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## **Operator's Manual**

**GR-3200 VIBRATORY ROLLER**



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## **Contact Information**

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# Section 1

## Roller Specifications

Weight	550 lbs dry
Centrifugal Force	3200 lbs
Vibration Frequency	5400 VPM
Compaction Depth	10 in
Overall Width	31 in
Overall Length	28 in (Handle up) 61 in (Handle down)
Overall Height	41 in (Handle up) 54 in (Handle down)

## Engine Specifications

Honda GX-160  
Four cycle, gasoline, air cooled  
Overhead valve, slant cylinder  
Dual element heavy-duty air cleaner  
5.5 Horsepower/4.1 Kilowatts  
3400 RPM  
Rewind starter  
Low oil alert system  
Transistorized magneto ignition

## **Section 2**

### **Serial Number Location**

#### **Engine**

When ordering replacement parts from the engine distributor, state the model, specification and serial number. Model and specification numbers are located on the flywheel cover. The serial numbers are found on the front of the crankcase housing.

#### **Compactor**

The Vibco model and serial numbers are mounted on the rear left side of the top plate, adjacent to the handle mount plate. Furnish both numbers when corresponding with your authorized dealer.

## **Section 3**

### **Maintenance**

*Keep your machine clean!*

#### **Every 10 hours or daily**

1. Periodically check bolts and nuts for tightness, especially in the period following initial operation.
2. Check engine oil daily.
3. Check hydraulic fluid level, fill to 1-1/4" below top of fill tube if low.

#### **Every 50 hours or weekly**

1. Check belt tension.
2. Check and tighten all nuts and bolts.
3. If water flow through the sprinkler pipe fails, clear pipe using carburetor cleaner.
4. Check and grease fittings located near the shift lever, rear roller and the belt chain drive.
5. Clean air filter.

#### **Every 100 hours or 6 months**

1. Change engine oil.
2. Check spark plug.

Always fill the water tank with clean, clear water to ensure good flow and to avoid discoloration of the fresh asphalt.

Replace hydraulic filter cartridge every 200 hours.

Change hydraulic fluid every 200 hours or once per season.

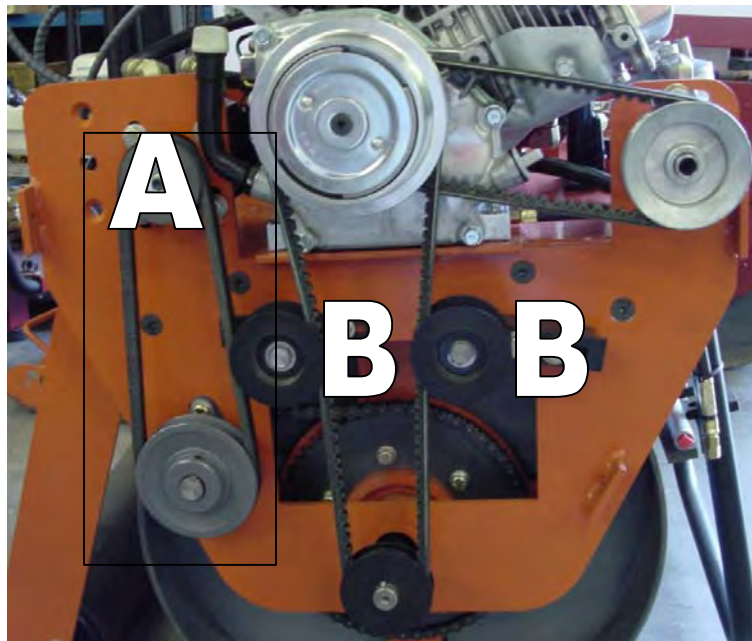
Fill with any good grade industrial, non-foaming hydraulic oil with a viscosity of approximately 200 to 350 SUS at 100°F, 20 wt approximately (i.e. Mobil DTE® 26) or equal.

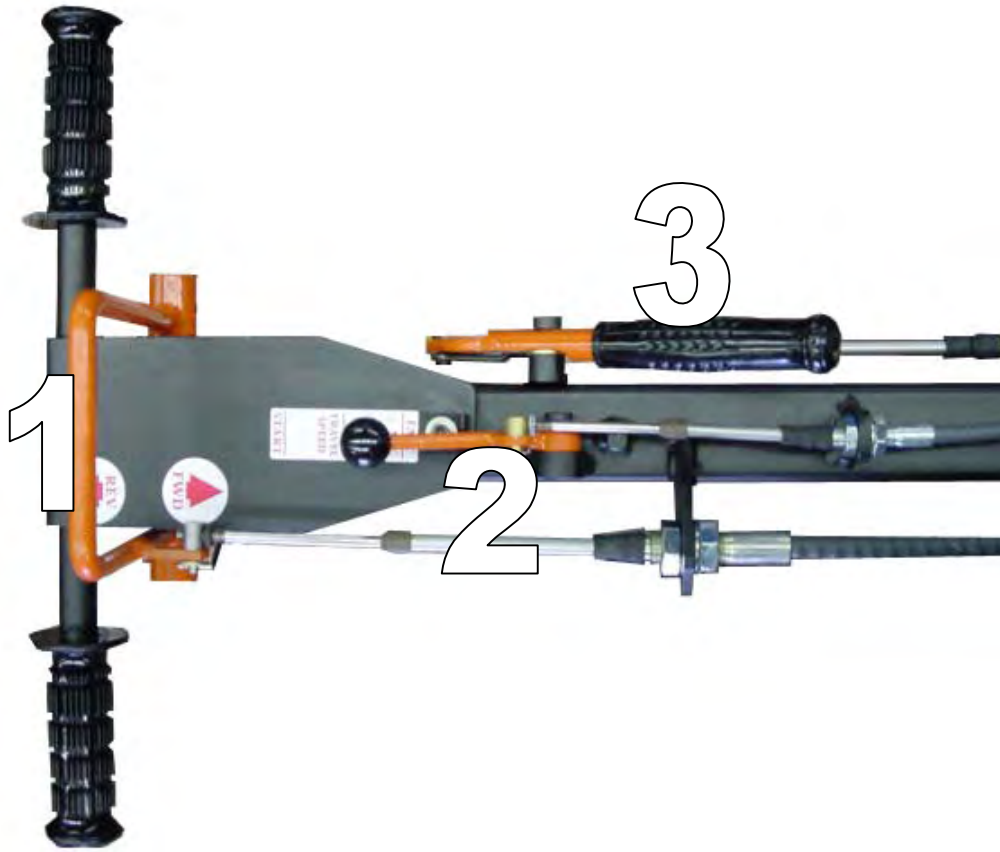
For proper engine maintenance refer to the owners manual supplied with the Honda® engine.

## Section 4

### Operating Notes

1. Before starting the machine, READ all manuals CAREFULLY.
2. Remember to check the engine oil.
3. Unlock the handle by removing the pin and lowering the handle to the desired position. Reinsert the pin and the machine is ready to start.
4. Allow machine ample time for warm up, particularly in cold weather conditions.
5. The throttle lever controls engine speed.
6. The flow control lever controls roller travel. The farther back you pull this lever the faster the machine will travel.
7. The roller can be shifted between forward and reverse while at full vibration and full travel speed by using the shift lever. Push the lever away from you to travel forward and pull the lever toward you to travel in reverse. This lever is spring loaded, when released it will return to the upright position, and stop the roller.
8. A travel speed of 100 ft per minute can be obtained from partial throttle without engagement of vibration. A travel speed of 200 ft per minute is obtained at full throttle and when the flow control lever is in the full forward position.
9. If over time the drive belt begins to slip, loosen the four 3/8-16 hex bolts located at the top of the highlighted area in the picture below. Then lift the hydraulic motor (marked with an "A") using a pry bar or large screwdriver until there is no slack in the belt. Also, if the vibration drive belt needs to be adjusted or replaced loosen the four 3/8-16 hex bolts marked with a "B" and adjust the idler pulleys until there is no slack in the belt.





1. Shift Lever
2. Throttle lever
3. Flow Control Lever
4. Hydraulic filter
5. Hydraulic tank



# **Section 5**

## **General Guidelines**

- ◆ Initial break-in and testing is done at Vibco, Inc. so there is no need for precautions or other procedures. Make sure that drum surface is clean and free of any debris before beginning compaction of fresh asphalt.
- ◆ In order to ensure a smooth finish keep roller moving at all times while compacting. Stop the roller on a flat, solid surface. Never leave the machine idle on top of fresh asphalt. Doing so may cause unsightly marks or depressions, which will be difficult to remove.
- ◆ When compacting a seam between fresh asphalt and compacted asphalt place 3/4 of the drum width over the fresh asphalt side to accomplish an even and steady joint.
- ◆ Avoid dropping the roller off of curbs and high grades as this may cause damage to the shaft and drive components.
- ◆ Always use a non-flammable and non-toxic solution when cleaning your machine.
- ◆ When storing the machine drain the water tank and fuel tank as well as turn the fuel valve to the off position. Store in a dry location free from dust, dirt and objects that may cause damage to the unit. For other storage suggestions refer to the Honda<sup>®</sup> engine owner's manual.



