

Form No.
909860
Revision B

1640

Forage Box



PARTS MANUAL

GEHL® AGRICULTURE

Introduction

When ordering service parts, specify the correct part number, full description, quantity required, the unit model number and serial number.

The model number and serial number for this unit are on a decal located on the left side of the box frame just forward of the chain reduction drives. “Right” and “left” are determined from a position standing at the rear of the unit and looking toward the direction of travel.

GEHL Company reserves the right to make changes or improvements in the design or construction of any part of the unit without incurring the obligation to install such changes on any previously delivered units.

Refer to the abbreviations table located on this page for the various fastener descriptions. Standard attaching hardware torque values are also provided on the inside back cover.

In the exploded view parts list, Reference Numbers may have additional information following the Reference Number.

Also, a number inside a hexagon will be the torque value required, in foot pounds, on the associated Reference Number. Items shown in the parts list that do not have Reference Numbers are shown for reference purposes only and are NOT available for purchase.

Unless otherwise specified, all cap screws or bolts are Grade 5, cadmium plated; hexagon nuts for Grade 5 screws or bolts are Grade B; hexagon nuts for other screws or bolts are Grade A.

NOTE: *The following abbreviations may be used herein:*

| | |
|---|----------------------------------|
| A/R | - As Required |
| ASSD | - Assembled |
| ASSY | - Assembly |
| CB | - Carriage Bolt |
| CCW | - Counterclockwise |
| CP | - Cotter Pin |
| CS | - Cap Screw (Hexagon Head) |
| CTR | - Center |
| CW | - Clockwise |
| DEG | - Degree |
| DIA | - Diameter |
| FCS | - Flanged Cap Screw |
| FHMS | - Flat Head Machine Screw |
| FL | - Flanged |
| FLN | - Flanged Lock Nut (Hexagon) |
| FLS | - Flanged Lock Screw (Hexagon) |
| FW | - Flat Washer |
| GA | - Gauge |
| GR | - Grade |
| HD | - Hard or Head |
| HN | - Hex Nut |
| INCL | - Includes |
| JT | - Joint |
| LG | - Large |
| LN | - Lock Nut |
| LW | - Lock Washer |
| LT | - Left |
| M | - Metric |
| MM/mm | - Millimeter |
| NF | - National Fine |
| PB | - Plow Bolt |
| PTO | - Power Take Off |
| RHMS | - Round Head Machine Screw |
| RPM | - Revolutions Per Minute |
| RT | - Right |
| SERR | - Serrated |
| SHCS | - Socket Head Cap Screw |
| SHSS | - Socket Head Set Screw |
| SN | - Serial Number or Slotted Nut |
| SQ | - Square |
| T | - Tooth or Teeth |
| TFS | - Thread Forming Screw |
| THMS | - Truss Head Machine Screw |
| THRD | - Thread |
| WLDMT | - Weldment |
| # | - Number |
|  | - Torque required in foot pounds |

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CHAPTER 1

DECAL LOCATIONS

GENERAL INFORMATION

Decal location information is provided to assist in the proper selection and application of new decals, in the event the original decals become damaged or the machine is repainted. Refer to the listing for the illustration reference number, part number, description and quantity of each decal provided in the kit. Refer to the appropriate illustrations for replacement locations.

NOTE: Refer to the SAFETY chapter of the Operator's Manual for the specific information provided on the various safety decals furnished in the decal kits.

To ensure proper selection of the correct replacement decals, compare the various location photographs to your machine before starting to refinish the unit. Then circle each pictured decal (applicable to your machine) while checking off its part number in the listing. After you have verified all the decals needed for replacement, place any unneeded decals aside for disposal.

NEW DECAL APPLICATION

Surfaces MUST be free from dirt, dust, grease and other foreign material before applying the new decal. To apply, remove the smaller portion of the decal backing paper and apply this part of the exposed adhesive backing to the clean surface while maintaining proper position and alignment. Peel the other portion of the backing paper off slowly while applying hand pressure to smooth out decal surface.



CAUTION

ALWAYS observe safety precautions on decals. If decals become damaged, or if the unit is repainted, replace the decals. If repainting, BE SURE that ALL decals from the kits that apply to your machine are affixed to your unit.

