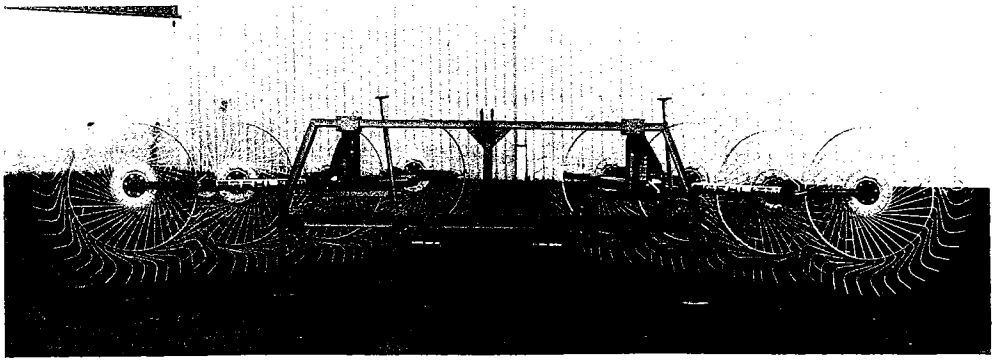
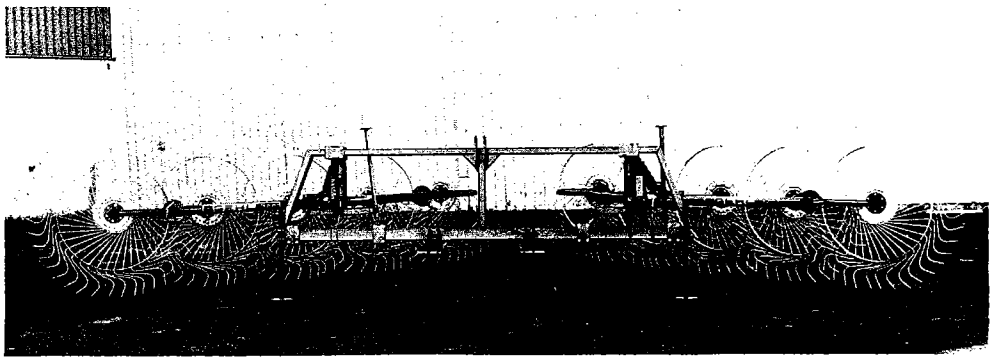
Form No.
904073

318/320 Finger Wheel V-Rakes

WR318



WR320



OPERATOR'S AND SERVICE PARTS MANUAL

GEHL® COMPANY

Warranty

GEHL COMPANY
New Agricultural Equipment

GEHL Company (Incorporated), hereinafter referred to as GEHL, as manufacturer of quality machinery since 1859, warrants new GEHL machinery and/or attachments at the time of delivery to the original purchaser to be free from defects in material and workmanship if properly set up and operated in accordance with the recommendations set forth in GEHL's Operator Manual.

GEHL's liability for any defect with respect to accepted goods shall be limited to repairing the goods at an authorized GEHL dealer or other GEHL designated location, or replacing them, as GEHL shall elect. The above shall be in accordance with GEHL warranty adjustment policies. GEHL's obligation shall terminate twelve (12) months after the delivery of the goods to the original user or when the equipment is first put into use.

This warranty shall not apply to any machine or attachment which shall have been repaired or altered outside the GEHL factory or authorized GEHL dealership or in any way so as in GEHL's judgment, to affect its stability or reliability, nor which has been subject to misuse, negligence or accident, nor to any machine or attachment which shall not have been operated in accordance with GEHL's printed instructions or beyond the Company recommended machine rated capacity.

This warranty shall not be limited to items which are subject to the warranties of their respective manufacturers. Such items would include but would not be limited to engines, clutches, universal joints, knives, hydraulic components, bearings, tires, belts and other trade accessories.

EXCLUSION OF WARRANTIES

Except as otherwise expressly stated herein, GEHL makes no representation or warranty of any kind, express or implied, AND MAKES NO WARRANTY OF MERCHANTABILITY IN RESPECT TO ITS MACHINERY AND/OR ATTACHMENTS AND MAKES NO WARRANTY THAT ITS MACHINERY AND/OR ATTACHMENTS ARE FIT FOR ANY PARTICULAR PURPOSE. GEHL shall not be liable for incidental or consequential damages for any breach of warranty, including but not limited to inconvenience, rental or replacement equipment, loss of profits or other commercial loss. GEHL shall not be liable for, and the buyer assumes all liability for, all personal injury and property damage resulting from the handling, possession or use of the goods by the buyer.

No agent, employee or representative of GEHL has any authority to bind GEHL to any affirmation, representation or warranty concerning its machinery and/or attachments except as specifically set forth herein.

TABLE OF CONTENTS

CHAPTER 1

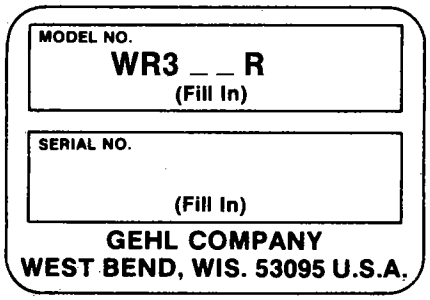
INTRODUCTION

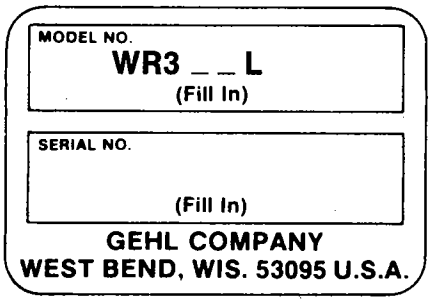
Your decision to purchase this piece of GEHL equipment was a good one. We are sure that your decision was strongly considered and that you are looking forward to many seasons of reliable performance from this machine.

We, as a Company, have invested a great deal of time and effort in developing our lines of agricultural and industrial equipment. The equipment you have purchased is built with a great deal of pride and designed to give you long life, efficient operation, durability and dependability. We ask that you study this manual carefully and familiarize yourself with the unit prior to using it; especially the information on safe operation contained in the **SAFETY** chapter. The information, contained within, was prepared for your assistance in preparing, adjusting, maintaining and servicing your machine. More importantly, this manual provides an operating plan for safe and proper use of your machine. Refer to the Table of Contents for an outline of this manual.

Modern machinery has become more sophisticated and with that in mind, GEHL Company asks that you read and understand the contents of this manual COMPLETELY and become familiar with your new machine, BEFORE you attempt to operate it. Furthermore, we recommend if this machine is re-sold that this Manual accompany the unit.

Typical Model & Serial No. Plate





The Model and Serial numbers are on a decal plate located on the backside of the Moveable Head of each Rake assembly.

"Right" and "Left" are determined from a position standing behind the V-Rake and facing the direction of travel.

Our wide Dealership network stands by to provide any assistance required, including genuine GEHL service parts. All parts should be obtained from or ordered through your GEHL Dealer. Give complete information about the part as well as the model number and serial numbers of your machine. Record numbers, in the spaces provided as a handy record for quick reference.

GEHL Company reserves the right to make changes or improvements in the design or construction of any part without incurring the obligation to install such changes on any unit previously delivered.

Throughout this manual, information is provided which is set in **bold type** and introduced by the word **NOTE. BE SURE** to **read carefully** and **comply with** the message or directive given. Following this information will improve your operating or maintenance efficiency, help you to avoid costly breakdowns or unnecessary damage and extend your machine's life.

The GEHL Company, in cooperation with the Farm and Industrial Equipment Institute, has adopted this SAFETY ALERT SYMBOL

to pinpoint characteristics which, if NOT properly followed, can create a safety hazard. When you see this symbol in this manual or on the unit itself, you are reminded to BE ALERT! Your personal safety is involved!

CHAPTER 2

SPECIFICATIONS

All Dimensions are in Inches (Millimeters) Unless Otherwise Noted

Models & Descriptions	WR318 & WR320 Finger Wheel V-Rakes
Mounting	To Catagory I or II Tractor 3-Point Hitch
Finger Wheel Diameters	55-1/8 (1400)
Number of Tines per Finger Wheel	Forty
Transport Width	114 to 162 (2895 to 4115) for **318** or 114 to 174 (2895 to 4420) for **320***
Minimum Power Required	35 hp (28 kw)
Operating Speed	Up to 14 mph (9 kmh)
Number of Finger Wheels	Eight (**for 318**) or Ten (**for 320**)
Raking Width	Up to 216 (5485) (**for 318**) or 264 (6705) (**for 320**)

*Depending on position of Finger Wheels in Transport Position.

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CHAPTER 3

CHECKLISTS

PRE-DELIVERY

After the Finger Wheel V-Rake has been completely set-up, the following inspections should be made before delivering it to the Customer. Check off each item after prescribed action is taken.

Check that:

___ **NO** parts of the unit have been damaged in shipment. Check for such things as dents and loose or missing parts; correct or replace components as required.

___ Finger Wheel V-Rake has been completely and properly set-up according to the details in this manual

___ All fasteners are in place and tightly secured.

___ All Guards, Shields and Decals are in place and securely attached.

___ Model and Serial Numbers of this unit are recorded on this page and page 2.

_____
Dealership's Name

_____
Dealer Representative's Signature

_____
Date Checklist Filled-out

_____
Model & Serial Numbers

DELIVERY

The following Checklist is an important reminder of valuable information that MUST be passed on to the Customer at time the unit is delivered. Check off each item as you explain it to the Customer.

___ Give the Operator's & Service Parts Manual to the Customer. Instruct Customer to **BE SURE** to read and completely understand its contents **BEFORE** operating the unit.

___ Explain and review with Customer the **SAFETY** information in this manual.

___ Explain the function and demonstrate the use of the Transport(Storage) Latch.

___ Completely fill out the Owner's Registration, including Customer's signature, and return to the GEHL Company.

I acknowledge that above points were reviewed with me at the time of delivery.

_____
Customer's Signature

_____
Date Delivered

(Dealer's File Copy)

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(To be removed as Dealer's File Copy)

CHAPTER 3

CHECKLISTS

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Dealership's Name

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I acknowledge that above points were reviewed with me at the time of delivery.

_____

Customer's Signature

_____

Date Delivered

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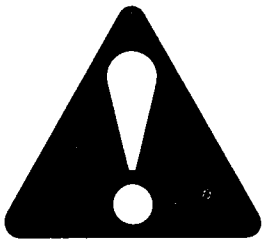
CHAPTER 4



SAFETY

BEFORE ATTEMPTING TO OPERATE THIS EQUIPMENT, READ AND STUDY THE FOLLOWING SAFETY INFORMATION. IN ADDITION, ALWAYS MAKE SURE THAT EVERY INDIVIDUAL WHO OPERATES OR WORKS WITH THIS EQUIPMENT IS FAMILIAR WITH THESE SAFETY PRECAUTIONS.

GEHL Company always takes the operators and their safety into consideration when designing its machinery and guards exposed, moving parts for their protection; some areas, however, cannot be guarded or shielded in order to assure proper operation. In addition, the operator's manual and Decals on the machine itself warn of further danger and **MUST** be read and observed closely.

The safety alert symbol means **ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!** It stresses an attitude of **"HEADS UP"** for safety and it will be found throughout this manual and on the machine itself.

Remember: The careful operator is the best operator. Most accidents are caused by human error. Certain precautions must be observed to prevent the possibility of injury or damage.

The words **CAUTION, WARNING** and **DANGER**, used herein and on the machine itself, signal three degrees of hazard. **CAUTION** is used for a general reminder of good safety practices or to direct attention to unsafe practices. **WARNING** is used to denote a specific potential hazard. **DANGER** is used to denote the most serious specific potential hazard.

Please read the rules listed below for safe operation **BEFORE** you operate this equipment.

MANDATORY SAFETY SHUTDOWN PROCEDURE

Work of any type on machinery is always more dangerous when the machine is operating. Therefore, unless otherwise expressly instructed to the contrary, BEFORE cleaning, adjusting, lubricating or servicing this machine, the following MANDATORY SAFETY SHUTDOWN PROCEDURE should ALWAYS be followed:

Shut the tractor engine off and remove the ignition key and take it with you before leaving the tractor seat to remedy the problem.

Only when you have taken these precautions can you be sure it is safe to proceed. Failure to follow the above procedure could lead to death or serious bodily injury!

