

Ashland EARTHMOVERS



I-155XL2 PARTS MANUAL

Ver. 1008-22079



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HOW TO ORDER PARTS:

IMPORTANT

Parts must be ordered through your local authorized ASHLAND dealer.

Be sure to state MODEL and SERIAL NUMBER of your machine, PART NUMBER, DESCRIPTION and QUANTITY needed.



Unless this is done, we cannot provide prompt service or assure shipment of the correct parts.

Ashland Industries weldable replacement parts are available to rebuild, modify or update your scraper to current factory specifications.

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Operators and Maintenance Instructions

OPERATORS AND MAINTENANCE INSTRUCTIONS

This scraper is a durable piece of equipment and with proper care will yield many years of trouble free operation. The scraper requires a power source with TWO 4 way (double acting) hydraulic control valves.

The scraper should be greased at all points where grease fittings are provided. Connect hydraulic hoses to the tractor and retract lift cylinders to **REMOVE TRANSPORT LOCK PINS** (point A), then extend and retract all cylinders several times to force out any air from the hydraulic cylinders and lines. Check the oil levels in the tractor hydraulic system and add to maintain the proper level. Care should be used when adding oil or when disconnecting any oil line to keep all dirt out of the oil as dirt is a major factor in the failure of hydraulic components.

When the scraper is placed into operation, the operator will have to "feel out" the amount of depth of cut to obtain maximum loading efficiency. This is usually accomplished by taking a lesser and more uniform cut; however, some soil conditions such as loose sand may require a "pumping action" obtained by taking successive deep cuts and lifting out of cut as the tractor begins to lose power or traction.

1. After 10 hours work, all bolts should be checked and tightened if necessary.
2. Every 10 hours all grease fittings should be lubricated.
3. After 50 hours work, all bolts should be rechecked and tightened if necessary. Check wheel bearings and adjust if necessary.
4. After 300 hours work, clean and repack wheel bearings and replace, if necessary, cutting edges, worn pins, etc.

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Safety Guidelines



SAFETY SIGNAL WORDS

Note the use of the signal words DANGER, WARNING and CAUTION with the safety messages. The appropriate signal word for each has been selected using the following guidelines:



DANGER: Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.

This signal word is to be limited to the most extreme situations typically for machine components which, for functional purposes, cannot be guarded.



WARNING: Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.



CAUTION: Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.



GENERAL SAFETY GUIDELINES

Safety of the operator is one of the main concerns in designing and developing a new piece of equipment. Designers and manufacturers build in as many safety features as possible. However, every year many accidents occur which could have been avoided by a few seconds of thought and a more careful approach to handling equipment. You, the operator, can avoid many accidents by observing the following precautions in this section. To avoid personal injury, study the following precautions and insist those working with you, or for you, follow them.

Replace any CAUTION, WARNING, DANGER or instruction safety decal that is not readable or is missing. Location of such decals is indicated in this booklet.

Do not attempt to operate this equipment under the influence of drugs or alcohol.

Review the safety instructions with all users annually.

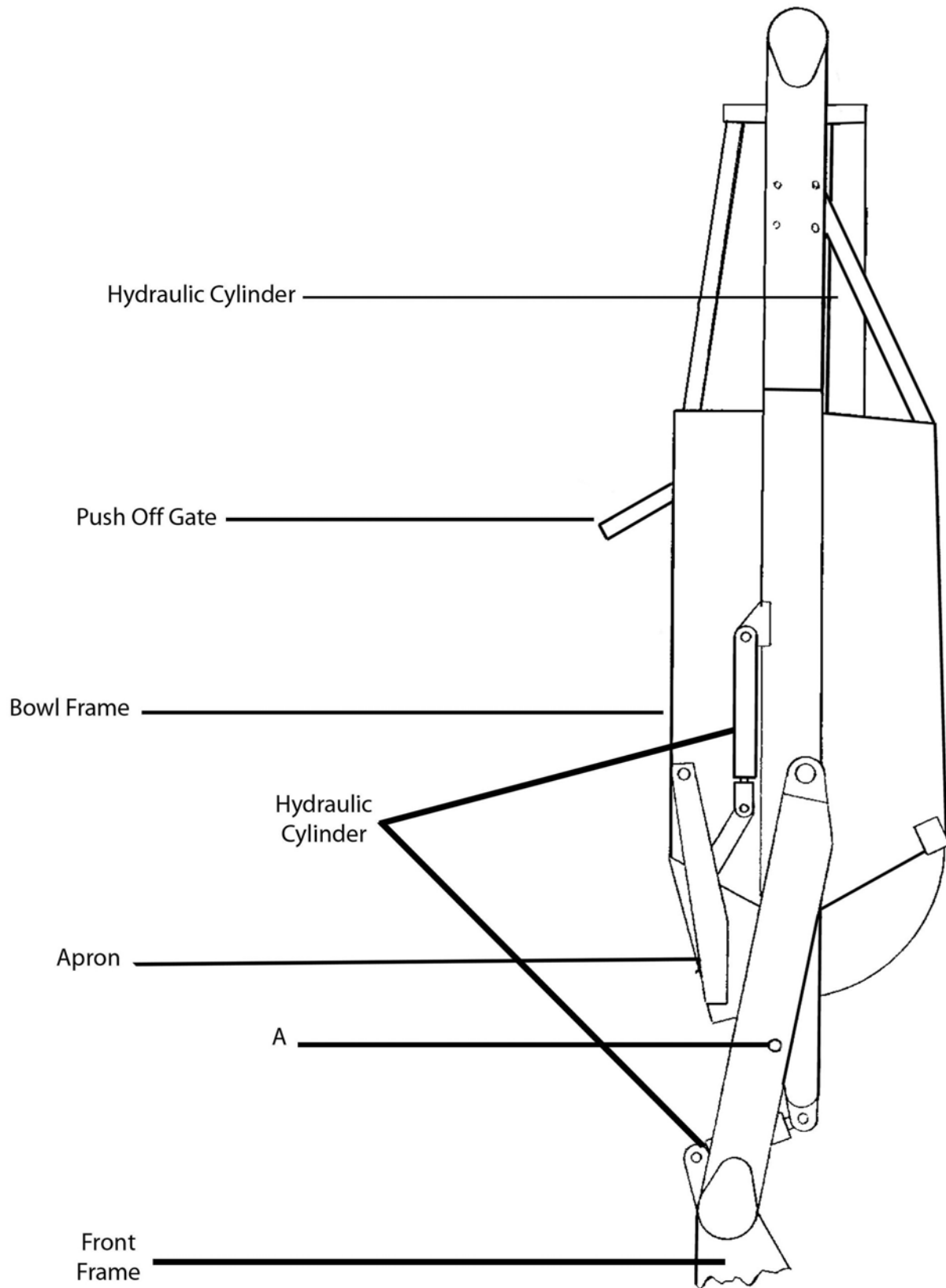
This equipment is dangerous to children and persons unfamiliar with its operation. The operator should be a responsible adult familiar with farm machinery and trained in this equipment's operations. **Do not allow persons to operate or assemble this unit until they have read this manual and have developed a thorough understanding of the safety precautions and of how it works.**

To prevent injury or death, use a tractor equipped with a Roll Over Protective System (ROPS). Do not paint over, remove or deface any safety signs or warning decals on your equipment. Observe all safety signs and practice the instructions on them.

