

Farm King

OPERATOR AND PARTS MANUAL

Rollermill

Model 180



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Manufacturer’s statement: for technical reasons Buhler Industries Inc. reserves the right to modify machinery design and specifications provided herein without any preliminary notice. Information provided herein is of descriptive nature. Performance quality may depend on soil fertility, applied agricultural techniques, weather conditions and other factors.

Introduction

Farm King Rollermills are built to last using durable, heavy gauge materials. They deliver top-quality rolled grains, year after year, with minimum maintenance and low daily operating costs. The 180 handles 200-300 bushels/hour and uses 40-60 PTO. A power magnet trap keeps nails and other metal objects from entering rollers. Model 180 features an optional 12' hydraulic auger system, which swivels a full 180 degrees. Adjustable roll scrapers, to keep rollers clean, are standard on Model 180. Chrome plated rollers for longer life. Stationary stand for easy setup. Transport with 15" wheels available. (Requires stand) PTO driven standard for Model 180.

Keep this manual handy for frequent reference. All new operators or owners must review the manual before using the equipment and at least annually thereafter. Contact your Farm King Dealer if you need assistance, information, or additional copies of the manual. Visit our website at www.buhlerindustries.com for a complete list of dealers in your area.

The directions left, right, front and rear, as mentioned throughout this manual, are as seen facing in the direction of travel of the implement.

Safety

Safety Instructions

Remember, YOU are the key to safety. Good safety practices not only protect you, but also the people around you. Make these practices a working part of your safety program. Be certain that everyone operating this equipment is familiar with the recommended operating and maintenance procedures and follows all the safety precautions. Most accidents can be prevented. Do not risk injury or death by ignoring good safety practices.

The alert symbol is used throughout this manual. It indicates attention is required and identifies hazards. Follow the recommended precautions.



The safety alert symbol means...
ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!



CAUTION

The caution symbol 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.



WARNING

The Warning Symbol 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.



DANGER

The Danger Symbol 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 that, for functional purposes, cannot be guarded.

General Safety Instructions

- Have a first-aid kit available for use and know how to use it.
- Have a fire extinguisher available, stored in a highly visible location, and know how to use it.
- Wear appropriate protective gear. This list may include but is not limited to:
 - hard hat
 - protective shoes with slip resistant soles
 - protective glasses or goggles
 - heavy gloves
 - wet weather gear
 - hearing protection
 - respirator or filter mask
- Read and understand the Operator's Manual and all safety signs before operating, servicing, adjusting, repairing, or unplugging the equipment.
- Do not attempt any unauthorized modifications to your Farm King product as this could affect function or safety, and could affect the life of the equipment.
- Never start or operate the mower except from the operator's station on the power unit.
- Inspect and clean the working area before operating.
- Keep hands, feet, clothing, and hair away from moving parts.
- Ensure bystanders are clear of the area before operating.

Start-up Safety

- Do not let inexperienced operators or children run this equipment.
- Ensure all shields are in place and in good condition before operating.
- Stay clear of PTO shaft and machine when engaging PTO.

Operation Safety

- Do not permit riders.
- Do not wear loose fitting clothing during operation.
- Never operate over 540 rpm PTO speed.

Transport Safety

- Check with local authorities regarding transport on public roads. Obey all applicable laws and regulations.
- Do not tow equipment that does not have brakes at speeds over 32 km/hr (20 miles/hr).
- Do not tow equipment that does not have brakes that, when fully loaded, has a mass (weight) over 1.5T (3300 lbs.) and more than 1.5 times the mass (weight) of the towing unit.
- Make sure the SMV (Slow Moving Vehicle) emblem and all the lights and reflectors that are required by the local highway and transport authorities are in place, are clean, and can be seen clearly by all overtaking and oncoming traffic.
- Never had the equipment in operation during transport.
- The equipment should never be towed without the safety chain securely attached to the unit and the towing vehicle.
- Always travel at a safe speed.
- Inflate transport tires to recommended pressure.

Service and Maintenance Safety

- Stop engine, set brake, remove ignition key, and wait for all moving parts to stop before servicing, adjusting, repairing, or unplugging.
- Support the equipment with blocks or safety stands before working beneath it.
- Follow good shop practices including:
 - keep service area clean and dry
 - be sure electrical outlets and tools are properly grounded
 - use adequate light for the job.
- Use only tools, jacks, and hoists of sufficient capacity for the job.
- Replace and secure all shields removed during servicing before operating.
- Use heavy leather gloves to handle sharp objects.
- Check hydraulics regularly for leaks. Use cardboard to look for leaks, and use hand and eye protection.
- Relieve pressure on hydraulic system before repairing or adjusting.
- Failure to follow proper procedures when mounting a tire on a wheel or rim can produce an explosion, which may result in serious injury or death.

Storage

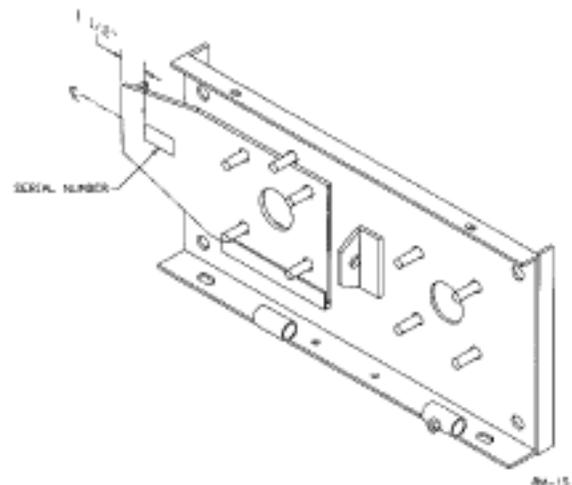
- Store the unit in an area away from human activity.
- Do not permit children to play on or around the stored machine.
- Support the frame on stands and blocks to provide a secure base.

Safety Signs

- The following illustration shows the approximate location and detail of safety signs.
- Keep all safety signs clean and legible and replace any that are damaged or missing.
- When original parts are replaced, any safety signs affixed to those parts should be replaced as well. Replacement safety signs are available from your local dealer.

Installation

- To install safety signs, ensure the installation area is clean and dry. Decide on the exact position before you remove the backing paper. Remove the smallest portion of the split backing paper and align over the specified area. Carefully press in place.
- Slowly peel back the remaining paper and smooth the remaining portion in place. Small air pockets can be pierced with a pin and smoothed out.