BEFORE transporting the Wheel Rake on a public highway, take the time necessary to place the Rake in the "Transport" position!

BEFORE placing Rake into Transport position and while transporting, avoid contact with overhead power lines!

BEFORE disconnecting the Wheel Rake from the tractor or transporting it on a public highway, engage the Transport (Storage) Latch!

Wheel Rake operation is a function of the travel of the tractor; to STOP the Rake, STOP the tractor!

The operator MUST be seated on the tractor seat at all times while operating this machine!

BEFORE making any adjustments or repairs on the Wheel Rake, shut off the tractor engine, remove the ignition key and take it with you BEFORE leaving the tractor seat!

BE SURE to review and comply with ALL Safety recommendations set forth in tractor operator's manual!

Do NOT allow minors to operate or be near this machine unless properly supervised!

Do NOT allow personnel other than a qualified tractor operator near this machine!

Do NOT wear loose or baggy clothing when operating this machine!

CHAPTER 5

OPERATION

CAUTION: BEFORE starting the tractor engine and operating the Finger Wheel Rake for the first time, review and comply with ALL SAFETY recommendations set forth in the SAFETY chapter of this manual.

EMERGENCY SHUTDOWN

In an emergency or in case material or a foreign object becomes lodged in or between the Finger Wheels, stop Rake operation **IMMEDIATELY** by stopping tractor forward movement.

CAUTION: BEFORE proceeding, exercise the following MANDATORY SAFETY SHUTDOWN PROCEDURE; shut the tractor engine off and remove the ignition key and take it with you before leaving the tractor seat to remedy the problem.

GENERAL INFORMATION (Figs. 5-1 & 5-2)

The GEHL 318 and 320 Finger Wheel Rakes are suitable for raking, turning or spreading hay, straw, grass, etc. Both models consist of a Right and a Left Rake assembly mounted onto a Toolbar Frame assembly which conveniently mounts to the 3-point hitch of a Category I or Category II tractor.

NOTE: The Lower Link Pins are reversible to accomodate V-Rake mounting on either a Category I or Category II tractor.

The Finger Wheel Tine pressure on the ground is the most important factor toward achieving clean raking. If too much pressure is applied against the ground, unnecessary dirt and trash will be brought into the windrow. Finger Wheel to ground pressure is established and adjusted by appropriate positioning of the tractor lower links. Most tractors are equipped with a downstop adjustment on the control lever which should be adjusted and locked, after the desired position is achieved.

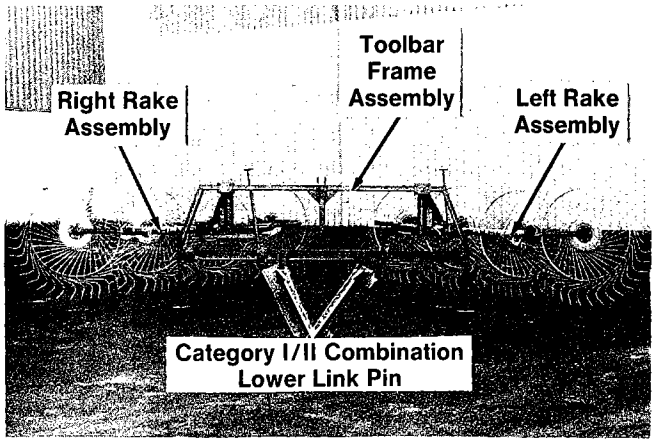


Fig. 5-1: WR318 V-Rake

ASSEMBLED RAKE ATTACHMENT (Figs. 5-1, 5-2 & 5-3)

To attach either model Rake to a tractor 3-point hitch, proceed as follows:

NOTE: Assembled Rake detachment can be accomplished by reversing the following attachment procedure.

1. Back up the tractor so that the 3-point lower links are aligned with the Lower Link Pins on the Toolbar Frame. Then, install and secure the tractor lower links onto the Toolbar Lower Link Pins with Lynch Pins (**NOT** provided).

2. Raise the tractor 3-point lower links so that the Park Stands clear the ground. Then, raise and store the Park Stands.

3. Lower the tractor 3-point lower links to align the 3-point upper link with Toplink Brackets on the Toolbar Frame. Then, install and secure the 3-point upper link to the Brackets with an appropriately-sized hitch pin and lock pin (**NOT** provided).

NOTE: Adjust tractor upper link so that the Toolbar Frame is vertical.

Proceed to adjust the Rake for raking, spreading or turning following details in the Adjustments chapter or place the Rake in the Transport position, for highway travel, following details under the next topic.

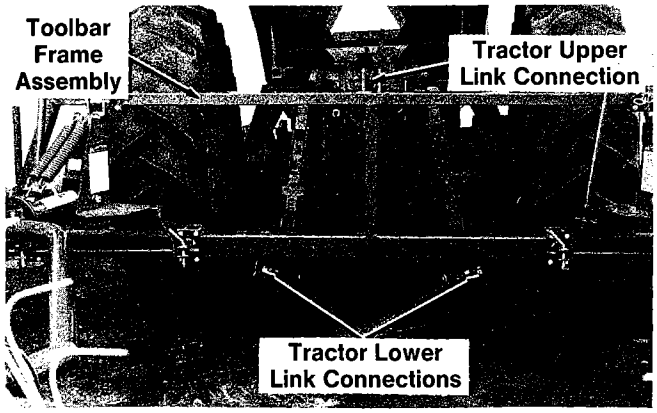


Fig. 5-2

TRANSPORTING (Figs. 5-2 thru 5-8)

DANGER: Whenever the Rake is raised for or being transported, maintain a safe distance away from all overhead high voltage power lines!

WARNING: ALWAYS observe appropriate regulations regarding highway transportation of this or any farm equipment!

When transporting either model Rake on a public highway, the Transport (Storage) Latches for both the Right and Left Rake assemblies **MUST** be engaged and both Rake assemblies and Finger Wheels should be repositioned to reduce the overall width of the Rake. To place either model Rake in the Transport position, proceed as follows:

NOTE: On tractors with adjustable 3-point hitch links, it may be necessary to adjust the tractor links to their shortest lengths before proceeding to place the V-Rake in the transport position.

1. Using the tractor 3-point control, raise the Rake as far off the ground as possible.

2. Pull the Moveable Head Pins and reposition the Arms on both the right and left assemblies so that they are in the centers of their moveable Heads and place the Pins into their Transport holes.

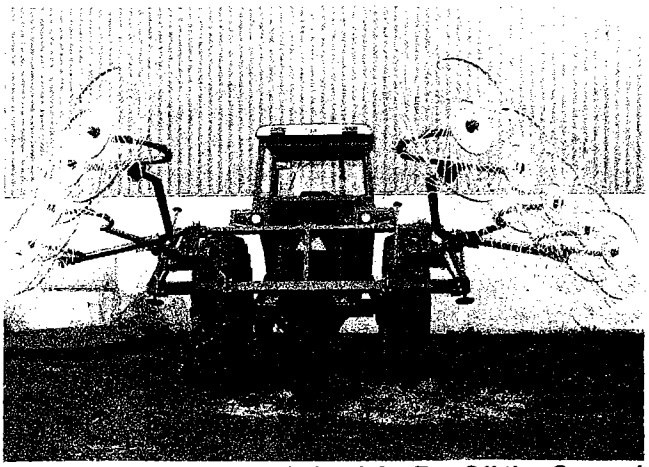


Fig. 5-3: WR320 Rake Raised As Far Off the Ground As Possible

3. Following the detail shown on the Warning Decal on each Rake assembly, engage the Transport (Storage) Latch by detaching the Lock Pin, pulling the Pin w/Chain and repositioning the Latch. Then, replace the Pin w/Chain and resecure the Lock Pin.

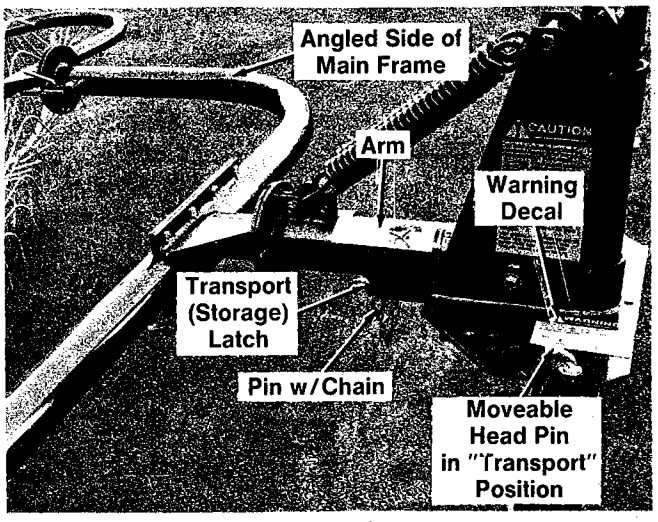


Fig. 5-4

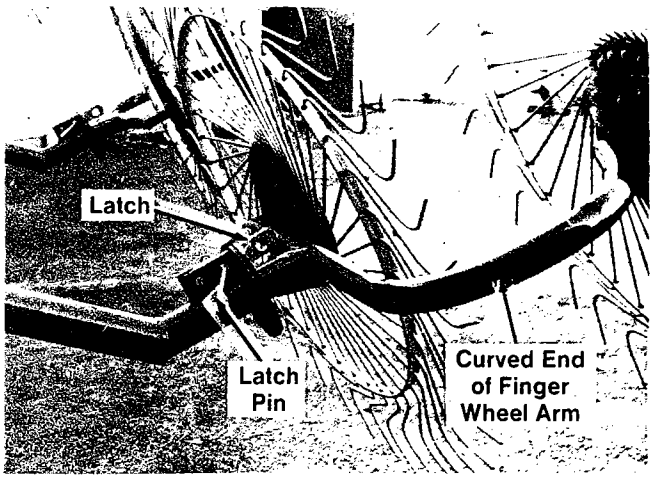


Fig. 5-5

NOTE: To achieve the narrowest overall transport width of 144" (3660mm) the Main Frames and Finger Wheel Arms should all be rotated and latched in their vertical positions. To achieve the most ground clearance, the Main Frames should be oriented with their angled sides down and curved ends of the bottom Finger Wheel Arms also facing down.

4. Unlatch and rotate the right and left Main Frame so that the angled sides are facing down.

NOTE: To minimize the overall height of the V-Rake, and if the tractor 3-point hitch can NOT raise the Rake so that ample clearance exists for transporting, rotate the lower Finger Wheel Arms to their horizontal positions with their curved ends facing outward; this will increase the overall width of the 318 model from 144" (3660mm) to 162" (4115mm) and the 320 model from 144" (3660mm) to 176" (4470mm).