Never exceed the limits of a piece of machinery. If its ability to do a job, or to do so safely, is in question - **DON'T TRY IT.**

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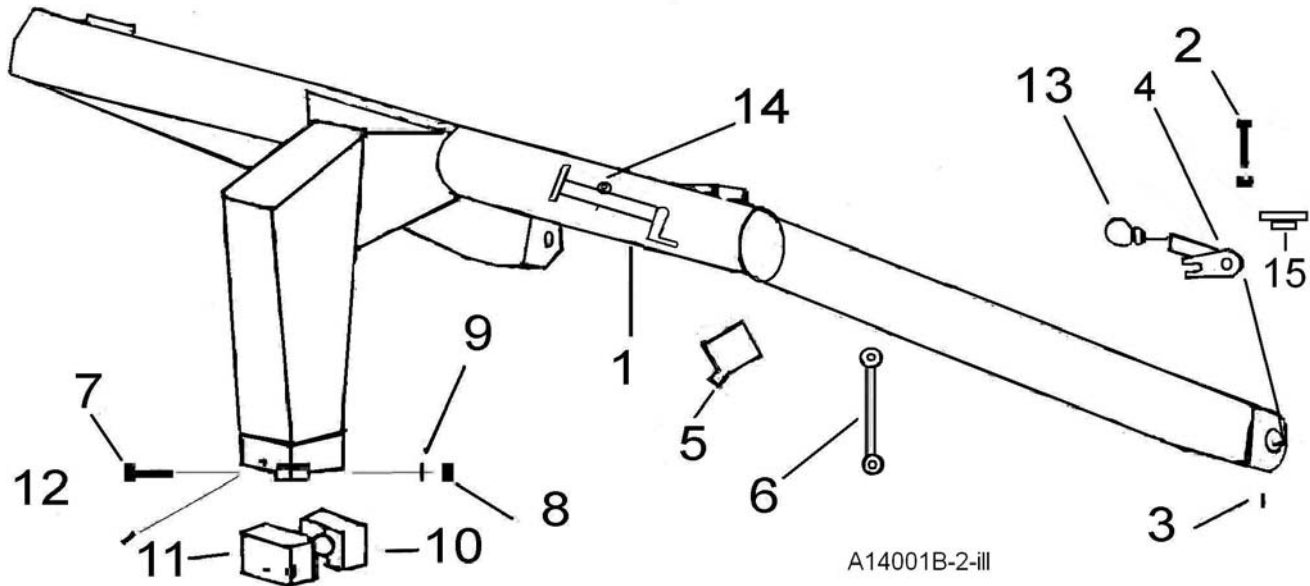
Assembly Illustration



I-Series Assembly-ILL

I-155 XL2

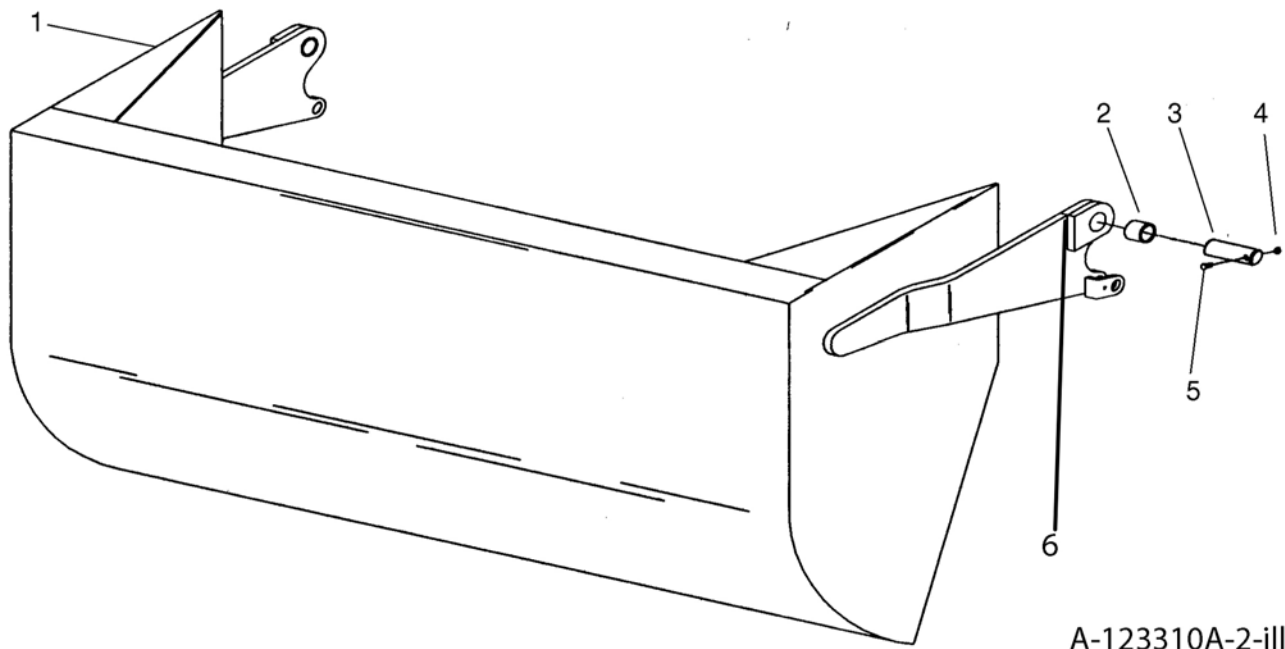
Gooseneck Assembly Part No. A14001B



Key Number	Part Number	Description
1	A14001B	Gooseneck Frame
2	AFB-00079	Bolt, 5/8 NC X 1 1/2" Gr 8
3	AHF-00028	Fitting Grease 90° 1/8 NPT
4	A123321-09	Pin, Main Frame
5	A125006	Safety Link Pin
6	A123230-20	Travel Lock
7	AFB-00025	Bolt, 7/8"NC x 5" Lg. Grade 8
8	AFN-00019	Nut, 7/8"NC"
9	8125	Lockwasher 7/8"
10	A14002	Cast Socket Half - Rear
11	A14003	Cast Socket Half - Front w/Zerk Hole
12	A2206	Grease Zerk - Long Shank
13	A123320-08	Bushing, 3 ID X 3.5 OD X 3"
14	OPT-00001	Hitch Jack
15	A123321-89	Bushing Pin Keeper

