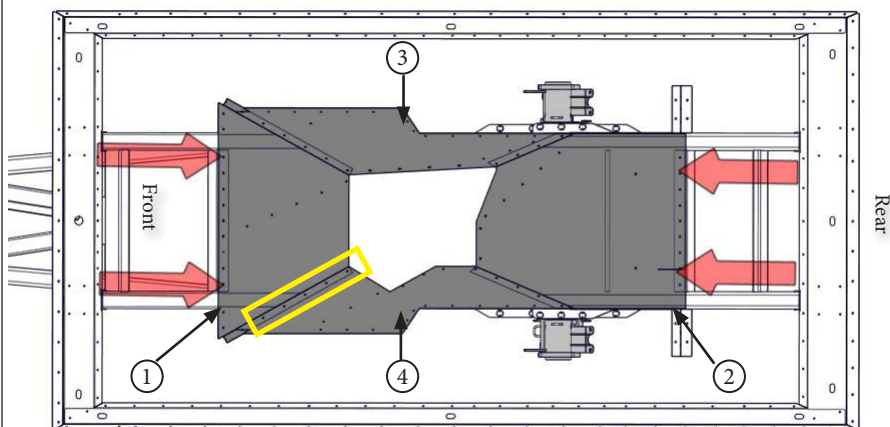
## Step 8



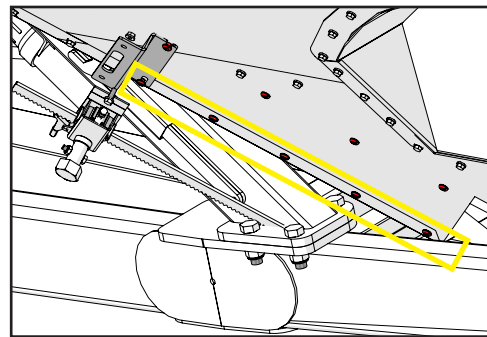
- Attach the cylinder mount to the front rail.  
Use (14) M12 x 50 hex bolts and (14) M12 hex nuts.
- Tighten the hardware before moving to the next step.



## Step 9



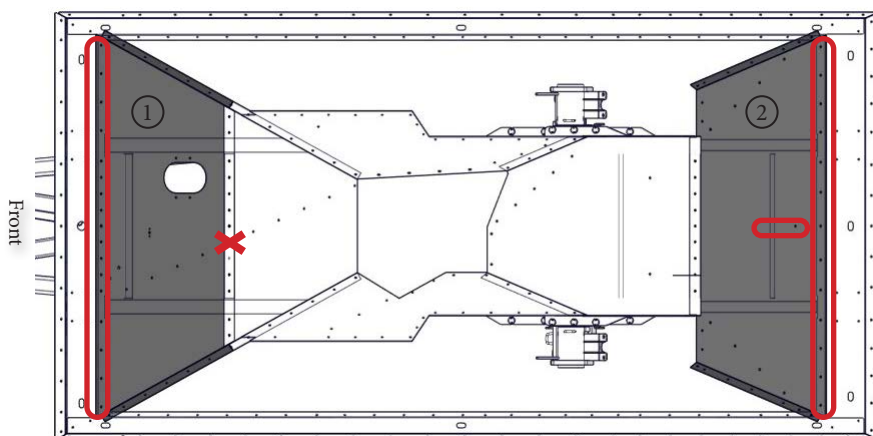
**Fig. 9**



- Attach panels 1 and 2 to the front and rear legs using (4) M10 x 25 hex bolts each. Place bolts in holes according to arrows in Fig 9. These bolts will be removed in the next step.
- Attach panels 3 & 4 to panels 1 and 2.
- Use (14) M10 x 25 hex bolts and nuts to install panels 3 & 4.
- Use (5) M10 x 25 Round head bolts and serrated flange nuts where the yellow box indicated above.

\*In comparison to Panel 3, Panel 4 has an extra set of holes for the bottom tube.

## Step 10



**Fig. 10**

Note: Do not place hardware wherever there is an **X** or **□**.

- Remove the 2 bolts installed in Step 9 on the front leg.
- Attach panel 1 to the front leg. Use (11) M10 x 25 hex bolts and (11) M10 hex nuts for panel 1.
- Remove the 2 bolts installed in Step 9 on the rear leg.
- Attach panel 2 to the rear leg. Use (9) M10 x 25 hex bolts and (9) M10 hex nuts for panel 2.

## Step 11

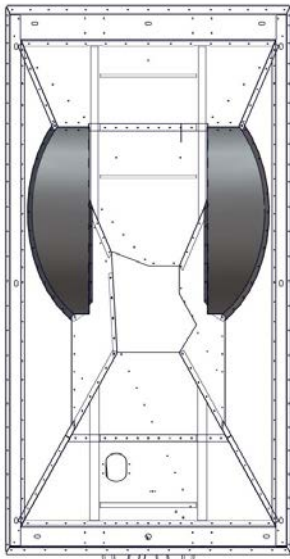


Fig. 11

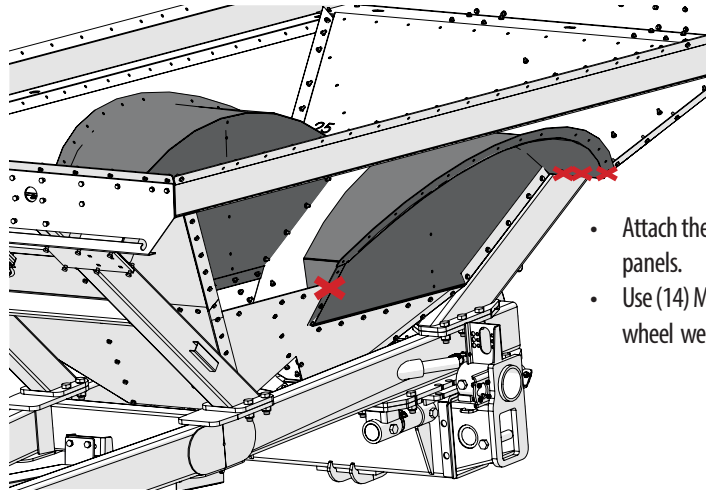


Fig. 12

Note: Do not place hardware wherever there is an **X** or **□**.

- Attach the wheel wells to the rear and middle panels.
- Use (14) M10 x 25 hex bolts and hex nuts for **each** wheel well.

**-STOP-**

Tighten all hardware before the next step.

## Step 12

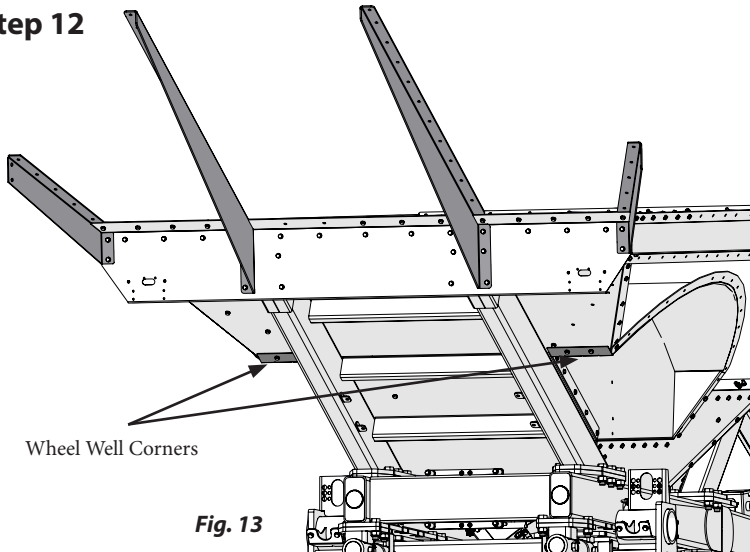


Fig. 13

- Attach the (4) rear wings and the (2) wheel well corners.
- Use (18) M10 x 25 hex bolts and (18) M10 hex nuts.

**-STOP-**

Tighten all hardware before the next step.

## Step 13

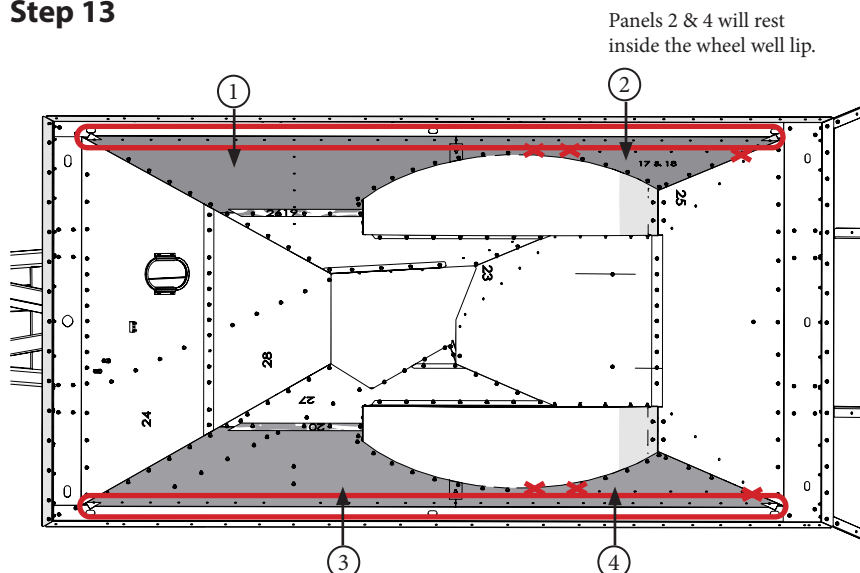


Fig. 14

Note: Do not place hardware wherever there is an **X** or **□**.

- Attach panel 1 to the shell followed by panel 2. Panel 2 will lay on top of panel 1. (Panel 2 will be closer to the middle of the cart.)
- Use (50) M10 x 25 hex bolts and hex nuts for panels 1 & 2.
- Attach panel 3 to the shell followed by panel 4. Panel 4 will lay on top of panel 3. (Panel 4 will be closer to the middle of the cart.)
- Use (50) M10 x 25 hex bolts and hex nuts for panels 3 & 4.

### Step 14

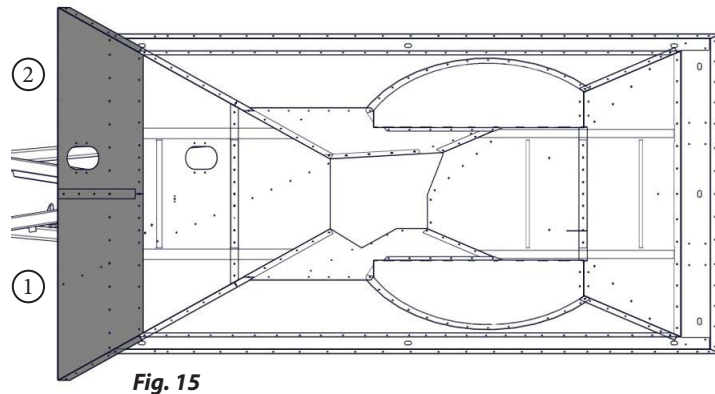


Fig. 15

- Attach panel 1 to the shell, followed by panel 2. Panel 2 will lay on top of panel 1.
- Use (14) M10 x 25 hex bolts and hex nuts for panel 1.
- Use (13) M10 x 25 hex bolts and hex nuts for panel 2.

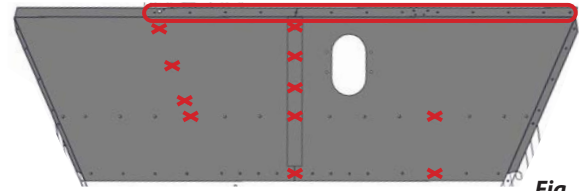




Fig. 16

Note: Do not place hardware wherever there is an  or .

### Step 15

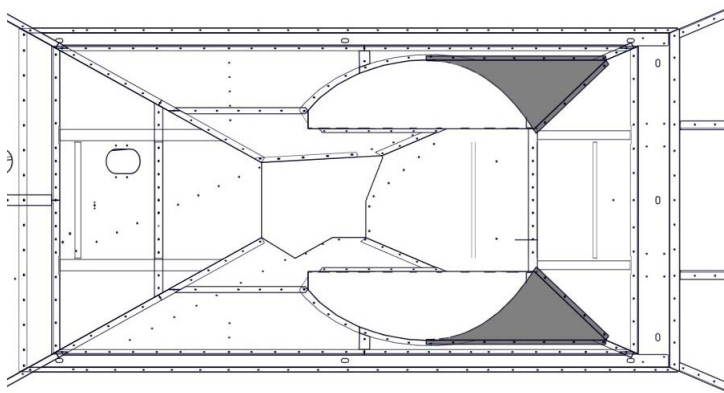


Fig. 17

- Attach both shedder panels.
- Use (20) M10 x 25 hex bolts and (20) M10 hex nuts.

### Step 16

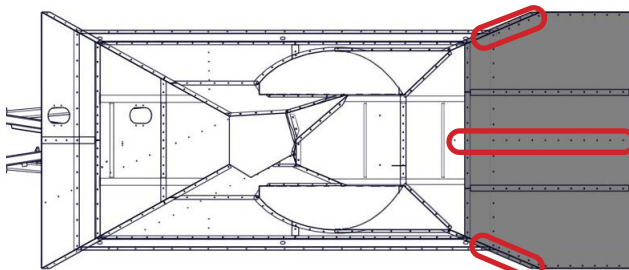


Fig. 18

Note: Do not place hardware wherever there is an  or .

- Attach the (3) rear panels according to Fig 18.
- Use (53) M10 x 25 hex bolts and (53) M10 hex nuts.

### Step 17

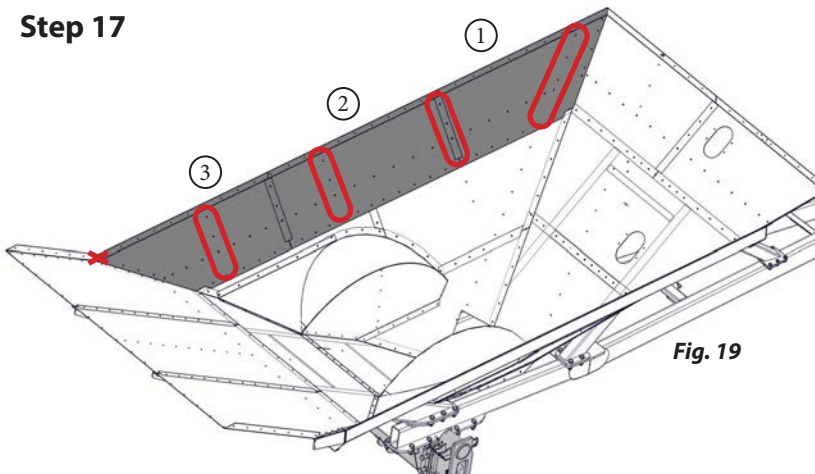

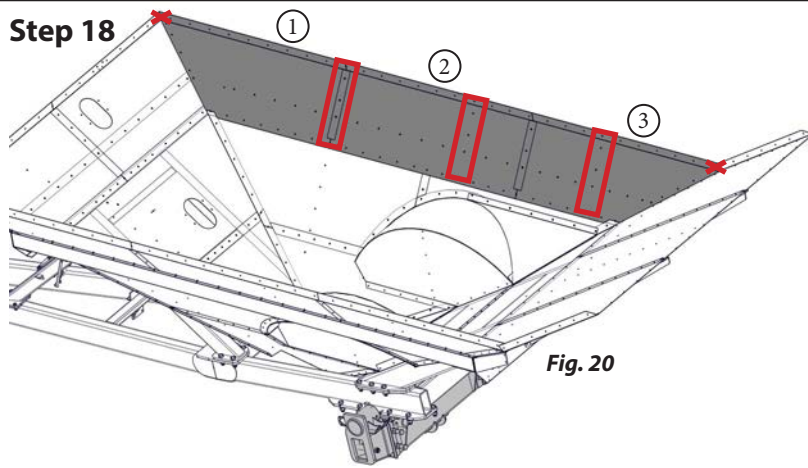


Fig. 19



- Attach (3) auger side panels in order according to Fig. 19
- Use (33) M10 x 25 hex bolts and (33) M10 hex nuts.

