TORQUE SPECIFICATIONS

TORQUE CHART

High-pressure relief valve	54 N·m (40 ft. lbs.)
Charge pump relief valve	94 N·m (70 ft. lbs.)
Transmission to flywheel housing	113 N·m (83 ft. lbs.)
Front to rear center section	47 - 61 N·m (35 - 45 ft. lbs.)
Center sections to hydro pump	71 N·m (38 ft. lbs.)
Hydro pump trunnion covers	27 N·m (20 ft. lbs.)
Control arm to pintle shaft	25 N·m (19 ft. lbs.)
Control arm to worm	97 N·m (72 ft. lbs.)

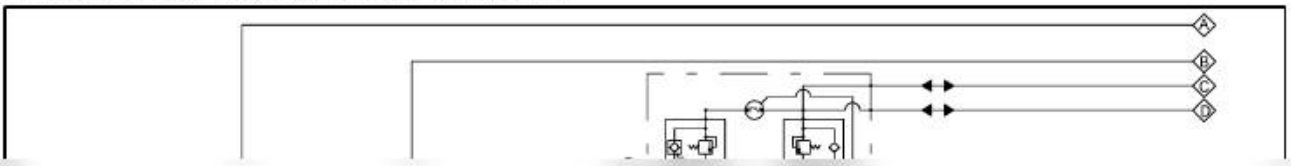
MOTOR AREA

Single-speed:	
End cap to housing	69 - 84 N·m (51 - 62 ft. lbs.)
Motor to wheel housing	137 N·m (101 ft. lbs.)
Double-speed:	
Front cover 3/8″	53 - 64 N·m (39 - 47 ft. lbs.)
Front cover 7/16″	81 - 100 N·m (60 - 74 ft. lbs.)
End cap to housing servo cover	13.6 -17.6 N·m (10 -13 ft. lbs.)
Motor to wheel housing	113 N·m (83 ft. lbs.)

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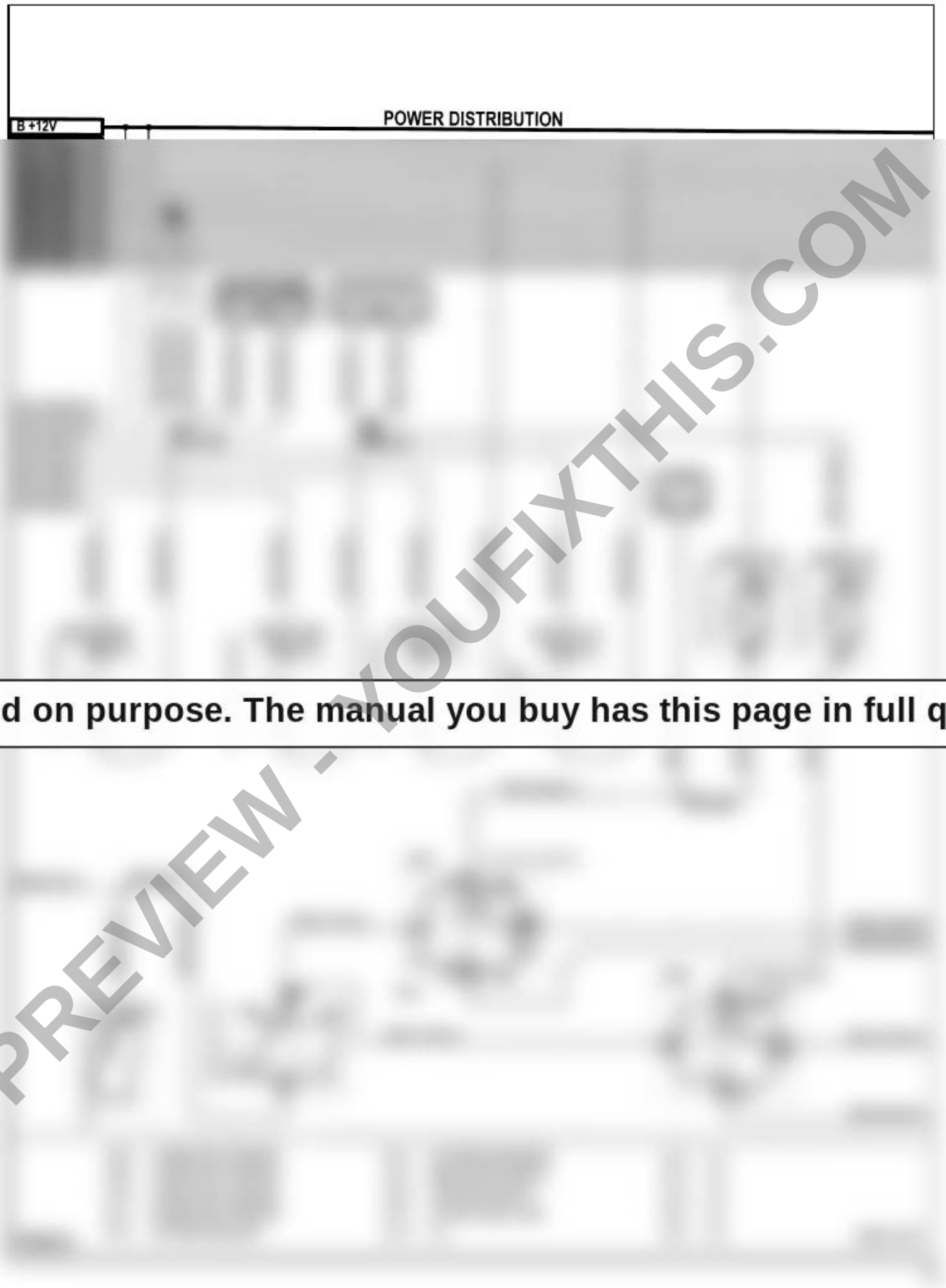
HW325 HYDRAULIC SYSTEM DIAGRAM