RM-15

Assembly Instructions

1. The basic Rollermill is completely assembled except for the hopper (#63). Mount the hopper on the top of the rollermill with the chain brackets to the rear of the mill as shown in drawing. Use the bolts supplied with the hopper.
2. PTO drive is standard on the 180 rollermill with the engine on the tractor shut off, attach the PTO shaft. The tractor end has a standard 6-spline end with a spring loaded locking pin. The Rollermill end has a clamp-style yoke with a 3/8" keyway. Slide the yoke onto the roller shaft with the 3/8" key supplied, lock the yoke in place with the 1/2" x 3" bolt and lock nut fitted through the groove in the roller shaft. After tightening the bolt, insert and tighten the 3/8" socket set screw supplied.

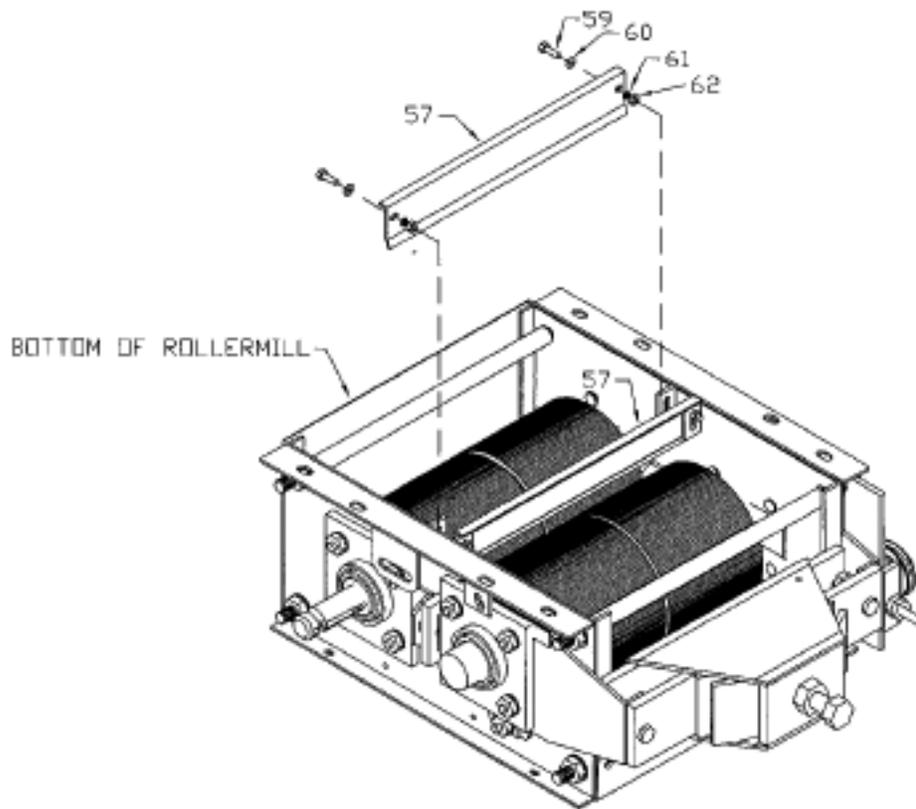


DANGER

Always check to see that both ends of the PTO shaft are securely attached every time the rollermill is used. This should always be done with the tractor engine off.

3. An optional stand (#71) is available for the #180 rollermill. The stand consists of two pieces which bolt underneath the rollermill using 1/2" x 1 1/4" hex bolts, lock washers and hex nuts.
4. A magnet for the intake hopper is available as an option for all rollermills. This will keep small metal objects out of the rolled feed and also prevent damage to the roller grooves.
5. If you intend to mount the rollermill on a transport, the stands described in step number three must also be purchased. First mount wheels and tires on the transport hubs. The bottom edge of the stand bolts to the top of the transport using 1/2" x 1-1/4" hex bolts, lock washers and hex nuts. Bolt the PTO holder (#77) to the front of the transport and the unloading auger support bracket (#78) at the rear of the transport. This bracket is required only if the optional 7" unloading auger is also used.
6. The optional unloading auger includes a discharge hopper (#83) and a cross auger (#102). The discharge hopper fits between the top edge of the stands and the bottom of the rollermill and fastens with the same bolts as the stands. Use 3/8" x 1-1/4" hex bolts, lock washers and hex nuts where the hopper bolts to the rollermill at the back edge.
7. Slide the hydraulic unloading auger (#103) onto the sleeve extending from the discharge hopper. The unloading auger is held in place by running the chain provided (#84) through the welded bracket on the auger and hooking the ends of the chain to the chain brackets on the hopper. Two hooks (#107) hold on the discharge auger by hooking onto a welded ring on the hopper sleeve. Bolt on using 5/16" x 1" hex bolts, lock washers and hex nuts. Bolt the spout (#105) to the top end of the unloading auger using 5/16" hex nuts.
8. Mount a 4 1/2" pulley (#66) with the 1" bore on the cross auger stub shaft at the front of the rollermill using a 1/4" x 1 3/4" key. The 6" pulley with the 1 1/2" bore (#16) is mounted on the same roller shaft end as the PTO shaft. There is both a 1/4" and a 3/8" keyway at the end of the shaft. The 1/4" is for the 6" pulley and the 3/8" is for the PTO shaft. The 3/8" key for the PTO shaft is packed in the plastic bag with the manual. Mount a 5L-400 V-belt (#70) and tighten using the idler pulley (#28) provided. The idler pulley bolts to the welded bracket on the front rollermill side. Bolt the guard (#101) across the pulley assembly using 7/16" x 1 1/4" bolt on the welded bracket on the side and one of the roller bearing bolts. Connect the PTO shaft after the guard is bolted on. The PTO shaft sits in the cradle bolted to the transport when the Rollermill is being moved.