Note: Do not place hardware wherever there is an  or .

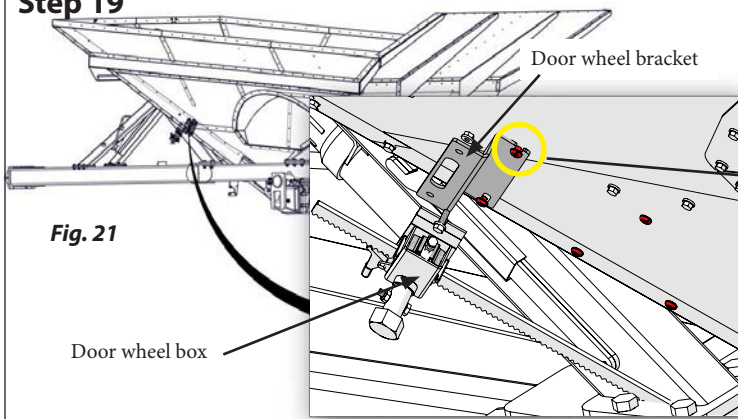
## Step 18



- Attach (3) opposite auger side panels in order according to Fig. 20
- Use (33) M10 x 25 hex bolts and (33) M10 hex nuts.

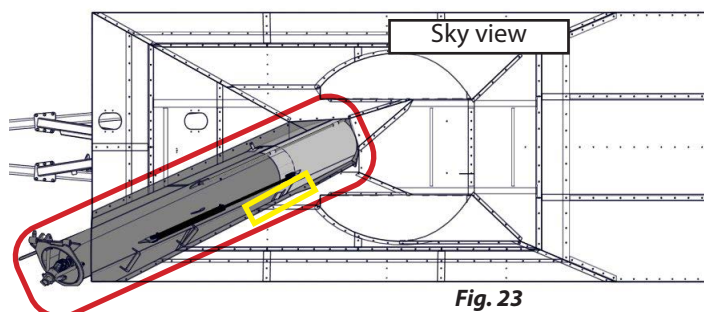
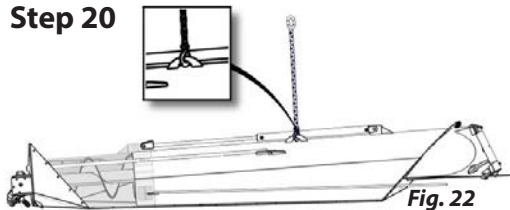
Note: Do not place hardware wherever there is an  or .

## Step 19

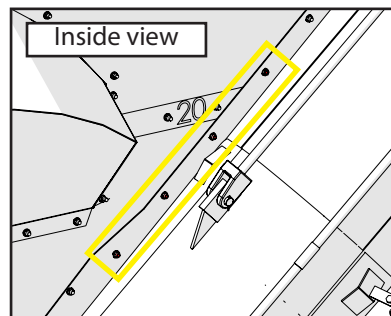
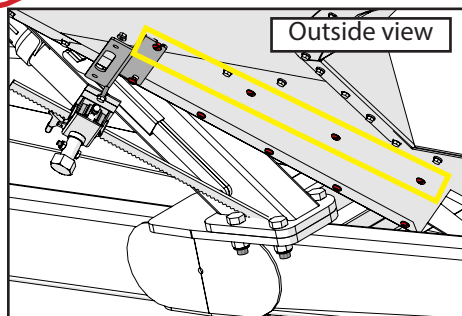


- Install door wheel weldment according to Fig. 21.
- Attach the door wheel weldment bracket to the shell using (2) M10 x 25 hex bolts and (2) M10 hex nuts.
- Attach the door wheel box to the bracket using (2) M10 x 25 hex bolts and (2) M10 hex nuts.
- The bolt on the right will have to wait until the lower auger is installed in step 20, but make sure to line up the holes.

## Step 20



- **Before beginning step 20, tighten all hardware that will be hidden by the bottom auger once installed. Use Fig 23 as a guide.**
- Attach the bottom auger to the shell assembly. Using an overhead hoist, lift the bottom tube assembly using the lifting hook hole.
- Use (29) M10 x 25 hex bolts and (29) M10 serrated flange hex nuts to fasten the auger to the shell.
- Use a drift pin to help line up holes.
- Use (4) M10 x 25 round head bolts and (4) M10 serrated flange hex nuts in the location specified by yellow boxes in the images to the left.
- Make sure to put the topmost round head bolt in the slot for the door wheel bracket.
- Then attach the door wheel to the bracket with (2) M10 x 25 hex bolt and (2) M10 serrated flange hex nut.





## Step 21

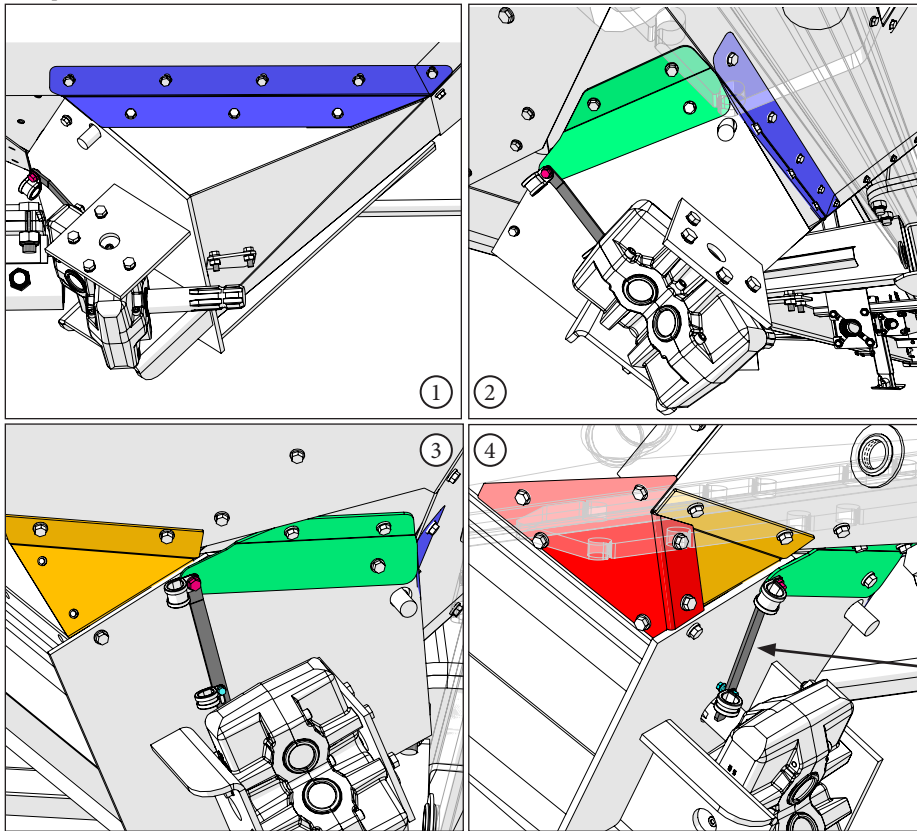


Fig. 24

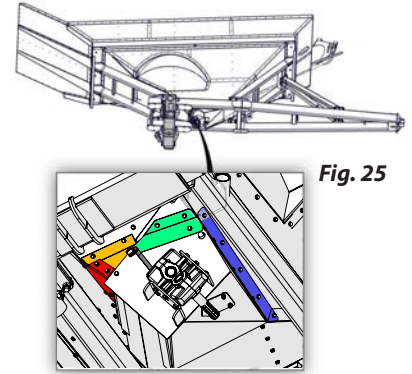


Fig. 25

- Attach the (4) gearbox plates according to Fig. 24.
- Use (19) M10 x 25 hex bolts and (19) M10 hex nuts.
- The Brake kit tube support will have wire looms added with bolts listed below.
- The top bolt of the Brake kit tube support is M10 x 35. The bolt shown in blue (bottom bolt of brake kit tube support) are M6 x 16 and the nut is M6 serrated flange.

Brake kit tube support

## Step 22

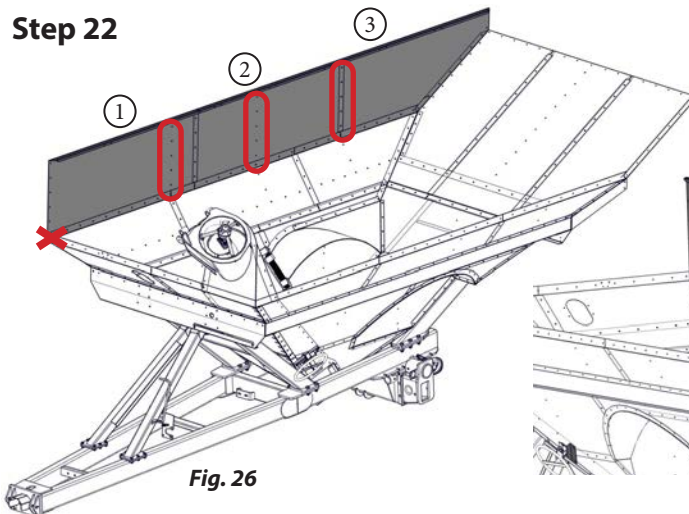


Fig. 26

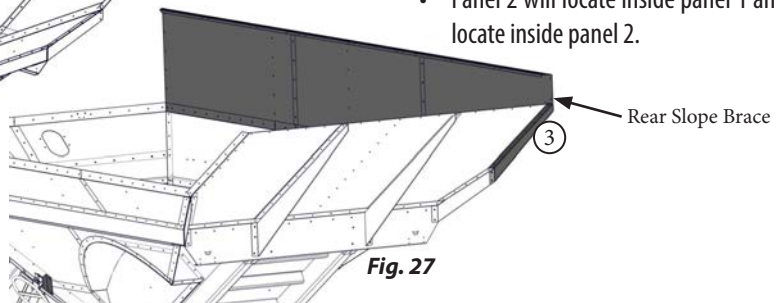


Fig. 27

- Attach the 3 OAS top panels and rear slope brace.
- Install in order according to Fig. 26 and Fig. 27.
- Use (36) M10 x 25 hex bolts and (36) M10 hex nuts for the top panels and slope brace.
- Panel 2 will locate inside panel 1 and panel 3 will locate inside panel 2.

Rear Slope Brace

Note: Do not place hardware wherever there is an or .

## Step 23

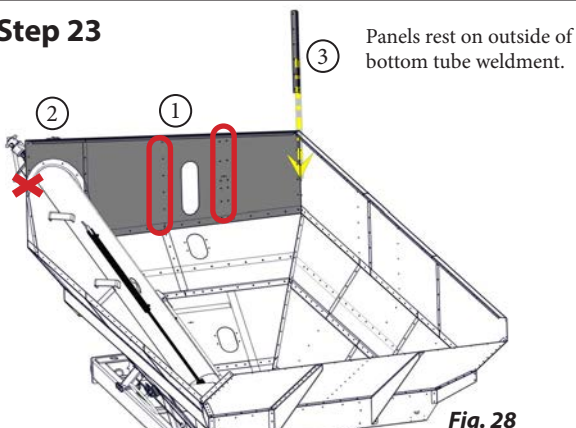
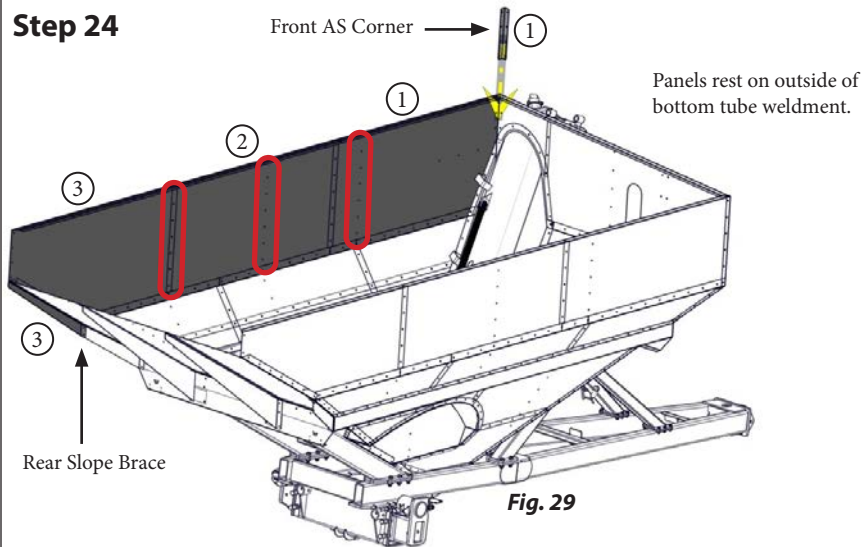


Fig. 28

- Attach the 2 front top panels and the front OAS corner.
- Install in order according to Fig. 28.
- Use (26) M10 x 25 hex bolts and (26) M10 hex nuts for the top panels.

Note: Do not place hardware wherever there is an or .

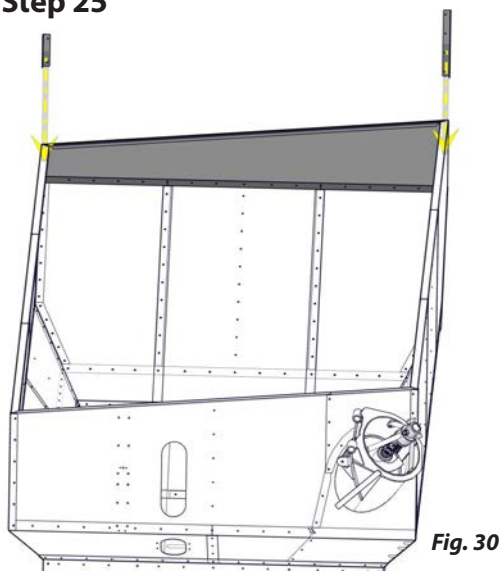
## Step 24



- Attach the 3 AS top panels, rear slope brace, and front AS corner.
- Install in order according to Fig. 29.
- Use (58) M10 x 25 hex bolts and (58) M10 hex nuts for the top panels and slope brace.

