

**GEHL**®

Form No.  
918180  
Revision A  
October 2007

# Compact Excavator Attachments



# Parts Manual

# INTRODUCTION

When ordering service parts, specify the correct part number, full description, quantity required and the unit model number and serial number. For your safety and continued proper operation, use only genuine GEHL service parts.

The model and serial number for the unit are on a tag located on a panel on the front of the cab.

"Right" and "left" are determined from a position sitting on the operator's seat and facing forward.

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 special parts descriptions. Standard attaching hardware torque values are also provided near the back of this manual. Metric torque values shown in the illustrations are in Newton-meters and are converted to foot-pounds by multiplying by 0.738.

Specific reference numbers, indicating a complete assembly, are circled in some illustrations. A small bag, pictured in some illustrations, indicates a seal kit (seals, o-rings, etc.). In the exploded view parts list, additional information may follow the Reference Number.

Unless otherwise specified, all cap screws and bolts are Grade 8.8, cadmium or zinc plated.

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

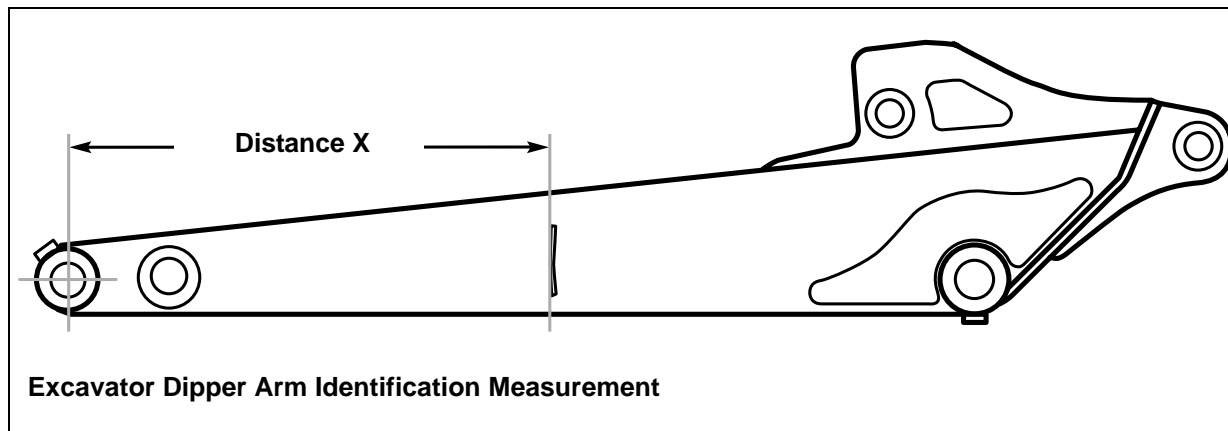
ASSD .....	Assembled
ASY .....	Assembly
ASSY .....	Assembly
AR.....	As Required
CB .....	Carriage Bolt
CP .....	Cotter Pin
CS .....	Cap Screw (Hexagon Head)
CYL .....	Cylinder
DIA .....	Diameter
FHCS .....	Flat Head Cap Screw
GR.....	Grade
HB .....	Hex Bolt
HLN .....	Hex Lock Nut
HN.....	Hex Nut
HP .....	High Pressure
HYD.....	Hydraulic
INS .....	Insert
LH.....	Left Hand
LN .....	Lock Nut
LT .....	Left
LW .....	Lock Washer
M.....	Meter or Meters
MM/mm .....	Millimeter
NPT .....	National Pipe Threaded
NSS .....	Not Sold Separately
RH.....	Right Hand
RT .....	Right
SHCS .....	Socket Head Cap Screw
SLTD.....	Slotted
SN .....	Serial Number or Slotted Nut
SQ .....	Square
W/ .....	With

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# NOTES

# DIPPER ARM IDENTIFICATION



Swivel buckets require different length hydraulic hoses depending upon the length of the dipper arm. Use the diagram and table on this page to determine dipper arm length.

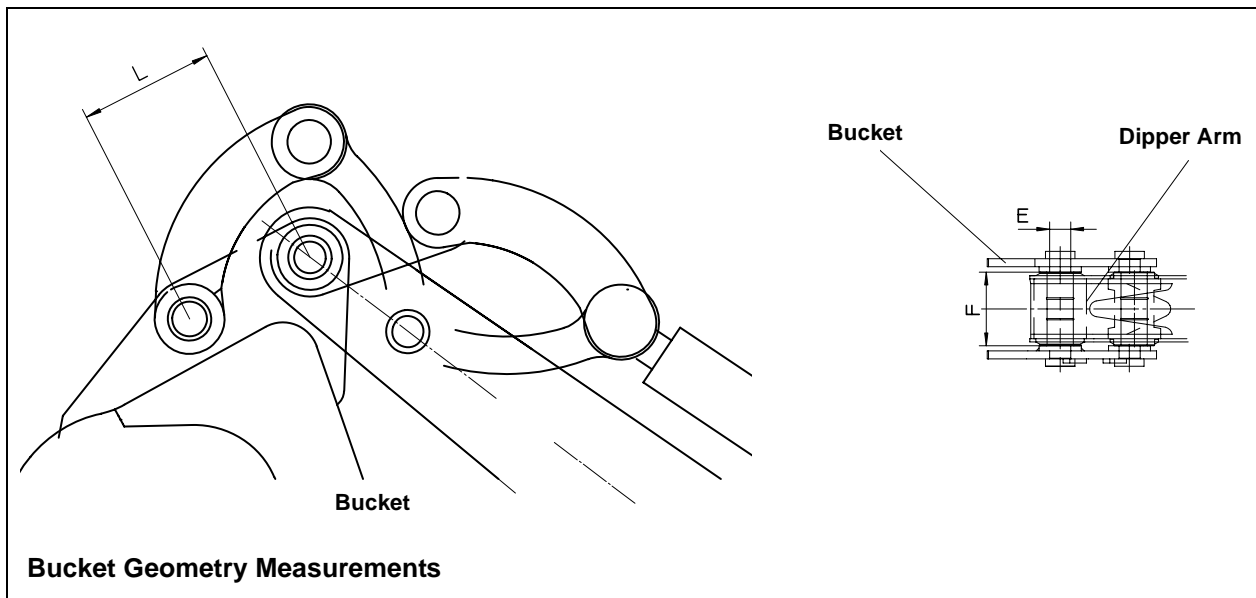
## EARLIER DIPPER ARMS

Excavator Model Number	Short Dipper Arm Distance X	Long Dipper Arm Distance X
153	29-3/4" (755 mm)	29-3/4" (755 mm)
223	32-1/2" (825 mm)	32-1/2" (825 mm)
303	22-5/8" (576 mm)	32-1/2" (826 mm)
353	28" (710 mm)	39-3/4" (1010 mm)
373	28" (710 mm)	39-3/4" (1010 mm)
383Z	35" (890 mm)	44-7/8" (1140 mm)
503Z	39" (990 mm)	48-7/8" (1240 mm)
603	46-1/4" (1175 mm)	58" (1475 mm)
753Z	46-7/8" (1190 mm)	58-5/8" (1490 mm)
803	52-3/4" (1340 mm)	64-1/2" (1640 mm)
12022	51-3/4" (1315 mm)	55-3/4" (1415 mm)

## LATER DIPPER ARMS

Excavator Model Number	Short Dipper Arm Distance X	Long Dipper Arm Distance X
153	29-3/4" (755 mm)	29-3/4" (755 mm)
223	32-1/2" (825 mm)	32-1/2" (825 mm)
353	28" (710 mm)	39-3/4" (1010 mm)
373	28" (710 mm)	39-3/4" (1010 mm)
383Z	35" (890 mm)	44-7/8" (890 mm)
503Z	39" (990 mm)	48-7/8" (990 mm)
603	46-1/4" (1175 mm)	58" (1175 mm)
753Z	46-7/8" (1300 mm)	58-5/8" (1300 mm)
803	52-3/4" (1300 mm)	64-1/2" (1300 mm)
1202	51-3/4" (1315 mm)	55-3/4" (1415 mm)

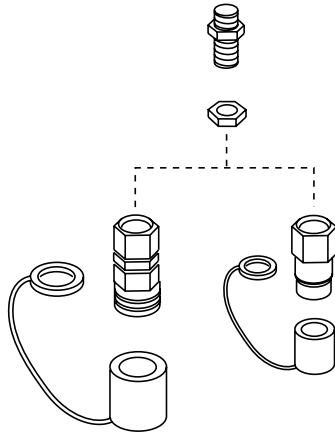
# BUCKET GEOMETRY



Excavator Model Number	E - Pin Diameter	F - Dipper Arm Width	L - Bolt Distance Bucket Carrier
142	1.181" (30 mm)	4.252" (108 mm)	4.656" (108 mm)
152	1.181" (30 mm)	4.252" (108 mm)	4.656" (108 mm)
153	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
192	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
193	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
222	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
223	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
253	1.260" (32 mm)	4.646" (118 mm)	5.098" (129.5 mm)
272	1.575" (40 mm)	5.512" (140 mm)	6.122" (155.5 mm)
292	1.575" (40 mm)	5.512" (140 mm)	6.122" (155.5 mm)
303	1.575" (40 mm)	5.512" (140 mm)	7.087" (180 mm)
342	1.575" (40 mm)	5.512" (140 mm)	6.122" (155.5 mm)
353	1.575" (40 mm)	5.512" (140 mm)	7.087" (180 mm)
373	1.575" (40 mm)	5.512" (140 mm)	7.087" (180 mm)
383Z	1.575" (40 mm)	5.512" (140 mm)	7.087" (180 mm)
373	1.575" (40 mm)	5.512" (140 mm)	7.087" (180 mm)
503Z	1.968" (50 mm)	7.677" (195 mm)	9.291" (236 mm)
502	1.968" (50 mm)	7.677" (195 mm)	9.291" (236 mm)
602	1.968" (50 mm)	7.677" (195 mm)	9.291" (236 mm)
603	1.968" (50 mm)	7.677" (195 mm)	9.291" (236 mm)
652	1.968" (50 mm)	7.677" (195 mm)	9.291" (236 mm)
753Z	2.165" (55 mm)	7.677" (170 mm)	11.811" (300 mm)
802	2.165" (55 mm)	7.677" (170 mm)	11.811" (300 mm)
803	2.165" (55 mm)	7.677" (170 mm)	11.811" (300 mm)
1202	2.362" (60 mm)	8.661" (220 mm)	13.189" (335 mm)

# AUXILIARY HYDRAULIC COUPLER IDENTIFICATION

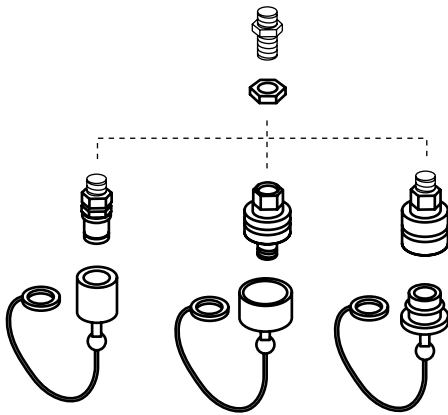
## Newer (Flat-Face) Hydraulic Couplers



The auxiliary hydraulic circuit on recent excavators is equipped with flat-face style quick-couplers of this type.

New attachments which use the auxiliary hydraulic circuit (such as swivel buckets) are equipped with quick-coupler fittings which fit this style.

## Older (Euro-Style) Hydraulic Couplers



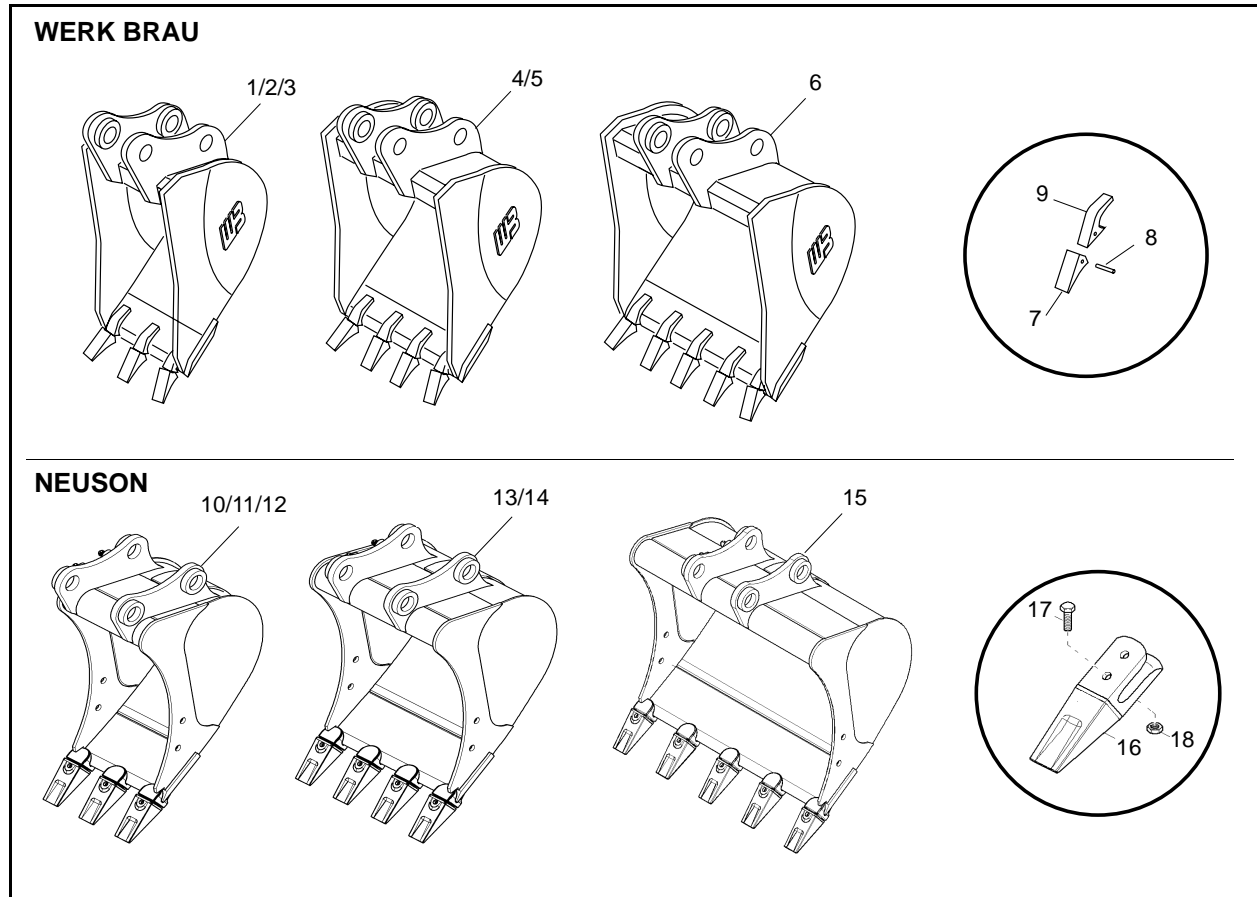
The auxiliary hydraulic circuit on older excavators is equipped with euro-style quick-couplers of this type.

