



**ORION XL/ORION XL PROFESSIONAL
Models 2500 & 25J1
November 1991-1993**

OWNERS INFORMATION

MACHINE MODEL NO: _____

SERIAL NO: _____

Located on label inside transmission housing

B&S ENGINE MODEL NO: _____ **TYPE** _____ **CODE** _____

DATE OF PURCHASE: _____

ISSUED TO:

OWNERS NAME: _____

ADDRESS: _____

TOWN/CITY: _____

STATE: _____

ISSUED BY:

**AUTHORISED COX DEALER/
DISTRIBUTOR:** _____

ADDRESS: _____

TOWN/CITY: _____

STATE: _____

PRE DELIVERY CHECK LIST

Check parts q Assemble q Service q Instruction q

ALWAYS KEEP THIS MANUAL IN A SAFE PLACE.

SAFETY INSTRUCTIONS

- Read, understand, & follow all instructions in the Owner/ Operators manual.
- Know the controls and how to stop the engine quickly in an emergency.
- Allow only responsible adults, who are familiar with the Instructions in this manual, to operate the machine.
- Clear the area to be mowed of loose objects such as sticks, stones, bones, wire, toys, debris, etc., which could be picked up and thrown by the blades.
- DO NOT mow whilst people, especially children, or pets are in the mowing area.
- DO NOT mow either direction on slopes beyond 15 degrees (1 in 3.75)
- Exercise extreme caution on slopes.
- Reduce speed on slopes and in sharp turns to prevent overturning or loss of control.
- Start or stop slowly when on slopes.
- Mow up and down slopes, not across the slope.
- Stay alert for holes or bumps in the terrain and other hidden hazards.
- Use care when pulling loads-
 - a] Use only approved hitch point;
 - b] limit loads to those you can safely control;
 - c] Do not turn sharply;
 - d] use care when backing up.
- Maximum weight on tow hitch (9kg).
- Maximum tow weight (Trailer & Load 130kg).
- DO NOT use ground engaging attachments, Dozer Blade, Plough etc.
- Watch out for traffic when crossing or operating the mower near roadways.
- Stop the blades rotating before crossing surfaces other than grass.
- When using attachments, never direct discharge of material toward bystanders nor allow anyone near the machine while it is in operation.
- Before leaving the operators position-
 - a] Disengage all clutches and secure cutting units;
 - b] Return drive pedal to neutral position and set the parking brake;
 - c] Stop the engine and remove the key.
- Disengage drive to attachments and stop engine-
 - a] Before refueling.
 - b] Before removing grass-catcher;
 - c] Before clearing blockages from chute;
 - d] Before checking, cleaning or working on the mower;
 - e] After striking a foreign object (check the mower for damage and make repairs before restarting and operating the equipment);
 - f] If machine starts to vibrate abnormally (check immediately).
- Disengage drive to attachments when transporting or not in use.
- A mower operator should be in good physical and mental health and not under the influence of alcohol or any drug which might impair vision, co-ordination or judgment.
- Never mow while barefoot or wearing open sandals or thongs. Wear long trousers and heavy shoes.
- It is advisable to wear suitable eye protection when operating a mower.
- Mow only in daylight or good artificial light.
- Before using, always visually inspect to see that blades, bolts and cutter assembly are not worn or damaged. Replace worn or damaged blades and bolts in sets to preserve balance.
- Check all nuts, bolts, and screws often; always be sure the mower is in safe operating condition.
- Keep safety devices (guards and switches) in place and in working order.
- Never use the mower unless the grass catcher, or guards provided by the manufacturer, are in position.
- Ensure any replacement parts used comply with the original manufacturer's recommendations and specifications.
- Replace worn or faulty silencers.
- Keep machine free of grass, leaves or other debris, excessive oil, grease, or spilt fuel. These can be a fire hazard.
- Refuel outdoors only. Do not smoke while fueling engine. Never remove the cap of the fuel tank or add petrol while the engine is running or the engine is hot. Remove fuel cap slowly to relieve any tank pressure. If fuel is spilled, do not attempt to start the engine but move machine away from the area of the spill and avoid creating any source of ignition until fuel vapors have dissipated.
- Check for fuel leaks while refueling, before and while using the mower. If a fuel leak is found, do not start or run the engine until the fuel leak is fixed and spilled fuel is wiped away.
- Do not operate engine in a confined space where exhaust fumes (carbon monoxide) can collect.
- Always mount the mower from the left or the opposite side to the discharge chute.
- Start the engine carefully with the cutting means disengaged.
- Do not over-speed the engine or alter governor settings. Excessive speed is dangerous and shortens mower life.
- Stop the engine whenever you leave the mower, even for a moment.
- Store the mower in a well-ventilated room away from naked flames such as may be found in hot water heaters.
- Do not lend or sell the mower, without the owners/ operators Manual.

OPERATING AND MAINTENANCE INSTRUCTIONS

IMPORTANT

When starting electric start machine, place right heel on micro switch located on rear of footrest. Ensure that cutter is disengaged, otherwise electric starter motor will not engage. If engine is cold move throttle to cold start position and return to desired throttle setting when engine starts. Do not attempt to operate engine with throttle lever in cold start (choke) position. (Note electric start engines fitted with recoil can be manually started with cutter disengaged and ignition on).

Keep feet and hands clear of mowing attachment when starting and operating machine.

Do not use mowing attachment with broken or bent blades, damaged or worn bolts and nuts or damaged cutter disc, otherwise damage and premature wear will result from vibration. Replace blades, bolts and nuts only in pairs to maintain correct balance.

DO NOT USE WITHOUT WINDROWER

Check all bolts and nuts after first hour of running to ensure trouble free service and adjust engine to clutch belt. (Refer instructions)

Mount and dismount only from left hand side of machine.

Reference to left or right hand side of machine is determined by sitting in the operating position on the machine.

Make sure ignition switch is turned to the off position And Key Removed For Security when machine is not in use.

TO OPERATE

BEFORE STARTING: See Engine Maintenance/Instruction Sheet.

DISENGAGING MOWING ATTACHMENT: The disengaging lever is situated on the right hand side by the steering column. Before starting, disengage mowing attachment by pulling lever fully to the operator. For safety it is advisable at all times, other than when mowing, that the mowing attachment be kept in the disengaged position.

TO DRIVE FORWARD/REVERSE: Power is regulated by the throttle. Set throttle control to desired engine power. Press down on the forward section of the clutch pedal for forward movement, on the rear of the clutch pedal for reverse. The amount of pressure can be used to control the ground speed, especially in heavier conditions.

MANOEUVRING: Owing to the heel and toe type action of the drive pedal, it is possible to take the machine straight from forward to reverse and vice versa. This instant forward and reverse operation makes the machine very manoeuvrable and the sharpest turns can be negotiated easily and quickly.

TO BRAKE (WITH ENGINE RUNNING): The clutch may be used to stop the machine. If travelling forward push the pedal into reverse until machine stops, then bring the pedal back to neutral position or vice versa if travelling in reverse.

TO BRAKE (WITH ENGINE STOPPED): The parking brake only must be used. Otherwise damage to clutch cone will occur. Parking brake is also emergency 'stop' and transport brake.