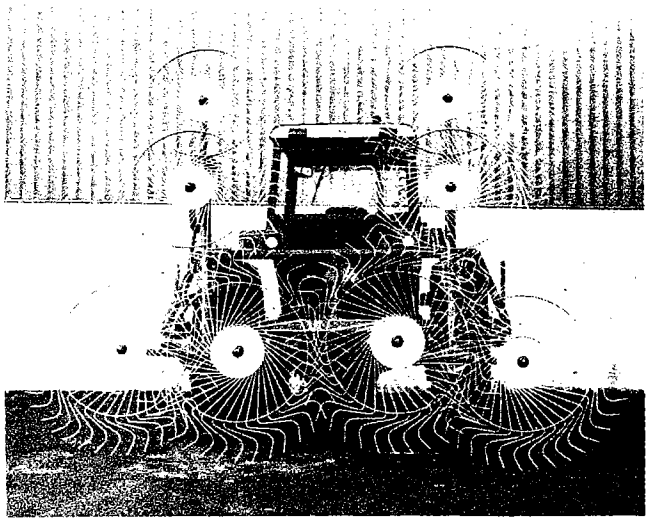


Fig. 5-6: WR318 Finger Wheel Rake in "Transport" Position

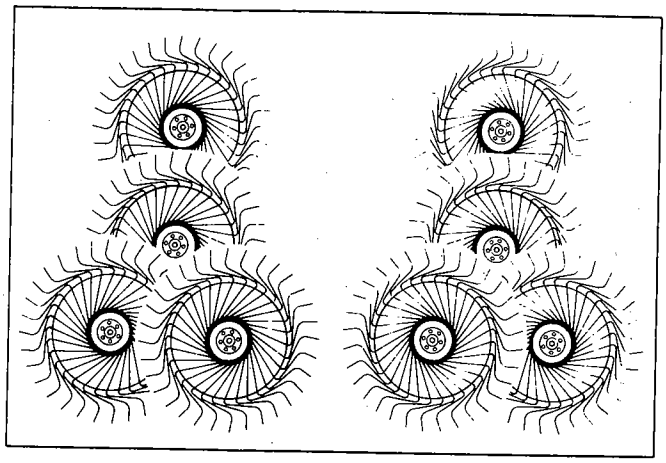


Fig. 5-7: Preferred WR318 Wheel Rake Transport Position

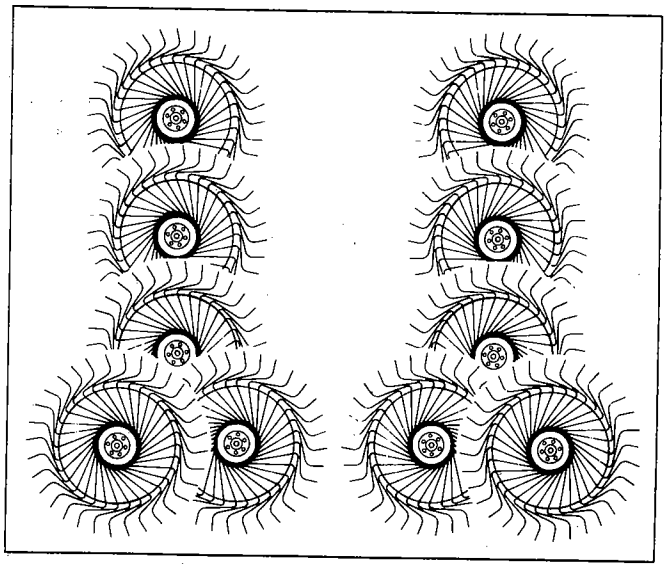


Fig. 5-8: Preferred WR320 Wheel Rake Transport Position

RAKE OPERATION (Fig. 5-9 & see Fig. 5-1)

Operation for either model Rake is quite similar with the 320 model having an additional Finger Wheel extending from the center of both the Right and Left Main Frames to provide a nominal 32″ (813 mm) of additional raking width on each side. The way both model Rakes are setup, the Finger Wheels on the Right Rake assembly will rotate to the right (clockwise) and the crop will traverse from right to left and, the Finger Wheels on the Left Rake assembly will rotate to the left (counterclockwise) and the crop will traverse from left to right. The overall width of either model Rake can be adjusted by repositioning both Main Frames with respect to their Moveable Heads. Refer to the Adjustments chapter for additional details.

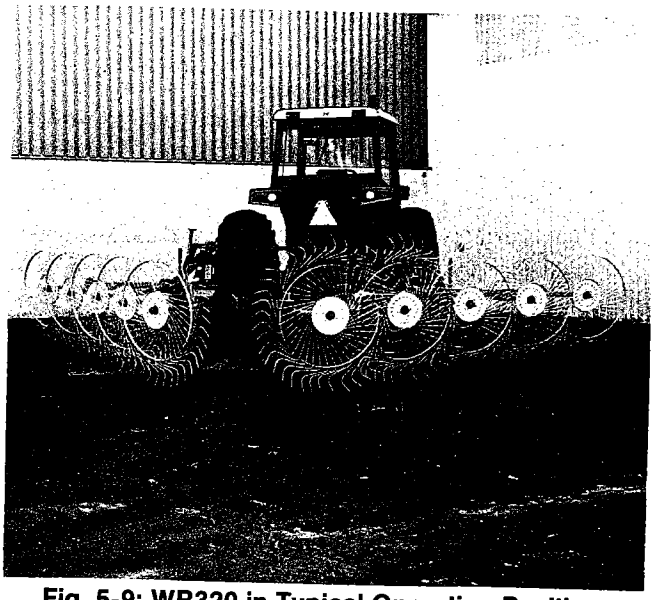


Fig. 5-9: WR320 in Typical Operating Position

CHAPTER 6

ADJUSTMENTS

CAUTION: BEFORE proceeding to make any adjustments on the Finger Wheel Rake, exercise the MANDATORY SAFETY SHUT-DOWN PROCEDURE (page 8). In addition, BE SURE to place the tractor transmission in park and/or lock the brakes, to shut off the engine and, to remove the ignition key and take it with you BEFORE leaving the tractor seat.

GROUND PRESSURE (Fig. 6-1)

NOTE: Proper Finger Wheel pressure on the ground is an important factor for achieving clean raking. Too much pressure will cause undue stress on the Finger Wheel Tines and cause unnecessary dirt and trash to be brought into the windrow.

Finger Wheel to ground pressure is a factor of how far the tractor lower links descend. Some tractors are equipped with a control lever down-stop to limit the lever travel. On tractors which do **NOT** have this type of limit stop, limit chains should be purchased separately and used to prevent exceeding the predetermined lower travel limit. Limit chains may also be useful for tractors with faulty hydraulic systems that leak-down when hydraulic system power is removed.

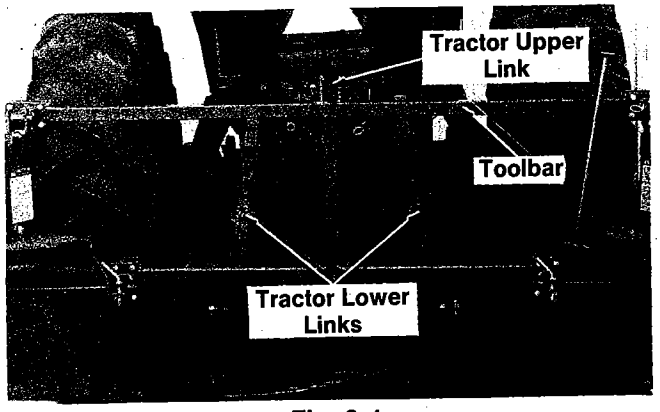


Fig. 6-1

RAKING (Figs. 6-2 thru 6-4)

NOTE: BEFORE attempting to operate either model Rake, BE SURE that the Transport (Storage) Latches are disengaged on both the right and left Rake assemblies.

Normally, the Finger Wheels on the Right and Left Rake assemblies are all positioned to overlap each other as shown. The cut material is then raked from right to left by the Right Rake assembly and from left to right by the Left Rake assembly. The Main Frames of both the right and left Rake assemblies can be adjusted to any one of three position to obtain three different raking widths as well as to accomodate different crop and field conditions. After the desired width is established, **BE SURE** to fix the adjusted position by reinstalling and locking each Lock Pin. As necessary, readjust the ground pressure per the preceding information.

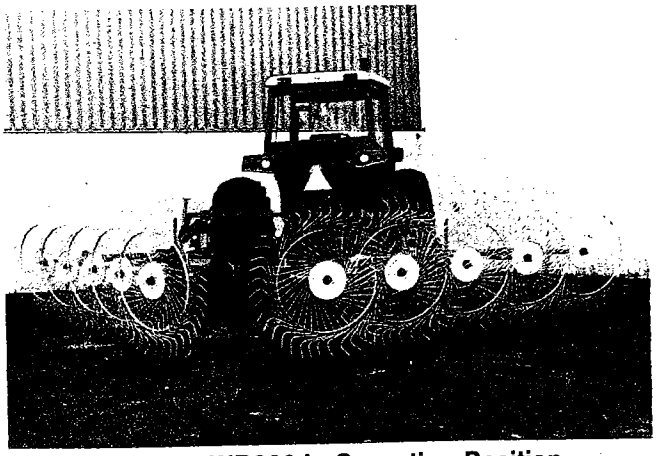


Fig. 6-2: WR320 in Operating Position

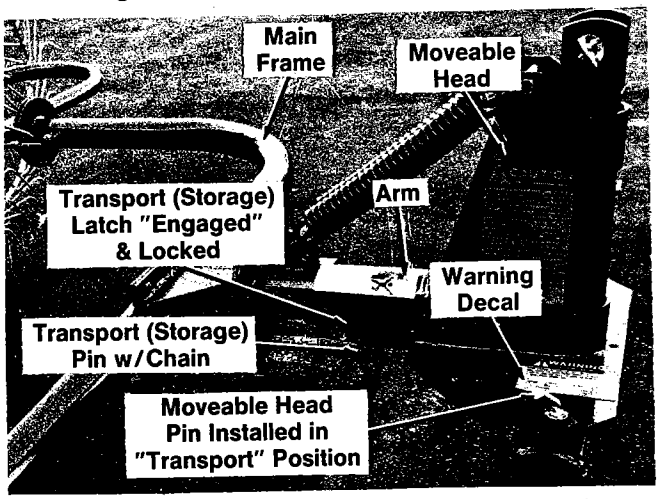


Fig. 6-3

SPREADING (Fig. 6-5)

NOTE: BEFORE attempting to operate either model Rake, BE SURE that the Transport (Storage) Latches of both the right and left Rake assemblies are disengaged.

In a spreading operation, the Finger Wheels move the crop from right to left separately on the Right Rake assembly and, from left to right on the Left Rake assembly. In wide swaths, eight (for the model 318) or ten (for the model 320) smaller widths windrows can be formed from four (or five) large windrows in a single pass. As conditions permit, eight (for the model 318) or ten (for the model 320) small swaths can also be spread into eight or ten small windrows respectively. Most spreading operation are carried-out with the width of both the Right and Left Rake assemblies adjusted to either hole position shown.

NOTE: If it becomes difficult to get the crop out of the Rake, reduce the width of the Rake by locating the Arms in different hole positions in their respective Moveable Heads. ALWAYS drive the tractor and operate the Rake in the appropriate direction which enables the Finger Wheels to work the tops of the crops first.