New attachments which use the auxiliary hydraulic circuit (such as swivel buckets) are equipped with flat-faced style quick couplers which do not fit the older euro-style couplers.

When buying new attachments, the euro-style quick-couplers must be replaced with the flat-face style couplers shown above.

# MODELS 142, 152

## General-Purpose Buckets



Ref. No.	Part No.	Description	Capacity.
1	807598*	GENERAL-PURPOSE BUCKET (WERK BRAU) 8" (200 MM)	0.6 FT <sup>3</sup> (0.016 M <sup>3</sup> )
2	807599*	GENERAL-PURPOSE BUCKET (WERK BRAU) 10" (250 MM)	0.8 FT <sup>3</sup> (0.022 M <sup>3</sup> )
3	807600*	GENERAL-PURPOSE BUCKET (WERK BRAU) 12" (300 MM)	1.0 FT <sup>3</sup> (0.028 M <sup>3</sup> )
4	807601*	GENERAL-PURPOSE BUCKET (WERK BRAU) 16" (400 MM)	1.2 FT <sup>3</sup> (0.033 M <sup>3</sup> )
5	807602*	GENERAL-PURPOSE BUCKET (WERK BRAU) 20" (500 MM)	1.5 FT <sup>3</sup> (0.042 M <sup>3</sup> )
6	807603*	GENERAL-PURPOSE BUCKET (WERK BRAU) 24" (600 MM)	1.8 FT <sup>3</sup> (0.005 M <sup>3</sup> )
7	207074	BUCKET TOOTH (WERK BRAU)	AS REQ.
8	207084	PIN (WERK BRAU)	AS REQ.
8	207079	SHANK (WERK BRAU)	AS REQ.

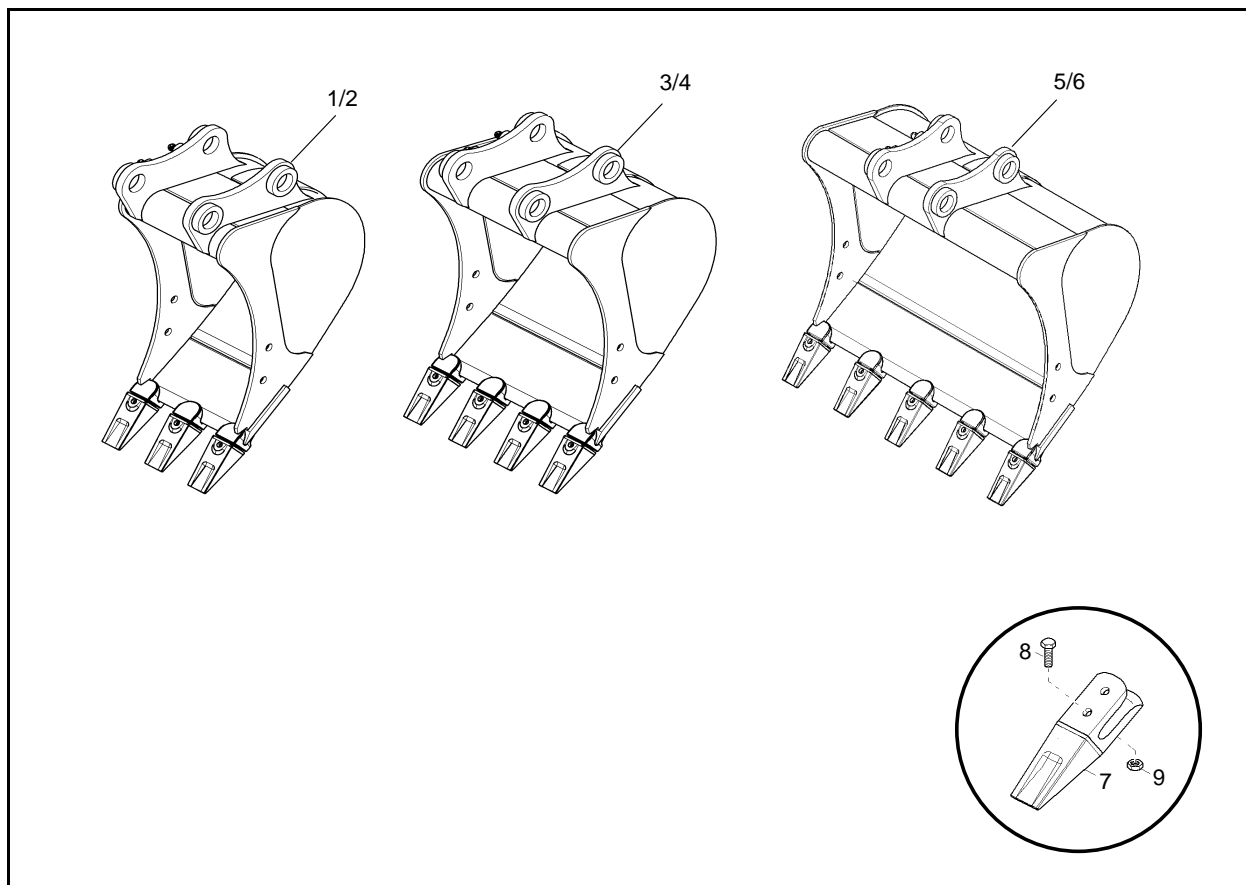
Ref. No.	Part No.	Description	Capacity.
10	807598N	GENERAL-PURPOSE BUCKET (NEUSON) 8" (200 MM)	0.6 FT <sup>3</sup> (0.016 M <sup>3</sup> )
11	807599N	GENERAL-PURPOSE BUCKET (NEUSON) 10" (250 MM)	0.8 FT <sup>3</sup> (0.022 M <sup>3</sup> )
12	807600N	GENERAL-PURPOSE BUCKET (NEUSON) 12" (300 MM)	1.0 FT <sup>3</sup> (0.028 M <sup>3</sup> )
13	807601N	GENERAL-PURPOSE BUCKET (NEUSON) 16" (400 MM)	1.2 FT <sup>3</sup> (0.033 M <sup>3</sup> )
14	807602N	GENERAL-PURPOSE BUCKET (NEUSON) 20" (500 MM)	1.5 FT <sup>3</sup> (0.042 M <sup>3</sup> )
15	807603N	GENERAL-PURPOSE BUCKET (NEUSON) 24" (600 MM)	1.8 FT <sup>3</sup> (0.005 M <sup>3</sup> )
16	162466	BUCKET TOOTH (NEUSON)	AS REQ.
17	651409	BOLT ((NEUSON)	AS REQ.
18	651450	NUT (NEUSON)	AS REQ.

\*Not an orderable part number



# MODEL 253

## General-Purpose Buckets

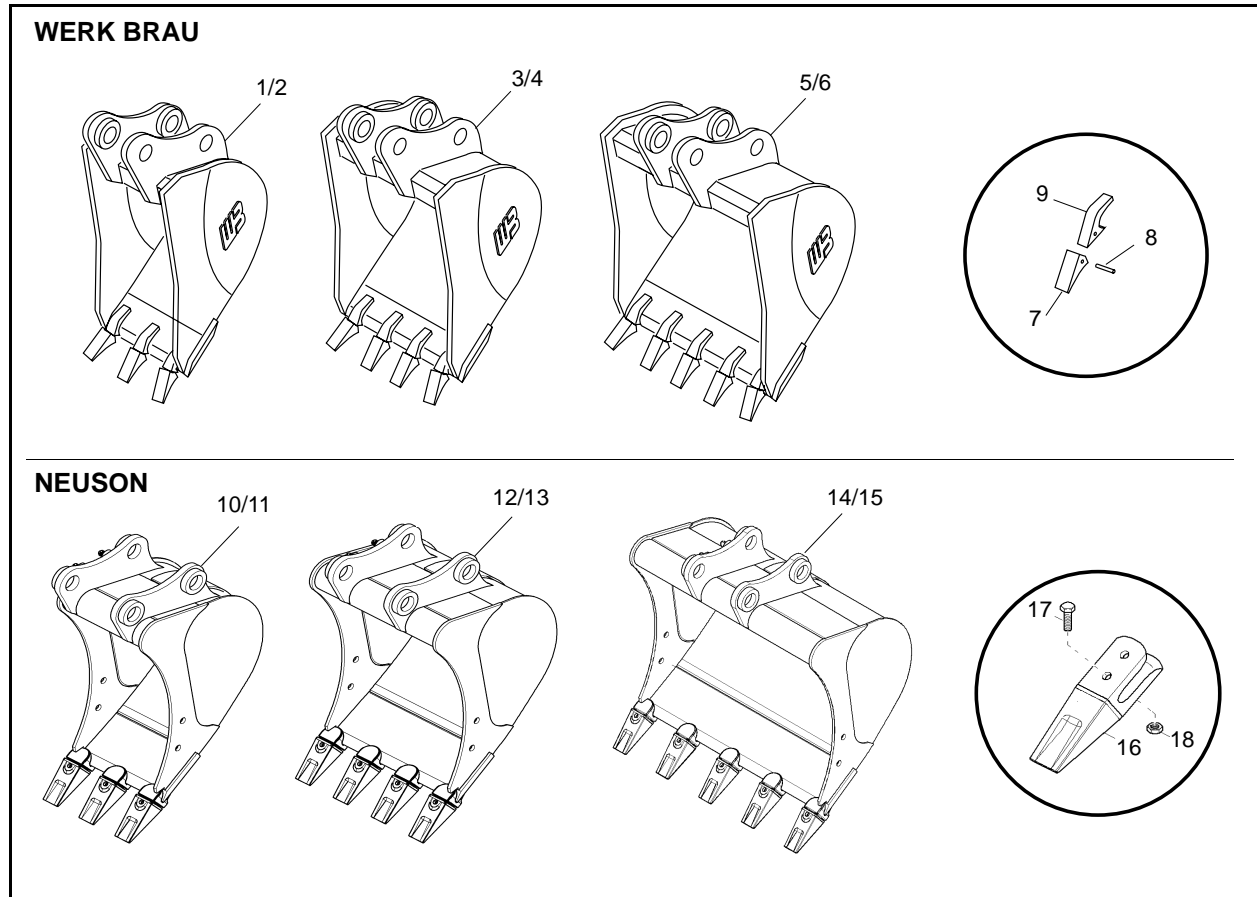


Ref. No.	Part No.	Description	Capacity.
1	808675	GENERAL-PURPOSE BUCKET (NEUSON) 10" (250 MM)	1.3 FT <sup>3</sup> (0.037 M <sup>3</sup> )
2	808676	GENERAL-PURPOSE BUCKET (NEUSON) 12" (300 MM)	2.4 FT <sup>3</sup> (0.067 M <sup>3</sup> )
3	808677	GENERAL-PURPOSE BUCKET (NEUSON) 16" (400 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
4	808678	GENERAL-PURPOSE BUCKET (NEUSON) 20" (500 MM)	4.7 FT <sup>3</sup> (0.133 M <sup>3</sup> )
5	808679*	GENERAL-PURPOSE BUCKET (NEUSON) 24" (600 MM)	6.4 FT <sup>3</sup> (0.181 M <sup>3</sup> )
6	808680*	GENERAL-PURPOSE BUCKET (NEUSON) 28" (700 MM)	3.8 FT <sup>3</sup> (0.107 M <sup>3</sup> )
7	162466	BUCKET TOOTH	AS REQ.
8	162024	BOLT	AS REQ.
9	656050	NUT	AS REQ.

\*Not an orderable part number

# MODELS 272, 292, 342, 362

## General-Purpose Buckets



Ref. No.	Part No.	Description	Capacity.
1*	808395**	GENERAL-PURPOSE BUCKET (WERK BRAU) 8" (200 MM)	1.4 FT <sup>3</sup> (0.040 M <sup>3</sup> )
2*	807613	GENERAL-PURPOSE BUCKET (WERK BRAU) 12" (300 MM)	2.4 FT <sup>3</sup> (0.067 M <sup>3</sup> )
3*	807614**	GENERAL-PURPOSE BUCKET (WERK BRAU) 16" 400 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
4*	807615**	GENERAL-PURPOSE BUCKET (WERK BRAU) 20" (500 MM)	4.7 FT <sup>3</sup> (0.133 M <sup>3</sup> )
5*	807616**	GENERAL-PURPOSE BUCKET (WERK BRAU) 24" (600 MM)	6.4 FT <sup>3</sup> (0.181 M <sup>3</sup> )
6*	807617**	GENERAL-PURPOSE BUCKET (WERK BRAU) 28" (700 MM)	8.8 FT <sup>3</sup> (0.250 M <sup>3</sup> )
7	207074	BUCKET TOOTH (WERK BRAU)	3
8	207084	PIN (WERK BRAU)	3
9	207079	SHANK (WERK BRAU)	3

