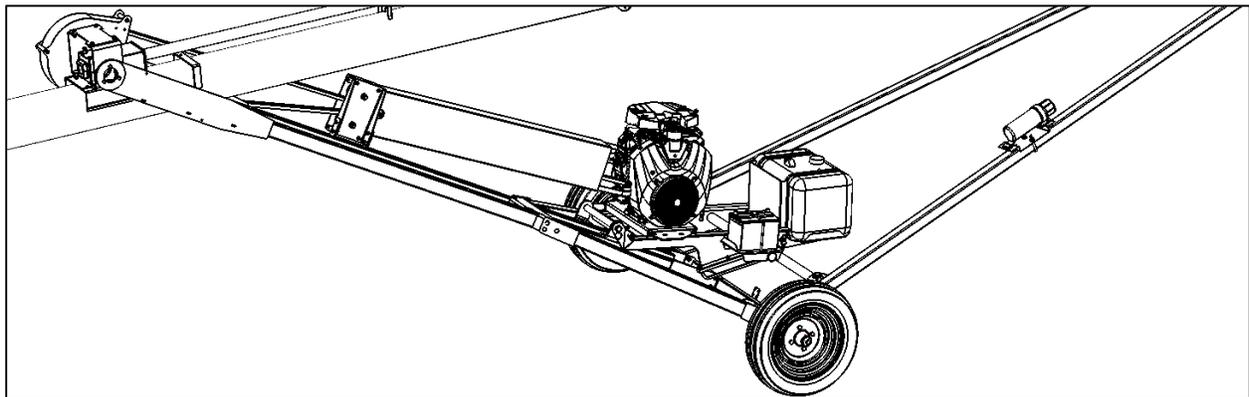
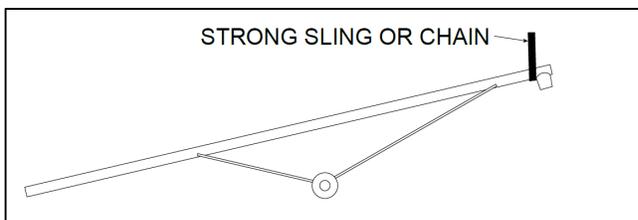


FIELD FIX INSTRUCTIONS

| | |
|-------------------|---|
| PART # | 31077 R0 |
| ECN ID# | ECN.WF-03195 |
| DATE | January 15, 2019 |
| BRAND | Westfield & Wheatheart |
| PRODUCT | STX2 & XTA Series Augers |
| MODEL | All Models |
| DATE RANGE | November 29, 2017 to October 31, 2018 |
| SERIAL # | WF: 214985 to WF02A401810769 WH:18383 to WH02A401810769 |
| DETAILS | These instructions are to be used when replacing the lower frame, axle, motor mount and gas drive components. |



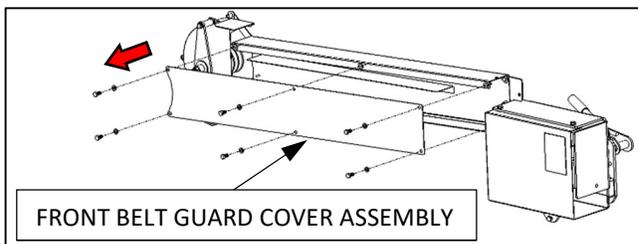
STX2/XTA Lower Frame with Gas Drive



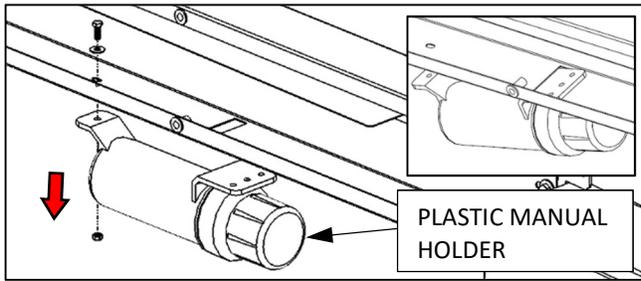
Important:

Be sure to use proper hoisting equipment and procedures when raising the discharge end of the auger. Lock out the hoist apparatus prior to working around or under the raised tube.

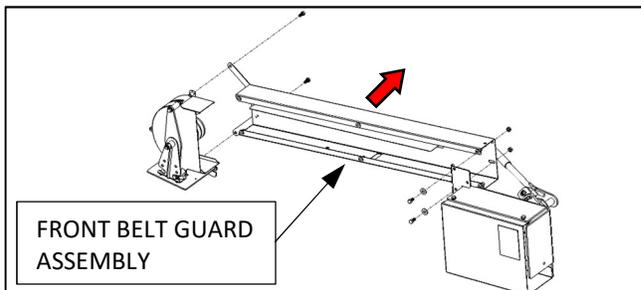
DISASSEMBLY:



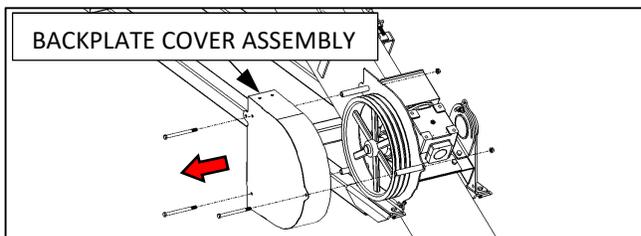
Step 1: Remove the front belt guard cover assembly.



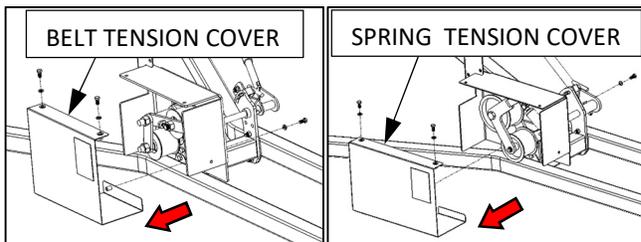
Step 2: Remove the plastic manual holder.



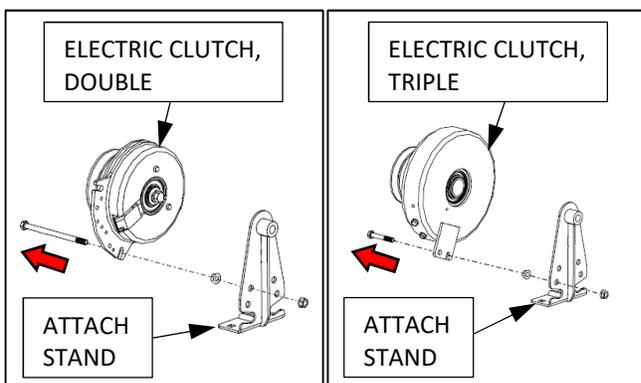
Step 3: Remove the front belt guard assembly.



Step 4: Remove the backplate cover assembly.

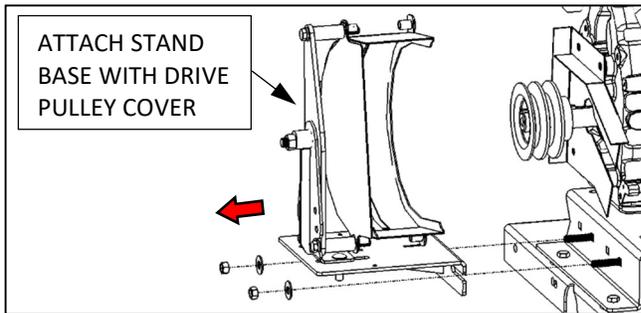


Step 5: Remove the belt/spring tension cover assembly.

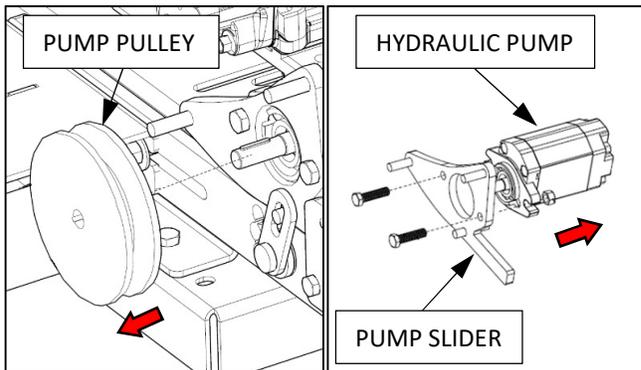


Note: The next step is only required for augers with an electric clutch.

Step 6: Remove bolt that secures the electric clutch to the attach stand.



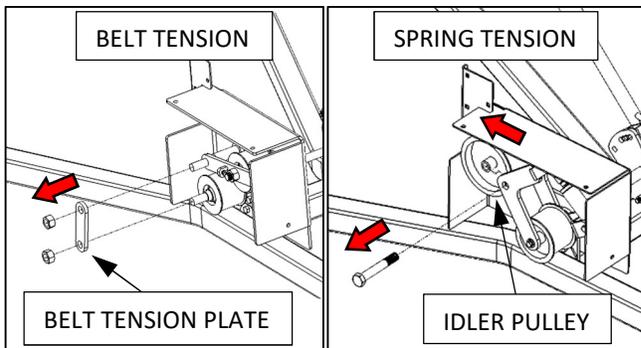
Step 7: Remove the attach stand base with drive pulley cover.



Note: The next two steps are only required for augers with an SP or HDSP kit.

Step 8: Loosen pump belt and remove the pump pulley.

Step 9: Disconnect the hydraulic hoses from the pump and remove the hydraulic pump.

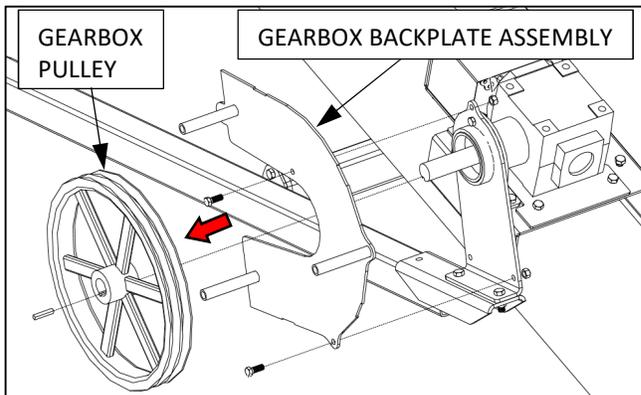


Step 10:

Belt Tension Assembly Only - Loosen belt and remove the belt tension plate.

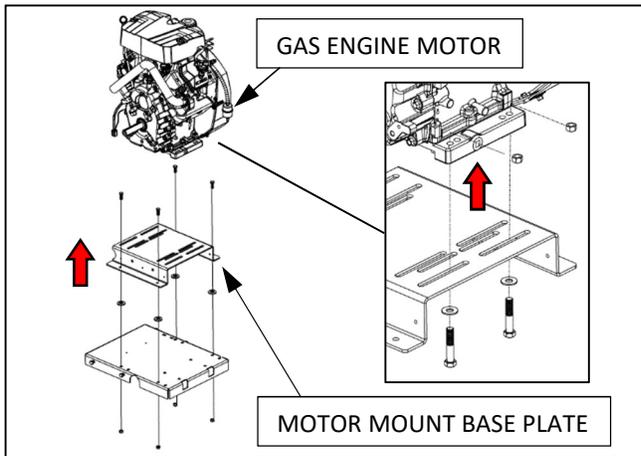
Spring Tension Assembly Only - Loosen belt and remove the larger flat idler pulley.

Step 11: Remove the existing belt.



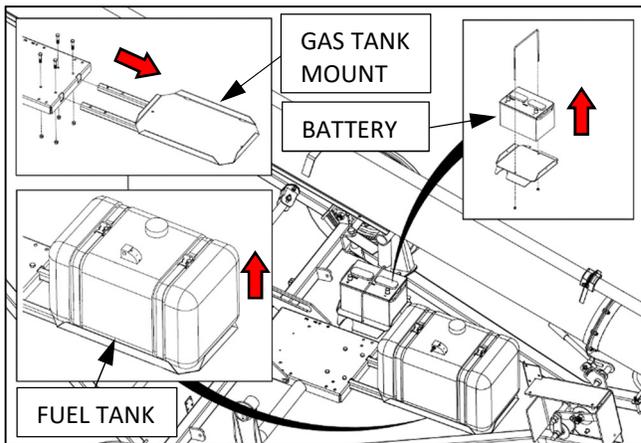
Step 12: Remove the gearbox pulley.

