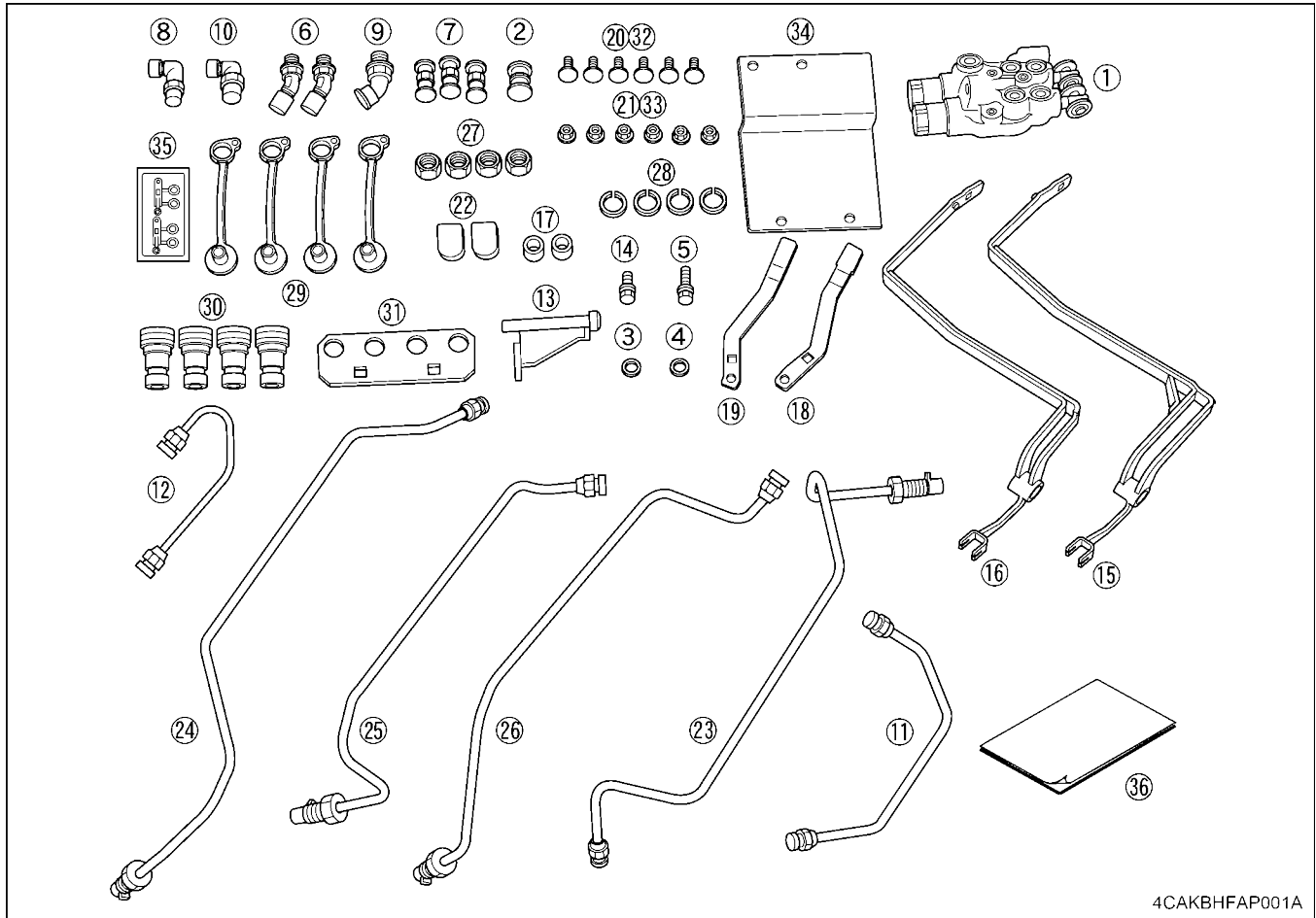


INSTRUCTION MANUAL BX2419 REAR AUX. KIT for KUBOTA TRACTOR BX1880, BX2380, BX2680

■ Parts List

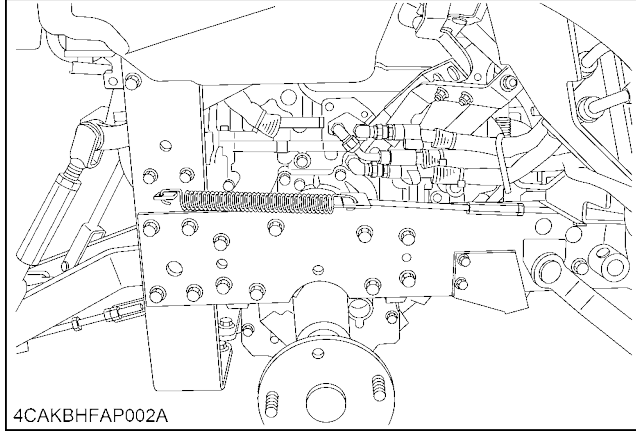


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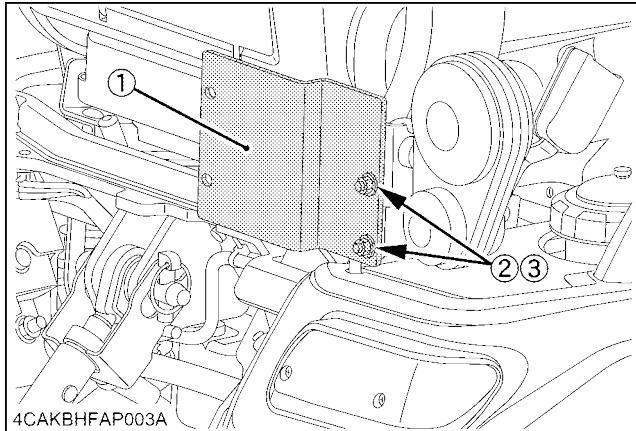
REF No.	PART No.	PART NAME	Q'TY	REF No.	PART No.	PART NAME	Q'TY
1	YW305-0010-0	ASSY, VALVE AUX.	1	19	K2871-3736-0	LEVER (UPPER, AUX. RH)	1
2	K2563-3721-0	CONNECTOR, DRAIN	1	20	K1122-9132-0	BOLT, SHORT SQU. NECK (M8*1.25)	2
3	K2563-3722-0	O RING	1	21	02751-50080	NUT, FLANGE	2
4	04816-00120	O RING	1	22	K2563-3737-0	GRIP, LEVER AUX.	2
5	01123-50830	BOLT, SEMS	1	23	K2581-3761-0	PIPE, SA AUX.	1
6	K2583-3666-2	CONNECTOR, 30-9/16-18	2	24	K2581-3762-0	PIPE, DA AUX.	1
7	K2561-3662-0	CONNECTOR, 9/16-18	3	25	K2581-3763-0	PIPE, SB AUX.	1
8	K2561-4159-0	ELBOW	1	26	K2581-3764-0	PIPE, DB AUX.	1