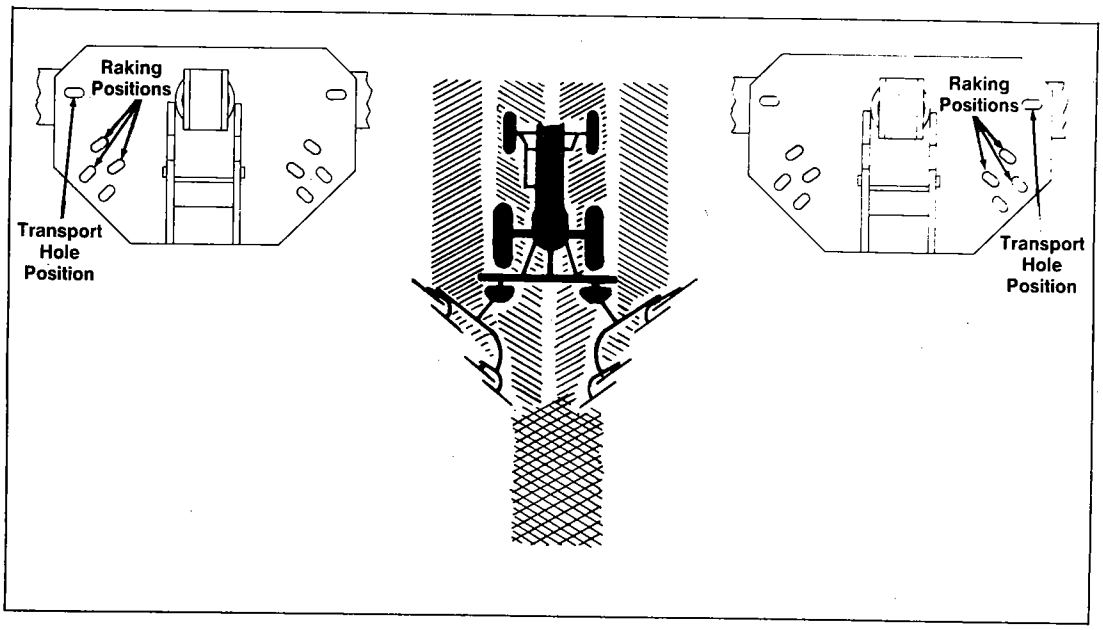


Fig. 6-4: Raking Detail

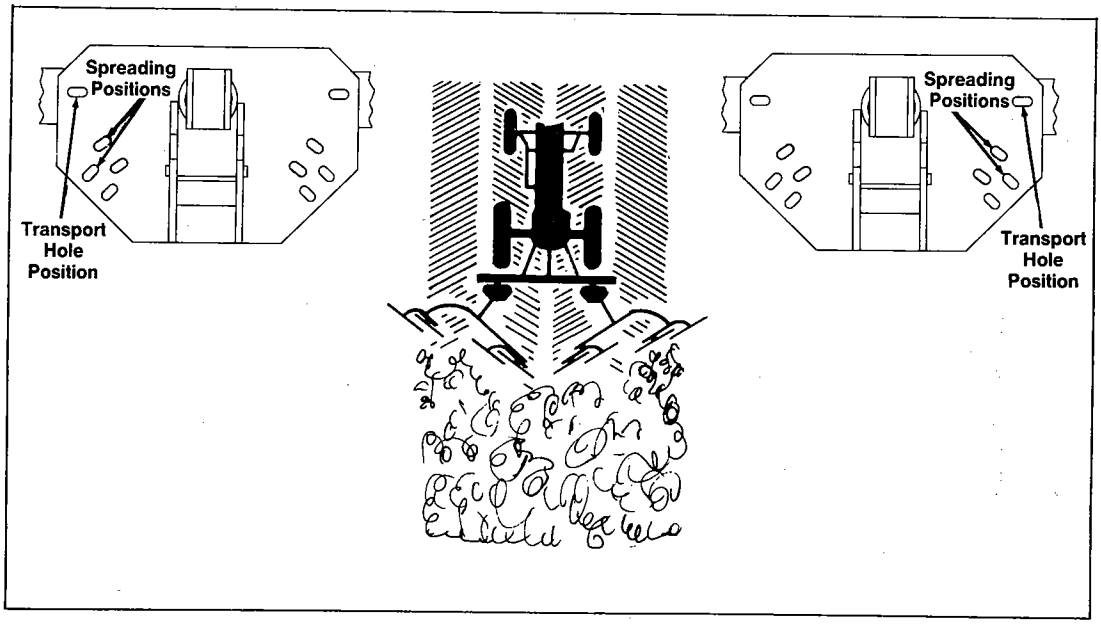


Fig. 6-5: Spreading Detail

TURNING (Fig. 6-6)

The following information applies mainly only to the 318, 8-Finger Wheel model. The model 320 model can also be used for turning however, the center Finger Wheel will form a narrower windrow than the pairs of Finger Wheels on each end of both the right and left Rake assemblies.

NOTE: BEFORE attempting to operate either model Rake, BE SURE that the Transport (Storage) Latches are disengaged on both the Right and the Left Rake assemblies.

In the turning operation, the Arm is set in either hole position shown, on both Moveable Heads so that four swaths can be turned at the same time. This process is normally used after the crop has been spread.

NOTE: ALWAYS drive the tractor and operate the Rake in the appropriate direction which enables the Finger Wheels to work the bottoms of the crop first.

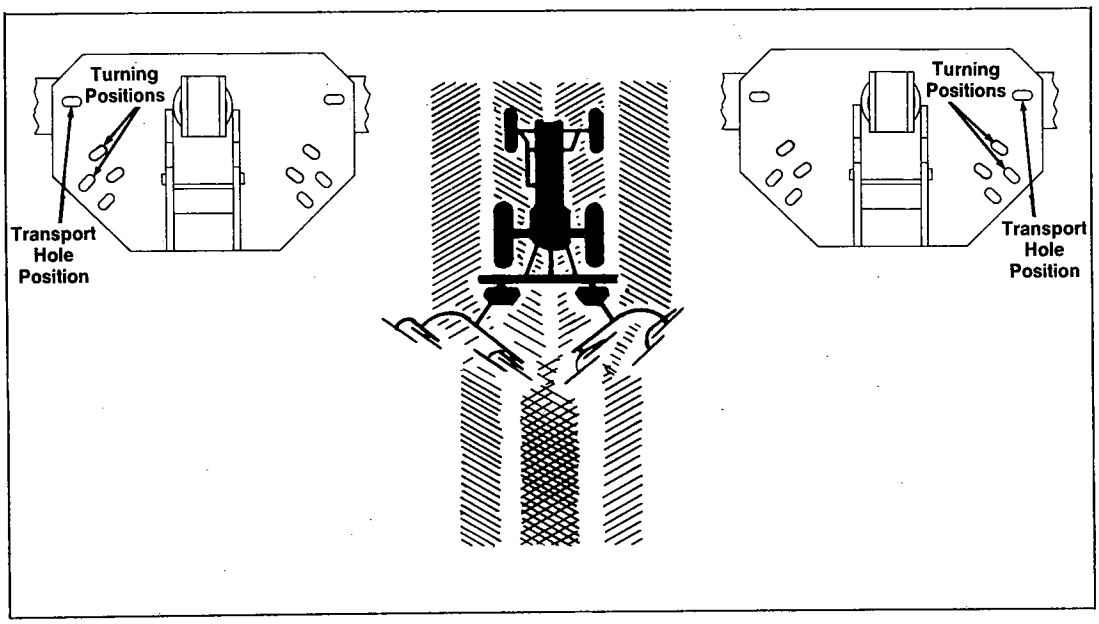


Fig. 6-6: Turning Detail

CHAPTER 7

MAINTENANCE & SERVICE

HARDWARE (Fig. 7-1)

After the first hour of operation, check all attaching hardware, especially in the areas of the Tine anchor bolts and Finger Wheel Hubs. Hardware torques should be checked on a routine basis after every 10 hours of operation.

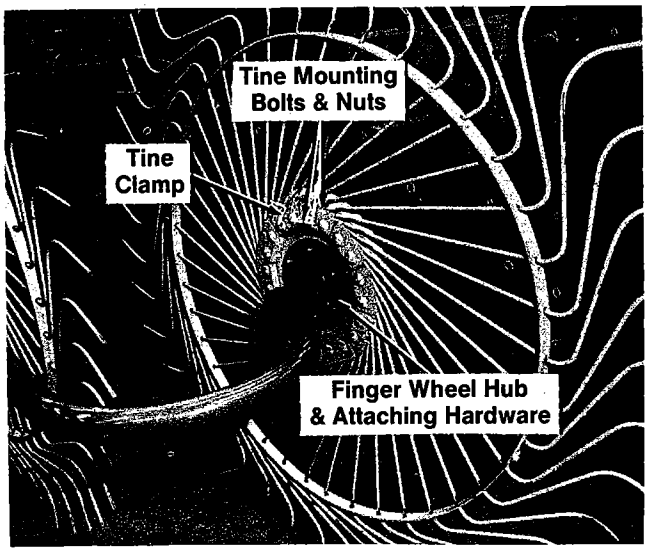


Fig. 7-1

LUBRICATION (Fig. 7-2)

Both Rake models can be considered lubrication-free. However, a good grade of foaming aerosol lubricant or new or used motor oil should be applied to all sliding and pivoting surfaces on a routine basis to maintain freedom of movement.

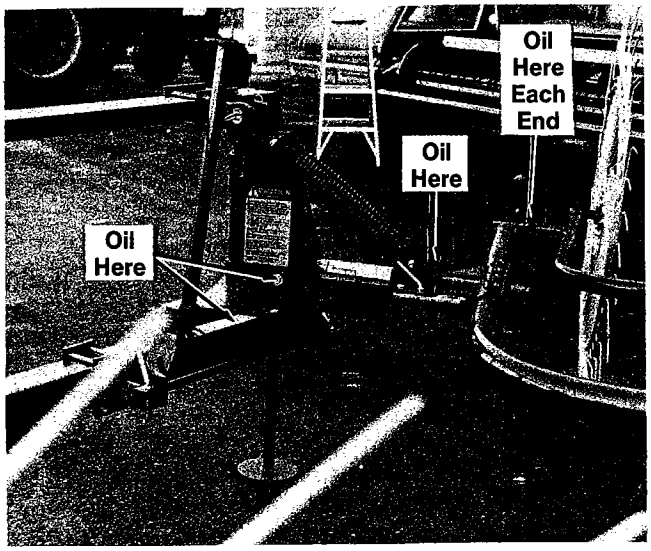


Fig. 7-2

CHAPTER 8

SET-UP & ASSEMBLY

NOTE: These assembly procedures should be performed inside an enclosed workshop equipped with an overhead hoist to facilitate lifting some of the heavier components or otherwise another person should be available to assist in lifting.

UNCRATING

Assembly procedures for both model V-Rakes are essentially the same. The following procedures should be carried-out in the manner outlined so that the Toolbar Frame is mounted first, the Right and Left Head assemblies are mounted second, the Right Rake assembly is mounted third and, lastly the Left Rake assembly is mounted.

NOTE: The major difference between the Left and the Right Rake assemblies is that the Right Rake has Right Finger Wheels and the Left Rake has Left Finger Wheels. With the exception of the Finger Wheel subassemblies, both Rake assemblies are formed using the same components. After asseembling the Right Rake onto the Head on the right side of the Toolbar Frame, repeat the same procedures for the Left Rake assembly except orient and install the Main Frame and Rake Arms in mirror image of the Right Rake.

TOOLBAR ASSEMBLY (Figs. 8-1 thru 8-5)

Refer to the exploded-view drawing and associated parts list and proceed to assemble and install the Toolbar Frame assembly in the following manner.

1. Properly orient and preassemble the Lower Link Pins to the appropriate brackets on the Bar Frame and secure them with (2 each) Klik Pins.

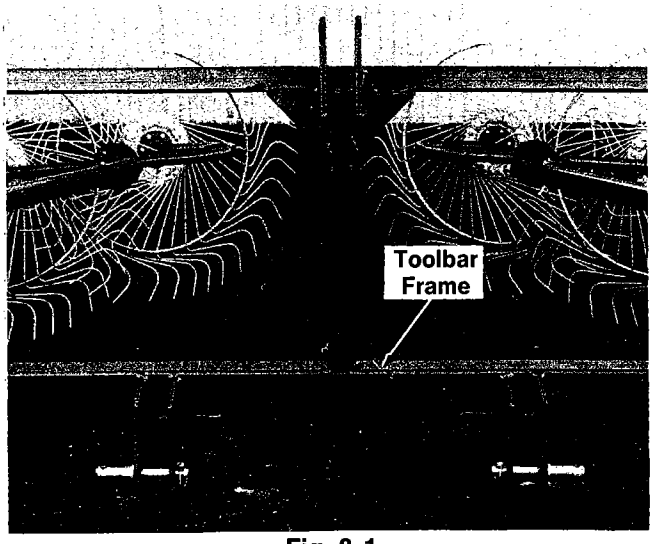


Fig. 8-1

NOTE: To facilitate setup & assembly, it is advisable that the components be mounted directly onto a tractor 3-point hitch whose lower links have been raised off the floor at least 24" (610 mm).

2. Carefully and properly raise the Toolbar Frame and attach it to the lower links of the tractor 3-point hitch with the reversible Category I/II Combination Lower Link Pins secured with the tractor lynch pins as shown.

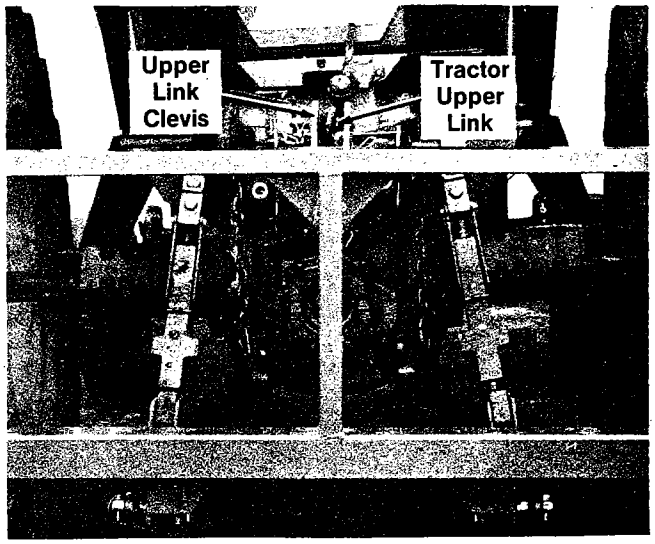


Fig. 8-2

3. Attach the tractor upper link to the Upper Link Clevis on the Toolbar Frame with an appropriately-sized Link Pin and Locking Pin (and appropriately-sized Category II bushings, where applicable).

4. On the right side of the lower beam of the Bar Frame, attach (but do **NOT** tightly secure) a Lower Link Bracket and a Plate in the manner illustrated using (4 each) 12 x 140mm Bolts and Nuts. Using another set of components, make a similar assembly on the left side of the lower beam.