Step 13: Remove the gearbox backplate assembly.



Step 14: Remove gas engine motor.

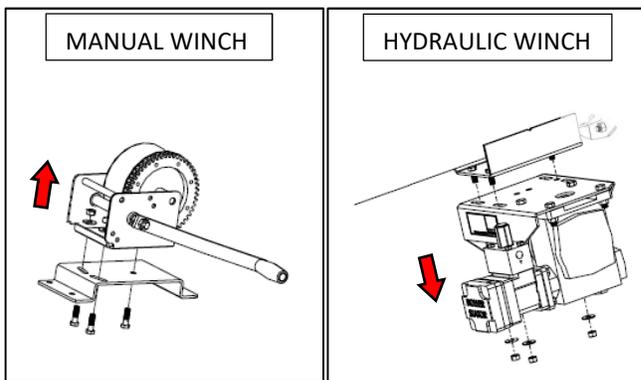
Step 15: Remove motor mount base plate.



Step 16: Remove the battery.

Step 17: Remove the fuel tank.

Step 18: Remove the gas tank mount.

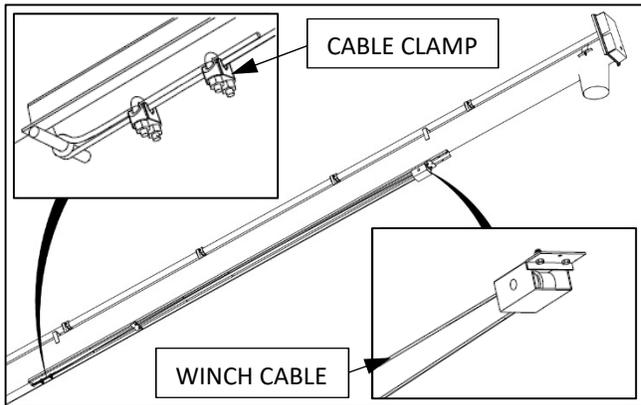


Step 19: Disconnect the lift cable from the winch.

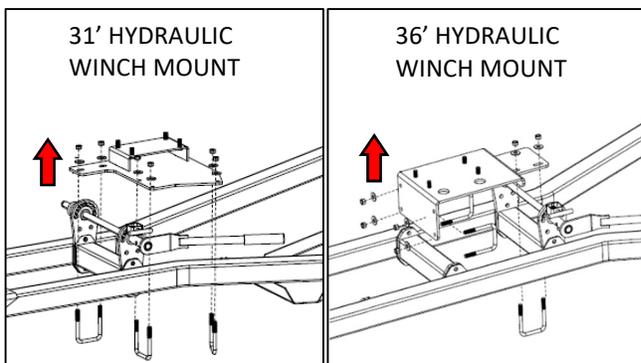
Note: Step 20 is *only required for augers with a hydraulic winch.*

Step 20: Disconnect the hydraulic hoses from the hydraulic winch.

Step 21: Remove the winch.

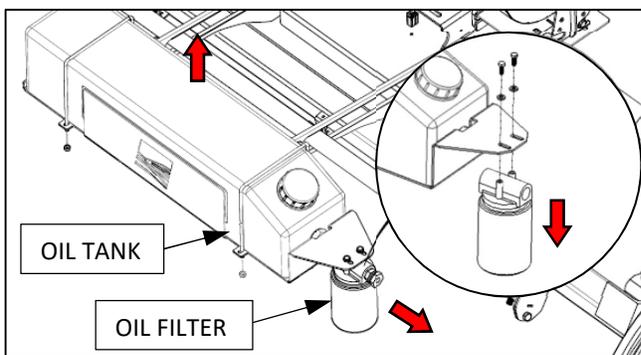


Step 22: Remove cable clamps and winch cable.



Note: The next step is only required for 31'/36' augers with a hydraulic winch.

Step 23: Remove the hydraulic winch mount from the lower frame.

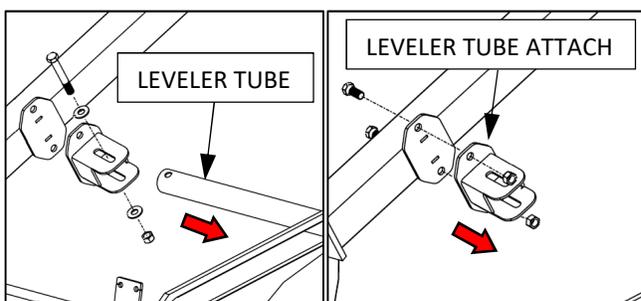


Note: The next three steps are only required for augers with an SP or HDSP kit.

Step 24: Disconnect hydraulic hoses from the oil filter and the oil tank.

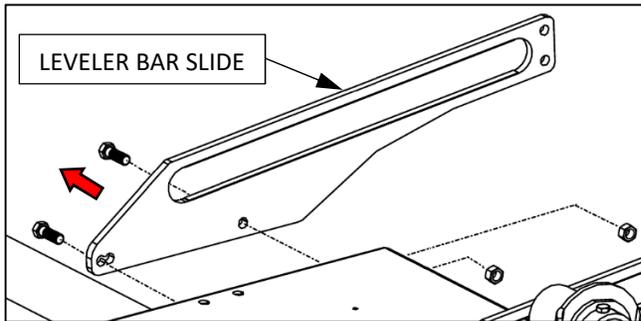
Step 25: Disconnect oil filter from the oil tank and remove the oil filter.

Step 26: Remove the oil tank.

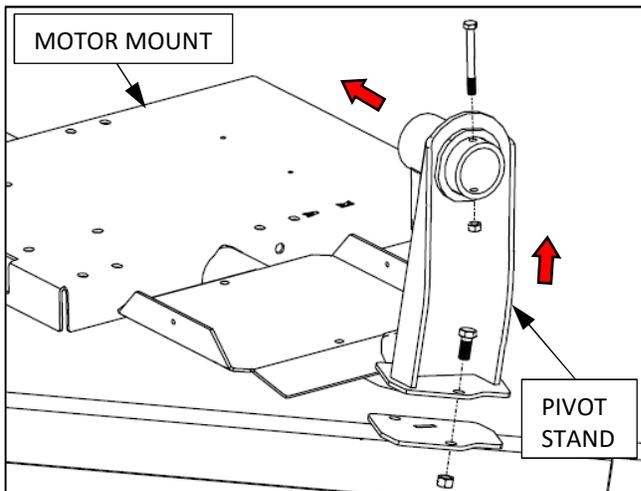


Step 27: Remove the leveler tube.

Step 28: Remove the leveler tube attach.

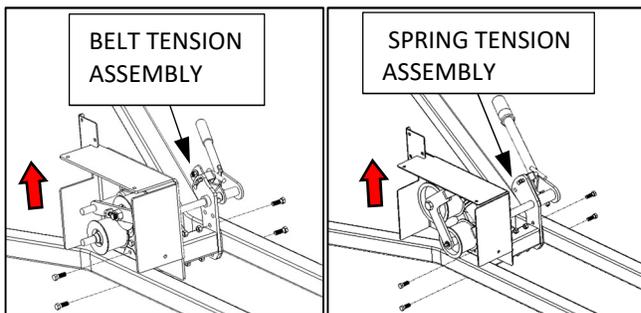


Step 29: Remove the leveler bar slide.

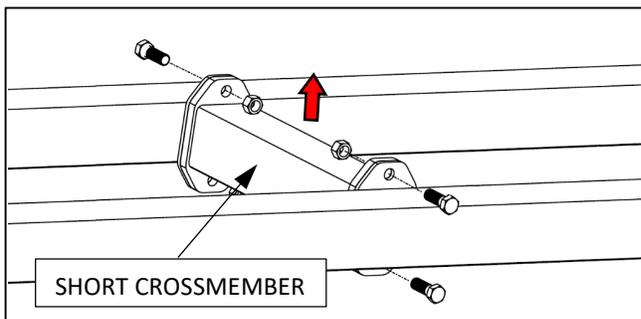


Step 30: Remove pivot stands.

Step 31: Remove motor mount.

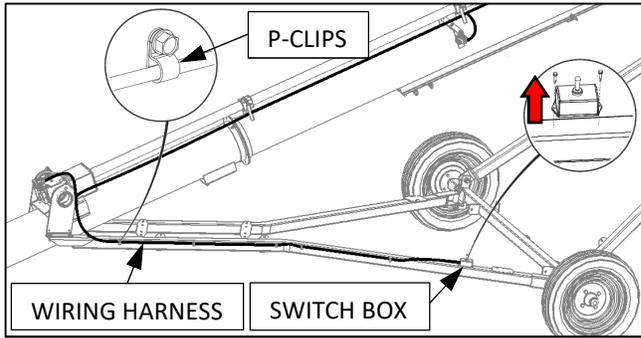


Step 32: Insert spreader clamp between frame tubes to remove the belt/spring tension assembly.



Note: The next step is not required for 31' auger models.

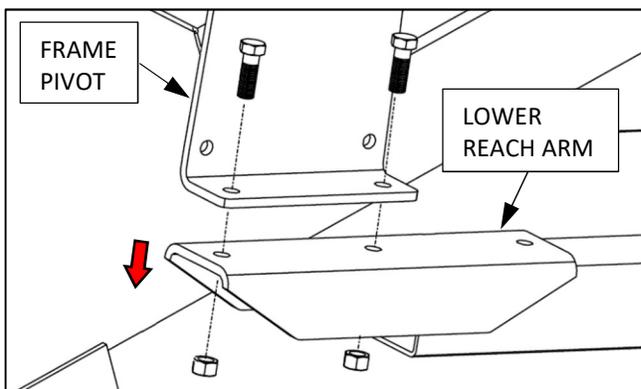
Step 33: Remove short crossmember.



Note: The next two steps are only required for augers with a work light kit.

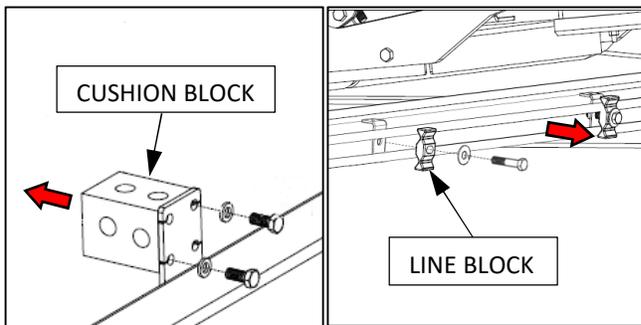
Step 34: Remove the switch box from the lower frame.

Step 35: Remove the wiring harness from the lower frame.



Step 36: Remove all hydraulic hoses and wiring from the lower frames, if applicable.

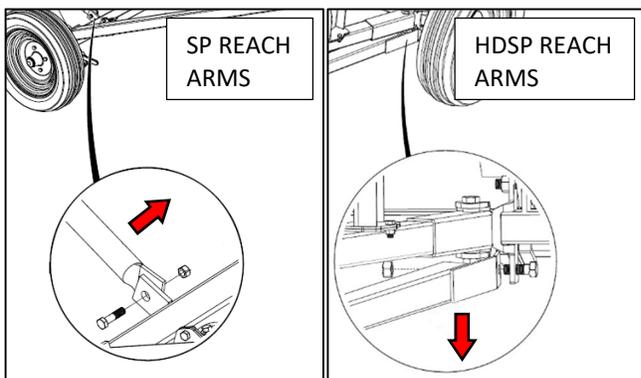
Step 37: Remove lower frame arms from the frame pivots.



