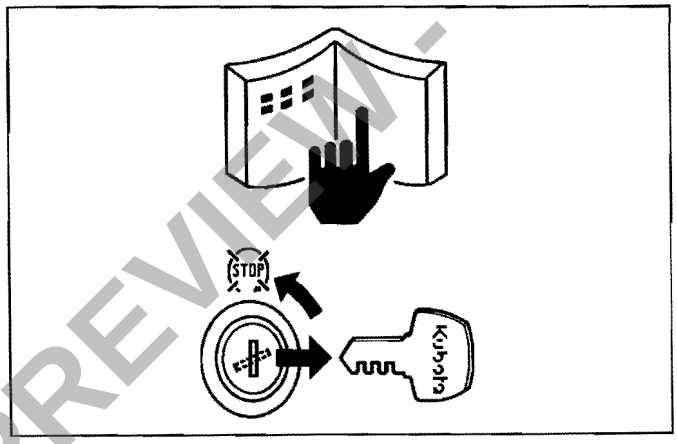
⚠ SAFETY FIRST

This symbol, the industry's "Safety Alert Symbol", is used throughout this manual and on labels on the machine itself to warn of the possibility of personal injury. Read these instructions carefully.

It is essential that you read the instructions and safety regulations before you attempt to repair or use this unit.

⚠ **DANGER**	**: Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.**
⚠ **WARNING**	**: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.**
⚠ **CAUTION**	**: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.**
■ **IMPORTANT**	**: Indicates that equipment or property damage could result if instructions are not followed.**
■ **NOTE**	**: Gives helpful information.**



BEFORE SERVICING AND REPAIRING

- Read all instructions and safety instructions in this manual and on your machine safety decals.
- Clean the work area and machine.
- Park the machine on a firm and level ground, and set the parking brake.
- Lower the implement to the ground.
- Stop the engine, and remove the key.
- Disconnect the battery negative cable.
- Hang a "**DO NOT OPERATE**" tag in operator station.

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SPECIFICATIONS

Model			BX25
PTO power			13.2 kW (17.7 HP)*
Engine	Maker		KUBOTA
	Model		D902-E3-BX-2
	Type		Indirect Injection, vertical, water-cooled, 4-cycle diesel
	Number of cylinders		3
	Bore and stroke		72 × 73.6 mm (2.83 × 2.90 in.)
	Total displacement		898 cm^3 (54.8 cu.in.)
	Engine gross power		17.1 kW (23.0 HP)
	Rated revolution		3200min^{-1} (rpm)
	Maximum torque		56.1 N·m (5.7 kgf·m, 41.4 ft-lbs)
	Battery		12 V, CCA : 535 A, RC : 80 min.
	Fuel		Diesel fuel No. 2-D [above −10 °C (14 °F)], Diesel fuel No. 1 [below −10 °C (14 °F)]
Capacities	Fuel tank		25 L (6.6 U.S.gals, 5.5 Imp.gals)
	Engine crankcase (with filter)		3.1 L (3.3 U.S.qts., 2.73 Imp.qts)
	Engine coolant		2.7 L (2.8 U.S.qts., 2.4 Imp.qts)
	Recovery tank		0.4 L (0.4 U.S.qts, 0.4 Imp.qts)
	Transmission case		11.6 L (3.1 U.S.gals, 2.6 Imp.gals)
Dimensions	Overall length (without 3P)		2170 mm (85.4 in.)
	Overall length (with 3P)		2490 mm (98.0 in.)
	Overall width		1145 mm (45.1 in.)
	Overall height	(with ROPS)	2140 mm (84.3 in.)
		(with Folded ROPS)	1610 mm (63.4 in.)
		(Top of steering wheel)	1255 mm (49.4 in.)
	Wheel base		1400 mm (55.1 in.)
	Min. ground clearance		175 mm (6.9 in.)
	Tread	Front	910 mm (35.8 in.)
		Rear	820 mm (32.2 in.)
Weight (with ROPS)			690 kg (1520 lbs)
Clutch			N / A
Travelling system	Tires	Front	18 × 8.50 – 10 (Turf, Bar, Ind.)
		Rear	26 × 12.00 – 12 (Turf, Bar, Ind.)
	Steering		Hydrostatic power steering
	Transmission		Main : Hydrostatic transmission, High-Low gear shift (2 forward and 2 reverse)
	Brake		Wet disk type
	Min. turning radius (without brake)		2.3 m (7.5 feet)
Hydraulic unit	Hydraulic control system		Directional control, auto-return lever system
	Pump capacity		23.5 L/min. (6.2 U.S.gals./min., 5.2 Imp.gals./min.)
	Three point hitch		SAE Category I
	Max. lift force	At lift points	5390 N (550 kg, 1210 lbs)
		24 in. behind points	3040 N (310 kg, 680 lbs)
PTO	Rear	PTO Shaft	SAE 1-3/8, 6 splines
		Revolution	1 speed (540 min^{-1} (rpm) at 3142 engine min^{-1} (rpm))
	Mid	PTO Shaft	USA No.5 (KUBOTA 10-tooth) involute spline
		Revolution	1 speed (2500 min^{-1} (rpm) at 3043 engine min^{-1} (rpm))

NOTE: * Manufacture's estimate. The company reserves the right to change the specifications without notice.
**See and check IMPLEMENT LIMITATIONS.