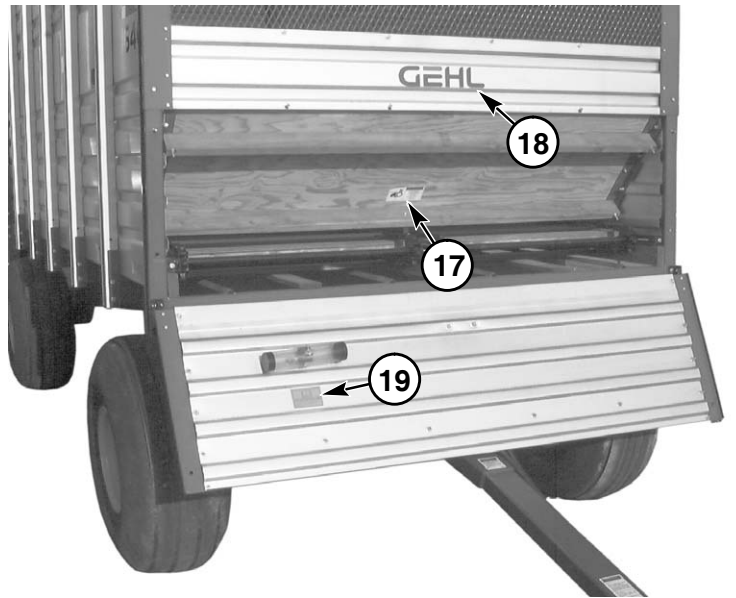
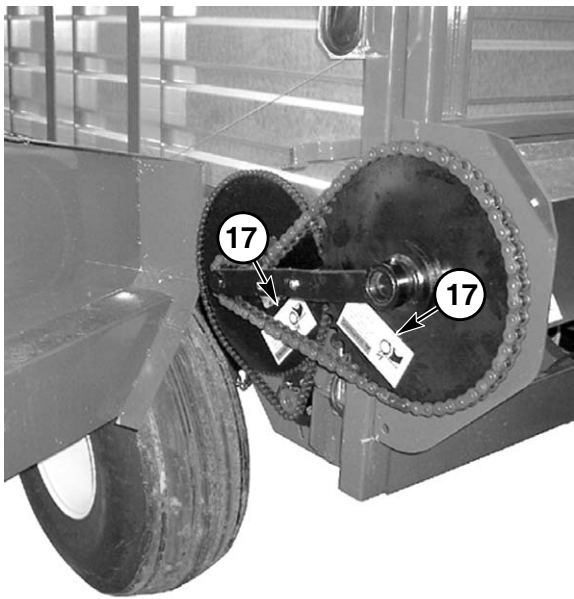
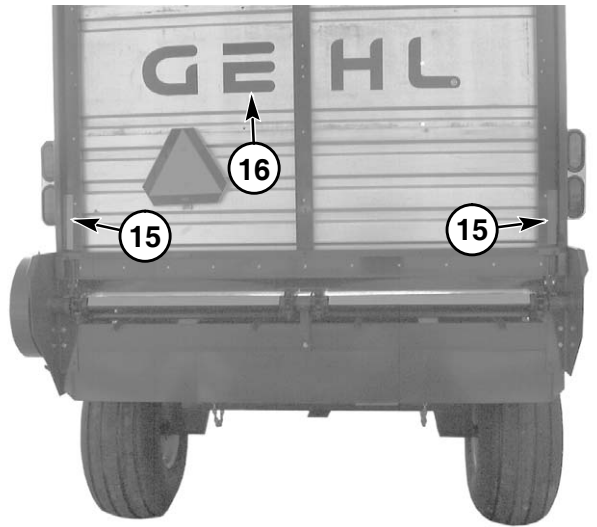
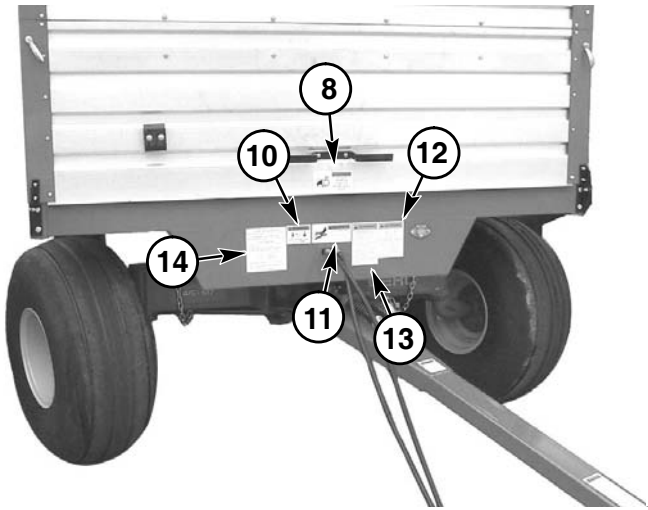
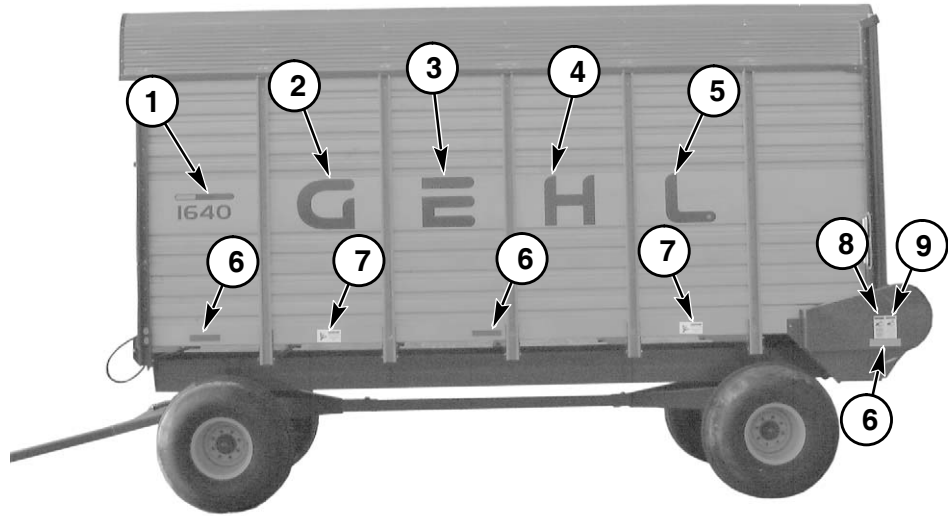
PAINT NOTICE

Use this list to order paint for refinishing:
906315 One Gal. AG Red
902872 One Qt. Light Grey
906316 6 (12 oz. Spray Cans) AG Red
902874 6 (12 oz. Spray Cans) Light Grey