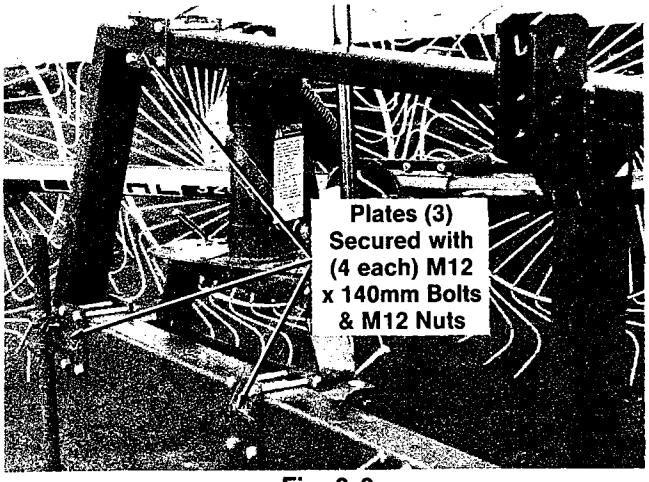


Fig. 8-3

5. At a distance of approximately 36″ in from each end of the lower beam of the Bar Frame, install (but do **NOT** tightly secure) two more sets of the same components installed in step 4.

6. On the upper beam of the Bar Frame and half way between each pair of Lower Link Brackets, install an Upper Link Bracket and a Plate in the manner illustrated using (4 each) 12 x 140mm Bolts and Nuts.

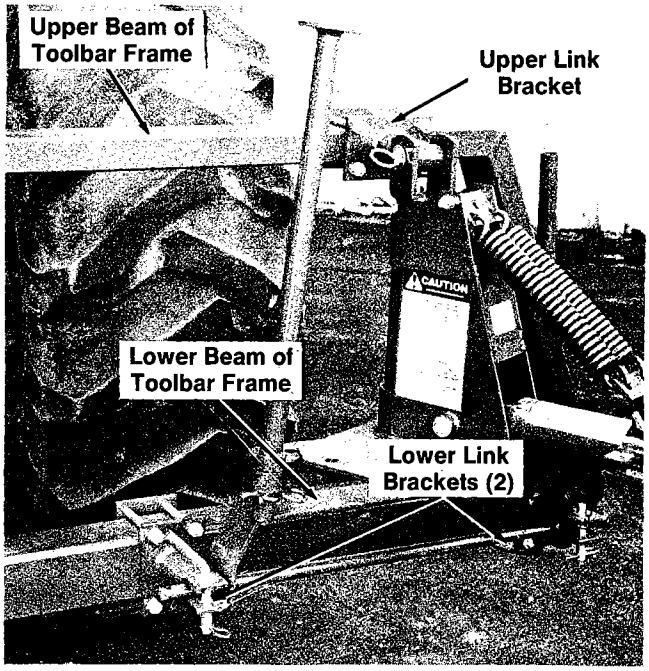


Fig. 8-4: Right End of Toolbar

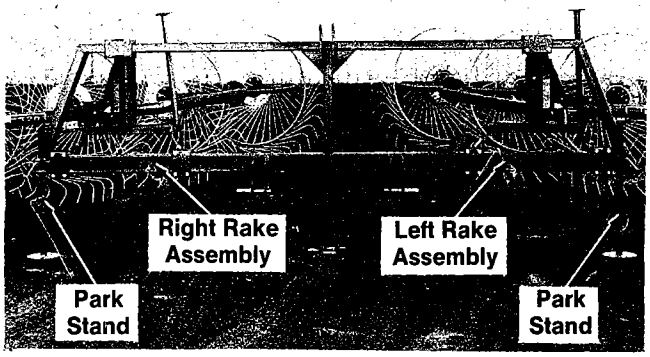


Fig. 8-5

HEADS ASSEMBLY (Figs. 8-6 thru 8-9)

Preassemble the same components for the Rake Heads for both the Right and Left Rake assemblies in the following manner:

7. Assemble and tightly secure the Moveable Head onto the pipe of the Lower Hitch with an M10 x 90mm Cap Screw, Lock Washer and 10mm Nut.

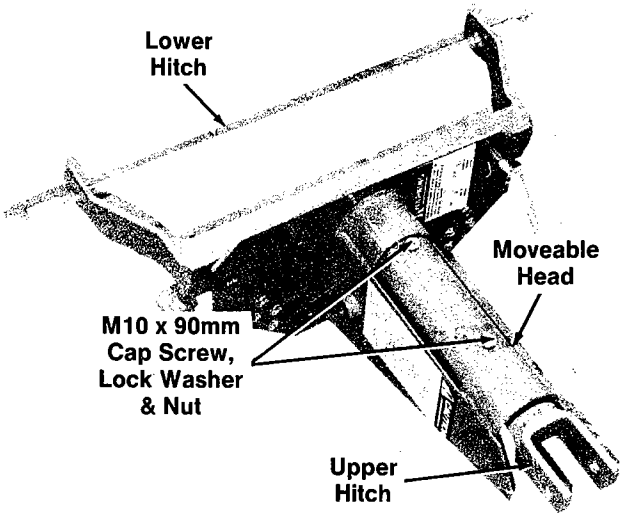


Fig. 8-6

8. In the top of the pipe of step 7, insert the Upper Hitch and orient it so that the Upper Hitch Pin hole offset is towards the Toolbar. Secure the Upper Hitch into the pipe of the Lower Hitch assembly with another M10 x 90mm Cap Screw, Lock Washer and 10mm Nut.

9. Repeat steps 7 & 8 to assemble the same components for the other Rake Head.

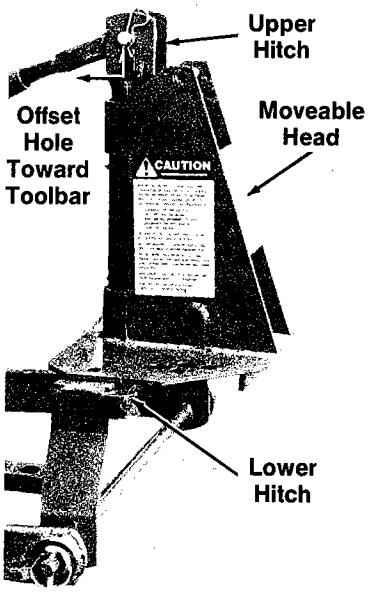


Fig. 8-7

10. Install the preassemblies of steps 7, 8 and 9 to both ends of the Toolbar Frame using the Upper and Lower Link Brackets installed under the preceding Toolbar Frame topic. As necessary, reposition the Brackets on the Upper and Lower Beams of the Bar Frame so that they are firmly contacted by the ends of each Lower Hitch assembly. With the proper positions established, tightly secure the hardware fastening all of the Brackets.

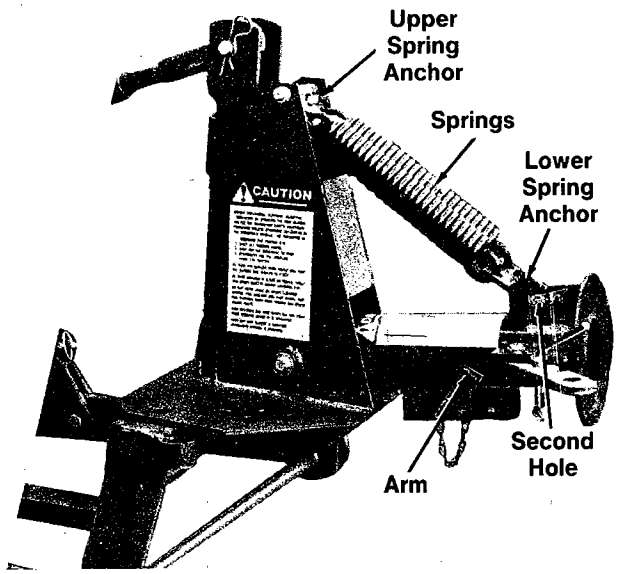


Fig. 8-8

11. On the right side of the Toolbar Frame, properly orient and attach the Arm into position between the mounting plates of the Moveable Head with the M25 x 130mm Pin and an M10 x 20mm Cap Screw and Washer on each side of the Pin.

12. Likewise, on the right side of the Toolbar Frame, properly orient and attach the appropriate end of the Shock Absorbing assembly into position between the mounting plates of the Moveable Head with an M12 x 120mm Cap Screw, Lock Washer and 12mm Nut. Secure the other end of the Shock Absorbing assembly between the brackets on the top of Arm with an M12 x 35mm Cap Screw, Lock Washer and Nut.

13. Repeat steps 11 and 12 and attach the same set of components onto the left side of the Toolbar Frame.

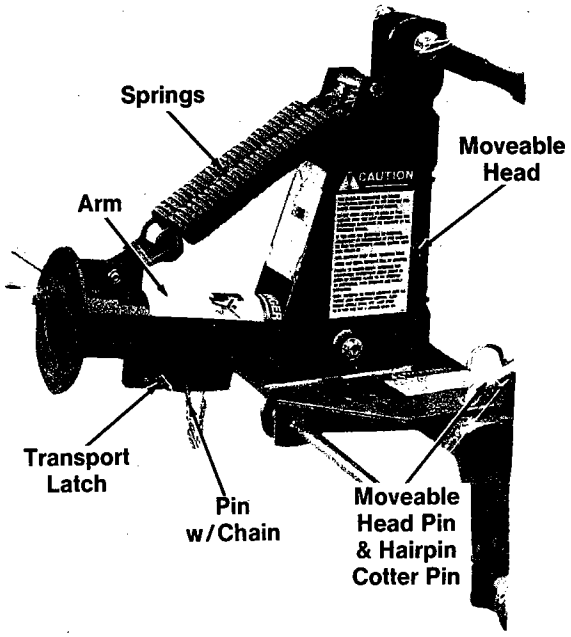


Fig. 8-9

RIGHT RAKE ASSEMBLY (Figs. 8-10 thru 8-16)

14. Generously lubricate the pipe portion of the Removeable Pipe of the Main Frame with grease. Then, secure the Removeable Pipe by engaging the Latch and installing a Lock Pin and a Hairpin Cotter Pin.

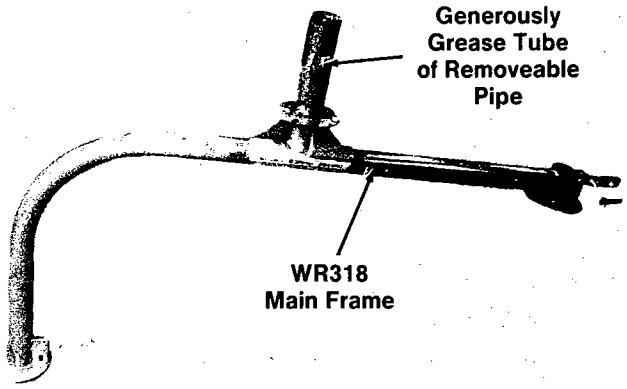


Fig. 8-10

15. Properly orient (so that the curved end is to the left) and attach the Main Frame to the Removeable Pipe with (2 each) M10 x 25 Cap Screws and M10 Lock Nuts thru the two innermost holes. In the two outermost holes, secure the Main Frame Brackets with (2 each) M10 x 30 Cap Screws and M10 Lock Nuts.

16. **On the 320 model only**, properly orient, install and secure the 5th Rake Wheel Arm in the tube of the Main Frame Arm with the M12 x 80 Cap Screw and M12 Nylon-insert Lock Nut.

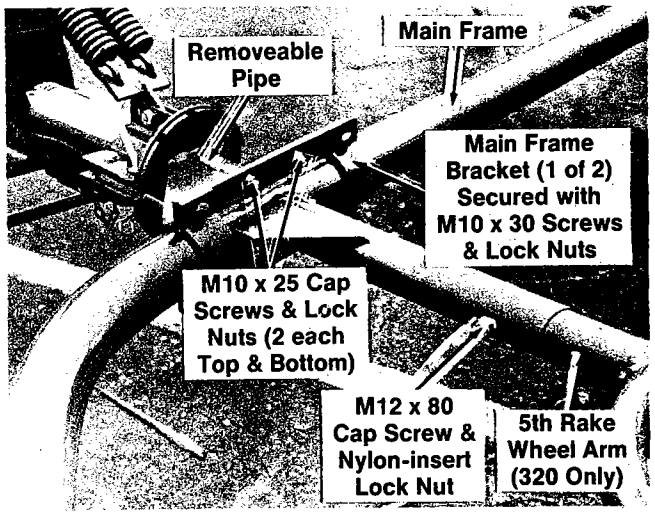


Fig. 8-11

17. Generously lubricate the pipes of both Wheel Arms with grease. Then, properly orient (so that the curved end is to the left) and install one Wheel Arm into the right Hub of the Main Frame and the other Right Arm into the left Hub of the Main Frame. Secure both assemblies by engaging the Latches and installing the Lock Pins and Hairpin Cotter Pins.