W1028103

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6. MAINTENANCE CHECK LIST

No.	Item	Period	Service Interval																	After purchase		Important		Reference page
			50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	1500	3000	1 year	2 years		
1	Engine oil	Change	★	☆		☆				☆				☆				☆							G-12
2	Engine oil filter	Replace	★			☆				☆				☆				☆							G-12
3	Transmission oil filter	Replace	★			☆				☆				☆				☆							G-13
4	Transmission fluid	Change								☆				☆				☆							G-13
5	Transmission strainer	Clean	★							☆				☆				☆							G-24
6	Front axle case oil	Change								☆				☆				☆							G-24
7	Front axle pivot	Adjust								☆								☆							G-25
8	Engine start system	Check	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆							G-14
9	Greasing	–	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆							G-15
10	Wheel bolt torque	Check	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆							G-15
11	Battery condition	Check		☆		☆		☆		☆		☆		☆		☆		☆					*4		G-16
12	Air cleaner element	Clean		☆		☆		☆		☆		☆		☆		☆		☆					*1	@	G-18
		Replace																			☆		*2		G-18
13	Fuel filter element	Check		☆		☆		☆		☆		☆		☆		☆		☆						@	G-19
		Replace										☆													G-19
14	Fan belt	Adjust		☆		☆		☆		☆		☆		☆		☆		☆							G-20
15	HST neutral spring	Adjust		☆		☆		☆		☆		☆		☆		☆		☆							G-21
16	Brake Pedal	Adjust		☆		☆		☆		☆		☆		☆		☆		☆							G-22
17	Radiator hose and clamp	Check				☆				☆				☆				☆							G-22
		Replace																				☆			G-22
18	Power steering oil line	Check				☆				☆				☆				☆							G-23
		Replace																				☆			G-23
19	Fuel line	Check		☆		☆	☆			☆		☆		☆		☆		☆						@	G-19
		Replace																				☆			G-19
20	Intake air line	Check			☆					☆				☆				☆						@	G-23
		Replace																				☆	*3		G-23
21	Toe-in	Adjust				☆				☆				☆				☆							G-23
22	Engine valve clearance	Adjust																☆							1-S13
23	Fuel injection nozzle injection pressure	Check																	☆	☆				@	1-S20
24	Injection pump	Check																		☆				@	1-S19
25	Cooling system	Flush																				☆			G-27
26	Coolant	Change																				☆			G-27
27	Fuel system	Bleed																			Service as required				G-30
28	Fuse	Replace																							G-31
29	Light bulb	Replace																							G-31

■ IMPORTANT

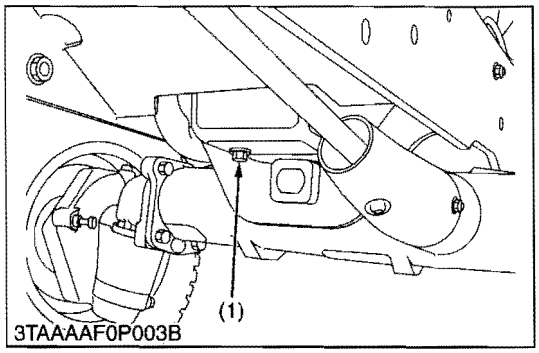
- **The jobs indicated by ★ must be done after the first 50 hours of operation.**
- ***1 : Air cleaner should be cleaned more often in dusty conditions than in normal conditions.**
- ***2 : Every year or every 6 times of cleaning.**
- ***3 : Replace only if necessary.**
- ***4 : When the battery is used for less than 100 hours per year, check the fluid level annually.**
- **The items listed above (@ marked) are registered as emission related critical parts by KUBOTA in the U.S.EPA non-road emission regulation. As the engine owner, you are responsible for the performance of the required maintenance on the engine according to the above instruction.**
  Please see the Warranty Statement in detail.

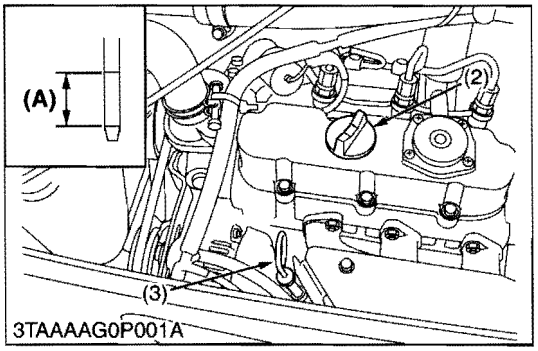
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[2] CHECK POINTS OF INITIAL 50 HOURS





Changing Engine Oil

CAUTION

- **Be sure to stop the engine before changing engine oil.**

1. Start and warm up the engine for approx. 5 minutes.
2. Place an oil pan underneath the engine.
3. To drain the used oil, remove the drain plug (1) at the bottom of the engine and drain the oil completely.
4. Screw in the drain plug (1).
5. Fill new oil up to upper line on the dipstick (3).

IMPORTANT

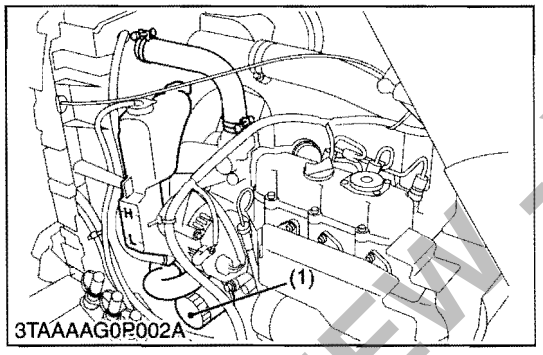
- **When using an oil of different manufacture or viscosity from the previous one, remove all of the old oil.**
- **Never mix two different types of oil.**
- **Use the proper SAE Engine Oil according to ambient temperatures.**
- **Refer to "LUBRICANTS, FUEL AND COOLANT". (See page G-7.)**

Engine oil capacity	3.1 L 3.3 U.S.qts 2.7 Imp.qts

(1) Drain Plug
(2) Oil Inlet
(3) Dipstick

(A) Oil level is acceptable within this range.

W1014065



Replacing Engine Oil Filter

CAUTION

- **Be sure to stop the engine before changing oil filter cartridge.**

1. Remove the oil filter.
2. Put a film of clean engine oil on the rubber seal of the new filter.
3. Tighten the filter quickly until it contacts the mounting surface. Tighten filter by hand an additional 1/2 turn only.
4. After the new filter has been replaced, the engine oil normally decrease a little. Make sure that the engine oil does not leak through the seal and be sure to check the oil level on the dipstick. Then, replenish the engine oil up to the specified level.
5. Properly dispose of used oil.

IMPORTANT

- **To prevent serious damage to the engine, replacement element must be highly efficient. Use only a KUBOTA genuine filter or its equivalent.**

(1) Engine Oil Filter Cartridge

W1014316

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3. TIGHTENING TORQUES

Tightening torques of screws, bolts and nuts on the table below are especially specified.
(Tractor section for general use screws, bolts and nuts : See page G-8.)