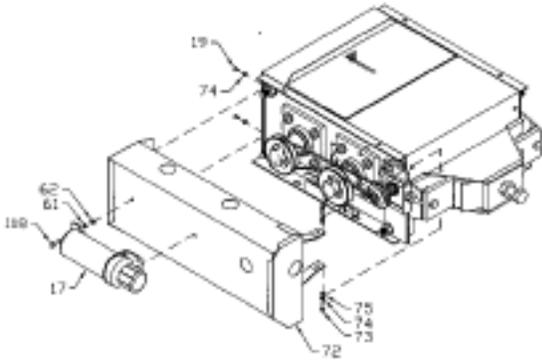
9. Mount the two 90° street elbows (#112) in the hydraulic motor. The hydraulic hoses (#111) run under the hopper to the front of the transport. Make sure the unloading auger is running before you start the rollermill to prevent plugging. The unloading auger has a clean-out lid (#106) near the bottom should the corner ever become plugged.



RM-10

- Turn rollermill upside down as shown.
- Four 1/4" x 1-1/4" x 2" flat iron brackets with slotted holes are positioned as shown in drawing and welded to the sides. Measure 10-1/2" from the end of the rollermill to the inside of the first bracket and space 1-3/4" apart. The brackets are flush with the bottom of the roller mill. **NOTE:** Weld on the inside edge only.
- Bolt the 18-1/2" long scrapers to the outside of the welded brackets using 5/16" x 1" cap screws, flat washers, lock washers and hex nuts. The bottom lip on the scraper is turned to the center of the rollermill.
- Adjust the scraper height so the scrapers are just short of touching the rolls.

Rollermill Guards



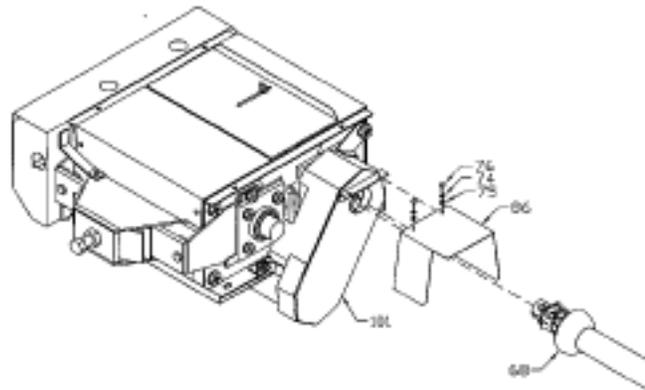
Belt Drive Guard

- Used on all Rollermills

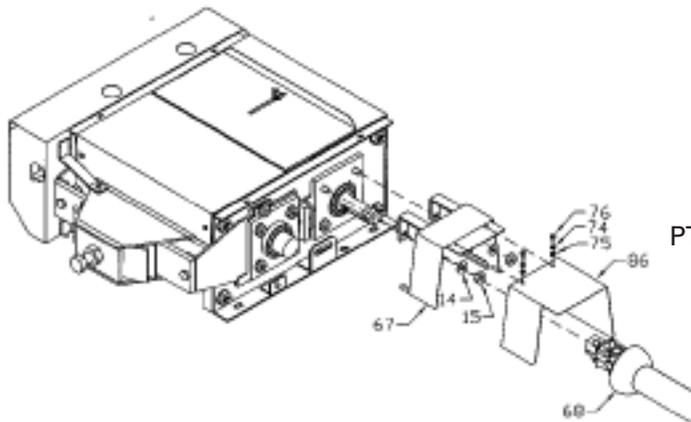
RM-11

PTO Drive Guard

- Used on Rollermills with discharged hopper.



RM-12



PTO Drive Guard

- Used on Rollermills without discharged hopper.

RM-13

Drive Pulley Guard

All rollermills are supplied with a drive pulley guard (#72). One end of the guard is bolted to the two holes punched in the spring holder using 1/4" x 1-3/4" hex bolts, lock washers and hex nuts. The other end is bolted on using the same bolts that hold on the rear cover plate.

PTO Drive Guard

All 180 rollermills with a discharge hopper are supplied with a PTO guard (#86). This guard bolts to the angle iron on the belt guard using 1/4" x 3/4" hex bolts, lock washers and hex nuts. This belt guard is supplied only with rollermills using a discharge hopper and auger. If the rollermill is being used without a discharge hopper, an adaptor (#67) must be used as shown in drawing. This adaptor bolts on using the top two bolts on the bearing flange. The guard (#86) then bolts onto the adaptor.



DANGER

Never use the rollermill without all the appropriate guards in place. Always turn off the machine before removing any guard or when servicing.

Operation Instructions

Before using the rollermill, check the clearance on the rollers. Place a piece of newspaper between the rollers and adjust the set screws on either side of the rollermill till you can feel a slight tension on the paper. The rollers, however, should not touch each other. It is very important that the rollers are evenly adjusted. To ensure good rolling results, check roller adjustment regularly and reset if necessary. Close the gate control (#20) before starting the rollermill. The intake hopper should be partially full before opening the gate control. Keep the hopper partially filled at all times while the rollermill is running. This will allow the grain to be rolled evenly across the full width of the roller and will result in more uniformly rolled feed. It also helps prevent the rollers from wearing unevenly. Before stopping the rollermill, close the gate control while there is still grain in the hopper. When the grain remaining in the machine has all been crushed, shut off the machine immediately. The gate control is left closed until the machine is started again. The roller bearings should be greased approximately every 80 hours or once a season if used less.



ALERT

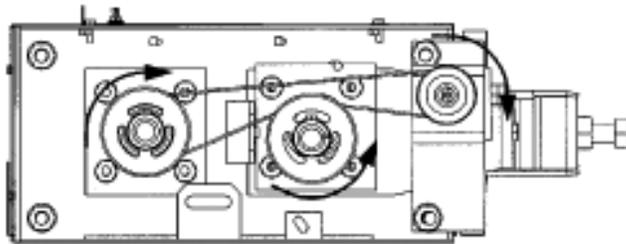
When replacing bearings or tightening a loose bearing collar, always tighten collar in the direction of shaft rotation using a center punch or a similar tool.

To regulate the type of rolled feed one wants, adjust the adjusting screw (#47). Increased pressure will result in finer and flatter feeds. Decreasing the tension will give you a coarser feed.