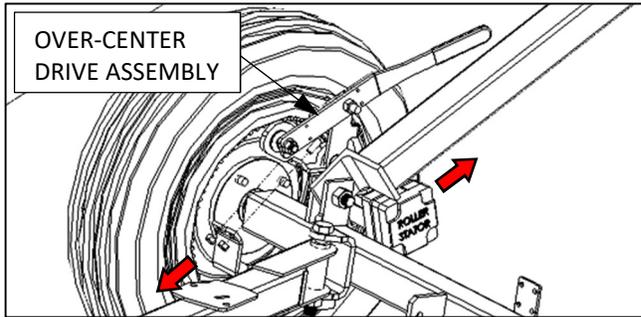
Note: The next four steps are only required for augers with an SP or HDSP kit.

Step 38: Disconnect the hydraulic hoses from the cushion block and remove the cushion block.

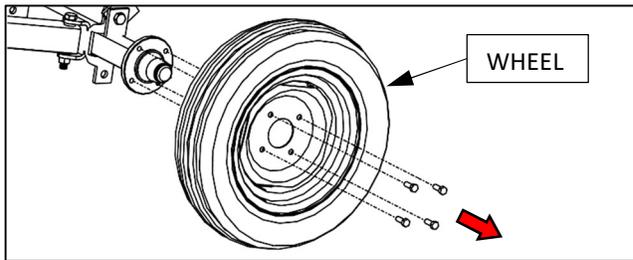
Step 39: Remove the two line blocks from the auger axle.



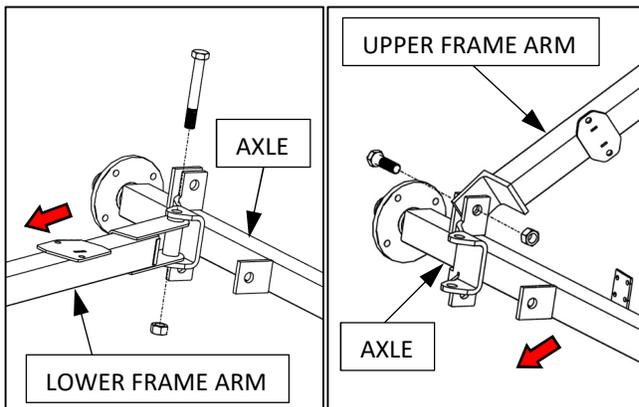
Step 40: Disconnect the SP/HDSP reach arms from the auger axle.



Step 41: Disconnect the hydraulic hoses from the over-center drive assemblies and remove the over-center drive assemblies from the auger axle.



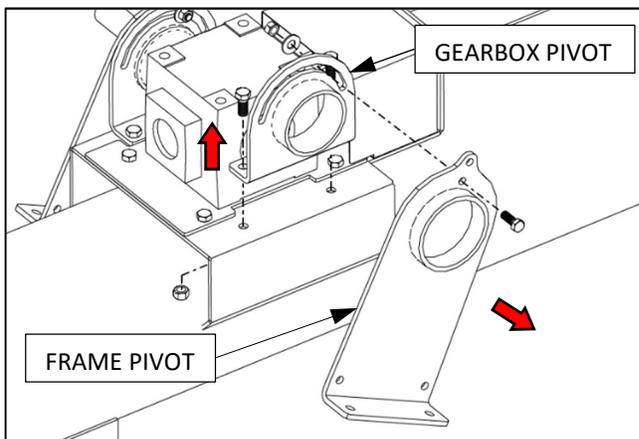
Step 42: Remove the wheels.



Note: Ensure all hydraulic hoses and wiring has been removed from the lower frame arms, if applicable.

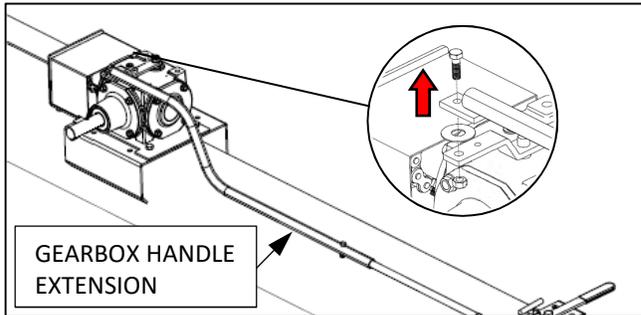
Step 43: Remove lower frame arms from the axle.

Step 44: Remove axle from the upper frame arms.



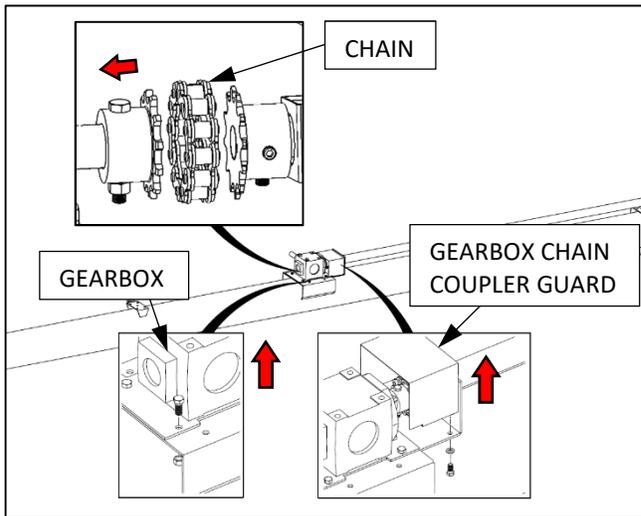
Step 45: Remove the frame pivots from the gearbox pivots.

Step 46: Remove the gearbox pivots.



Note: The next step is only required for augers (excluding 31') with a reversible gearbox.

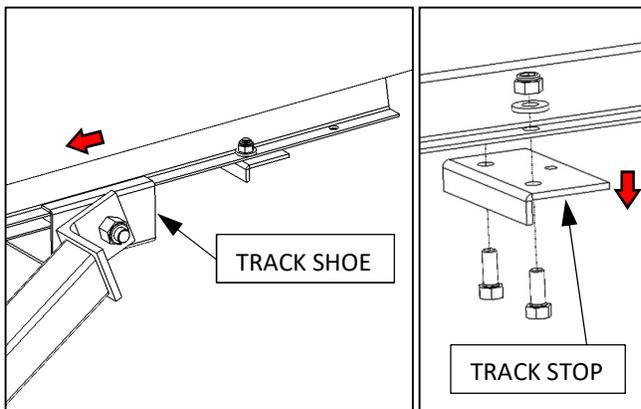
Step 47: Detach the gearbox handle extension from the reversible gearbox.



Step 48: Remove gearbox chain coupler guard.

Step 49: Disconnect chain from the coupler sprockets.

Step 50: Remove gearbox assembly from the auger tube.

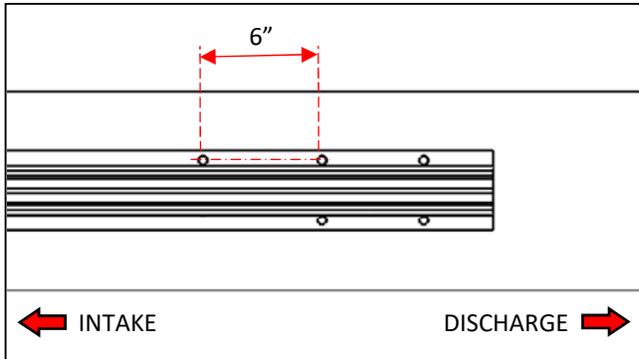


Note: The next two steps are only required for 31'/36' augers.

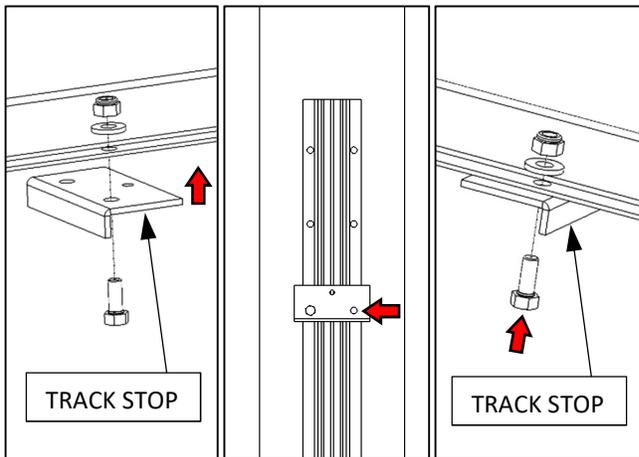
Step 51: Move track shoe away from the upper track stop.

Step 52: Remove the upper track stop.

INSTALL THE TRACK STOP (31'/36' AUGERS ONLY):



Step 1: Measure 6" from the center of the existing trackstop hole. The new hole must be positioned towards the intake end of auger. Drill the first bolt hole.



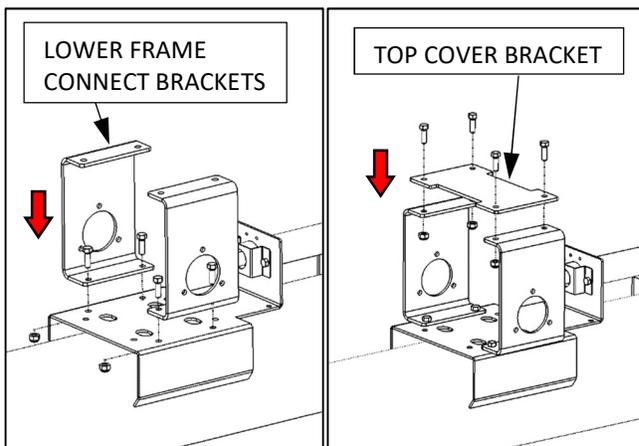
Step 2: Install the first 7/16" x 1" bolt, track washer and locknut. Tighten securely.

Note: Ensure the trackstop is tightened square with the track.

Step 3: Use the trackstop as a template, drill the second bolt hole.

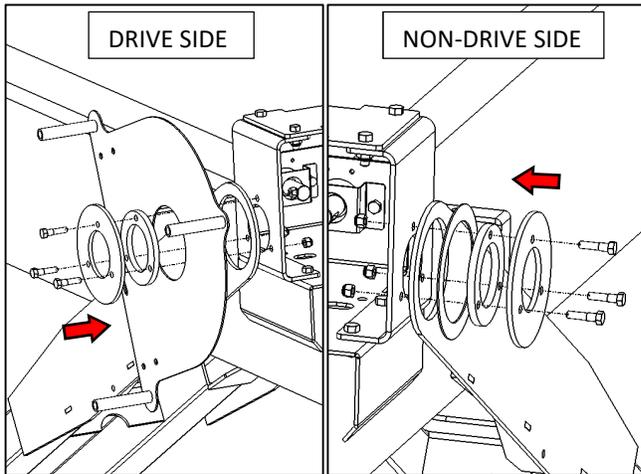
Step 4: Install the second 7/16" x 1" bolt, track washer and locknut. Tighten securely.

INSTALL THE LOWER FRAME, AXLE & WHEELS:



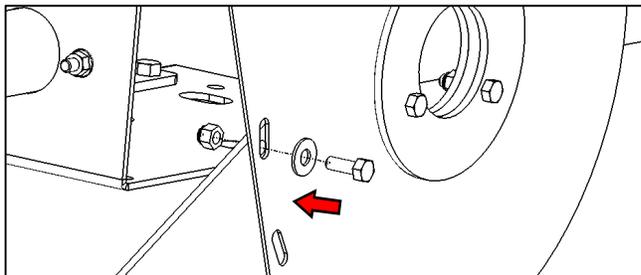
Step 1: Install the lower frame connect brackets to the tube using four 7/16" x 1-1/4" bolts and locknuts.

Step 2: Install the top cover bracket to the lower frame connect brackets using four 7/16" x 1-1/4" bolts and locknuts.



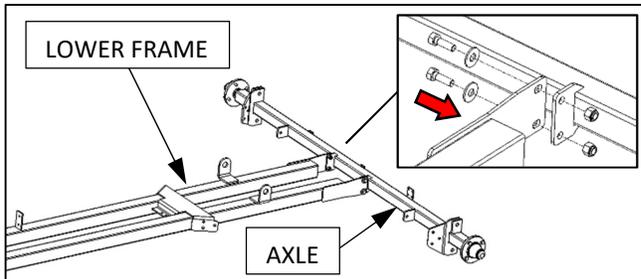
Step 3: Install the new lower frame to the lower frame mount brackets.