Tractor Section

Item	N·m	kgf·m	ft-lbs
Front coupling mounting bolt	23.6 to 27.4	2.4 to 2.8	17.4 to 20.2
Engine mounting nut	23.6 to 27.4	2.4 to 2.8	17.4 to 20.2
Cushion mounting nut	23.6 to 27.4	2.4 to 2.8	17.4 to 20.2

W1012736

Engine Section

Item	Size x Pitch	N·m	kgf·m	ft-lbs
*Cylinder head screw	M8 x 1.25	37.3 to 42.2	3.8 to 4.3	27.5 to 31.1
Oil pressure switch	PT 1/8	14.7 to 19.6	1.5 to 2.0	10.8 to 14.5
Engine oil filter joint	–	39.2 to 49.0	4.0 to 5.0	29.0 to 36.3
Nozzle holder	–	34.3 to 39.2	3.5 to 4.0	25.3 to 28.9
Overflow pipe retaining nut	M12 x 1.5	19.6 to 24.5	2.0 to 2.5	14.5 to 18.1
Nozzle holder assembly	M20 x 1.5	49.0 to 68.6	5.0 to 7.0	36.2 to 50.6
*Cylinder head cover screw	M6 x 1	6.86 to 11.3	0.7 to 1.15	5.1 to 8.3
Injection pipe retaining nut	M12 x 1.5	24.5 to 34.3	2.5 to 3.5	18.1 to 25.3
Glow plug	M8 x 1	7.8 to 14.7	0.8 to 1.5	5.8 to 10.8
*Rocker arm bracket nut	M6 x 1	9.8 to 11.3	1.00 to 1.15	7.2 to 8.3
*Fan drive pulley screw	M12 x 1.5	117.7 to 127.5	12.0 to 13.0	86.8 to 94.0
*Idle gear shaft mounting screw	M6 x 1	9.8 to 11.3	1.00 to 1.15	7.2 to 8.3
*Connecting rod screw	M7 x 0.75	26.5 to 30.4	2.7 to 3.1	19.5 to 22.4
*Flywheel screw	M10 x 1.25	53.9 to 58.8	5.5 to 6.0	39.8 to 43.4
Bearing case cover mounting screw	M6 x 1	9.8 to 11.3	1.00 to 1.15	7.2 to 8.3
*Main bearing case screw 2	M7 x 1	26.5 to 30.4	2.7 to 3.1	19.5 to 22.4
*Main bearing case screw 1	M6 x 1	12.7 to 15.7	1.3 to 1.6	9.4 to 11.6

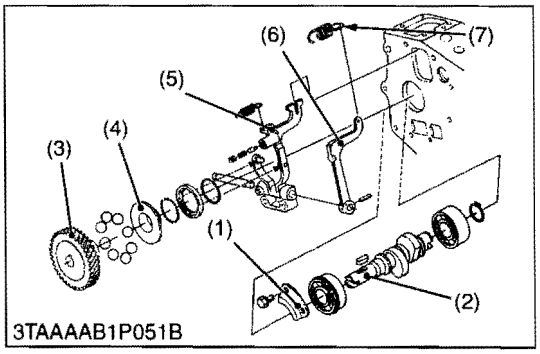
■ **NOTE**

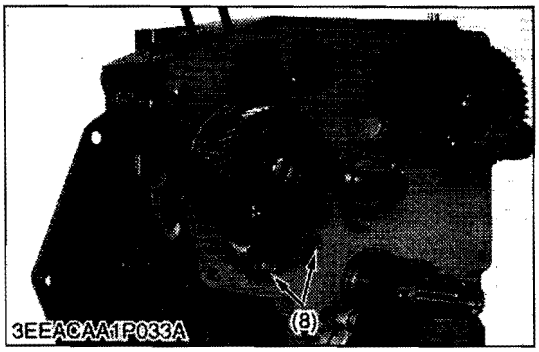
- **In removing and applying the bolts and nuts marked with "*", a pneumatic wrench or similar pneumatic tool, if employed, must be used with enough care not to get them seized.**
- **For * marked screws, bolts and nuts on the table, apply engine oil to their threads and seats before tightening.**
- **The letter "M" in Size × Pitch means that the screw, bolt or nut dimension stands for metric. The size is the nominal outside diameter in mm of the threads. The pitch is the nominal distance in mm between two threads.**

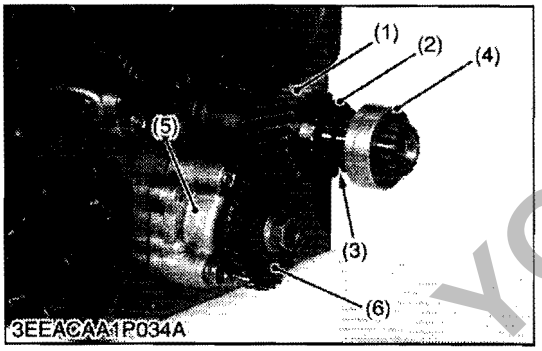
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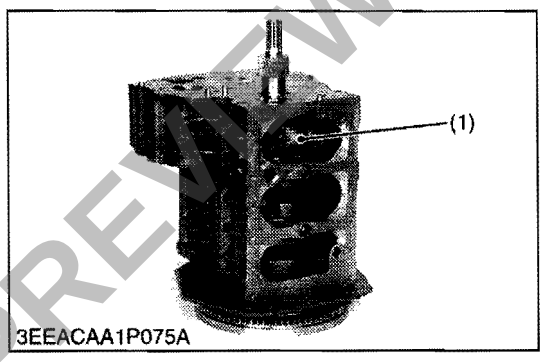
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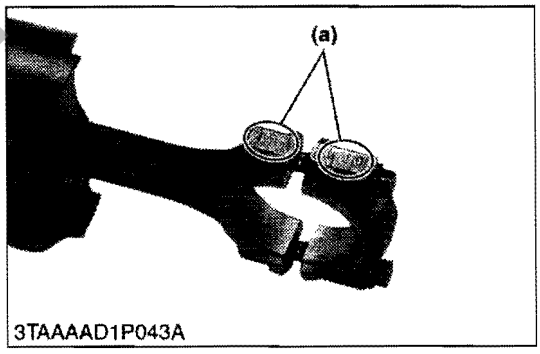






(5) Piston and Connecting Rod





Fuel Camshaft

1. Remove the retaining plate (1).
2. Remove the fork lever holder mounting screws (8), then draw out the injection pump gear (3) and fuel camshaft (2) with the governor fork assembly.

(When reassembling)

- Hook the governor spring (7) to the fork lever 2 (6) as shown in the figure before installing the fork lever assembly to the crankcase.