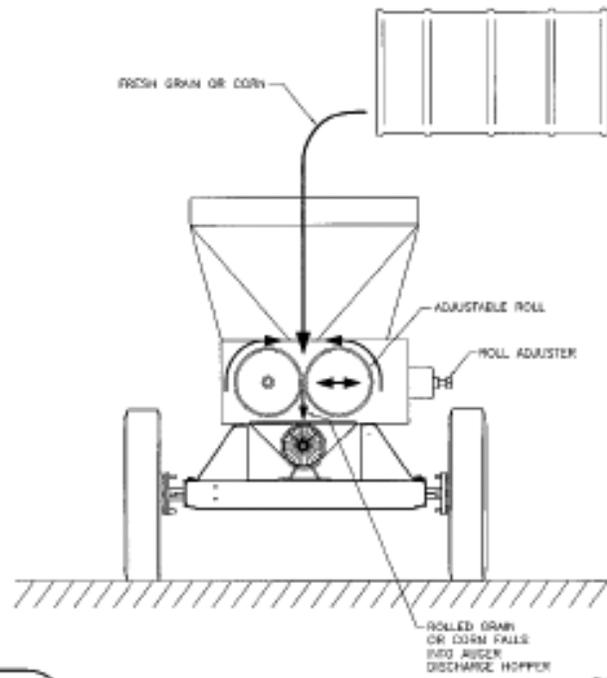
The unloading auger has a clean-out cover at the bottom of the discharge auger should it ever become plugged. The top section of the unloading auger swivels to allow unloading from any direction.

Recommended tire pressure is 60 psi.

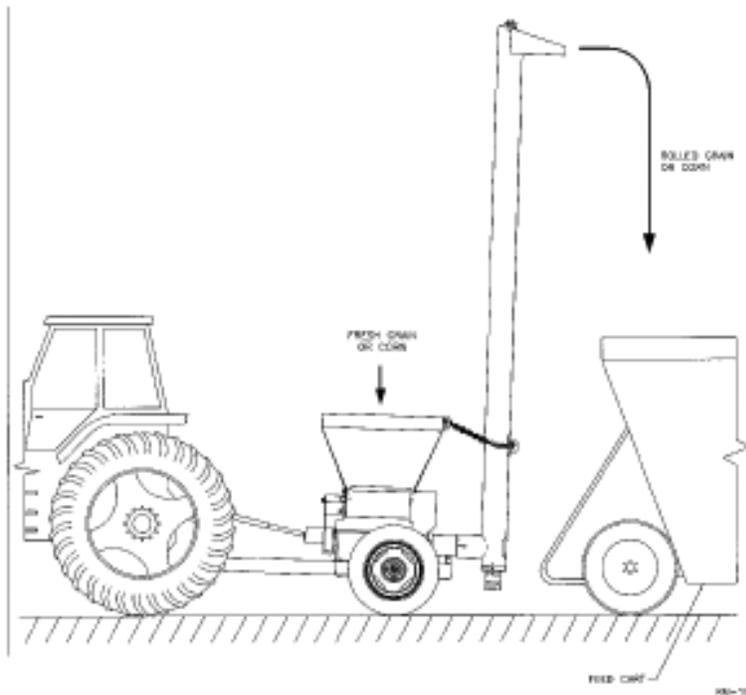
Theory of Operation



RN-17



RN-18

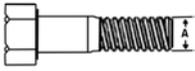


RN-19

Bolt Torque

Checking Bolt Torque

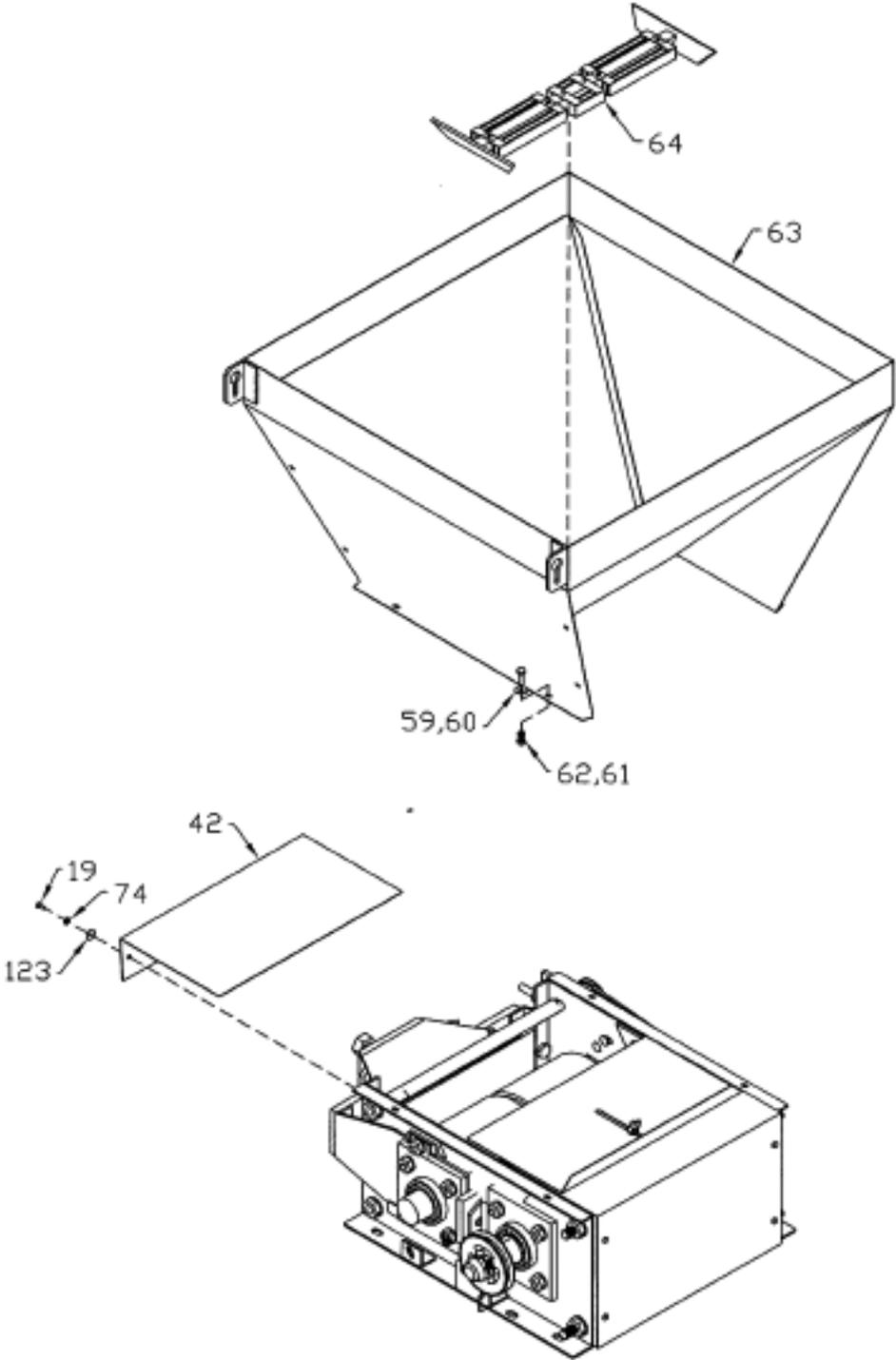
The tables shown below give correct torque values for various bolts and hex bolts. Tighten all bolts to the torques specified in chart unless otherwise noted. Check tightness of bolts periodically, using bolt torque chart as a guide. Replace hardware with the same strength bolt.