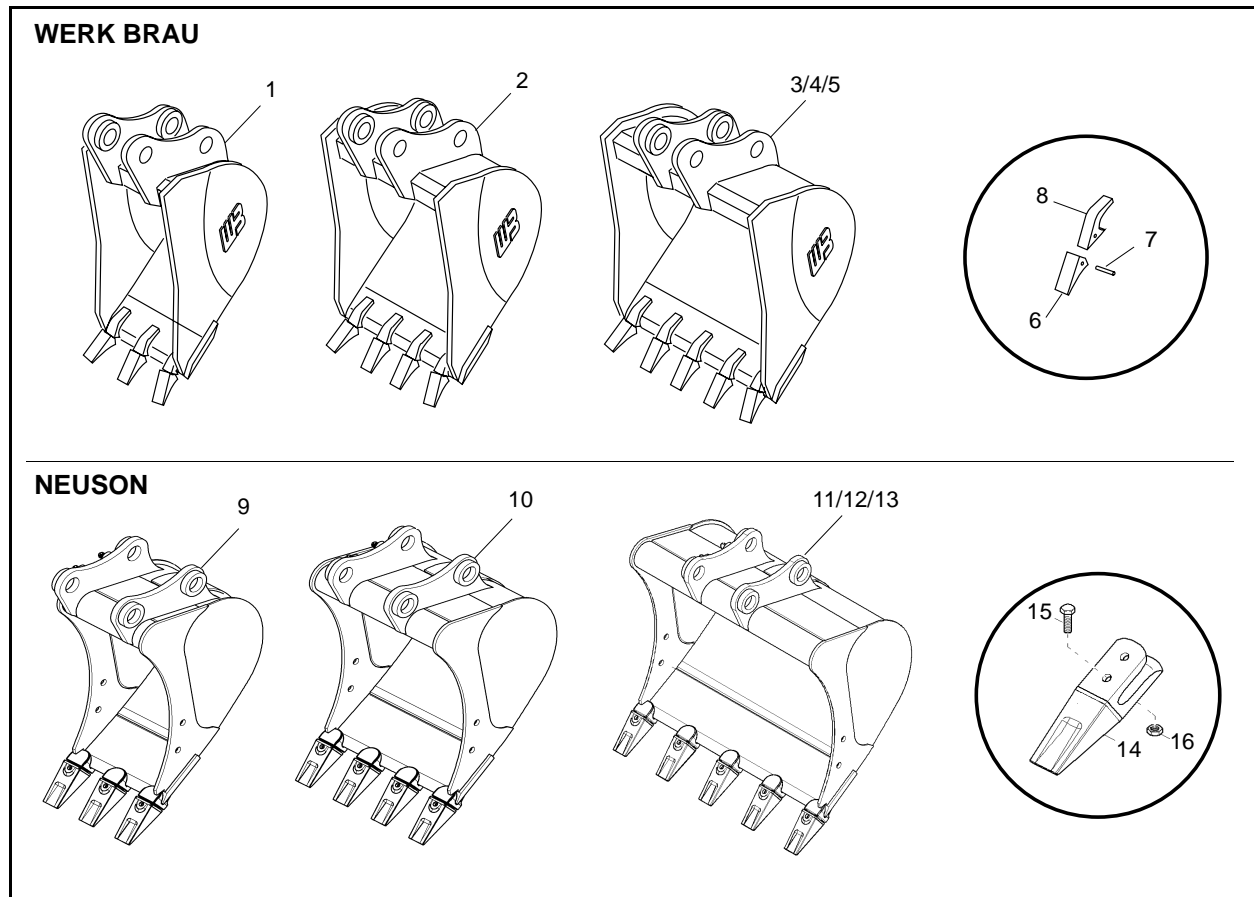
Ref. No.	Part No.	Description	Capacity.
10*	808395N**	GENERAL-PURPOSE BUCKET (NEUSON) 8" (200 MM)	1.4 FT <sup>3</sup> (0.040 M <sup>3</sup> )
11*	807613N	GENERAL-PURPOSE BUCKET (NEUSON) 12" (300 MM)	2.4 FT <sup>3</sup> (0.067 M <sup>3</sup> )
12*	807614N	GENERAL-PURPOSE BUCKET (NEUSON) 16" 400 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
13*	807615N	GENERAL-PURPOSE BUCKET (NEUSON) 20" (500 MM)	4.7 FT <sup>3</sup> (0.133 M <sup>3</sup> )
14*	807616N	GENERAL-PURPOSE BUCKET (NEUSON) 24" (600 MM)	6.4 FT <sup>3</sup> (0.181 M <sup>3</sup> )
15*	807617N	GENERAL-PURPOSE BUCKET (NEUSON) 28" (700 MM)	8.8 FT <sup>3</sup> (0.250 M <sup>3</sup> )
16	162466	BUCKET TOOTH (NEUSON)	AS REQ.
17	651409	BOLT (NEUSON)	AS REQ.
18	651450	NUT (NEUSON)	AS REQ.

\*Requires 2 Connecting links 165731

\*\*Not an orderable part number

# MODELS 753Z, 802, 803

## General-Purpose Buckets



Ref. No.	Part No.	Description	Capacity.
1	807627	GENERAL-PURPOSE BUCKET (WERK BRAU) 12" (300 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
2	807628**	GENERAL-PURPOSE BUCKET (WERK BRAU) 18" (450 MM)	5.1 FT <sup>3</sup> (0.144 M <sup>3</sup> )
3	807629	GENERAL-PURPOSE BUCKET (WERK BRAU) 24" (600 MM)	7.1 FT <sup>3</sup> (0.201 M <sup>3</sup> )
4	807630	GENERAL-PURPOSE BUCKET (WERK BRAU) 30" (750 MM)	9.2 FT <sup>3</sup> (0.260 M <sup>3</sup> )
5	807631**	GENERAL-PURPOSE BUCKET (WERK BRAU) 36" (900 MM)	11.3 FT <sup>3</sup> (0.319 M <sup>3</sup> )
6	207076	BUCKET TOOTH (WERK BRAU)	AS REQ.
7	207084	PIN (WERK BRAU)	AS REQ.
8	207083	SHANK (WERK BRAU)	AS REQ.

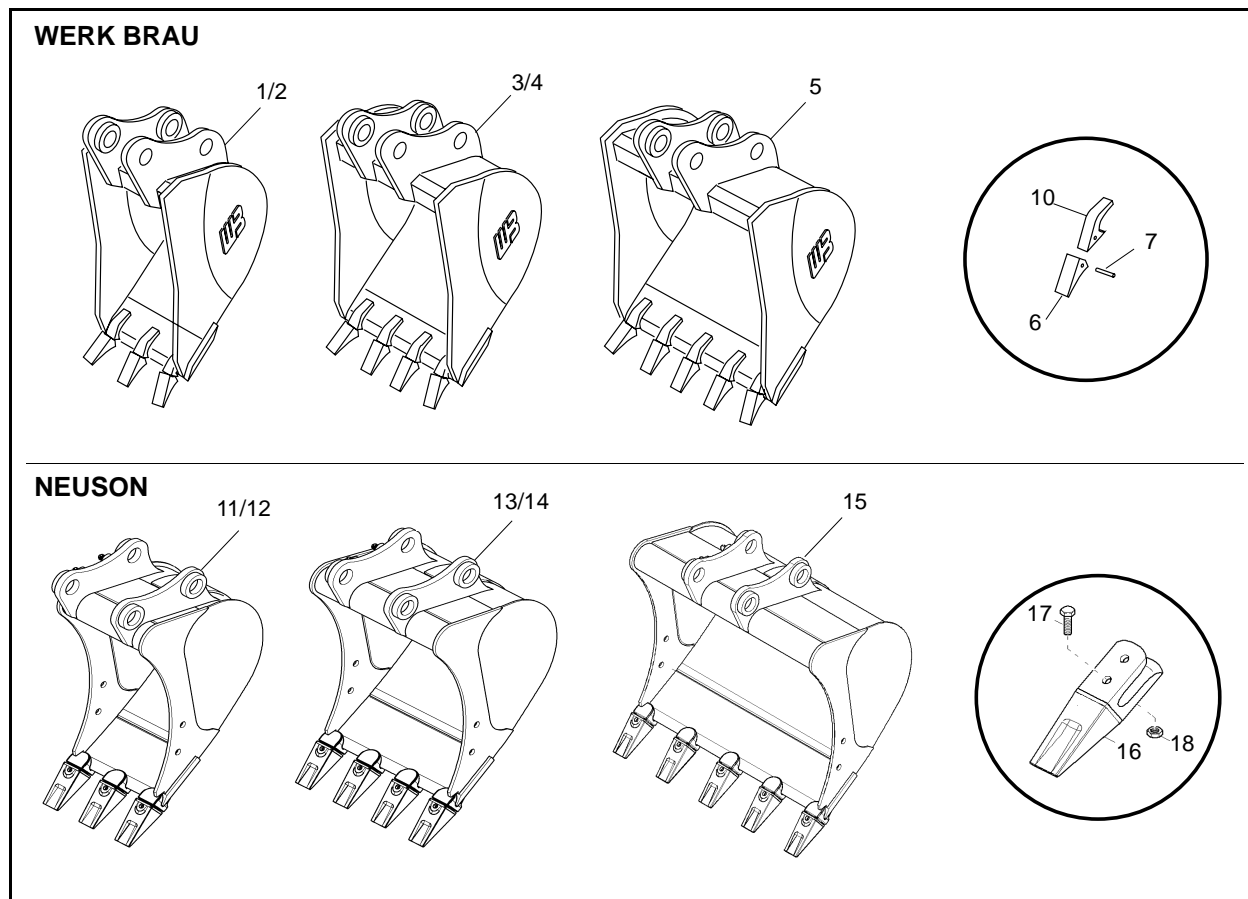
Ref. No.	Part No.	Description	Capacity.
9	807627N	GENERAL-PURPOSE BUCKET (NEUSON) 12" (300 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
10	807628N	GENERAL-PURPOSE BUCKET (NEUSON) 18" (450 MM)	5.1 FT <sup>3</sup> (0.144 M <sup>3</sup> )
11	807629N	GENERAL-PURPOSE BUCKET (NEUSON) 24" (600 MM)	7.1 FT <sup>3</sup> (0.201 M <sup>3</sup> )
12	807630N	GENERAL-PURPOSE BUCKET (NEUSON) 30" (750 MM)	9.2 FT <sup>3</sup> (0.260 M <sup>3</sup> )
13	807631N**	GENERAL-PURPOSE BUCKET (NEUSON) 36" (900 MM)	11.3 FT <sup>3</sup> (0.319 M <sup>3</sup> )
14	162466	BUCKET TOOTH (NEUSON)	AS REQ.
15	651409	BOLT (NEUSON)	AS REQ.
16	651450	NUT (NEUSON)	AS REQ.

\*Use Neuson equivalent for service

\*\*Not an orderable part number

# MODELS 153, 192, 193, 222, 223

## Heavy-Duty Buckets



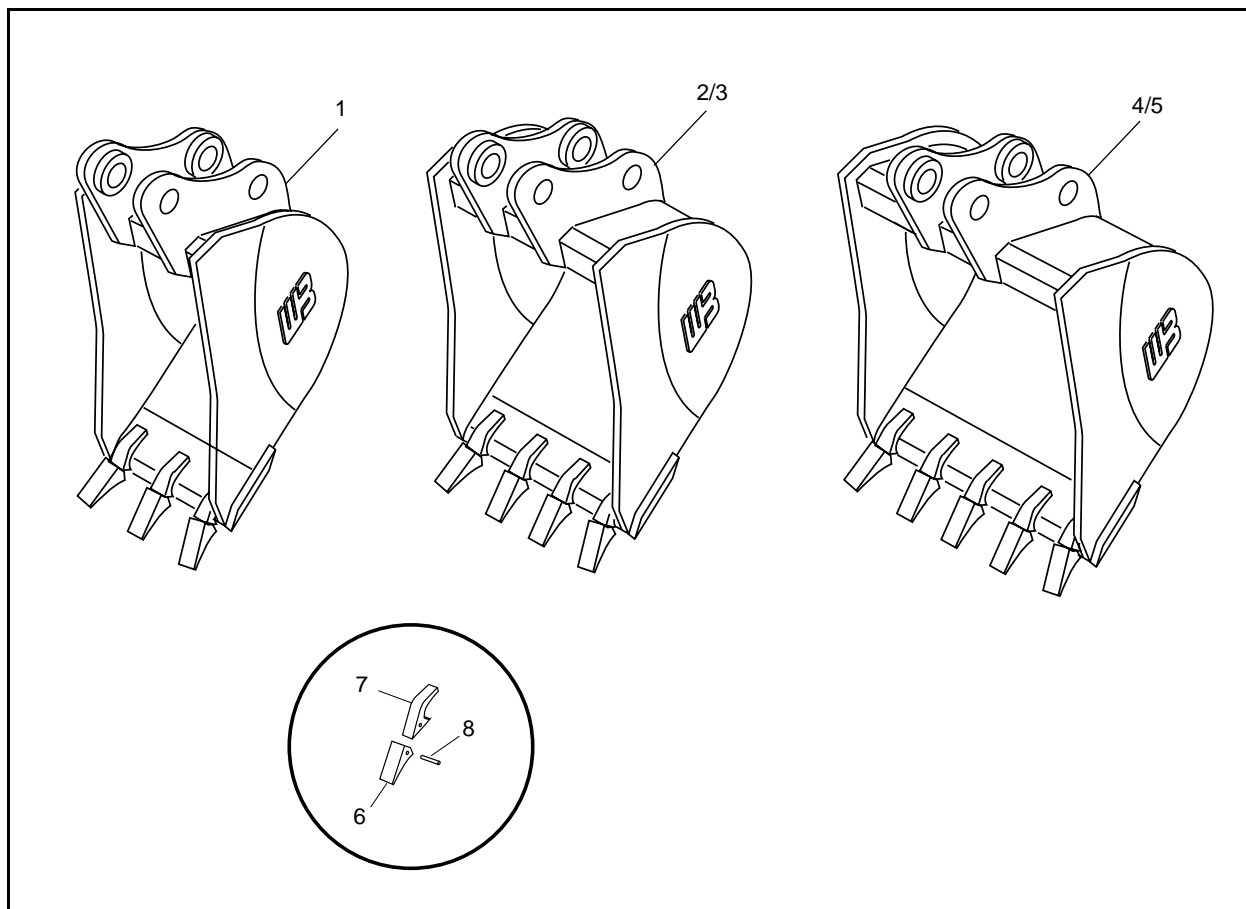
Ref. No.	Part No.	Description	Capacity.
1	807606	HEAVY-DUTY BUCKET (WERK BRAU) 10" (250 MM)	1.1 FT <sup>3</sup> (0.031 M <sup>3</sup> )
2	807607	HEAVY-DUTY BUCKET (WERK BRAU) 12" (300 MM)	1.3 FT <sup>3</sup> (0.037 M <sup>3</sup> )
3	807608	HEAVY-DUTY BUCKET (WERK BRAU) 16" (400 MM)	1.6 FT <sup>3</sup> (0.045 M <sup>3</sup> )
4	807609	HEAVY-DUTY BUCKET (WERK BRAU) 20" (500 MM)	2.3 FT <sup>3</sup> (0.065 M <sup>3</sup> )
5	807610	HEAVY-DUTY BUCKET (WERK BRAU) 24" (600 MM)	2.7 FT <sup>3</sup> (0.076 M <sup>3</sup> )
6	207074	BUCKET TOOTH (WERK BRAU)	AS REQ.
7	207084	ROLL PIN (WERK BRAU)	AS REQ.
8	207079	SHANK (WERK BRAU)	AS REQ.

Ref. No.	Part No.	Description	Capacity.
11	807606N	HEAVY-DUTY BUCKET (NEUSON) 10" (250 MM)	1.1 FT <sup>3</sup> (0.031 M <sup>3</sup> )
12	807607N	HEAVY-DUTY BUCKET (NEUSON) 12" (300 MM)	1.3 FT <sup>3</sup> (0.037 M <sup>3</sup> )
13	807608N	HEAVY-DUTY BUCKET (NEUSON) 16" (400 MM)	1.6 FT <sup>3</sup> (0.045 M <sup>3</sup> )
14	807609N	HEAVY-DUTY BUCKET (NEUSON) 20" (500 MM)	2.3 FT <sup>3</sup> (0.065 M <sup>3</sup> )
15	807610N*	HEAVY-DUTY BUCKET (NEUSON) 24" (600 MM)	2.7 FT <sup>3</sup> (0.076 M <sup>3</sup> )
16	162466	BUCKET TOOTH (NEUSON)	AS REQ.
17	651409	BOLT (NEUSON)	AS REQ.
18	651450	NUT (NEUSON)	AS REQ.