CUTTING HEIGHT ADJUSTMENT: The height adjustment lever is located on the left hand side of the machine and may be altered to suit varying conditions, while the machine is in motion.

NOTE: *When mowing slopes, leave machine in forward drive when going down hill. The low gearing will prevent it from picking up excessive speed. If very steep it may be necessary to throttle back slightly. Avoid holding machine on slopes using clutch with engine running and machine stationery as damage will occur to clutch plates.*

MAINTENANCE INSTRUCTIONS

IT IS THE OWNERS RESPONSIBILITY TO ENSURE THAT ALL PERIODICAL CHECKS, NECESSARY ADJUSTMENTS AND SERVICES ARE CARRIED OUT.

STOP ENGINE - NEVER ATTEMPT ANY FORM OF SERVICE OR ADJUSTMENT WITH ENGINE RUNNING, REMOVE SPARK PLUG LEAD. MAKE SURE THE BLADES HAVE STOPPED ROTATING BEFORE CARRYING OUT ANY ADJUSTMENT.

1. OIL CHANGING (ENGINE): See Engine Maintenance/Instructions Sheet and carry out as per Engine Manufacturers Recommendation.

2. LUBRICATION OF MACHINE: Lubrication of machine should be carried out every 25 hours of operation or once a month, whichever falls due first. Service engine and lubricate machine more frequently under adverse conditions.

A. OILING: A few drops of oil should be placed at the following points:- steering column shaft (top and bottom), steering linkage, disengaging linkages, height adjustment mechanism, pivot bolt and linkages on clutch arm and clutch pedal.

B. CHAIN:- Use only chain lube for lubricating the drive and steering chains .

C. GREASE POINTS:- Grease nipples are located on the front wheel stub axle bushes.

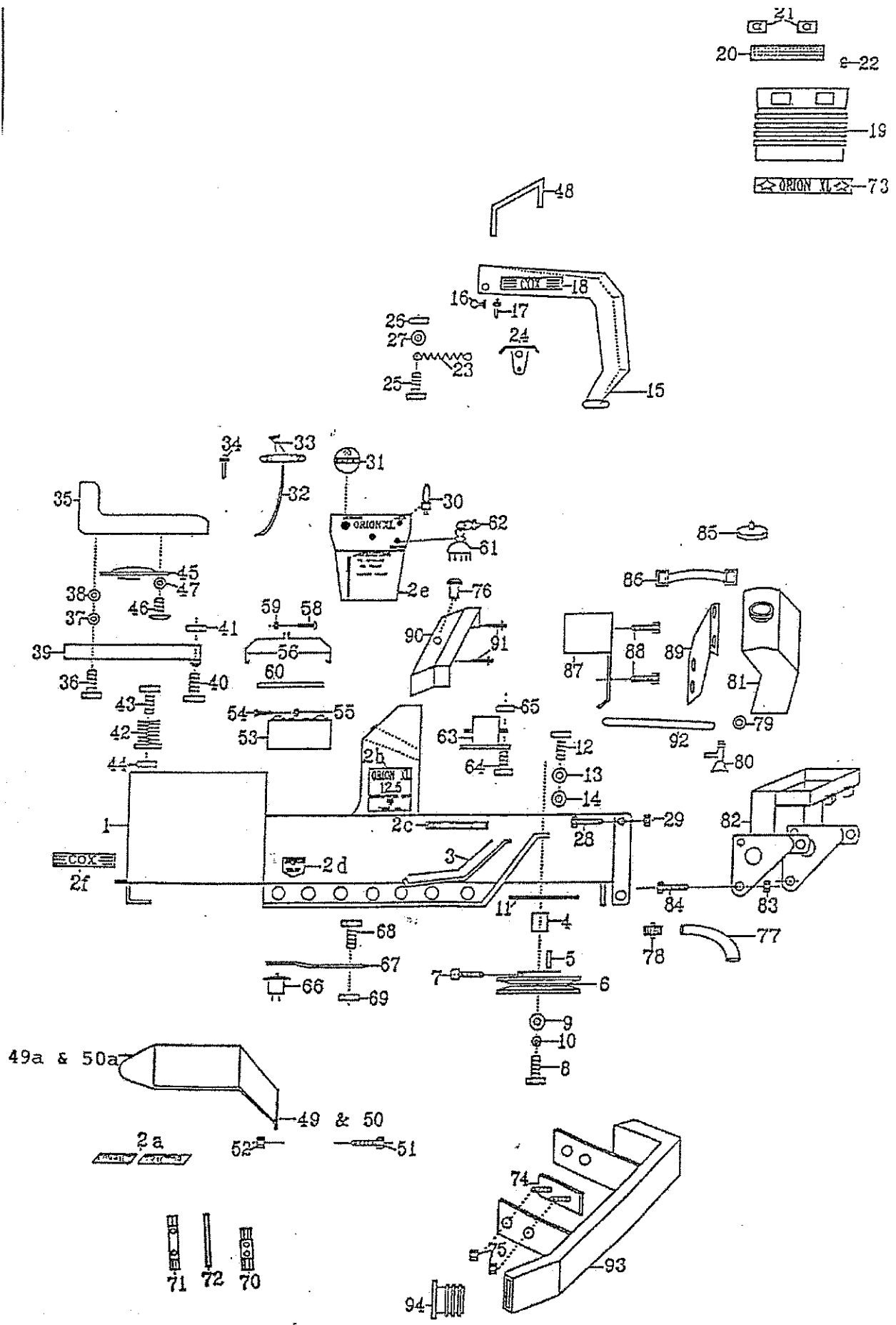
UNDER NO CIRCUMSTANCES ALLOW GREASE OR OIL TO COME INTO CONTACT WITH THE CLUTCH CONE OR THE CLUTCH PLATE. SHOULD THIS OCCUR, CLEAN OFF IMMEDIATELY WITH PETROL.

3. TO CHECK BLADES:- Stop engine. Remove spark plug lead. Lift windrower and height adjustment control to highest position. If necessary simply remove the blade bolt and nut using a suitable spanner and replace worn parts.

4. CUTTER TO CLUTCH VEE BELT:- Tension is automatically adjusted by the belt tensioning springs. However, as the belt stretches it will be necessary to lower the rear of the cutter housing by loosening the rear lifting link nut to level the cutter housing and vice versa when a new belt is fitted. Check belt tension and level cutter at machine service period (every 25hrs or more frequently is required).

5. ENGINE TO CLUTCH VEE BELT ADJUSTMENT:- Loosen the four engine mounting bolts. Move engine forward and adjust belt firmly. Do not over tension. While maintaining tension on the engine re-tighten bolts. Check belt tension at machine service period (25hrs) or more frequently under heavy mowing conditions.