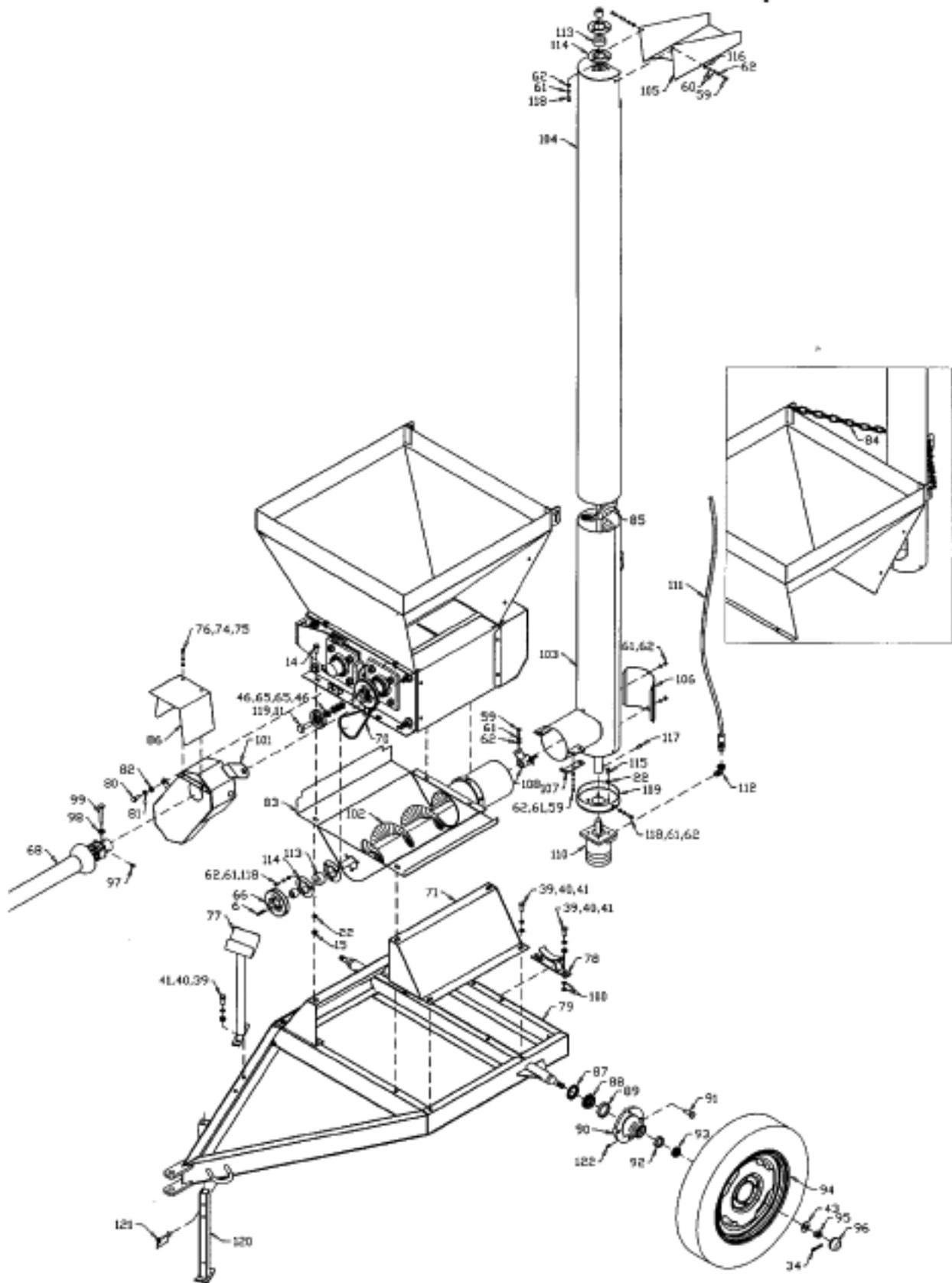
Bolt Torque*						
						
Bolt Diameter	Grade 2 Bolts		Grade 5 Bolts		Grade 8 Bolts	
(inches)	SAE 2		SAE 5		SAE 8	
"A"	(lb-ft)	(N.m)	(lb-ft)	(N.m)	(lb-ft)	(N.m)
0.25 (1/4)	6	8	9	12	12	17
0.313 (5/16)	10	13	19	25	27	36
0.375 (3/8)	20	27	33	45	45	63
0.438 (7/16)	30	42	53	72	75	100
0.5 (1/2)	45	61	80	110	115	155
0.563 (9/16)	70	95	115	155	165	220
0.625 (5/8)	95	128	160	215	220	305
.75 (3/4)	165	225	290	390	400	540
0.875 (7/8)	170	230	420	570	650	880
1	225	345	630	850	970	1320

Torque figures indicated above are valid for non-greased or non-oiled threads and heads unless otherwise specified. Therefore, do not grease or oil bolts or hex bolts unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

*Torque value for bolts and hex bolts are identified by their head markings.

Rollermill Assembly Drawings





RM-C9

When Ordering Parts

Always give your dealer the Model, Color and Serial Number of your machine to assist him in ordering and obtaining the correct parts. Use the exploded view and tabular listing of the area of interest to exactly identify the required part.