# **Section 6**

## **Troubleshooting**

### **Engine Doesn't Start**

If at any time the engine will not start remove the belt guard. Then remove the belt connecting the engine to the hydraulic pump. Try to start the engine. If it still will not start then contact your nearest authorized Honda dealer. If the engine starts then the problem lies in the hydraulic pump. Most likely what has happened is debris was forced through the hydraulic pump and ceased the gears. The pump now must be taken apart using extreme caution and cleaned out. You may either attempt this yourself or contact Vibco, Inc. in order to make arrangements to have it delivered to the factory.

### **Roller Will Not Travel**

If the drum will not move in any direction check the hydraulic fluid level, fill to 1-1/4" below top of fill tube if low. If the problem still persists inspect the chain drive and make sure the chain is aligned with the sprocket and not at an angle, as this will cause the chain to bind and not work properly. Also, inspect under the top plate to ensure no foreign objects have been wedged into the space between the top plate and the drum, which would prohibit rotation of the drum.

### **There Is A Scraping Sound While In Motion**

First, check the front scraper bar and make sure it is at least 1/4" away from the drum. Next, see if the drive shaft is contacting the drive side plate or if the drum is scraping the top plate while rotating. If either of these is the case than the isolator mounts will need to be replaced.

### **Sprinkler System Not Working**

If water flow through the sprinkler pipe fails, clear pipe using carburetor cleaner. Also, remember to always fill the water tank with clean, clear water to ensure good flow and to avoid discoloration of the fresh asphalt.

### **Belts are Slipping**

It is important to check belts periodically to guarantee that the machine is working to its optimum potential. For the procedure on how to properly tighten belts refer to Section 4 number 9.

# **Section 7**

## **Exploded Views/Parts Lists**

Water System and Front Bar

Drum Assembly and Shock Mount Plates

Rear Roller

Handle Assembly

Drive Components and Engine

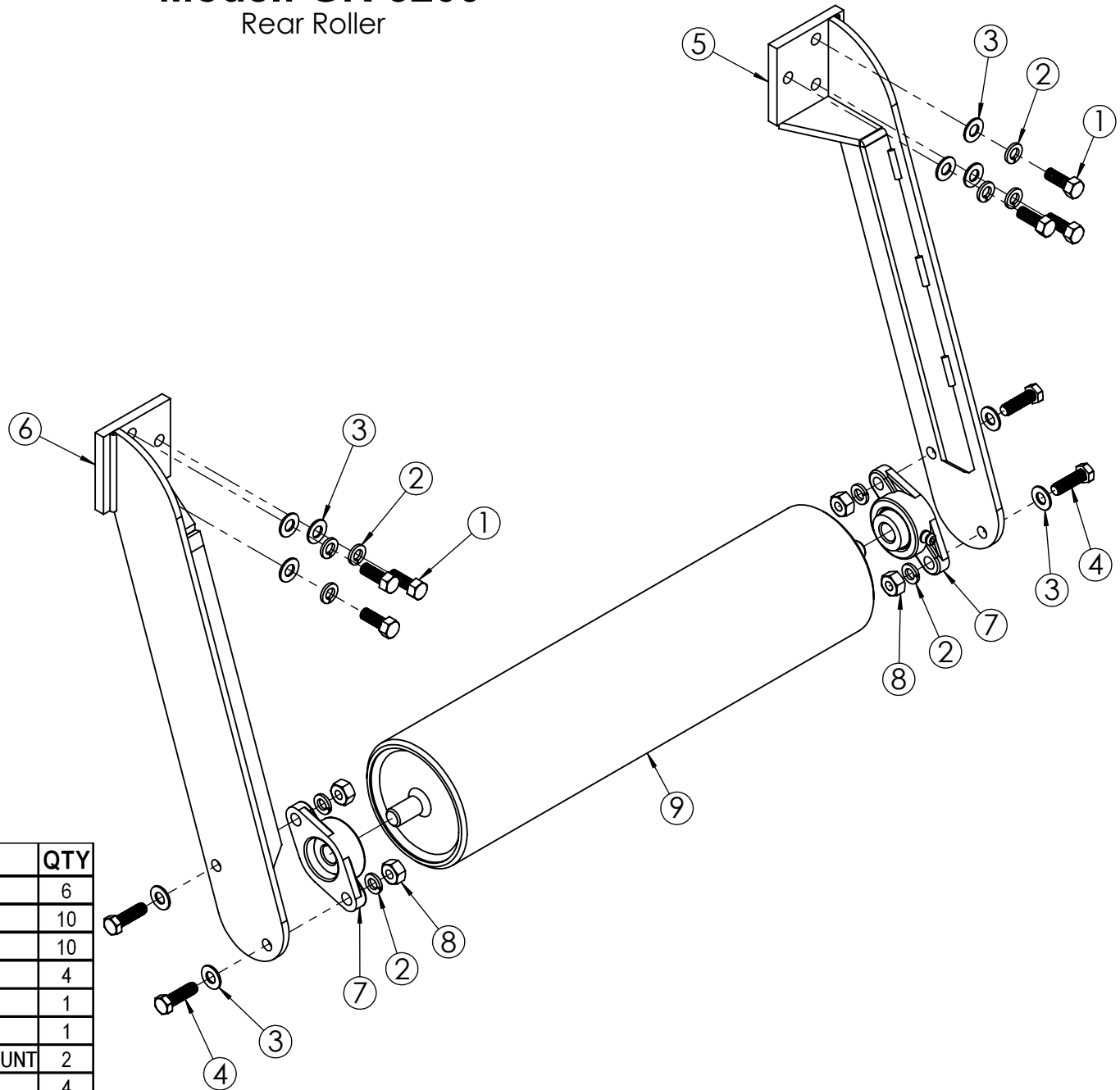
Hydraulic Components

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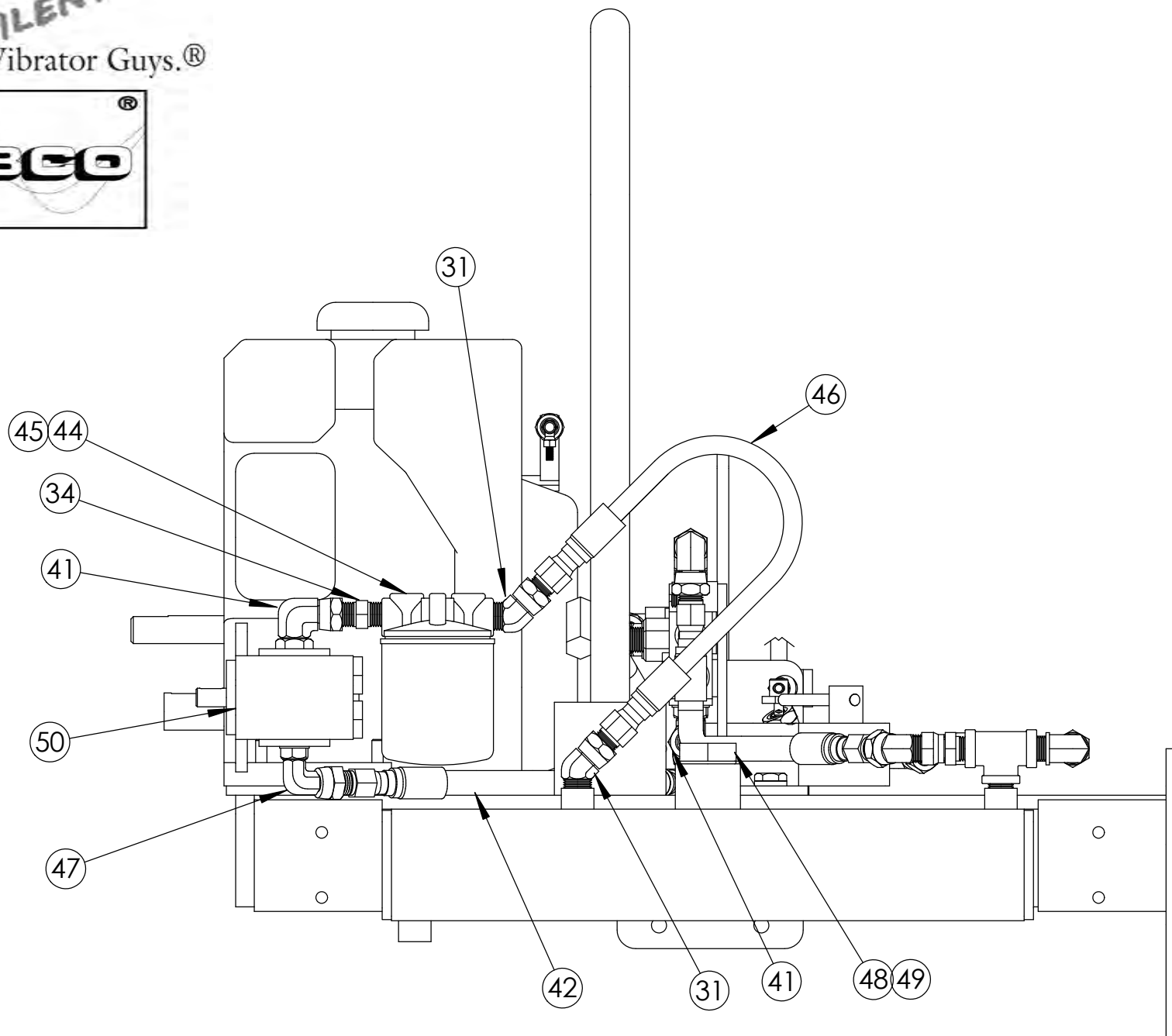
## Model: GR-3200