\*Not an orderable part number

# MODELS 303, 353, 373, 383Z

Werk Brau Heavy-Duty Buckets

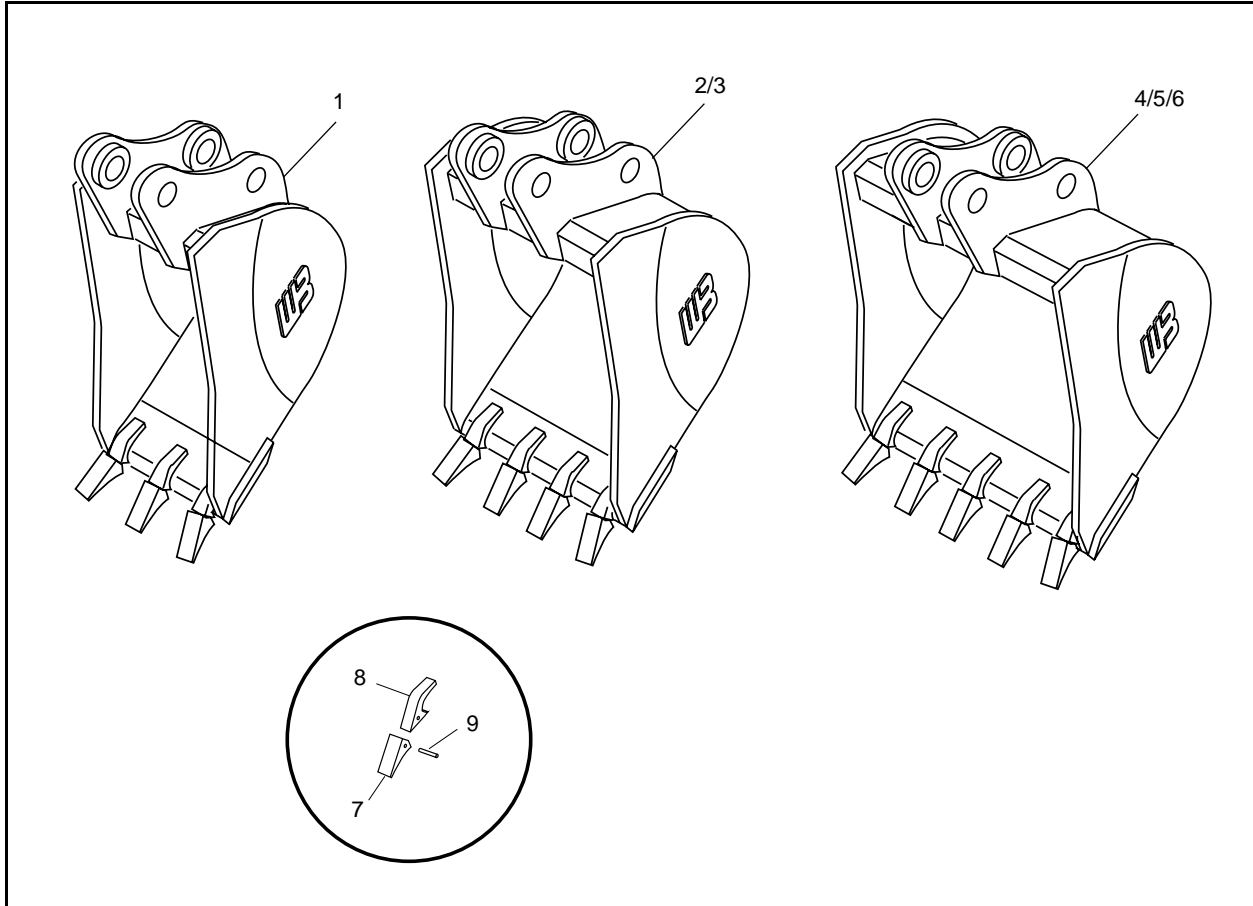


Ref. No.	Part No.	Description	Capacity.
1	808685	HEAVY-DUTY BUCKET 12" (300 MM)	1.8 FT <sup>3</sup> (0.050 M <sup>3</sup> )
2	808686	HEAVY-DUTY BUCKET 16" (400 MM)	2.4 FT <sup>3</sup> (0.067 M <sup>3</sup> )
3	808687	HEAVY-DUTY BUCKET 20" (500 MM)	3.1 FT <sup>3</sup> (0.087 M <sup>3</sup> )
4	808688	HEAVY-DUTY BUCKET 24" (600 MM)	3.8 FT <sup>3</sup> (0.107 M <sup>3</sup> )

Ref. No.	Part No.	Description	Capacity.
5	808689	HEAVY-DUTY BUCKET 28" (700 MM)	4.8 FT <sup>3</sup> (0.136 M <sup>3</sup> )
6	207074	BUCKET TOOTH	AS REQ.
7	207084	PIN	AS REQ.
8	207079	SHANK	AS REQ.

# MODELS 502, 503Z, 602, 652

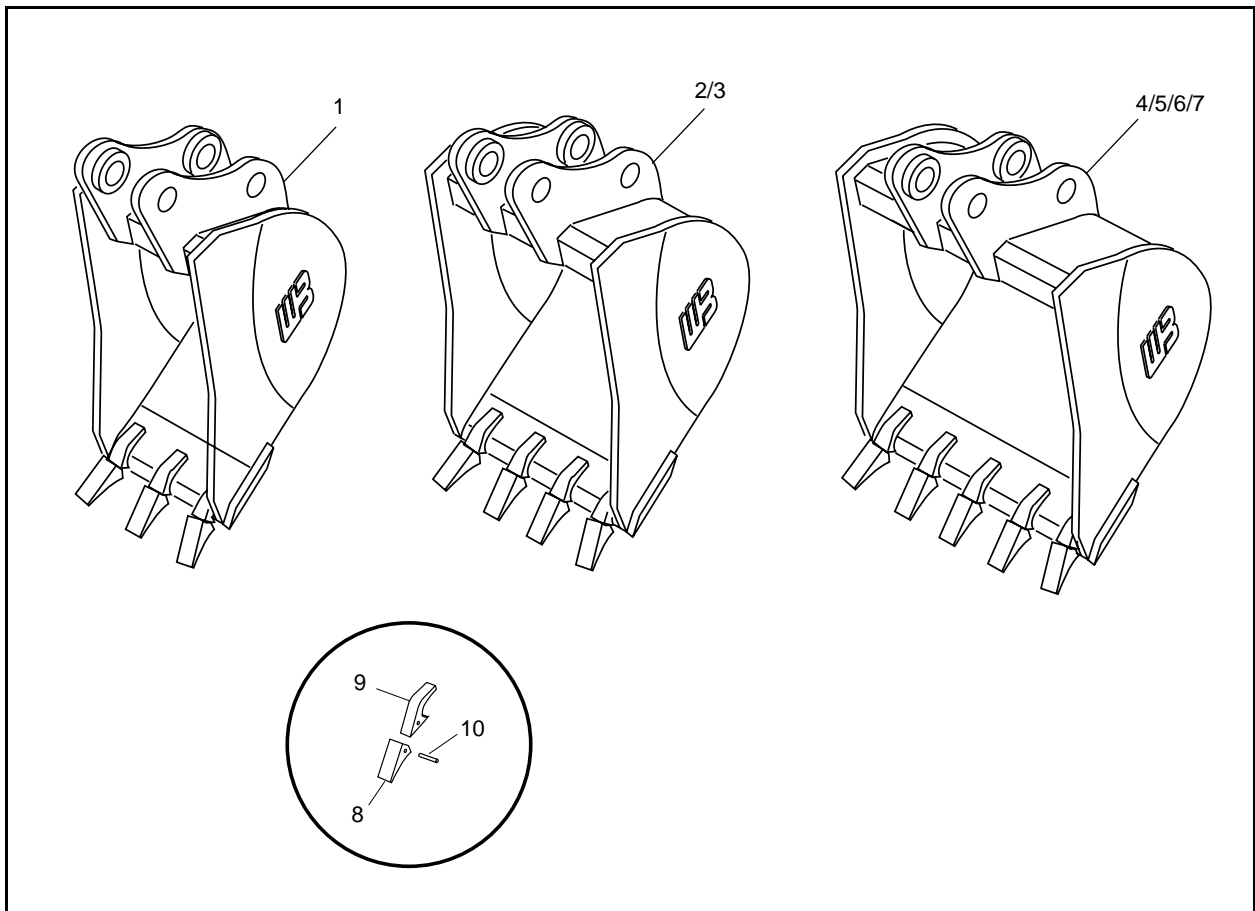
## Werk Brau Heavy-Duty Buckets



Ref. No.	Part No.	Description	Capacity.
1	807620	HEAVY-DUTY BUCKET 10" (250 MM)	2.5 FT <sup>3</sup> (0.070 M <sup>3</sup> )
2	807621	HEAVY-DUTY BUCKET 16" (400 MM)	3.3 FT <sup>3</sup> (0.093 M <sup>3</sup> )
3	807622	HEAVY-DUTY BUCKET 20" (500 MM)	3.7 FT <sup>3</sup> (0.104 M <sup>3</sup> )
4	807623	HEAVY-DUTY BUCKET 24" (600 MM)	6.4 FT <sup>3</sup> (0.181 M <sup>3</sup> )

Ref. No.	Part No.	Description	Capacity.
5	807624	HEAVY-DUTY BUCKET 30" (750 MM)	8.8 FT <sup>3</sup> (0.249 M <sup>3</sup> )
6	809316	HEAVY-DUTY BUCKET 36" (900 MM)	9.8 FT <sup>3</sup> (0.278 M <sup>3</sup> )
7	207074	BUCKET TOOTH	AS REQ.
8	207084	PIN	AS REQ.
9	207079	SHANK	AS REQ.

**MODELS 753Z, 802, 803**  
**Werk Brau Heavy-Duty Buckets**

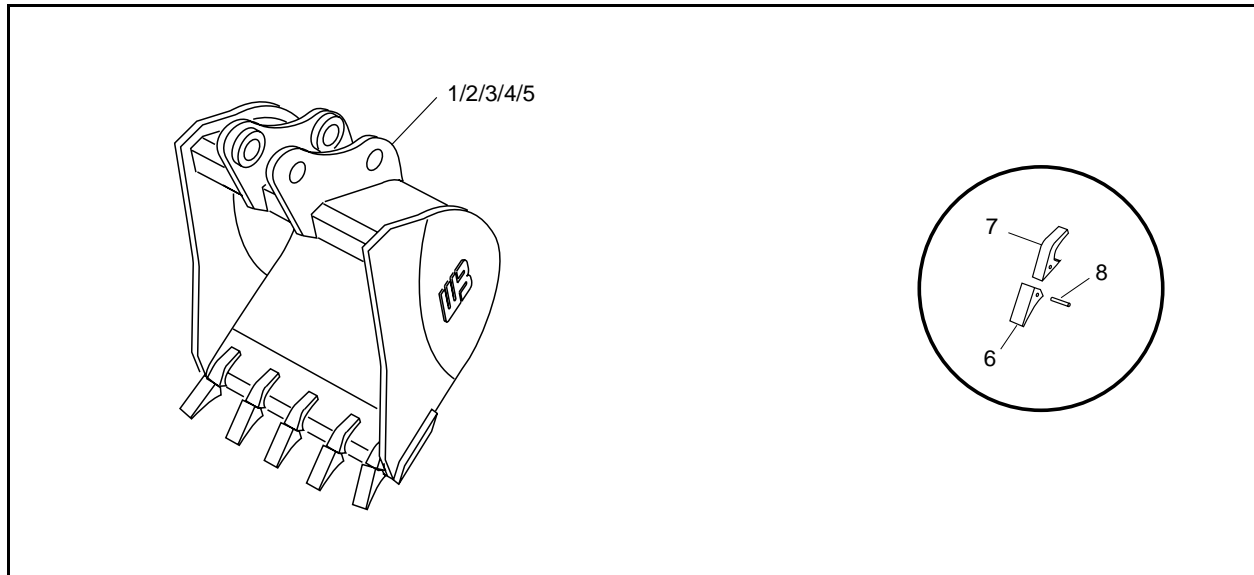


Ref. No.	Part No.	Description	Capacity.
1	808092	HEAVY-DUTY BUCKET 12" (300 MM)	3.9 FT <sup>3</sup> (0.110 M <sup>3</sup> )
2	808093	HEAVY-DUTY BUCKET 16" (400 MM)	5.5 FT <sup>3</sup> (0.156 M <sup>3</sup> )
3	808094	HEAVY-DUTY BUCKET 18" (450 MM)	6.2 FT <sup>3</sup> (0.176 M <sup>3</sup> )
4	808095	HEAVY-DUTY BUCKET 20" (500 MM)	7.0 FT <sup>3</sup> (0.198 M <sup>3</sup> )
5	808096	HEAVY-DUTY BUCKET 24" (600 MM)	8.0 FT <sup>3</sup> (0.227 M <sup>3</sup> )

Ref. No.	Part No.	Description	Capacity.
6	808097	HEAVY-DUTY BUCKET 30" (750 MM)	10.9 FT <sup>3</sup> (0.308 M <sup>3</sup> )
7	808098	HEAVY-DUTY BUCKET 36" (900 MM)	13.4 FT <sup>3</sup> (0.379 M <sup>3</sup> )
8	207076	BUCKET TOOTH	AS REQ.
9	207084	PIN	AS REQ.
10	207083	SHANK	AS REQ.