(1) Retaining Plate
(2) Fuel Camshaft
(3) Injection Pump Gear
(4) Governor Sleeve
(5) Fork Lever 1
(6) Fork Lever 2
(7) Governor Spring
(8) Fork Lever Holder Mounting Screw

W10178820

Oil Pump and Crankshaft Gear

1. Remove the oil pump gear (6).
2. Remove the oil pump (5).
3. Remove the collar (4), O-ring (3) and crankshaft oil slinger (2).
4. Remove the crankshaft gear (1) with a puller.

(When reassembling)

- Install the collar (4) after aligning the marks on the gears. (See page 1-S34 "**Idle Gear**".)

(1) Crankshaft Gear
(2) Crankshaft Oil Slinger
(3) O-ring
(4) Crankshaft Collar
(5) Oil Pump
(6) Oil Pump Gear

W10180290

Connecting Rod Cap

1. Remove the connecting rod caps (1) using a bihexagonal 8 mm socket.

(When reassembling)

- Align the marks **(a)** with each other. (Face the marks toward the injection pump.)
- Apply engine oil to the connecting rod screws and lightly screw it in by hand, then tighten it to the specified torque.
  If the connecting rod screw won't be screwed in smoothly, clean the threads.
  If the connecting rod screw is still hard to screw in, replace it.

Tightening torque	Connecting rod screw	26.5 to 30.4 N·m 2.7 to 3.1 kgf·m 19.5 to 22.4 ft-lbs

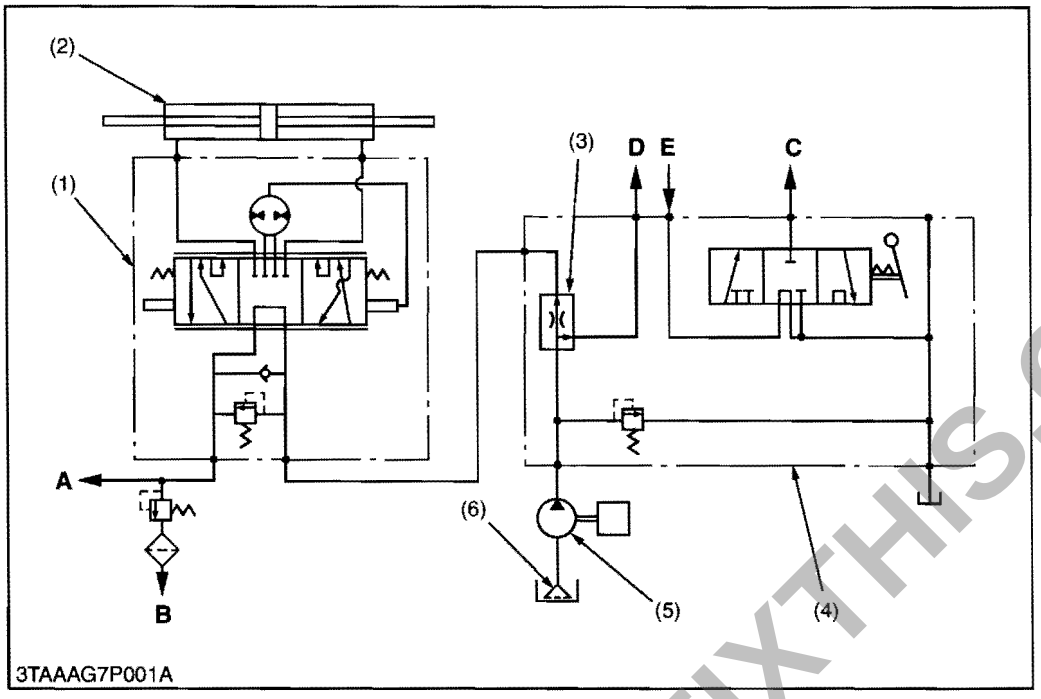
(1) Connecting Rod Cap **(a) Mark**

W10275480

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1. HYDRAULIC CIRCUIT



(1) Steering Controller
(2) Steering Cylinder
(3) Flow Priority Valve
(4) Hydraulic Control Valve Assembly
(5) Hydraulic Pump
(6) Oil Strainer

A : To PTO Clutch Valve
B : To HST
C : To Hydraulic Cylinder
D : To Implement
E : From Implement

W1012655

This model is provided with a full hydrostatic power steering.

In the full hydrostatic power steering, the steering controller is connected to the steering cylinder with only the hydraulic piping. Accordingly, it does not have mechanical transmitting parts such as steering gear, pitman arm, drag link, etc.. Therefore, it is simple in construction. This steering system consists of the oil strainer (6), hydraulic pump (5), flow priority valve (3), steering controller (1), steering cylinder (2), etc..