Rear Roller



ITEM #	PART #	DESCRIPTION	QTY
1	3/8-16X1HHG8	SCREW, HEX HEAD BOLT GRADE 8	6
2	3/8LWG8	LOCKWASHER GRADE 8	10
3	3/8FWG8	FLAT WASHER SAE GRADE 8	10
4	3/8-16X1-1/4HH8	SCREW, HEX HEAD CAP GRADE 8	4
5	32GR64	RIGHT ROLLER ARM	1
6	32GR62	LEFT ROLLER ARM	1
7	FYT-5/8	5/8IN DIA PILLOW BLOCK FLANGE MOUNT	2
8	3/8-16HNG8	GRADE 8 HEX NUT	4
9	32GR19	REAR ROLLER ASSEMBLY	1

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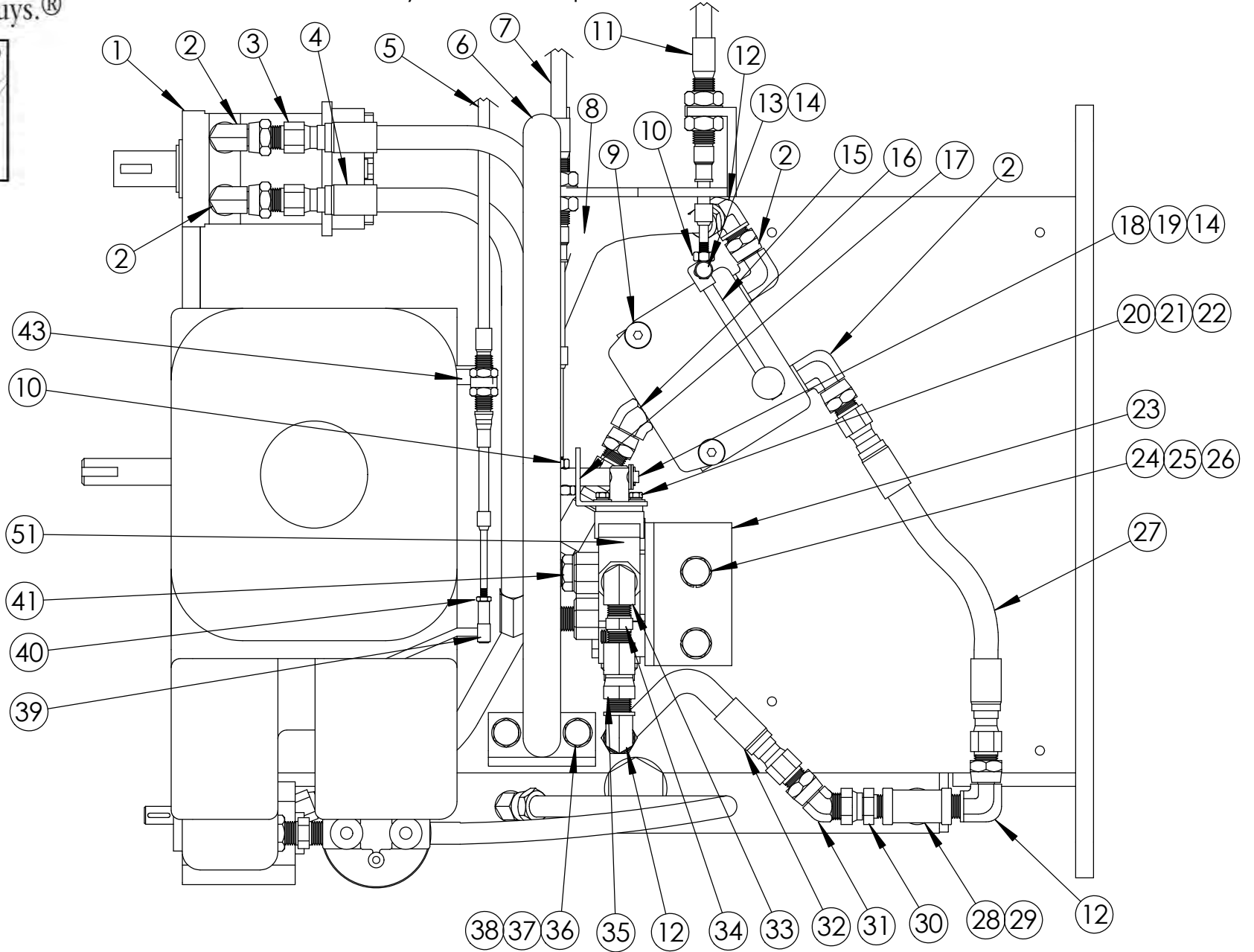


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# Model: GR-3200

Hydraulic Components



## Hydraulic Components

ITEM NO	PART NO	DESCRIPTION	QTY
1	32GR184	Hydraulic Motor	1
2	2107-8-6	1/2 NPTF to 3/8 NPSM Swivel 90deg	4
3	32GR221	Hose Assembly (SV Back to Motor Front)	1
4	32GR223	Hose Assembly (SV Front to Motor Back)	1
5	32GR133	CableCraft Cable (174-LTT-4-46)	1
6	32GR70	Lift Hook Weld	1
7	32GR132	CableCraft Cable (174-VTT-2-46)	1
8	32GR222	Hose Assembly (SV Bottom to CF of FV)	1
9	3/8-16X2-1/2FHS	Screw, Flat Head Socket Cap	2
10	1/4-28HN	Hex Nut	2
11	32GR131	CableCraft Cable (174-LTT-4-36) - <b>OBSOLETE</b>	1
12	2107-6-6	3/8 NPTF to 3/8 NPSM Swivel 90deg	3
13	32GR17	Flow Control Pivot	1
14	3/32X1/2CP	Stainless Steel Cotterpin	2
15	32GR16	Flow Control Lever	1
16	3107-8-6	1/2 NPTF to 3/8 NPSM Swivel 45deg	1
17	32GR180	Spool Valve Pivot Slide	1
18	32GR182	Spool Valve Pivot	1
19	5/16FWG8	Flat Washer Grade 8	2
20	M5-0.8X20HH	Hex Head Bolt (Metric)	2
21	10LW	Lock Washer	2
22	10FW	Flat Washer	2
23	32GR181	Spool Valve Mount Plate Bucher Hydraulic	1
24	1/2-13X1HH	Screw, Hex Head Cap Grade 5	2
25	1/2LW	Lock Washer	2
26	1/2FW	Flat Washer	2
27	32GR220	Hose Assembly (EF Port of FV to Tee)	1
28	32GR149	3/8 NPT Tee Stainless Steel	1
29	32GR150	3/8 NPT Close Nipple Stainless Steel	1
30	0107-6-6	3/8 to 3/8 NPSM Swivel Straight	1
31	3107-6-6	3/8 NPTF to 3/8 NPSM Swivel 45deg	3
32	32GR218	Hose Assembly (Top Port of SV to Tee)	1
33	8-3/8AOEGS	SAE 8 to 3/8 NPTF Female 90deg	1
34	0101-6-6	3/8 to 3/8 NPTF Nipple	2
35	0207-6-6	3/8 NPSM Swivel to 3/8 NPTF Adapter	1
36	3/8-16X1HH	Screw, Hex Head Cap	2
37	3/8LW	Lock Washer	1
38	3/8FW	Flat Washer	1
39	161-091-000	10-32 Threaded Pivot (CableCraft)	1
40	10-32HN	Hex Nut	1
41	2507-8-6	SAE 8 to 3/8 NPSM Swivel 90deg	3
42	32GR224	Hose Assembly (Pump Bottom to in of FV)	1
43	32GR168	Throttle Cable Mount	1
44	32GR205	Filter Head	1
45	32GR206	Filter Element	1
46	32GR219	Hose Assembly (Hydraulic Tank to Filter)	1
47	2507-6-6	SAE 6 to 3/8 NPSM Swivel 90deg	1
48	32GR67	Hydraulic Tank Cap	1
49	320	O-Ring	1
50	32GR183	Hydraulic Pump	1
51	32GR155	Spool Valve	1