- a. Drive Side: Attach with new pulley shim guard, one small bolt plate, one large bolt plate, three 3/8" x 1-1/2" bolts and three 3/8" locknuts.
- b. Non-Drive Side: Attach using one spacer, one small bolt plate, one large bolt plate, three 3/8" x 1-1/2" bolts and three 3/8" locknuts.

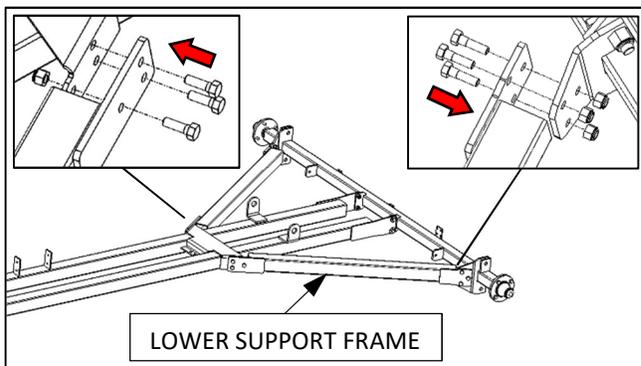


Step 4: Lock the pulley shim guard using one 3/8" x 1" bolt, flat washer and locknut.

Note: Ensure that the pulley shim guard is centered on the lower arm bolt plates.



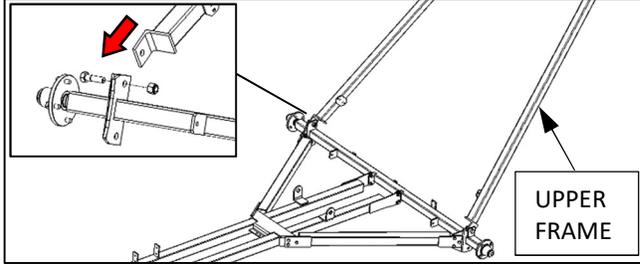
Step 5: Loosely install the lower frame to the new axle using four 1/2" x 1-1/2" bolts, flat washers and locknuts.



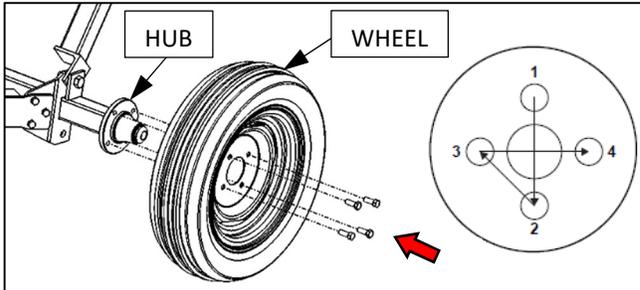
Step 6: Loosely install the lower support frames to the axle using six 1/2" x 1-3/4" bolts and locknuts.

Step 7: Loosely install the lower support frames to the lower frame using six 1/2" x 1-1/2" bolts and locknuts.

Step 8: Tighten all hardware that secures the lower frame to the axle.



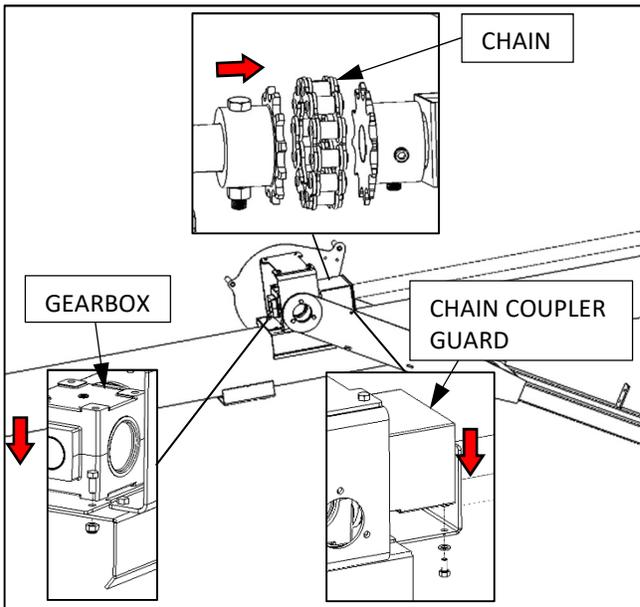
Step 9: Install upper frame arms to axle using the two existing 3/4" x 2-1/2" bolts and locknuts.



Step 10: Re-install wheels to hubs using the eight existing 1/2" x 1" wheel bolts.

Note: Torque the wheel bolts to 80 ft·lb ± 10 ft·lb (108.5 N·m ± 13.5 N·m) using the pattern shown.

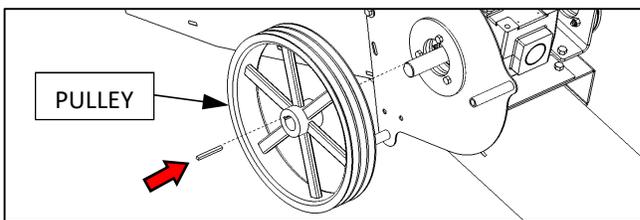
INSTALL THE GEARBOX:



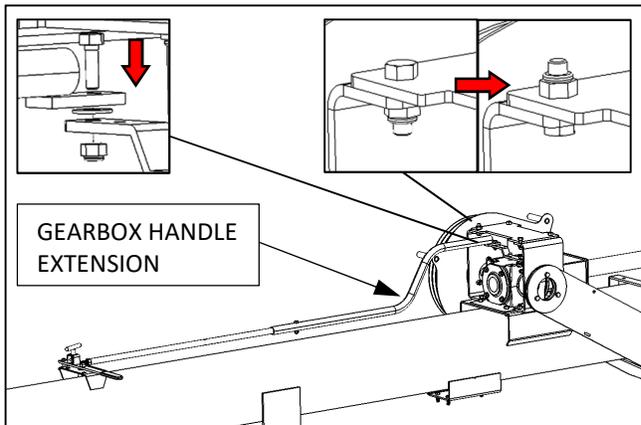
Step 1: Re-install chain on the coupler sprockets.

Step 2: Re-install gearbox using the four existing 7/16" x 1" bolts and locknuts.

Step 3: Re-install chain coupler guard using the two existing 3/8" x 3/4" bolts and lock washers.



Step 4: Re-install the pulley onto the gearbox shaft using the existing square key.

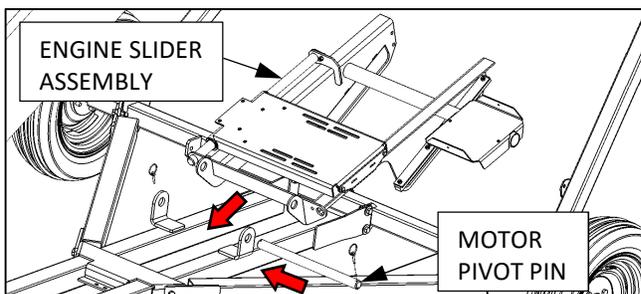


Note: The next two steps are only required for augers (excluding 31') with a reversible gearbox.

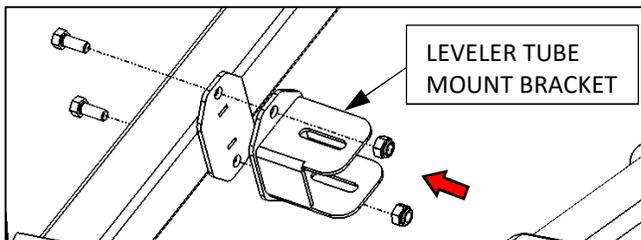
Step 5: Flip around the top cover bracket bolt and locknut that is above the gearbox handle extension.

Step 6: Attach the gearbox handle extension to the reversible gearbox using the existing 5/16" x 1" bolt, flat washer and locknut.

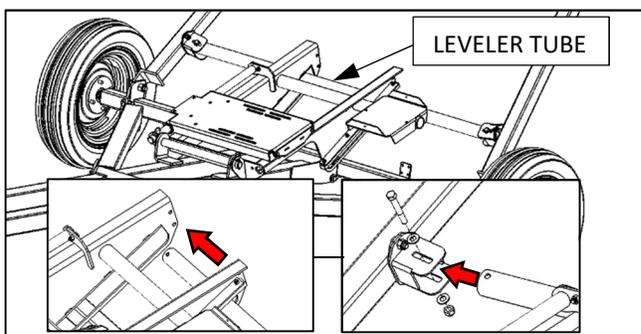
INSTALL THE MOTOR MOUNT:



Step 1: Attach the new engine slider assembly to the lower frame using the motor pivot pin and two lynch pins.

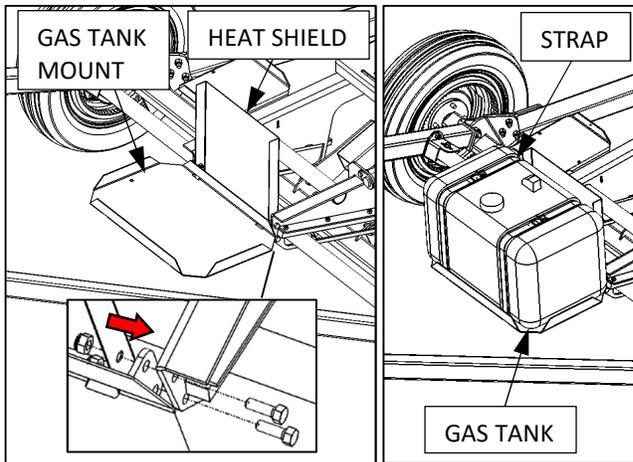


Step 2: Attach the leveler tube mount brackets to the upper frame arms using four 7/16" x 1" bolts and locknuts.



Step 3: Slide leveler tube through the two slots in the engine slider assembly. Secure to the leveler tube mount brackets using two 7/16" x 3" bolts, four 7/16" flat washers and two 7/16" locknuts.

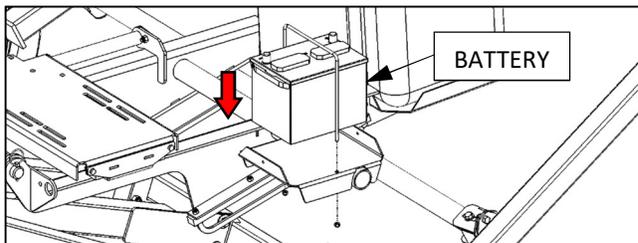
INSTALL THE GAS TANK & BATTERY:



Step 1: Attach the heat shield and gas tank mount to the engine slider assembly using four 7/16" x 1-1/4" bolts and locknuts.

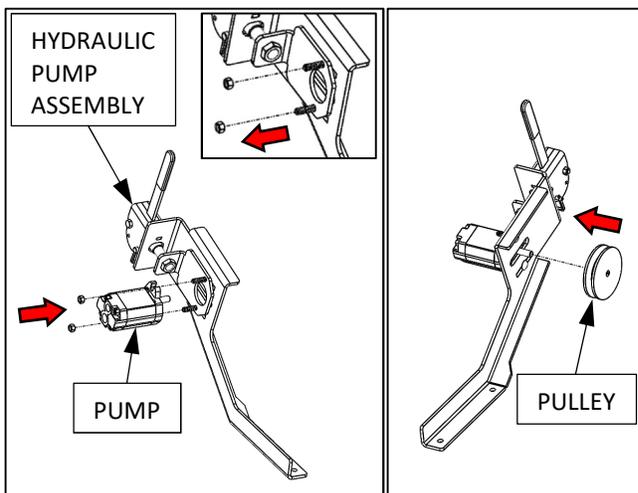
Step 2: Re-install gas tank to gas tank mount using the two existing straps.

Note: Route the 60" fuel line between the heat shield and the gas tank.