I-155 XL2

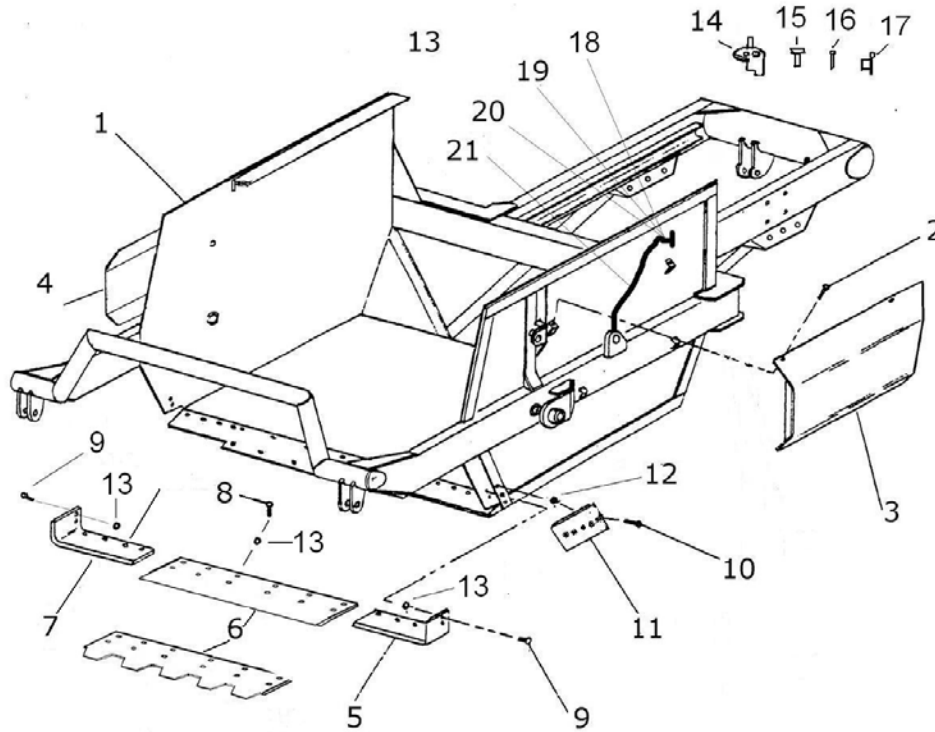
Apron Assembly Part No. A123310A



Key Number	Part Number	Description
1	A123310A	Apron Model I-155 XL2
2	A16027	Bushing: 2" OD x 1-1/2" ID x 2" Long
3	A123337	Pin: 1-1/2" x 5-3/8"
4	7450	Nut: 3/8" NC
5	AFB-00049	Bolt: 3/8" NC x 3"

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Bowl & Frame Assembly Part No. A123309



A-123309-III

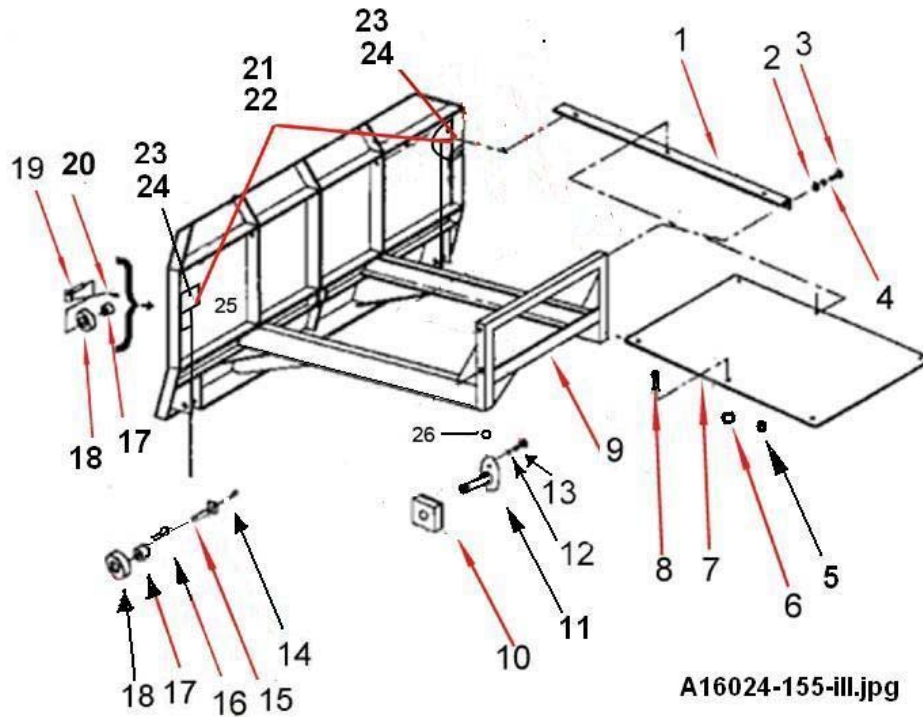
Blade Bolts Required:

		Qty	Bolts
A123330 (& Ser)	PB9P-NC-088-0275	(12)	AFN-00019
A123332L & R	PB9P-NC-088-0275	(4)	AFN-00019
	PB9P-NC-088-0225	(2)	
A123357	AFB-00018	(4)	AFN-00012

Key Number	Part Number	Description
1	A123309	"Bowl and Frame, Model I-155
2	AFB-00094	Flanged Bolt: 3/8 NC X 1"
3	A123309-62L	Cylinder Guard - Left Hand
4	A123309-62R	Cylinder Guard - Left Hand
5	A123332L	Left Cutting Edge
6	A123330	Center Cutting Edge, Straight 1-1/8" x 12" x 63"
	A123330-SER	"Center Cutting Edge, Serrated 1-1/8" x 12" x 63"
7	A123332R	Right Cutting Edge
8	PB9P-NC-088-0275	Plow Bolt: 7/8 NC X 2-3/4" -> 12 Required
10	PB9P-NC-088-0225	Plow Bolt: 7/8 NC X 2-1/4"
10	AFB-00018	Bolt, 1" NC x 3" long, (5 per Blade Required)
11	A123357	Bank Shaver/router bit Reversible, L & R
12	AFN-00012	Nut: 1" NC (5 per Blade Required)
13	AFN-00019	Nut: 7/8" NC -> 6 Required
14	A123309-93	3" Locking Lug for Rear Hitch
15	A123309-96	Pin for Locking Lug (2)
16	AFP-00001	Pin, Cotter, 1/4" X 3
17	A125006	Safety Snap Pin
18	A125019	Grease Fitting 1/4 x 28.54 Long
19	A125026	Bulkhead Nut
20	A123309-89	Single Hole Tab
21	A125022	18" Grease Line

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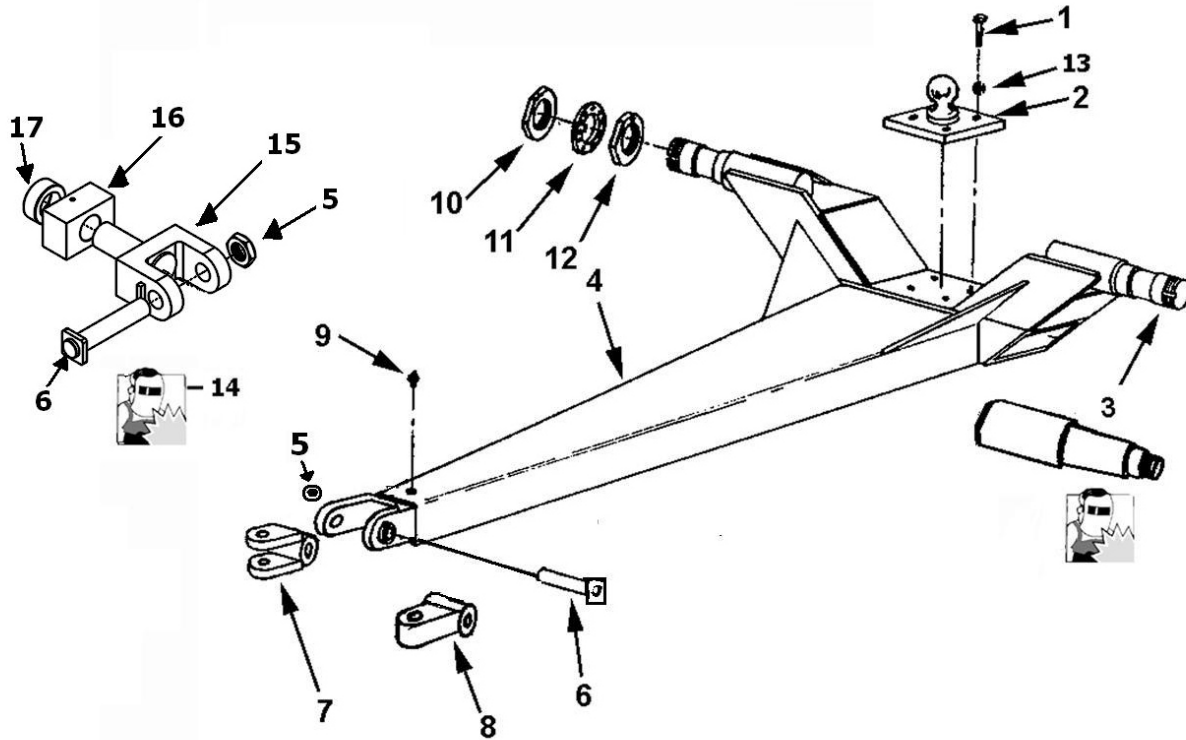
Pushoff Gate Assembly Part No. A16024