# MODEL 1202

## Werk Brau Heavy-Duty Buckets



Ref. No.	Part No.	Description	Capacity.
1	808391	HEAVY-DUTY BUCKET 30" (750 MM)	14 FT <sup>3</sup> (0.396 M <sup>3</sup> )
2*	808392*	HEAVY-DUTY BUCKET 36" (900 MM)	17 FT <sup>3</sup> (0.481 M <sup>3</sup> )
3*	808393	HEAVY-DUTY BUCKET 40" (1000 MM)	18 FT <sup>3</sup> (0.509 M <sup>3</sup> )
4*	808394	HEAVY-DUTY BUCKET 42" (1050 MM)	20 FT <sup>3</sup> (0.560 M <sup>3</sup> )

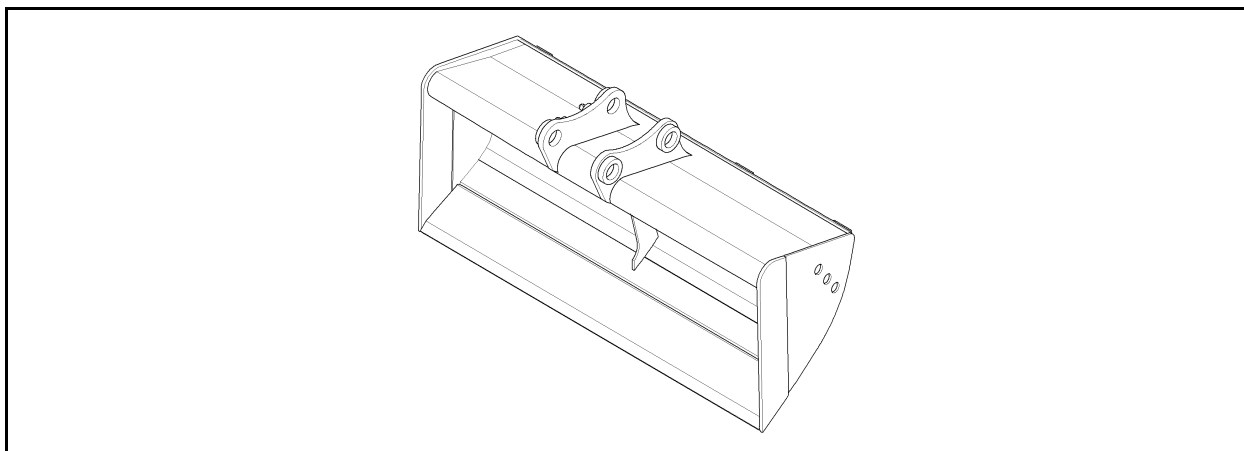
Ref. No.	Part No.	Description	Capacity.
5	808391	HEAVY-DUTY BUCKET 30" (750 MM)	14 FT <sup>3</sup> 0.396 M <sup>3</sup>
6	207075	BUCKET TOOTH	AS REQ.
7	207086	PIN	AS REQ.
8	207081	SHANK	AS REQ.

\*Additional counterweight required. See excavator parts manual.



# ALL MODELS

## Ditching Buckets



**142**

**152**

Bucket

Part No.	Description	Capacity
807604	GENERAL-PURPOSE DITCHING BUCKET 31" (775 MM)	1.9 FT <sup>3</sup> (0.040 M <sup>3</sup> )

**153**

**192**

**193**

**222**

**223**

Bucket

Part No.	Description	Capacity
807611	GENERAL-PURPOSE DITCHING BUCKET 33" (800 MM)	2.2 FT <sup>3</sup> (0.040 M <sup>3</sup> )

**253**

Bucket

Part No.	Description	Capacity
808682	GENERAL-PURPOSE DITCHING BUCKET 33" (700 MM)	1.9 FT <sup>3</sup> (0.062 M <sup>3</sup> )

**272**

**292**

**303 \***

**342**

**353 \***

**362**

**373 \***

Bucket

Part No.	Description	Capacity
807618 *	GENERAL-PURPOSE DITCHING BUCKET 39" (1000 MM)	3.6 FT <sup>3</sup> (0.101 M <sup>3</sup> )

\*Not an orderable part number; Models 253, 303, & 373 need two connecting links 165731. See excavator parts manual

**303**

**353**

**373**

**383Z**

Bucket

Part No.	Description	Capacity
808690	HEAVY-DUTY DITCHING BUCKET 39" (1000 MM)	4.1 FT <sup>3</sup> (0.116 M <sup>3</sup> )
808691	HEAVY-DUTY DITCHING BUCKET 55" (1400 MM)	5.9 FT <sup>3</sup> (0.167 M <sup>3</sup> )

# ALL MODELS

## Ditching Buckets

### 503Z

#### Bucket

Part No.	Description	Capacity
807625	HEAVY-DUTY DITCHING BUCKET 48" (1000 MM)	5.9 FT <sup>3</sup> (0.167 M <sup>3</sup> )
809148*	HEAVY-DUTY DITCHING BUCKET 48" (1000 MM)	7.0 FT <sup>3</sup> (0.198 M <sup>3</sup> )
809149*	HEAVY-DUTY DITCHING BUCKET 55" (1400 MM)	8.4 FT <sup>3</sup> (0.238 M <sup>3</sup> )

\*Not an orderable part number

### 1202

#### Bucket

Part No.	Description	Capacity
*	HEAVY-DUTY DITCHING BUCKET 60" (1525 MM)	22.7 FT <sup>3</sup> (0.643 M <sup>3</sup> )

\*Contact CEA Attachments

### 502

### 602

### 603

### 652W

#### Bucket

Part No.	Description	Capacity
807625	HEAVY-DUTY DITCHING BUCKET 48" (1000 MM)	5.9 FT <sup>3</sup> (0.167 M <sup>3</sup> )

### 753Z

### 802

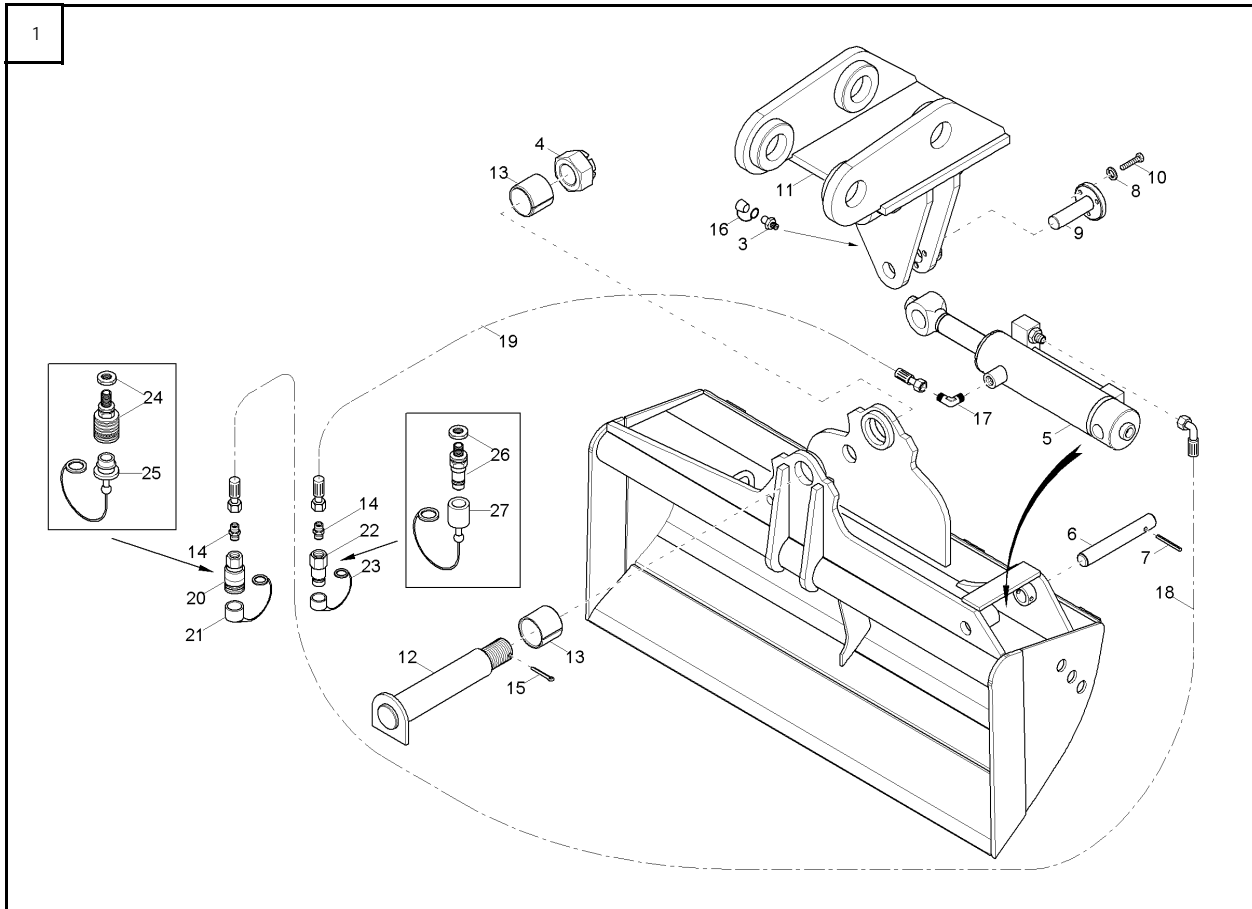
### 803

#### Bucket

Part No.	Description	Capacity
807632	HEAVY-DUTY DITCHING BUCKET 48" (1000 MM)	7.6 FT <sup>3</sup> (0.215 M <sup>3</sup> )
807633	HEAVY-DUTY DITCHING BUCKET 60" (1525 MM)	9.7 FT <sup>3</sup> (0.275 M <sup>3</sup> )

# MODELS 142, 152

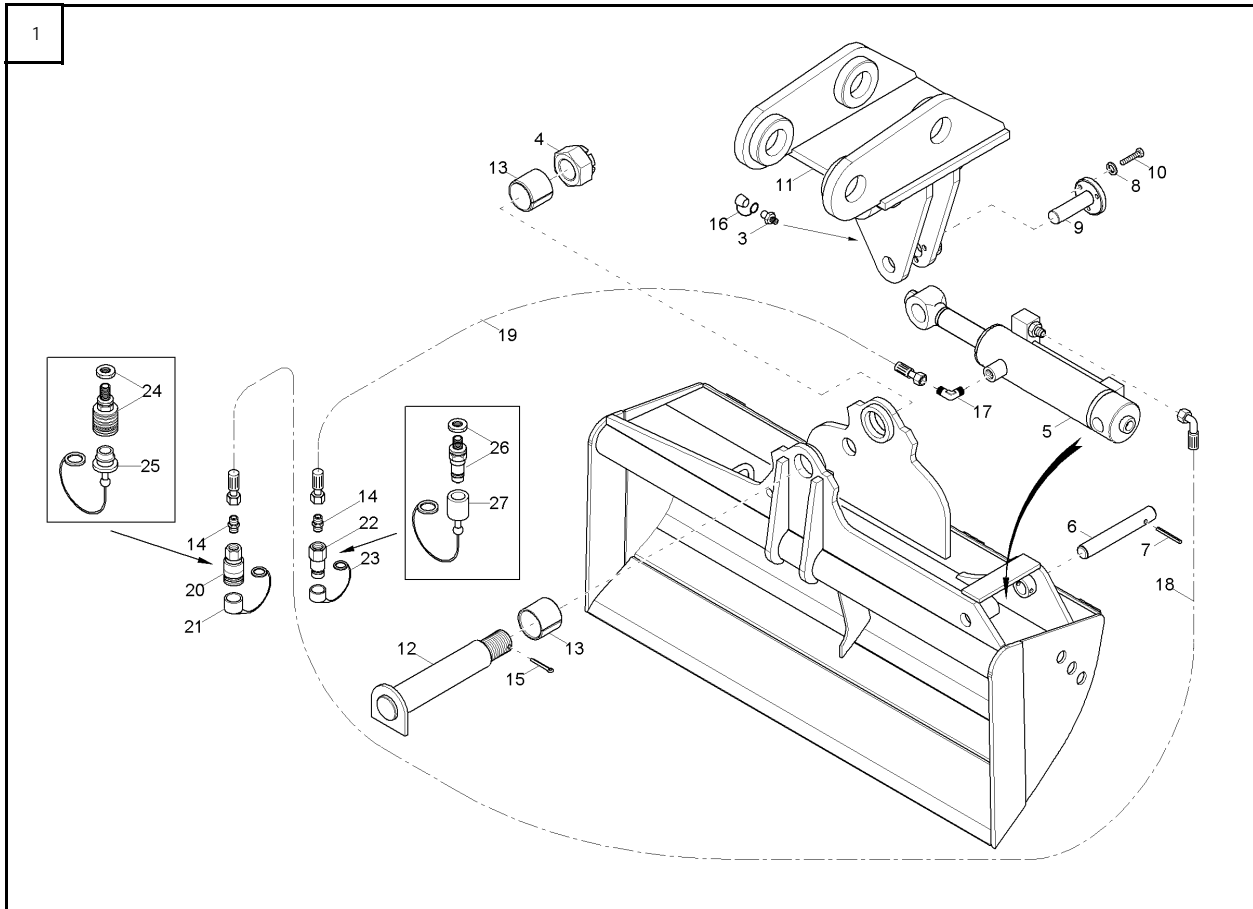
## Swivel Buckets -- 1000149187



Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	807605	BUCKET/SWIVEL 31" (850 MM) 1.6 FT <sup>3</sup> (0.045 M <sup>3</sup> )	1	16	161422	CAP	1
3	161441	GREASE ZERK	1	17	161440	ELBOW	2
4	651443	HN SLTD M36-4 C8ZY	1	18	205688	HP HOSE	1
5	207476	CYLINDER See page 24 for individual components	1	19	165852	HP HOSE	1
6	207478	PIN	1	20	177798	QUICK COUPLER (Flat-face coupler. See page 6)	1
7	207478	COTTER PIN	1	21	177804	DUST PLUG	1
8	656110	LW M8 R20	3	22	177794	QUICK COUPLER (Flat-Face coupler. See page 6)	1
9	208116	PIN	1	23	177803	DUST CAP	1
10	177648	HEX SCREW	3	24	160467	QUICK COUPLER (Euro-style coupler. See page 6)	1
11	204509	SWIVEL BRACKET	1	25	160458	DUST PLUG	1
12	207477	PIN	2	26	160468	QUICK COUPLER (Euro-style coupler. See page 6)	1
13	208117	BUSHING 45/55 X 40	2	27	160459	DUST CAP	1
14	161430	SCREW JOINT	2				
15	161682	PIN/SPRING M6.3 X 63 ZO	1				