Step 3: Re-install battery to engine slider assembly using the existing 1/4" u-bolt and two 1/4" locknuts.

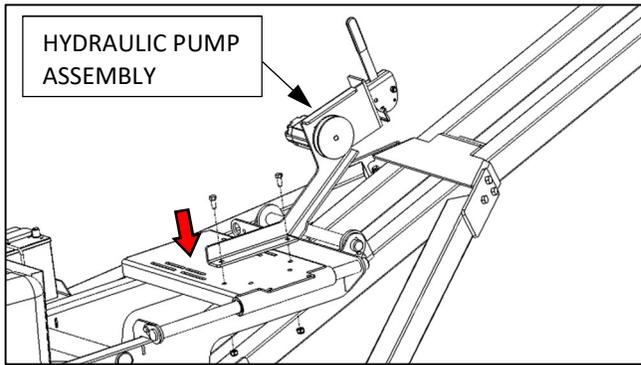
INSTALL THE HYDRAULIC PUMP (AUGERS WITH SP & HDSP KIT ONLY):



Step 1: Remove the two 3/8" hex nuts from the hydraulic pump assembly.

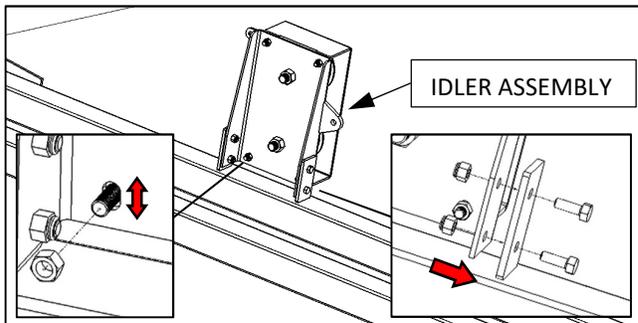
Step 2: Loosely install the existing hydraulic pump to the hydraulic pump assembly using the two 3/8" x 1-3/4" carriage bolts and hex nuts provided.

Step 3: Re-install the existing pulley to the hydraulic pump.



Step 4: Attach the new hydraulic pump assembly to the engine slider assembly using two 7/16" x 1-1/4" bolts and locknuts.

INSTALL THE IDLER ASSEMBLY (EXCLUDING 31' AUGERS):

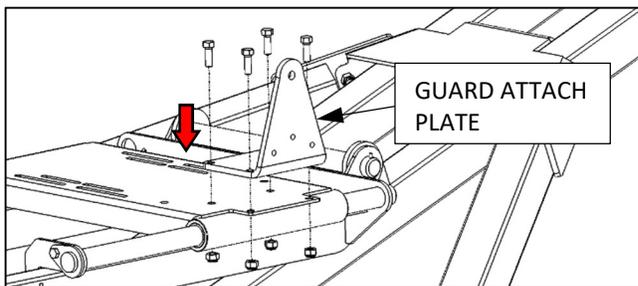


Step 1: Attach the new idler assembly to the lower frame using four 3/8" x 1" bolts and locknuts.

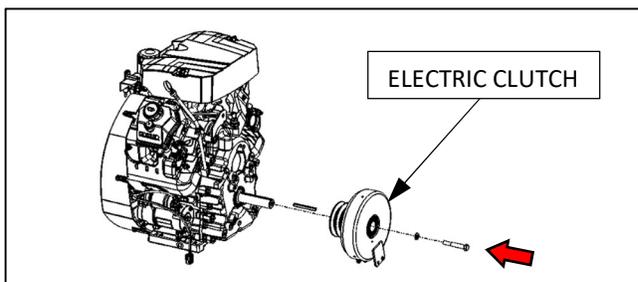
Notes:

- Use a level/square to ensure the idler assembly is mounted straight.
- The slots in the main plate can be used to adjust the tilt of the pulleys.

INSTALL THE ELECTRIC CLUTCH, MOTOR, BELT & GUARDS:

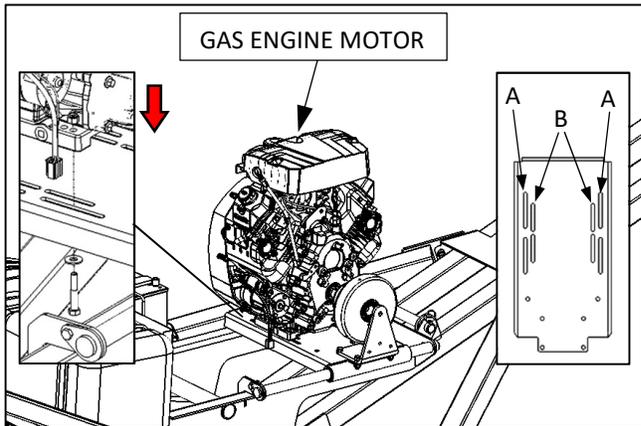


Step 1: Attach the new guard attach plate to the engine slider assembly using four 7/16" x 1-1/4" bolts and locknuts.



Note: The next step is only required for augers that did not have the electric clutch option kit.

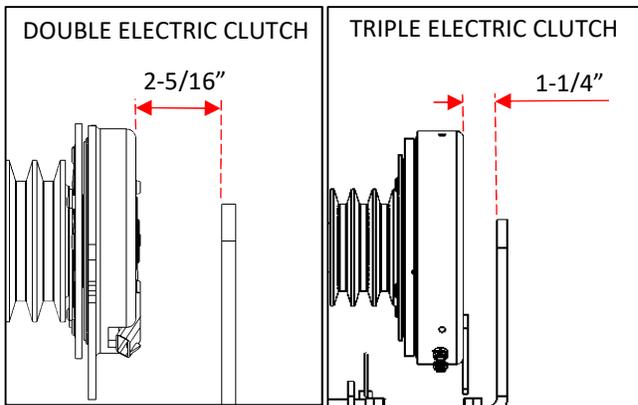
Step 2: Slide electric clutch onto motor shaft using the existing square key. Secure with one 7/16" x 3" bolt and lock washer.



Step 3: Loosely install gas engine motor to engine slider assembly using the four existing 3/8" x 2-1/4" bolts, flat washers and locknuts.

| | |
|---|---|
| A | Kohler, 32.5 HP & Larger Vanguard, 35 HP |
| B | Kohler, 27 HP & Smaller |

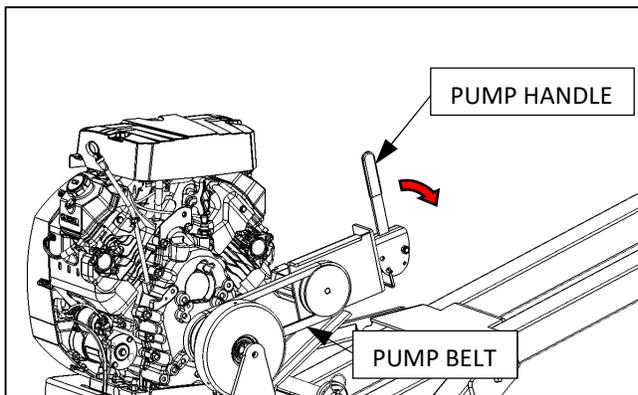
Step 4: Perform all engine wiring. Connect fuel hose and secure with the existing hose clamps.



Step 5: Place the motor so that the gap between the face of the electric clutch and the inside face of the guard attach bracket is:

- Double Clutch: 2-5/16".
- Triple Clutch: 1-1/4".

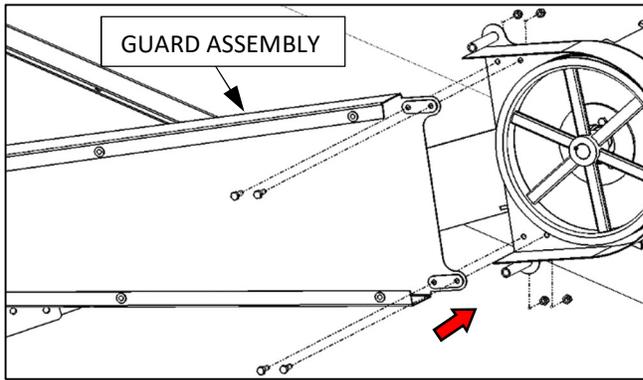
Step 6: Tighten hardware that secures the gas engine motor to the engine slider assembly.



Note: The next two steps are only required for augers with an SP or HDSP kit.

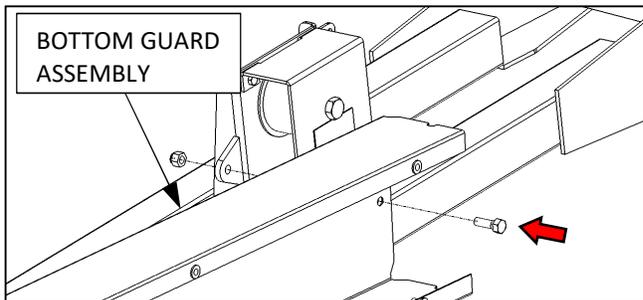
Step 7: Install the BX35 pump belt. Tighten the hardware that secures the pump.

Step 8: Rotate pump handle clockwise to apply tension to the pump belt and pull down handle to lock the belt in place.



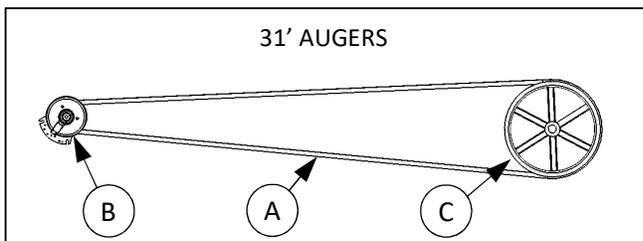
Note: The next step is only required for 31' augers.

Step 9: Attach the new guard assembly to the pulley shim guard using four 3/8" x 1" bolts and locknuts.



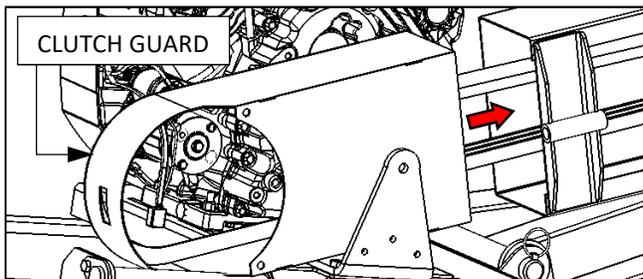
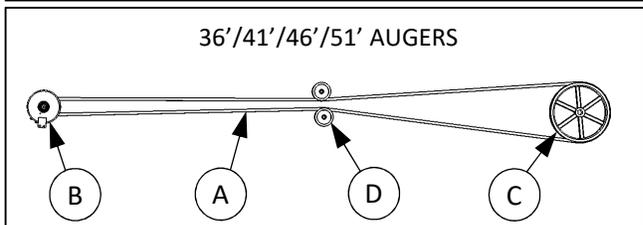
Note: The next step is only required for 36'/41'/46'/51' augers.

Step 10: Attach the new bottom guard assembly to the idler assembly using one 1/2" x 1-3/4" bolt and locknut.

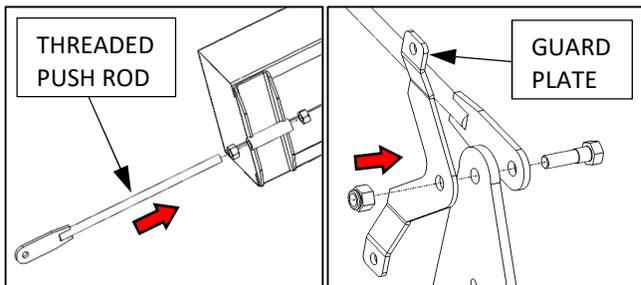


Step 11: Install the drive belt.

| | |
|---|-----------------|
| A | Drive Belt |
| B | Electric Clutch |
| C | Gearbox Pulley |
| D | Idler Pulley |

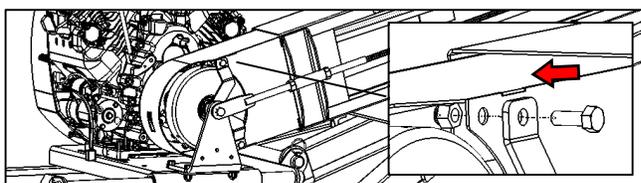


Step 12: Slip the clutch guard over the electric clutch and slide into the guard assembly.