ORION XL & ORION XL PROFESSIONAL25J1 GROUP 11: CHASSIS & COMPONENTS

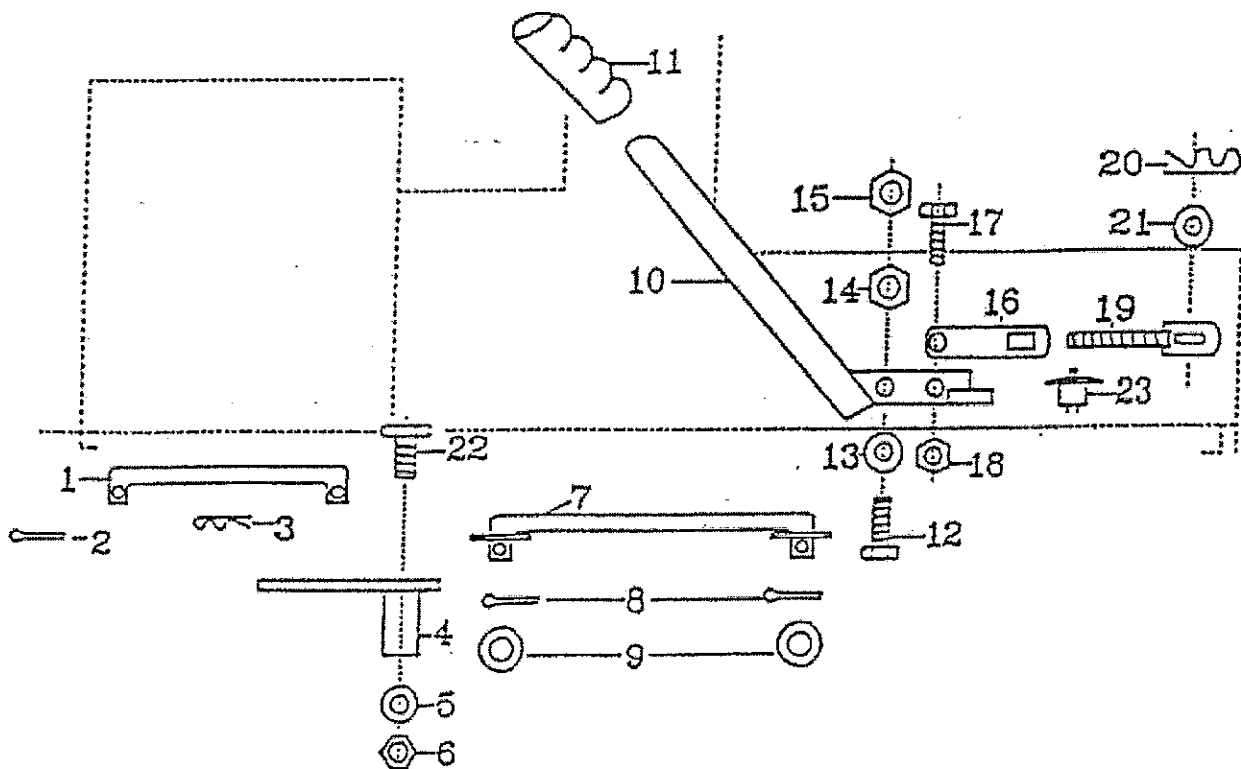


ORION XL & ORION XL PROFESSIONAL25J1 GROUP 11: CHASSIS & COMPONENTS

Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	251101C96	Chassis NLA	46	SR0408W	Seat Micro Attach Bolt (2)
2a	TR53	Transfer-Compact Tractor NLA	47	W04S	Seat Micro Att. Washer (2)
2b	STR58	Transfer – 12.5HP	48	AM179	Bonnet Trim
2c	TR52	Transfer – Out Cutter In NLA	49	251102Q2M/B	Mudguard LH NLA
2d	STR51	Transfer – Depress to Start	49a	AM302	Mudguard LH
2e	STR55	Transfer – Orion XL Dash NLA	50	251103	Mudguard RH NLA
2f	TR01J1	Transfer – 'COX'	50a	AM303	Mudguard RH
3	NSM01	Non-Skid Material Clutch Pedal	51	SH0408C	Mudguard Ret. Bolt (4)
4	AM233	Engine Pulley Spacer	52	N04CN	Mudguard Ret. Bolt Nut (4)
5	AM175	Engine Pulley Key	53	AM109	Battery
6	AM234	Engine Pulley	54	SH0412C	Terminal Bolt (2)
7	GS0505C	Engine Pulley Key Screw	55	N04C	Terminal Bolt Nut (2)
8	SH0720F	Engine Pulley Retaining Bolt	56	AM300	Battery Clamp (2)
9	W072004	Eng. Pulley Ret. Bolt Washer	58	SR0420C	Battery Clamp Screw
10	W07S	Ret. Bolt Shakeproof Washer	59	N04C	Clamp Screw Nut
11	AM078B0	Engine Mtg. Bolt Plate (2)	60	AM098M8	Battery Cover
**	251114	Engine Mtg. Bolt Plate (2)	61	AM014	Ignition Switch
12	B0524C	Engine Mounting Bolt (4)	62	AM015	Ignition Switch Key
**	B0620TFS	Engine Mounting Bolt (4)	63	AM159	Solenoid
13	WS050216	Engine Mtg. Spring Washer (4)	64	SH0408C	Solenoid Mounting Bolt (2)
14	W051216	Engine Mtg. Bolt Washer	65	N04CN	Solenoid Mtg. Bolt Nut (2)
15	KIT52B/M	Bonnet Complete NLA	66	AM092	Micro Switch
	SAM235	Bonnet NLA	67	AM100R2	Foot Micro Spring Plate
16	SAM178M	Bonnet Strap Pillar (2) NLA	68	SH0408C	Spring Plate Bolt
17	PR0306R	Bonnet Strap Pillar Rivet (2)	69	N04CN	Spring Plate Bolt Nut
18	SAM219	'COX' Badge (2)	70	AM005G0	Spark Plug Spanner
19	AM224F3	Bonnet Grill	**	AM295	Spark Plug Spanner
20	AM222	Head Light Lens	**	AM296	Spark Plug Tommy Bar
	ST0610	Lens Ret. Screw (2)	71	AM006C1	Tube Spanner
21	AM221	Head Light Reflector	72	AM007	Tommy Bar
22	AM228	Lamp (2)	73 **	S251104	ORION XL Badge
23	AM180	Bonnet Spring (2)	74 **	AM278	Inner Plate (2)
24	AM181	Bonnet Strap (2)	75 **	NF06CN	Inner Plate Retaining Nut (4)
25	SH0408C	Bonnet Spring Bolt (2)	76 **	AM289	Oil Pressure Light
26	N04CN	Bonnet Spring Nut (2)	77 **	AM291	Oil Drain Pipe
27	W040816	Bonnet Spring Washer (2)	78 **	AM292	Oil Drain Nipple
28	SH0412C	Bonnet Hinge Bolt (2)	79 **	AM294	Fuel Tank Grommet
29	N04CN	Bonnet Hinge Bolt Nut (2)	80 **	AM293	Petrol Tap
30	AM229	Light Switch	81 **	251105F3	Fuel Tank
31	AM211	Hourmeter	82 **	251106H95	Fuel Tank Bracket
32	KIT51S2	Throttle Cable c/w Lever	83 **	N06CN	Fuel Tank Brkt Nut Lower (2)
33	AM088	Throttle Lever	84 **	SH0616C	Fuel Tank Brkt Bolt Lower (2)
34	PR0306	Throttle Lever Rivet (2)	85 **	231126	Petrol Cap
35	AM164	Seat	86 **	S251108	Petrol Tank Restraining Strap (2)
36	SH0512C	Seat Retaining Bolt (4)	87 **	S251111	Muffler Heat Shield
37	W05S	Seat Ret. S/P Washer (4)	88 **	SH0620M	Muffler Heat Shield Bolt (2)
38	W052002	Seat Ret. Bolt Washer (4)	89 **	251110	Fuel Tank Heat Shield NLA
39	AM226B99F	Seat Mount	90 **	251112	Bonnet Extension
40	SH0516C	Seat Mount Hinge Bolt (2)	91 **	PR0306	Bonnet Extension Rivet (5)
41	N05CN	Hinge Bolt Nut (2)	92 **	S251113	Fuel Line
42	AM177	Seat Spring (2)	93 **	251107B	Bumper Bar NLA
43	SH0612C	Seat Spring Ret. Bolt (2)	94 **	AM277	End Cap (2)
44	N06CN	Ret. Bolt Nut (2)			
45	AM165	Seat Micro Switch	**	DENOTES SKIT50	14HP Professional Only Head Light Kit

ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 12: RIGHT HAND SIDE OF CHASSIS

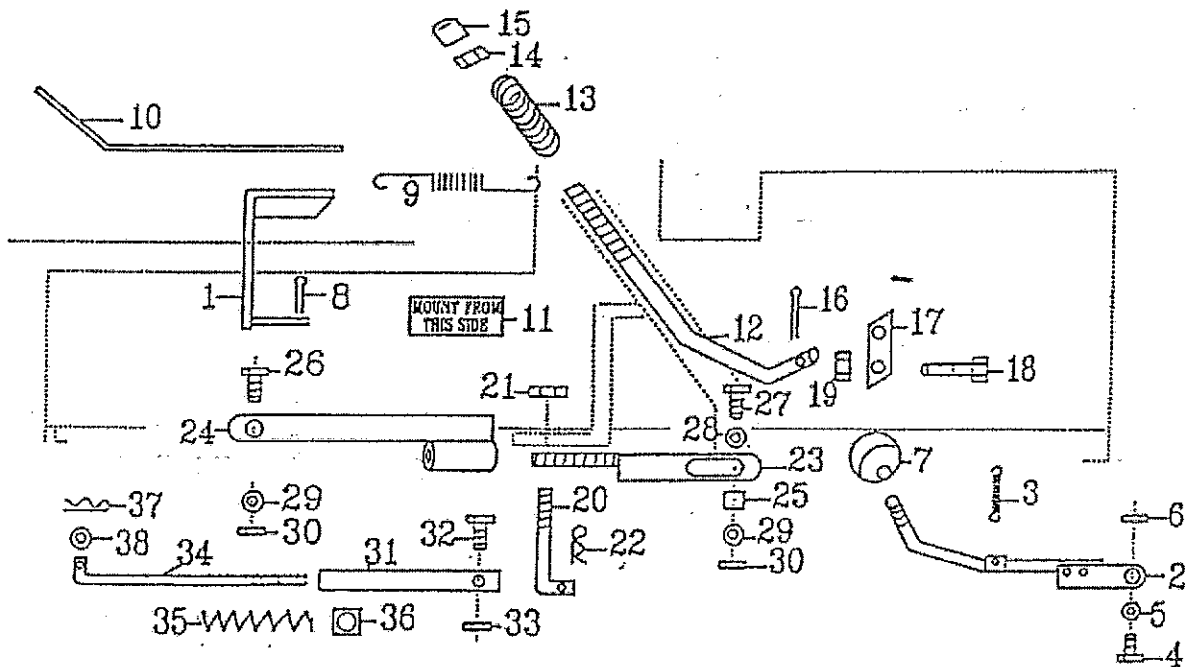
Ref No.	Part No.	Description
1	AM238	Clutch Rod Short
2	CP3-220	Clutch Rod Short Split Pin
3	RP01	Clutch Rod Short 'R' Pin
4	AM182E94	Clutch Rod Short Pivot Plate
5	W061216	Clutch Rod Pivot Plate Washer
6	N06CN	Clutch Rod Pivot Plate Nut
7	251201	Clutch Rod Long
8	CP3-220	Clutch Rod Long Split Pin (2)
9	W071416	Clutch Rod Long Washer (2)
10	AM239H0	Disengaging Handle
11	AM009	Handle Grip
12	B0625C	Disengaging Handle Pivot Bolt
13	W061214	Pivot Bolt Washer (2)
14	N06C	Disengaging Handle Pivot Bolt Nut
15	N06CN	Pivot Bolt Lock nut
16	AM240	Disengaging Adjuster Bushed
17	SH0512C	Disengaging Adjuster Bolt
18	N05C	Disengaging Adjuster Bolt Nut
19	AM241	Disengaging Adjuster Threaded
20	RP01	Disengaging Adjuster 'R' Pin
21	W051216	Disengaging Adjuster Washer (2)
22	B0636C	Clutch Pivot Plate Bolt
23	AM092	Disengaging Micro Switch



ORION XL & ORION XL PROFESSIONAL

25J1 GROUP 13: LEFT HAND SIDE OF CHASSIS

Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	AM285	Brake Pedal	20	AM185B0	Cutter Housing Lifting Link
2	AM284K94	Hand Park Brake	21	N06CN	Cutter Lifting Link Nut
3	AM288	Hand Brake Spring	22	RP02	Cutter Lifting Link 'R' Pin
4	B0624C	Hand Park Brake Bolt	23	AM267	Front-Rear Conn. Rod Thrd.
5	W061216	Hand Park Brake Washer	24	AM268	Front-Rear Conn. Rod Bushed
6	N06CN	Hand Park Brake Nut	25	AM249	Connecting Rod Bush
7	AM290	Hand Brake Knob	26	SH0616C	Front-Rear Conn. Rod Bolt Front
8	CP3-220	Brake Pedal Split Pin	27	B0620C	Front-Rear Conn. Rod Bolt Rear
9	AM183	Brake Pedal Spring	28	W0620HD	Conn. Rod Rear Bolt Washer
10	NSM25	Non Skid Material Foot Rest	29	W061216	Conn. Rod Bolt Washer (2)
11	STR05	Transfer - Mount This Side	30	N06CN	Connecting Rod Bolt Nut (2)
12	AM143M9	Height Adj. Pawl Push Rod	31	AM034H0	Cutter Brake Adjusting Bracket
13	AM012	Height Adj. Push Rod Spring	32	SH0512C	Cutter Brake Adj. Bracket Bolt
14	N04C	Height Adj. Push Rod Lock Nut	33	N05CN	Cutter Brake Adj. Brkt Bolt Nut
15	AM013Q2	Height Adj. Push Rod Button	34	251301	Cutter Brake Adjusting Rod
16	CP2-512	Height Adj. Push Rod Split Pin	35	AM035	Cutter Brake Spring
17	AM011	Height Adj. Pawl Split Pin	36	NS05C	Cutter Brake Adjusting Rod Nut
18	SH0516C	Height Adj. Pawl Pivot Bolt	37	RP01	Cutter Brake Adj. Rod 'R' Pin
19	N05CN	Height Adj. Pawl Pivot Bolt Nut	38	W051216	Cutter Brake Adj. Rod Washer