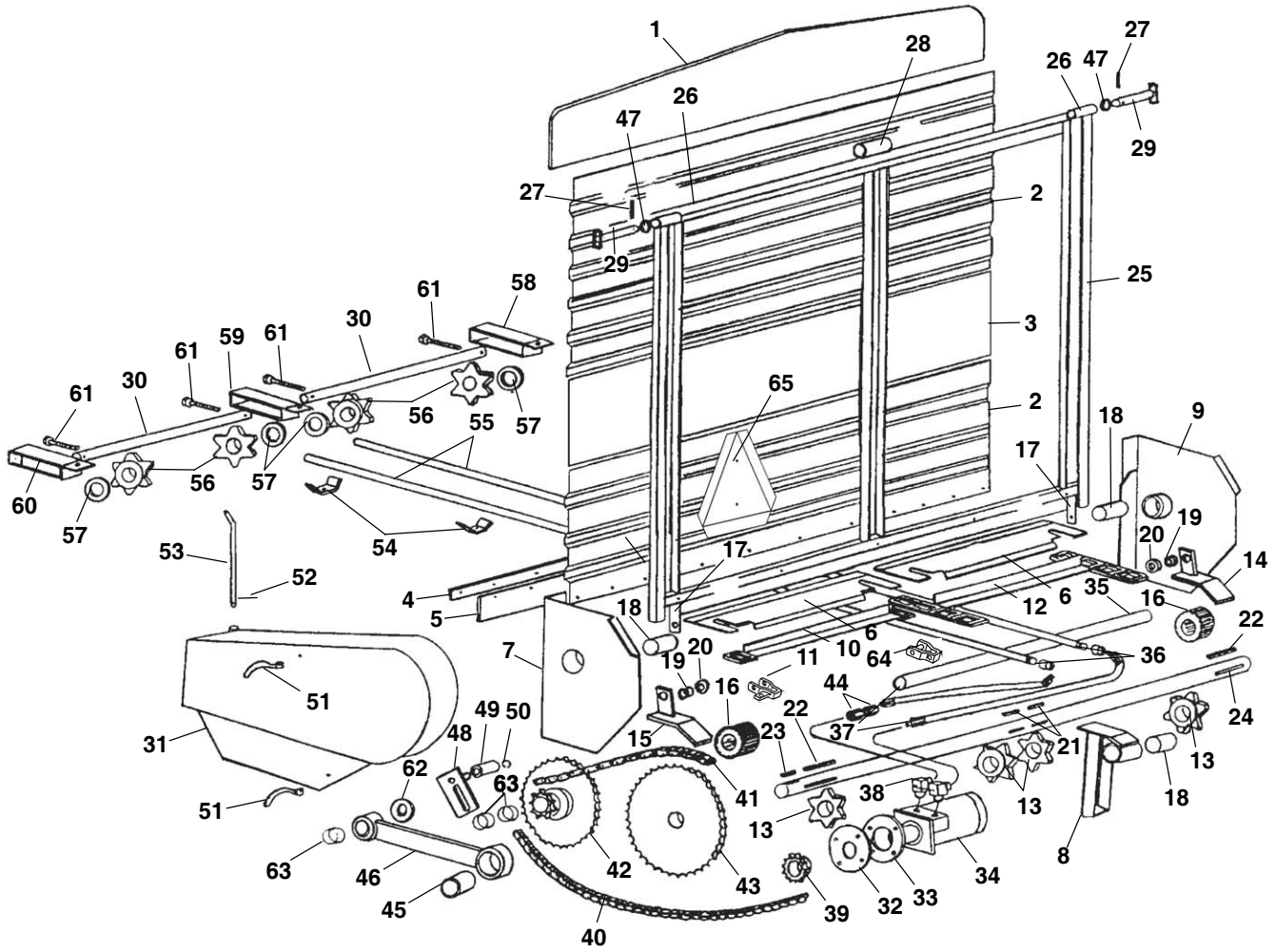
The decal set number for the 1640 Forage Box is 170506. The set includes the following:

Ref. Part

| No. | No. | Description and Quantity |
|-----|--------|--|
| 1 | 170317 | 1640 Label (2 Places) |
| 2 | 094920 | Decal - "G" (2 Places) |
| 3 | 094921 | Decal - "E" (2 Places) |
| 4 | 094922 | Decal - "H" (2 Places) |
| 5 | 094923 | Decal - "L" (2 Places) |
| 6 | 145217 | Amber Reflector (6 Places) |
| 7 | 093444 | WARNING - Moving Parts (4 Places) |
| 8 | 163957 | WARNING - Do Not Remove Shields (2 Places) |
| 9 | 170534 | WARNING - Do Not Clean |
| 10 | 170531 | WARNING - Keep Children Away |
| 11 | 170532 | WARNING - Stay Clear of Hydraulic Lines |
| 12 | 093367 | WARNING - Read Operator's Manual |
| 13 | 093373 | WARNING - Before Inspecting |
| 14 | 170533 | Decal - Field Operation |
| 15 | 145216 | Red Reflector (2 Places) |
| 16 | 170357 | Decal - GEHL |
| 17 | 170520 | WARNING - Do Not Operate (3 Places) |
| 18 | 119661 | Decal - GEHL |
| 19 | 093366 | Decal - Manual Location |