# MODELS 153, 192, 193, 222, 223, 253

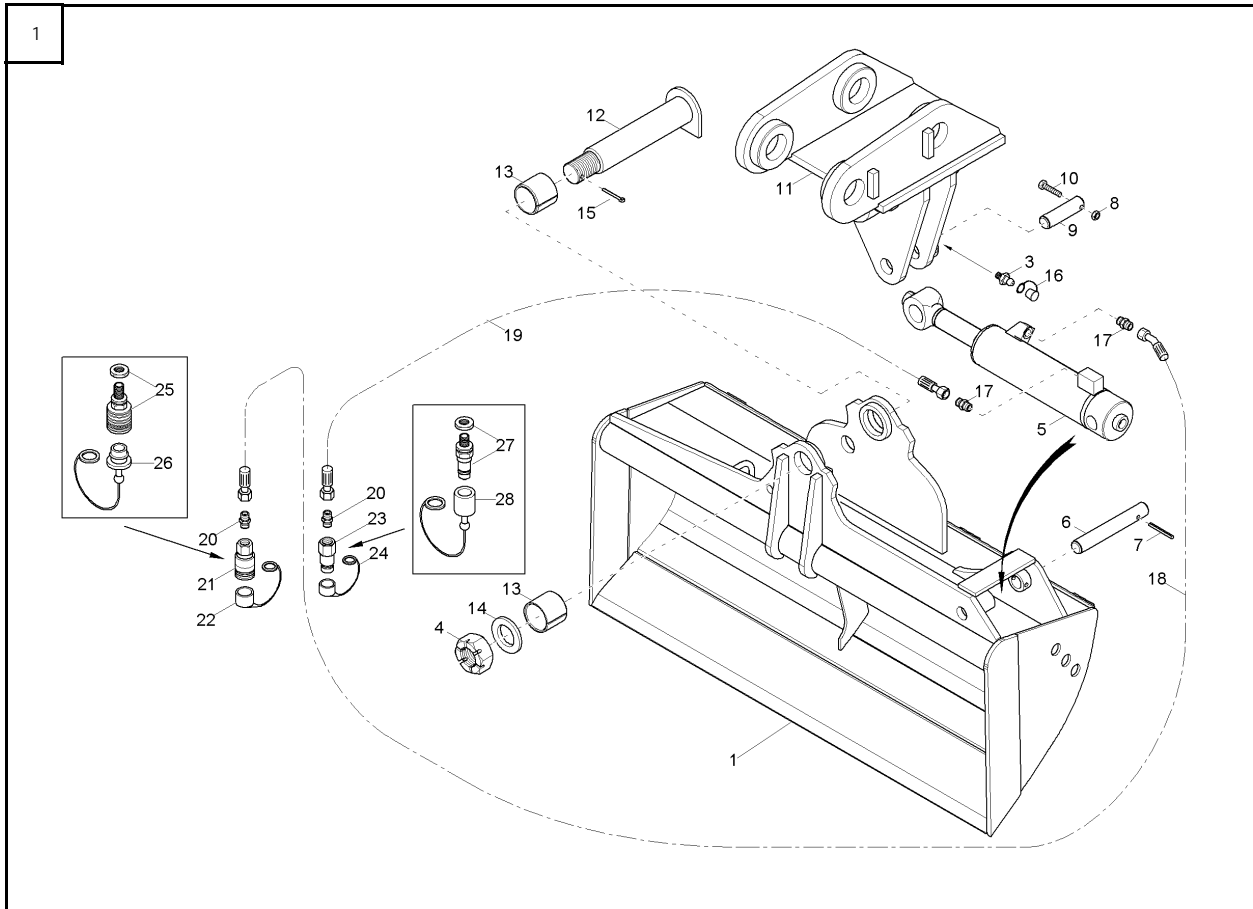
## Swivel Buckets -- 1000143840



Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	807612	BUCKET/SWIVEL 33" (850 MM) 2.0 FT <sup>3</sup> (0.057 M <sup>3</sup> )	1	18	205688	HP HOSE	1
3	161441	GREASE ZERK	1		207482	HP HOSE (REQUIRED FOR LONG DIPPER ARM ON MODELS 252/ME2503)	1
4	651443	HN SLTD M36-4 C8ZY	1	19	165852	HP HOSE	1
5	207476	CYLINDER See page 24 for individual components	1		207483	HP HOSE (REQUIRED FOR LONG DIPPER ARM ON MODELS 252/ME250)	1
6	207478	PIN	1	20	177798	QUICK COUPLER (Flat-face coupler. See page 6)	1
7	207484	COTTER PIN	1	21	177804	DUST PLUG	1
8	656110	LW M8 R20	3	22	177794	QUICK COUPLER (Flat-Face coupler. See page 6)	1
9	208116	PIN	1	23	177803	DUST CAP	1
10	177648	HEX SCREW	3	24	160467	QUICK COUPLER (Euro-style coupler. See page 6)	1
11	204510	SWIVEL BRACKET	1	25	160458	DUST PLUG	1
12	207477	PIN	2	26	160468	QUICK COUPLER (Euro-style coupler. See page 6)	1
13	208117	BUSHING 45/55 X 40	2	27	160459	DUST CAP	1
14	161430	SCREW JOINT	2				
15	161682	PIN/SPRING M6.3 X 63 ZO	1				
16	161422	CAP	1				
17	161440	ELBOW	2				

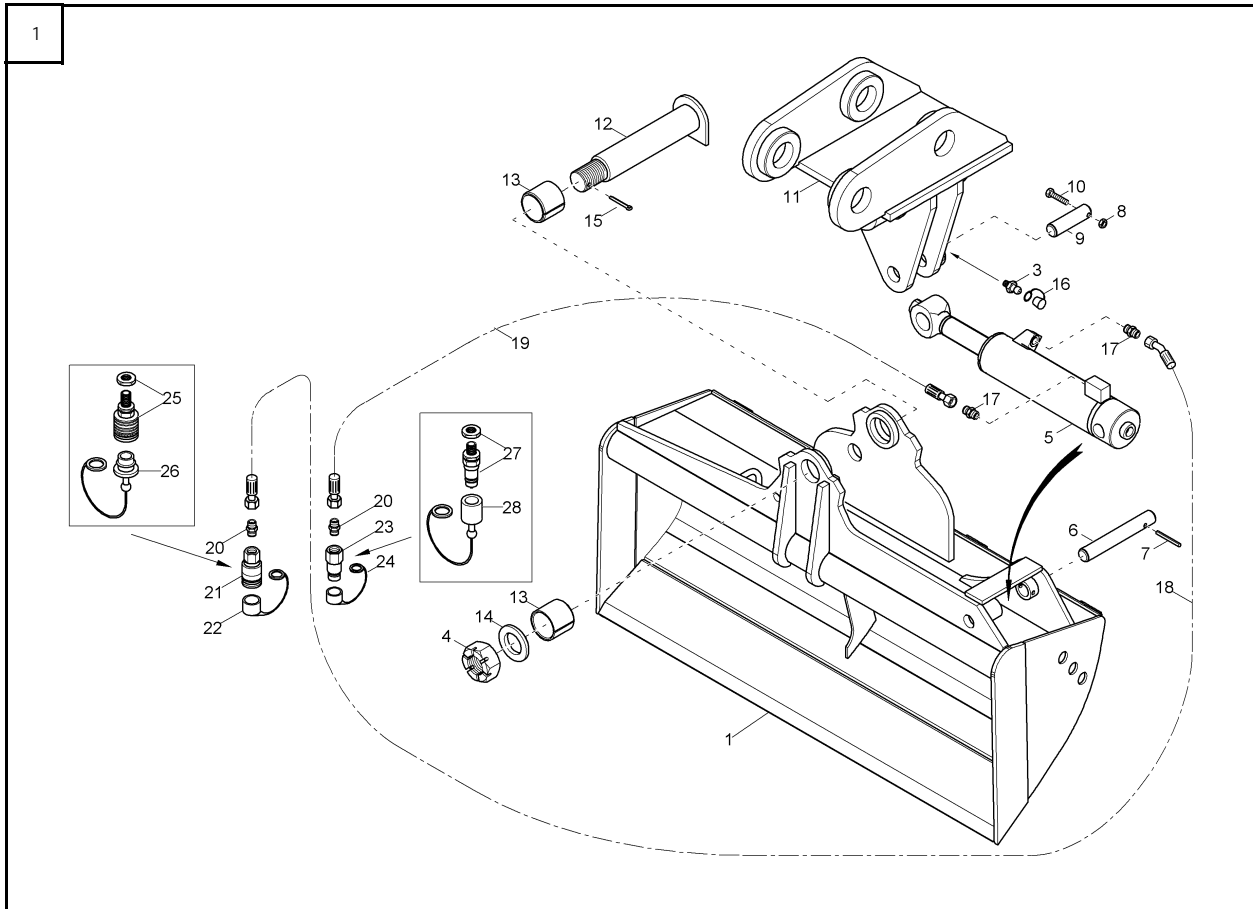
# MODELS 272, 292, 342, 362

## Swivel Buckets -- 1000149192



Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	808692	BUCKET/SWIVEL 39" (1000 MM) 3.0 FT <sup>3</sup> (0.110 M <sup>3</sup> )	1	17	161429	SCREW JOINT	2
3	161411	GREASE ZERK	1	18	205689	HP HOSE	1
4	651443	HN SLTD M36-4 C8ZY	1	19	205669	HP HOSE	1
5	206059	SWIVEL BUCKET CYLINDER See page 25 for individual components	1	20	161430	SCREW JOINT	2
6	205680	PIN	1	21	177798	QUICK COUPLER (Flat-face coupler. See page 6)	1
7	207484	COTTER PIN	1	22	177804	DUST PLUG	1
8	651458	LN INS M8-1.25 C8ZY	1	23	177794	QUICK COUPLER (Flat-Face coupler. See page 6)	1
9	205681	PIN	1	24	177803	DUST CAP	1
10	651438	HB M8-1.25 X 70	1	25	160467	QUICK COUPLER (Euro-style coupler. See page 6)	1
11	204511	SWIVEL BRACKET (1000070343)	1	26	160458	DUST PLUG	1
12	205679	PIN	1	27	160468	QUICK COUPLER (Euro-style coupler. See page 6)	1
13	205696	BUSHING	2	28	160459	DUST CAP	1
14	205700	FLAT WASHER	1				
15	161682	PIN/SPRING M6.3 X 63 ZO	1				
16	161422	CAP	1				

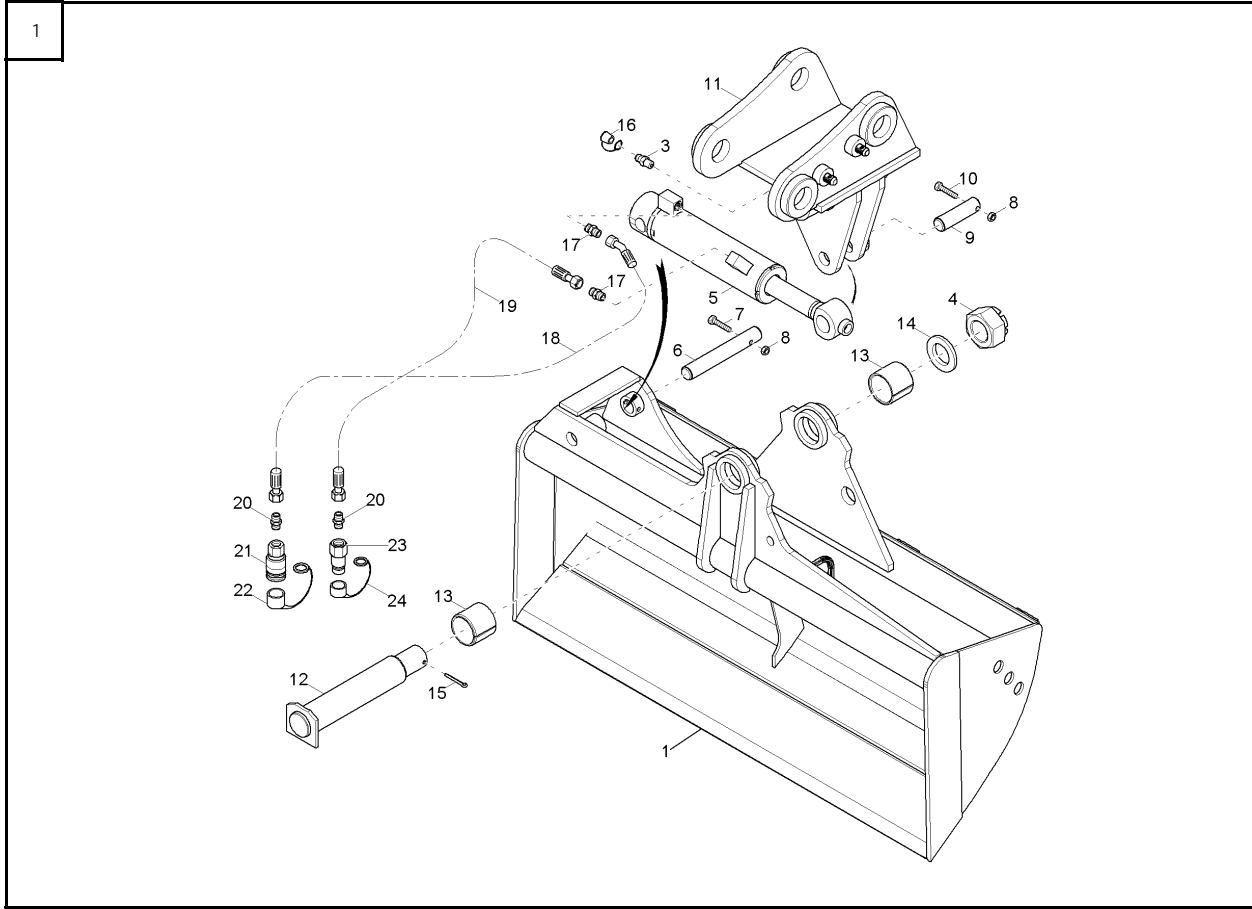
**MODELS 303, 353, 373, 383Z**  
**Swivel Buckets -- 1000143535, 1000143537**



Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	808692	BUCKET/SWIVEL 40" (1000 MM) 3.9 FT <sup>3</sup> (0.110 M <sup>3</sup> )	1	18	205689	HP HOSE (REQUIRED FOR SHORT DIPPER ARM)	1
	808693	BUCKET/SWIVEL 55" (1400 MM) 5.6 FT <sup>3</sup> (0.159 M <sup>3</sup> )	1		205670	HP HOSE (REQUIRED FOR LONG DIPPER ARM)	1
3	161441	GREASE ZERK	1	19	205669	HP HOSE (REQUIRED FOR SHORT DIPPER ARM)	1
4	651443	HN SLTD M36-4 C8ZY	1		205688	HP HOSE (REQUIRED FOR LONG DIPPER ARM)	1
5	206059	SWIVEL BUCKET CYLINDER See page 25 for individual components	1	20	161430	SCREW JOINT	2
6	205680	PIN	1	21	177798	QUICK COUPLER (Flat-face coupler. See page 6)	1
7	207478	COTTER PIN	1	22	177804	DUST PLUG	1
8	651458	LN INS M8-1.25 C8ZY	1	23	177794	QUICK COUPLER (Flat-Face coupler. See page 6)	1
9	205681	PIN	1	24	177803	DUST CAP	1
10	651438	HB M8-1.25 X 70	1	25	160467	QUICK COUPLER (Euro-style coupler. See page 6)	1
11	205766	SWIVEL BUCKET	1	26	160458	DUST PLUG	1
12	205679	PIN	1	27	160468	QUICK COUPLER (Euro-style coupler. See page 6)	1
13	205696	BUSHING	2	28	160459	DUST CAP	1
14	205700	FLAT WASHER	1				
15	161682	PIN/SPRING M6.3 X 63 ZO	1				
16	161422	CAP	1				
17	161429	SCREW JOINT	2				