9	K2581-3665-2	CONNECTOR, 45-9/16-18	1	27	02174-50160	HEX. NUT	4
10	K2561-3663-0	CONNECTOR, 90-9/16-18	1	28	04512-50160	WASHER, SPRING LOCK	4
11	K2583-3751-0	PIPE, DELIVERY AUX.	1	29	7J245-6634-0	1/4" PLUG, DUST (PDP-4W)	4
12	K2583-3753-2	PIPE, RETURN AUX.	1	30	K2581-6632-0	1/4" COUPLER H2-62	4
13	K2583-3725-2	STAY, AUX. VALVE	1	31	K2581-3766-0	BRACKET, COUPLER	1
14	01123-50820	BOLT, SEMS	1	32	K1122-9132-0	BOLT, SHORT SQU. NECK (M8*1.25)	4
15	K2871-3731-0	LEVER (LOWER AUX. LH)	1	33	02751-50080	NUT, FLANGE	4
16	K2871-3732-0	LEVER (LOWER AUX. RH)	1	34	K2871-3767-0	BRACKET (COUPLER 2)	1
17	K3111-5622-3	BUSH (DP-FL-1/2 x 3/4)	2	35	K2583-6558-0	LABEL, Q. COUPLER	1
18	K2871-3735-0	LEVER (UPPER, AUX. LH)	1	36	K2871-9375-1	MANUAL, INST (AUX.)	1

■ Assembly Procedure

1. Park the tractor on a level ground, apply the parking brake and stop the engine.
2. Jack up the back of the tractor and remove the right rear tire.