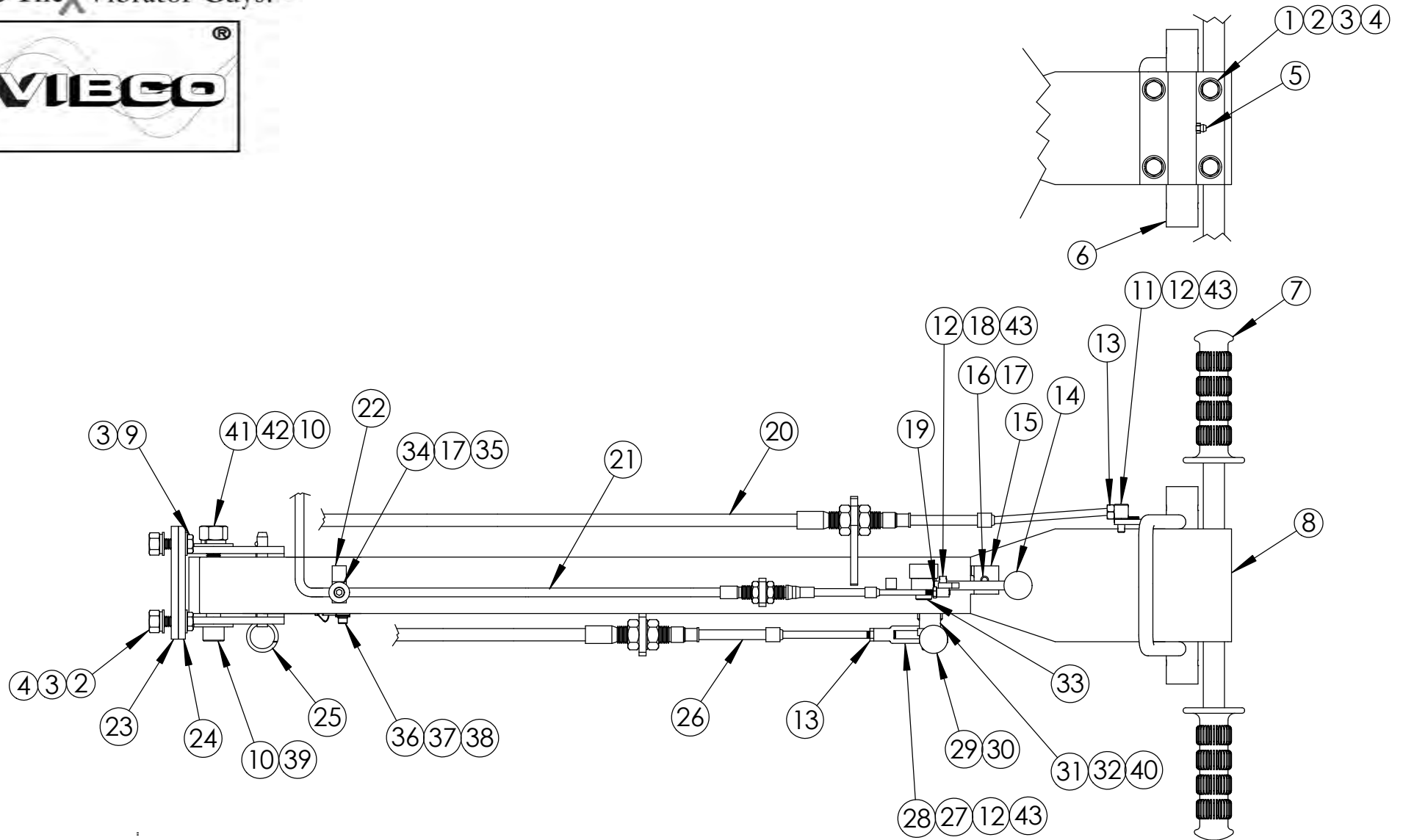
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# Model: GR-3200

Handle Assembly

BOTTOM VIEW



<b>HANDLE ASSEMBLY</b>			
<b>ITEM NO</b>	<b>PART NO</b>	<b>DESCRIPTION</b>	<b>QTY</b>
1	3/8-16X1HHG8	Screw, Hex Head Cap Grade 8	4
2	3/8LW	Lock Washer	8
3	3/8FWG8	Flat Washer Grade 8	12
4	3/8-16HN	Hex Nut	4
5	32GR151	1/4-28 Grease Fitting	1
6	32GR81	Flow Control Handle Assembly	1
7	18VR053	7/8ID Grip	2
8	32GR80	Handle Weld	1
9	3/8-16X1-1/4HH8	Screw, Hex Head Cap Grade 8	4
10	1/2FW	Flat Washer	2
11	32GR17	Flow Control Pivot	1
12	3/32X1/2CP	Stainless Steel Cotterpin	3
13	1/4-28HN	Hex Nut	2
14	32GR92	Throttle Lever	1
15	32GR43	Throttle Rest	1
16	1/4-20X5/8SH	Screw, Socket Head Cap	1
17	1/4LW	Lock Washer	2
18	161-091-000	10-32 Threaded Pivot (CableCraft)	1
19	10-32HN	Hex Nut	1
20	32GR132	CableCraft Cable (174-VTT-2-46)	1
21	32GR133	CableCraft Cable (174-LTT-4-46)	1
22	16GR38	Cable Clamp (3225T42)	1
23	32GR214	Handle Isolator, 60 Duro (4 X 6)	1
24	32GR26	Pivot Mount Weld	1
25	32GR216	Handle Pin Lanyard	1
26	32GR131	CableCraft Cable (174-LTT-4-36)	1
27	32GR154	Yoke End	1
28	32GR215	Clevis Pin	1
29	32GR197	Flow Lever Weld	1
30	32GR157	1/2ID Round Grip	1
31	1/4-20X1/2FHS	Screw, Flat Head Socket Cap	2
32	32GR209	Flow Lever Spacer	2
33	32GR207	Shoulder Bolt (5/16-18X1/2X3/8)	1
34	1/4-20X3/4SH	Screw, Socket Head Cap	1
35	1/4FWG8	Flat Washer Grade 8	1
36	10-24X3/4SH	Screw, Socket Head Cap	1
37	10LW	Lock Washer	1
38	10FW	Flat Washer	1
39	1/2-13X3-1/2SH	Screw, Socket Head Cap	1
40	32GR172	Flow Lever Mount Weld	1
41	1/2-13HN	Hex Nut	1
42	1/2LW	Lock Washer	1
43	1/4SW	Seal Washer	3