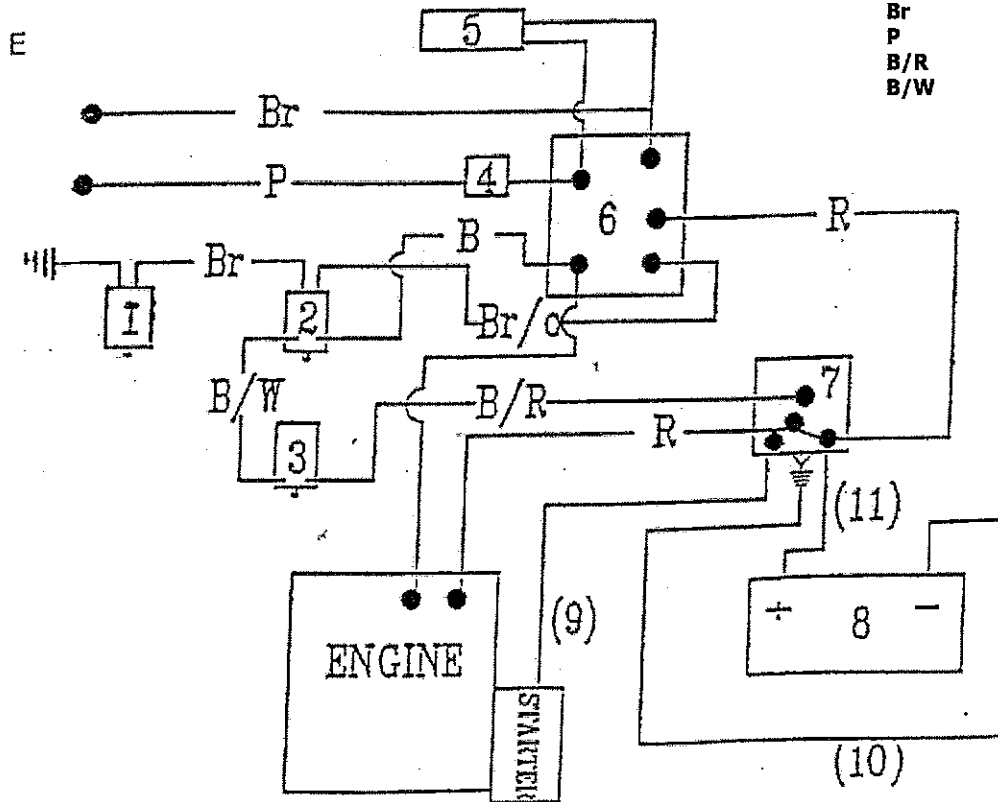


ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 14: ELECTRICAL

Ref No.	Part No.	Description
1	AM165	Seat Micro
2	AM092	Disengaging Micro
3	AM092	Foot Micro
4	AM229	Light Switch
5	AM211	Hourmeter
	SAM247	Hourmeter Lead NLA
6	AM014	Ignition Switch
	AM015	Ignition Key (2)
7	AM159	Solenoid
8	AM109	Battery
9	AM265	Lead - Starter Motor to Solenoid (TEC) Red
	251401	Charge Lead - Orange NLA
10	13117	Battery to Solenoid (Black)
	13117	Chassis to Engine (Black)
11	AM265	Lead-Battery to Solenoid (Red)
	AM265	Lead-Solenoid to Starter Motor (Red)
	AM244N1	Wiring Loom
	AM289	Oil Pressure Light
	251402	Oil Pressure Light Lead
	SAM104	Fuse NLA
	SAM160	Fuse Holder
	AM096	Loom Clamp (2)
	PR0308	Loom Clamp Pop Rivet(2)
	W030816	Pop Rivet Washer (2)
	SH0408C	Earth Lead Bolt
	N04CN	Earth Lead Bolt Nut