Key Number	Part Number	Description
1	A14022	Brace
2	AFN-00006	Nut: 3/4" NC
3	AFB-00037	Bolt: 3/4" NC x 2" Lg.
4	AFW-00002	Lockwasher: 3/4"
5	8100	Lockwasher: 1/2"
6	AFN-00015	Nut 1/2" NC
7	A14023	Dirt Shield
8	AFB-00015	Bolt: 1/2" x 1-1/2" NC bolt
9	A16024	Pushoff Gate: Model I-155
10	A123353	Wear Pad
11	A123305A	Pin: 1-1/4 x 2-3/4" w/grease roller
12	8100	Lockwasher: 1/2"
13	AFB-00033	Bolt: 1/2 NC x 2-1/2"
14	AHF-00028	Grease Fitting: 1/8" NPT -90 degrees
15	A6007A	Pin: 1-1/4" x 4-1/8" Lg.
16	AFP-00001	Cotter Pin: 1/4 x 3
17	A10163	Bushing: 1-3/4" OD x 1-1/4" ID
18	A10164	Roller 3-1/2 OD x 1-3/4 ID
16	A123323-21	Pin: 1-1/4" x 4 1/8" Tab Head
19	A123321-21	Pin: 1 1/4 X 4 1/8" Tab Head
20	7036	Bolt: 1/2 NC x 2"
21	A125020	Remote Grease Lines, 32"
19	A10164	Roller 3-1/2 OD x 1-3/4 ID
22	A125021	Remote Grease Lines, 54"
23	A125019	Grease Fitting 1/4 X 28.54 Long
24	A125026	Bulkhead Nut
25	A123323-40	Double Hole Tab
26	7500	1/2" Nut

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Pole & Axle Assembly 22079

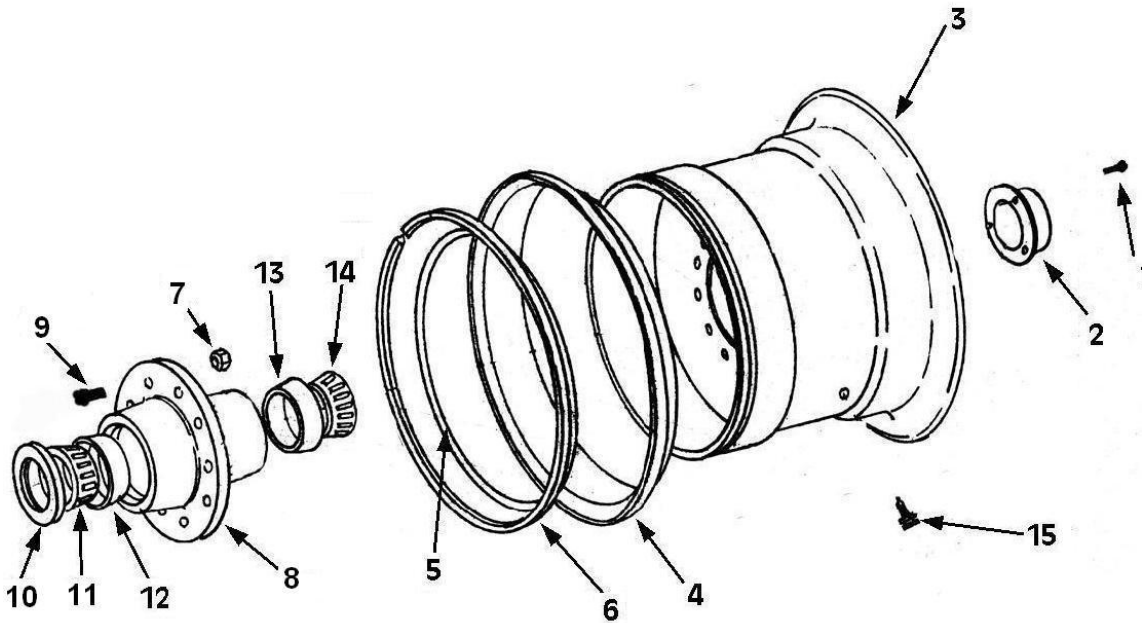


155X-A123375-22079


Key Number	Part Number	Description
1	AFB-00018	Bolt, 1" NC X 3" Lg.
2	A14017	Ball Swivel
3	A14021	Spindle, Weld on Blank
4	A123375	Pole W/20.5 X 25 Tires
5	500462	Nut, Swivel Pin
6	600055	Pin, Swivel Hitch
7	A17511	Swivel Hitch, Double Lip
8	A17510	Swivel Hitch Single Lip
9	14505	Grease Fitting
10	A10048	Spindle Nut
11	A10049A	Lock Collar
12	A10172	Nut with Lock Pin
13	AFW-00006	Lockwasher 1"
14	A123232A	Swivel Hitch Rebuild Kit, includes items 5,6,15,16,17
15	A123232-3	Hitch: Yoke Assembly
16	A123232-2	Swivel Block 4x6x3
17	A123232-1	Hitch: Retaining Collar

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Front Wheel & Hub Assembly A14006A