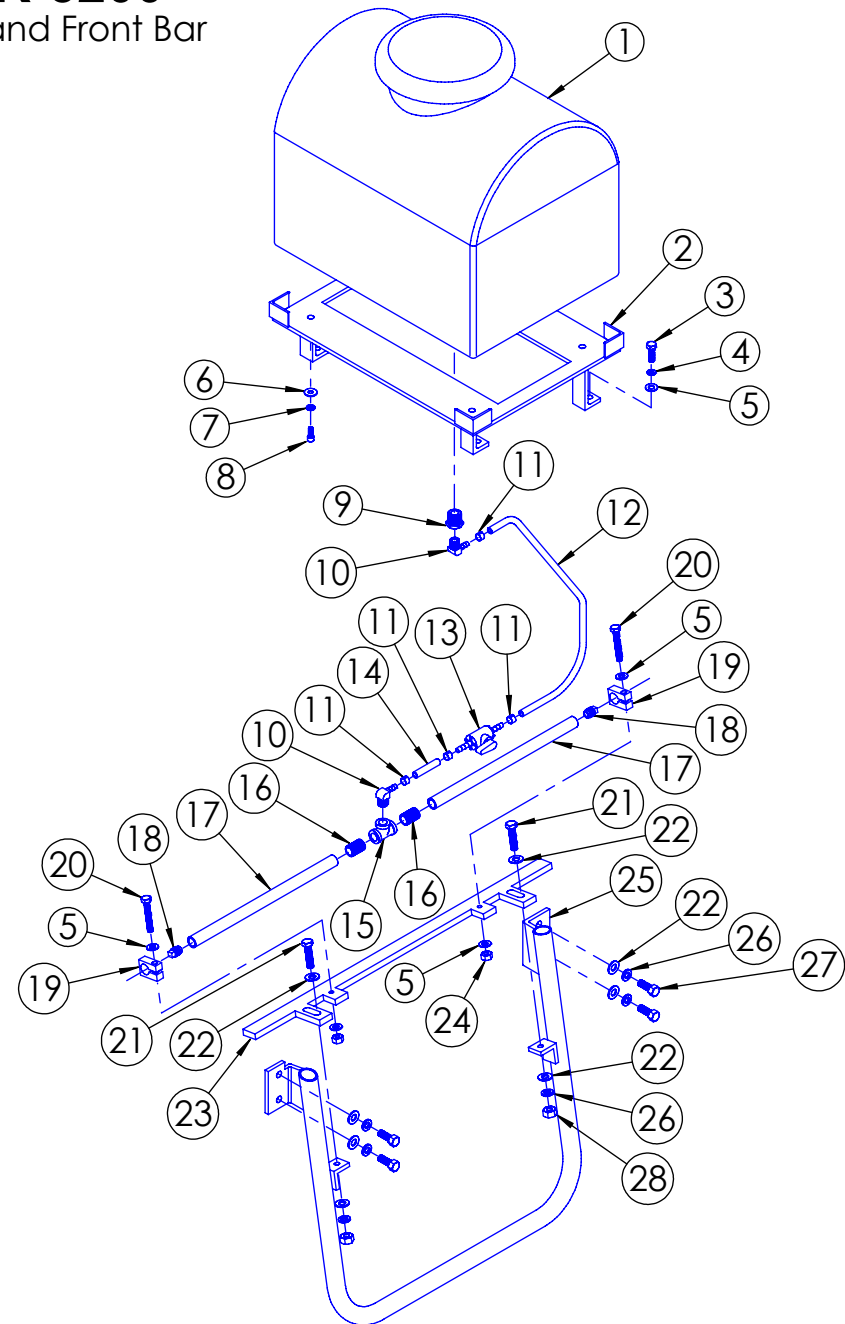
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## Model: GR-3200

Water System and Front Bar

ITEM NO	PART NO	DESCRIPTION	QTY
1	32GR201	Water Tank	1
2	32GR100	Water Tank Assembly	1
3	5/16-18X1HHG8	Hex Head Bolt Grade 8	4
4	5/16LW	Lock Washer	4
5	5/16FW	Flat Washer Grade 8	8
6	1/4FW	Flat Washer Grade 8	4
7	1/4LW	Lock Washer	4
8	1/4-20X5/8SH	Socket Head Cap Screw	4
9	32GR229	1/2 NPT X 1/4 NPT Brass	1
10	122030	90° Barb	2
11	133	Dixon Clamp	4
12	122094	Sprinkler Hose 16-1/2" Long	1
13	201134	PVC Sprinkler Valve	1
14	122094	Sprinkler Hose 2-1/4" Long	1
15	1/4NPT-TB	Tee, Brass	1
16	1/4NPT-B	Close Nipple, Brass	2
17	122103-1	Sprinkler Pipe	2
18	122041	Pipe Plug (P-28)	2
19	201129	Pipe Bracket	2
20	5/16-18X2HH	Hex Head Bolt Grade 5 Zinc	2
21	3/8-16X1-1/2HH	Hex Head Bolt Grade 8	8
22	3/8FW	Flat Washer Grade 8	4
23	32GR204	Scraper Bar	1
24	5/16-18HN	Hex Nut	2
25	32GR105	Front Bar Weld	1
26	3/8LW	Lock Washer	6
27	3/8-16X1HHG8	Hex Head Bolt Grade 8	4
28	3/8-16HN	Hex Nut	2