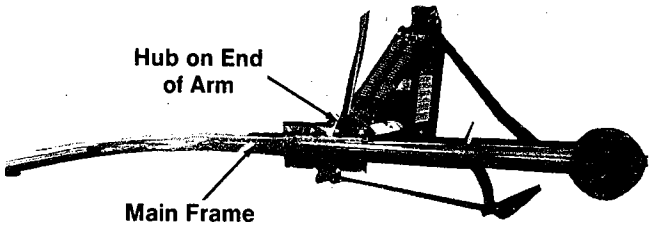


Fig. 8-12

18. Properly orient and install a Right Finger Wheel subassembly on each of the (four for 318 or five for 320) Wheel Hubs as shown.

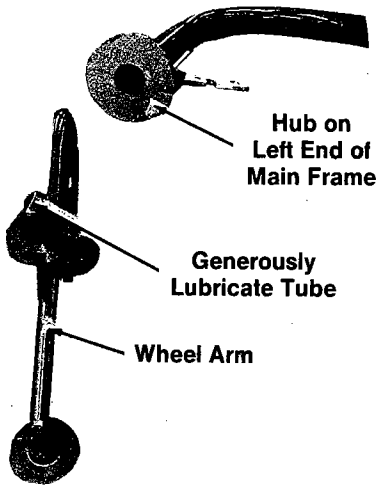


Fig. 8-13

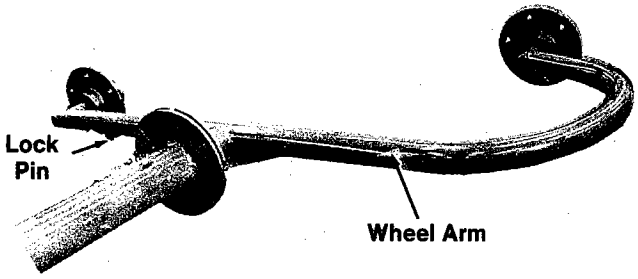


Fig. 8-14

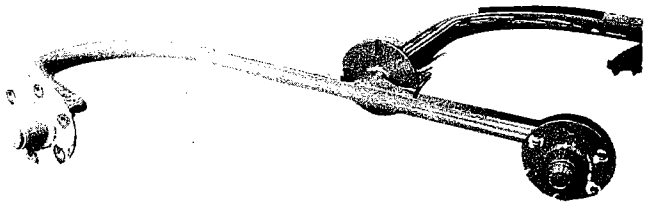


Fig. 8-15: Wheel Arm Installed on Left End of Main Frame of Right Rake Assembly

LEFT RAKE ASSEMBLY (See Fig. 8-5)

19. In a mirror image fashion and following steps 14 thru 18, install the Rake components for the Left Rake assembly.

PARK STAND ASSEMBLY (See Fig. 8-5)

20. After the entire V-Rake is completely assembled, install Park Stand onto each side of the Toolbar Frame in the manner shown.

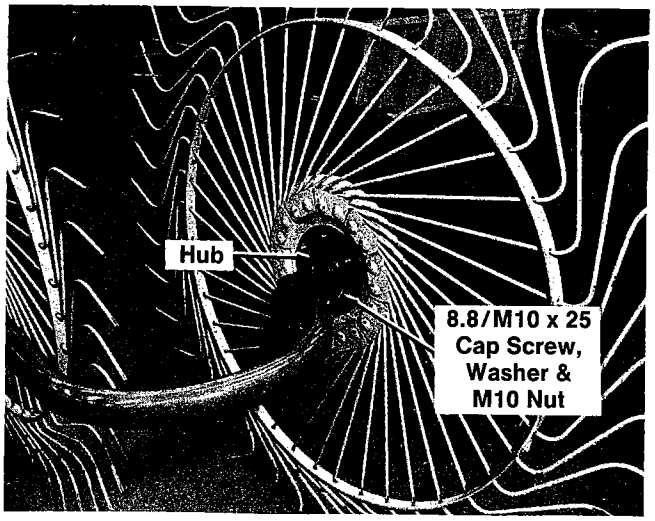


Fig. 8-16

NOTES

CHAPTER 9

DECAL LOCATIONS

GENERAL INFORMATION

Decal Locations information is provided to assist in the proper selection and application of new decals, in the event the original decal(s) become(s) damaged or the machine is repainted. Refer to the listing for the illustration reference number, part number, description and quantity of each decal provided in the Kit. Refer to the appropriate illustration(s) for replacement location(s).

To insure proper selection of the correct replacement decal(s), compare all of the various closeup location photographs to your machine, before starting to refinish the unit. Then, circle each pictured decal (on or otherwise applicable to your machine) while checking-off its part number in the listing. After you have verified all the decals needed for replacement, place any unnecessary decals aside for disposal.

NEW DECAL APPLICATION

Surfaces **MUST** be free from dirt, dust, grease and other foreign material before applying the new decal. To apply a solid-formed decal, remove the smaller portion of the decal backing paper and apply this part of the exposed adhesive backing to the clean surface while maintaining proper position and alignment. Peel the other portion of the backing paper off slowly while applying hand pressure to smooth-out decal surface.

CAUTION: ALWAYS observe Safety Rules shown on Decals. If Decal(s) become(s) damaged, or if the unit is repainted, replace the Decal(s). If repainting, BE SURE that ALL Decals from the Kit(s), which apply to your machine, are affixed to your unit.

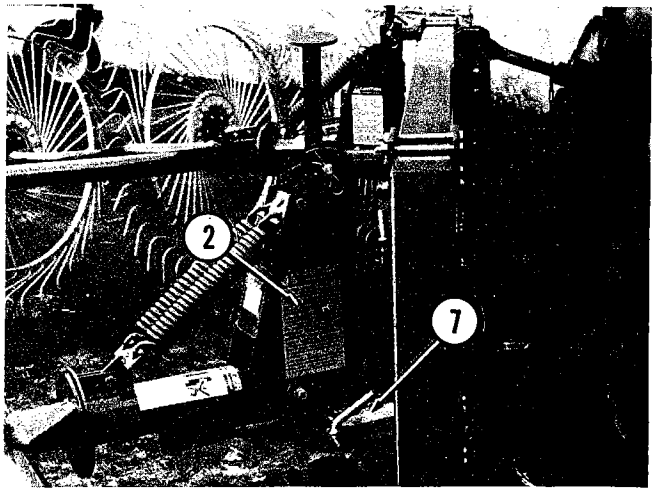
The Decal Kit for the WR318 & WR320 Finger Wheel Rakes is 088325. The Kit includes the following:

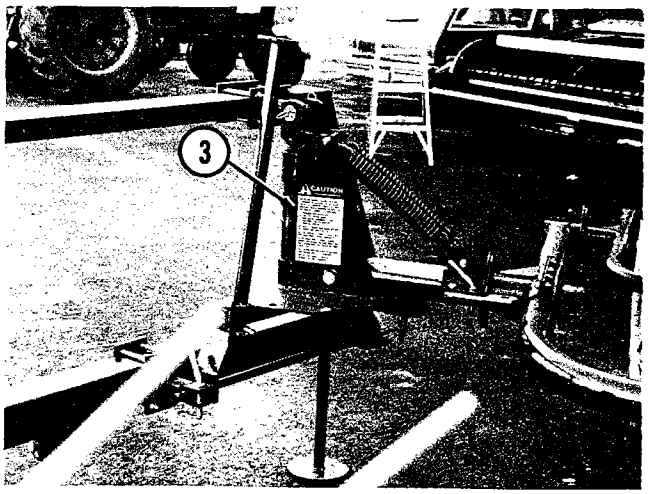
Ref. No.	Part No.	Description & Quantity
1.	072148	DANGER - Avoid Electrical Contact (2 Places)
2.	076894	CAUTION - Operator's Responsiblility & Read Manual (2 Places)
3.	077682	CAUTION -General Safety (2 Places)
4.	088314	GEHL (2 Places)
5.	088323	318 -318 Model Only (2 Places)
6.	088324	320 -320 Model Only (2 Places)
7.	088317	WARNING - Install Transport Latch (2 Places)

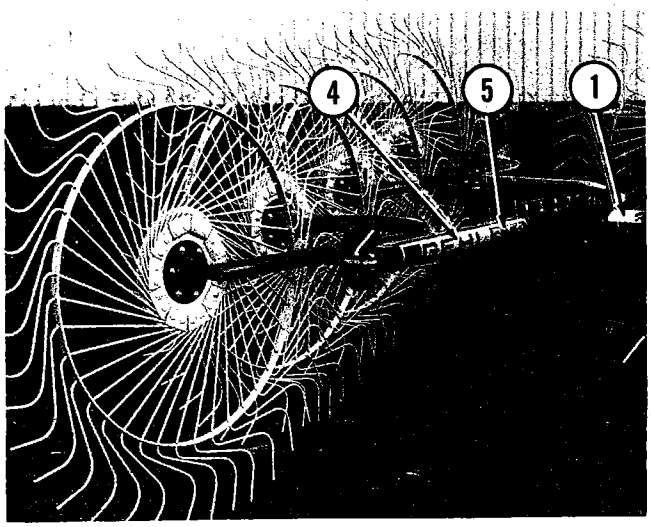
NOTICE

Order paint for refinishing machines from this list:

901225	One Gallon Blaze Paint
901226	One Gallon Maize Paint
610239	6 (12oz) Cans Blaze Spray Paint
610240	6 (12oz) Cans Maize Spray Paint



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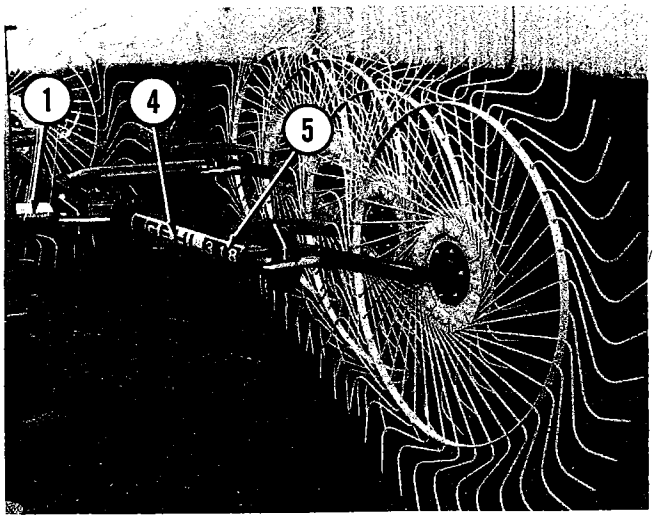
5
1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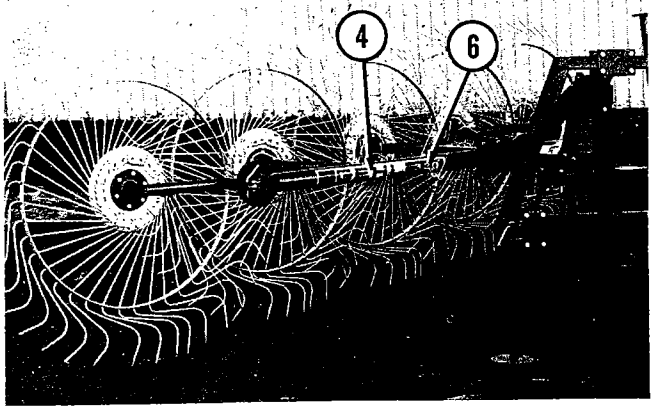
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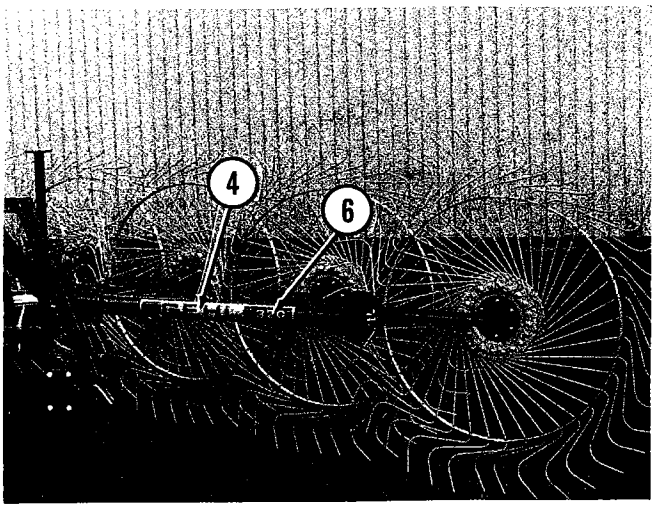
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6