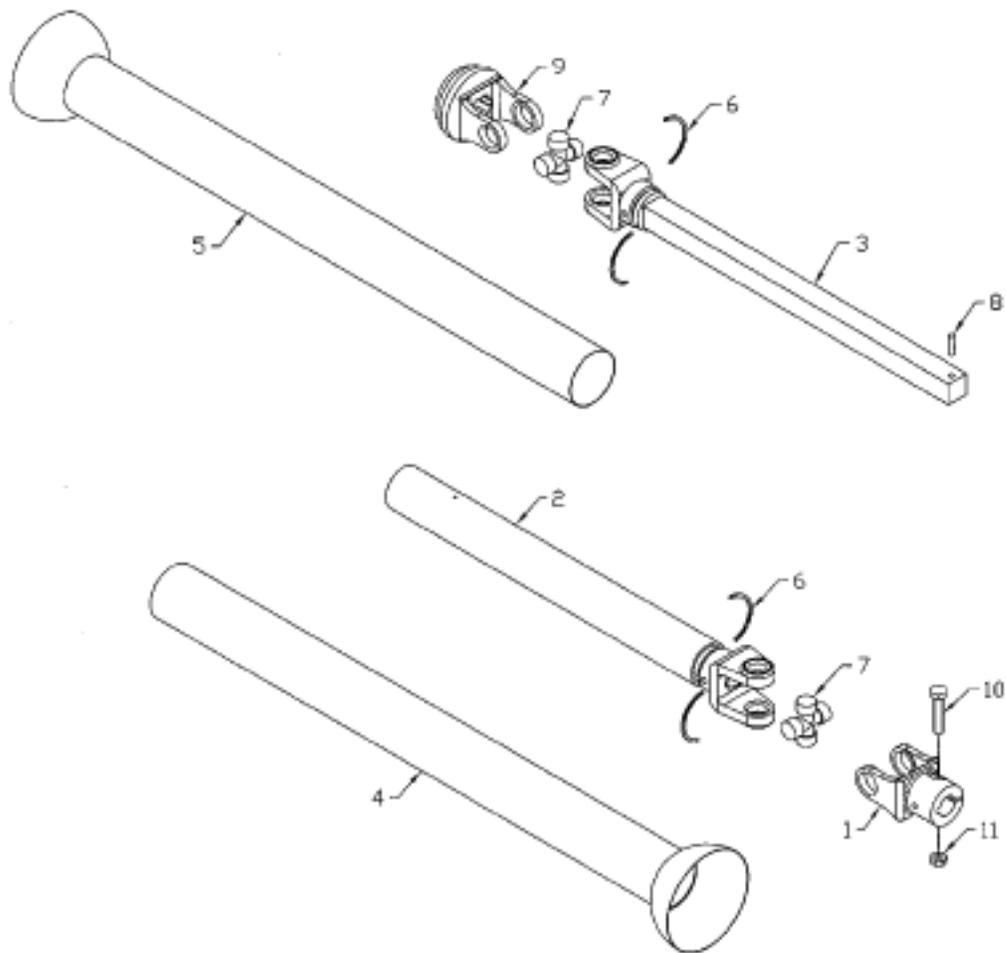
Item	Part Number	Description
1	968922	Standard 18" x 10" Rear Roll (8 Groove)
	968923	Chrome 18" x 10" Rear Roll (8 Groove)
	901546	Chrome 18" x 10" Rear Roll (6 Groove)
2	968896	Standard 18" x 10" Front Roll (8 Groove)
	968920	Chrome 18" x 10" Front Roll (8 Groove)
	901545	Chrome 18" x 10" Front Roll (6 Groove)
	Y8107	Standard Rolls For #180 (8 Groove)
	Y8110	Chrome Rolls For #180 (8 Groove)
	Y8119	Chrome Rolls For #180 (6 Groove)
3	968807	3/8" x 3/8" x 2" Key
4	968895	Left Side Plate
5	968908	Right Side Plate
6	901550	1/4" x 1/4" x 1-3/4" Key
7	968809	Frame Bolt (2 Used) 3/4" x 21"
8	81701	3/4" Lock Washer (pl)
9	81700	3/4" Hex Nut (pl)
10	968808	Frame Bolt (4 Used) 1.05" x 18-5/8"
11	981664	5/8" x 2-1/4" Hex Bolt (Idler)
12	84126	5/8" Jam Nut (pl)
13	968803	Slide Bracket (2 Used)
14	86171	3/8" x 1-1/4" Hex Bolt (pl)
15	81592	3/8" Hex Nut (pl)
16	968816	6" Sheave, B-Groove, 1-1/2" Bore
17	909277	Manual Holder
18	968810	Rear Cover Plate
19	81523	1/4" x 1/2" Hex Bolt (pl)
20	968815	Gate Control
21	84000	3/8" Flat Washer (pl)
22	81593	3/8" Lock Washer (pl)
23	84217	3/8" Wing Nut (pl)
24	968818	Drive Belt - BB51
25	110339	Grease Zerk Bolt
26	968802	5/8" x 2" Square Head Set Screw
27	901504	2-1/4" O.D. Flat Washer
28	968822	4" Sheave, Belt Tightener
29	968827	Roller Bearing

Item	Part Number	Description
30	84522	1" SAE Flat Washer (pl)
31	901500	Tightener Weldment
32	901503	Bracket Weldment
33	901495	Spacer 1-1/4" O.D. x 1-1/8" Long
34	9812486	1/8" x 1-1/2" Cotter Pin
35	968830	Frame Bolt (1 Used) 3/4" x 22-1/2"
36	968911	Adjustable Bearing Holder - Right
37	968894	Adjustable Bearing Holder - Light
38	968910	2" Bearing Flange & Insert
	968909	2" Bearing Only
39	81620	1/2" x 1-1/4" Hex Bolt (pl)
40	81637	1/2" Lock Washer (pl)
41	81636	1/2" Lock Nut (pl)
42	968831	Front Cover
43	84050	3/4" SAE Flat Washer (pl)
44	968836	Spring Support
45	81677	5/8" Lock Washer (pl)
46	81676	5/8" Hex Nut (pl)
47	968832	Adjusting Screw
48	968835	Spring Plate
49	968834	.36" x 4" x 15" Spring
50	968833	.36" x 4" x 14" Spring
51	812364	1/2" Lock Nut (pl)
52	967166	1/2" x 1-1/2" Flat Head Socket Bolt
53	985639	3/8" x 1/2" Socket Set Screw (br)
54	968812	Belting Seal
55	9812399	1/4" x 3/4" Flat Head Stove Bolts
56		1/4" Square Nuts (Included w/ Bolts)
57	968893	Roll Scraper - 18-1/2"
59	812026	5/16" x 1" Hex Bolt (pl)
60	81570	3/8" BS Flat Washer (pl)
61	81569	5/16" Lock Washer (pl)
62	81568	5/16" Hex Nut (pl)
63	968861	Hopper For #180 Rollermill
64	F7610	Magnet For #180 Rollermill
65	81678	11/16" B.S. Flat Washer
66	968912	4-1/2" O.D. Pulley, 1" Bore
67	968821	PTO Guard Adaptor w/o Discharge Hopper
68	F0841	PTO Shaft Complete
70	968913	Belt 5L400
71	901664	Stand Weldment