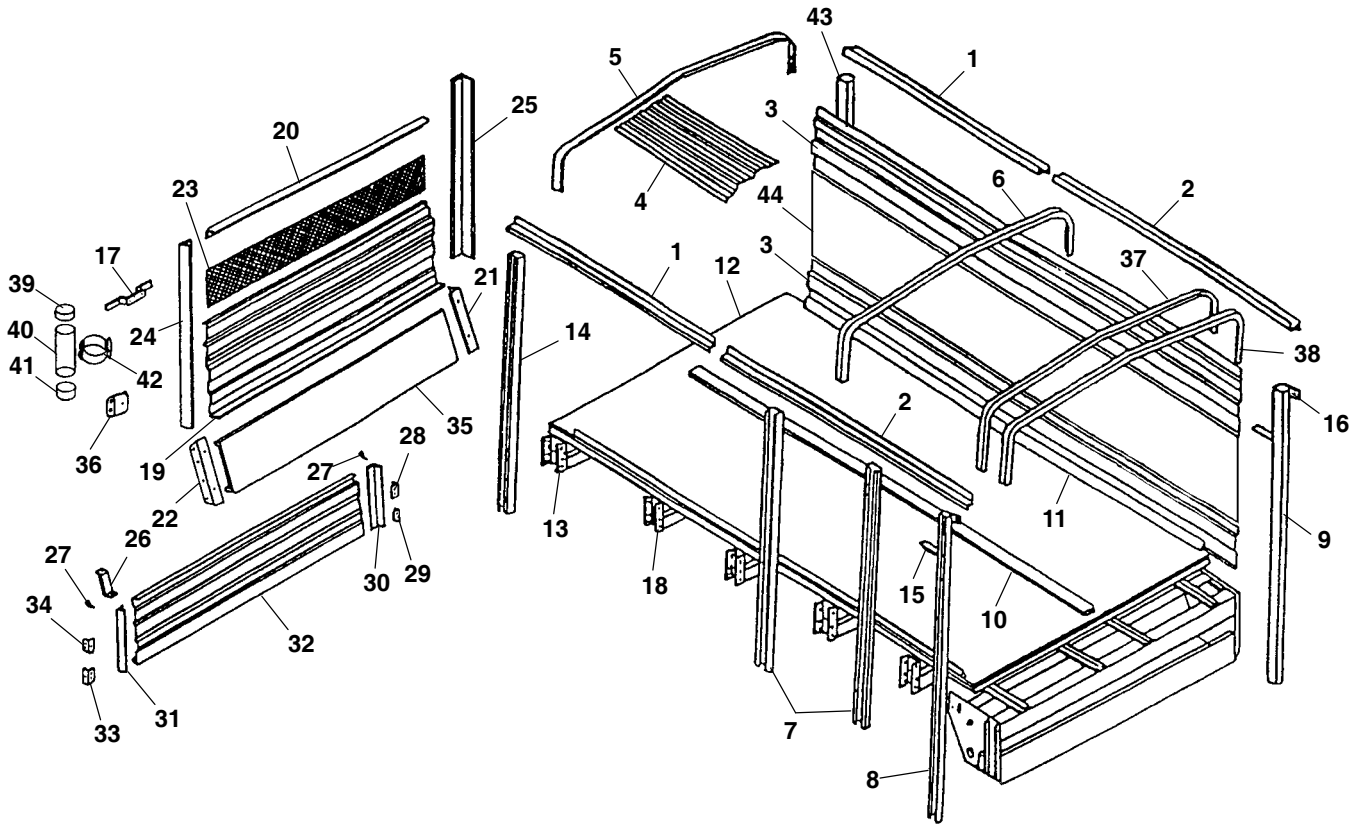
1640 - REAR UNLOAD ASSEMBLY



1640 - REAR UNLOAD ASSEMBLY

| Ref. No. | Part No. | Description | Qty. Req. | Ref. No. | Part No. | Description | Qty. Req. |
|----------|----------|---------------------------------------|-----------|----------|----------|-----------------------------------|-----------|
| 1 | 166388 | TOP PANEL | 1 | 32 | 166400 | HYDRAULIC MOTOR MOUNT | 1 |
| 2 | 166372 | BACK DOOR STEEL | 2 | 33 | 166399 | HYDRCLC MOTOR MOUNT SPACER ... | 1 |
| 3 | 166373 | BACK DOOR CENTER (FLAT) STEEL .. | 1 | 34 | 049073 | HYDRAULIC MOTOR | 1 |
| 4 | 166703 | STRAP | 1 | 35 | 166326 | IDLER SHAFT | 1 |
| 5 | 166376 | RUBBER SEAL | 1 | 36 | 660027 | 1/2 PIPE COUPLER | 2 |
| 6 | 166390 | DRIVE SHAFT PANEL | 2 | 37 | 166109 | 1/2 HOSE X 60 | 2 |
| 7 | 166392 | LH DRIVE SHAFT MOUNT | 1 | 38 | 058654 | 1/2 STREET ELBOW | 2 |
| 8 | 166393 | CENTER BEARING MOUNT | 1 | 39 | 166082 | 13T SPROCKET | 1 |
| 9 | 166394 | RH DRIVE SHAFT MOUNT | 1 | 40 | 074879 | ROLLER CHAIN #50 X 90 LINKS | 1 |
| 10 | 166189 | SLAT W/667H PINTLE ATT. LINKS AR | | 41 | 082023 | ROLLER CHAIN #80 X 73 LINKS | 1 |
| | | (18' BOX: 20 PER APRON, 40 TOTAL) | | 42 | 166120 | 84 TOOTH SPROCKET (50A84) | 1 |
| | | (20' BOX: 22 PER APRON, 44 TOTAL) | | 43 | 166119 | 52 TOOTH SPROCKET (80B52) | 1 |
| 11 | 058620 | LINK/ATTACHMENT | AR | 44 | 067457 | 1/2 CHECK VALVE | 1 |
| 12 | 166178 | 667H COMPLETE APRON 18' | 2 | 45 | 166880 | BUSHING | 1 |
| | | (190 LINKS PER STRAND) | | 46 | 166401 | DRIVE SHAFT BRACE | 1 |