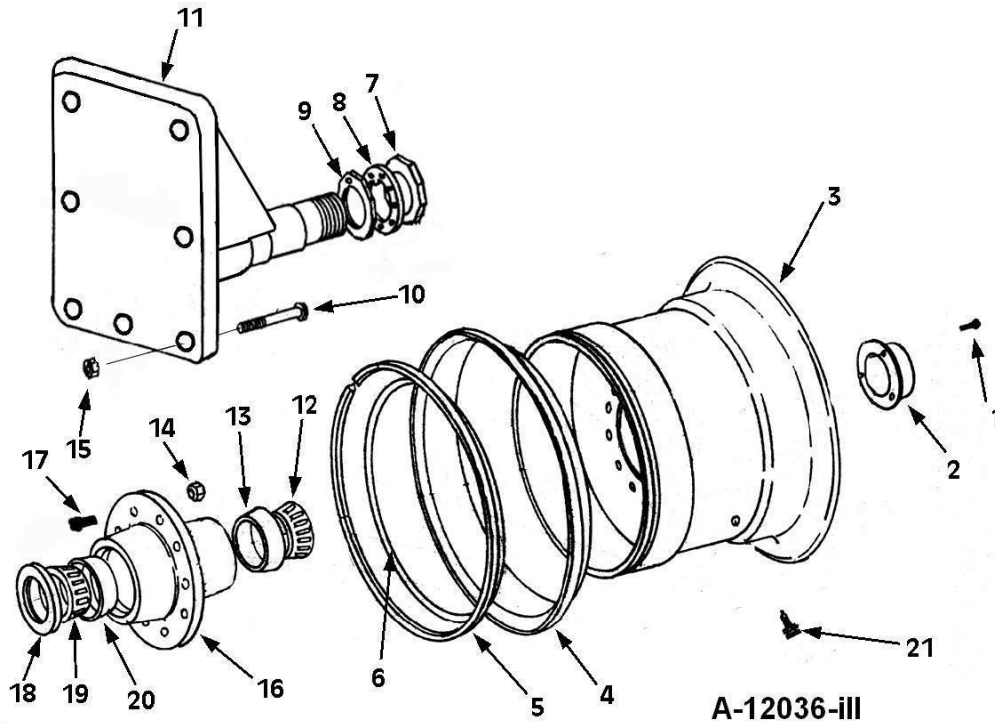


A-14006A-III

Key Number	Part Number	Description
1	AFB-00080	Bolt 5/16" NC x 1/2"
2	A14004	Hub Cap
3	A14006A	Wheel 17" x 25" 
4	A14007A	Side Ring for 17" x 25" Wheel
5	A14008	"O" Ring
6	A14009	Lock Ring
7	A10046	Lug Nut
8	A14010	Hub
9	A10176	Stud
10	A14011	Grease Seal
11	A14012	Bearing Cone
12	A14013	Bearing Cup
13	A14014	Bearing Cup
14	A14015	Bearing Cone
15	A14016	Valve Stem

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REAR WHEEL and HUB ASSEMBLY Part No. A12036

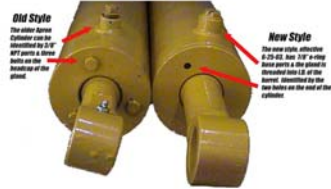


Key Number	Part Number	Description
1	AFB-00080	Bolt 5/16" NC X 1/2" Lg.
2	A14004	Hub Cap
3	A12036	Wheel Ass'y. 25" x 25"
3	A12036-1	Center Dish Weldment, Flat
3	A12036-2	Six Gussets for Center Dish
4	A12041	Side Ring
5	A12042	Lock Ring
6	A12047	O-Ring
7	A10048	Spindle Nut
8	A10049A	Lock Collar
9	A10172	Nut with Lock Pin
10	AFB-00067	Bolt 1-1/4" NF X 7-1/2" Lg.
11	A123350	Spindle
12	A125001	Bearing Cone
13	A125002	Bearing Cup
14	A12051	Lug Nut
15	AFN-00009	Lock Nut: 1-1/4" NF
16	A12035	Hub
17	A12050	Lug
18	A12037	Grease Seal
19	A125003	Bearing Cone
20	A125004	Bearing Cup
21	A14016	Valve Stem

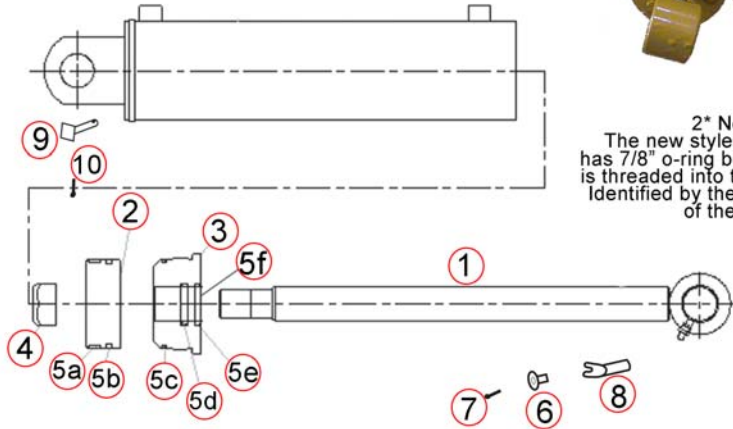
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Apron Cylinder 4 X 13 Part Number A125050

1*Old Style
The older apron cylinder can be identified by 3/8" NPT parts & 3 bolts on the head cap of the gland.



2* New Style
The new style, effective 6/25/03 has 7/8" o-ring base ports, the gland is threaded into the I.D. of the barrel. Identified by the 2 holes on the end of the cylinder.

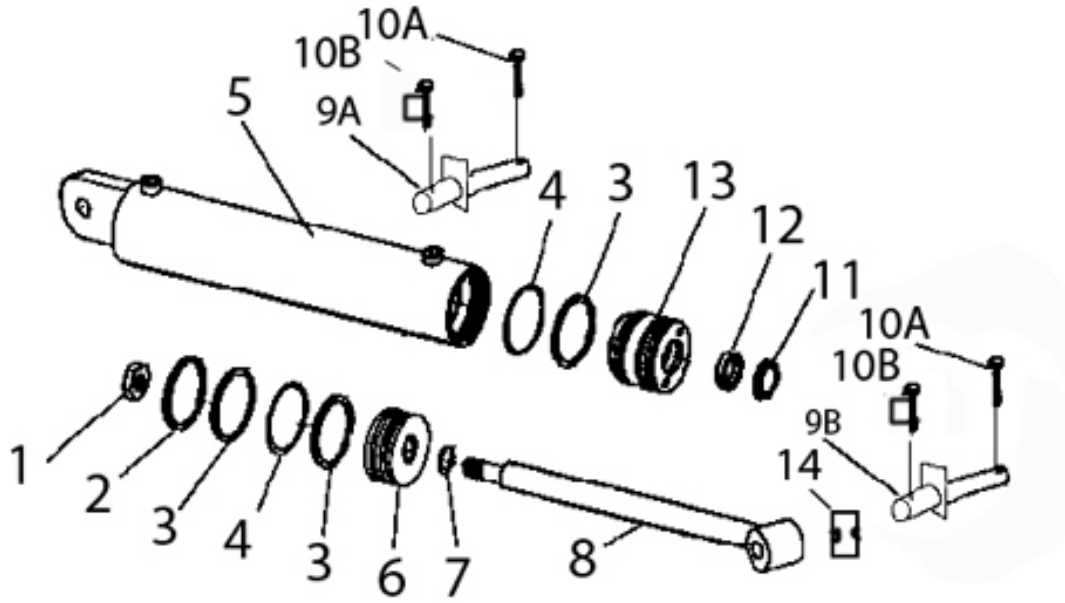


A-125050-III

Key Number	Part Number	Description
1	A125050-01	Rod 1-3/4" with welded eye
2	A125050-02	Piston
3	A125050-03	Gland, Threaded
4	A125050-04	Lock Nut, 1-1/8" NF
5	A125050-05	Seal Kit, a-f
	A125050-05a	Nylon Wear Ring
	A125050-05b	FSP Seal
	A125050-05c	O-Ring
	A125050-05d	Backup Washer
	A125050-05e	Hallite Rod Seal
	A125050-05f	Snap-in Rod Wiper
6	A123362	Pin, 1-1/2" with slot for keeper bushing
7	8602	Pin, Cotter 1/4" x 2" Zinc
8	A123363	Pin: 1-1/2" square head

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Hydraulic Lift Cylinder 5 X 20 Part Number A520H275