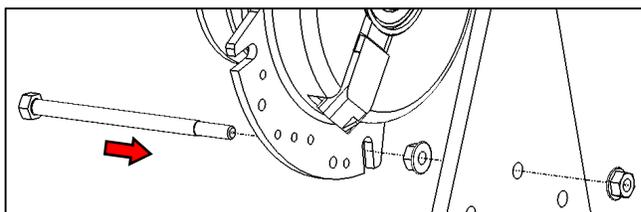


Step 13: Attach the threaded push rod through the guard assembly using two 5/8" hex nuts.

Step 14: Attach the guard retainer plate and threaded push rod to the guard attach plate using one 1/2" x 1-3/4" bolt and locknut.

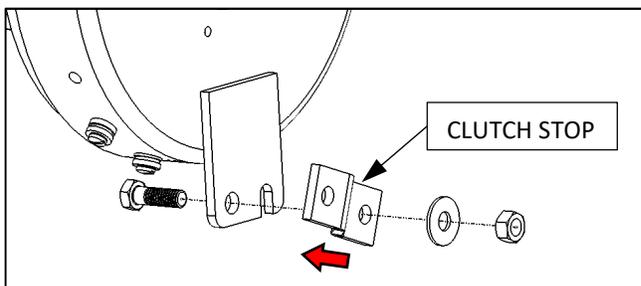


Step 15: Attach the guard retainer plate to the clutch guard using two 3/8" x 1" bolts and locknuts.



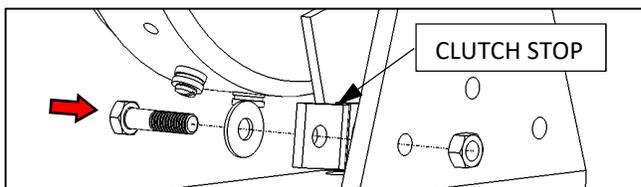
Note: The next step is only required for augers with a double electric clutch.

Step 16: Position the 5/16" x 5" bolt so that it fits into the clutch case slot and secure it with two 5/16" whiznuts.

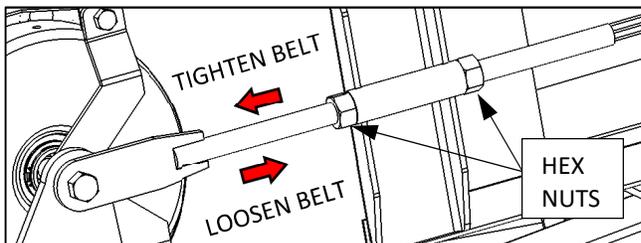


Note: The next two steps are only required for augers with a triple electric clutch.

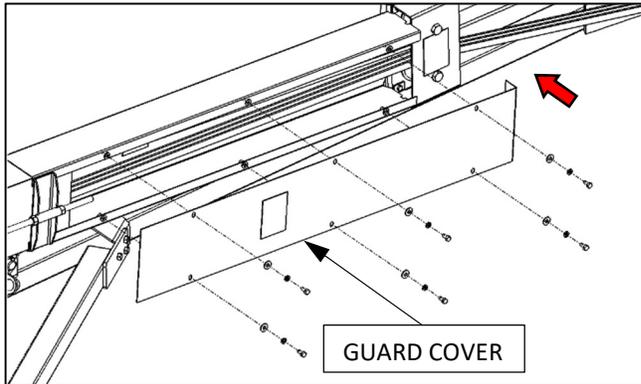
Step 17: Attach the clutch stop to the electric clutch using one 5/16" x 1" bolt, flat washer and locknut.



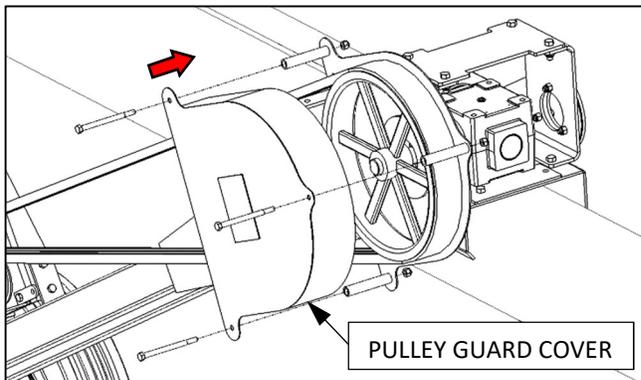
Step 18: Attach the clutch stop to the guard attach bracket using one 5/16" x 1-1/4" bolt, flat washer and locknut.



Step 19: Use the two hex nuts to apply tension to the drive belt.

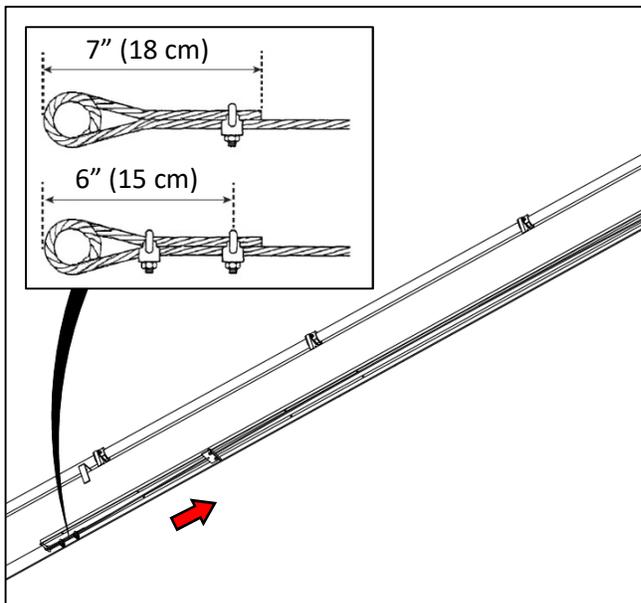


Step 20: Attach the guard cover to the guard assembly using six 3/8" x 3/4" bolts, lock washers and flat washers.



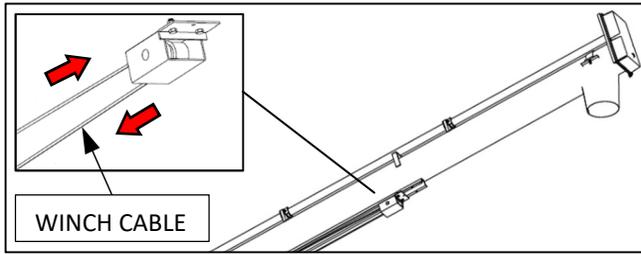
Step 21: Attach the pulley guard cover to the pulley guard using three 3/8" x 5" bolts and locknuts.

INSTALL THE LIFT CABLE:



Step 1: Attach the new cable to the cable attach rod by wrapping it around the rod 1.5 times and doubling-back 7" (18 cm) of cable. Secure the cable in place by installing and tightening the two existing 1/4" cable clamps.

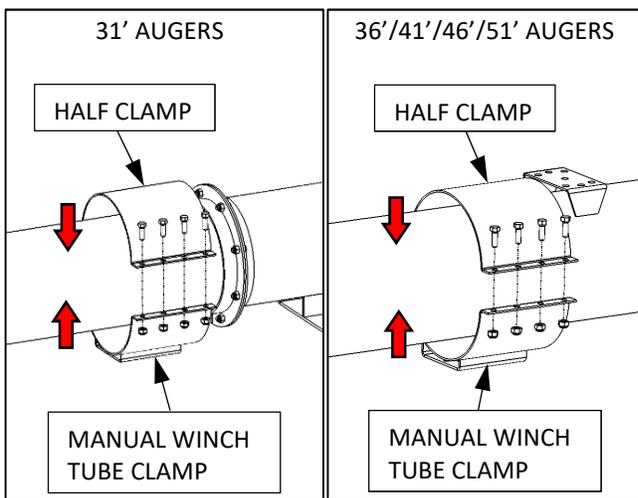
- a. Apply the first clamp 6" (15.2 cm) from the cable loop with u-bolt over the dead end. Live end rests in clamp saddle. Tighten nuts evenly to recommended torque of 15 ft·lb.
- b. Apply second clamp as close to loop as possible with the u-bolt over the dead end. Live end rests in clamp saddle. Apply tension and tighten nuts evenly to recommended torque of 15 ft·lb.



Step 2: Run cable between the track stop and the auger tube.

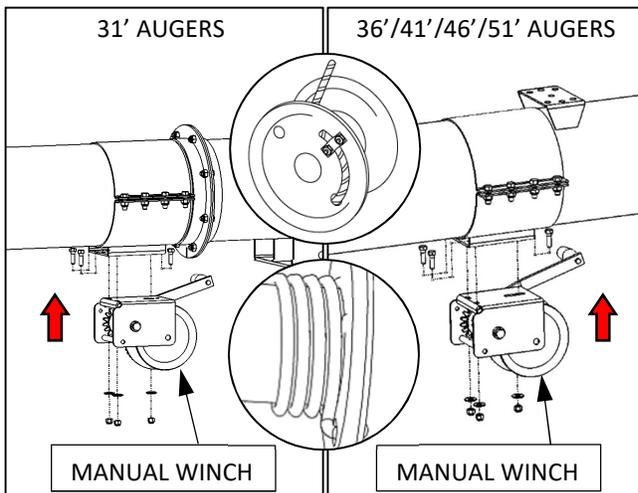
Step 3: Thread the cable over and around the track shoe. Make certain it is properly seated in the cable groove.

INSTALL THE MANUAL WINCH:



Step 1: Attach manual winch tube clamp to the auger tube using a half clamp, eight 7/16" x 1-1/4" bolts and eight 7/16" locknuts.

- 31' Augers: The half clamp should be as close as possible to the angle ring.
- 36'/41'/46'/51' Augers: The half clamp should be as close as possible to the detent bracket.

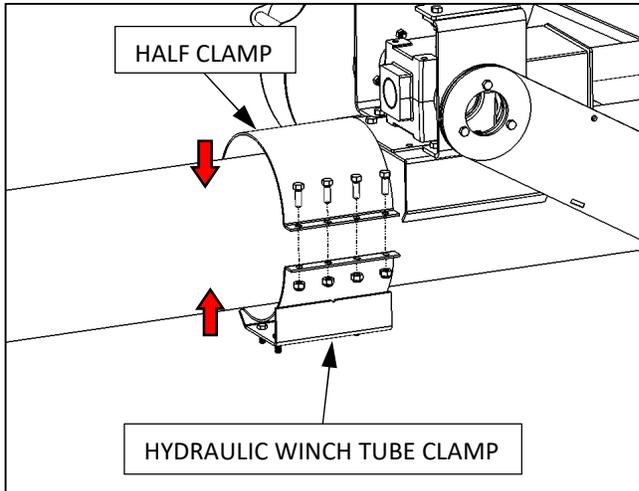


Step 2: Attach manual winch to the manual winch tube clamp using three 3/8" x 1-1/4" bolts, flat washers and locknuts.

Step 3: Pull cable to the winch. Wrap the cable over and around the winch drum. Secure using a cable clamp.

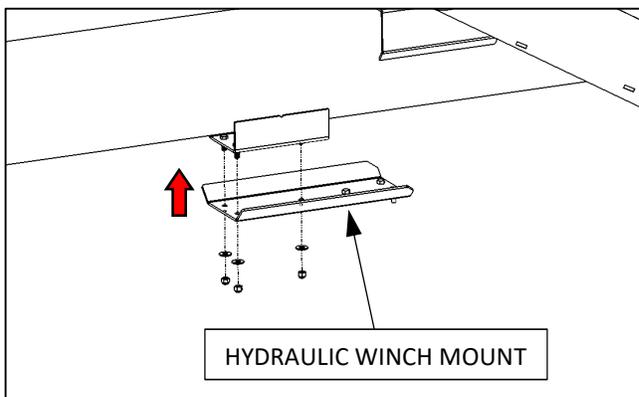
Note: Ensure there is a minimum of three wraps of cable on the winch drum when in transport position.