| | 166391 | 667H COMPLETE APRON 20' | 2 | 47 | 166336 | COLLAR | 2 |
| | | (211 LINKS PER STRAND) | | 48 | 166200 | CHAIN TIGHTENER BRACKET | 1 |
| 13 | 166068 | DRIVE SHAFT SPROCKETS | 4 | 49 | 166203 | ROLLER CHAIN TIGHTENER | 1 |
| 14 | 166377 | LATCH BRACKET-R.H. | 1 | 50 | 166059 | RING/SNAP | 1 |
| 15 | 166378 | LATCH BRACKET-L.H. | 1 | 51 | 166650 | HANDLE NUTS | 2 |
| 16 | 166116 | LATCH SPROCKET | 2 | 52 | 651160 | CP EPSC 5/32X1-1/2 | 1 |
| 17 | 166379 | LATCH PLATE | 2 | 53 | 166320 | HINGE PIN | 1 |
| 18 | 166201 | DRIVE SHAFT BUSHING | 3 | 54 | 166073 | HOSE HOLDER | 4 |
| 19 | 166380 | LATCH PIVOT | 2 | 55 | 166360 | HYDRAULIC PIPE | 2 |
| 20 | 166217 | LATCH WASHER | 2 | 55 | 166322 | HYDRAULIC PIPE 18' | 2 |
| 21 | 056230 | KEY 3/8 SQUARE X 2 LONG | 2 | 56 | 166885 | REAR IDLER SPROCKET | 4 |
| 22 | 166100 | KEY 3/8 SQ. X 4-3/8 | 2 | 57 | 166886 | IDLER SHAFT SPACER | 4 |
| 23 | 166111 | KEY 3/8 X 2-1/4 | 1 | 58 | 166810 | LH REAR IDLER BRACKET | 1 |
| 24 | 166367 | REAR DRIVE SHAFT (STRESSPROOF) | 1 | 59 | 166812 | CENTER IDLER BRACKET | 1 |
| 25 | 166389 | BACK DOOR FRAME WORK | 1 | 60 | 166813 | RH REAR IDLER BRACKET | 1 |
| 26 | 166381 | HINGE PIPE | 2 | 61 | 166084 | CS 1/2-13 X 9-1/2 | 4 |
| 27 | 116353 | SPIRAL PIN | 2 | 62 | 166342 | WASHER | 1 |
| 28 | 166382 | GUARD | 1 | 63 | 166099 | BUSHING 1-1/2 OD X 1-1/4 ID | 1 |
| 29 | 166335 | HINGE PIN | 2 | 64 | 058621 | LINK/PINTLE CHAIN | AR |
| 30 | 166811 | REAR IDLER SHAFT | 2 | 65 | 145235 | SMV MARKER/MOUNTED | 1 |
| 31 | 166402 | REAR DRIVE SHIELD | 1 | | | | |