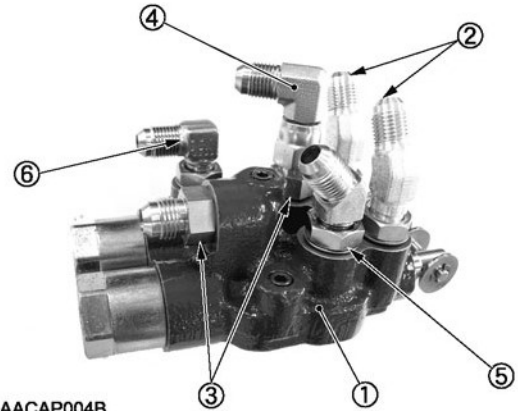
3. Attach the coupler bracket 2 (1) with flange nuts (2) and neck bolts (3).



- (1) Coupler bracket 2 <34>
 (2) Flange nut <21, 33>
 (3) Neck bolt <28, 32>

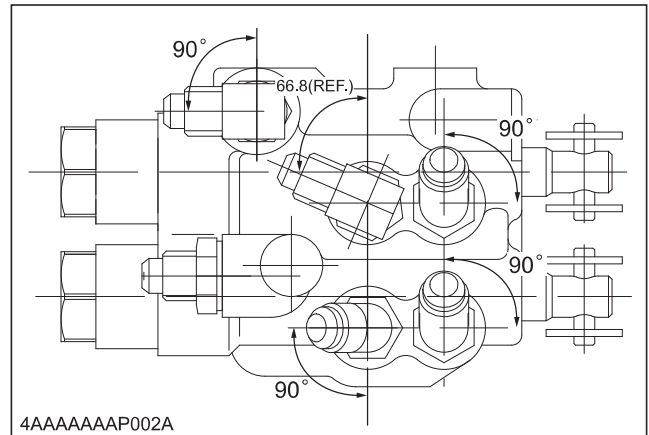
Tightening torque :
 23.5 to 27.4 N-m
 2.4 to 2.8 kgf-m
 17.4 to 20.2 lbf-ft

4. Connect the connectors (2),(3),(5),(6) to the valve (1). Temporarily fit the elbow (4), but tighten up all the other parts.

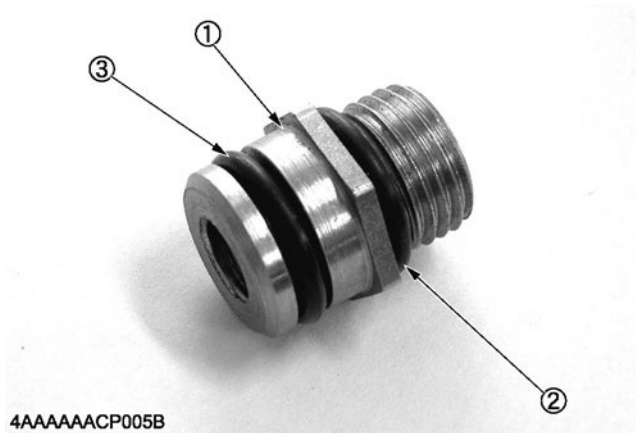


- (1) Valve <1> (4) Elbow <8>
 (2) Connector (30-9/16-18) <6> (5) Connector (45-9/16-18) <9>
 (3) Connector (9/16-18) <7> (6) Connector (90-9/16-18) <10>

Tightening torque :
 29.0 to 39.0 N-m
 2.9 to 3.9 kgf-m
 21.4 to 28.8 lbf-ft



5. Apply oil to the connector (1) and install the O rings (2),(3). Keep in mind that the thin O ring (2) is on the threaded side of the connector.