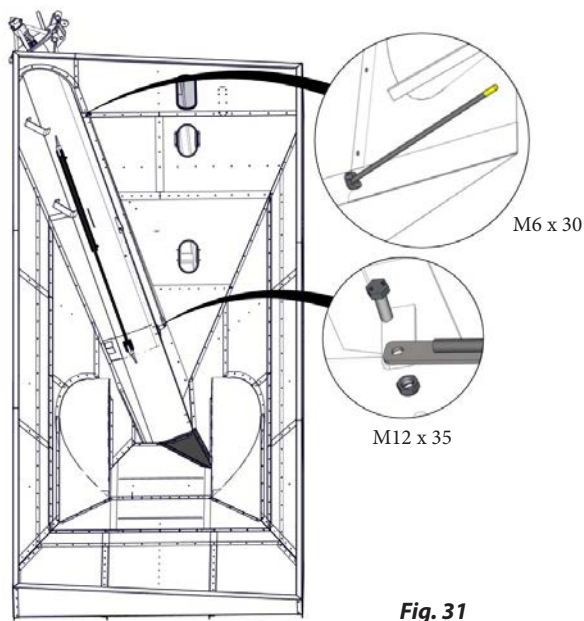
Note: Do not place hardware wherever there is an ✖ or □

## Step 25

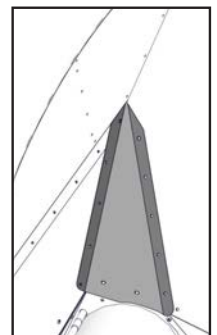
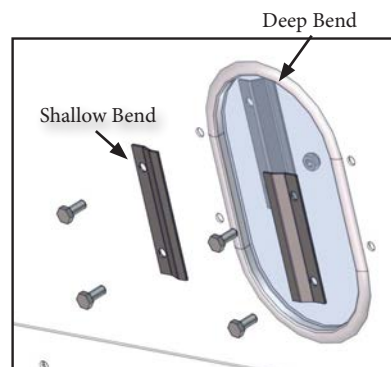


- Attach the rear top panel and both rear corners.
- Use (30) M10 x 25 hex bolts and (30) M10 hex nuts.

## Step 26



- Install the lower sheddar panel. (Fig 33)
- Use (12) M10 x 25 hex bolts and (12) M10 hex nuts.
- Install the 3 window assemblies.
- Use (4) M10 x 25 hex bolts and (4) M10 hex nuts per window.
- Install the indicator rod.
- Use a M12 x 35 hex bolt, M12 nylon locking hex nut, (2) M6 x 30 hex bolts, and (2) M6 nylon locking hex nuts.



## Step 27

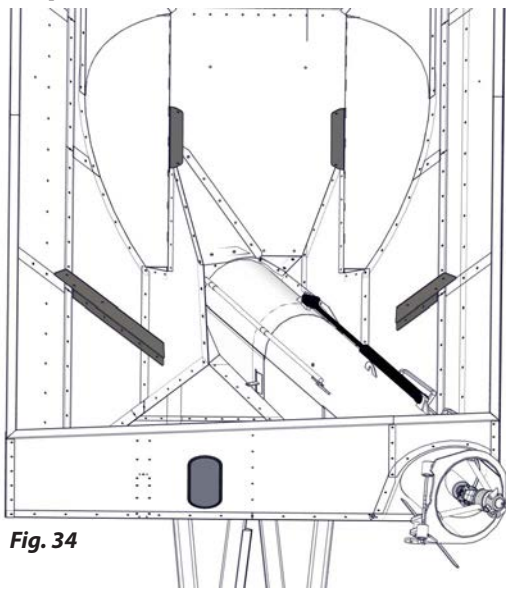


Fig. 34

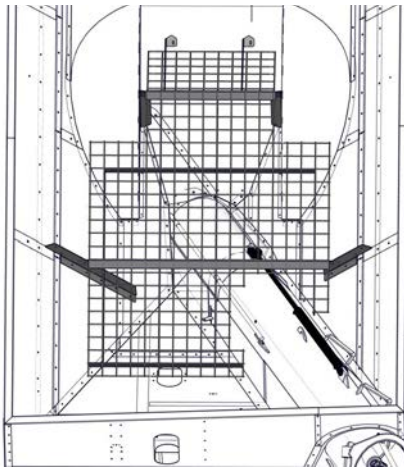


Fig. 35

**-STOP-**

Tighten all hardware.

- Attach the 4 screen braces as shown in fig. 34.
- Use (19) M10 x 25 hex bolts and (19) M10 hex nuts for the braces.
- Attach both screens to the braces as shown in fig 35.
- Use (8) M10 x 25 hex bolts and (8) M10 hex nuts.

## Step 28

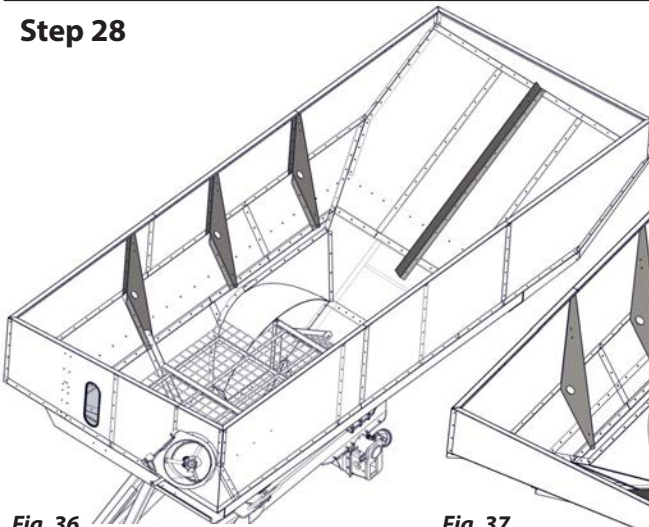


Fig. 36

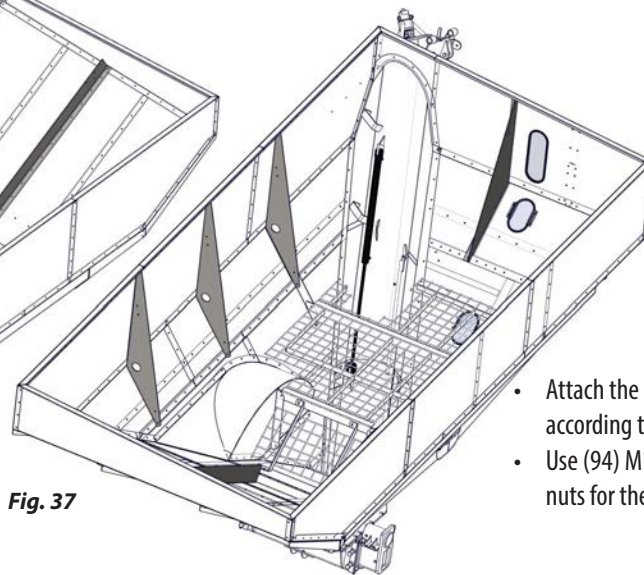


Fig. 37

- Attach the 7 triangle braces and 1 slope brace according to the images in Fig 36 & Fig 37.
- Use (94) M10 x 25 hex bolts and (94) M10 hex nuts for the braces and slope.

## Step 29

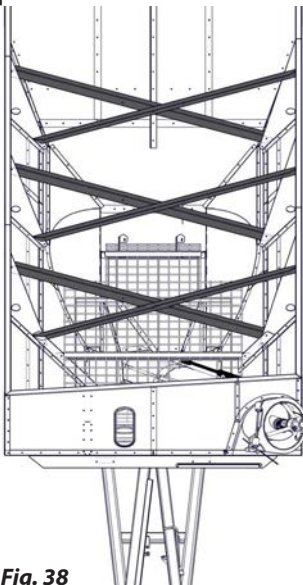


Fig. 38

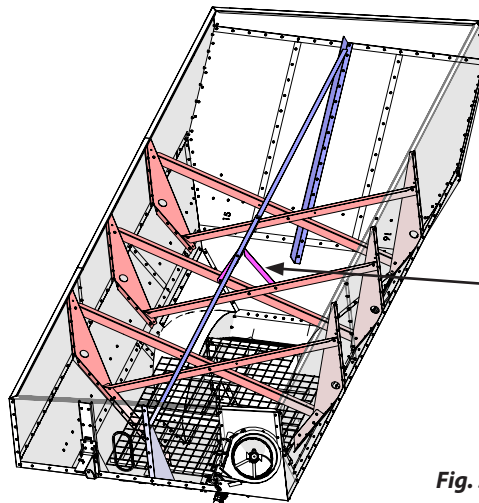


Fig. 39

- Attach the 6 cross braces to the triangle braces according to the images in Fig 38.
- Use (15) M10 x 25 hex bolts and (15) M10 hex nuts.
- Attach the front to back cross braces according to the image in Fig 39.
- Use (10) M10 x 25 hex bolts and (10) M10 hex nuts.
- Attach the Extra Center Brace Support using (3) M10 x 25 hex bolts and (3) M10 hex nuts

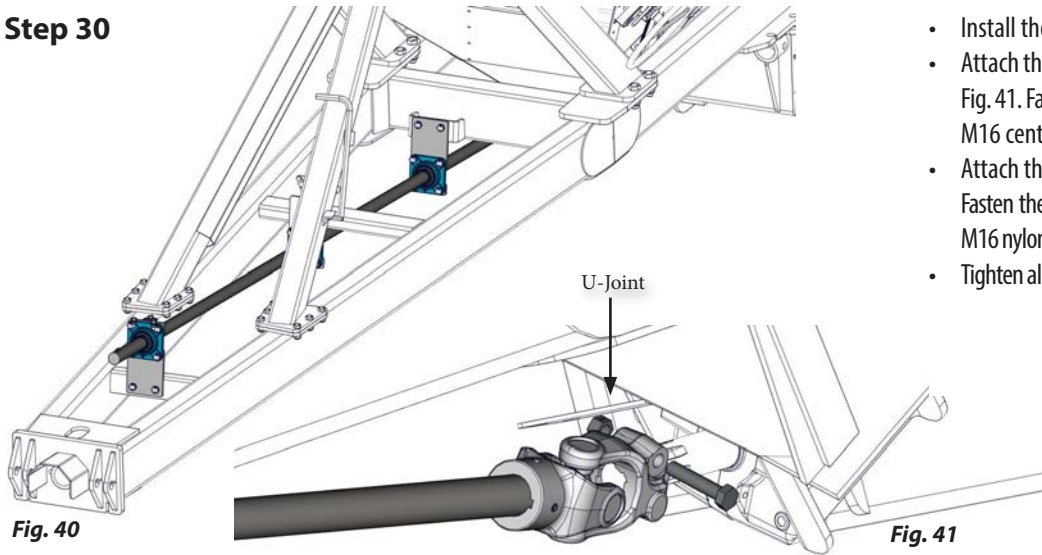
Extra Center Brace Support

**-STOP-**

Tighten all hardware.

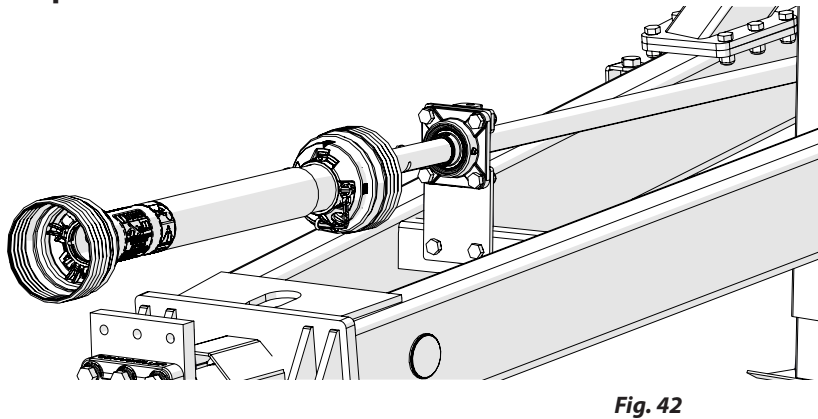


### Step 30



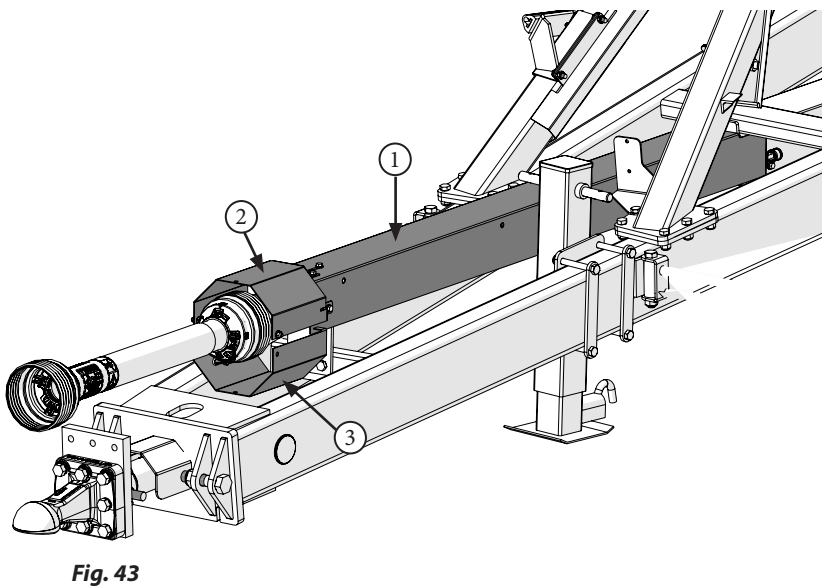
- Install the drive-line.
- Attach the U-Joint to the gearbox spline according to Fig. 41. Fasten the u-joint with a M16 x 75 hex bolt and M16 centerlock hex nut.
- Attach the driveline to the frame according to Fig. 40. Fasten the driveline with (6) M16 x 45 hex bolts and (6) M16 nylon locking hex nuts.
- Tighten all hardware.