INSTALL THE HYDRAULIC WINCH:

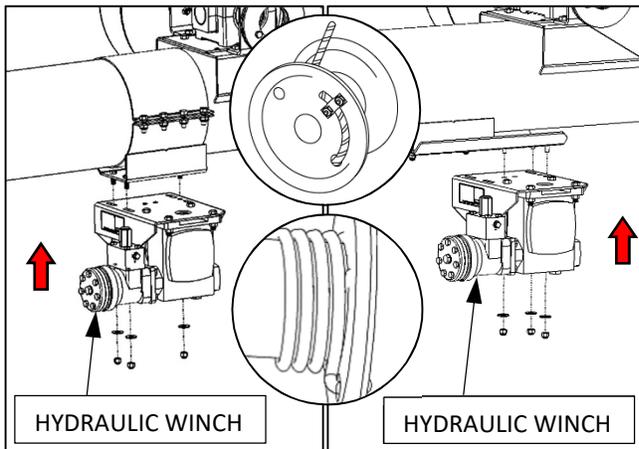


Note: Proceed to step 2 if the auger has a winch mount bracket in this location.

Step 1: Attach hydraulic winch tube clamp to the auger tube using a half clamp, eight 7/16" x 1-1/4" bolts and eight 7/16" locknuts. The half clamp should be as close as possible to the gearbox mount bracket.



Step 2: Attach hydraulic winch mount to the winch mount bracket using three 3/8" flat washers and locknuts.

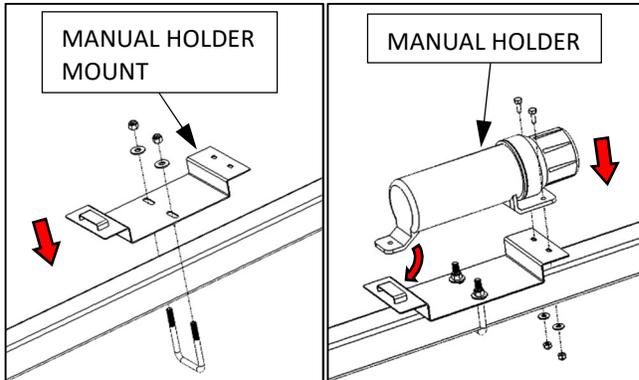


Step 3: Attach hydraulic winch to mount using three 3/8" flat washers and locknuts.

Step 4: Pull cable to the winch. Wrap the cable over and around the winch drum. Secure using a cable clamp.

Note: Ensure there is a minimum of three wraps of cable on the winch drum when in transport position.

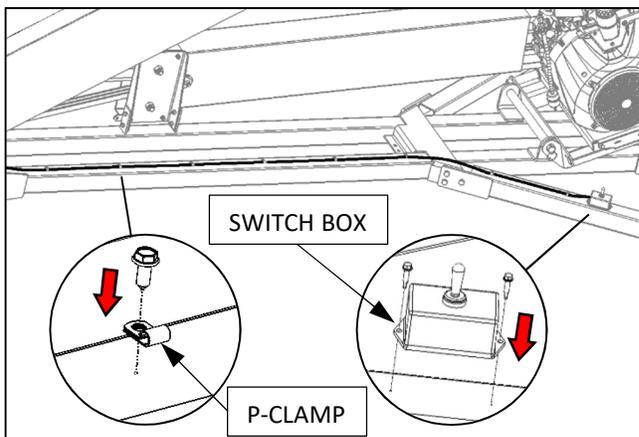
INSTALL THE MANUAL HOLDER:



Step 1: Attach the manual holder mount to the upper frame using one 3/8" u-bolt, two 3/8" flat washers and two 3/8" locknuts.

Step 2: Attach the manual holder to the manual holder mount using two 1/4" x 3/4" bolts, flat washers and locknuts.

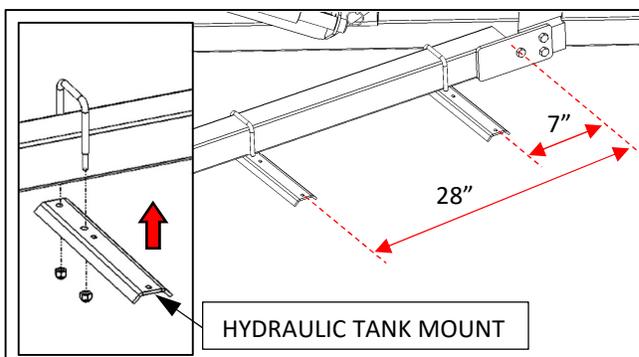
INSTALL SWITCH BOX & WIRE HARNESS (AUGERS WITH WORK LIGHT KIT ONLY):



Step 1: Attach the switch box to the lower support frame using the two existing #8 x 3/4" tek screws.

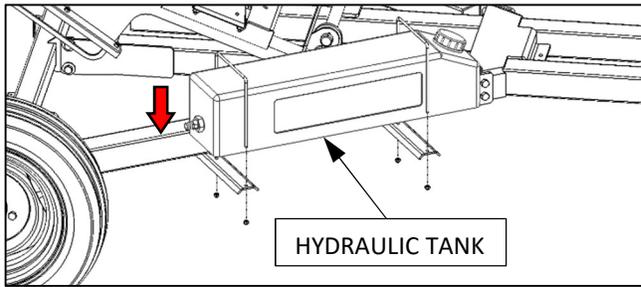
Step 2: Secure wiring harness to the lower frame using the existing p-clamps and #14 x 5/8" self-tapping screws.

INSTALL THE SP & HDSP KIT COMPONENTS:



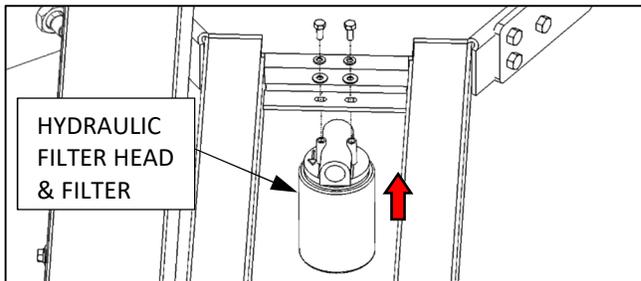
Step 1: Attach two hydraulic tank mounts to the right lower support frame using two 3/8" u-bolts and four 3/8" locknuts.

- 1st Bracket: 7" from end of tube.
- 2nd Bracket: 28" from end of tube.

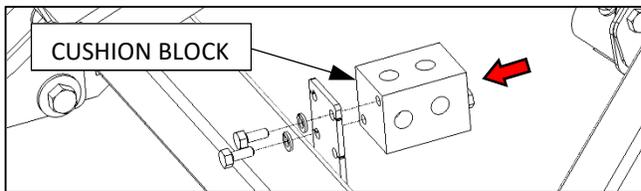


Step 2: Re-install hydraulic tank to tank mounts using the two existing 1/4" u-bolts and four 1/4" locknuts.

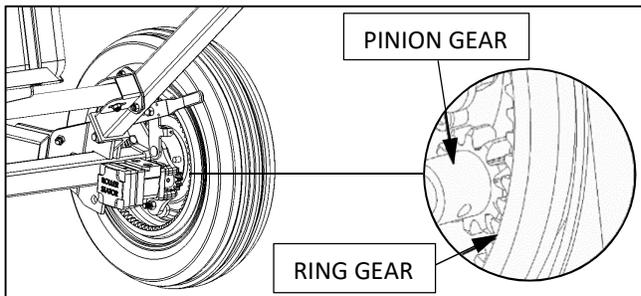
Note: Ensure the cap is located on the raised side.



Step 3: Re-install hydraulic filter head and filter to the lower frame using two 1/4" x 3/4" bolts, lock washers and flat washers.

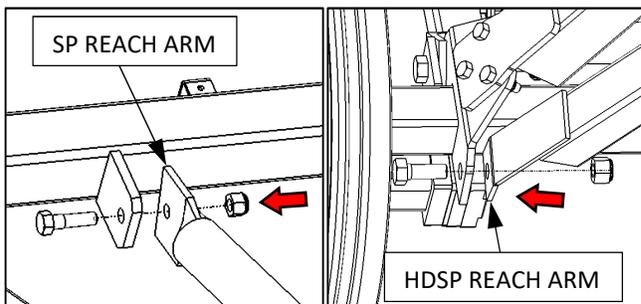


Step 4: Re-install cushion block to axle using the two existing 5/16" x 3/4" bolts and lock washers.



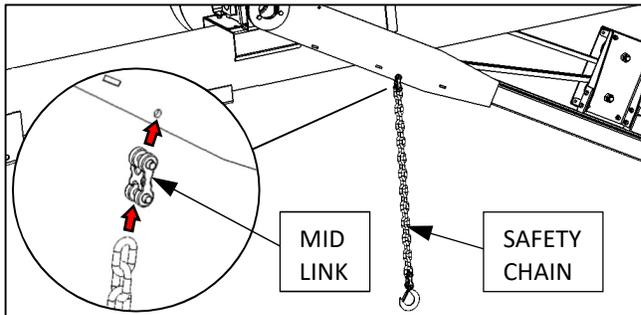
Step 5: Re-install the two over-center drive assemblies onto axle using the eight existing 3/8" x 1-1/4" carriage bolts and locknuts.

Note: Ensure the pinion gears are flush with the ring gears.



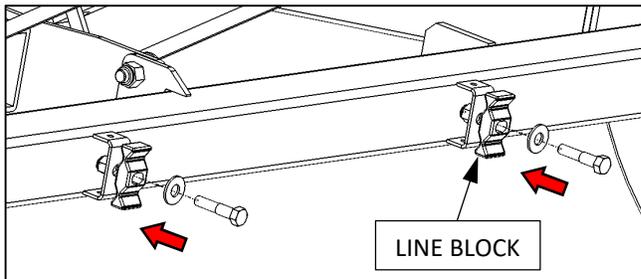
Step 6: Re-install the two SP/HDSP reach arms to axle using the existing hardware.

- SP Kit: two 1/2" x 1-3/4" bolts and locknuts.
- HDSP Kit: two 3/4" x 2" bolts and locknuts.



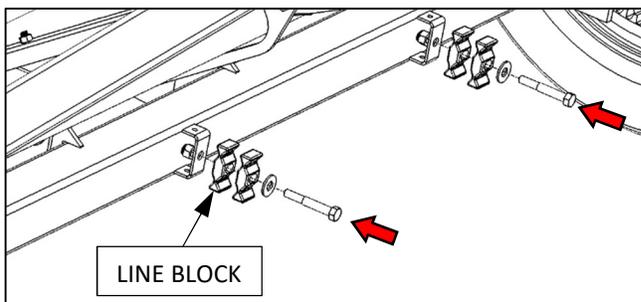
Step 7: Attach the safety chain to the lower frame using one mid link. The length of the safety chain is for the longest span. If necessary, the chain can be shortened.

- a. Remove mid link from chain.
- b. Attach mid link to the appropriate chain link.



Note: The next step is only required for augers with a regular SP kit.

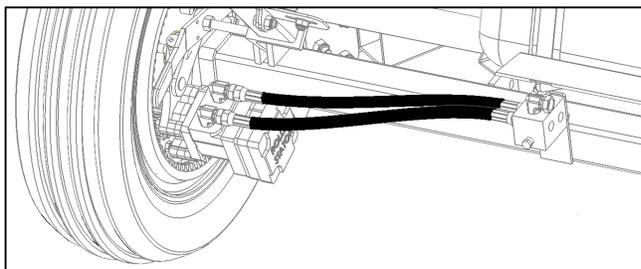
Step 8: Loosely install the two line blocks to the axle using the two existing 3/8" x 1-3/4" bolts, flat washers and locknuts.