CHAPTER 10

SERVICE PARTS & NUMERICAL INDEX

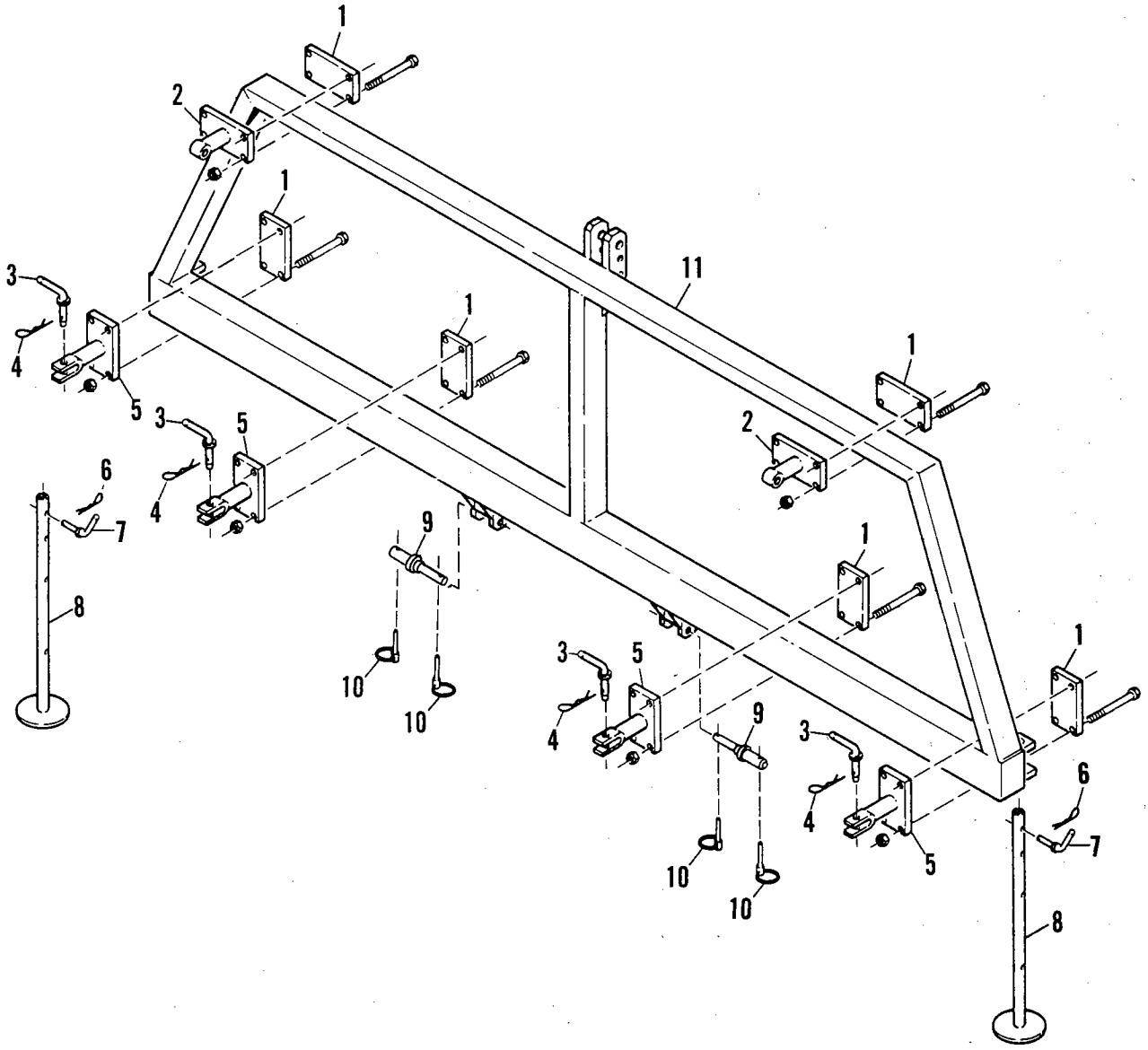
When ordering service parts, specify the correct part number, full description, quantity required, the unit model number and serial number.

The Rake Model and Serial Number is stamped on a plate located on the back side of the Moveable Head.

"Right" and "Left" are determined from a position standing behind the Rake and facing the direction of travel.

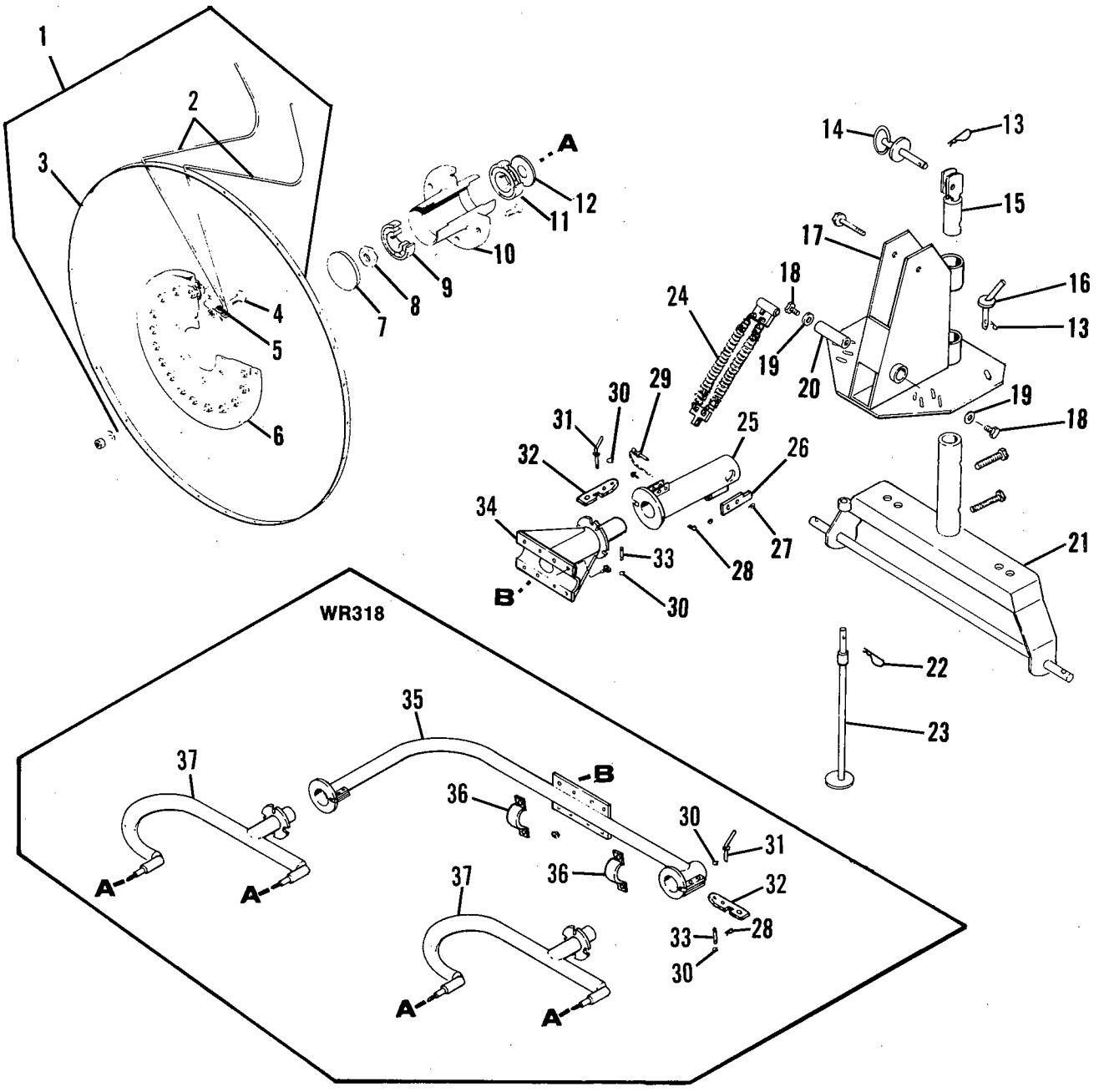
GEHL Company reserves the right to make changes or improvements in the design or construction of any part of the unit without incurring the obligation to install such changes on any unit previously delivered.

Common attaching hardware, such as Cotter Pins, Set Screws, Woodruff Keys, Screws, Nuts, etc., are included in the parts lists, indented below the part it is (they are) associated with:



REF NO	PART NUMBER	PART DESCRIPTION...ETC..	QTY REQ
01	612790	PLATE.....	6
	656026	BOLT, 8.8/M12X140.....	24
	656050	NUT, HEX M12.....	24
	612795	M12 SERRATED LW.....	24
02	612791	BRACKET, UPPER LINK.....	2
03	612760	PIN, LOCK 16MM.....	4
04	612759	PIN, HAIRPIN COTTER 4MM..	4
05	612789	BRACKET, LOWER LINK.....	4
06	612773	PIN, HAIRPIN COTTER 2.5MM	2
07	612772	PIN, LOCK.....	2
08	612793	STAND, PARK.....	2
09	612792	PIN, LOWER LINK.....	2
10	060471	PIN, KLIK.....	4
11	612794	FRAME (318).....	1
	612989	FRAME (320).....	1