### Step 31

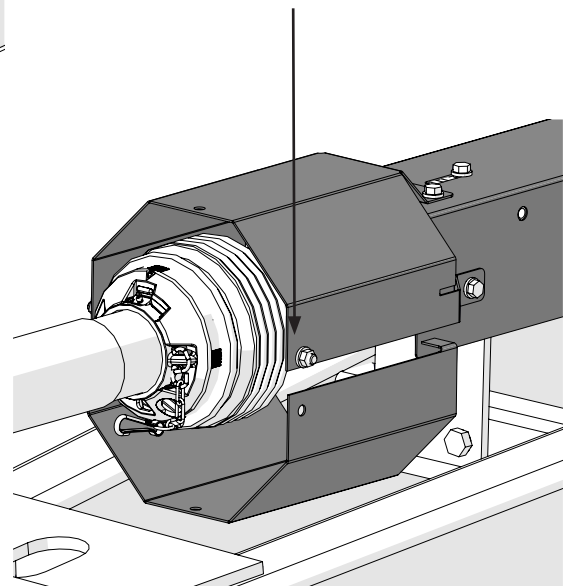


- Install the PTO.
- Slide PTO onto driveline shaft.
- Tighten hardware

### Step 32



- Install the 3 driveline guards in Fig. 42.
- Use (5) M10 x 25 hex bolts.
- On shield number 3 it needs to hook into the back of shield 2.
- Use (2) M10 x 20 round head slot screws and (2) M10 serrated flange hex nut. Make sure the round head bolt is on the inside of the shield and the hex nut is on the outside.





### Step 33

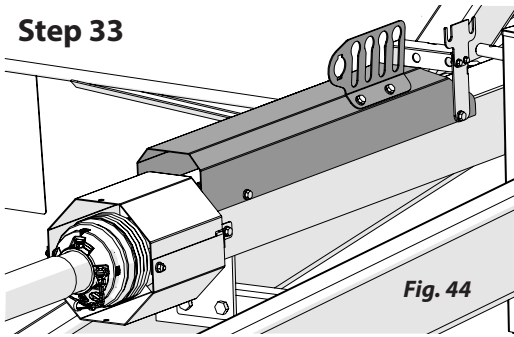


Fig. 44

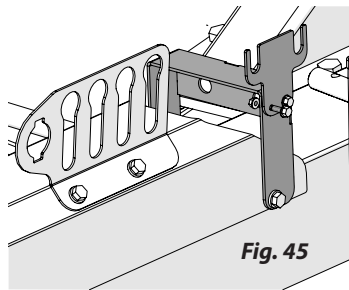


Fig. 45

- Attach the hydraulic hose holder to the hydraulic hose conduit according to Fig. 44.
- Use (2) M10 x 25 hex bolts.
- Tighten both bolts.
- Attach the hydraulic hose conduit to the driveline shield according to Fig. 44.
- Use (2) M10 x 25 hex bolts on the front half of the hydraulic hose conduit.
- Use (2) M10 x 25 hex bolts on the back half of the hydraulic hose conduit after lining up the pneumatic bracket as well shown in figure 45.
- Pneumatic hose holder is bolted onto the pneumatic bracket with (2) M6 x 16 hex bolts and nuts.

### Step 34

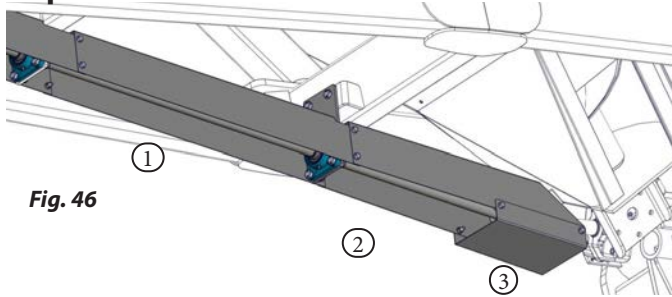


Fig. 46

- Attach the final 3 driveline shields according to Fig. 46.
- Use (14) M10 x 25 hex bolts.
- Tighten hardware.

### Step 35

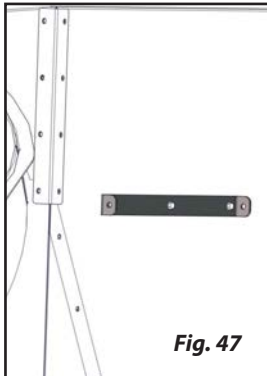


Fig. 47

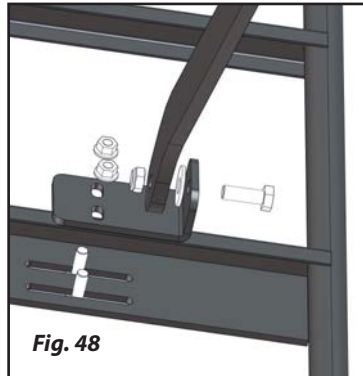


Fig. 48

- Attach the ladder mount bracket according to Fig. 47.
- Use (3) M10 x 25 hex bolts and (3) M10 hex nuts.
- Attach the ladder to the ladder mount bracket according to Fig. 49
- Use (2) M12 x 35 hex bolts, (2) M12 washers and (2) M12 nylon locking hex nuts.
- Attach the ladder support leg and support leg bracket to the ladder according to Fig. 48.
- Use (2) M10 x 25 hex bolts and nuts, M12 x 35 hex bolt, M12 nylon locking hex nut and a 1/2" washer.
- Tighten hardware installed with Fig. 47, 48, and 49. Do not over tighten pivoting bolts.
- Adjust the ladder support leg until it is perpendicular to the ladder itself at point A and point B. (Fig. 50)
- Tighten all hardware.
- Bolt on the ladder extension with (2) M10 x 35 hex bolts then (2) washers and (2) spacers between the two ladders and (2) M10 Nylon nuts. Fig 51.

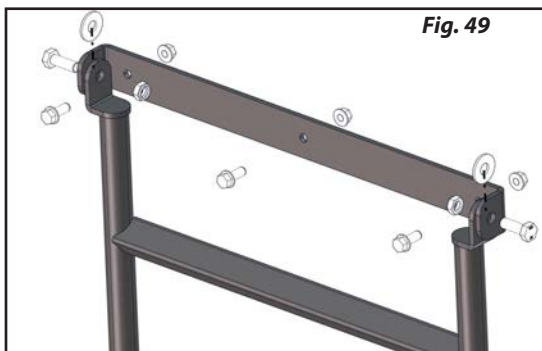


Fig. 49

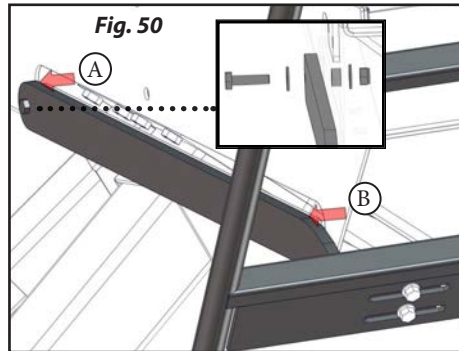


Fig. 50

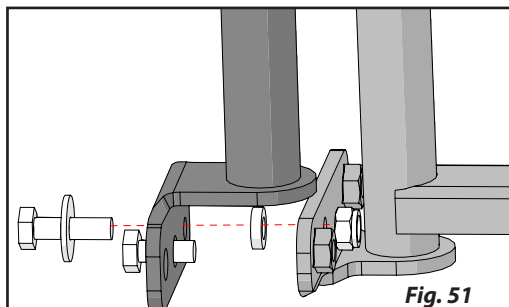
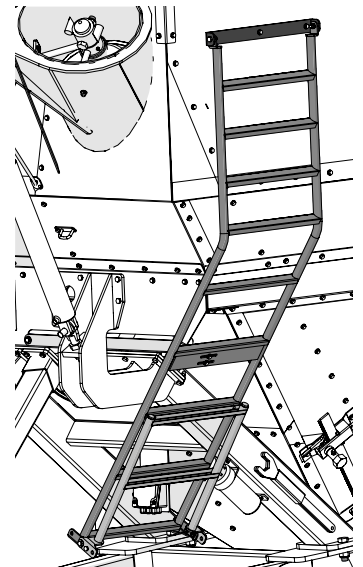


Fig. 51

- The (2) M10 x 25 hex bolts are there to lock the ladder in storage or extended position.



## Step 36

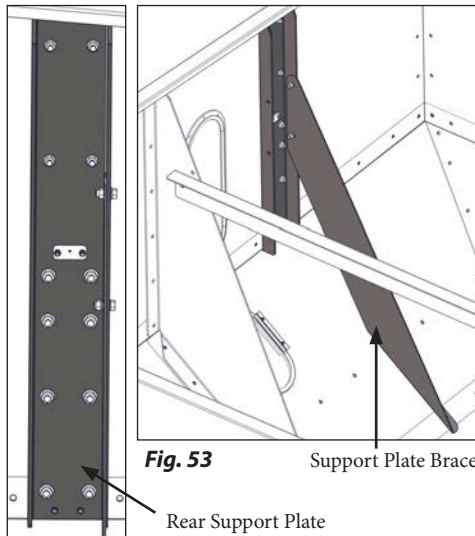
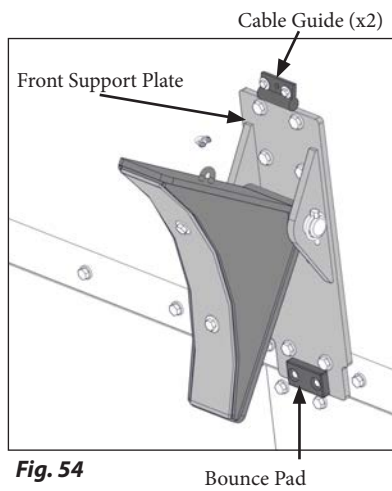
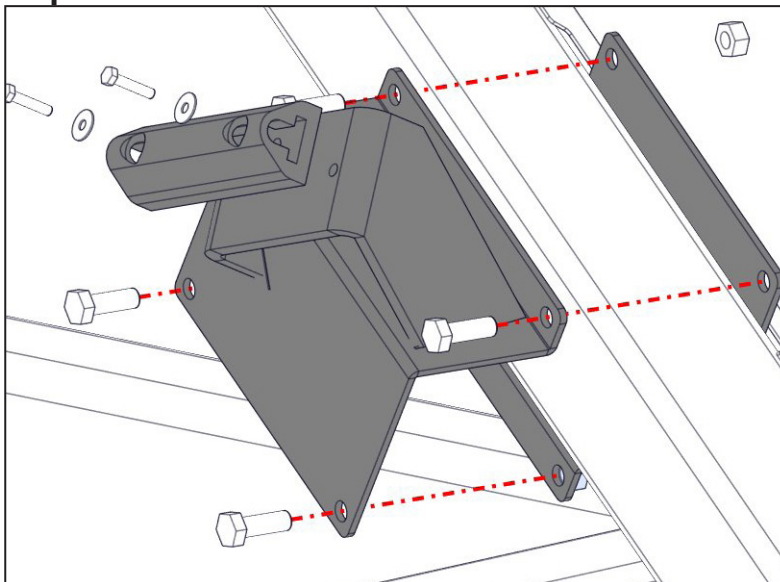


Fig. 52



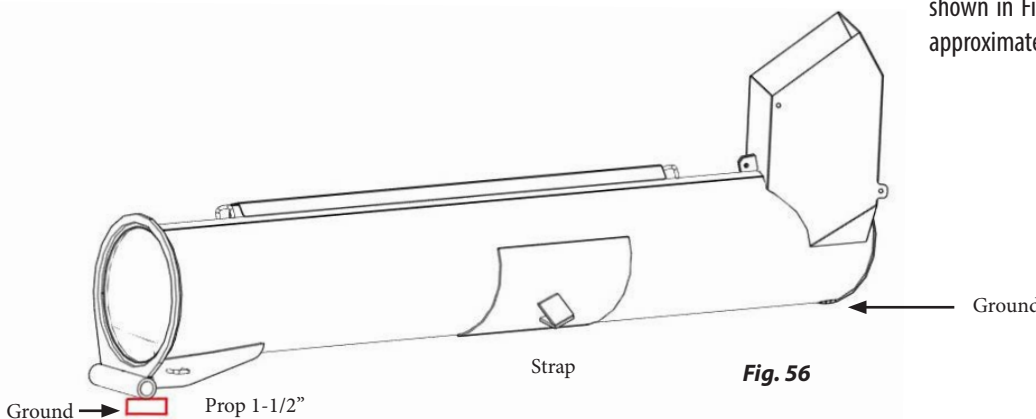
- Install the auger rest assembly. Attach the rear support plate using (4) M10 x 25 hex bolts and hex nuts. (Fig. 52) Top 4 holes only.
- Attach the front support plate using (8) M12 x 35 hex bolts and hex nuts. (Fig. 54)
- Attach the bounce pad and both cable guides. Use (4) M6 x 30 hex bolts, washers and nuts. (Fig 54) Cable guides are located on each side of the front panel. Do not over-tighten.
- Attach the auger rest weldment to the front support plate using the auger pin and (2) snap rings.
- Attach the support plate brace on the inside of the cart. Use (4) M10 x 25 hex bolts and hex nuts. (Fig 53)
- Tighten all hardware.

## Step 37



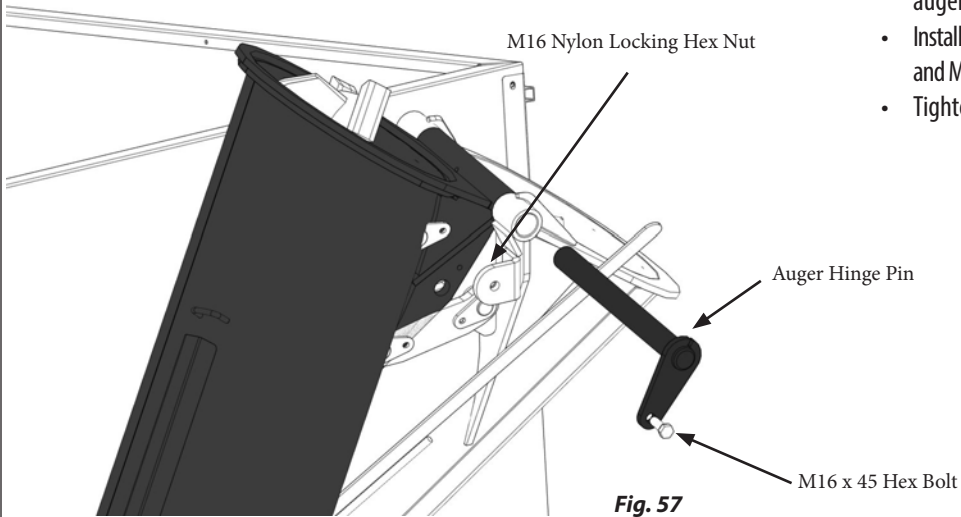
- Install the lower auger rest assembly.
- Slide the auger rest through the conduit and attach the other bracket on the back side.
- Use (4) M10 x 25 hex bolts and (4) M10 hex nuts. Do not tighten hardware.
- Attach the rubber bumper using (2) M6 x 30 hex bolts, (2) M6 washers, and (2) M6 nylon locking hex nuts.
- **Tighten all hardware except for support bracket. (Bracket will need to move when installing upper auger.)**

## Step 38



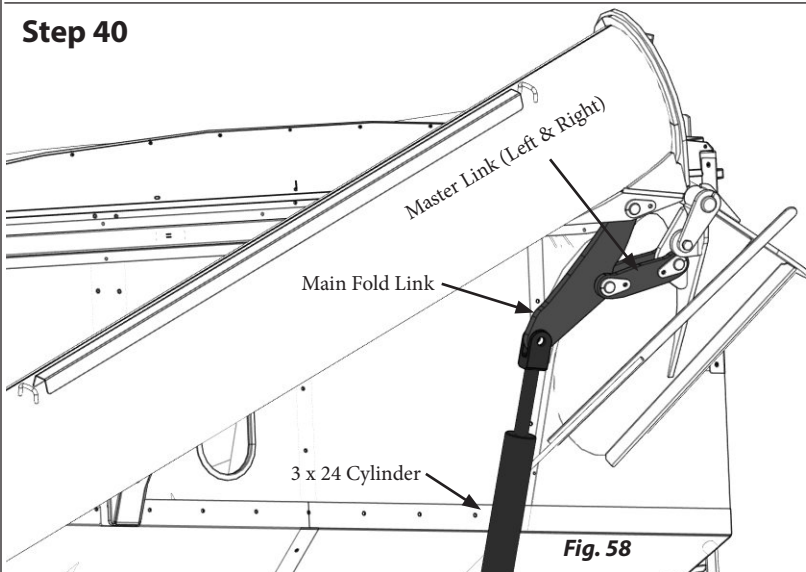
- Orientate the top auger to the same position shown in Fig. 56. The spool should be propped up approximately a 1-1/2" as shown.