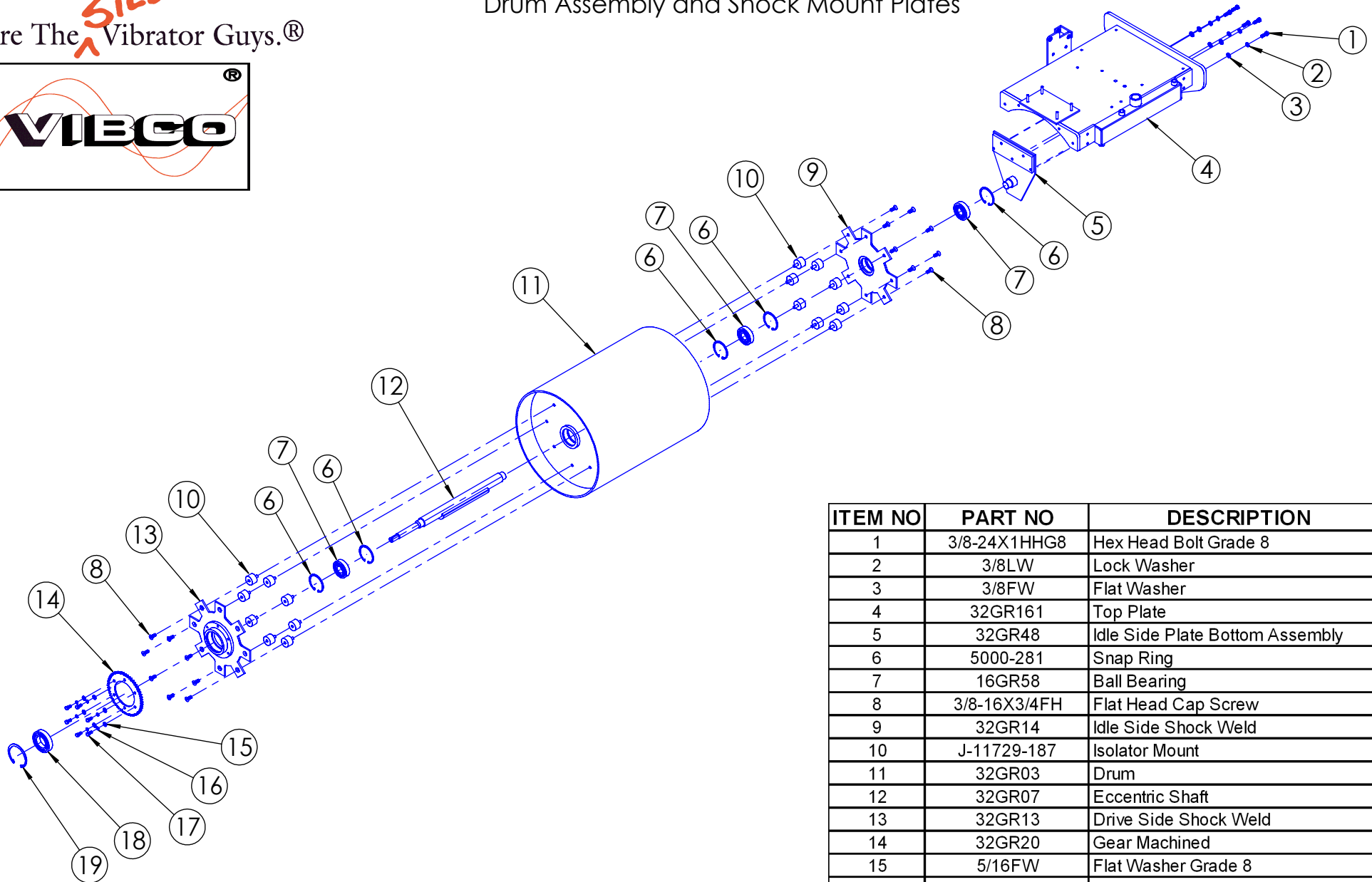


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## Model: GR-3200

### Drum Assembly and Shock Mount Plates



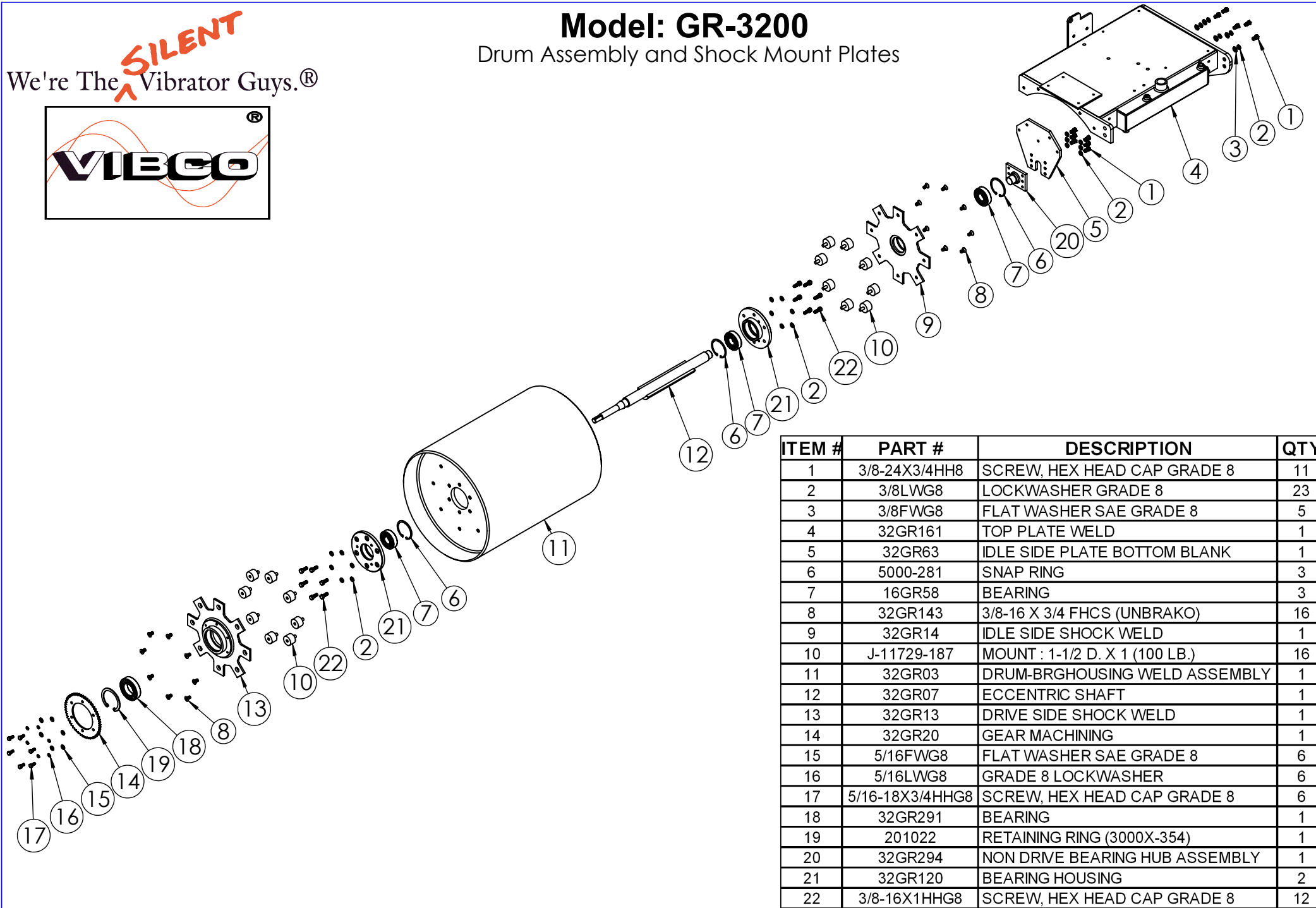
ITEM NO	PART NO	DESCRIPTION	QTY
1	3/8-24X1HHG8	Hex Head Bolt Grade 8	5
2	3/8LW	Lock Washer	5
3	3/8FW	Flat Washer	5
4	32GR161	Top Plate	1
5	32GR48	Idle Side Plate Bottom Assembly	1
6	5000-281	Snap Ring	3
7	16GR58	Ball Bearing	3
8	3/8-16X3/4FH	Flat Head Cap Screw	16
9	32GR14	Idle Side Shock Weld	1
10	J-11729-187	Isolator Mount	16
11	32GR03	Drum	1
12	32GR07	Eccentric Shaft	1
13	32GR13	Drive Side Shock Weld	1
14	32GR20	Gear Machined	1
15	5/16FW	Flat Washer Grade 8	6
16	5/16LW	Lock Washer	6
17	5/16-18X3/4HHG8	Hex Head Bolt Grade 8	6
18	32GR291	Ball Bearing	1
19	201022	Snap Ring	1

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## Model: GR-3200

### Drum Assembly and Shock Mount Plates



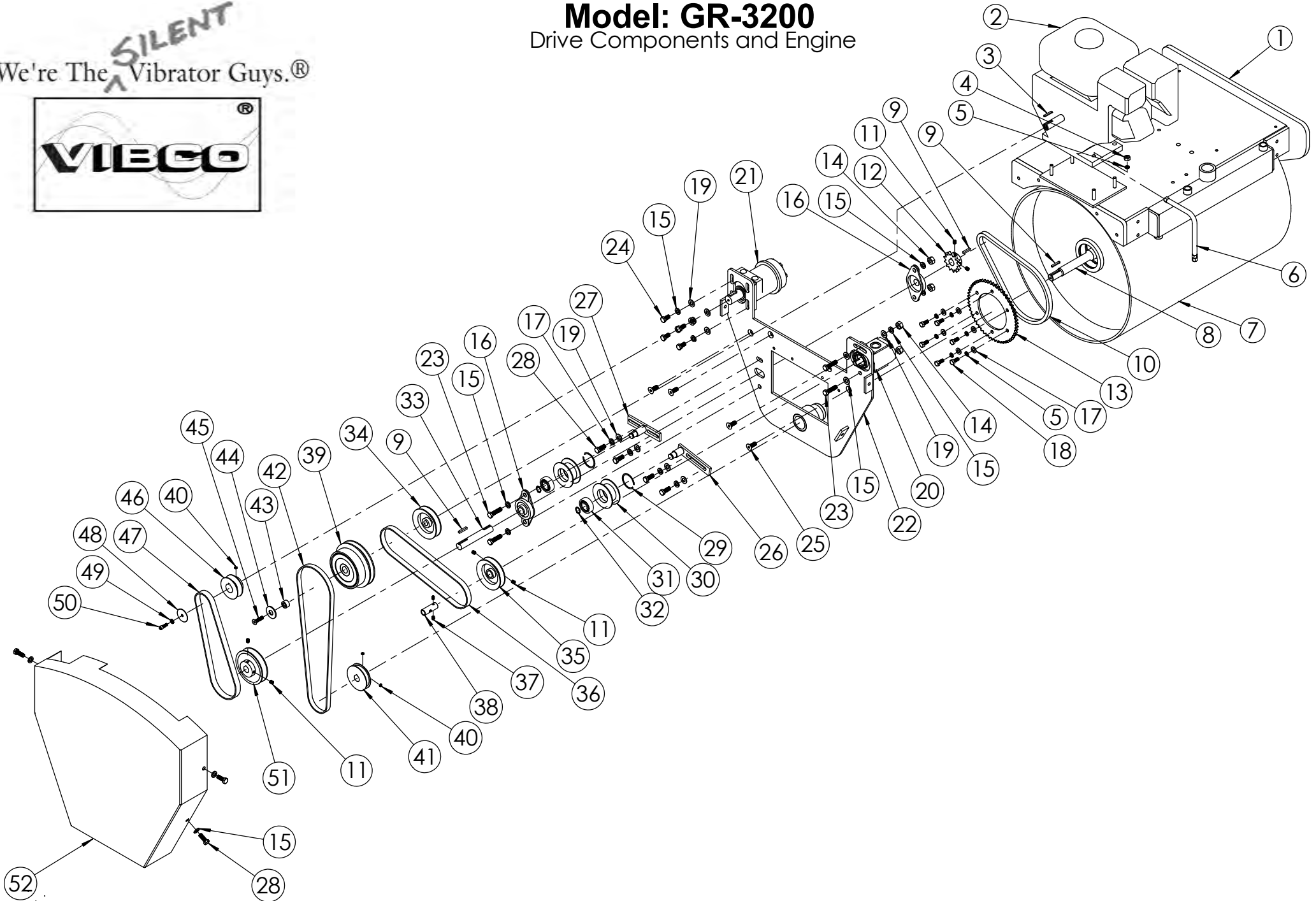
ITEM #	PART #	DESCRIPTION	QTY
1	3/8-24X3/4HH8	SCREW, HEX HEAD CAP GRADE 8	11
2	3/8LWG8	LOCKWASHER GRADE 8	23
3	3/8FWG8	FLAT WASHER SAE GRADE 8	5
4	32GR161	TOP PLATE WELD	1
5	32GR63	IDLE SIDE PLATE BOTTOM BLANK	1
6	5000-281	SNAP RING	3
7	16GR58	BEARING	3
8	32GR143	3/8-16 X 3/4 FHCS (UNBRAKO)	16
9	32GR14	IDLE SIDE SHOCK WELD	1
10	J-11729-187	MOUNT : 1-1/2 D. X 1 (100 LB.)	16
11	32GR03	DRUM-BRGHOUSING WELD ASSEMBLY	1
12	32GR07	ECCENTRIC SHAFT	1
13	32GR13	DRIVE SIDE SHOCK WELD	1
14	32GR20	GEAR MACHINING	1
15	5/16FWG8	FLAT WASHER SAE GRADE 8	6
16	5/16LWG8	GRADE 8 LOCKWASHER	6
17	5/16-18X3/4HHG8	SCREW, HEX HEAD CAP GRADE 8	6
18	32GR291	BEARING	1
19	201022	RETAINING RING (3000X-354)	1
20	32GR294	NON DRIVE BEARING HUB ASSEMBLY	1
21	32GR120	BEARING HOUSING	2
22	3/8-16X1HHG8	SCREW, HEX HEAD CAP GRADE 8	12