Item	Part Number	Description
72	968819	19-1/2" x 27-3/4" Guard
73	81527	1/4" x 1" Hex Bolt (pl)
74	81545	1/4" Lock Washer (pl)
75	81544	1/4" Hex Nut (pl)
76	81525	1/4" x 3/4" Hex Bolt (pl)
77	968880	PTO Holder
78	968881	Unloading Auger Support
79	905062	Transport Frame
80	81598	7/16" x 1-1/4" Hex Bolt (pl)
81	81615	7/16" Lock Washer (pl)
82	81614	7/16" Hex Nut (pl)
83	968635	Discharge Hopper (Hydraulic)
84	968860	1/4" x 8' Chain
85	968640	Discharge Auger Flighting 7" x 12'
86	968820	PTO Guard 7" x 21"
87	961891	Seal CTD (SE11)
88	967712	Inner Bearing Cone (LM67048)
89	967711	Inner Bearing Cup (LM67010)
90	105173	Hub complete with Cups (4 Bolt) - H411
	9105173	
91	968404	1/2" Wheel Bolt
92	968405	Outer Bearing Cup (LM11910)
93	968406	Outer Bearing Cone (LM11949)
94	F7110	4-1/2" x 15" x 4 Bolt Wheel
95	81834	3/4" Slotted Hex Nut (br)
96	968409	Dust Cap (DC12)
97	812490	3/8" x 3/8" Socket Set Screw (pl)
98	812364	1/2" Lock Nut (pl)
99	81627	1/2" x 3" Hex Bolt (pl)
100	81638	1/2" B.S. Flat Washer (pl) (As Required)
101	968882	Belt Cover w/ Discharge Hopper
102	968636	Cross Auger (Hydraulic)
103	968637	7" x 12' Hydraulic Unloading Auger Tube
104	968638	Top Swivel Tube (Hydraulic)
105	968639	Discharge Spout (Hydraulic)
106	968641	Clean Out Lid (7-3/4" Square)
107	968641	Hook Clamp
108	968641	Bushing Holder
109	968644	7" End Cap
110	971517	Hydraulic Motor (101-1002)
111	967463	1/2" x 120" Hydraulic Hose (Both Ends 1/2" NPT)

Item	Part Number	Description
112	964650	1/2" Street Elbow
113	961627	1" Bearing w/ Collar
114	973511	1" Bearing Flange
115	84072	3/8" x 3/4" Hex Bolt (pl)
116	812362	5/16" Lock Nut (STL) (pl)
117	985639	3/8" x 1-1/2" Socket Set Screw (br)
118	81549	5/16" x 3/4" Hex Bolt (pl)
119	968892	3" Sheave, Belt Tightener
120	905060	Stand Weldment
121	912301660	Wire Lock Pin
122	967900	1/4" Grease Fitting
123	81546	1/4" Flat Washer (pl)

PTO Shaft Drawing



Item	Part Number	Description
	F0841	Shaft Complete
1	936266	Clamp Yoke
2	936051	Yoke & Tube Assembly
3	936052	Yoke & Shaft Assembly
4	936214	Inner Shield
5	936215	Outer Shield
6	936111	Shield Bearing Kit
7	936025	Repair Kit
8		Spring Pin
9	909674	6 Spline End Yoke
	936026	21 Spline End Yoke
10	967179	1/2" x 3" Fine Thread Bolt
11	967105	1/2" Fine Thread Lock Nut

Shipping Kit and Bundle Numbers

The following is a list of Kit Numbers for this product and the Bundle Numbers, Descriptions, and Quantities for each Kit.

Quantity	Bundle Number	Description
Y180 - Rollermill		
1	F0866	Manual Carton
1	F0841	PTO Shaft
1	F7601	Hopper
1	F7600	Rollermill - Standard
1	F7654	PTO Guard/Adaptor
Y180C - 180 Rollermill w/ Chromed Rolls		
1	F0866	Manual Carton
1	F0841	PTO Shaft
1	F7601	Hopper
1	F7603	Rollermill – Chromed Rolls
1	F7654	PTO Guard/Adaptor
Y180C-6 - 180 Rollermill w/ Chromed Corn Rolls		
1	F0866	Manual Carton
1	F0841	PTO Shaft
1	F7601	Hopper
1	F7608	Rollermill – Chromed Corn Rolls
1	F7654	PTO Guard/Adaptor

Optional Bundle Numbers

The following is a list of options available for the Kits listed above.

Quantity	Bundle Number	Description
Y183 - Transport w/ Rims (Stand Required w/Transport)		
2	F7110	15" x 4.5" x 4 Bolt Wheel
1	F7647	Transport I/ Rims
	F6710	Magnet
	F7620	Stand
	Y207	Tire Set

Farm King Limited Warranty

This document limits your warranty rights.

Base Limited Warranty

Buhler Industries Inc. provides this warranty only to original retail purchasers of its product. Buhler Industries Inc. warrants to such purchasers that all Buhler Industries Inc. manufactured parts and components used and serviced as provided for in the Operator's Manual shall be free from defects in materials and workmanship for a period following delivery to the original retail purchaser of 12 months (80 days for commercial applications). This limited warranty applies only to those parts and components manufactured by Buhler Industries Inc. Parts and components manufactured by others are subject to their manufacturer's warranties, if any.

Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Buhler Industries Inc. reserves the right to either inspect the product at the buyer's location or have it returned to the factory for inspection. Parts must be returned through the selling representative and the buyer must prepay transportation charges.