### Step 39



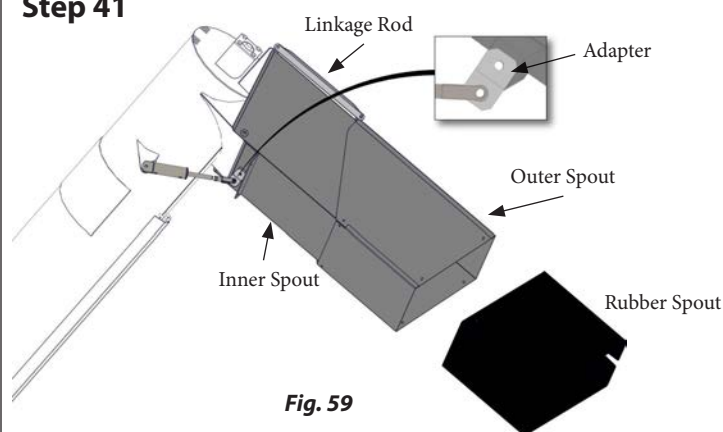
- Fasten the upper auger to the grain cart by positioning the auger to allow the auger hinge pin to be installed.
- Install the auger hinge pin then fasten with a M16 x 45 hex bolt and M16 nylon locking hex nut. (Fig 57)
- Tighten hardware once installed.

### Step 40



- Install the three linkage pieces and the 3" x 24" cylinder.
- Attach the main fold link to the top auger with a linkage pin. Add the M10 x 35 keeper bolt and M10 hex nut.
- Attach both master links to the bottom auger as shown. (Fig 58) Secure with keeper bolt and nut.
- Attach both master links to the main fold link. Secure with keeper bolt and nut.
- Attach the 3" x 24" cylinder to the top auger weldment and the main fold link. Use (2) linkage pins and (4) hair pins to secure the cylinder.
- **Both ports for the hydraulic fittings should face the inside of the cart.**

### Step 41



- Install the tip spout.
- Install tip spout cylinder adapter with a M12 x 35 hex bolt and M12 nylon locking hex nut.
- Attach the inner tip spout with (2) M12 x 50 hex bolts and (2) M12 nylon locking hex nuts. Tighten the hardware. Leave some "play" to allow the tip spout to move freely.
- Install the 1-3/4" x 4" hydraulic cylinder according to Fig 59. Use a M12-1.75 x 30 hex bolt, M12 Nylon hex nut, 1/2" clevis pin and a 1-1/2" cotter pin.
- Tighten all hardware.
- Add tip spout linkage rods to the top tube pins. Secure using (4) M4-20 hex bolts and (4) M4 nylon locking nuts.
- Slide the outer spout over the inner spout and connect the linkage rods to the pins. Secure using M4-20 hex bolts and M4 nylon locking nuts. Tighten all hardware.
- **Rubber Spout:** Install the rubber spout. Fasten using (4) M10 x 30 carriage bolts, (4) 1/2" ID x 2-1/4" OD washers, and (4) M10 nylon locking nuts.

## Step 42

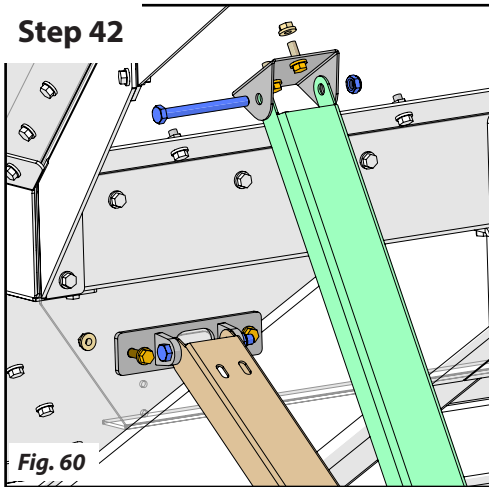


Fig. 60

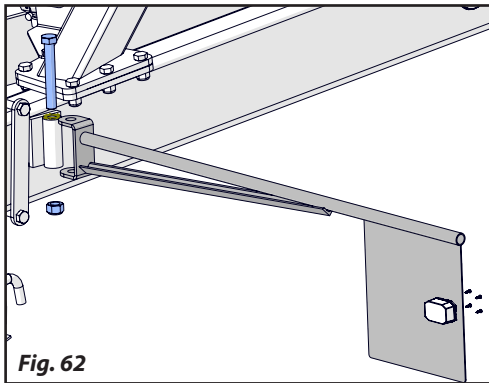


Fig. 62

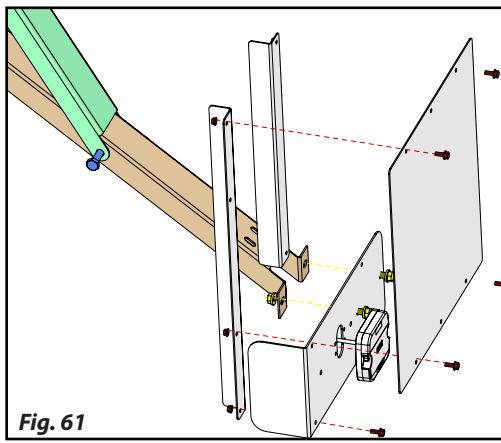


Fig. 61

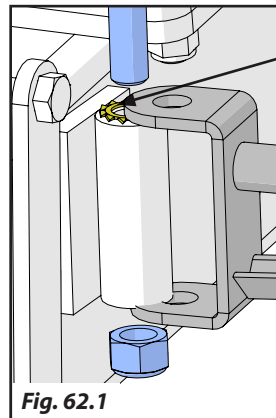


Fig. 62.1

Lock washer goes between spool and flag "C".

- Install the rear brake lights using hardware provided.
- Install the rear light arm brackets using (4) M10 x 25 hex nut and (4) M10 serrated flange hex nut. Hardware is shown in orange in figure 60.
- Attach the arms (shown in green and brown) to the brackets and to each other with (3) M12 x 120 hex bolt and (3) M12 nylon locking nuts. Hardware is shown in blue here.
- The light bracket is attached with (2) M10 x 25 hex bolts and (2) M10 serrated flange hex nuts and are shown in yellow in figure 61.
- The plate and support brackets for the plate are mounted as shown using (5) M6 x 16 hex bolts, and (5) M6 serrated flange hex nuts.
- Install the front position light arm brackets as shown in Figure 62. Fasten to the cart using a M20 x 140 hex bolt, M20 lock washer, and M20 nylon locking hex nut.
- Fasten the white lamps to the arms using M3.5 x 13 self tapping screws.
- Tighten all hardware.

## Step 43

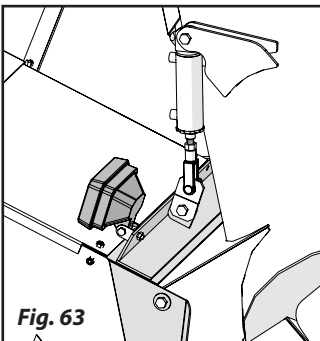


Fig. 63

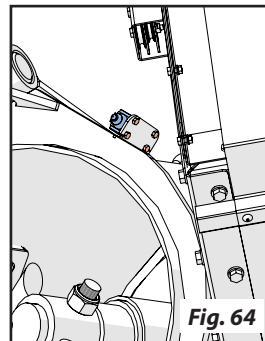


Fig. 64

- Install the field light. Figure 63.
- Attach to the tip spout using a 3/8" x 2" hex bolt and a 3/8" centerlock hex nut. Tighten hardware.
- Install the limit switch to turn on the field light using the M5 x 12 hex bolts. Figure 64
- Install the light harness. Figure 65
- Feed the field light harness through the front rail, towards the top auger. Run the wire through the top tube conduit and connect it to the field light. The remaining portion of the field light harness should run towards the front auger-side slot located on the bottom of the auger-side rail.
- From the front auger side of the cart feed the main harness down the auger-side rail towards the rear of the cart. The short end of the cable can be guided down the rear light arm to connect to the light there. Then feed the longer portion of the main harness down the rear rail towards the opposite auger side. Then run it down the rear light arm to connect to the light there.
- Run the wire for both the front position white lamps up the front leg braces and connect them to the CE front harness.

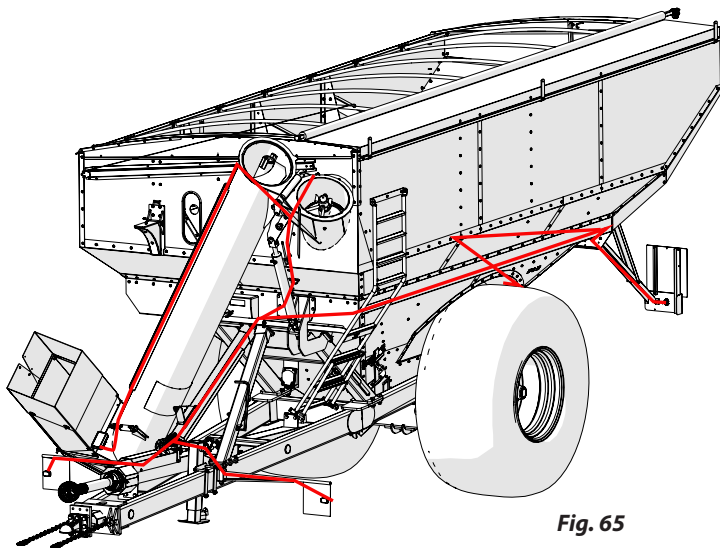
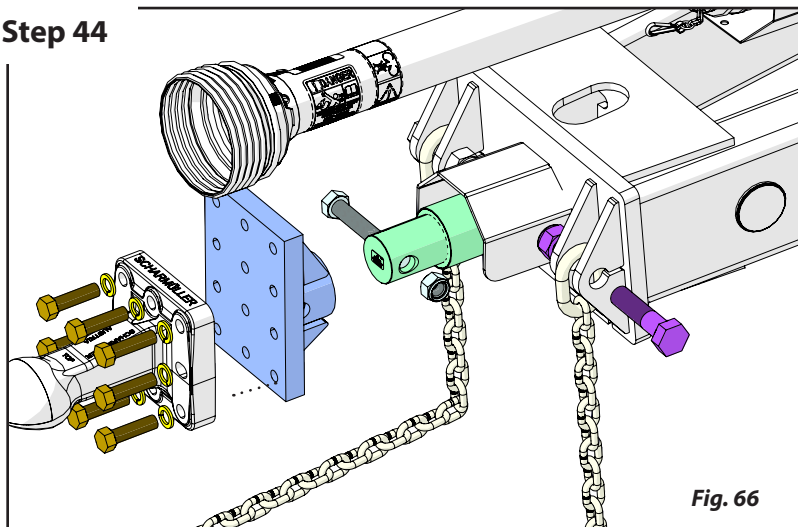


Fig. 65

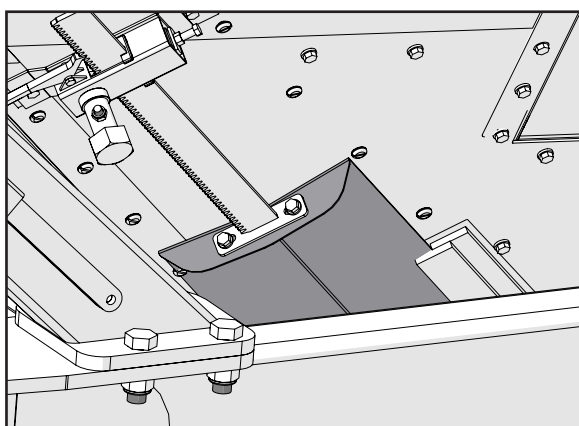


## Step 44



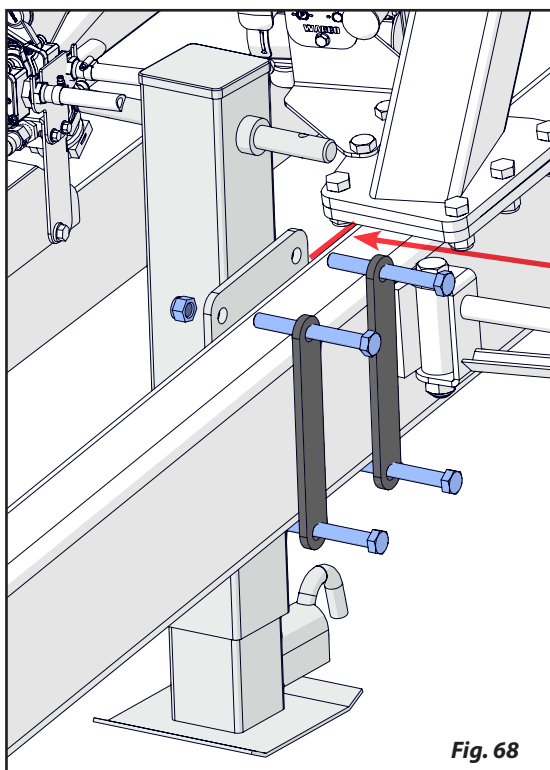
- Install hitch weldment.
- **FOR SCALES:** Attach the weigh bar with the arrow pointing upwards. Use a M24 x 165 hex bolt and a M24 nylon locking hex nut.
- Feed wire through the back of the spindle.
- **FOR NON SCALES:** Attach the non-scale hitch bar using a M24 x 165 hex bolt and a M24 nylon locking hex nut.
- **FOR BOTH SCALES & NON SCALES:** Attach the universal hitch weldment to the hitch spindle using a M24 x 165 hex bolt and a M24 nylon locking hex nut.
- Secure the Scharmuller spoon hitch to the universal hitch weldment using M20 x 75 hex bolts and M20 lock washers.
- Secure each of the safety chains with a M30 x 120 hex bolt and M30 locking hex nut.
- Tighten hardware.