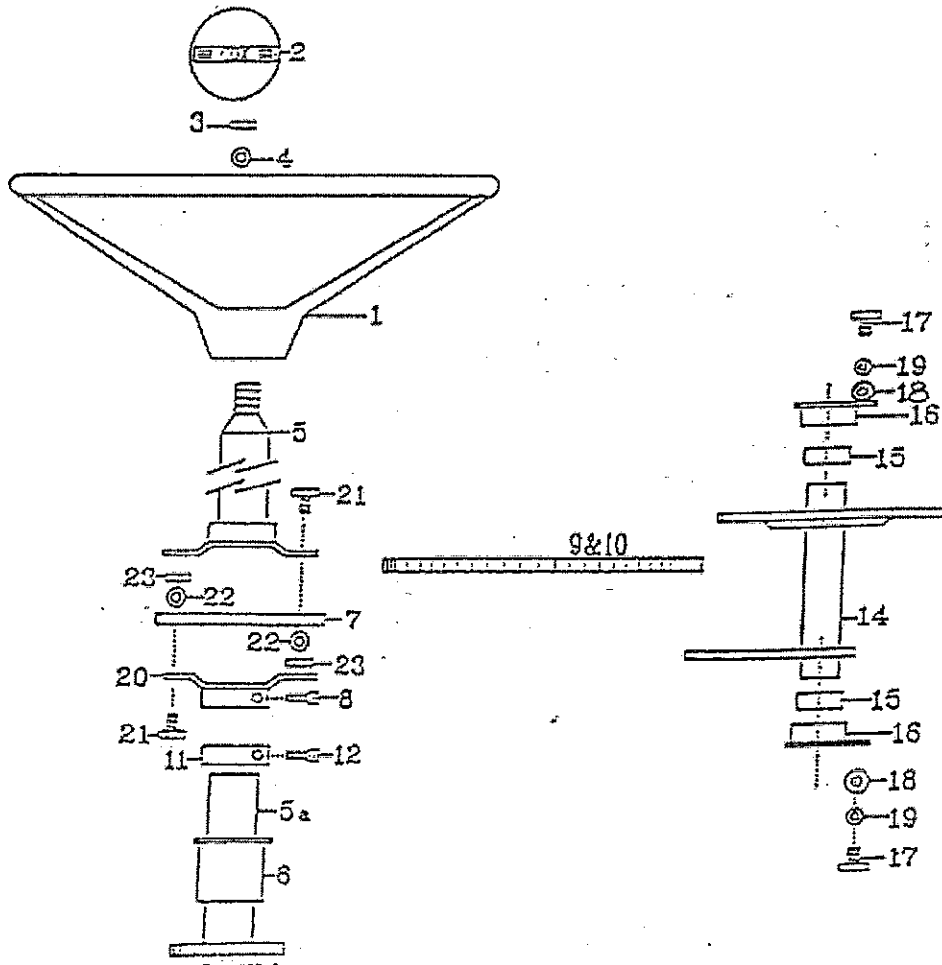
COLOUR CODE

R	RED
B	BLUE
Br/o	BROWN-
ORANGE	
Br	BROWN
P	PURPLE
B/R	BLUE RED
B/W	BLUE WHITE



ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 15: STEERING COMPONENTS

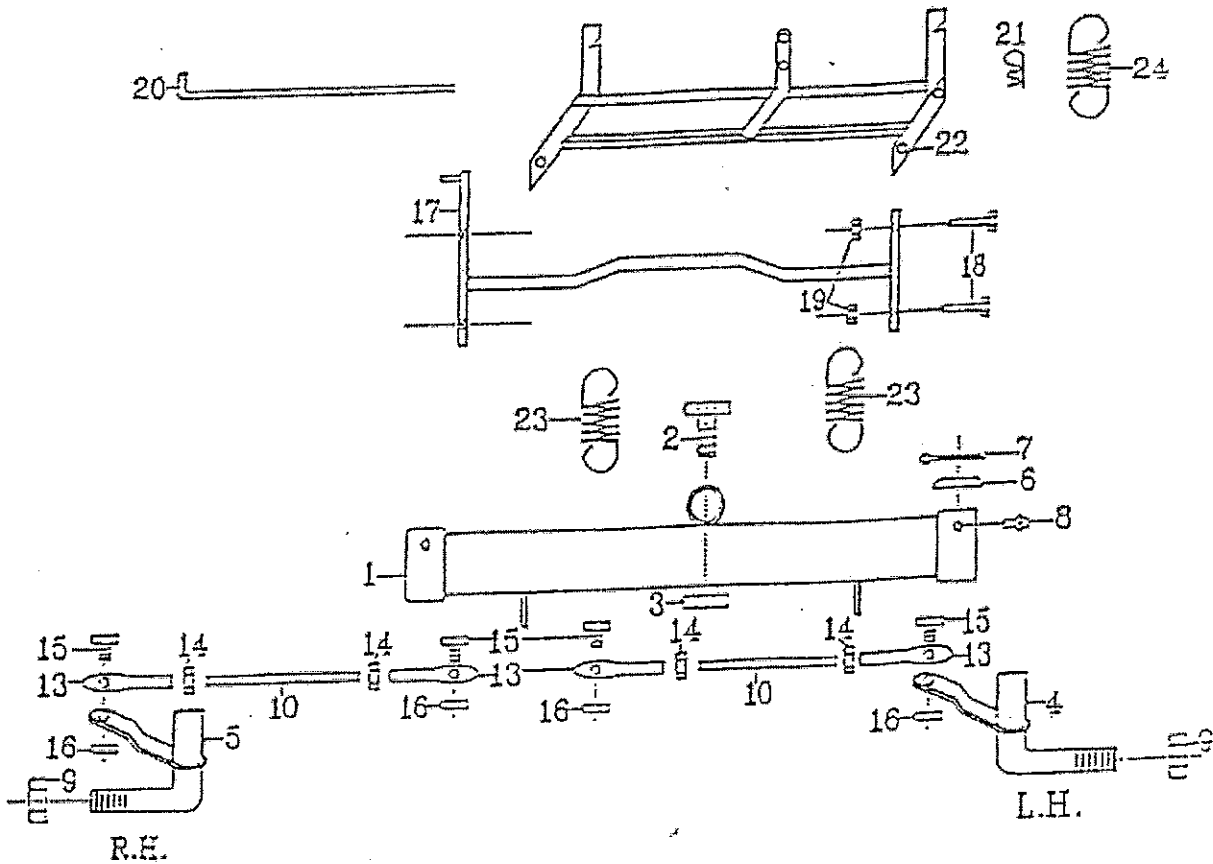
Ref No.	Part No.	Description
1	SKIT37	Steering Wheel inc Emblem
	AM167M8	Steering Wheel
2	AM225	Steering Wheel Emblem
3	N06CN	Steering Wheel Nut
4	W061216	Steering Wheel Washer
5	AM250	Steering Shaft Upper
5a	AM251	Steering Shaft Lower
6	AM017C1	Steering Shaft Bush (3)
7	AM25399J	Steering Shaft Universal
8	GS0404C	Steering Shaft Flange Set Screw
9	AM018	Chain Incl. Link
10	SAM019	Connecting Link
11	AM066	Steering Shaft Lock Collar
12	GS0404C	Lock Collar Set Screw
14	AM254	Steering Idler Shaft
15	AM215	Idler Shaft Mtg Brkt Bush (2)
16	AM255	Idler Shaft Mtg Brkt (2)
17	SH0512C	Idler Shaft Mtg Brkt Bolt (4)
18	W051216	Idler Shaft Mtg Brkt Washer (4)
19	W05S	Idler Shaft Mtg Brkt S/P Washer(4)
20	AM252	Steering Shaft Flange
21	SH0416C	Flange Mounting Bolt (4)
22	W041216	Flange Mtng Bolt Washer (4)
23	N04CN	Flange Mounting Bolt Nut (4)



ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 16: FRONT AXLE COMPONENTS

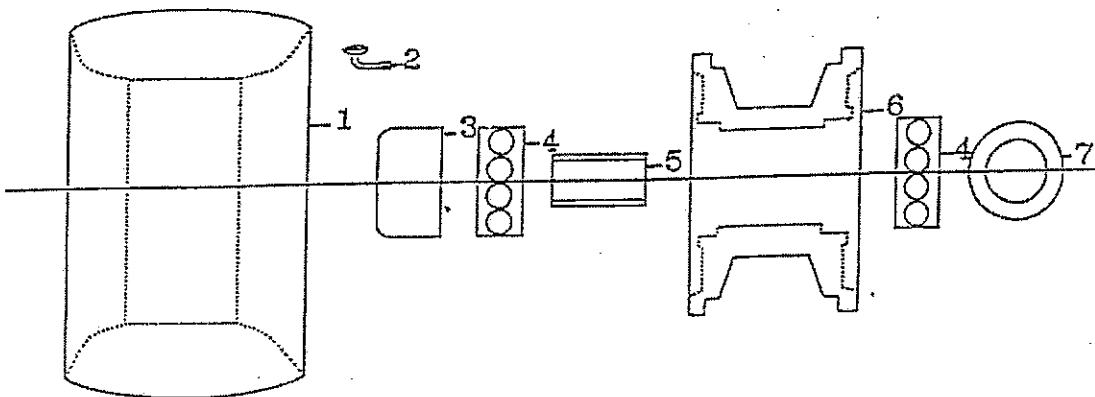
Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	SAM190 ***	Front Axle Beam NLA	17	SAM192G3	Front Axle Connecting Link
2	B1236W	Front Axle Pivot Bolt	18	SH0616C	Connecting Link Bolt (4)
3	N12CN	Front Axle Pivot Bolt Nut	19	N06CN	Connecting Link Bolt Nut (4)
4	AM067	Stub Axle LH	20	AM039S2	Cutter Housing Pivot Rod NLA
5	AM068	Stub Axle RH	21	RP02	Cutter Hsing Pivot Rod 'R' Pin
6	AM069	Stub Axle Dust Cap (2)	22	SKIT62	C/Housing Con Link Incl. Bush
7	CP3-225	Stub Axle Split Pin (2)		AM230	Cutter Hsg Con Link Bush (2)
8	GNTF3	Grease Nipple (2)	23	AM040	Cutter Belt Tension Spring (2)
9	NHM20X1.5T	Front Wheel Nut (2)	24	AM145	Weight Compensating Spring
10	AM256	Tie Rod (2)			
13	AM020	Tie Rod End (4)			
14	N06F	Tie Rod End Lock Nut (4)			
15	B0620C	Tie Rod End Bolt (4)			
16	N06CN	ie Rod End Bolt Nut (4)			

