



1557BE1 Rotary Cultivator mounted on Commercial 15A Cummins Tractor.
When Used: 1.5 HP Commercial, Commercial 15A and 1.5 Commercial Tractors.
Additional Equipment Required: 1557BE1 Rotary Flow or 1557BE1 Flow-Cultivator Drive.
Additional Equipment Recommended: None.

ASSEMBLY INSTRUCTIONS

ALL ITEM NUMBERS REFER TO ILLUSTRATED PARTS LIST

1. Remove spacers, washers and lockwash (Items 27, 28, 29 and 30) from the shafts (Items 4 and 34). Place Drive (2) top nuts (Item 38) on each end shaft in the position as shown on the Illustrated Parts List. Place one long spacer (Item 27) on each end shaft followed by another set of three set in the same position as the first set. Replace the short spacer, washer and lockwash. Torque to 100-150 Ft. Lbs.
2. Install the end plates (Items 27 and 28) on the dirt shield (Item 35) in the position shown on the Illustrated Parts List, using the three (3) 1/4 x 1.5 bolts, six (6) Lockwashers, take on each side of the plate and three (3) nuts (Items 43, 44, and 45) on each side. Tighten securely.

ATTACHING TO 1557BE1 ROTARY FLOW

The following steps are to be used if the rotary cultivator is to be used on a rotary flow.

3. Remove the dirt shield (Figure 2, Item 1) from the flow drive by removing the bolts holding the adjusting straps to the drive. Replace the bolts in the drive and tighten securely.
4. Remove the rotor shaft and spider assembly (Figure 2, Item 4) from the drive.
5. Remove the depth wheel assembly (Figure 2, Item 5) by removing the four bolts securing the drive housing extension to the drive housing.
NOTE: Replace the bolts in the bolt holes using One (1) 3/8 Lockwashers on each bolt. These bolts MUST be replaced to prevent oil loss from the drive unit.



Figure 2

ALTERNATE PROCEDURE: The depth wheel assembly need not be removed to install the rotary cultivator.

This allows the use of the depth wheels to regulate the depth of the rotary cultivator. If desired, the depth wheels can be completely removed by unscrewing the wheel bracket cover caps (Figure 2, Item 1).

6. The top side of the drive is identified by the oil filler plug. Turn the drive housing upside down and remove the two bolts closest to the center of the drive. Install the four studs (Item 40) in the drive housing with the coarse threaded end going into the housing. (See Figure 3).
7. Install the dirt shield assembly on the housing as shown in Figure 4.
8. Remove the bolt, lockwasher, hex washer and nut (Items 31, 32, 33 and 34) from the drive shaft on the cultivator unit. Install the cultivator assembly on the shaft with the oil check plug facing the front of the unit relative to operator position. (See Figure 1).

Gravely Service Manual 911

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