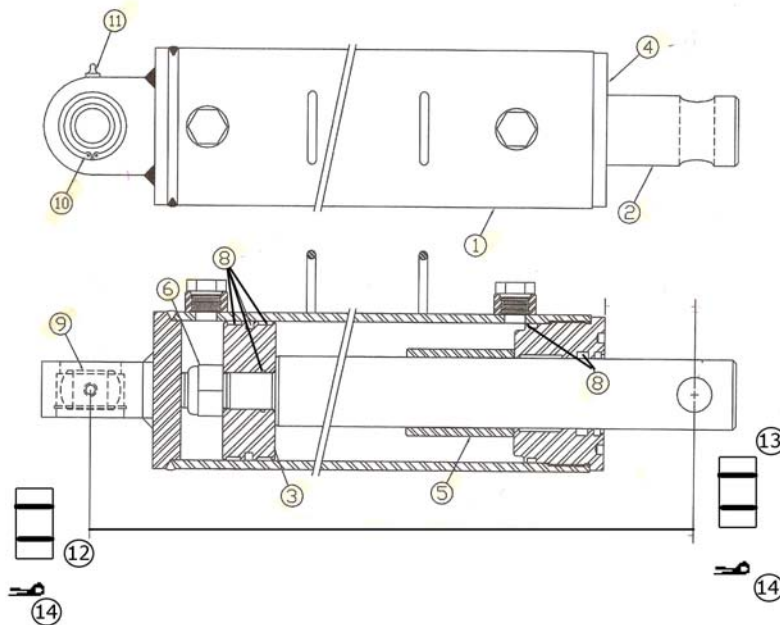


A-520h275-ill

Key Number	Part Number	Description
1	A400H17	Nut 1-1/4" NF, Lock Type
2	A400H04	Cast Ring, 5" OD
3	A400H05	"Back-up Washer, 5" OD x 1/4"
4	A400H06	"O" Ring, 5" OD x 1/4"
5	A80H35	Barrel Assembly with 2" holes
6	A80H01	Piston, 5" OD
7	A60H52	"O" Ring, 1-1/4" OD x 1/16"
8	A80H32	Shaft 2" Dia.
9A.	A123372	Pin, upper
9B.	A123335	Pin, lower
10A.	AFP-00001	Cotter Pin, 1/4" x 3"
10B.	A125006	SafetySnap Pin
11	A80H06	Wiper Seal 2" ID
12	A80H04	Seal 2" ID
13	A80H05A	Head Gland
14	A123231-88	Spacer for lower Pin
	A80H07	Packing Kit, Containing: (1) A400H04 (1) A60H52 (3) A400H05 (1) A80H04, (2) A400H06 (1) A80H06

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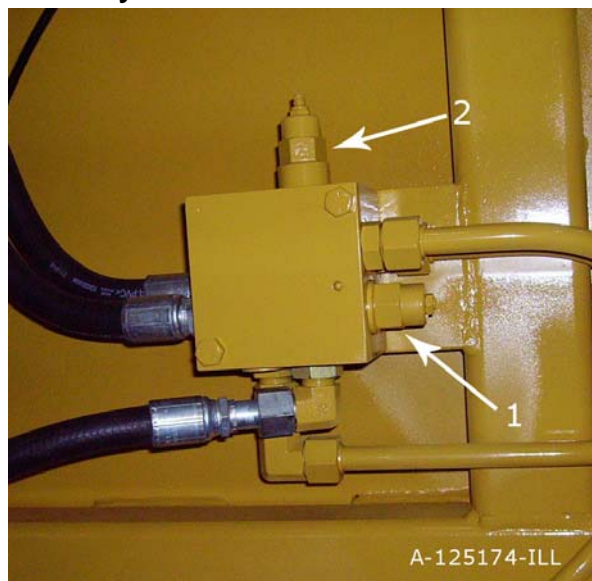
Pushoff Cylinder 5 x 60 Part No. A125177



Key Number	Part Number	Description
1	A125177-10	Barrel Weldment
2	A125177-20	Shaft
3	A125177-30	Piston
4	A125177-31	Head
5	A125176-32	Spacer
6	A125175-33	1 1/4" Nylock Nut
8	A125177-40	Seal Kit
9	A125175-35	Bearing
10	A125175-36	Snap Ring
11	A125175-37	Grease Zerk
12	A9024	Pin 1-1/4 x 4-3/4 Lg
13	A14033	Pin 1-1/4 x 5 Lg
14	AFP-00001	Cotter Pin 1/4 x 2

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Hydraulic Manifold Assembly



IMPORTANT: This Hyd. Manifold was integrated into production April, 2006 It replaces A125070 valve.

For older machines see master parts book on Ashlandind.com.

HYDRAULIC MANIFOLD ASSEMBLY

A125174

SETTING THE APRON AND PUSHOFF VALVE

The manifold block containing the pushoff sequence valve cartridge and apron sequence valve cartridge is used to control two hydraulic circuits with one hydraulic remote. When the tractor hydraulic remote is activated, oil flows first to the apron cylinders until they are fully extended. Once the cylinders are fully extended, the apron circuit's hydraulic pressure begins to increase. Once the pressure threshold is surpassed (which is adjustable, see adjustment section), the sequence valve diverts the oil flow to the pushoff's hydraulic circuit. Once the push off is completely extended, the operator then reverses the tractor's hydraulic remote. The counterbalance valve will hold the apron open until the push off is fully retracted. The Apron sequence valve then opens and allows the apron to close.

Setting the valves:

STEP 1 PUSHOFF SEQUENCE VALVE

Loosen the lock nut (9/16") on the sequence valve cartridge. Turn the setscrew (4mm) clockwise until the front apron rises before the push-off begins to advance. (Earthmover should be empty) Turn the adjustment screw an additional 1/4 turn clockwise and tighten jam nut.