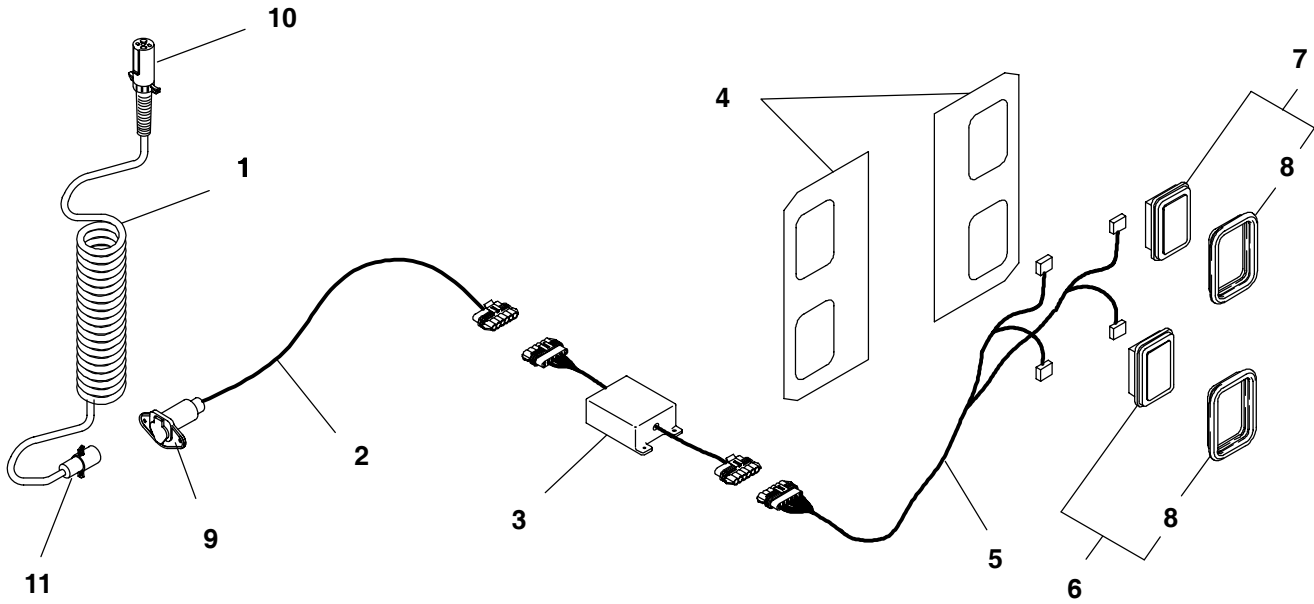
1640 - BOX COMPONENTS



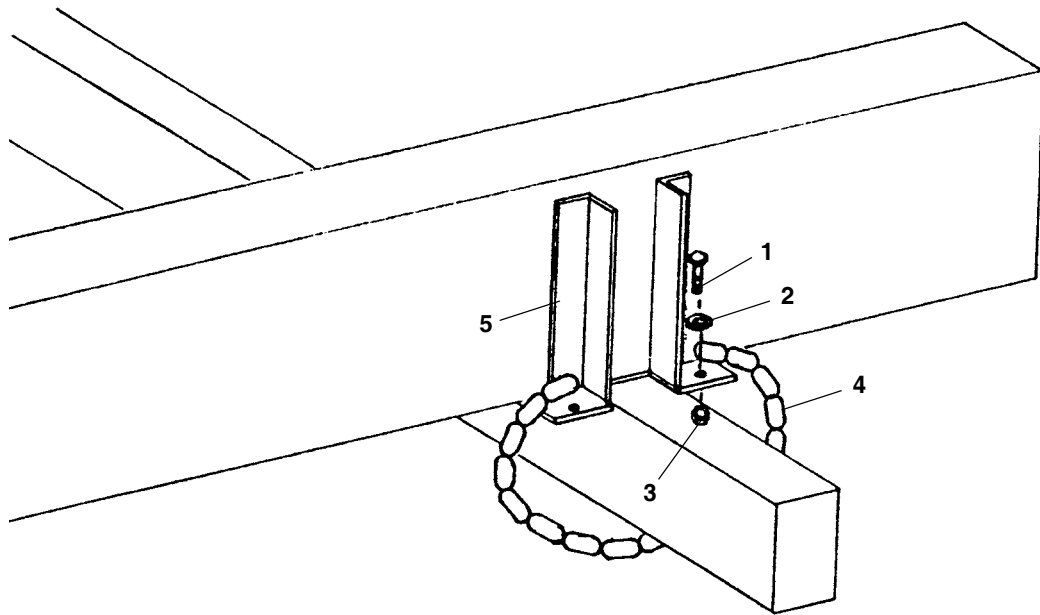
1640 - BOX COMPONENTS

| Ref. No. | Part No. | Description | Qty. Req. | Ref. No. | Part No. | Description | Qty. Req. |
|----------|----------|------------------------------------|-----------|----------|----------|--------------------------------------|-----------|
| 1 | 166618 | ROOF SILL BACK SECTION (18') | 2 | 19 | 166386 | FRONT DOOR BOTTOM STEEL | 1 |
| | 166709 | ROOF SILL BACK SECTION (20') | 2 | 20 | 166375 | TOP RAIL | 1 |
| 2 | 166615 | ROOF SILL FRONT SECTION (18') | 2 | 21 | 166365 | BARGE BOX SHELF ANGLE | 1 |
| | 166710 | ROOF SILL FRONT SECTION (20') | 2 | 22 | 166369 | BARGE BOX SHELF ANGLE | 1 |
| 3 | 166622 | SIDE STEEL 214-1/2 X (18') | 4 | 23 | 166385 | EXPANDED METAL | 1 |
| | 166712 | SIDE STEEL 238-1/2 X (20') | 4 | 24 | 166337 | FRONT LH SIDE PIECE | 1 |
| 4 | 166625 | ROOF STEEL (18') | 6 | 25 | 166338 | FRONT RH SIDE PIECE | 1 |
| | 166714 | ROOF STEEL (20') | 6 | 26 | 166649 | SLANT PANEL BRACE | 1 |
| 5 | 166842 | BRANCH GUARD (18') | 1 | 27 | 166650 | HANDLE NUTS | 2 |
| 6 | 166841 | ROOF SUPPORT (18') | 5 | 28 | 166651 | LH HINGE TOP PIECE | 1 |
| | | ROOF SUPPORT (20') | 6 | 29 | 166652 | RH STAKE HINGE | 1 |
| 7 | 166836 | SIDE STAKE (18') | 10 | 30 | 166653 | TAILGATE LH SIDE PIECE | 1 |
| | | SIDE STAKE (20') | 12 | 31 | 166654 | TAILGATE RH SIDE PIECE | 1 |
| 8 | 166383 | LH REAR STAKE | 1 | 32 | 166655 | TAILGATE STEEL | 1 |
| 9 | 166384 | RH REAR STAKE | 1 | 33 | 166656 | RH HINGE BOTTOM PIECE | 1 |
| 10 | 166631 | APRON CHAIN CENTER SPACER (18') 1 | | 34 | 166657 | RH HINGE TOP PIECE | 1 |
| | 166715 | APRON CENTER SPACER (20') | 1 | 35 | 166374 | FRONT SLANT PANEL | 1 |
| 11 | 166634 | APRON CHAIN SIDE SPACER (18') ... | 2 | 36 | 166093 | HOSE COUPLING HOLDER | 1 |
| | 166716 | APRON SIDE SPACER (20') | 2 | 37 | 166672 | REAR ROOF SUPPORT (HIGH SIDED) 1 | |
| 12 | 166637 | FLOOR ASSEMBLY (18') | 1 | 38 | 166772 | REAR BRANCH GUARD | 1 |
| | 166717 | FLOOR ASSEMBLY (20') | 1 | 39 | 166780 | CAP-NO HOLE | 1 |
| 13 | 166695 | BACK STAKE POCKET | 2 | 40 | 166781 | CLEAR TUBE | 1 |
| 14 | 166837 | LH BACK STAKE | 1 | 41 | 166783 | CAP W/HOLE | 1 |
| 15 | 166387 | BRACE | 2 | 42 | 166935 | CLAMP | 1 |
| 16 | 166333 | DOOR HINGE | 2 | 43 | 166838 | RH BACK STAKE | 1 |
| 17 | 166106 | HOSE HOLDER | 1 | 44 | 166936 | SIDE CENTER PANEL 214-1/2 (18') | 2 |
| 18 | 166694 | STAKE POCKET (18') | 10 | | 166937 | SIDE CENTER PANEL 238-1/2 (20') | 2 |
| | | STAKE POCKET (20') | 12 | | | | |