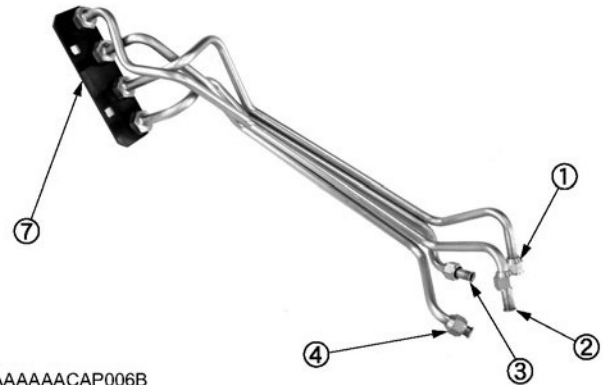
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- (1) Connector <2>
(2) O ring : Thin type <3>
(3) O ring <4>

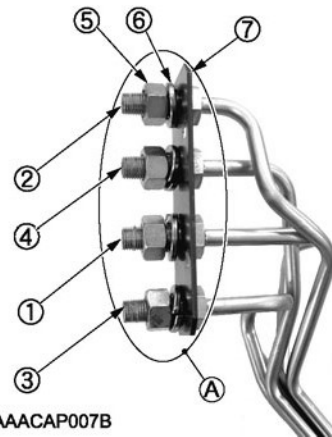
NOTE :

- Be careful not to damage the O rings.

6. Temporarily assemble the auxiliary pipes (1), (2), (3), (4) to the bracket (7) with bolt (5) and spring washer (6). Then put seal tape clockwise 3 times to pipes. Make sure only thread side.



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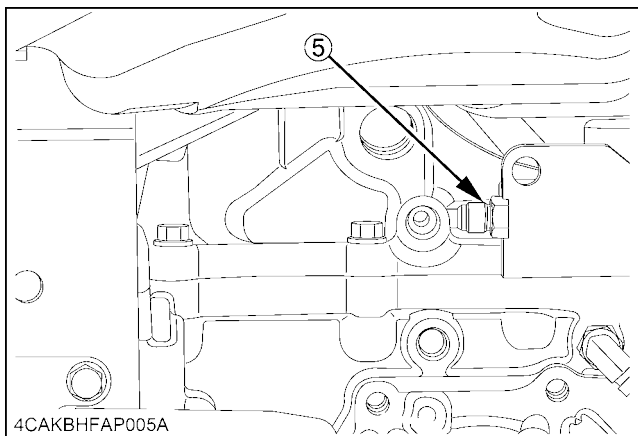
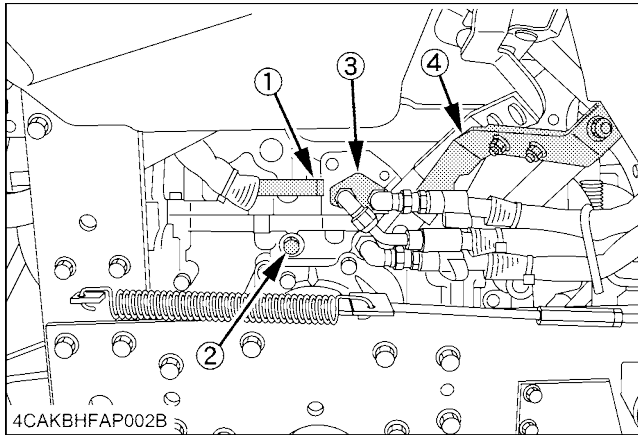
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- (1) Auxiliary pipe (SA) <23> (A) Thread side
(2) Auxiliary pipe (DA) <24>
(3) Auxiliary pipe (SB) <25>
(4) Auxiliary pipe (DB) <26>
(5) Nut <27>
(6) Spring washer <28>
(7) Bracket <31>

NOTE :

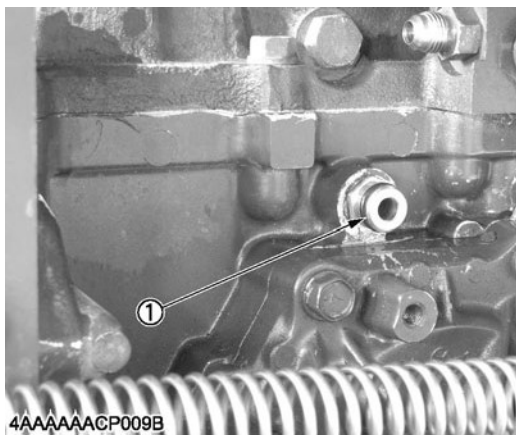
- Be careful no to confuse the positions of the pipes.