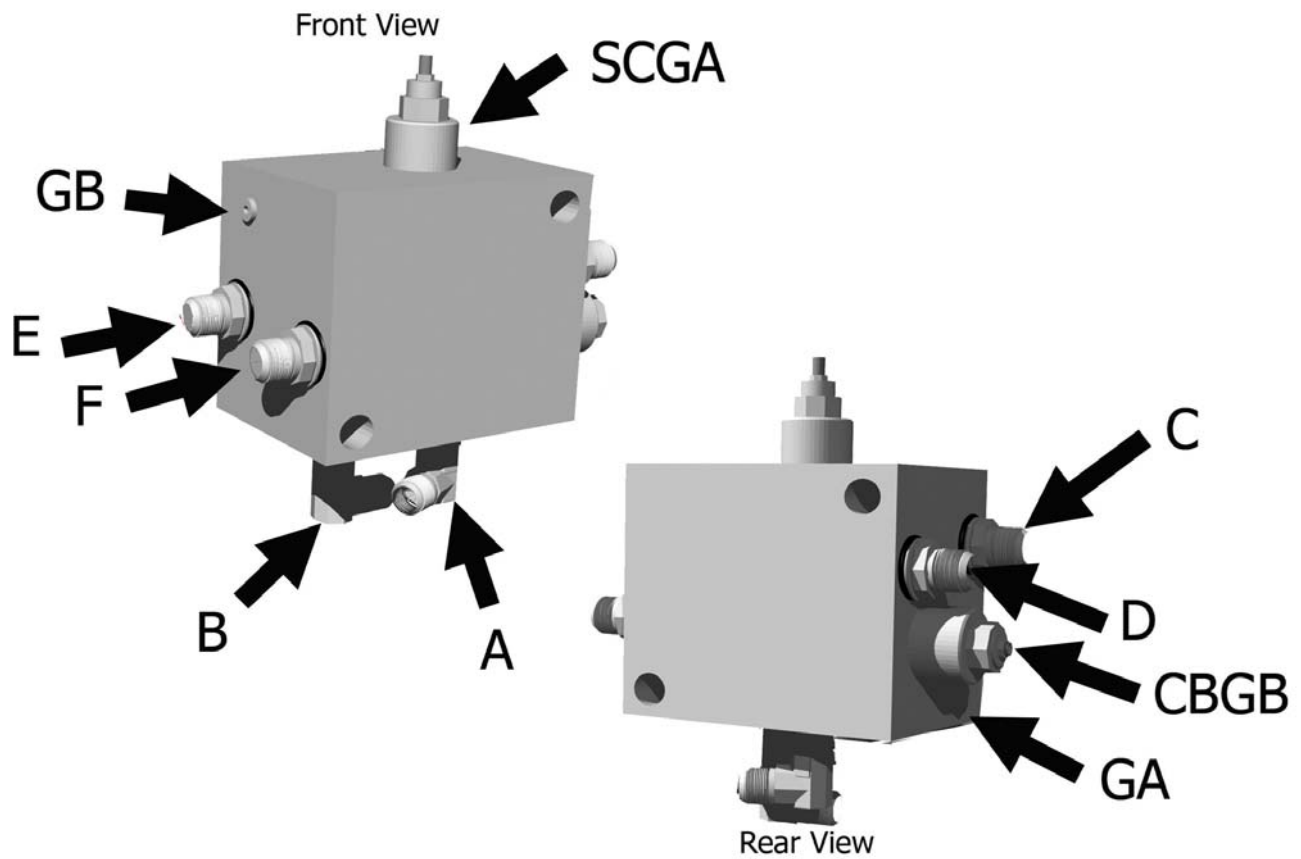
STEP 2 Counter Balance VALVE

Loosen the lock nut (9/16") on the counterbalance valve cartridge. Turn the setscrew (4mm) counter-clockwise until the apron holds in a raised position while rear gate is being retracted. Turn adjustment screw an additional 1/4 turn, tighten jam nut. DO NOT tighten adjusting screw more than necessary.

Key Number	Part Number	Description
1	A125162-01	CENTER BALANCE CARTRIDGE
2	A125162-02	SEQUENCE CARTRIDGE

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Hydraulic Valve Assembly Ports



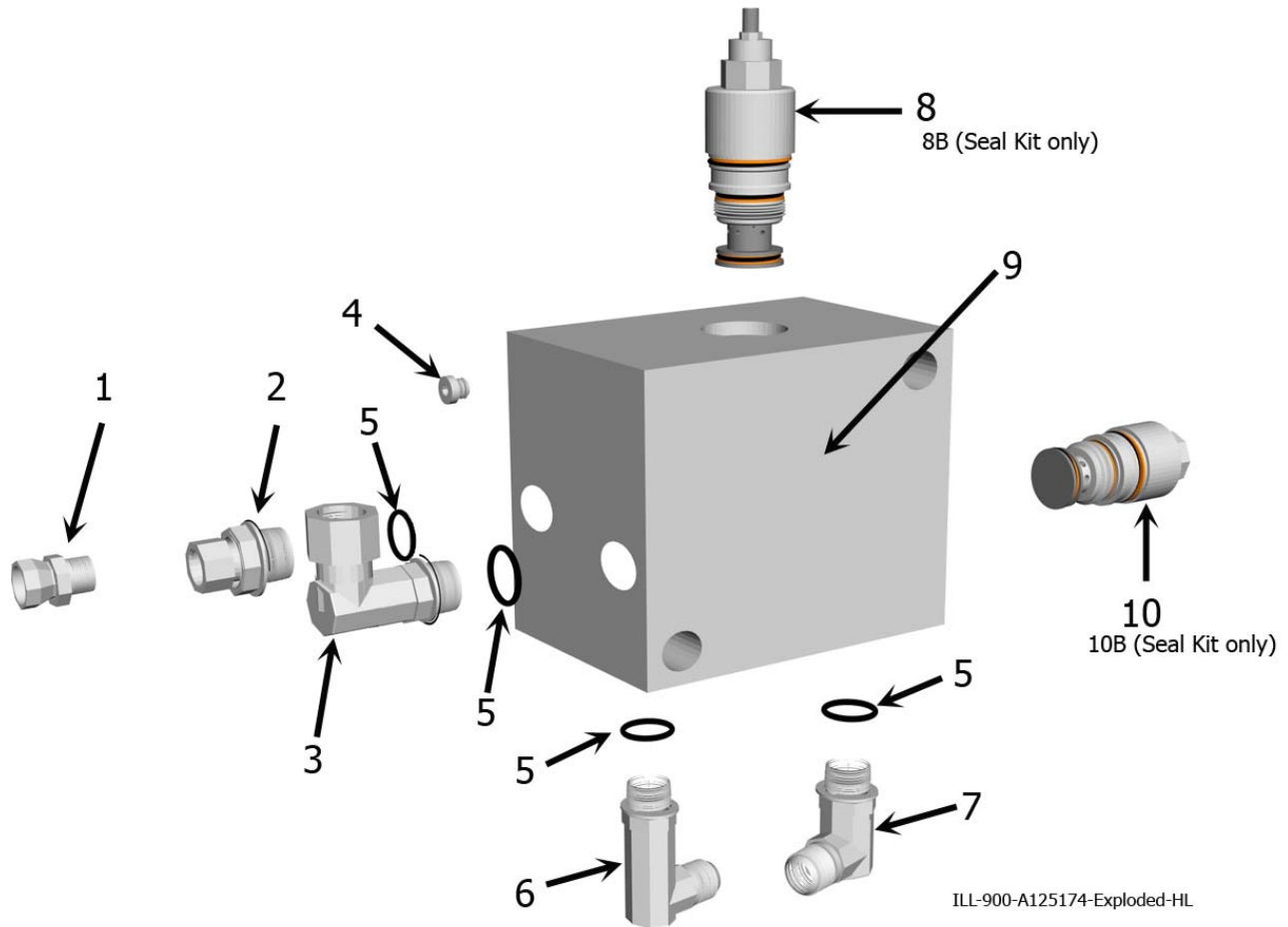
The lettering for the port locations are stamped on the block

A125174 Port Locations.ILL

Key Number	Description
A	Supply Line
B	Pushoff Cyl. (Rod End)-Apron Cyl., Right side (Rod End)-Supply Line
C	Pushoff Cylinder, (Base End)
D	Apron Cylinder, Right side, (Base End)
E	Apron Cylinder, Left side, (Rod End)
F	Apron Cylinder, Left side, (Base End)
CBGB	Counterbalance Valve, adjustable
SCGA	Sequence Valve, adjustable
GA	Pressure test port
GB	Pressure test port

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Hydraulic Valve Seals



<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	AHA-00076	Adapter: Str. Swiv ½ MP X ½ FP. 109 Rest
2	AHA-00043	Adapter: Str. Sw. 1 1/16 M ORB X ½ FP
3	AHA-00048	Adapter: 90 Deg. Swiv. 1 1/16 M ORB X ½ FP
4	AHA-00046	6 ORB Plug
5	AHS-00153	O-ring for 12 M ORB Fitting
6	AHA-00047	Adapter: 90 Deg. XL ¾ MJ X 1 1/16 M ORB
7	AHA-00044	Adapter: 90 Deg. ¾ MJ X 1 1/6 M ORB
8	A125162-02	Valve: Sequence Cartridge for Ver. III & IV
9	A125174	Valve: Manifold Block IV Body
10	A125162-01	Valve: Counterbalance Cartridge for Ver. III & IV
<u>Seal Kits:</u>	A125162-01KIT	Seal Kit for A125162-01 Valve Cartridge
	A125162-02KIT	Seal Kit for A125162-02 Valve Cartridge

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Maintenance check list

MAINTENANCE CHECKLIST

1. Grease all zerks.
 - a) Every 8 hours of operation.
 - b) See Lubrication Points section on next page.

2. Greasing the hubs.
 - a) Re-pack wheel bearings after 600 hrs of operation.
 - b) Completely clean grease out of hub and bearings every 1200 hours of operation.