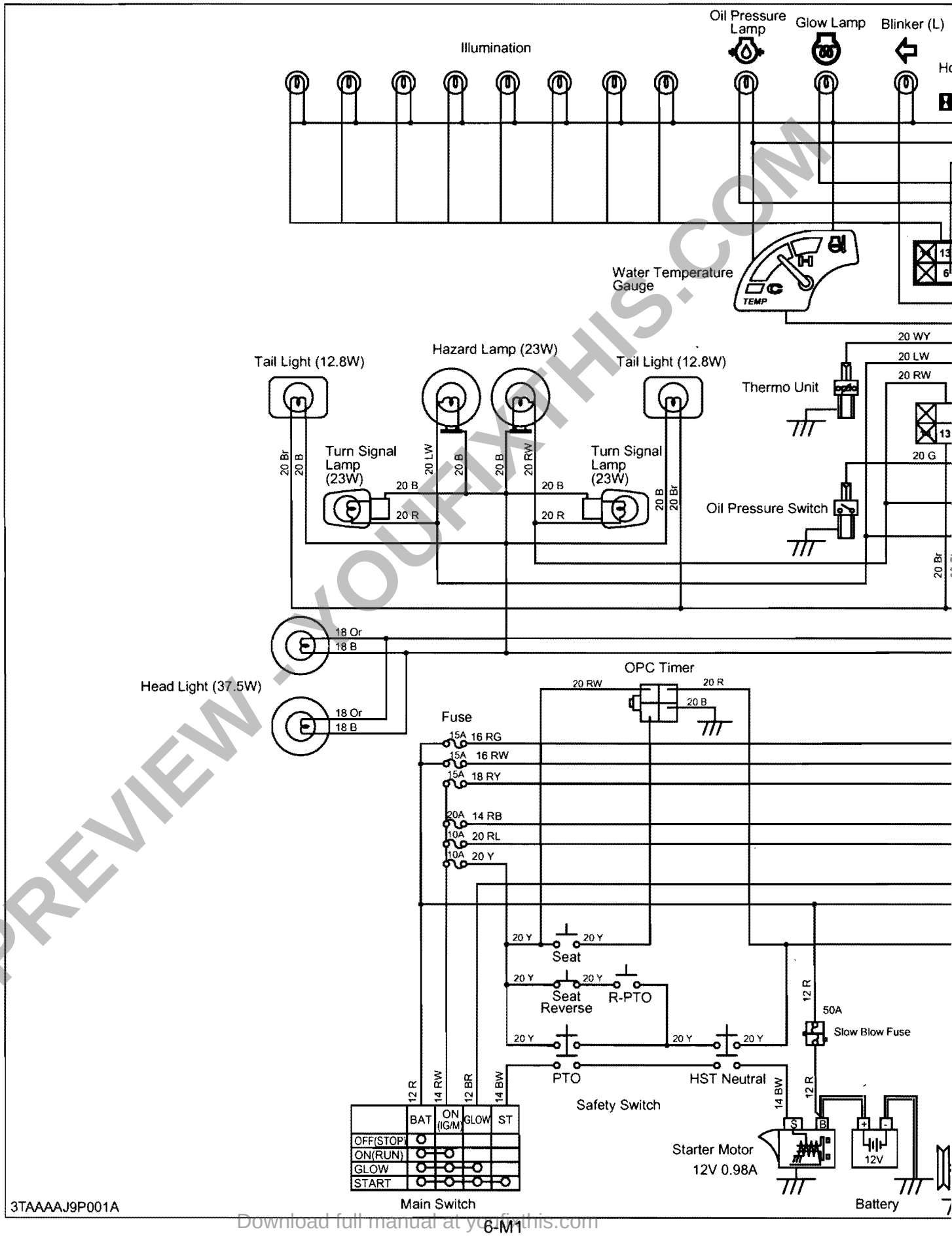
Flow priority valve (3) which located in the hydraulic control valve assembly (4) divides the oil into two direction. One is the control flow to power steering (constantly 8.0 L/min., 2.1 U.S.gals./min., 1.8 Imp.gals./min.), and the other is excessive flow to control valve of implement lift control.

By operating the power steering body, the required amount of oil is fed to the steering cylinder (2).

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1. WIRING DIAGRAM



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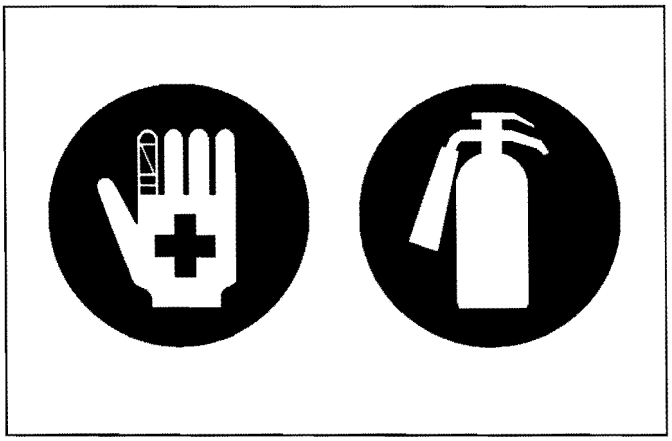
1. TROUBLESHOOTING

Symptom	Probable Cause	Solution	Reference Page
Engine Does Not Start	No fuel	Replenish fuel	G-7
	Air in the fuel system	Bleed	G-30
	Water in the fuel system	Change fuel and repair or replace fuel system	–
	Fuel pipe clogged	Clean	G-25
	Fuel filter clogged	Change	G-25
	Excessively high viscosity of fuel or engine oil at low temperature	Use specified fuel or engine oil	G-7
	Fuel with low cetane number	Use specified fuel	G-7
	Fuel leak due to loose injection pipe retaining nut	Tighten retaining nut	1-S25
	Incorrect injection timing	Adjust	1-S17
	Fuel camshaft worn	Replace	1-S35
	Injection nozzle clogged	Clean or replace	1-S26
	Injection pump malfunctioning	Replace	1-S30
	Seizure of crankshaft, camshaft, piston, cylinder or bearing	Repair or replace	1-S34
	Compression leak from cylinder	Replace head gasket, tighten cylinder head screw, glow plug and nozzle holder	1-S26, S27
	Improper valve timing	Correct or replace timing gear	1-S34
	Piston ring and cylinder worn	Replace	1-S35 to S37
	Excessive valve clearance	Adjust	1-S13
Starter Does Not Run	Battery discharged	Charge	G-17
	Starter malfunctioning	Repair or replace	6-S27
	Main switch malfunctioning	Repair or replace	6-S9
	Safety switches malfunctioning	Adjust or replace	6-S8, S9
	Wiring disconnected	Connect	–
Engine Revolution Is Not Smooth	Fuel filter clogged or dirty	Replace	G-19
	Air cleaner clogged	Clean or replace	G-18
	Fuel leak due to loose injection pipe retaining nut	Tighten retaining nut	1-S26
	Injection pump malfunctioning	Replace	1-S30
	Incorrect nozzle injection pressure	Adjust	1-S20
	Injection nozzle stuck or clogged	Repair or replace	1-S26
	Governor malfunctioning	Repair	1-S30