# MODELS 502, 503Z, 602, 603, 652

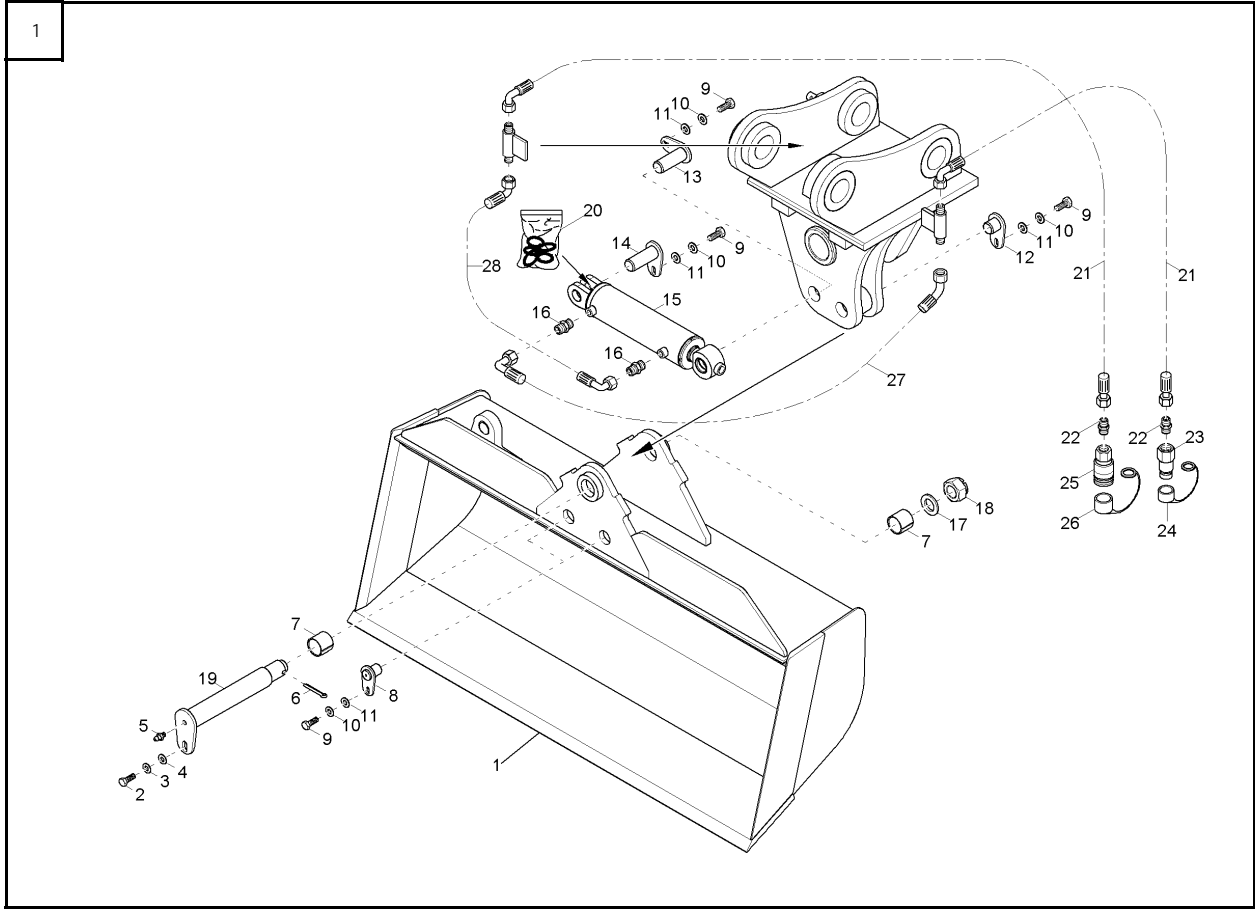
## Swivel Buckets -- 1000126289, 1000125502, 1000143113, 100143132



Ref. No.	Part No.	Description	Qty.
1	809126	BUCKET/SWIVEL 48" (1200 MM) 5.9 FT <sup>3</sup> (0.167 M <sup>3</sup> )	1
	809155	BUCKET/SWIVEL 48" (1200 MM) 7.0 FT <sup>3</sup> (0.198 M <sup>3</sup> )	1
	809156	BUCKET/SWIVEL 55" (1400 MM) 8.4 FT <sup>3</sup> (0.238 M <sup>3</sup> )	1
3	161411	GREASE ZERK	1
4	651444	HN SLTD M48-3 F8 ZY	1
5	177624	CYLINDER/SWIVEL BUCKET See page 26 for individual components	1
6	177627	PIN	1
7	651437	HB M8-1.25 X 60 C8.8SY	1
8	651458	LN INS M8-1.25 C8 ZY	2
9	177628	PIN	1
10	651438	HB M8-1.25 X 70 C8.8 ZY	1
11	177622	SWIVEL BRACKET	1
12	177626	PIN	1
13	177620	BUSHING	2

Ref. No.	Part No.	Description	Qty.
14	177623	SPACER/SWIVEL BRACKET	1
15	161683	PIN/SPRING M8 X 80 ZO	1
16	161416	PROTECTION CAP	1
17	161429	SCREW JOINT 12L	2
18	204512	HP HOSE (REQUIRED FOR SHORT DIPPER ARM)	1
	204513	HP HOSE (REQUIRED FOR LONG DIPPER ARM)	1
19	204514	HP HOSE (REQUIRED FOR SHORT DIPPER ARM)	1
	204515	HP HOSE (REQUIRED FOR LONG DIPPER ARM) (1000129482)	1
20	161430	SCREW JOINT	2
21	177798	COUPLING/FEMALE	1
22	177804	DUST CAP SLEEVE	1
23	177797	COUPLING/MALE A13 BG3	1
24	177803	DUST CAP PLUG	1

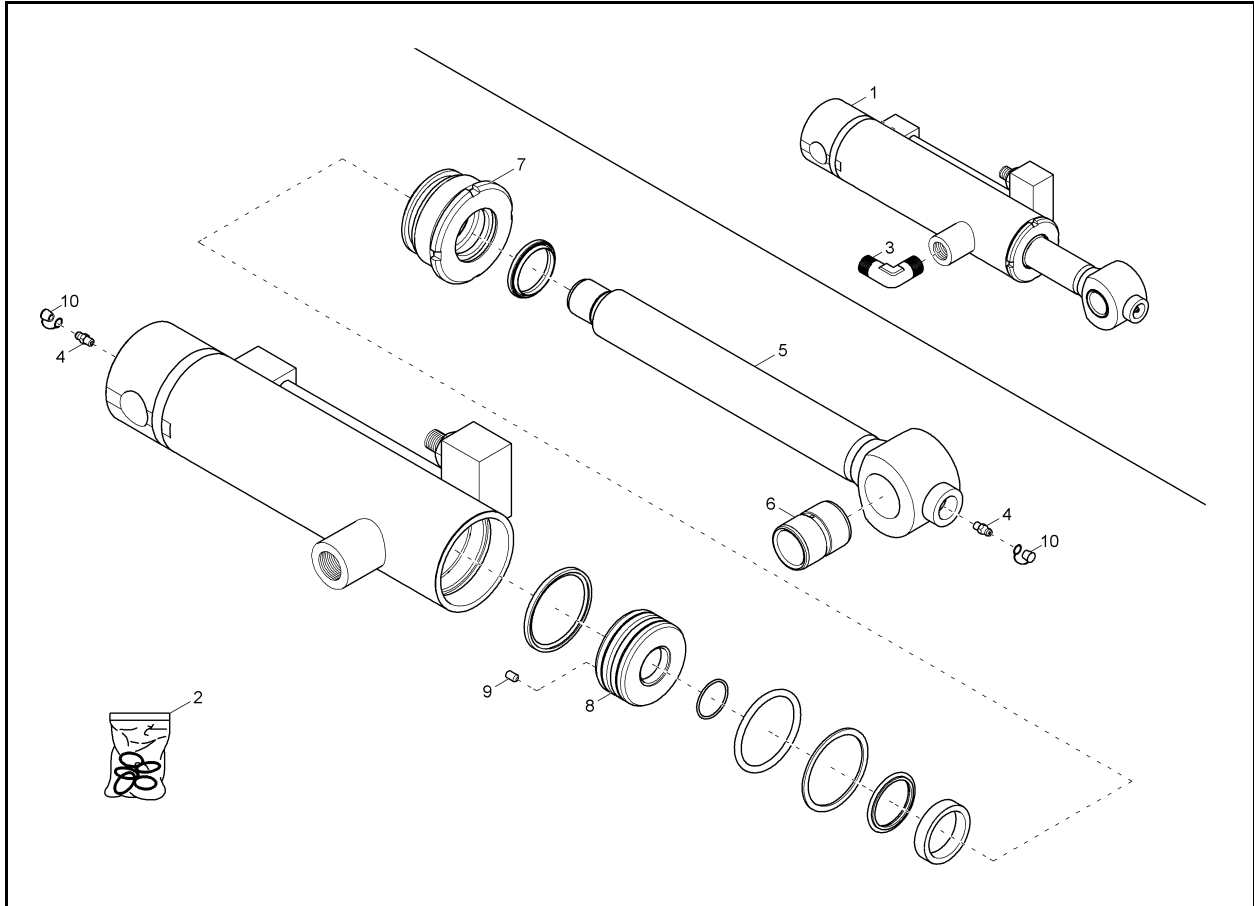
**MODELS 753Z, 802, 803**  
**Swivel Buckets -- 1000132354, 1000143171**



Ref. No.	Part No.	Description	Qty.
1	807634	BUCKET/SWIVEL 60" (1525 MM) 8.8 FT <sup>3</sup> (0.250 M <sup>3</sup> )	1
2	9901160G	SCREW	1
3	204494	SPRING RING	1
4	7451680116	WASHER B17-140HV A2C	1
5	161412	GREASE ZERK	1
6	161683	PIN/SPRING M8 X 80 ZO	1
7	204495	GROOVED BUSHING	2
8	204496	PIN	2
9	651405	CS M12-1.75 X 30 C10.9 ZO	5
10	161624	LW SPRING B12 DIM 7982	5
11	161642	WASHER GR A13	1
12	204497	PIN	1
13	204498	PIN	1
14	204499	PIN	1
15	204500	CYLINDER/SWIVEL BUCKET	1
16	165966	SCREW JOINT	2
17	204501	SPACER	1
18	204502	CROWN NUT	1
19	204503	PIN	1
20	204504	SEAL KIT	1
21	204505	HP HOSE (REQUIRED FOR SHORT DIPPER ARM)	2
	204506	HP HOSE (REQUIRED FOR LONG DIPPER ARM)	2
22	179833	SCREW JOINT	2
23	177204	COUPLING/MALE A17 3/4"	1
24	177203	DUST CAP SLEEVE	1
25	177796	COUPLING/FEMALE A17 3/4"	1
26	177805	DUST CAP PLUG	1
27	204507	HP HOSE	1
28	204508	HP HOSE	1



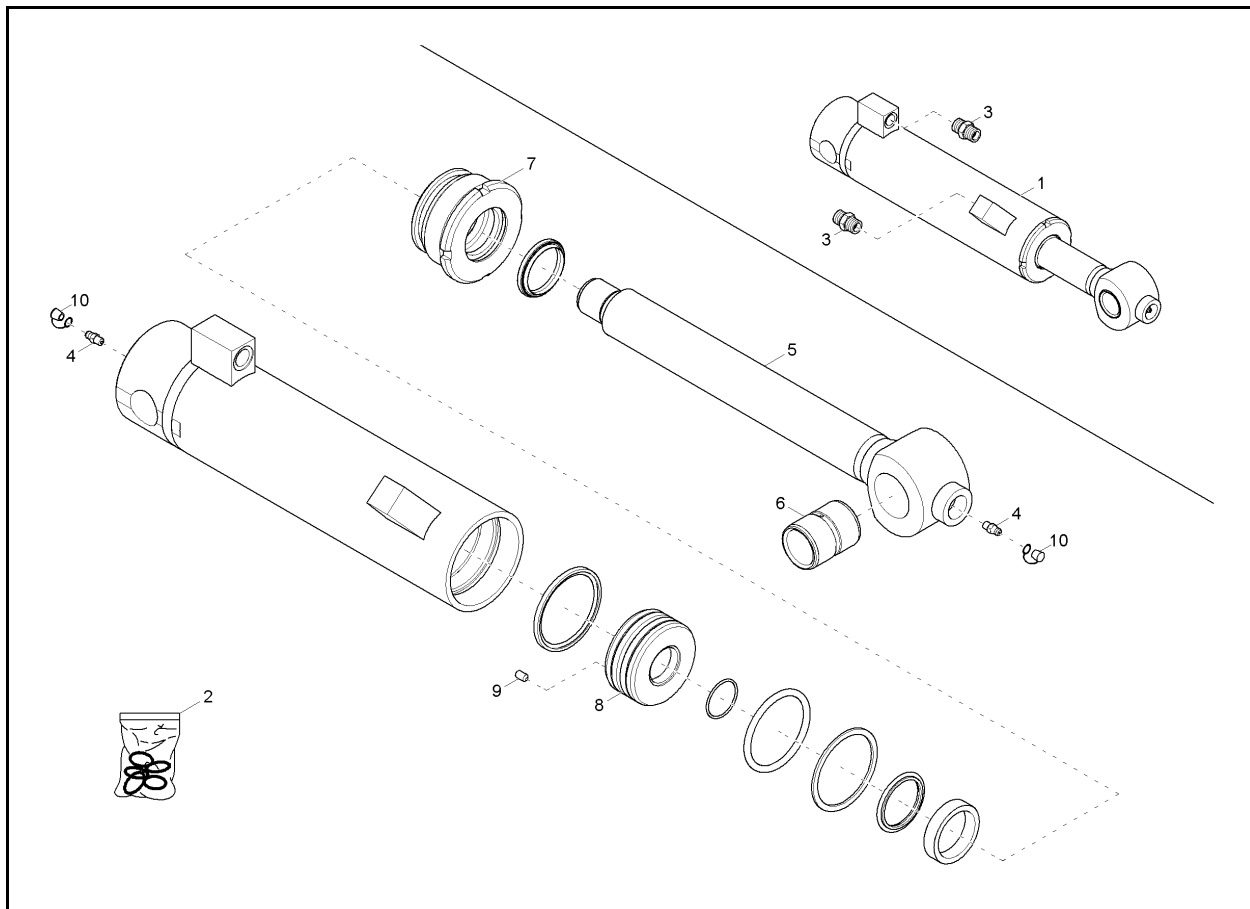
**MODELS 142, 152, 153, 192, 193, 222, 223, 253**  
**Swivel Bucket Cylinders -- 1000143945**



Ref. No.	Part No.	Description	Qty.
1	207476	CYLINDER	1
2	207475	SEAL KIT	1
3	161440	ELBOW	2
4	161411	GREASE ZERK	2
5	204491	PISTON ROD	1
6	207481	BUSHING	1
7	204492	GUIDE BUSHING	1
8	204493	PISTON	1
9	161400	SET SCREW	1
10	160459	DUST CAP	1