Buhler Industries Inc. will not be responsible for repairs or replacements that are necessitated, in whole or part, by the use of parts not manufactured by or obtained from Buhler Industries Inc. Under no circumstances are component parts warranted against normal wear and tear. There is no warranty on product pump seals, product pump bearings, rubber product hoses, pressure gauges, or other components that require replacement as part of normal maintenance. Also: Buckets and Bucket Tines carry no warranty, Bent Spears carry no warranty, Snowblower Fan Shafts carry no warranty, Mower Blades carry no warranty, Portable Auger Parts Have Two (2) Year Warranty, Loader Parts Have Two (2) Year Warranty. The purchaser is solely responsible for determining suitability of goods sold. This warranty is expressly in lieu of all other warranties expressed or implied. Buhler Industries Inc. will in no event be liable for any incidental or consequential damages whatsoever. Nor for any sum in excess of the price received for the goods for which liability is claimed.

Repair Parts Limited Warranty

Buhler Industries Inc. warrants Farm King replacement parts purchased after the expiration of the Buhler Industries Inc. Limited Warranty, and used and serviced as provided for in the Operator's Manual, to be free from defects in materials or workmanship for a period of thirty (30) days from the invoice date for the parts. Buhler Industries Inc. will fulfill this limited warranty by, at its option, repairing or replacing any covered part that is defective or is the result of improper workmanship, provided that the part is returned to Buhler Industries Inc. within thirty (30) days of the date that such defect or improper workmanship is, or should have been, discovered. Such parts must be shipped to Buhler Industries Inc. at the purchaser's expense.

What is Not Covered

Under no circumstances does this limited warranty cover any components or parts that have been subject to the following: negligence; alteration or modification not approved by Buhler Industries Inc.; misuse; improper storage; lack of reasonable and proper maintenance, service, or repair; normal wear; damage from failure to follow operating instructions; accident; and/or repairs that have been made with parts other than those manufactured, supplied, and or authorized by Buhler Industries Inc.

Authorized Dealer and Labor Costs

Repairs eligible for labor under this limited warranty must be made by Buhler Industries Inc. or an authorized Farm King dealer. Buhler Industries Inc. retains the exclusive discretion to determine whether it will pay labor costs for warranty repairs or replacements, and the amount of such costs that it will pay and the time in which the repairs will be made. If Buhler Industries Inc. determines that it will pay labor costs for warranty work, it will do so by issuing a credit to the dealer's or distributor's account. Buhler Industries Inc. will not approve or pay invoices sent for repairs that Buhler Industries Inc. has not previously approved. Warranty service does not extend the original term of this limited warranty.

Warranty Requirements

To be covered by warranty, each Farm King new product must be registered with Buhler Industries Inc. within thirty (30) days of delivery to original retail purchaser. If the customer decides to purchase replacement components before the warranty disposition of such components is determined, Buhler Industries Inc. will bill the customer for such components and then credit the replacement invoice for those components later determined to be covered by this limited warranty. Any such replacement components that are determined not be covered by this limited warranty will be subject to the terms of the invoice and shall be paid for by the purchaser.

Warranty Claims:

Warranty requests must be prepared on Buhler Industries Inc. Warranty Claim Forms with all requested information properly completed. Warranty Claims must be submitted within a thirty (30) day period from date of failure repair.

Warranty Labor:

Any labor subject to warranty must be authorized by Buhler Industries Inc. The labor rate for replacing defective parts, where applicable, will be credited at 100% of the dealer's posted shop rate.

Exclusive Effect of Warranty and Limitation of Liability

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY WARRANTIES, REPRESENTATIONS, OR PROMISES, EXPRESS OR IMPLIED, AS TO THE QUALITY, PERFORMANCE, OR FREEDOM FROM DEFECT OF THE COMPONENTS AND PARTS COVERED BY THIS WARRANTY AND NOT SPECIFICALLY PROVIDED FOR HEREIN.

TO THE EXTENT PERMITTED BY LAW, BUHLER INDUSTRIES INC. DISCLAIMS ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ON ITS PRODUCTS COVERED HEREIN, AND DISCLAIMS ANY RELIANCE BY THE PURCHASER ON BUHLER INDUSTRIES INC.'S SKILL OR JUDGMENT TO SELECT OR FURNISH GOODS FOR ANY PARTICULAR PURPOSE. THE PURCHASER'S ONLY AND EXCLUSIVE REMEDIES IN CONNECTION WITH THE BREACH OR PERFORMANCE OF ANY WARRANTY ON PRODUCTS MANUFACTURED BY BUHLER INDUSTRIES INC. ARE THOSE SET FORTH HEREIN. IN NO EVENT SHALL BUHLER INDUSTRIES INC. BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING, BY WAY OF EXAMPLE ONLY AND NOT LIMITATION, LOSS OF CROPS, LOSS OF PROFITS OR REVENUE, OTHER COMMERCIAL LOSSES, INCONVENIENCE, OR COST OF REPLACEMENT OF RENTAL EQUIPMENT). IN NO EVENT SHALL FARM KING'S CONTRACT OR WARRANTY LIABILITY EXCEED THE PURCHASE PRICE OF THE PRODUCT.

(Note that some provinces or states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitations and exclusion may not apply to you.) This warranty gives you specific legal rights and you may also have other rights, which vary from province to province or state to state.

Buhler Industries Inc. neither assumes nor authorizes any person or entity, including its selling representatives, to assume any other obligations or liability in connections with the sale of covered equipment, or to make any other warranties, representations, or promises, express or implied, as to the quality, performance, or freedom from defect of the components and parts covered herein. No one is authorized to alter, modify, or enlarge this limited warranty, or its exclusions, limitations and reservations.

Corrections of defects and improper workmanship in the manner, and for the applicable time periods, provided for herein shall constitute fulfillment of all responsibilities of Buhler Industries Inc. to the purchaser, and Buhler Industries Inc. shall not be liable in negligence, contract, or on any other basis with respect to the subject equipment.

This limited warranty is subject to any existing conditions of supply which may directly affect Buhler Industries Inc.'s ability to obtain materials or manufacture replacement parts.

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

Government Legislation:

Warranty terms and conditions are subject to provincial or state legislation.

Important Note: This warranty does not apply to rentals.

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