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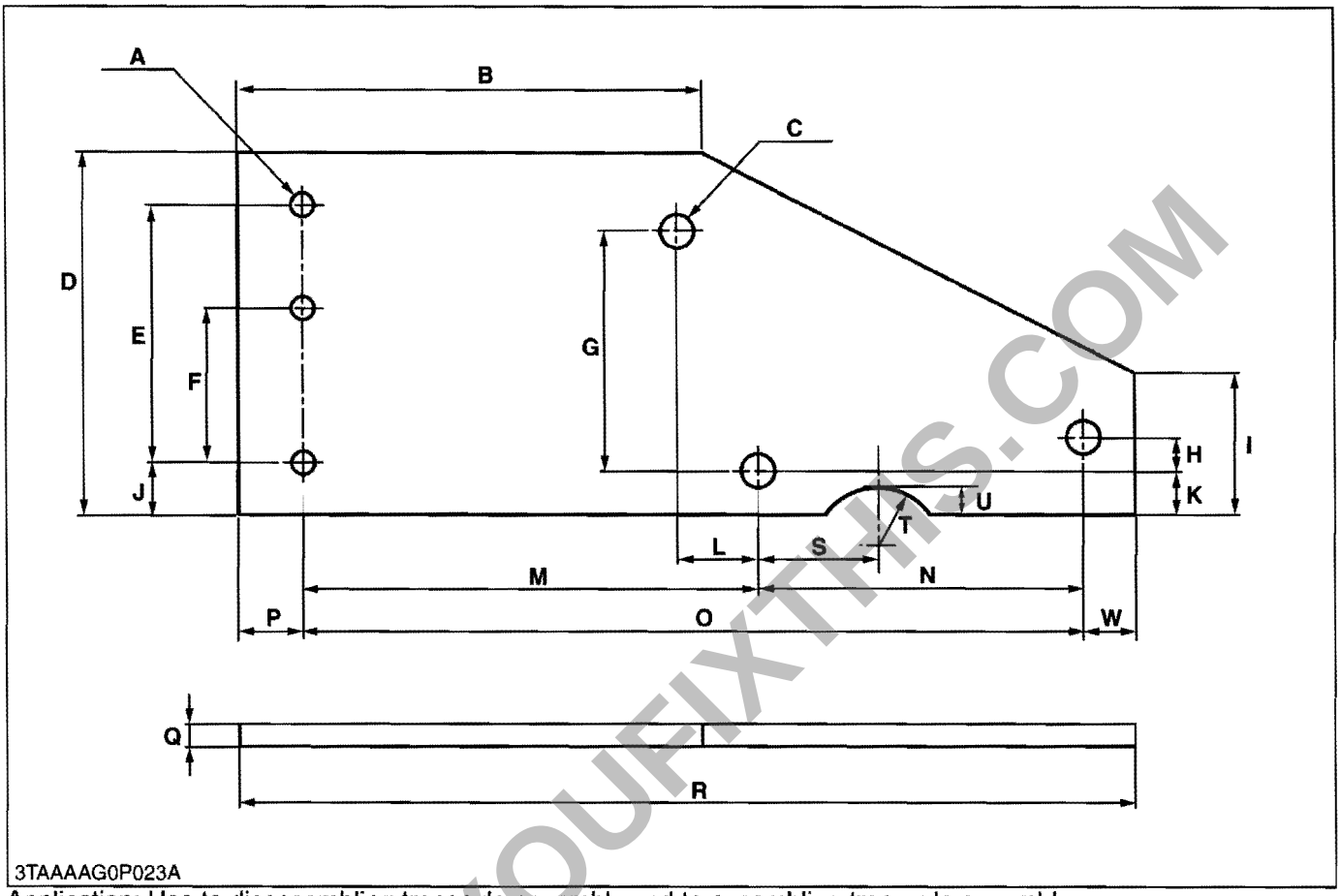
PREPARE FOR EMERGENCIES

- Keep a first aid kit and fire extinguisher handy at all times.
- Keep emergency numbers for doctors, ambulance service, hospital and fire department near your telephone.

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Disassembling and Assembling Stand (1/2)



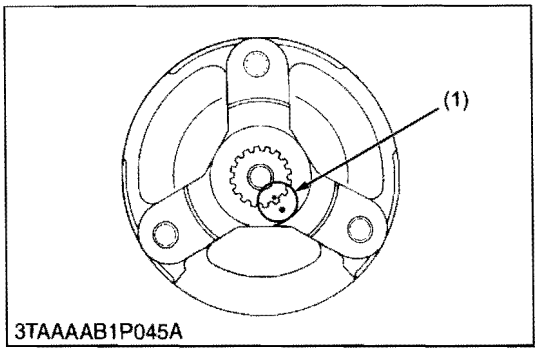
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Application: Use to disassembling transaxle assembly and to assembling transaxle assembly.

A	ϕ 9 mm (ϕ 0.35 in.) 3 Holes	L	30.5 to 31.5 mm (1.21 to 1.24 in.)
B	225 mm (8.86 in.)	M	226 mm (8.90 in.)
C	ϕ 13 mm (ϕ 0.51 in.) 3 Holes	N	125.5 to 126.5 mm (4.95 to 4.98 in.)
D	140 mm (5.51 in.)	O	352 mm (13.86 in.)
E	99.5 to 100.5 mm (3.92 to 3.95 in.)	P	25 mm (0.98 in.)
F	59.5 to 60.5 mm (2.35 to 2.38 in.)	Q	9.5 mm (0.37 in.)
G	92.5 to 93.5 mm (3.65 to 3.68 in.)	R	397 mm (15.63 in.)
H	12.5 to 13.5 mm (0.50 to 0.53 in.)	S	46 mm (1.81 in.)
I	55 mm (2.17 in.)	T	R 25 mm (0.98 in.)
J	20 mm (0.79 in.)	U	11 mm (0.43 in.)
K	17 mm (0.67 in.)	W	20 mm (0.79 in.)

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Fan Drive Pulley

1. Secure the flywheel to keep it from turning.
2. Remove the fan drive pulley screw.
3. Draw out the fan drive pulley with a puller.

(When reassembling)

- Install the pulley to crankshaft, aligning the mark (1) on them.
- Apply engine oil to the fan drive pulley retaining screws. And tighten them.