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# Model: GR-3200

Drive Components and Engine



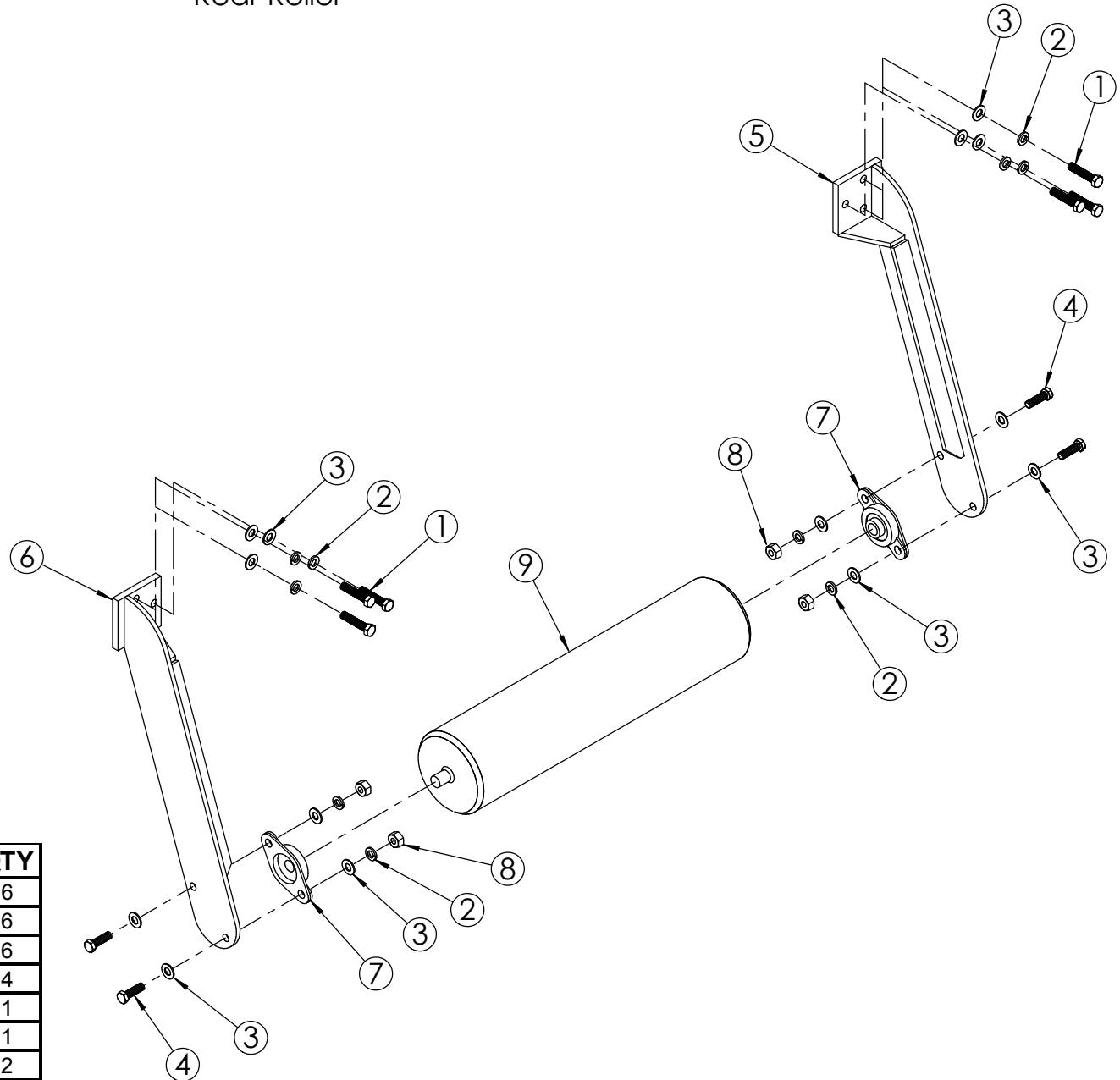
<b>DRIVE COMPONENTS AND ENGINE</b>			
<b>ITEM NO</b>	<b>PART NO</b>	<b>DESCRIPTION</b>	<b>QTY</b>
1	32GR161	Top Plate	1
2	GX-160	Honda Engine	1
3	122084	Key (Clutch)	1
4	5/165-18HN	Hex Nut	4
5	5/16LW	Lock Washer	10
6	HON1010	Drainzit Oil Drain Tube	1
7	32GR03	Drum	1
8	32GR07	Eccentric Shaft	1
9	32GR217	Drive Pulley Key	3
10	32GR159	Drive Chain	3 ft.
11	1/4-20X1/4SS	Socket Set Screw	6
12	32GR88	Small Sprocket	1
13	32GR20	Gear Machined	1
14	3/8-16HN	Hex Nut	4
15	3/8LW	Lock Washer	17
16	32GR25	Pillow Block Machined	2
17	5/16FWG8	Flat Washer Grade 8	6
18	5/16-18X3/4HHG8	Hex Head Bolt Grade 8	6
19	3/8FWG8	Flat Washer Grade 8	12
20	32GR183	Hydraulic Pump	1
21	32GR184	Hydraulic Motor	1
22	32GR95	Drive Side Plate Weld	1
23	3/8-16X1-1/2HHG8	Hex Head Bolt Grade 8	4
24	3/8-16X3/4HHG8	Hex Head Bolt Grade 8	4
25	3/8-16X3/4FH	Flat Head Cap Screw	4
26	32GR167	Idler Pulley Arm Weld	1
27	32GR198	Idler Arm Left	1
28	3/8-16X1HHG8	Hex Head Bolt Grade 8	0
29	UR-168	Retaining Ring	2
30	18RPC072-2	Idler Sheave	2
31	6302LLB-C3	Ball Bearing	2
32	5100-59	Snap Ring	2
33	32GR65	Shaft (Sprocket and Pulley)	1
34	32GR139	Pulley 3-1/2OD 3/4in Bore	1
35	32GR140	Pulley 3-1/2OD 1/2in Bore	1
36	9295	Gates XL Green Stripe	1
37	10-32X1/4SS	Socket Set Screw	2
38	32GR199	Hydraulic Pump Extension Sleeve	1
39	32GR165	Clutch	1
40	5/16-18X3/8SS	Socket Set Screw	3
41	32GR194	Drive Pulley	1
42	9405	Gates XL Green Stripe	1
43	18VR043	Clutch Spacer	1
44	1/2FW	Flat Washer	1
45	5/16-24X1-1/4FH	Flat Head Cap Screw	1
46	32GR237	Pulley 2-1/2OD 1in Bore	1
47	32GR280	V-Belt	1
48	1/4X1-1/2	Fender Washer	1
49	1/4LW	Lock Washer	1
50	1/4-28X1SHCS	Socket Head Cap Screw	1
51	32GR236	Pulley 4OD 3/4in Bore	
52	32GR111	Belt Guard Bend and Weld	1