7. Disconnect the long connector (1), plug (2), port block (3) and hydraulic lever (4). Then connect the connector (5).



- (1) Long connector
(2) Plug
(3) Port block
(4) Hydraulic lever
(5) Connector, 9/16-18 <7>

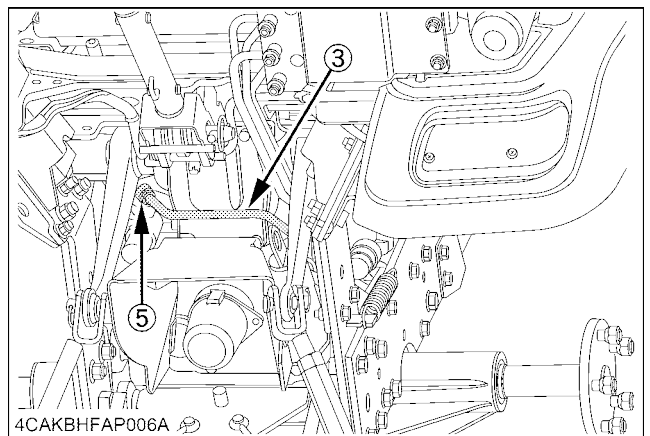
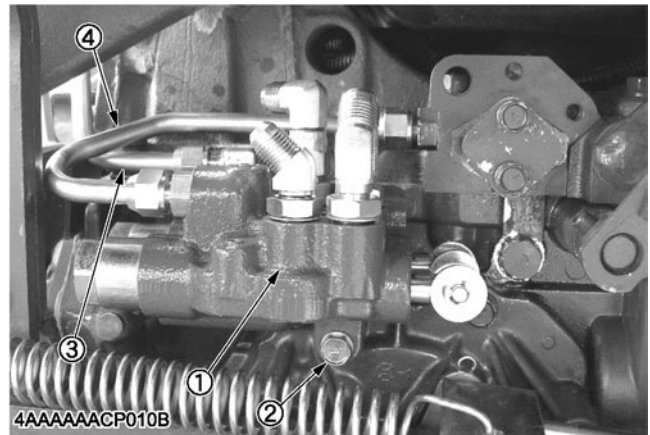
8. Connect the connector (1) in place of the above plug.



- (1) Connector <2>

Tightening torque : 16.7 to 19.6 N-m
1.7 to 2.0 kgf-m
12.3 to 14.5 lbf-ft

9. Fix the valve (1) horizontal using the bolt (2). Then connect the delivery pipe (3) and return pipe (4) in this order.



- (1) Valve <1>
(2) Bolt <5>
(3) Delivery pipe <11>
(4) Return pipe <12>
(5) Connector, 90-9/16-18 <10>

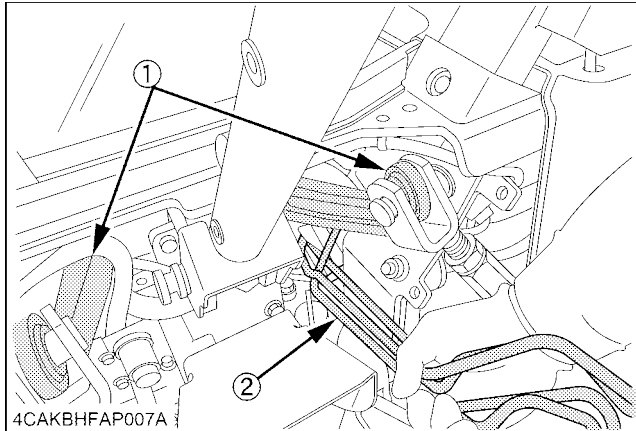
Bolt tightening torque : 17.6 to 20.6 N-m
1.8 to 2.1 kgf-m
13.0 to 15.2 lbf-ft

Pipe tightening torque : 22.0 to 25.0 N-m
2.2 to 2.5 kgf-m
16.2 to 18.4 lbf-ft

NOTE :

- Fix the valve (1) horizontal.