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Valve Identification Codes

All of the major components and ports are identified with code letters stamped into the manifold. The “L” code numbers correspond to coil identification numbers used on the machine electrical schematic.

The last two columns indicate the presence/absence of a particular component or line fitting on that model windrower. Diagrams of the components’ locations follow this chart.

HW305/305S/325 CONTROL VALVE MANIFOLD COMPONENTS			
CODE (COIL)	**DESCRIPTION**	**HW305/305S**	**HW325**
3A (L–28)	Parking Brake Release	YES	YES
3B (L–23)	2-Speed Drive Cylinders (Ground Drive)	NO	YES
4A (L–06)	Header Lift	YES	YES
4B (L–13)	Tilt Cylinder Retract	OPT	YES
5A (L–01)	Header Floatation Proportional	YES	YES
6A (L–08)	Accumulator Check Valve (Header Lower)	YES	YES
6B (L–10)	Header Float	YES	YES
8A	Check Valve (Lift Control)	YES	YES
8B	Check Valve (Lift Control)	YES	YES
10A (L–03)	Master Relief Valve	YES	YES
AD	Accumulator Dump	YES	YES
BRK	Parking Brake Release Connection	YES	YES
2SP	2-Speed Ground Drive Connection	NO	YES
TLT	Tilt Cylinder Retract Connection	OPT	YES
P1	Circuit Supply Port	YES	YES
P3	MFH Control Supply Connection	YES	YES
P4	Tilt Cylinder Extend Connection	OPT	YES
P5	Charge Pump Supply Port	YES	YES
P6	Diagnostic Coupler (Header Lift Pressure)	YES	YES
ML	SAE–6 HH Plug	YES	YES
ACC	Accumulator Supply Connection	YES	YES
HL	Header Lift Cylinder Retract Connection	YES	YES
T1	Tank Port #1 Main Return to Front Reservoir Filter Connection	YES	YES
T2	Tank Port #2 SAE-6 HH Plug	YES	YES
T3	Tank Port #3 SAE–8 HH Plug	YES	YES
RD	RH Lift Return (Manifold Port)	YES	YES
LD	LH Lift Return (Manifold Port)	YES	YES
MBV	Manual Biasing Valve (Header Balance)	YES	YES

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SPECIFICATIONS

Rear Tires
- Rating . . . . . 8 ply rating
- Type . . . . . Grooved implement
- Size . . . . . 37 x 14–16.1
- Inflation pressure . . . . . 97 kPa (14 PSI)

Rear Axle Clearance
- Height . . . . . 1001 mm (39.4 in.)

Channel Widths (spindle to spindle)
- Minimum . . . . . 2286 mm (90 in.)
- Plus 12″ (6″ each side) . . . . . 2666 mm (105 in.)
- Maximum . . . . . 3048 mm (120 in.)

Tractor Weight
- HW325 . . . . . 4966 kg (10,950 lbs.)

Axle Spring Features
- Load range (isolator) . . . . . 635 – 3545 kg (1400 – 7815 lbs.)
- Design height range (isolator) . . . . . 203 – 254 mm (8.0 – 10.0 in.)
- Useable stroke (actuator) . . . . . 274 mm (10.8 in.)
- Assembly weight . . . . . 7.6 kg (16.9 lbs.)
- Temperature range . . . . . –55 – 70°C (–67 – 158°F)
- Working pressure . . . . . 172 – 276 kPa (25 – 40 psi)

Tightening Torques
- Axle extension bolts . . . . . 960 N·m (710 ft. lbs.)
- Pivot pin bolts . . . . . 400 N·m (295 ft. lbs.)
- Fork shaft bolt . . . . . 400 N·m (295 ft. lbs.)
- Axle shaft bracket to fork . . . . . 108 N·m (80 ft. lbs.)
- Wheel to wheel hub . . . . . 115 N·m (85 ft. lbs.)
- Axle nut . . . . . 271 N·m (200 ft. lbs.)
- Air fitting . . . . . 27 N·m (20 ft. lbs.)
- Air spring retaining bolts (lower) . . . . . 67 N·m (50 ft. lbs.)
- Center retaining nut . . . . . 104 N·m (75 ft. lbs.)
- Air spring retaining nut . . . . . 34 N·m (25 ft. lbs.)
- Air fitting stud . . . . . 67 N·m (50 ft. lbs.)

NOTE: *Use 277 Loctite on threads of all bolts and nuts in this section.*

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SECTION 10 - ENGINE

Chapter 1 - Engine

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SECTION 58 - HEADER ATTACHMENTS

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