## Step 45



- Install the clean-out door.
- Use (2) M10 x 25 hex bolts and (2) M10 hex nuts.
- Tighten hardware.

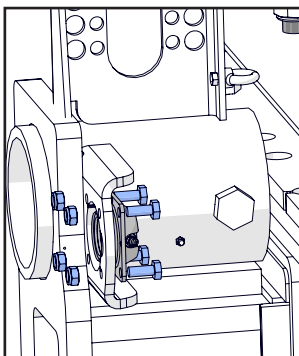
## Step 46



- Install the jack stand assembly. Use (4) M16 x 140 hex bolts and (4) M16 nylon locking hex nuts to secure the jack back support bar.
- Tighten hardware.

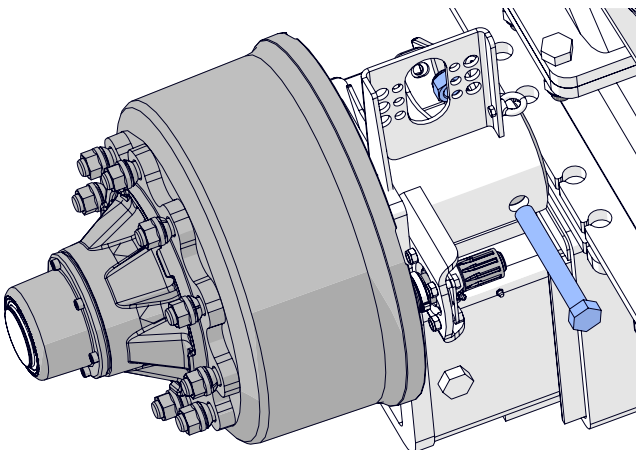
47cm (From the front of the leg mounting plate to the back of the jack mounting plate)

## Step 47



- Install a brake bearing on each side. Use (4) M10 x 25 hex bolts and (4) M10 nylon locking hex nuts. Do not tighten hardware.

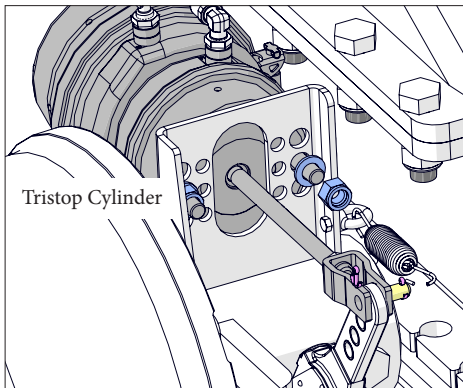
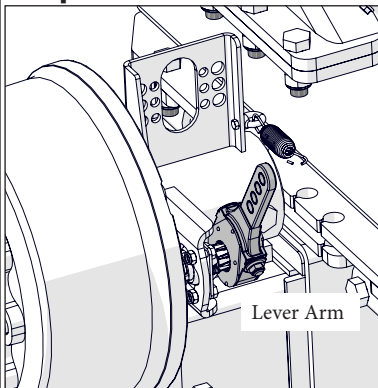
## Step 48



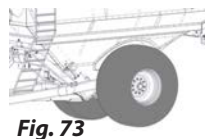
- Install the hub spindle. Orient the hub so the spline slides through the brake bearing.
- Fasten the hub spindle with a M24 x 180 hex bolt and a M24 nylon locking hex nut.
- There are left and right brake hubs. The left hub is labeled SZZVF1XDN002 and the right is labeled SZZVF1XCN002.

Right = SZZVF1XCN002    Left = SZZVF1XDN002

## Step 49

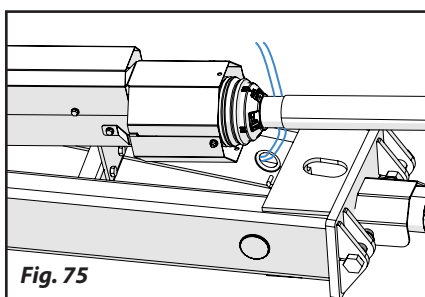
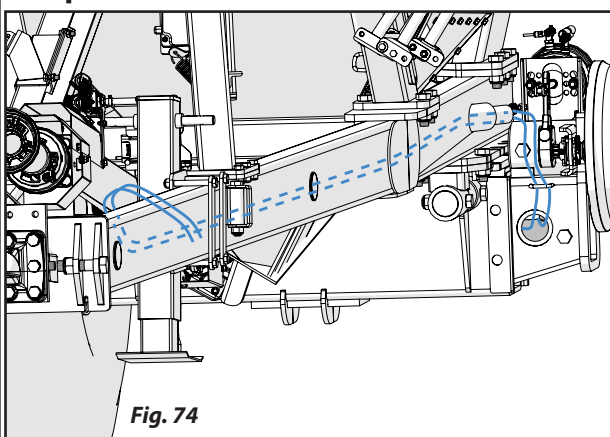


- Install the lever arm. Slide the lever arm onto the spline coming off the spindle. Fig. 71
- Install the brake actuator. Use (2) M16 nylon locking hex nuts.
- Attach the lever arm to the tristop cylinder using the supplied clevis and cotter pin.
- For complete brake set-up instructions, see **brake manufacturer's manual**.
- Install tires. See owners manual for correct torque and seating practices.



**Torque 20mm lugnuts to 644 N•m**

## Step 51

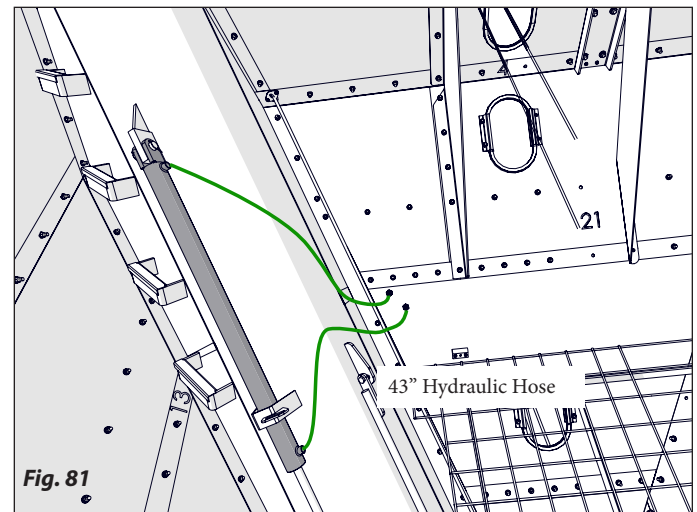
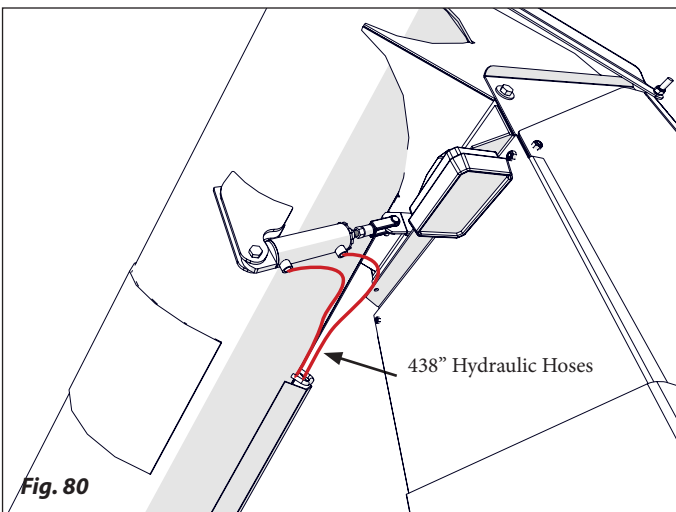
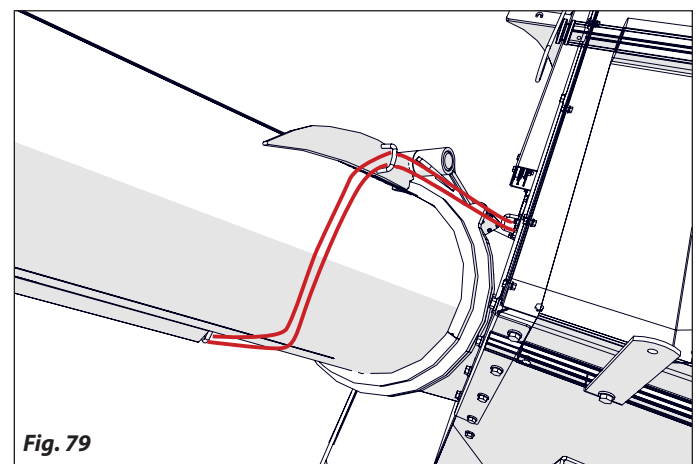
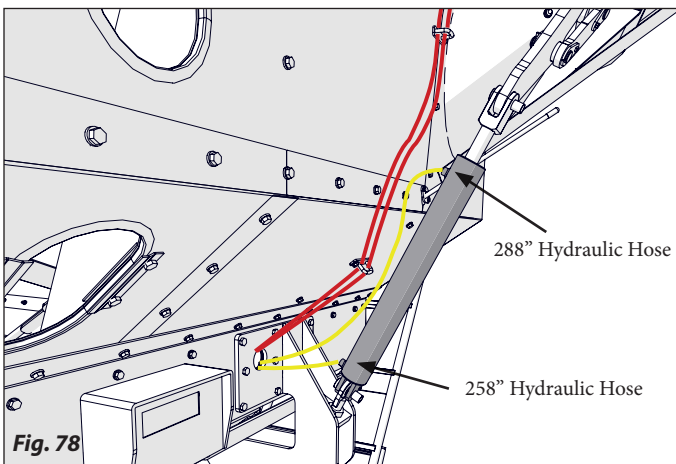
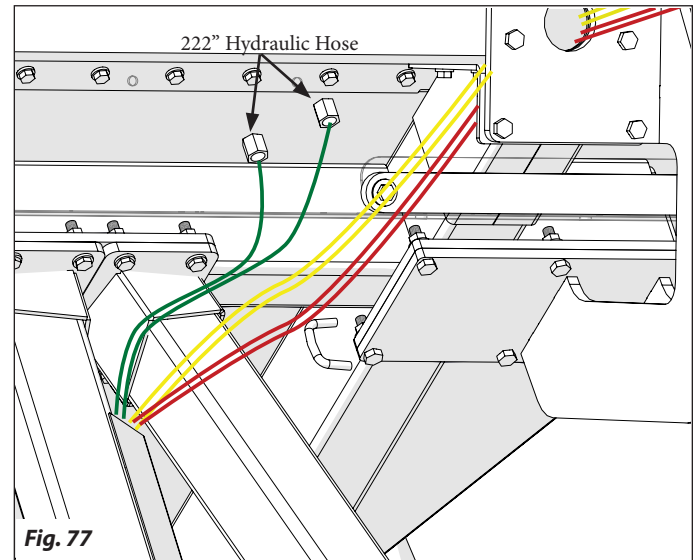
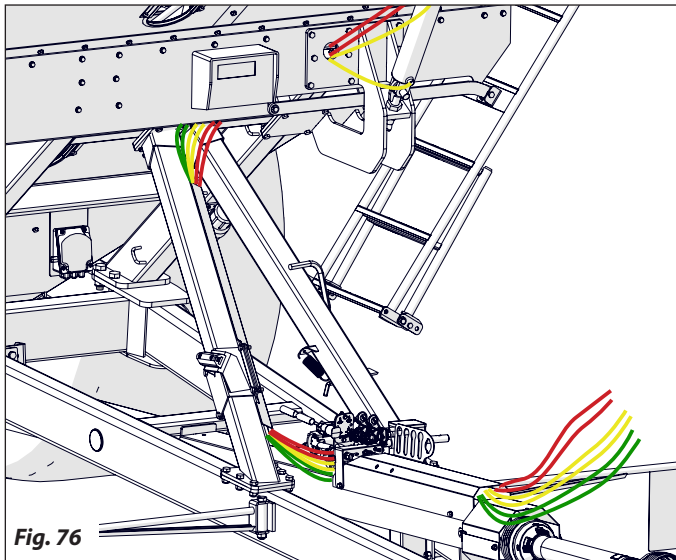


- There is a cylinder mounted inside the axle.
- Run the hoses as shown in the image to the left, starting at the axle going through the protective spring.
- If you reach inside the axle in the hole where the image shows the hydraulic lines coming from there are 2 hoses laying inside. These are the hoses used to connect to the cylinder.
- They come out at the front of the cart by the hitch shown in fig 75.

## Step 52

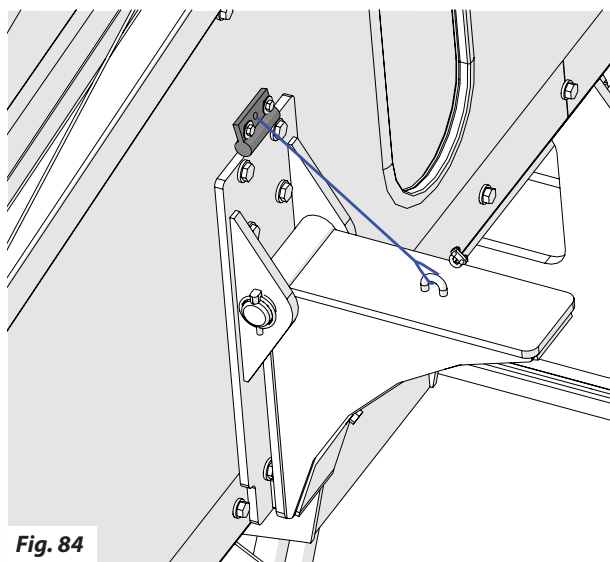
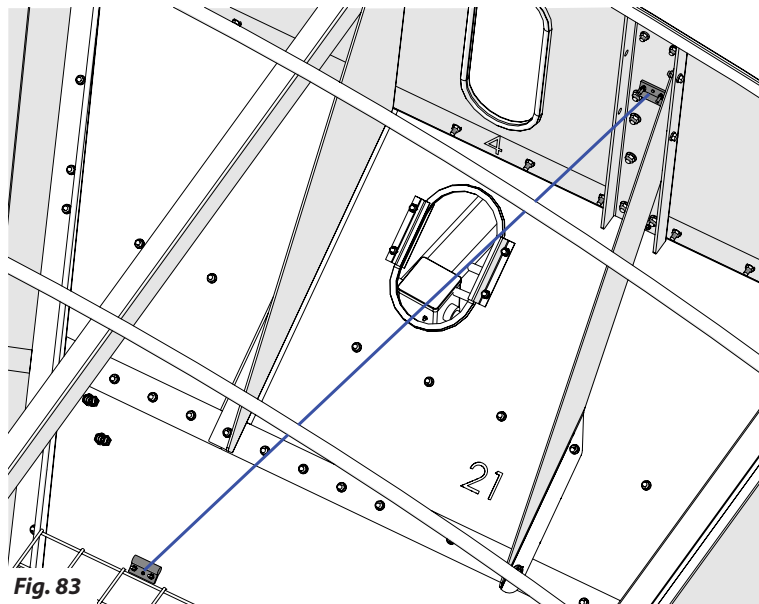
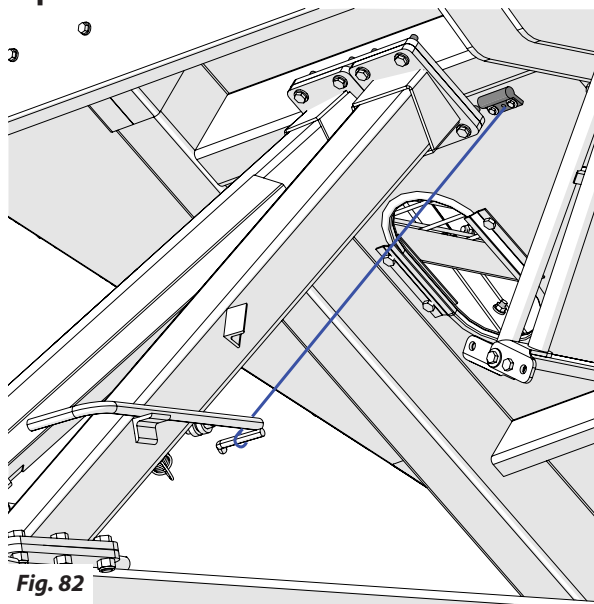
- Install the hydraulic hoses.
- Tighten all fittings once installed.
- Secure all hoses with zip-ties.