10. Raise the hydraulic arm by hand and put the pipes assembled in step 6 into the back of the tractor.



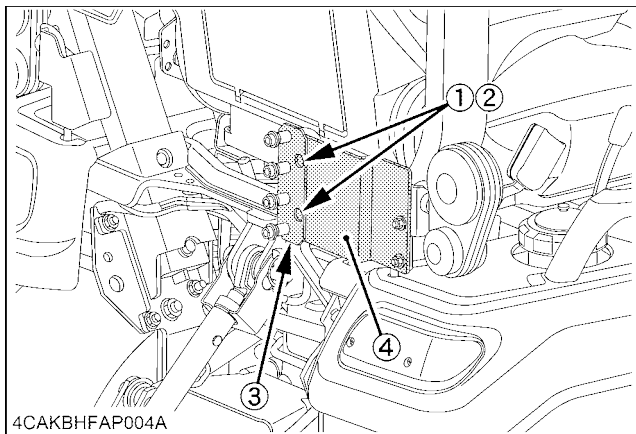
(1) Hydraulic arm (2) Pipes

11. Connect the other pipes before hand-tightening the joint of auxiliary pipe (DB) (1).



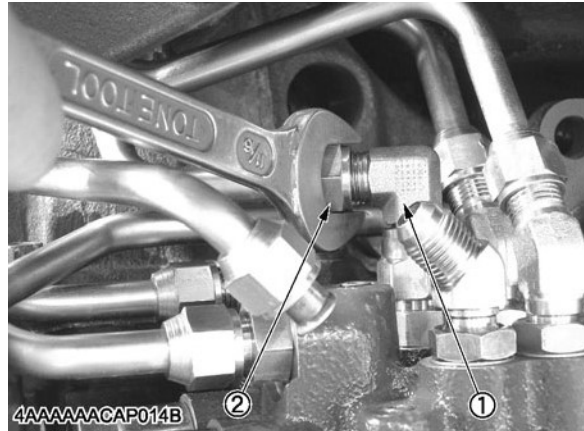
(1) Auxiliary pipe (DB) <26>

12. Hand-tighten the neck bolts (1) and flange nuts (2) to secure the brackets (3) and (4) in position.



(1) Neck bolt <20, 32> (2) Flange nut <21>
(3) Bracket 1 <31> (4) Bracket 2 <34>

13. Position the pipes as specified and tighten up the elbow (1). Then tighten up the auxiliary pipe (SB) (2).

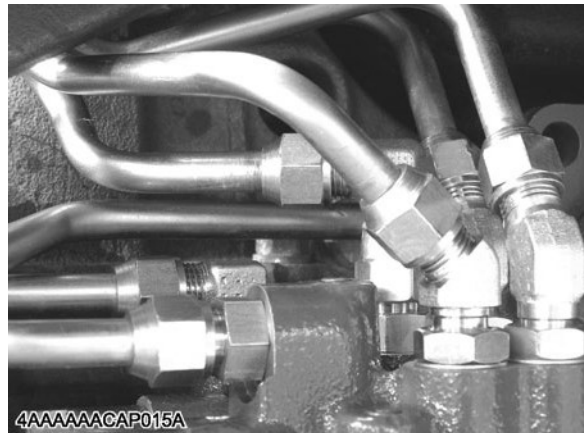


(1) Elbow <8>
(2) Auxiliary pipe (SB) <25>

Elbow tightening torque : 29.0 to 39.0 N-m
2.9 to 3.9 kgf-m
21.4 to 28.8 lbf-ft

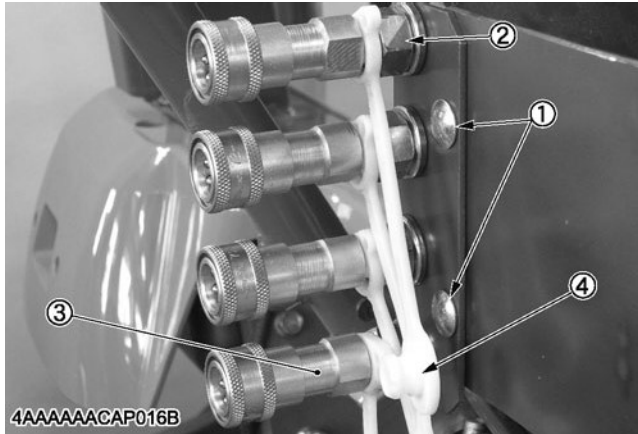
Pipe tightening torque : 22.0 to 25.0 N-m
2.2 to 2.5 kgf-m
16.2 to 18.4 lbf-ft

14. Tighten up all the pipes starting with the farthest one.



Pipe tightening torque : 22.0 to 25.0 N-m
2.2 to 2.5 kgf-m
16.2 to 18.4 lbf-ft