1640 - LIGHTS



| Ref. No. | Part No. | Description | Qty. Req. | Ref. No. | Part No. | Description | Qty. Req. |
|----------|----------|-----------------------------|-----------|----------|----------|-------------------------------|-----------|
| 1 | 119514 | RETRACTABLE CORD | 1 | 6 | 166199 | RED LIGHT | 2 |
| | | (ACCESSORY OPTION) | | 7 | 166198 | AMBER LIGHT | 2 |
| 2 | 166965 | FRONT HARNESS | 1 | 8 | 166720 | RUBBER LIGHT MOUNT | 4 |
| 3 | 170670 | LIGHTING MODULE | 1 | 9 | 059060 | 4 WAY SOCKET | 1 |
| 4 | 166329 | LIGHT BRACKET | 2 | 10 | 112917 | PLUG/ 7-PIN W/CABLE | 1 |
| 5 | 170673 | Y CONNECT HARNESS | 1 | 11 | 059070 | PLUG/4 WAY TRAILER | 1 |



| Ref. No. | Part No. | Description | Qty. Req. | Ref. No. | Part No. | Description | Qty. Req. |
|----------|----------|--------------------|-----------|----------|----------|--------------------------|-----------|
| 1 | 650453 | CS 1/2X1-1/2 | 8 | 4 | 166726 | 1/4 TIE DOWN CHAIN | 4 |
| 2 | 651148 | FW 1/2 | 8 | 5 | 166727 | TIE DOWN BRACKET | 4 |
| 3 | 071706 | LN T 1/2 | 8 | | | | |

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
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|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| 049073 | 05 | 34 | 166120 | 05 | 42 | 166387 | 07 | 15 | 166716 | 07 | 11 |
| 056230 | 05 | 21 | 166178 | 05 | 12 | 166388 | 05 | 01 | 166717 | 07 | 12 |
| 058620 | 05 | 11 | 166184 | 05 | 11 | 166389 | 05 | 25 | 166720 | 08 | 08 |
| 058621 | 05 | 64 | 166189 | 05 | 10 | 166390 | 05 | 06 | 166726 | 09 | 04 |
| 058654 | 05 | 38 | 166198 | 08 | 07 | 166391 | 05 | 12 | 166727 | 09 | 05 |
| 059060 | 08 | 09 | 166199 | 08 | 06 | 166392 | 05 | 07 | 166772 | 07 | 38 |
| 059070 | 08 | 11 | 166200 | 05 | 48 | 166393 | 05 | 08 | 166780 | 07 | 39 |
| 067457 | 05 | 44 | 166201 | 05 | 18 | 166394 | 05 | 09 | 166781 | 07 | 40 |
| 071706 | 09 | 03 | 166203 | 05 | 49 | 166399 | 05 | 33 | 166781 | 07 | 42 |
| 074879 | 05 | 40 | 166217 | 05 | 20 | 166400 | 05 | 32 | 166783 | 07 | 41 |
| 082023 | 05 | 41 | 166320 | 05 | 53 | 166401 | 05 | 46 | 166810 | 05 | 58 |
| 093366 | 02 | 19 | 166322 | 05 | 55 | 166402 | 05 | 31 | 166811 | 05 | 30 |
| 093367 | 02 | 12 | 166324 | 08 | 04 | 166615 | 07 | 02 | 166812 | 05 | 59 |
| 093373 | 02 | 13 | 166326 | 05 | 35 | 166618 | 07 | 01 | 166813 | 05 | 60 |
| 093444 | 02 | 07 | 166333 | 07 | 16 | 166622 | 07 | 03 | 166836 | 07 | 07 |
| 094920 | 02 | 02 | 166335 | 05 | 29 | 166625 | 07 | 04 | 166837 | 07 | 14 |
| 094921 | 02 | 03 | 166336 | 05 | 47 | 166631 | 07 | 10 | 166838 | 07 | 43 |
| 094922 | 02 | 04 | 166337 | 07 | 24 | 166634 | 07 | 11 | 166841 | 07 | 06 |
| 094923 | 02 | 05 | 166338 | 07 | 25 | 166637 | 07 | 12 | 166842 | 07 | 05 |
| 112917 | 08 | 10 | 166342 | 05 | 62 | 166649 | 07 | 26 | 166880 | 05 | 45 |
| 116353 | 05 | 27 | 166360 | 05 | 55 | 166650 | 05 | 51 | 166885 | 05 | 56 |
| 119514 | 08 | 01 | 166365 | 07 | 21 | 166650 | 07 | 27 | 166886 | 05 | 57 |
| 119661 | 02 | 18 | 166367 | 05 | 24 | 166651 | 07 | 28 | 166936 | 07 | 44 |
| 145216 | 02 | 15 | 166369 | 07 | 22 | 166652 | 07 | 29 | 166937 | 07 | 44 |
| 145217 | 02 | 06 | 166372 | 05 | 02 | 166652 | 07 | 29 | 166937 | 07 | 44 |
| 163957 | 02 | 08 | 166373 | 05 | 03 | 166653 | 07 | 30 | 166965 | 08 | 02 |
| 166059 | 05 | 50 | 166374 | 07 | 35 | 166654 | 07 | 31 | 170317 | 02 | 01 |
| 166068 | 05 | 13 | 166375 | 07 | 20 | 166655 | 07 | 32 | 170357 | 02 | 16 |
| 166073 | 05 | 54 | 166376 | 05 | 05 | 166656 | 07 | 33 | 170520 | 02 | 17 |
| 166082 | 05 | 39 | 166377 | 05 | 14 | 166657 | 07 | 34 | 170531 | 02 | 10 |
| 166084 | 05 | 61 | 166378 | 05 | 15 | 166672 | 07 | 37 | 170532 | 02 | 11 |
| 166093 | 07 | 36 | 166379 | 05 | 17 | 166694 | 07 | 18 | 170533 | 02 | 14 |
| 166099 | 05 | 63 | 166380 | 05 | 19 | 166695 | 07 | 13 | 170534 | 02 | 09 |
| 166100 | 05 | 22 | 166381 | 05 | 26 | 166703 | 05 | 04 | 170670 | 08 | 03 |
| 166106 | 07 | 17 | 166382 | 05 | 28 | 166709 | 07 | 01 | 170671 | 08 | 05 |
| 166109 | 05 | 37 | 166383 | 07 | 08 | 166710 | 07 | 02 | 650453 | 09 | 01 |
| 166111 | 05 | 23 | 166384 | 07 | 09 | 166712 | 07 | 03 | 651148 | 09 | 02 |
| 166116 | 05 | 16 | 166385 | 07 | 23 | 166714 | 07 | 04 | 651160 | 05 | 52 |
| 166119 | 05 | 43 | 166386 | 07 | 19 | 166715 | 07 | 10 | 660027 | 05 | 36 |