3. Check tire pressure.
 - a) 20.5 - 25, 12-ply tire requires a tire pressure of 35-40 psi on a rear machine, 40-50 on a front machine.

4. Check all pins for signs of wear.
 - a) Daily

5. Check wheel lug nut torque.
 - a) After first 2 hours of operation.
 - b) Recheck daily for next 2 weeks.
 - c) Tighten wheel lug nuts in a star pattern.
 - d) Torque wheel lug nuts to 450 ft-lbs.

6. Check and retighten all bolts.
 - a) After initial 10 hours of use.
 - b) Again after 50 hours of use.
 - c) See Torque Specifications on next page.

7. Inspect cutting edges.
 - a) Daily
 - b) Replace cutting edges when center blade has been worn to approximately 6" and side edges worn to approximately 4".



CAUTION! Failure to replace worn cutting edges may result in unnecessary wear to the earthmover sides and floor.

Note: Please specify left or right "L" shaped cutting edges when ordering replacements.

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Torque Specifications

TORQUE SPECIFICATIONS

<i>Bolt</i>	<i>Torque</i>
<i>Diameter</i>	<i>Ft-lbs</i>
1/4	12
5/16"	25
3/8"	45
7/16"	70
1/2"	110
9/16"	150
5/8"	220
3/4"	380
7/8"	600
1"	900
1-1/8"	1280
Lug Nuts	750

LUBRICATION

1. Grease all zerks every 8 hrs of operation with high quality, general-purpose grease.
 - a) Grease until grease flows from around pin.

Lubrication Points (see III.)

1. Hitch – Horizontal and vertical pins.
2. Lift Cylinders – Rod end & Trunion; Both left & right sides.
3. Front Arm Pivot Joint – Both left & right sides.
4. Apron Cylinders – Rod clevis pin; Both left & right sides.
5. Apron Pivot Pin – Both left & right sides.
6. Hold-down Rollers – Both left & right sides.
7. Floor Rollers – Both left & right sides.
8. Tapered Rollers – Both left & right sides.

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Pushing the Earthmover



PUSHING THE EARTHMOVER

The I-110TS was designed to be pushed when equipped with the optional push-bar. However, Ashland Industries, Inc. **STRONGLY** recommends using extreme caution when pushing the I-110TS earthmover to prevent any unnecessary damage.

CAUTION! The I-110TS earthmover must be pushed in a straight line with a maximum of a 100 hp dozer. Do not ram or jar the earthmover while pushing and push at a constant speed.

TROUBLESHOOTING

Introduction

With proper care and maintenance, the I-110TS will give many years of reliable service. When a situation arises where the earthmover performance is not satisfactory, this section will give some pointers on finding and correcting the problem.

Grease zerk will not take grease.

1. Grease zerk plugged.
 - a) Remove and replace grease zerk.
 2. Pin is frozen.
 - a) Remove, clean, and inspect pin.
 - b) Replace pin if necessary.
 3. Bushing grease passage is not aligned with grease zerk.
 - a) Remove, clean, inspect, and realign bushing.
 - b) Replace bushing if necessary and realign.
-

Push-off rollers do not roll.

1. The rollers need lubrication.
 - a) Check zerk hole and grease.
 - b) Remove pin, clean, inspect, and replace if necessary.
 2. The roller bushing is worn out.
 - a) Remove roller assembly and replace bushing.
 - b) See parts manual.
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Cylinders will not hold in preset position, i.e. the cylinder creeps.

1. Seals leaking internally.
 - a) Remove and replace seal kit.
-

Machine cuts unevenly.

1. Cutting edges worn unevenly.
 - a) Replace cutting edges.
 2. Improperly inflated tires.
 - a) Check air pressure in tires.
-

I-155 XL2

Warranty Statement

Limited Warranty Statement

Ashland Industries Inc. warrants each new product to be free from defects in material and workmanship. This warranty is applicable only for the normal service life expectancy of the product or components, not to exceed **six consecutive months** from the date of delivery of the new Ashland Industries product to the purchaser, or the date the product is first put into service via a rental agreement or other means, whichever occurs first.

The major components of swivel hitches used on Industrial series scrapers are warranted for three consecutive months from the date of delivery of the new Ashland Industries product to the purchaser, or the date the product is first put into service via a rental agreement or other means, whichever occurs first, except those components described below.

Genuine Ashland Industries Inc. replacement parts and components will be warranted for 30 days from date of purchase, or the remainder of the original equipment warranty period, whichever is longer.

Under no circumstances will it cover any merchandise or components thereof, which in the opinion of the company, has been subjected to misuse, unauthorized modification, alterations, an accident or if repairs have been made with parts other than those obtained through Ashland Industries Inc.

Ashland Industries Inc. in no way warrants Tires since their respective manufacturer warrants these items separately. Please call Ashland Industries Inc. to receive phone numbers of tire suppliers.

Ashland Industries Inc. in no way warrants wearable items such as cutting edges, front dolly wheel balls, socket halves, rollers, bushings, yoke hitch pins, hitch bushings, etc..

Our obligation under this warranty shall be limited to repairing or replacing, free of charge to the original purchaser, any part that, in our judgement, shall show evidence of such defect, provided further that such part shall be returned within 30 days from the date of failure to Ashland Industries Inc. routed through the dealer and distributor from whom the purchase was made, transportation charges prepaid. Upon warranty approval proper credits will be reimbursed for transportation.

This warranty shall not be interpreted to render Ashland Industries Inc. liable for injury or damages of any kind or nature to person or property. This warranty does not extend to the loss revenue, extra labor cost associated with downtime, substitute machinery, rental or for any other reason.

Except as set forth above, Ashland Industries Inc. shall have no obligation or liability of any kind on account of any of its equipment and shall not be liable for special or consequential damages. Ashland Industries Inc. make no other warranty, expressed or implied, and, specifically, Ashland Industries Inc. disclaims any implied warrant or merchantability or fitness for a particular purpose. Some states or provinces do not permit limitations or exclusions of implied warranties or incidental or consequential damages, so the limitations or exclusion in this warranty may not apply.

This warranty is subject to any existing conditions of supply which may direct affect our ability to obtain materials or manufacture replacement parts.

Ashland Industries Inc. reserves the right to make improvements in design or changes in specifications at any time, without incurring any obligation to owners of units previously sold

No one is authorized to alter, Modify or enlarge this warranty nor the exclusion, limitations and reservations.

Ashland Industries Inc.
Warranty Department