15. Tighten up the nuts (2) first and then the bracket-mounting neck bolts (1). Wrap sealing tape around the ends of the pipes, insert the plugs (4) and tighten up the couplers (3).



(1) Neck bolt <20, 32>
(2) Nut <27>

(3) Coupler <30>
(4) Plug <29>

Nut tightening torque :
80.0 to 85.0 N-m
8.1 to 8.6 kgf-m
59.0 to 62.7 lbf-ft

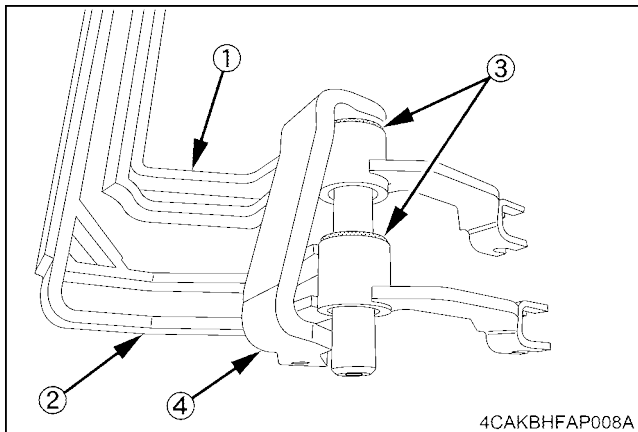
Coupler tightening torque :
29.0 to 44.0 N-m
2.9 to 3.9 kgf-m
21.4 to 32.5 lbf-ft

Neck bolt tightening torque :
23.5 to 27.4 N-m
2.4 to 2.8 kgf-m
17.3 to 20.2 lbf-ft

NOTE :

- In tightening up the nuts, hold the pipes tightly to keep them free from any excessive force.

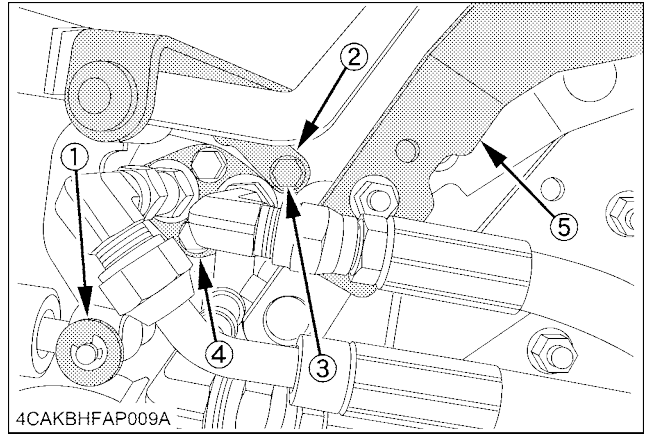
16. Assemble lever lower RH (1) and lever lower LH (2) through the bush (3) and the stay (4) as shown below.



(1) Lever lower RH <16>
(2) Lever lower LH <15>

(3) Bush <17>
(4) Stay <13>

17. Put the lever lower RH and LH between the valve spool washer (1). Insert the stay (2) in the hydraulic cylinder case. Then secure the stay (2) with the bolt (3) and reassemble port block (4) and hydraulic lever (5).