NOTES

TORQUE SPECIFICATIONS

NOTE: Use these torque values when tightening **GEHL** hardware (excluding: Locknuts and Self-tapping, Thread Forming and Sheet Metal Screws) unless specified otherwise.

All torque values are in Lb-Ft except those marked with an * which are Lb-In
(For metric torque value Nm, multiply Lb-Ft value by 1.355 or Lb-In value by 0.113)

| Unified National Thread | Grade 2  | | Grade 5  | | Grade 8  | |
|----------------------------|---|------------|--|------------|--|------------|
| | Dry | Lubed | Dry | Lubed | Dry | Lubed |
| 8-32 8-36 | 19* 20* | 14* 15* | 30* 31* | 22* 23* | 41* 43* | 31* 32* |
| 10-24 10-32 | 27* 31* | 21* 23* | 43* 49* | 32* 36* | 60* 68* | 45* 51* |
| 1/4-20 1/4-28 | 66* 76* | 50* 56* | 9 10 | 75* 86* | 12 14 | 9 10 |
| 5/16-18 5/16-24 | 11 12 | 9 | 17 19 | 13 14 | 25 | 18 20 |
| 3/8-16 3/8-24 | 20 23 | 15 17 | 30 35 | 23 25 | 45 50 | 35 |
| 7/16-14 7/16-20 | 32 36 | 24 27 | 50 55 | 35 40 | 70 80 | 55 60 |
| 1/2-13 1/2-20 | 50 55 | 35 40 | 75 90 | 55 65 | 110 120 | 80 90 |
| 9/16-12 9/16-18 | 70 80 | 55 60 | 110 120 | 80 90 | 150 170 | 110 130 |
| 5/8-11 5/8-18 | 100 110 | 75 85 | 150 180 | 110 130 | 220 240 | 170 180 |
| 3/4-10 3/4-16 | 175 200 | 130 150 | 260 300 | 200 220 | 380 420 | 280 320 |
| 7/8-9 7/8-14 | 170 180 | 125 140 | 430 470 | 320 360 | 600 660 | 460 500 |
| 1-8 1-14 | 250 270 | 190 210 | 640 710 | 480 530 | 900 1000 | 680 740 |
| Metric Course Thread | Grade 8.8  | | Grade 10.9  | | Grade 12.9  | |
| | Dry | Lubed | Dry | Lubed | Dry | Lubed |
| M6-1 | 8 | 6 | 11 | 8 | 13.5 | 10 |
| M8-1.25 | 19 | 14 | 27 | 20 | 32.5 | 24 |
| M10-1.5 | 37.5 | 28 | 53 | 39 | 64 | 47 |
| M12-1.75 | 65 | 48 | 91.5 | 67.5 | 111.5 | 82 |
| M14-2 | 103.5 | 76.5 | 145.5 | 108 | 176.5 | 131 |
| M16-2 | 158.5 | 117.5 | 223.5 | 165.5 | 271 | 200 |

GEHL®

Gehl Company 143 Water Street, P.O. Box 179, West Bend, WI 53095-0179 U.S.A.
(www.gehl.com)