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# Model: GR-3200

Rear Roller



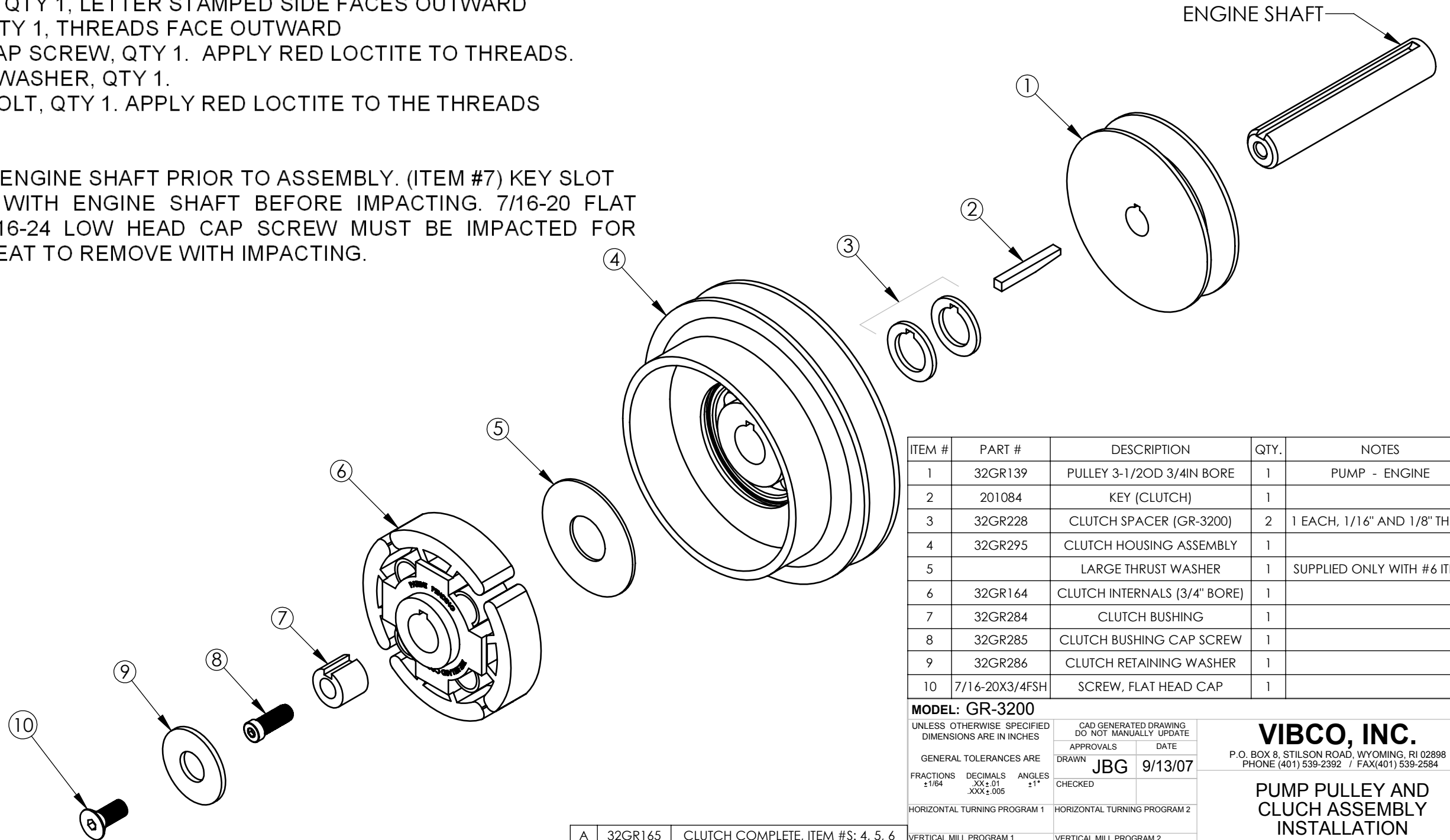
ITEM NO	PART NO	DESCRIPTION	QTY
1	3/8-16X1HHG8	HEX HEAD BOLT GRADE 8	6
2	3/8LW	LOCK WASHER	6
3	3/8FWG8	FLAT WASHER GRADE 8	6
4	3/8-16X1-1/2HH8	HEX HEAD BOLT GRADE 8	4
5	32GR64	RIGHT ROLLER ARM	1
6	32GR62	LEFT ROLLER ARM	1
7	FYT-5/8	PILLOW BLOCK	2
8	3/8-16HN	HEX NUT	4
9	32GR19	REAR ROLLER ASSEMBLY	1

**INSTALL IN THIS ORDER**

1. 3-1/2" OD STEEL PULLEY, QTY 1, FLAT SIDE FACES OUTWARD
2. 3/16" KEY 1-17/32" LONG, TAPERED END INSIDE OF STEEL PULLEY TAPER FACING DOWN, QTY 1
3. 3/16" KEYED ARBOR SHIM, QTY 2, ONE 1/8" THICK AND ONE 1/16" THICK. OUTER CLUTCH HOUSING MUST SPIN FREELY AND HAVE NO CONTACT WITH STEEL PULLEY.
4. OUTER CLUTCH HOUSING, QTY 1, BEARING SIDE FACES STEEL PULLEY
5. LARGE THRUST WASHER, QTY1
6. CLUTCH INTERNALS, QTY 1, LETTER STAMPED SIDE FACES OUTWARD
7. CLUTCH BUSHING, QTY 1, THREADS FACE OUTWARD
8. 5/16-24 LOW HEAD CAP SCREW, QTY 1. APPLY RED LOCTITE TO THREADS.
9. CLUTCH RETAINING WASHER, QTY 1.
10. 7/16-20 FLAT HEAD BOLT, QTY 1. APPLY RED LOCTITE TO THE THREADS

NOTE: (ALUMINUM PULLEY DESIGN ONLY) IF 1/8" THICK NON-KEYED SPACER IS PRESENT BETWEEN THE ALUMINUM PULLEY AND THE ENGINE BLOCK, PLEASE DISCARD IT BEFORE MOUNTING NEW STYLE STEEL PUMP PULLEY AND CLUTCH ASSEMBLY.

**NOTE:** USE ANTI-SEAZE ON ENGINE SHAFT PRIOR TO ASSEMBLY. (ITEM #7) KEY SLOT MUST BE INDEXED WITH ENGINE SHAFT BEFORE IMPACTING. 7/16-20 FLAT HEAD BOLT AND 5/16-24 LOW HEAD CAP SCREW MUST BE IMPACTED FOR TIGHTENING. USE HEAT TO REMOVE WITH IMPACTING.



ITEM #	PART #	DESCRIPTION	QTY.	NOTES
1	32GR139	PULLEY 3-1/2OD 3/4IN BORE	1	PUMP - ENGINE
2	201084	KEY (CLUTCH)	1	
3	32GR228	CLUTCH SPACER (GR-3200)	2	1 EACH, 1/16" AND 1/8" THICK
4	32GR295	CLUTCH HOUSING ASSEMBLY	1	
5		LARGE THRUST WASHER	1	SUPPLIED ONLY WITH #6 ITEM
6	32GR164	CLUTCH INTERNALS (3/4" BORE)	1	
7	32GR284	CLUTCH BUSHING	1	
8	32GR285	CLUTCH BUSHING CAP SCREW	1	
9	32GR286	CLUTCH RETAINING WASHER	1	
10	7/16-20X3/4FSH	SCREW, FLAT HEAD CAP	1	

**MODEL: GR-3200**

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CAD GENERATED DRAWING DO NOT MANUALLY UPDATE	
GENERAL TOLERANCES ARE		APPROVALS	DATE
FRACTIONS ±1/64	DECIMALS .XX ±.01	DRAWN <b>JBG</b>	9/13/07
ANGLES .XXX ±.005	±1°	CHECKED	
HORIZONTAL TURNING PROGRAM 1	HORIZONTAL TURNING PROGRAM 2		
VERTICAL MILL PROGRAM 1	VERTICAL MILL PROGRAM 2		
MANUAL FIXTURE	DO NOT SCALE DRAWING		

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**PUMP PULLEY AND  
CLUTCH ASSEMBLY  
INSTALLATION**

A	32GR165	CLUTCH COMPLETE, ITEM #S: 4, 5, 6
B	32GR169	RETRO FIX KIT, ITEM #S: 6, 7, 8, 9, 10
C	32GR293	32GR165 AND 32GR169 COMBINED

DWG. NO.	<b>SD-9036</b>	SIZE	<b>B</b>	REV.	
SCALE	1:2	SHEET	1	OF	1