LEFT HAND RAKE ASSEMBLY

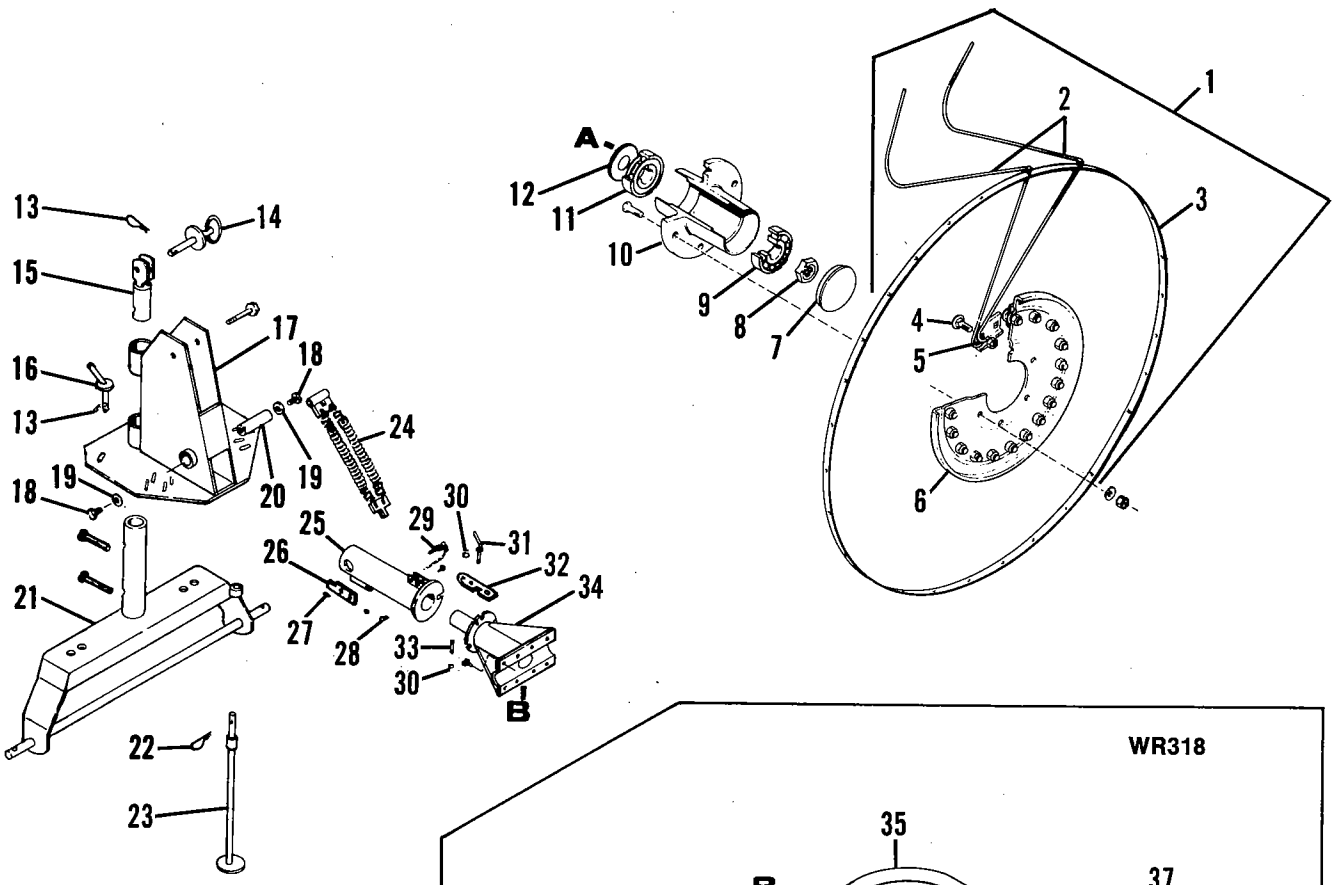


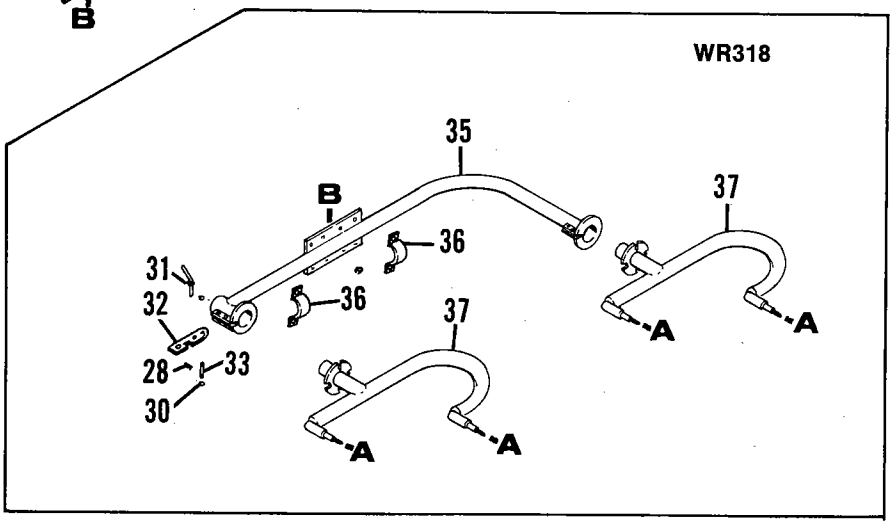
LEFT HAND RAKE ASSEMBLY

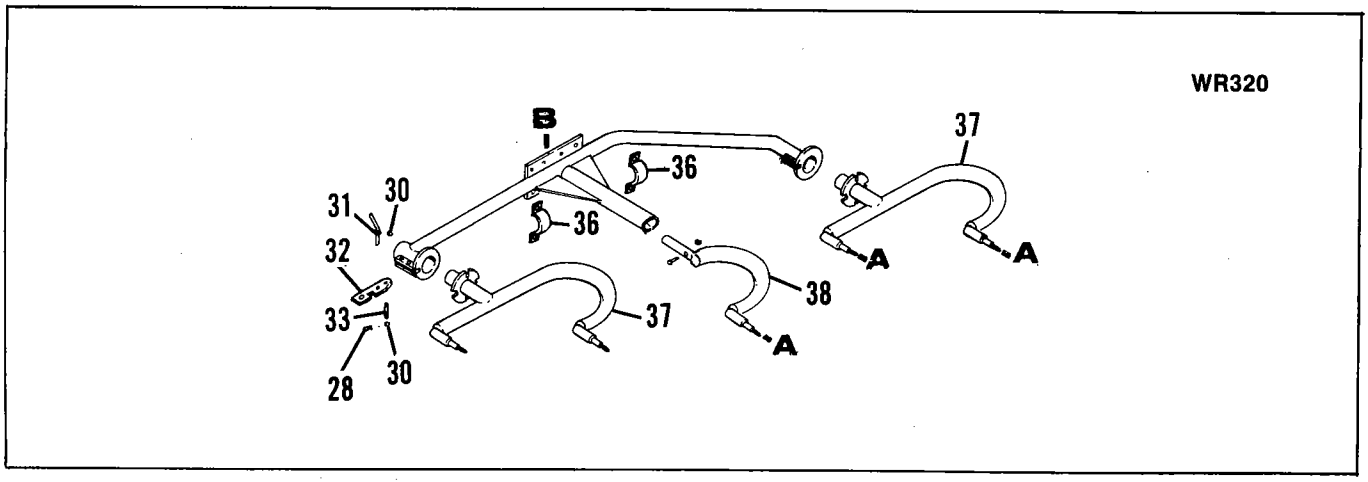
REF NO	PART NUMBER	PART DESCRIPTION...ETC..	QTY REQ
01	612988a	FINGER WHEEL-ASSM. (LH)..	AR
02	612686	TINE.....	40
03	612781	RIM.....	1
04	612785	BOLT, TOOTH.....	20
	656049	NUT, M10/1.25.....	20
05	612784	CLIP.....	10
06	612782	PLATE, TINE.....	AR
07	612788	CAP, HUB.....	AR
08	656134	NUT, LOCK M18X1.5.....	AR
09	520074	BEARING, BALL.....	AR
10	612787	HUB.....	AR
	656007	SCREW, CAP 8.8/M10X25...	AR
	656049	NUT, M10/1.25.....	AR
	612103	WASHER M10.....	AR
11	062367	BEARING, BALL.....	AR
12	612786	SHIELD, BEARING.....	AR
13	612759	PIN, HAIRPIN COTTER 4MM..	2
14	612758	PIN, UPPER HITCH.....	1
15	612757	HITCH, UPPER.....	1
16	612760	PIN, MOVEABLE HEAD.....	1
17	612756	HEAD, MOVEABLE.....	1
18	612763	CAP SCREW-SL 8.8/M10X20..	2
19	656133	WASHER M10X30X2.....	2
20	612764	PIN, PIVOT M25X130.....	1
21	612755	HITCH, LOWER.....	1
	656015	SCREW, CAP 8.8/M10X90...	2
	656049	NUT, HEX M10.....	2
	656103	WASHER, LOCK M10.....	2
22	604629	PIN, HAIRPIN COTTER 5MM..	1
23	612762	STAND, PARK.....	1
24	612766	SHOCK ABSORBING ASSM.....	1
	656017	SCREW, CAP 8.8/M12X35...	1
	656024	SCREW, CAP 8.8/M12X120..	1
	656050	NUT, HEX M12.....	2
	656118	WASHER, LOCK M12.....	2
25	612765	ARM.....	1
26	612771	LATCH, TRANSPORT.....	1
27	612770	PIN, HAIRPIN COTTER 2MM..	1
28	612773	PIN, HAIRPIN COTTER 2.5MM	3
29	612769	PIN W/CHAIN.....	1
30	087596	RING, RETAINING.....	6
31	612772	PIN, LOCK.....	3
32	612774	LOCK, ARM.....	3
33	612775	PIN, ARM LOCK.....	3
34	612767	PIPE, REMOVEABLE.....	1
35	612777	FRAME, MAIN (318).....	1
	612779	FRAME, MAIN (320).....	1
	656007	SCREW, CAP 8.8/M10X25...	4
	071246	NUT, LOCK 8/M10.....	4
36	612776	BRACKET, MAIN FRAME.....	2
	656008	SCREW, CAP 8.8/M10X30...	4
	071246	NUT, LOCK 8/M10.....	4
37	612778	ARM, WHEEL.....	2
38	612986	ARM, 5TH RAKE WHEEL..... (320 ONLY)	1
	656104	SCREW, CAP 8.8/M12X80...	1
	071247	NUT/M12, NYLON-INSERT...	1

a) FOUR USED ON WR318 & FIVE USED ON WR320.

RIGHT HAND RAKE ASSEMBLY







RIGHT HAND RAKE ASSEMBLY

REF NO	PART NUMBER	PART DESCRIPTION...ETC..	QTY REQ
01	612780a	FINGER WHEEL-ASSM. (RH)..	AR
02	612686	TINE.....	40
03	612781	RIM.....	1
04	612785	BOLT, TOOTH.....	20
	656049	NUT, M10/1.25.....	20
05	612784	CLIP.....	10
06	612782	PLATE, TINE.....	AR
07	612788	CAP, HUB.....	AR
08	656134	NUT, LOCK M18X1.5.....	AR
09	520074	BEARING, BALL.....	AR
10	612787	HUB.....	AR
	656007	SCREW, CAP 8.8/M10X25...	AR
	656049	NUT, M10/1.25.....	AR
	612103	WASHER M10.....	AR
11	062367	BEARING, BALL.....	AR
12	612786	SHIELD, BEARING.....	AR
13	612759	PIN, HAIRPIN COTTER 4MM..	2
14	612758	PIN, UPPER HITCH.....	1
15	612757	HITCH, UPPER.....	1
16	612760	PIN, MOVEABLE HEAD.....	1
17	612756	HEAD, MOVEABLE.....	1
18	612763	CAP SCREW-SL 8.8/M10X20..	2
19	656133	WASHER M10X30X2.....	2
20	612764	PIN, PIVOT M25X130.....	1
21	612755	HITCH, LOWER.....	1
	656015	SCREW, CAP 8.8/M10X90...	2
	656049	NUT, HEX M10.....	2
	656103	WASHER, LOCK M10.....	2
22	604629	PIN, HAIRPIN COTTER 5MM..	1
23	612762	STAND, PARK.....	1
24	612766	SHOCK ABSORBING ASSM.....	1
	656017	SCREW, CAP 8.8/M12X35...	1
	656024	SCREW, CAP 8.8/M12X120..	1
	656050	NUT, HEX M12.....	2
	656118	WASHER, LOCK M12.....	2
25	612765	ARM.....	1
26	612771	LATCH, TRANSPORT.....	1
27	612770	PIN, HAIRPIN COTTER 2MM..	1
28	612773	PIN, HAIRPIN COTTER 2.5MM	3
29	612769	PIN W/CHAIN.....	1
30	087596	RING, RETAINING.....	6
31	612772	PIN, LOCK.....	3
32	612774	LOCK, ARM.....	3
33	612775	PIN, ARM LOCK.....	3
34	612767	PIPE, REMOVEABLE.....	1
35	612777	FRAME, MAIN (318).....	1
	612779	FRAME, MAIN (320).....	1
	656007	SCREW, CAP 8.8/M10X25...	4
	071246	NUT, LOCK 8/M10.....	4
36	612776	BRACKET, MAIN FRAME.....	2
	656008	SCREW, CAP 8.8/M10X30...	4
	071246	NUT, LOCK 8/M10.....	4
37	612778	ARM, WHEEL.....	2
38	612986	ARM, 5TH RAKE WHEEL..... (320 ONLY)	1
	656104	SCREW, CAP 8.8/M12X80...	1
	071247	NUT/M12, NYLON-INSERT...	1

a) FOUR USED ON WR318 & FIVE USED ON WR320.

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612758	25	14	612770	27	27	612781	27	03	612989	23	11
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General Bolt Torque Data in Ft-Lb*

BOLT SIZE	GRADE					
	8.8		10.9		12.9	
Metric	DRY	LUB.	DRY	LUB.	DRY	LUB.
M6	8	6	11	8	13.5	10
M8	19	14	27	20	32.5	24
M10	37.5	28	53	39	64	47
M12	65	48	91.5	67.5	111.3	82
M14	103.5	76.5	145.5	108	176.5	131
M16	158.5	117.5	223.5	165.5	271	200.5

***Multiply by (1.355) for metric Nm**

FARM EQUIPMENT

GEHL COMPANY WEST BEND, WISCONSIN 53095 U.S.A.

904073/1P188 (66)

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