**Top Auger should be in Unload Position through-out this step.**



## Step 53

**Top Auger should be in Field Position through-out this step.**



- Install the cable for the "over-center handle," which controls the movable auger rest.
- Fasten the cable to the upper auger rest using a small cable clamp.
- Route the cable according to the images ABOVE. Wrap the cable between the spring and handle.
- Pull the cable tight then fasten with small cable clamp.



## Step 54

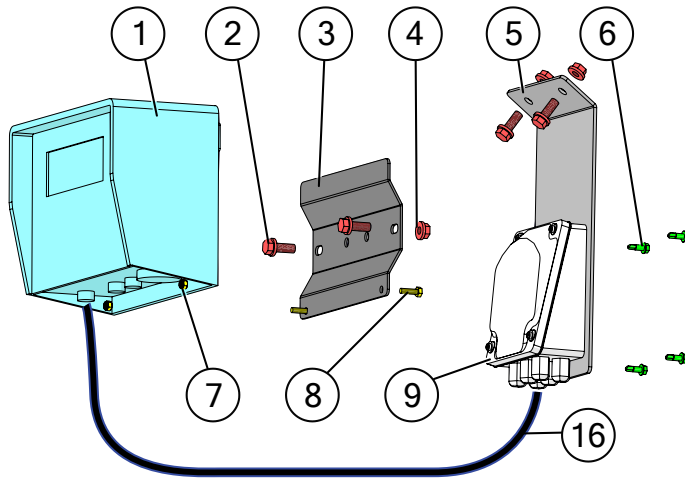


Fig. 86

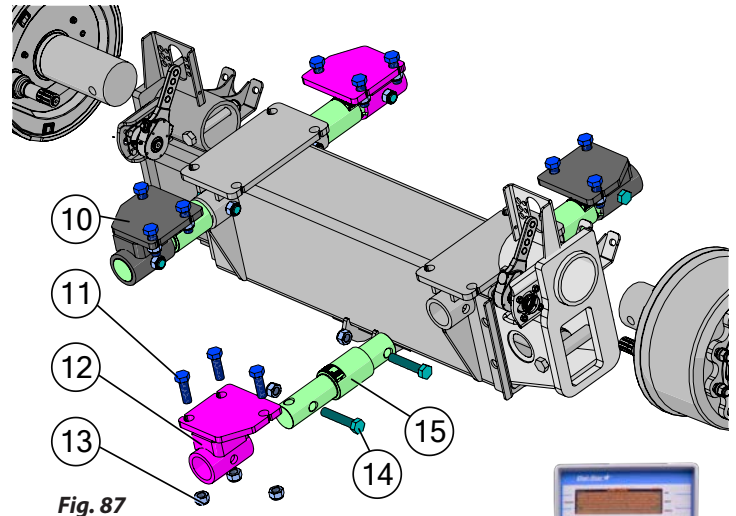


Fig. 87

\*Insert short end of scale bars into axle with labels facing up.

Description	Part No.
1 GT 400 Digi-Star Scale Display Monitor	JM0019040
1 GT 560 Digi-Star Scale Display Monitor	JM0044177
2 M10-1.5 x 25 Gr8.8 YZ SF Hex Bolt	JM0002093
3 GT 400 Scale Monitor Display Bracket	JM0000361
3 GT 560 Scale Monitor Display Bracket	JM0046976
4 M10-1.5 Gr8.8 YZ SF Hex Nut	JM0002154
5 Bolt Together Junction Box Mount	JM0000366
6 1/4" x 3/4" Self Tapping Screw	JM0001570
7 M6-1.0 Gr8.8 YZ Nylon Locking Hex Nut	JM0002167
8 M6-1.0 x 20 Gr8.8 YZ Hex Bolt	JM0002120
9 Digi-Star 6-Point Junction Box (JB-5)	JM0019038
10 External 5 Pt Scale Mount - Narrow Pad (Rear Left, Front Right) (1925, 2431)	JM0029540
11 M24-3.0 x 75 Gr8.8 Hex Bolt	JM0002118
12 External 5 Pt Scale Mount - Narrow Pad (Rear Right, Front Left) (1925, 2431)	JM0030032
13 M24-3.0 Gr8.8 YZ Nylon Locking Hex Nut	JM0002165
14 M24-3.0 x 125 Gr8.8 YZ Hex Bolt	JM0031228
15 2-7/8" Digi-Star Weigh Bar, 1" Pin Hole (278WB-T1)	JM0000355
16 8' Cable from J-Box to Indicator (Digi-Star)	JM0047238



Fig. 88

GT 400



Fig. 89

GT 560

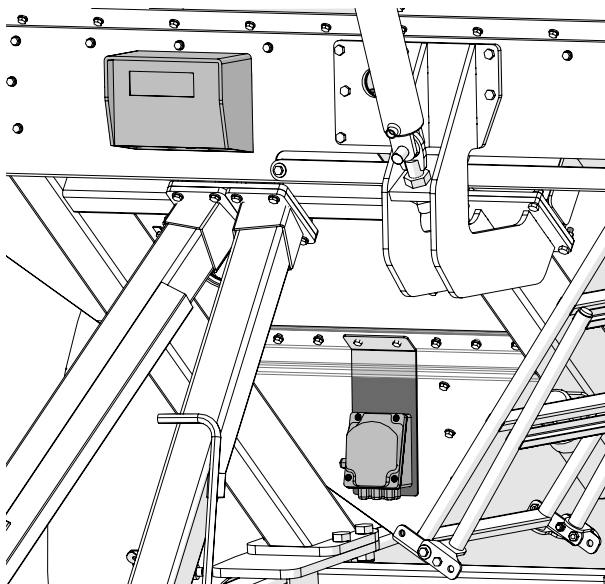
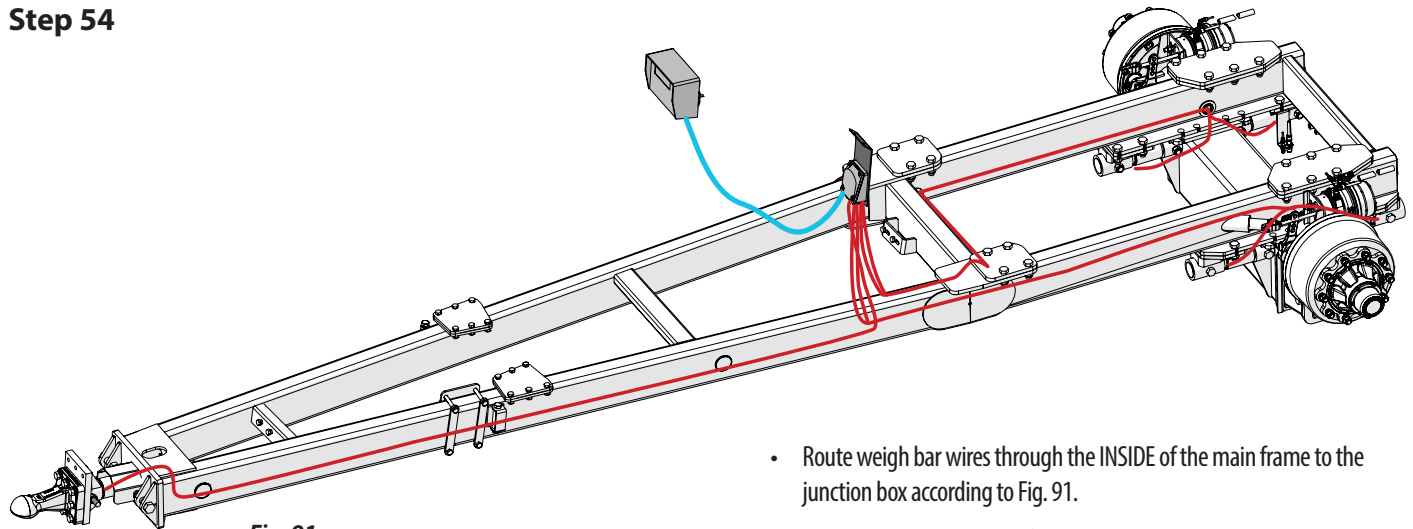


Fig. 90

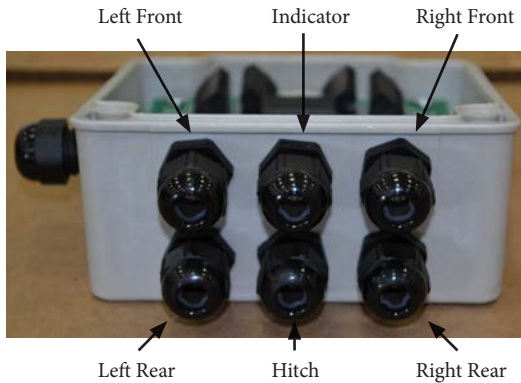
- Install the scale indicator and junction box mounts.
- Attach the scale indicator to the front faceplate using (2) M10 x 25 hex bolts and hex nuts.
- Attach the junction box mount using (2) M10 x 25 hex bolts and hex nuts.
- Fasten hardware.

## Step 54

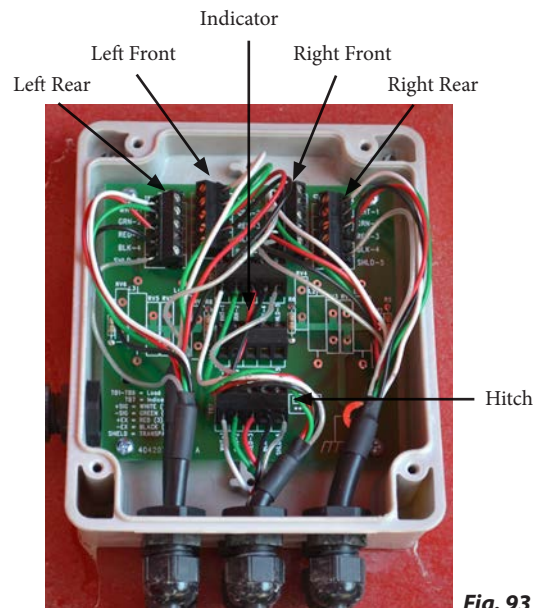


**Fig. 91**

- Route weigh bar wires through the INSIDE of the main frame to the junction box according to Fig. 91.



**Fig. 92**



**Fig. 93**

- Insert all of the wires into the Junction Box according to the diagram above. Connect the wires to the terminal of the Junction Box by matching the colored wires.
- Once finished replace cover of the Junction Box.
- Attach the cord wrap around the wires running from the frame to the Junction Box.
- Attach the cord wraps for all four rear weigh bars.
- Connect the display screen to the battery. The red wire is to be run to the positive side (+) and the black wire is to be run to the negative side (-).