Tightening torque	Fan drive pulley screw	117.7 to 127.5 N·m 12.0 to 13.0 kgf·m 86.8 to 94.0 ft-lbs

(1) Alignment Mark

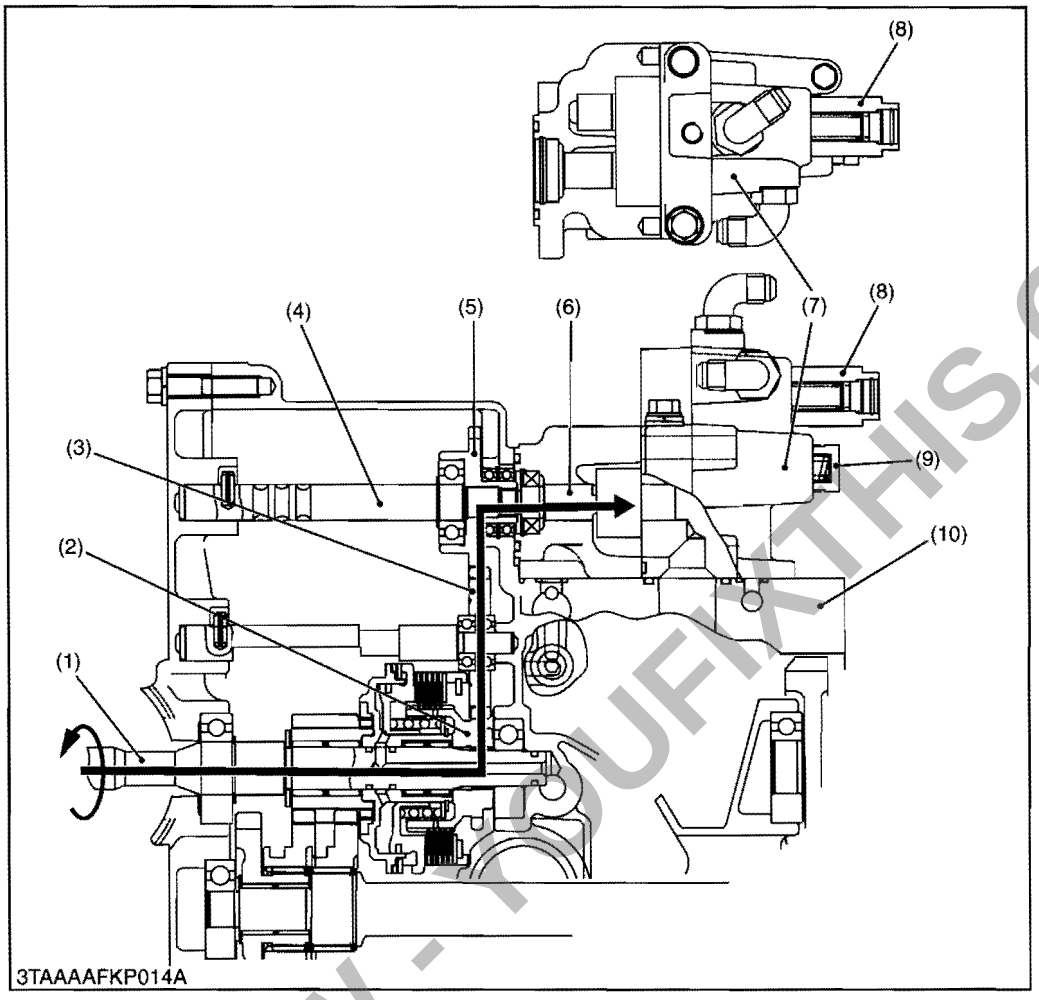
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4. OTHERS

[1] HYDRAULIC PUMP DRIVE GEAR SECTION



(1) HST Pump Shaft
(2) Spline Boss
(3) Idle Gear
(4) Hydraulic Pump Drive Gear Shaft
(5) Hydraulic Pump Drive Gear
(6) Hydraulic Pump Drive Gear Shaft
(7) Hydraulic Pump
(8) Flow Priority Valve
(9) Relief Valve (3P Hitch)
(10) Transmission Case

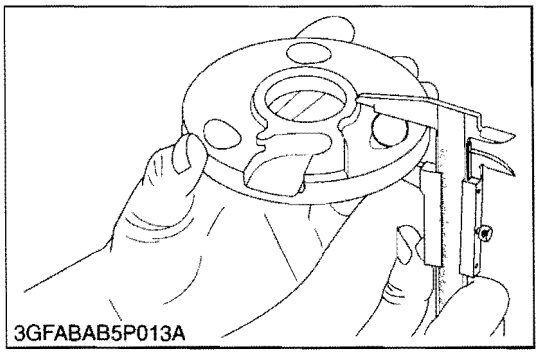
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The hydraulic pump (7) is mounted to the transmission case (10) and driven by the hydraulic pump drive gear (5).

The spline boss (2) mounted on the HST pump shaft drives the hydraulic pump drive gear (5) mounted on the hydraulic pump drive gear shaft (4) through the idle gear (3).

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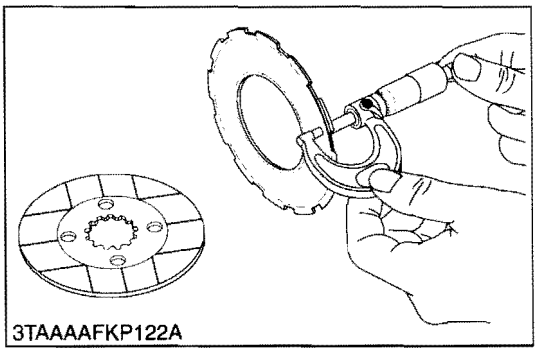

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Height of Cam Plate and Ball

1. Measure the height of the cam plate with the ball installed.
2. If the measurement is less than the allowable limit, replace the cam plate and balls.
3. Inspect the ball holes of cam plate for uneven wear.
4. If the uneven wear is found, replace it.

Height of cam plate and ball	Factory spec.	22.89 to 22.99 mm 0.9012 to 0.9051 in.
	Allowable limit	22.40 mm 0.8819 in.

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Brake Disc and Friction Plate Wear

1. Measure the brake disc thickness and the friction plate thickness with an outside micrometer.
2. If the thickness is less than the allowable limit, replace it.

Brake disc thickness	Factory spec.	3.30 to 3.50 mm 0.130 to 0.137 in.
	Allowable limit	3.0 mm 0.12 in.