*** Replace with KIT163



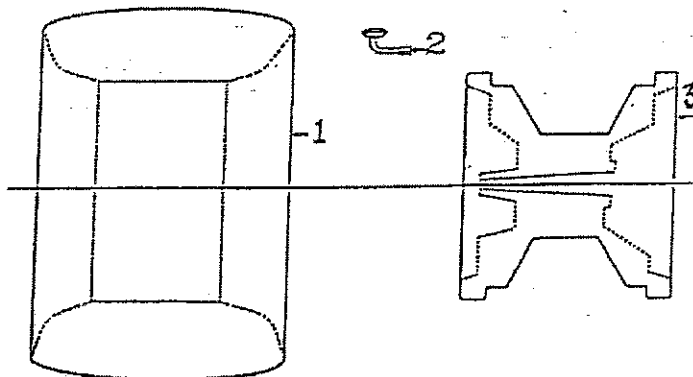
**ORION XL & ORION XL PROFESSIONAL
25J1 GROUP 17: FRONT WHEEL COMPONENTS**

Ref No.	Part No.	Description
1	TT500x6 STU500X6	Front Wheel Tyre & Tube (2)
3	AM07099C	Front Wheel Hub Cap (2)
4	BB204212N	Bearing (4)
5	AM021	Bearing Spacer (2)
6	AM193M9	Wheel Hub (2)
7	W203902	Inner Dust Washer (2)



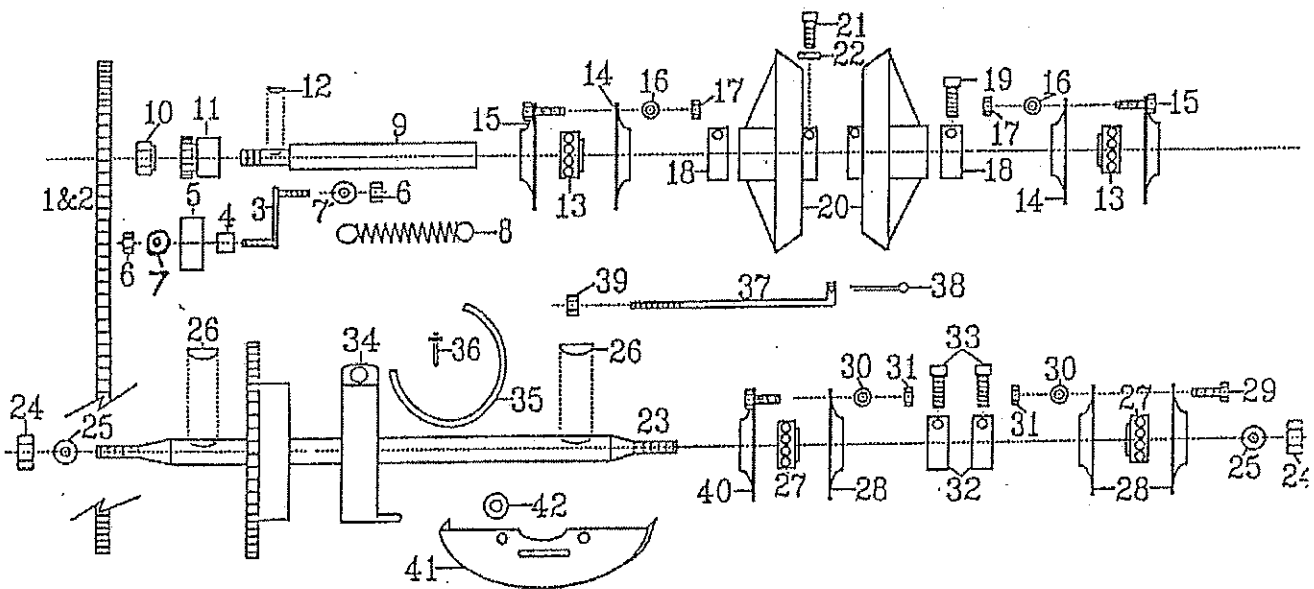
**ORION XL & ORION XL PROFESSIONAL
25J1 GROUP 18: REAR WHEEL COMPONENTS**

Ref No.	Part No.	Description
1	TT650x8 STU650X8	Rear Wheel Tyre & Tube (2)
3	AM194	Wheel Hub (2)



ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 19: DRIVE COMPONENTS

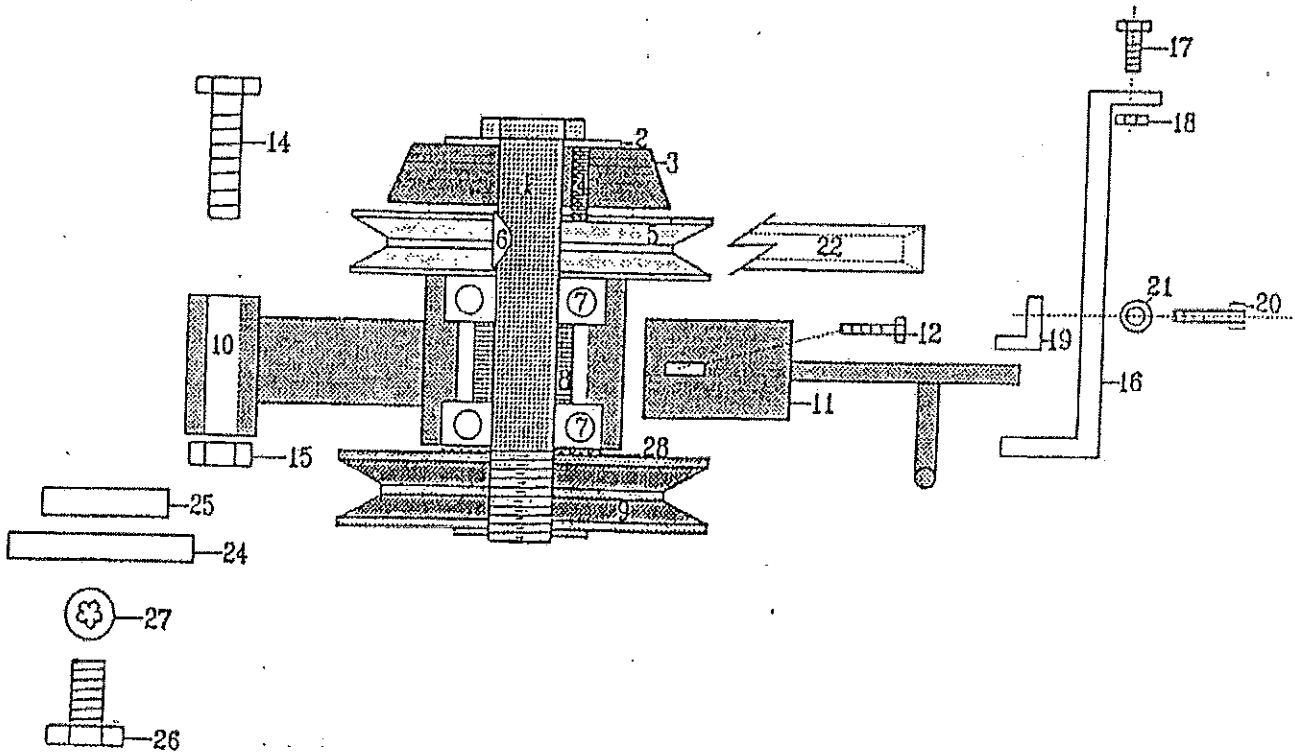
Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	AM018	Drive Chain Incl Link	24	N10F	Rear Axle Nut (2)
2	SAM019	Connecting Link	25	W102016	Rear Axle Washer (2)
3	SAM245	Chain Tensioner (2) NLA	26	K18	Rear Axle Key (2)
4	AM275	Spacer (2)	27	BB25SAN	Rear Axle Bearing (2)
5	PIFBB126598A	Bearing (2)	28	AM024	Rear Axle Bearing Flange (3)
6	N06CN	Ret. Nut (4)	29	SH0616C	Bearing Flange Bolt (3)
7	W061216	Ret. Nut Washer (6)	30	W061216	Bearing Flange Bolt Washer (3)
8	AM180	Chain Tensioning Spring	31	N06CN	Bearing Flange Bolt Nut (6)
9	SAM071E95	Intershaft	32	AM025	Rear Axle Lock Collar (2)
10	SAM022	Intershaft Nut	33	GS0505C	Lock Collar Set Screw (2)
11	SKIT30	Intershaft Sprocket & Key	34	KIT16	Drum Brake Incl Lining
12	SK03	Intershaft Sprocket Key	35	AM200	Brake Band Lining
13	BB25SAN	Intershaft Bearing (2)	36	PR0205	Brake Lining Rivet (4)
14	AM024	Intershaft Bearing Flange (4)	37	AM266	Drum Brake Rod
15	SH0616C	Bearing Flange Bolt (6)	38	CP3-220	Drum Brake Rod Split Pin
17	N06CN	Bearing Flange Bolt Nut (6)	39	N05CN	Drum Brake Rod Nut
18	AM025	Intershaft Lock Collar (2)	40	AM202	Rear Axle Bearing Flange LH
19	GS0505C	Lock Collar Set Screw (2)	41	AM203	Chain Guard
20	AM197	Clutch Plate (2)	42	W061216	Guard Washer (2)
21	SS0612W	Clutch Plate Set Screw Set (4)	**	SKIT6898A	Chain Adj. Duel Bearing Kit
22	N06C	Clutch Plate S/Screw Lock Nut(4)			
23	SAM198	Rear Axle			



ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 20: CLUTCH ARM & COMPONENTS

Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	AM204J3	Clutch Shaft Incl Nut	16	AM206	Clutch Arm Locating Bracket
2	W204303	Clutch Cone Ret. Washer	17	SH0412C	Clutch Arm Locating Brkt Bolt(2)
3	CC2095G	Clutch Cone	18	N04CN	C/Arm Locating Brkt Bolt Nut(2)
4	AM026	Clutch Cone Pin	19	AM246	Clutch Arm Bracket Wear Plate
5	AM158	Clutch Pulley Upper	20	SH0512C	C/Arm Brkt Wear Plate Bolt(2)
6	SK09	Clutch Pulley Key	21	W051216	C/Arm Brkt Wear Plate Washer (2)
7	BB205215N	Clutch Bearing (2)		W05S	Wear Plate S/P Washer (2)
8	AM072	Clutch Bearing Spacer	22	SV22	Belt-Engine to Clutch
9	252001	Clutch Pulley Lower	24	AM208	Clutch Adjusting Plate
10	AM207	Clutch Arm c/w Yoke	25	AM209	Clutch Adj Tapped Plate (2)
12	SH0512C	Yoke Ret. Bolt (2)	26	SH0616C	Adjusting Plate Bolt (2)
14	B0652C	Clutch Arm Pivot Bolt	27	W06S	Bolt Lock Washer (2)
15	N06CN	Clutch Arm Pivot Bolt Nut	28	W203902	Clutch Pulley Bearing Washer

* SKIT64 Clutch Arm Complete 87' On



ORION XL & ORION XL PROFESSIONAL 25J1 GROUP 21: 32" MOWING ATTACHMENT COMPONENTS

Ref No.	Part No.	Description	Ref No.	Part No.	Description
1	SKIT122	Cutter Housing	24	AM030	Cutter Shaft Pulley
2	AM259	Deflector	25	W204303	Pulley Ret. Washer
2a	AM272	Deflector Spring	26	NHM20X1.5T	Pulley Ret. Nut
3	AM273	Deflector Rod	27	KIT15	Cutter Brake Incl. Pad
4	AM274	Deflector Ratchet Plate	28	AM033I95	Cutter Brake Pad
	W041216	Deflector Bracket Washer	29	PR0205	Brake Pad Pop Rivet (2)
5	AM052E1	Deflector Bracket	30	B0520C	Cutter Brake Pivot Bolt
6	SH0412C	Deflector Bracket Bolt (2)	31	N05CN	Cutter Brake Pivot Bolt Nut
7	N04CN	Deflector Bracket Bolt Nut (2)	32	AM07604A	Cutter Disc
9	STR56	Transfer - Warning	33	SH0612C	Cutter Disc Ret. Bolt (4)
10	STR49	Transfer - Do Not Step	34	N06CN	Cutter Disc Ret. Bolt Nut (4)
11	AM036D9	Cutter Housing Roller	35	SMB198SHD	Cutter Blade - Stepped
12	AM037	Cutter Roller Shaft		SMB198AHD	Cutter Blade - Air Flow (opt)
13	CP3-225	Cutter Roller Shaft Split Pin	37	SKIT01D1	Blade Bolt & Nut Set
14	SKIT08	Bearing Housing c/w Belt Guides	43	V11	Belt - Cutter to Clutch Orion XL
15	AM073	Belt Guide (2)	45	AM220	Cutter Front Guard
16	B0416C	Belt Guide Bolt (2)	46	W051216	Cutter Guard Washer (3)
17	N04CN	Belt Guide Bolt Nut (2)	47	N05CN	Cutter Guard Ret. Nut (3)
18	B0620C	Cutter Brng Housing Bolt (4)			
19	NF06CN	Cutter Brng Hsng Bolt Nut (4)			
20	13181	Cutter Shaft			
21	SK09	Cutter Shaft Key			
22	BB205215N	Cutter Shaft Bearing (2)			
23	AM029	Bearing Spacer			

*** SKIT54 Blade,Bolt,Nut Set -Stepped
SKIT55 Blade,Bolt,Nut Set-Air Flow
SKIT66 Deflector Kit