Digi-Star

Junction Box Wiring Diagram

+Sig = White

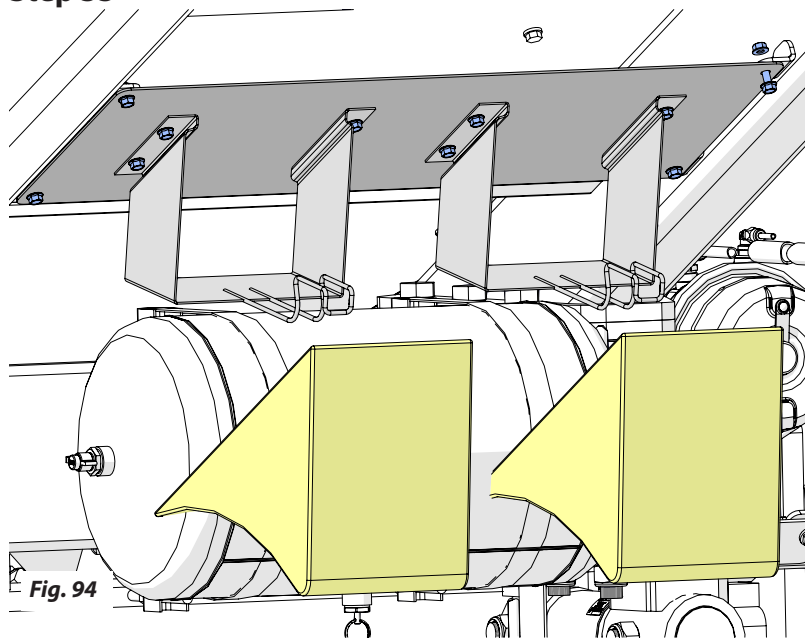
-Sig = Green

+Exc = Red

-Exc = Black

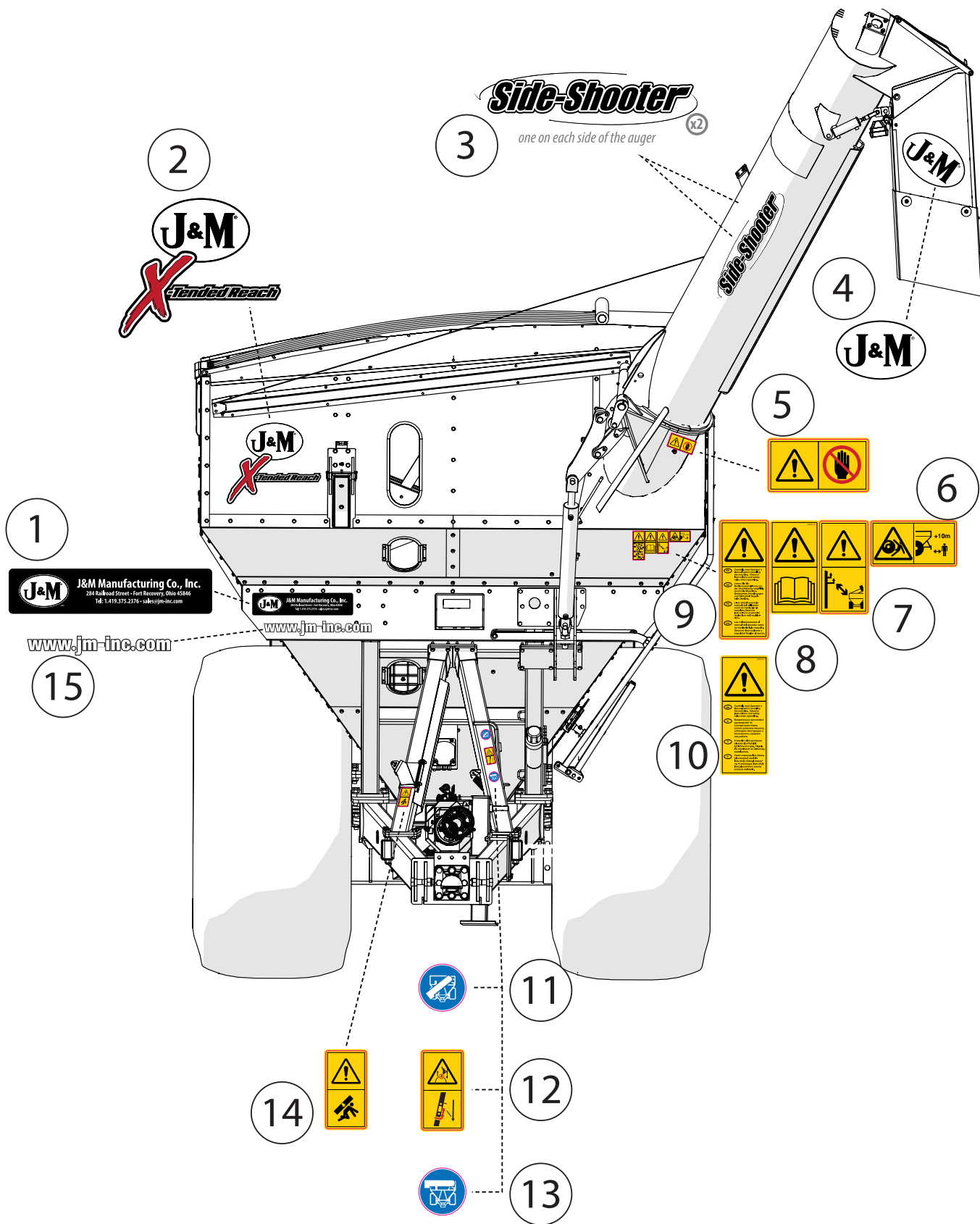
Shield = Orange

## Step 55

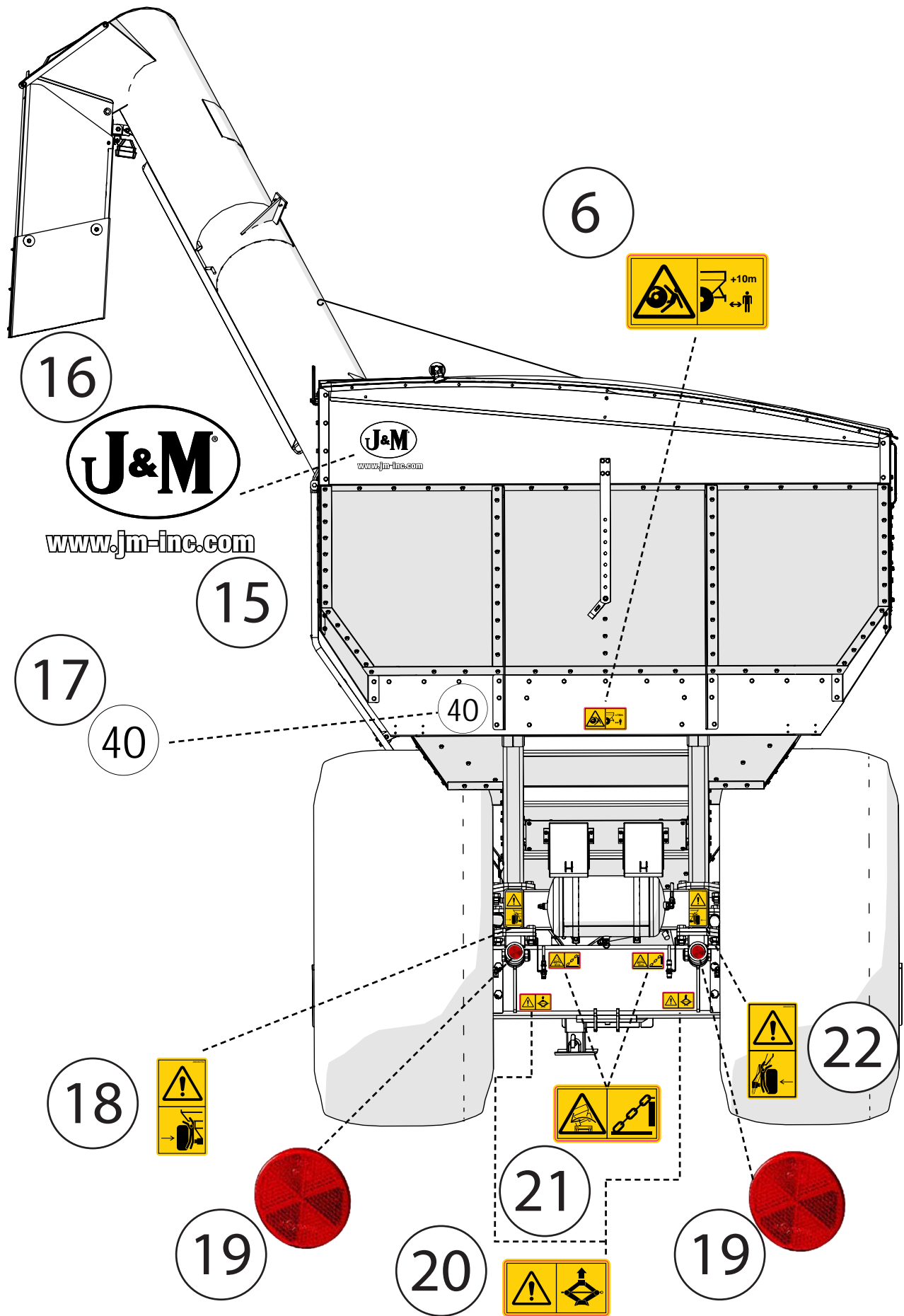


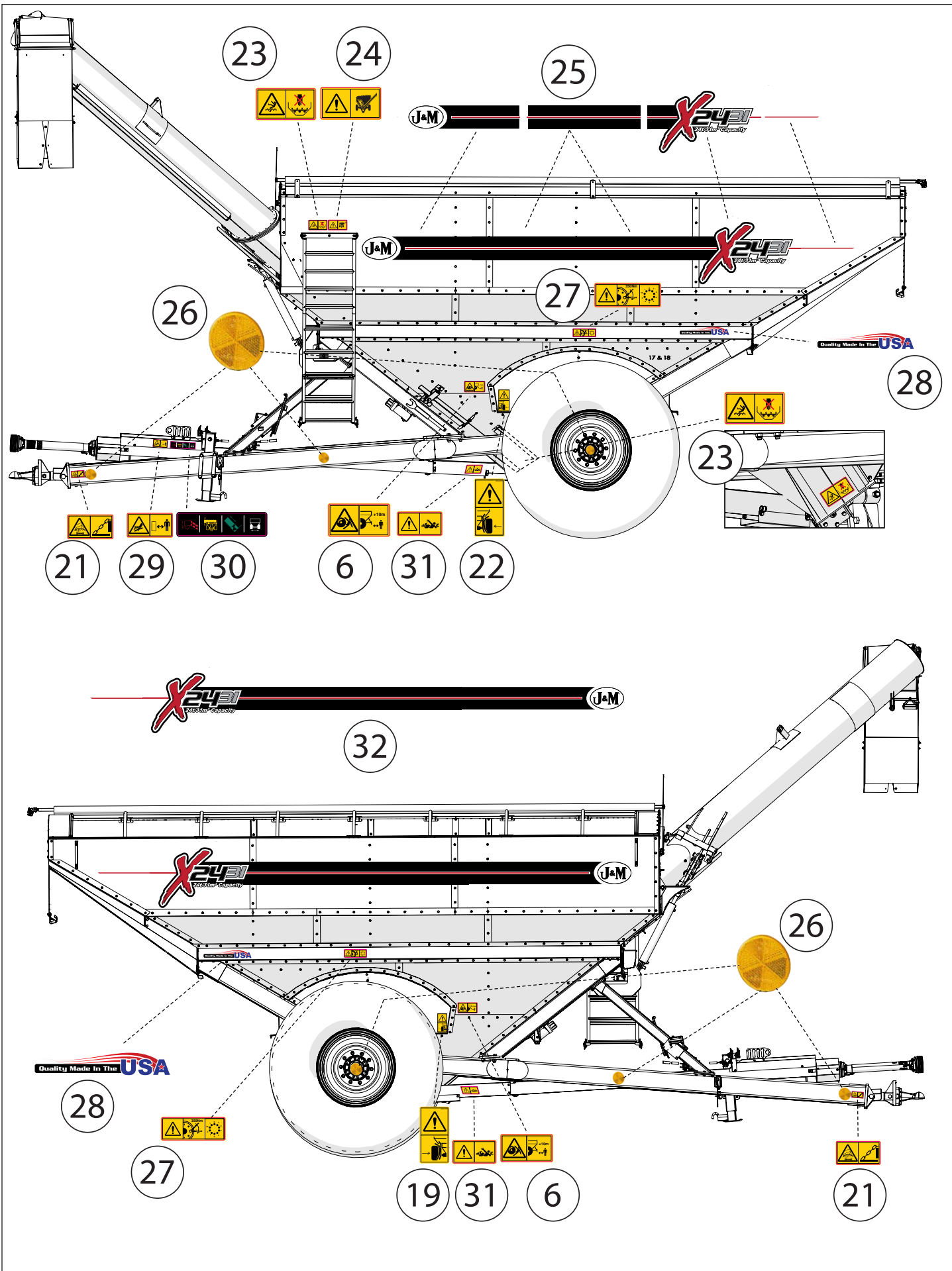
- Install wheel chocks onto the rear of the cart.
- Mount wheel chock plate using (4) M8 x 20 hex bolts and (4) M8 serrated flange hex nuts.
- Mount wheel chock holders onto wheel chock plate using (4) M8 x 20 hex bolts and (4) M8 serrated flange hex nuts each.
- Pull down on the wire and slide wheel chocks in as shown until wire wraps around and holds chock in place.

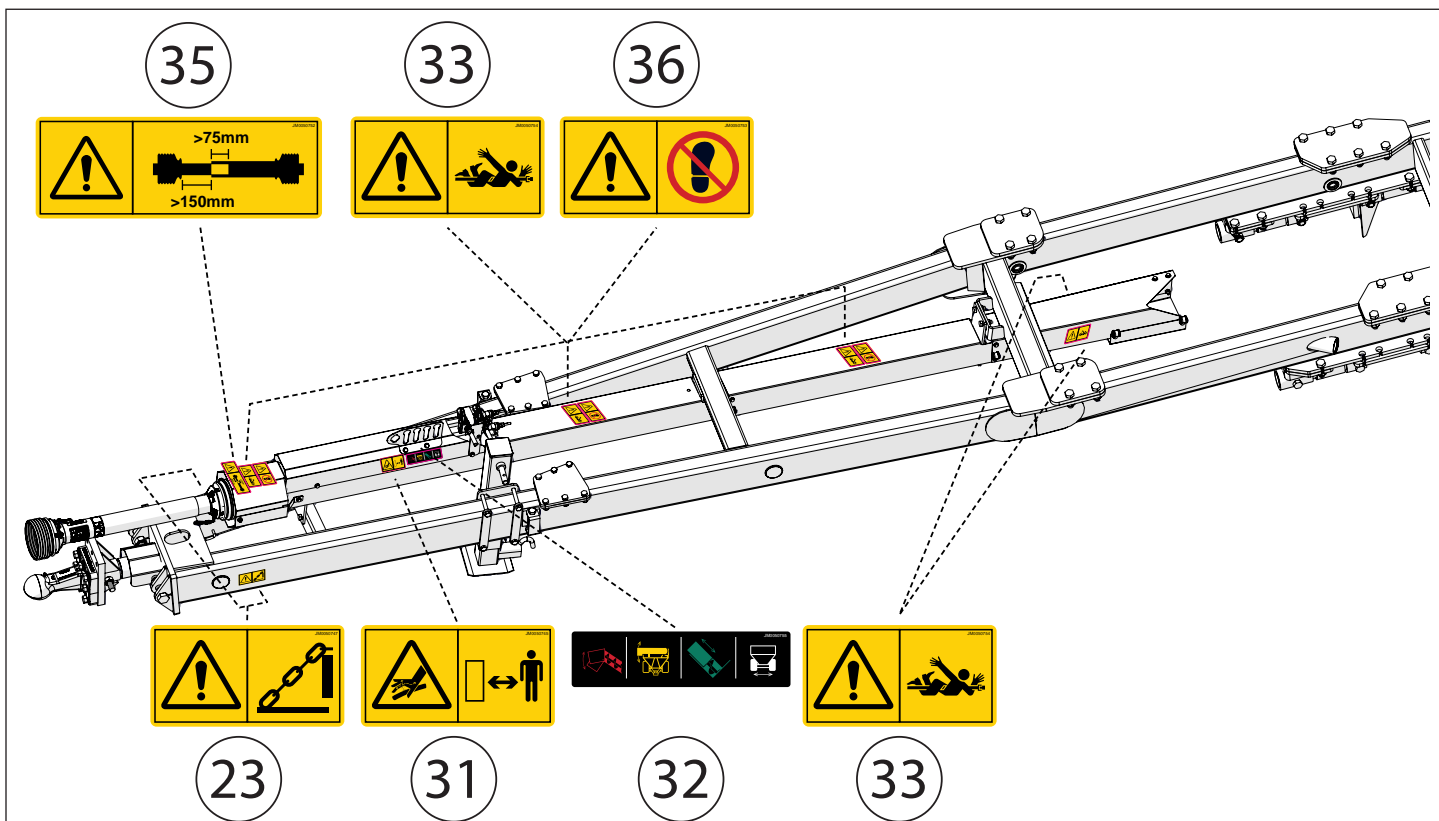
# Step 56











- Step 56**
- For a complete sealed cart, use polyurethane or caulking (acid-free) around the seams between panels. It is recommended to prevent any water damage or leaking by using caulking or polyurethane over all seams between panels. Apply caulking to the outside of the cart.

- Step 57**
- See "Adjusting The Upper Auger" service guide for instructions on how to set the upper auger.
  - See "ADR Brake Setting" to set the brakes.
  - Read and understand the owners manual before operation.