(1) Valve spool washer
(2) Stay <13>
(3) Bolt <14>

(4) Port block
(5) Hydraulic lever

Bolt (Stay <13>) tightening torque :

23.5 to 27.4 N-m
2.4 to 2.8 kgf-m
17.3 to 20.2 lbf-ft

Bolt (Port block) tightening torque :

24.0 to 28.0 N-m
2.4 to 2.8 kgf-m
17.7 to 20.6 lbf-ft

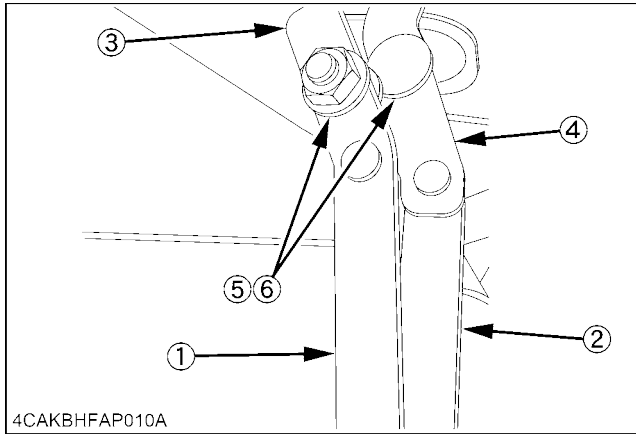
Flange nut (Hydraulic lever) tightening torque :

23.5 to 27.4 N-m
2.4 to 2.8 kgf-m
17.3 to 20.2 lbf-ft

NOTE :

- Lever lower RH and LH to be between washers.

18. Put lever upper RH (3) to the protrusion of lever lower RH (1).
Put lever upper LH (4) to the protrusion of lever lower LH (2).
Tighten neck bolt (5) and flange nut (6).

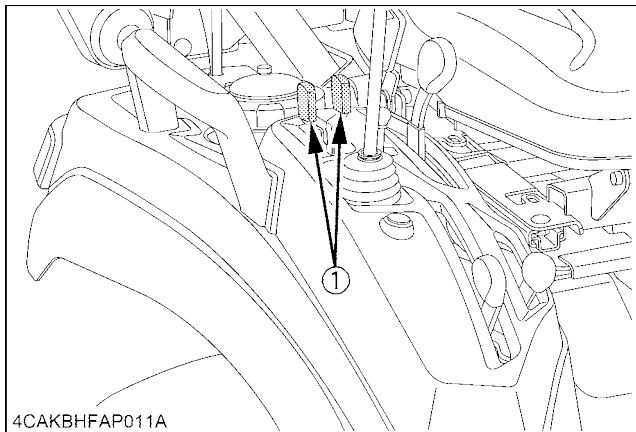


- (1) Lever lower RH <16> (4) Lever upper LH <18>
(2) Lever lower LH <15> (5) Neck bolt <20, 32>
(3) Lever upper RH <19> (6) Flange nut <21, 33>

Flange nut and weld nut tightening torque :

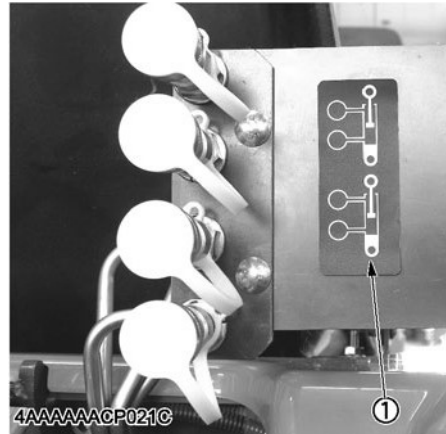
23.5 to 27.4 N-m
2.4 to 2.8 kgf-m
17.3 to 20.2 lbf-ft

19. Attach the grips (1) to the tips of the levers.



- (1) Grip <22>

20. Apply the label (1) to the bracket, and connect the plug to the coupler.



- (1) Label <35>

21. Attach the tire back in place.
22. Move the levers to their neutral positions. Start engine and move the accelerator lever to the middle position. Move the levers forward and backward to make sure there is no oil leak from the pipes.