# MODELS 272, 292, 303, 342, 353, 373, 383Z

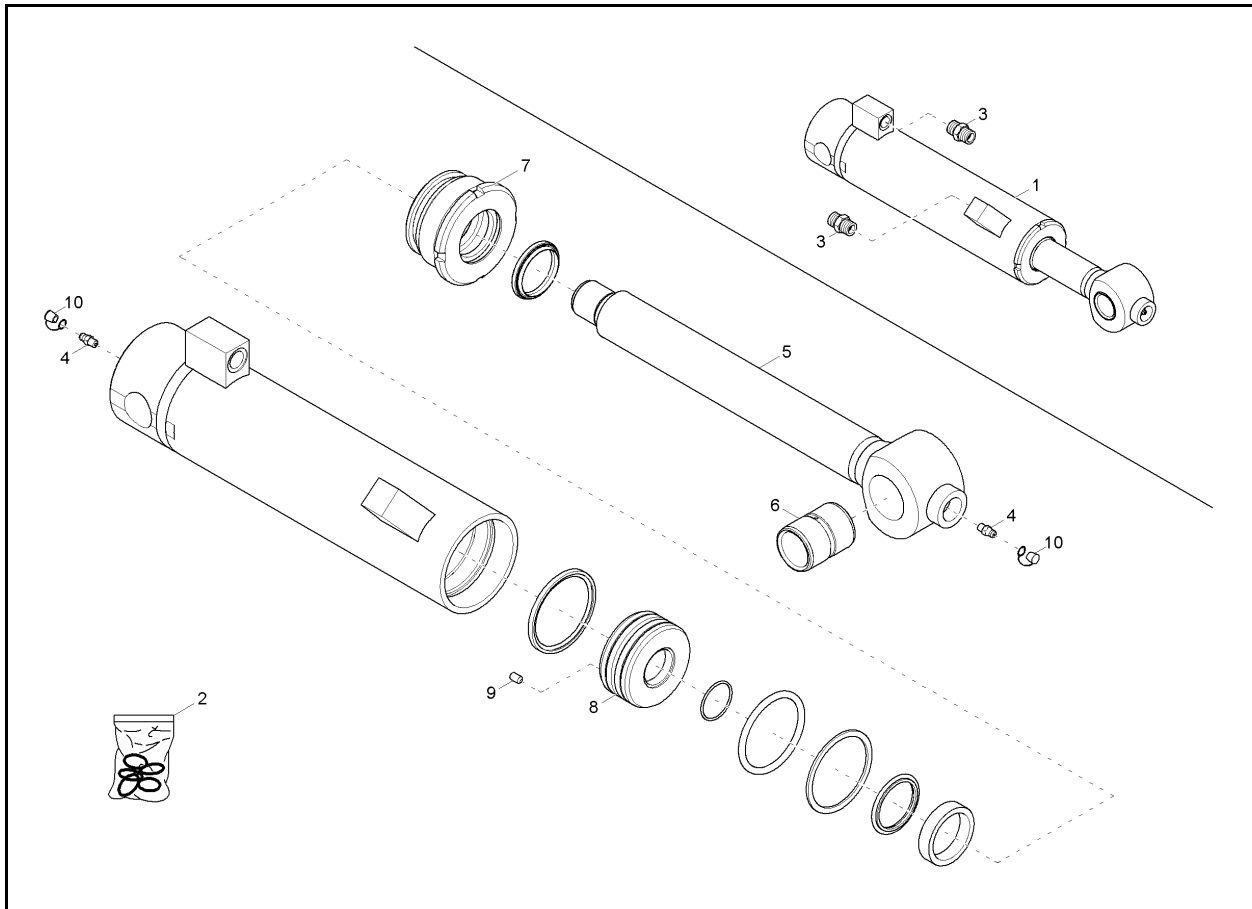
Swivel Bucket Cylinders -- 1000143534



Ref. No.	Part No.	Description	Qty.
1	206059	SWIVEL BUCKET CYLINDER	1
2	206050	SEAL KIT TILT BUCKET	1
3	161429	SCREW 12L	2
4	161411	GREASE ZERK	2
5	206060	PISTON ROD	1
6	177629	STEEL BUSHING	1
7	177641	GUIDE BUSHING	1
8	177640	PISTON	1
9	161400	THREAD PIN SET SCREW	1
10	161416	PROTECTION CAP	2

# MODELS 502, 503Z, 602, 603, 652

Swivel Bucket Cylinders -- 1000125512



Ref.	No.	Part No.	Description	Qty.
	1	177624	SWIVEL BUCKET CYLINDER	1
	2	177621	SEAL KIT TILT BUCKET CYLINDER	1
	3	161429	SCREW JOINT 12L	2
	4	161411	GREASE ZERK	2
	5	177625	PISTON ROD	1
	6	177629	STEEL ROD	1
	7	177641	GUIDE BUSHING	1
	8	177640	PISTON	1
	9	161400	SET SCREW	1
	10	161416	PROTECTION CAP	1

# NOTES

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204514	22	19	207083	10	8	651443	20	4
204515	22	19	207083	14	10	651443	21	4
205669	20	19	207084	7	8	651444	22	4
205669	21	19	207084	9	8	651450	7	18
205670	21	18	207084	10	7	651450	9	18
205679	20	12	207084	11	7	651450	10	16
205679	21	12	207084	12	7	651450	11	18
205680	20	6	207084	13	8	651458	20	8
205680	21	6	207084	14	9	651458	21	8
205681	20	9	207086	15	7	651458	22	8
205681	21	9	207475	24	2	656050	8	9
205688	18	18	207476	18	5	656110	18	8
205688	19	18	207476	19	5	656110	19	8
205688	21	19	207476	24	1	807598	7	1
205689	20	18	207477	18	12	807604	16	8
205689	21	18	207477	19	12	807605	18	1
205696	20	13	207478	18	6	807606	11	1
205696	21	13	207478	18	7	807607	11	2
205700	20	14	207478	19	6	807608	11	3
205700	21	14	207478	21	7	807609	11	4
205766	21	11	207481	24	6	807610	11	5
206050	25	2	207482	19	18	807611	16	8
206059	20	5	207483	19	19	807612	19	1
206059	21	5	207484	19	7	807613	9	2
206059	25	1	207484	20	7	807618	16	8
206060	25	5	208116	18	9	807620	13	1
207074	7	7	208116	19	9	807621	13	2
207074	9	7	208117	18	13	807622	13	3

Part No.	Page No.	Ref. No.	Part No.	Page No.	Ref. No.
807623	13	4	809156	22	1
807624	13	5	809316	13	6
807625	17	8	7451680116	23	4
807625	17	8	807598N	7	10
807627	10	1	807599	7	2
807629	10	3	807599N	7	11
807630	10	4	807600	7	3
807632	17	8	807600N	7	12
807633	17	8	807601	7	4
807634	23	1	807601N	7	13
808092	14	1	807602	7	5
808093	14	2	807602N	7	14
808094	14	3	807603	7	6
808095	14	4	807603N	7	15
808096	14	5	807606N	11	11
808097	14	6	807607N	11	12
808098	14	7	807608N	11	13
808391	15	1	807609N	11	14
808391	15	5	807613N	9	11
808392	15	2	807614	9	3
808393	15	3	807614N	9	12
808394	15	4	807615	9	4
808675	8	1	807615N	9	13
808676	8	2	807616	9	5
808677	8	3	807616N	9	14
808678	8	4	807617	9	6
808679	8	5	807617N	9	15
808682	16	8	807627N	10	9
808685	12	1	807628	10	2
808686	12	2	807628N	10	10
808687	12	3	807629N	10	11
808688	12	4	807630N	10	12
808689	12	5	807631	10	5
808690	16	8	807631N	10	13
808691	16	8	808395	9	1
808692	20	1	808395N	9	10
808692	21	1	808680	8	6
808693	21	1	809149	17	8
809126	22	1	9901160G	23	2
809155	22	1			

# 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.

Hydraulic fittings with various seals (light application). All torque values are in lb.-ft. (Nm) unless marked otherwise.					
Thread	Straight pipe fitting with thread and screwed plug (GE)			Non-return valve with elastic seal	Identification aid outside Ø
	Sealing washer	Elastic seal	O-ring		
M10X1.0	7 (9)	13 (18)	11 (15)	13 (18)	0.4 in. (10 mm)
M12X1.5	15 (20)	18 (25)	18 (25)	18 (25)	0.5 in. (12 mm)
M14X1.5	26 (35)	33 (45)	26 (35)	26 (35)	0.6 in. (14 mm)
M16X1.5	33 (45)	41 (55)	30 (40)	37 (50)	0.6 in. (16 mm)
M18X1.5	41 (55)	52 (70)	33 (45)	52 (70)	0.7 in. (18 mm)
M22X1.5	48 (65)	92 (125)	44 (60)	92 (125)	0.9 in. (22 mm)
M27X2.0	66 (90)	133 (180)	74 (100)	107 (145)	1.0 in. (27 mm)
M33X2.0	111 (150)	229 (310)	118 (160)	155 (210)	1.3 in. (33 mm)
M42X2.0	177 (240)	332 (450)	155 (210)	266 (360)	1.7 in. (42 mm)
M48X2.0	214 (290)	398 (540)	192 (260)	398 (540)	1.9 in. (48 mm)
G1/8A	7 (9)	13 (18)	11 (15)	13 (18)	0.4 in. (9.73 mm)
G1/4A	26 (35)	26 (35)	22 (30)	26 (35)	0.5 in. (13.16 mm)
G3/8A	33 (45)	52 (70)	33 (45)	37 (50)	0.7 in. (16.66 mm)
G1/2A	48 (65)	66 (90)	41 (55)	48 (65)	0.8 in. (20.96 mm)
G3/4A	66 (90)	133 (180)	74 (100)	103 (140)	1.0 in. (26.44 mm)
G1A	111 (150)	229 (310)	118 (160)	140 (190)	1.3 in. (33.25 mm)
G1 1/4A	177 (240)	332 (450)	155 (210)	266 (360)	1.7 in. (41.91 mm)
G1 1/2A	214 (290)	398 (540)	192 (260)	398 (540)	1.9 in. (47.80 mm)

Hydraulic fittings with various seals (heavy application). All torque values are in lb.-ft. (Nm) unless marked otherwise.

Thread	Straight pipe fitting with thread and screwed plug (GE)			Non-return valve with elastic seal	Identification aid outside Ø
	Sealing washer	Elastic seal	O-ring		
M12X1.5	15 (20)	26 (35)	26 (35)	26 (35)	0.5 in. (12 mm)
M14X1.5	26 (35)	41 (55)	33 (45)	33 (45)	0.6 in. (14 mm)
M16X1.5	33 (45)	52 (70)	41 (55)	41 (55)	0.6 in. (16 mm)
M18X1.5	41 (55)	66 (90)	52 (70)	52 (70)	0.7 in. (18 mm)
M20X1.5	41 (55)	92 (125)	59 (80)	74 (100)	0.8 in. (20 mm)
M22X1.5	48 (65)	100 (135)	74 (100)	92 (125)	0.9 in. (22 mm)
M27X2.0	66 (90)	133 (180)	125 (170)	100 (135)	1.0 in. (27 mm)
M33X2.0	111 (150)	229 (310)	229 (310)	155 (210)	1.3 in. (33 mm)
M42X2.0	177 (240)	332 (450)	243 (330)	266 (360)	1.7 in. (42 mm)
M48X2.0	214 (290)	398 (540)	310 (420)	398 (540)	1.9 in. (48 mm)
G1/8A	26 (35)	41 (55)	33 (45)	33 (45)	0.5 in. (13.16 mm)
G1/4A	33 (45)	59 (80)	44 (60)	44 (60)	0.7 in. (16.66 mm)
G3/8A	48 (65)	85 (115)	55 (75)	74 (100)	0.8 in. (20.96 mm)
G1/2A	66 (90)	133 (180)	125 (170)	107 (145)	1.0 in. (26.44 mm)
G3/4A	111 (150)	229 (310)	229 (310)	192 (260)	1.3 in. (33.25 mm)
G1A	177 (240)	332 (450)	243 (330)	266 (360)	1.7 in. (41.91 mm)
G1 1/4A	214 (290)	398 (540)	310 (420)	398 (540)	1.9 in. (47.80 mm)

With coarse-pitch thread. All torque values are in lb.-ft. (Nm) unless marked otherwise.

Thread	Threads according to DIN 912, DIN 931, DIN 933, etc.			Threads according to DIN 7984	
	8.8	10.9	12.9	8.8	10.9
M5	4.1 (5.5)	6 (8)	7 (10)	4 (5)	5 (7)
M6	7 (10)	10 (14)	13 (17)	6.3 (8.5)	9 (12)
M8	18 (25)	26 (35)	31 (42)	15 (20)	22 (30)
M10	33 (45)	48 (65)	59 (80)	30 (40)	44 (59)
M12	64 (87)	81 (110)	108 (147)	51 (69)	74 (100)
M14	100 (135)	133 (180)	170 (230)	81 (110)	118 (160)
M16	155 (210)	203 (275)	258 (350)	125 (170)	184 (250)
M18	207 (280)	302 (410)	354 (480)	181 (245)	254 (345)
M20	302 (410)	420 (570)	509 (690)	251 (340)	361 (490)
M22	406 (550)	575 (780)	686 (930)	339 (460)	487 (660)
M24	524 (710)	738 (1000)	878 (1190)	435 (590)	620 (840)
M27	767 (1040)	1092 (1480)	1305 (1770)	642 (870)	922 (1250)
M30	1047 (1420)	1482 (2010)	1770 (2400)	885 (1200)	1254 (1700)

With fine-pitch thread. All torque values are in lb.-ft. (Nm) unless marked otherwise.

Thread	Threads according to DIN 912, DIN 931, DIN 933, etc.			Threads according to DIN 7984	
	8.8	10.9	12.9	8.8	10.9
M8X1.0	18 (25)	27 (37)	32 (43)	16 (22)	24 (32)
M10X1.0	37 (50)	55 (75)	65 (88)	32 (43)	48 (65)
M10X1.25	36 (49)	52 (71)	61 (83)	31 (42)	46 (62)
M12X1.25	64 (87)	96 (130)	111 (150)	55 (75)	81 (110)
M12X1.5	61 (83)	92 (125)	107 (145)	53 (72)	77 (105)
M14X1.5	100 (135)	148 (200)	173 (235)	89 (120)	129 (175)
M16X1.5	155 (210)	229 (310)	266 (360)	133 (180)	195 (265)
M18X1.5	232 (315)	332 (450)	391 (530)	199 (270)	284 (385)
M20X1.5	325 (440)	465 (630)	538 (730)	277 (375)	391 (530)
M22X1.5	435 (590)	620 (840)	723 (980)	369 (500)	524 (710)
M24X2.0	546 (740)	789 (1070)	922 (1250)	465 (630)	664 (900)
M27X2.0	811 (1100)	1143 (1550)	1328 (1800)	679 (920)	959 (1300)
M30X2.0	1106 (1500)	1586 (2150)	1844 (2500)	959 (1300)	1364 (1850)

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