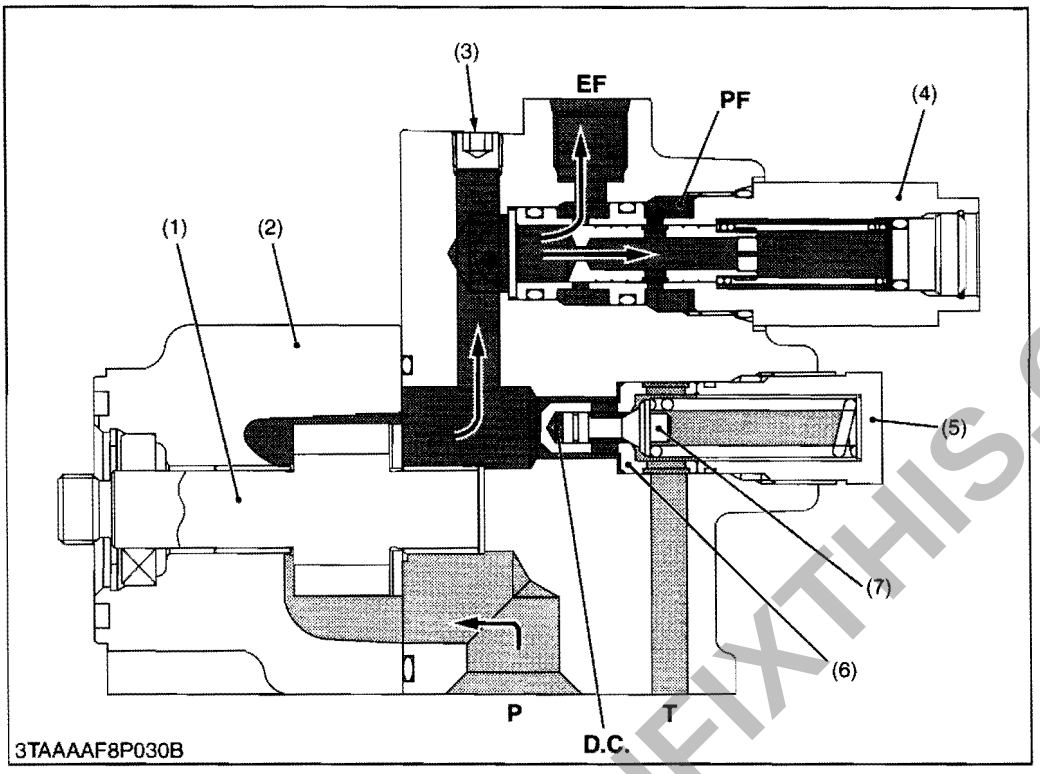
Friction plate thickness	Factory spec.	1.92 to 2.08 mm 0.0756 to 0.0818 in.
	Allowable limit	1.52 mm 0.0598 in.

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5. RELIEF VALVE



(1) Hydraulic Pump Gear
(2) Hydraulic Pump Case
(3) Plug
(4) Flow Priority Valve
(5) Relief Valve

EF :EF Port (To 3 Points Hitch Control Circuit)
PF :PF Port (To Power Steering, PTO Clutch and HST Circuit)
D.C.:Damping Chamber
P : Pump Port (Suction)
T : Tank Ports

W1015272

The implement control system circuit has a relief valve to restrict the maximum pressure in the circuit. The relief valve is located in the hydraulic control valve assembly.

The relief valve is a guide piston type with damping effect.

Among direct acting relief vales, this type is suited to higher pressure and has large capacity. Furthermore, this type is free from unstable operation, such as chattering, which occurs often in direct acting relief valves.

As shown in the figure, the guide is attached to the poppet (5) and a valve chamber **D.C.** (called the damping chamber) is formed at the top of the guide piston. The inlet of the valve leads to the chamber via a clearance between the sliding portion of the guide and the seat (6), minimizing valve vibration with the damping effect of the chamber.

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3. TIGHTENING TORQUES

Tightening torques of screws, bolts and nuts on the table below are especially specified.
(For general use screws, bolts and nuts : See page G-8.)

Item	N·m	kgf·m	ft-lbs
Starter **B** terminal nut	5.9 to 11.8	0.6 to 1.2	4.3 to 8.7

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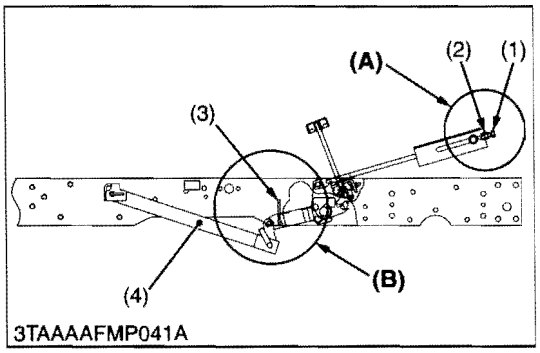
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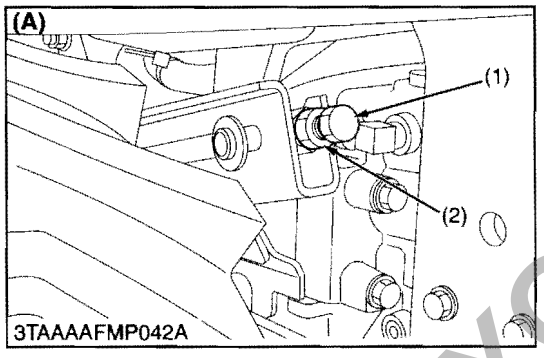
[7] MOWER ADJUSTMENT

CAUTION

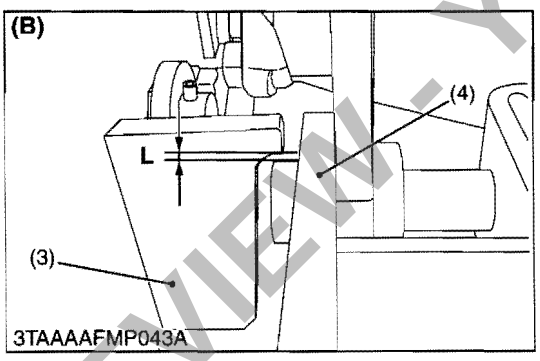
- **Park the tractor on a firm, flat and level surface and set the parking brake.**
- **Stoop the engine, remove the key, and allow the blades to stop before making adjustments.**
- **Wear heavy gloves or wrap end of blade with a rag when you handle blades.**
- **Before starting the engine, set the PTO clutch lever to off position and range gear shift lever to the neutral position.**



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Adjusting Mower Link

1. Tire pressure must be correct.
2. Move the hydraulic control lever rearward to raise the mower to the highest position.
3. Stop the engine and remove the key.
4. Adjust the left side links with bolt so that the clearance **L** is as follows.

Clearance (**L**) between stopper and rear link	Factory spec.	0 to 0.5 mm 0 to 0.02 in.

(1) Bolt
(2) Lock Nut
(3) Stopper
(4) Rear Link

L : 0 to 0.5 mm (0 to 0.02 in.)

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