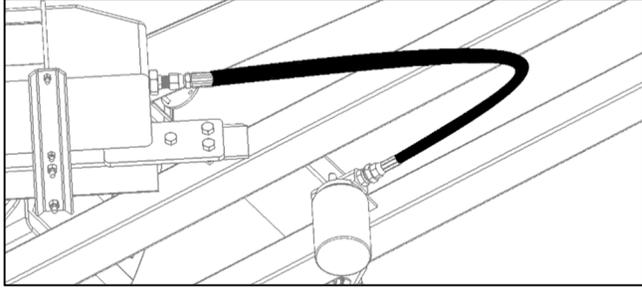
Note: The next step is only required for augers with an HDSP kit.

Step 9: Loosely install four line blocks to the axle using two 3/8" x 2-1/2" bolts, flat washers and locknuts

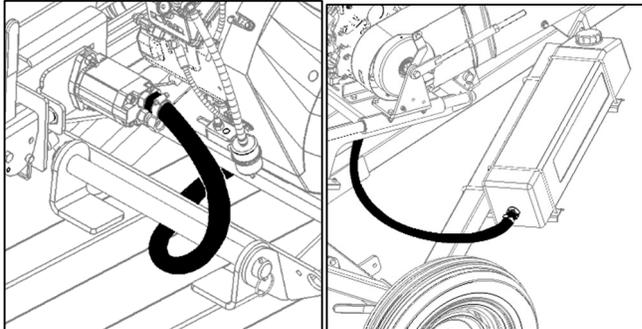
INSTALL THE SP & HDSP KIT HYDRAULIC HOSES:



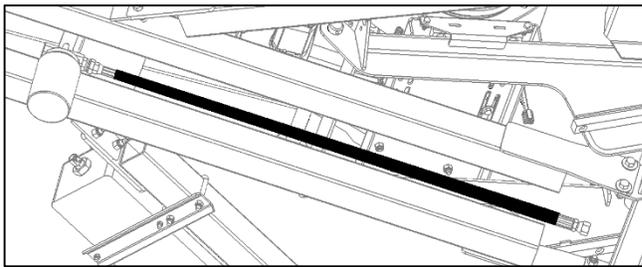
Step 1: Install the two existing 3/8" x 18" hydraulic hoses between the cushion block and the over-center drive assembly.



Step 2: Install the new 1/2" x 22" hydraulic hose between the hydraulic tank and the oil filter.

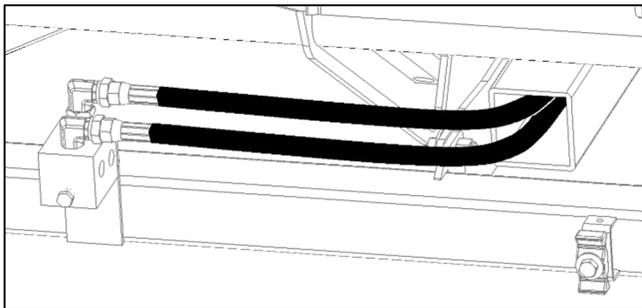


Step 3: Install the new 3/4" x 78" hydraulic hose between the hydraulic pump and the hydraulic tank. Route the hose under the engine slider assembly and along the lower frame.

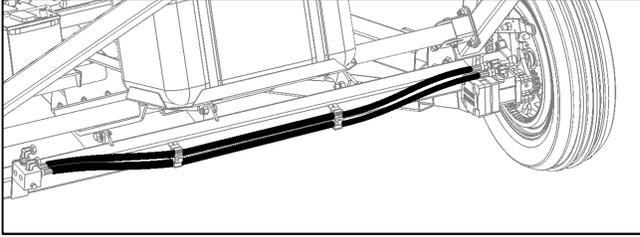


Step 4: Connect the new 1/2" x 60" hydraulic hose extension to the oil filter and route between the lower frame.

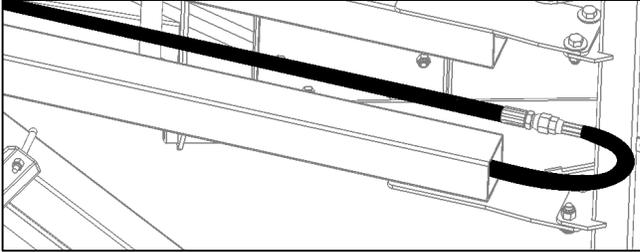
INSTALL THE REGULAR SP KIT HYDRAULIC HOSES:



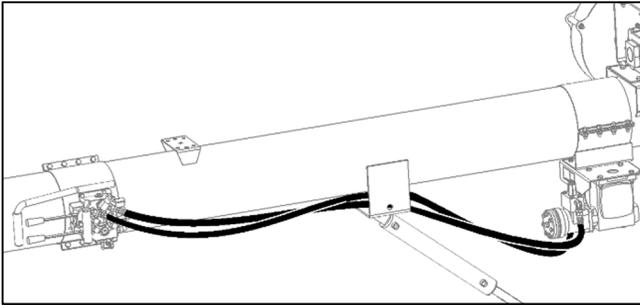
Step 1: Route the two existing cushion block hydraulic hoses through the lower frame and connect to the cushion block.



Step 2: Install the two existing 3/8" x 56" hydraulic hoses between the cushion block and the over-center drive assembly. Tighten the line blocks securing the hydraulic hoses to the axle.

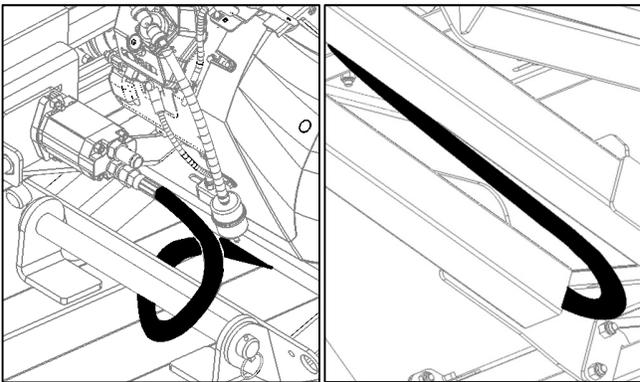


Step 3: Route the existing oil filter hydraulic hose through the lower frame and connect to the hydraulic hose extension.



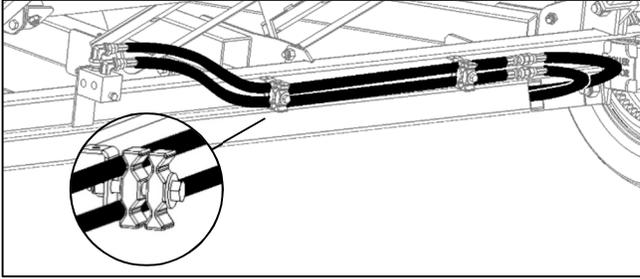
Step 4: Re-connect the two existing hydraulic winch hoses to the hydraulic winch.

Note: *The existing hoses will be too long. Take up the extra slack by wrapping around the tube, or take to the local hydraulic supplier to have them shortened.*



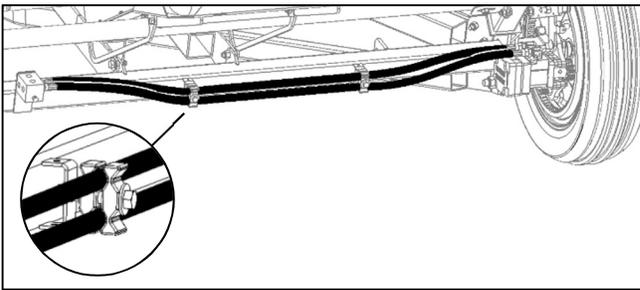
Step 5: Route the existing pump hydraulic hose through the lower frame and connect to the hydraulic pump.

INSTALL THE HDSP KIT HYDRAULIC HOSES:

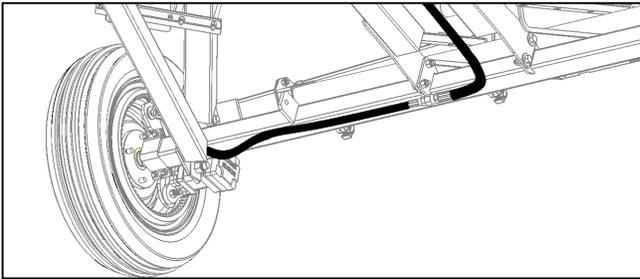


Step 1: Connect the two new 3/8" x 40" hydraulic hose extensions to the cushion block.

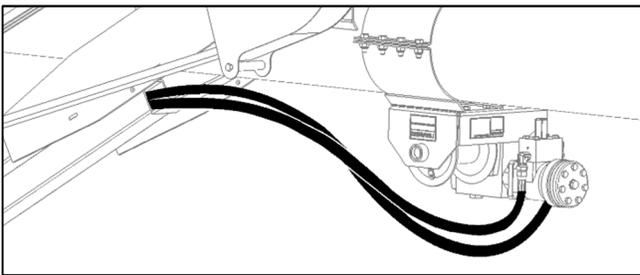
Step 2: Connect the existing cushion block hydraulic hoses to the hydraulic hose extensions.



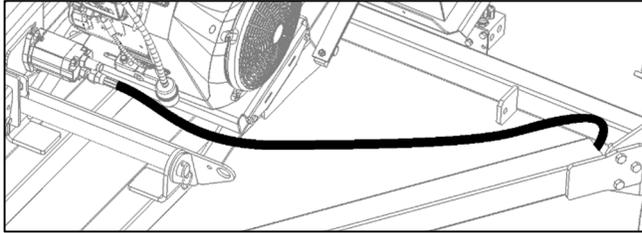
Step 3: Install the two existing 3/8" x 56" hydraulic hoses between the cushion block and the over-center drive assembly. Tighten the line blocks securing the hydraulic hoses to the axle.



Step 4: Connect the existing oil filter hydraulic hose to the hydraulic hose extension.

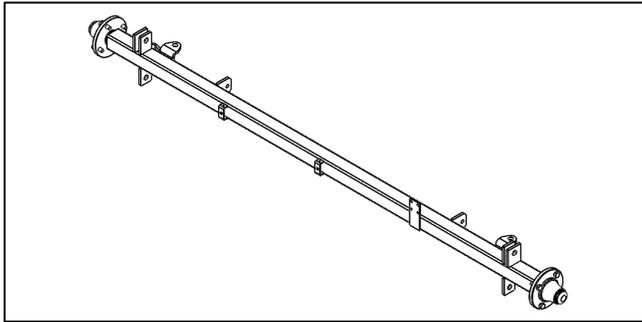


Step 5: Route the two existing hydraulic winch hoses through the lower frame. Re-connect to the hydraulic winch.



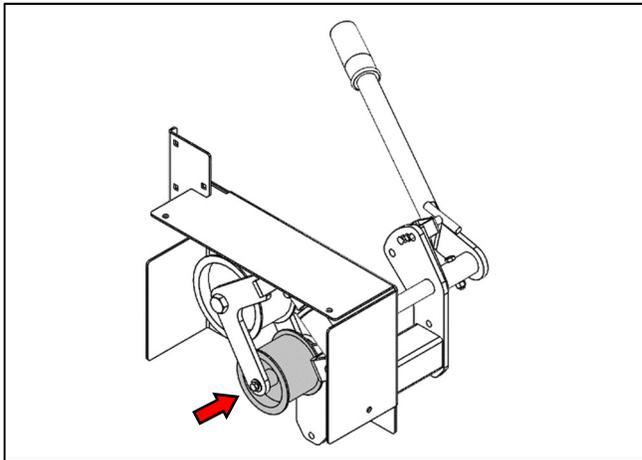
Step 6: Connect the existing pump hydraulic hose to the hydraulic pump.

ITEMS TO RETURN TO WESTFIELD:



| Part No. | Description |
|------------|-------------------------|
| 10-23459 | STX2 AXLE ASSY, 1 PIECE |
| 10-23459WH | XTA AXLE ASSY, 1 PIECE |

Important: The following item is only required from augers with the spring tension assembly.



| Part No. | Description |
|----------|------------------------|
| 10-23834 | 4" x 3/4" Idler Pulley |